# TOYOTA HIGHLANDER FENDER FLARE SET

## Part Number: 00016-48140

### Accessory Code: TG80

## Conflicts

Note:

## Kit Contents

<table>
<thead>
<tr>
<th>Item #</th>
<th>Quantity Req'd.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Left Front Fender Flare</td>
</tr>
<tr>
<td>2</td>
<td>1</td>
<td>Right Front Fender Flare</td>
</tr>
<tr>
<td>3</td>
<td>1</td>
<td>Left Front Inner Piece</td>
</tr>
<tr>
<td>4</td>
<td>1</td>
<td>Right Front Inner Piece</td>
</tr>
<tr>
<td>5</td>
<td>1</td>
<td>Left Rear Main Fender Flare</td>
</tr>
<tr>
<td>6</td>
<td>1</td>
<td>Right Rear Main Fender Flare</td>
</tr>
<tr>
<td>7</td>
<td>1</td>
<td>Left Rear Outer Door Piece</td>
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<tr>
<td>8</td>
<td>1</td>
<td>Right Rear Outer Door Piece</td>
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<td>9</td>
<td>1</td>
<td>Left Rear Inner Door Piece</td>
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<td>10</td>
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<td>Right Rear Inner Door Piece</td>
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## Hardware Bag Contents

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<tr>
<td>1</td>
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<td>Tuflock</td>
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<tr>
<td>2</td>
<td>8</td>
<td>Mylar Tab</td>
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<tr>
<td>3</td>
<td>6</td>
<td>#8 Spring U-Clip</td>
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<tr>
<td>4</td>
<td>4</td>
<td>#10 Long U-Clip</td>
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<tr>
<td>5</td>
<td>12</td>
<td>#10 U-Clip</td>
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<td>6</td>
<td>16</td>
<td>#10x5/8&quot; Phillips Truss Screw</td>
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<tr>
<td>7</td>
<td>6</td>
<td>#8x3/4&quot; Washer Pan Head Screw</td>
</tr>
<tr>
<td>8</td>
<td>4</td>
<td>#14x 3/4&quot; Phillips Truss Tapping Screw</td>
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## Color Applicability/Trim Level

<table>
<thead>
<tr>
<th>Vehicle/Trim Color</th>
<th>Accessory Color</th>
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<tbody>
<tr>
<td>Silver -01</td>
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<td>Black -02</td>
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<tr>
<td>Sandy Beach -04</td>
<td>X</td>
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<tr>
<td>Blizzard Pearl -10</td>
<td>X</td>
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<tr>
<td>Magnetic Gray -11</td>
<td>X</td>
</tr>
</tbody>
</table>

## General Applicability

Note: Highlander Models 2011-Up Except Hybrid

## Recommended Sequence of Application

<table>
<thead>
<tr>
<th>Item #</th>
<th>Accessory</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Fender Flare Set</td>
</tr>
</tbody>
</table>

*Mandatory

## Recommended Tools

### Safety Tools
- Safety Glasses

### Special Tools
- Inner Door Piece Clamp
- Fixture

### Installation Tools
- Nylon Tool: Standard
- Wiping Cloth: Non-Scratch, Lint Free
- #2 Phillips Screwdriver
- 3mm Allen Wrench
- 10mm Socket Wrench
- Electric Drill: 5/16" & 1/4" Drill Bits
- Pry Tool
- Awl

### Special Chemicals
- Cleaner: Isopropyl Alcohol-Based
- Distilled Water

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**Legend**

- **STOP**: Damage to the vehicle may occur. Do not proceed until process has been complied with.
- **OPERATOR SAFETY**: Use caution to avoid risk of injury.
- **CAUTION**: A process that must be carefully observed in order to reduce the risk of damage to the accessory/vehicle and to ensure a quality installation.
- **TOOLS & EQUIPMENT**: Used in Figures calls out the specific tools and equipment recommended for this process.
- **REVISION MARK**: This mark highlights a change in installation with respect to previous issue.
- **SAFETY TORQUE**: This mark indicates that torque is related to safety.

**SPECIAL NOTE:**

After TMS and Safety mandated preparatory steps have been taken, the installation sequence is the suggested method for completing the accessory installation. In some instances the suggested sequence is written for one associate to install and in others the sequence is given as part of a team accessory installation. Unless otherwise stