



INSTALLATION MANUAL
OPEN FENDER BASE/FLARE
PRODUCT NUMBER: TF6100/6110
APPLICATION: 2024 CHEVROLET HD



IMPORTANT SAFETY GUIDE | Your safety and the safety of others is very important.

In order to help you make informed decisions about safety, we have provided the following warnings, safety precautions, installation instructions, and other important information to alert you to potential hazards that could hurt you or others.

Please do a job safety analysis before each task to identify potential hazards for your situation and remove/protect against them. Use own good judgment and take your time.

Check packaged materials immediately upon arrival to ensure that all listed parts are included and undamaged.

Read and understand all warnings, safety precautions, and instructions before installing this product.

SENSORS FIELD OF VIEW MAY BE ALTERED WITH USE OF THE REPLACEMENT BUMPER.

WARNINGS

- Failure to observe the following warnings and instructions provided in this manual could lead to severe injury and/or death.
- For professional installation only. Careless installation and/or operation can result in serious injury, death, and/or equipment damage. All liability for installation and use rests with the user or consumer.
- Fab Fours, Inc. only approves installing this product according to these written instructions with the hardware provided. Failure to install according to these instructions will invalidate the warranty. This includes, but is not limited to, using alternative installation methods, hardware, or materials.
- This product is for off road use only.

SAFETY PRECAUTIONS

- Always remove jewelry and wear eye protection.
- Always use extreme caution when jacking up a vehicle for work. Set emergency brake and use tire blocks. Locate and use the vehicle manufacturers designated lifting points. Use jack stands.
- Always use appropriate and adequate care in lifting components into place.
- Always ensure components will remain secure during installation and operation.
- Always wear safety glasses when installing this kit. A drilling operation will cause flying metal chips. Flying chips can cause serious eye injury.
- Always use extreme caution when drilling a vehicle. Always disconnect power before welding. Thoroughly inspect the area to be drilled (on both sides of material when possible) prior to drilling, and relocate any objects that may be damaged.
- Always use extreme caution when welding a vehicle. Thoroughly inspect the area to be welded (on both sides of material when possible) prior to welding, and relocate any objects that may be a fire hazard. When welding in a cab, make sure the interior surfaces are covered (e.g., welding blanket) and a fire extinguisher is at hand.
- Always use extreme caution when cutting and trimming during fitting.
- Always tighten all nuts and bolts securely per installation instructions.
- Always route electrical cables carefully. Avoid moving parts, components that become hot, and rough or sharp edges.
- Always insulate and protect all exposed wiring and electrical terminals.
- Perform regular inspections and maintenance on mounts and hardware.



TABLE OF CONTENTS

2	SAFETY / DISCLAIMER
3	TABLE OF CONTENTS
4	A MESSAGE FROM THE OWNER
5	GETTING STARTED
6	PROVIDED MATERIAL
8	DISASSEMBLY
17	MARKING & CUTTING
23	INSTALLATION
30	CONTACT

A MESSAGE FROM THE OWNER



Fab Fours' was born out of a passion for customizing vehicles and a love of the outdoors. Our engineering team uses the latest 3D design software to turn new product ideas into reality. In our factory, designs come to life with the combination of cutting edge technology for metal cutting and forming and an American workforce that puts its' heart and pride into every product.

From design and manufacturing, to quality and delivery, Fab Fours' mission is to be the market leader for steel truck and jeep accessories. We make sure a quality product is delivered on time, more than expected, better than expected to our customers.

Enjoy your new Fab Fours product. Welcome to the family!

Greg Higgs

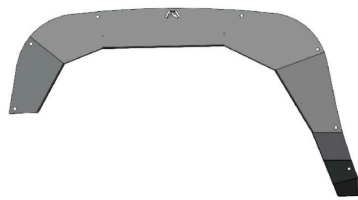
FOUNDER, FAB FOURS

GETTING STARTED

Before you begin the installation process of your new Fab Fours product, we suggest laying out all materials and parts on a pad or protective surface.

Failure to fully account for all components before beginning installation may leave vehicle immobile until part is acquired. Refer to the next pages as an inventory check.

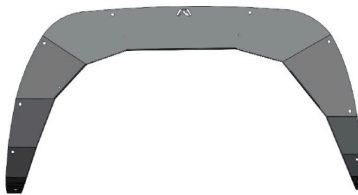
PROVIDED MATERIALS



23219 - DS FRONT BASE



23220 - PS FRONT BASE



23221 - DS REAR BASE



23222 - PS REAR BASE



23223 - DS FRONT FLARE



23224 - PS FRONT FLARE



23225 - DS REAR FLARE



23226 - PS REAR FLARE

61727 - RUBBER SEAL (QTY: 2)



TF6100



TF6110

REQUIRED TOOLS

10MM, 13MM SOCKET WRENCHES

T15 TORX DRIVER

3/16" ALLEN WRENCH

7/16" TRANSFER PUNCH

3/8" DRILL BIT

7/16" DRILL BIT

HAMMER

PLASTIC PANEL PRY TOOL

MASKING TAPE

BLACK AND SILVER SHARPIES

SMALL RECIPROCATING SAW

DRILL

WISE-GRIP C-CLAMP (QTY 3)

ANTI-SEIZE COMPOUND

DEBURRING TOOL

RAZOR BLADE

TAPE MEASURE

PAINT

ASSISTANCE

We recommend two people perform the installation as items are heavy and may need to be held in place while installing.

ORGANIZATION

Disassemble the vehicle where you can catalog and store everything. We suggest labeling and bagging all the OEM bolts when removing from the vehicle. Failure to keep track of parts could lead to an inability to properly reinstall components.

HARDWARE KIT | 50463-HW

ID #	COMPONENT DESCRIPTION	QTY
50463-HW	5/16"-18, RIVET NUTS	24
50463-HW	5/16", 3/4" OD, BONDED SEALING WASHERS, 18-8 SS	38
50463-HW	5/16"-18 X 3/4" BUTTON HEAD CAP SCREW, 18-8 SS	38
50463-HW	5/16"-18, NYLOCK HEX NUT, 18-8 SS	8
50463-HW	5/16", FLAT WASHERS, 18-8 SS	8
50463-HW	17/32" DRILL BIT W/ 1/2" SHANK	1
50463-HW	5/16"-18 RIVET NUT INSTALL TOOL	1
50464-HW	5/16"-18 x 3/4" BUTTON HEAD CAP SCREW, 18-8 SS	16

DISASSEMBLY

1. Using a T15 Torx bit, remove the four (4) screws attaching the front driver's side mud guard to the vehicle to remove the mud guard. Figure 1-2

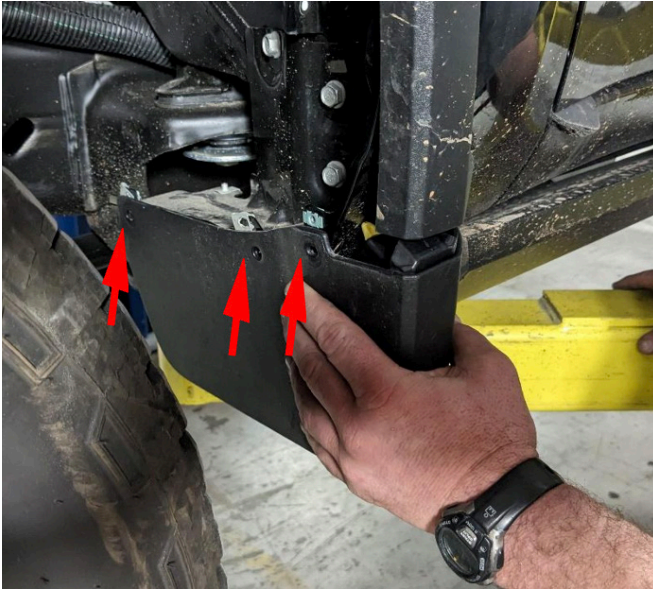


Figure 1



Figure 2

2. Using a T15 torx bit, remove the (13) screws from the front driver's side inner fender. Figure 3

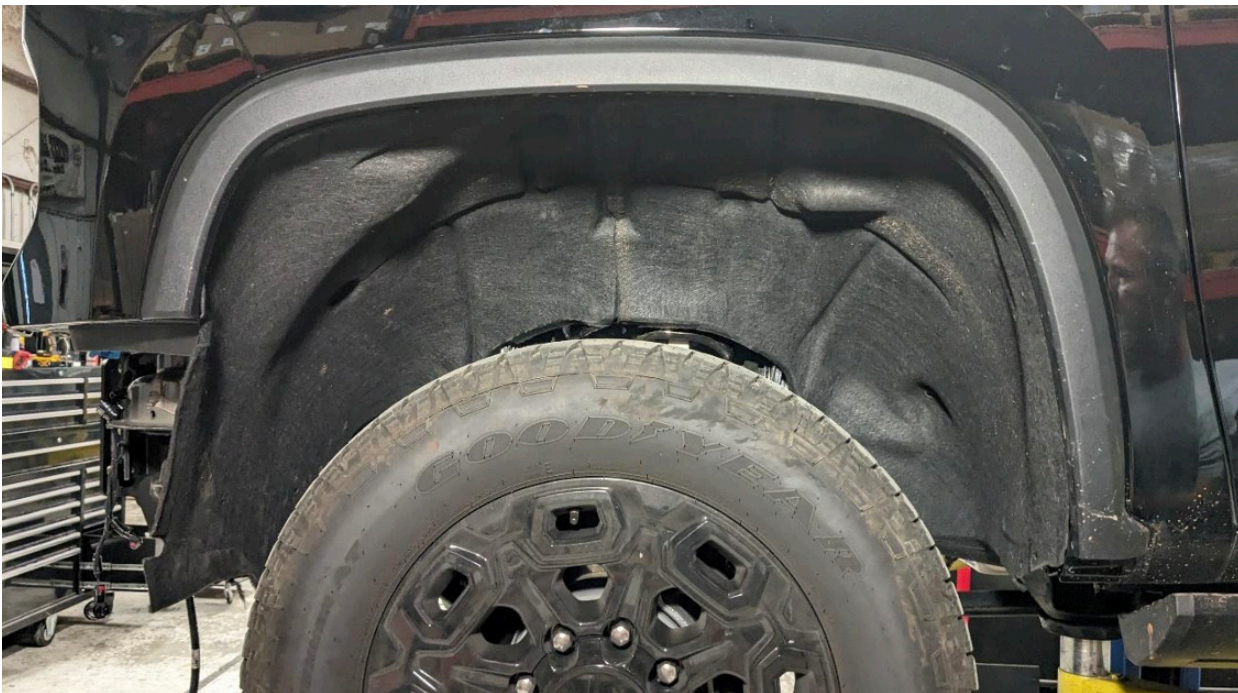


Figure 3

3. Using a panel pry tool, remove the one (1) push pin from the front inner fender and set the inner fender aside.

4. Using a panel pry tool, remove the driver's side front fender flare by releasing the plastic clips one at a time. Figure 4

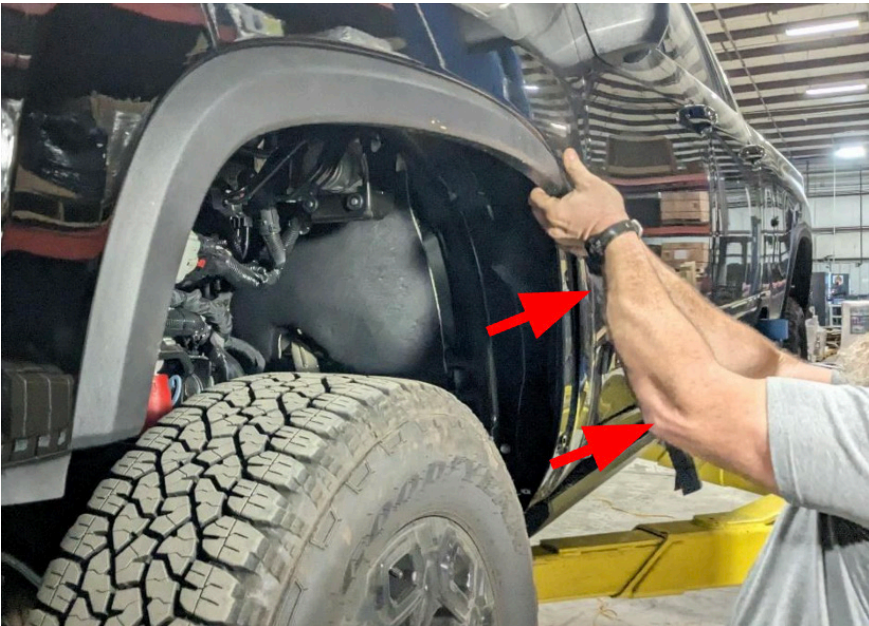


Figure 4

5. Using a 13mm socket wrench, remove the three (3) screws attaching the mud guard bracket to the vehicle. Figure 5

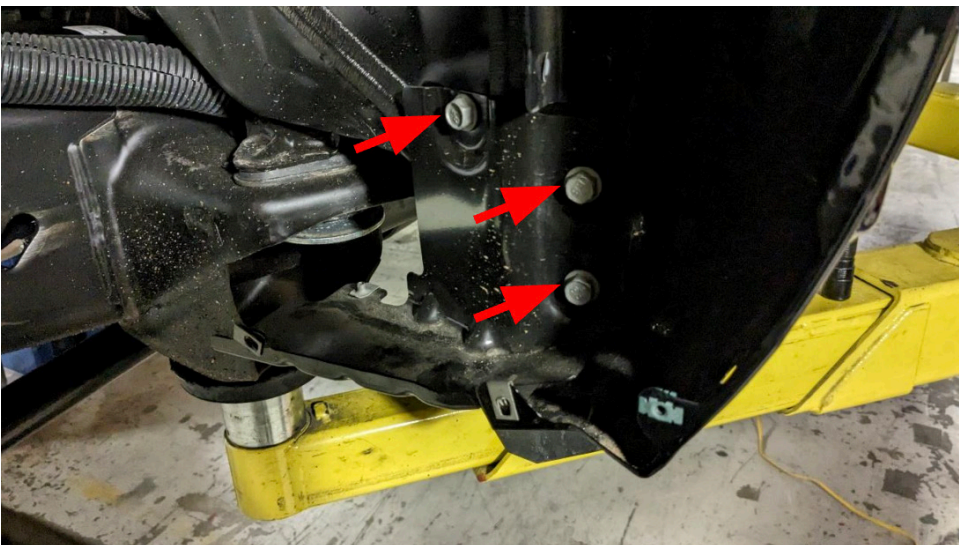


Figure 5

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6. Using a 10mm socket wrench, remove the two (2) screws attaching the inner fender support bracket to the core support. Figure 6



Figure 6

7. Use masking tape to protect the fender paint during installation and provide a marking surface.
8. Using a marker, trace the body line on the fender as shown. This is the line you will cut along later. Figure 7



Figure 7

9. Repeat steps on passenger's side front fender.

10. Using a T15 Torx bit, remove the five (5) screws attaching the mud guards at the front and rear of the driver's side rear wheel well. Pull down on the guards to remove them from the vehicle. Figure 8-9



Figure 8



Figure 9

11. Remove the inner fender using a 10mm socket wrench to remove two (2) screws, a panel pry tool to remove one (1) push pin and a T15 torx bit to remove the remaining seven (7) screws. Figure 10-11



Figure 10



Figure 11

12. Use masking tape to protect the bed side and give a surface for marking.

13. Using a measuring tape and marker, measure 13" up from the bottom of the fender flare (top of mud guard) and make a horizontal mark on the bed side. Figure 12



Figure 12

14. Use a panel pry tool to release the plastic clips attaching the fender flare to the bed side. Figure 13

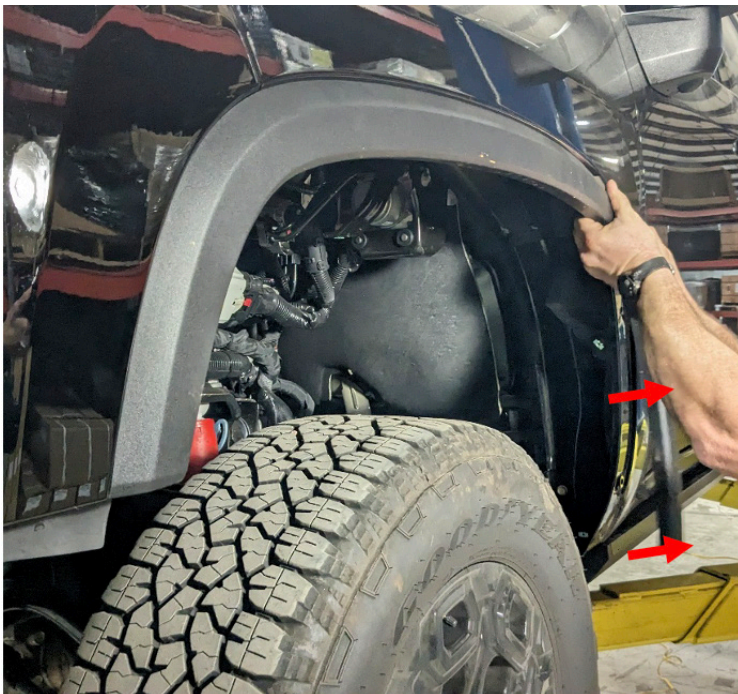


Figure 13

15. Using a marker, trace the body lines on the fender as shown. This mark will be the same forward of the wheel on the fender as it is behind the wheel on the fender. This is the line you will cut along later. Figure 14-16



Figure 14



Figure 15

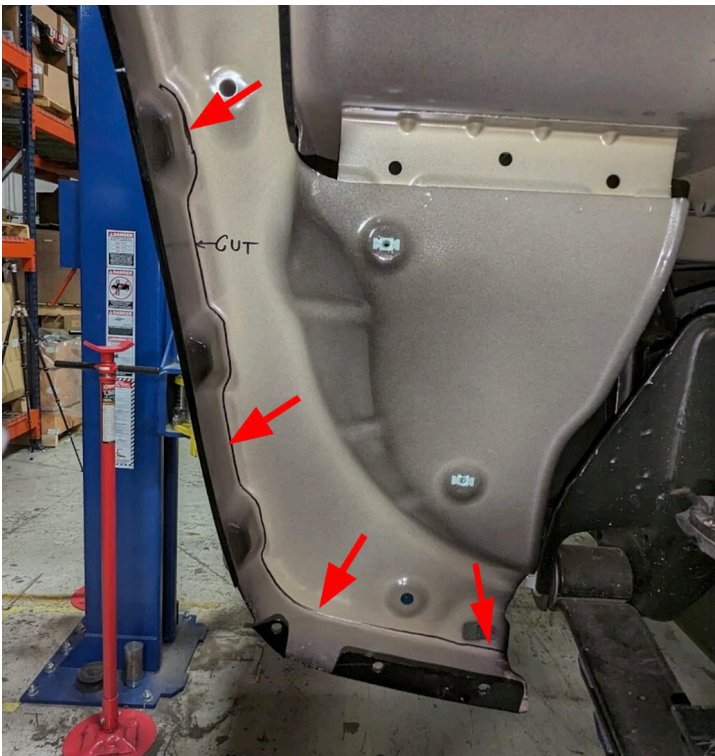


Figure 16

CUTTING

1. Using a small reciprocating saw, cut along the previously marked lines on the front fenders.
Figure 17-18

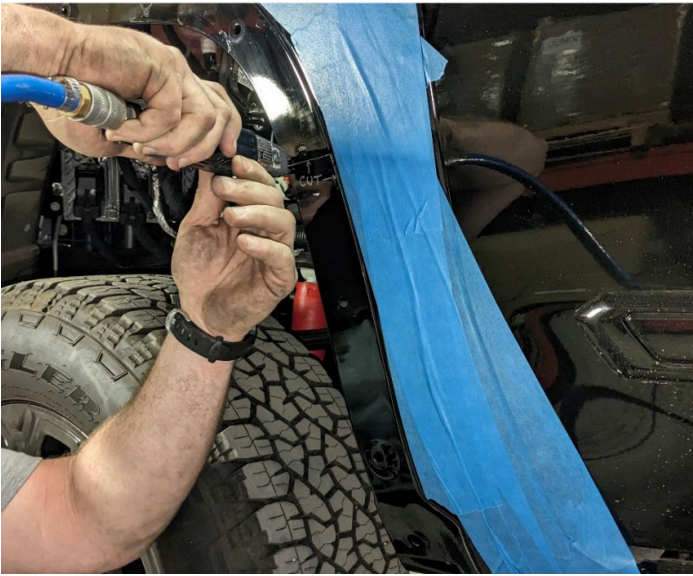


Figure 17



Figure 18

2. Apply provided paint to any bare metal areas to prevent rust.
3. Using a small reciprocating saw, cut along the previously marked lines on the bedsides and inner structure. Figure 19-22

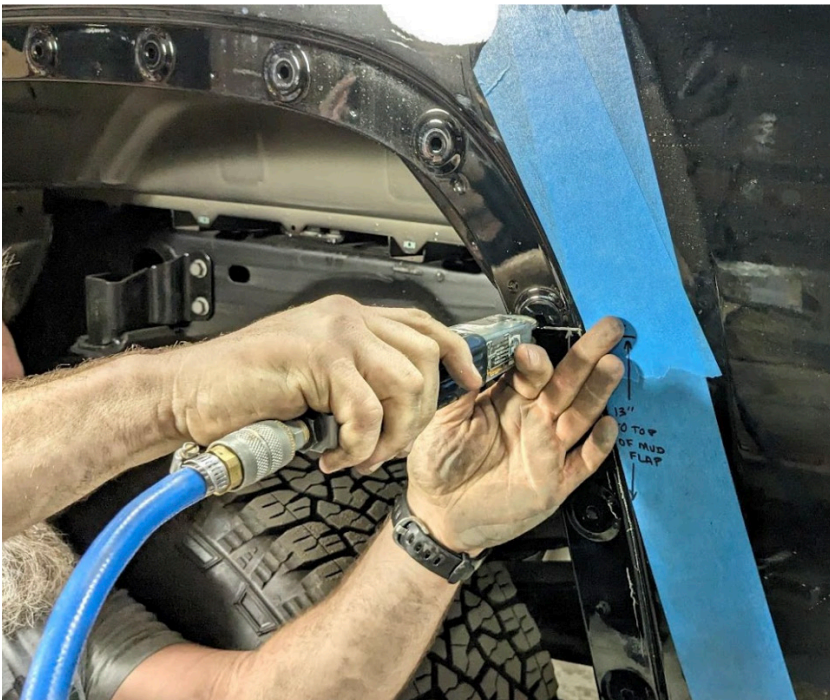


Figure 19



Figure 20



Figure 21



Figure 22

4. Apply paint to any bare metal areas to prevent rust.

INSTALLATION — FRONT FENDER BASES

**** Note: If installing fender flares, see fender flare installation section before proceeding with fender base installation. ****

1. Apply the provided rubber edge trim (61727) to the outer perimeter of the two (2) front fender bases (Part# 23219-23220). Do not stretch the trim during application or it will not stay in place. Start at one end of the fender base and use a razor blade to cut off the excess at the other end. Figure 23



Figure 23

2. Using three (3) vise-grip c-clamps, clamp the provided driver side front base (23219) onto to the vehicle. Align the front horizontal edge with the valance and pull the bottom edge of the base up tight to the bottom of the rocker channel. Figure 24

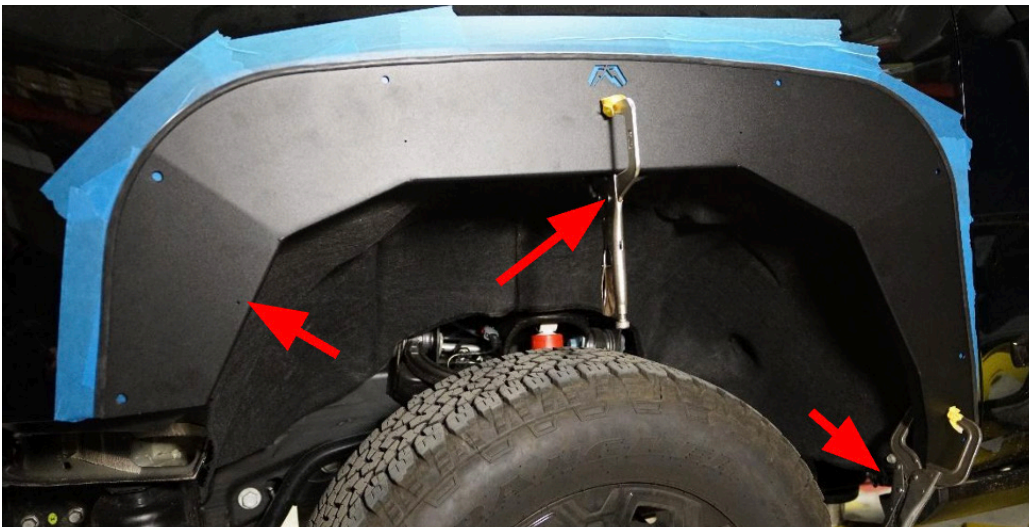


Figure 24

3. Using a center punch and hammer, make a mark in the OE fender at each one of the holes in the fender base. Figure 25



Figure 25

4. Remove the base from the vehicle and drill each marked location using the 17/32" drill bit. Figure 26

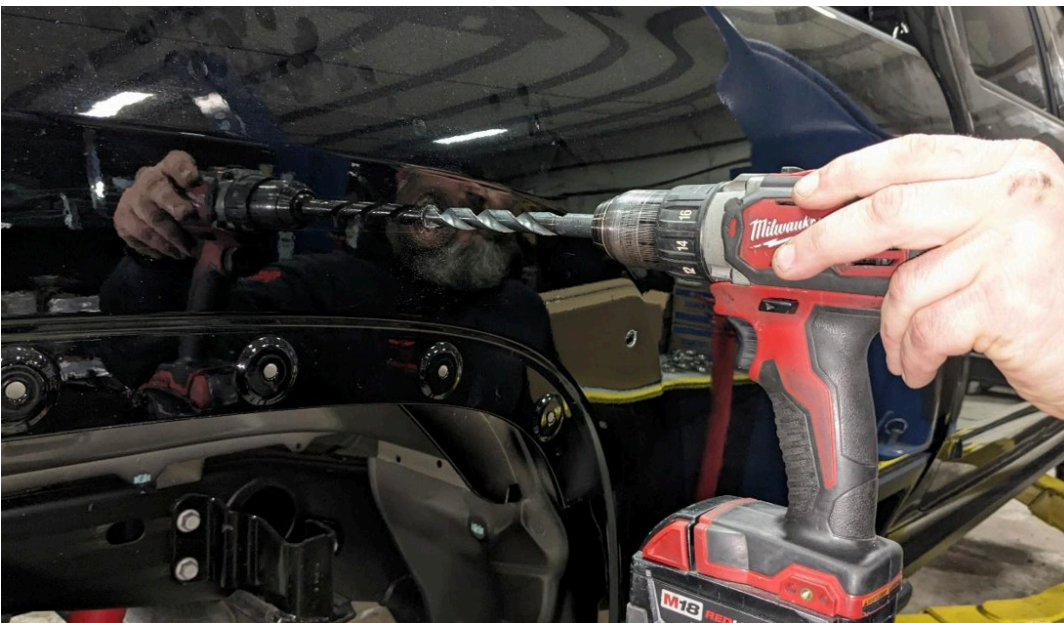


Figure 26

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5. Using the provided rivet nut tool, install a rivet nut in each of the previously drilled holes. Figure 27



Figure 27

6. Reinstall the inner fenders reusing the factory screws and push pins where possible. Figure 28



Figure 28

7. Drill a hole in the inner fender at the bottom of the rear of the liner where the mud guard bracket was removed and reinstall one (1) of the mud guard bracket screws through the inner fender. Figure 29



Figure 29

8. Drill another hole in the front of the inner fender where the inner fender support was removed and reinstall the support brackets hardware through the inner fender. Figure 30



Figure 30

9. Apply anti-seize compound and a bonded sealing washer to the provided 5/16" button head cap screws.

10. With assistance, hold the fender base (part#: 23219) in place on the driver's side front fender and install the 5/16" button head cap screws with bonded sealing washers in each previously installed rivet nuts. Figure 31



Figure 31

11. Tighten the previously installed 5/16" button head cap screws with a 3/16" Allen wrench.

12. Using a small reciprocating saw, trim the inner fenders to your specific application. Figure 32-33

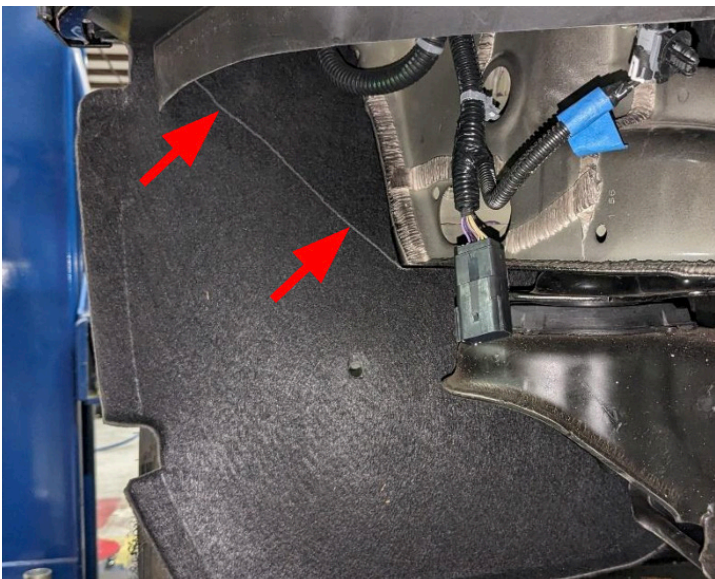


Figure 32



Figure 33

13. Repeat these steps on the passenger side with fender base (Part# 23220).

INSTALLATION — REAR FENDER BASES

1. Apply the provided rubber edge trim (61727) to the outer perimeter of the two (2) rear fender bases (Part# 23221-23222). Do not stretch the trim during application or it will not stay in place. Start at one end of the fender base and use a razor blade to cut off the excess at the other end. Figure 34



Figure 34

2. Using three (3) vise-grip c-clamps, clamp the provided driver side front base (23221) onto to the vehicle. Align the base with the wheel well body line and pull the bottom edges of the base up tight to the bottom of the bed side. Figure 35



Figure 35

-
3. Using a center punch and hammer, make a mark in the OE fender at each one of the holes in the fender base as well as marking the hole inside the wheel well behind the tire. Figure 36



Figure 36

4. Remove the base from the vehicle and drill each marked location in the bed side using the 17/32" drill bit and the inner structure using a 7/16" drill bit. Figure 37



Figure 37

5. Using the provided rivet nut tool, install a rivet nut in each of the previously drilled holes in the outside of the bedside EXCEPT the four (4) holes at the bottom of the base. Figure 38



Figure 38

6. Reinstall the inner fenders reusing the factory screws and push pins where possible. Figure 39



Figure 39

-
7. Apply anti-seize compound and a bonded sealing washer to the provided 5/16" button head cap screws.
8. With assistance, hold the fender base (part#: 23221) in place on the driver's side front fender and install the 5/16" button head cap screws with bonded sealing washers in each previously installed rivet nuts. Figure 40



Figure 40

9. Using a pair of pliers, remove the captured nut from the bottom of the bedside behind the rear tire. Using a 3/8" drill bit, enlarge the hole from which the captured nut was removed from. Figure 41-42

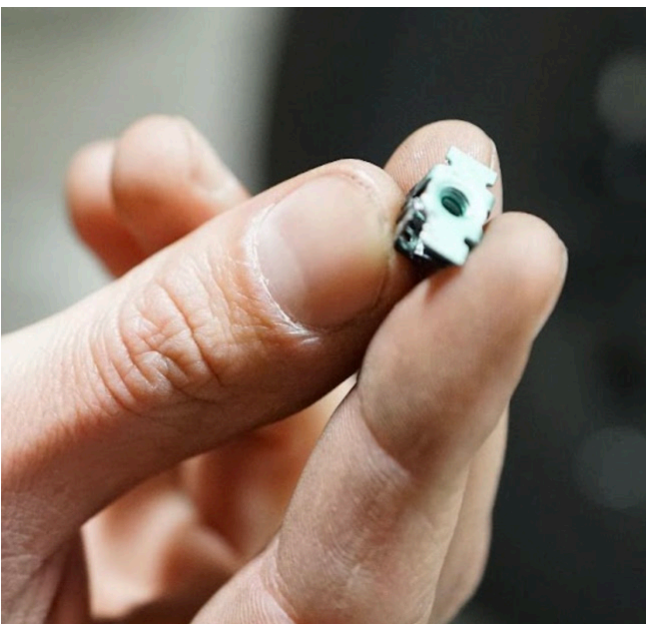


Figure 41



Figure 42

10. Using a 3/8" drill bit, drill one (1) hole in the bottom of the bed side forward of the rear tire using the slot in the fender base as a locator. Figure 43



Figure 43

11. Install a 5/16" button head cap screw with bonded sealing washer, flat washer, and nylock nut in the bottom most four (4) holes in the base. Figure 44-45



Figure 44



Figure 45

12. Tighten the previously installed 5/16" button head cap screws with a 3/16" Allen wrench and 1/2" combination wrench.
13. Using a small reciprocating saw, trim the inner fender if required.
14. Repeat these steps on the passenger side with fender base (Part# 23222).

INSTALLATION — FENDER FLARES

****Note:** If the fender bases have already been installed on the vehicle, they will need to be removed to install the fender flares. **

1. Apply the provided rubber edge trim (61727) to the outer profile of the four (4) provided fender flares (DS Front: 23223, PS Front: 23224, DS Rear: 23225, PS Rear: 23226) by starting at one end and working it across to the opposite end. Then use a razor blade to trim off the excess. Figure 46

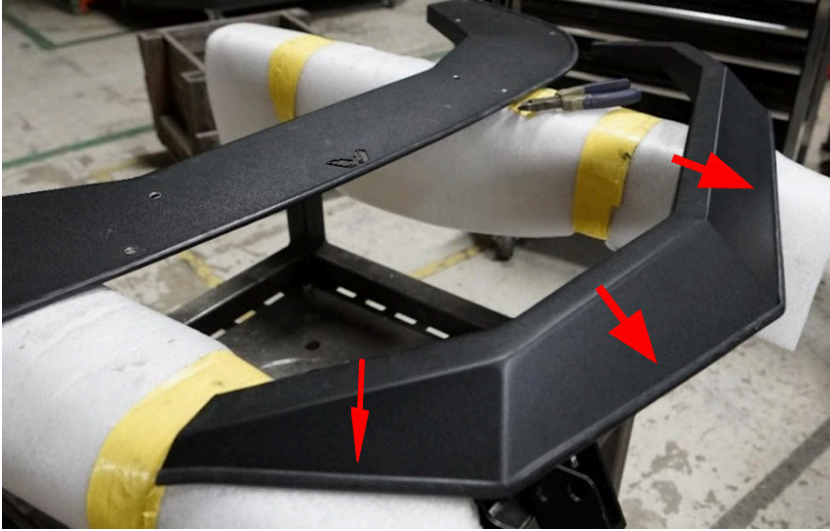


Figure 46

2. Using a center punch and hammer mark the center of the four (4) circles etched on the backside of the fender bases. Figure 47



Figure 47



Figure 48

3. Using a 3/8" drill bit, make holes in the fender base at each of the previously marked locations. Figure 49



Figure 49

4. Apply paint to the bare steel from the previously drilled holes.
5. Apply anti-seize compound to four (4) of the provided 5/16" button head cap screws.
6. Install fender flare (23223) onto fender base (23219) using four (4) of the 5/16" button head cap screws with anti-seize. Tighten hardware with a 3/16" Allen wrench. Figure 50-52



Figure 50



Figure 51

INSTALLATION – FENDER FLARES

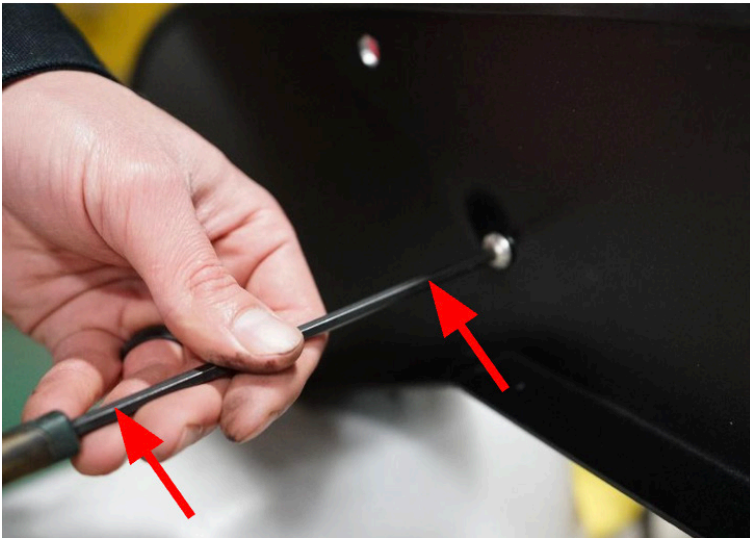


Figure 52

7. Install fender flare (23224) onto fender base (23220) using four (4) of the 5/16" button head cap screws with anti-seize. Tighten hardware with a 3/16" Allen wrench.
8. Install fender flare (23225) onto fender base (23221) using four (4) of the 5/16" button head cap screws with anti-seize. Tighten hardware with a 3/16" Allen wrench.
9. Install fender flare (23226) onto fender base (23222) using four (4) of the 5/16" button head cap screws with anti-seize. Tighten hardware with a 3/16" Allen wrench.
10. If fender bases were previously installed, they can be reinstalled now. Figure 53



Figure 53

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11. If fender bases have not been installed previously, reference the fender base installation section.

INSTALLATION COMPLETE

CONTACT INFORMATION

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**“IF YOU’RE LOOKING FOR MORE OF THE SAME,
THEN YOU’VE COME TO THE WRONG PLACE.”**

- GREG HIGGS

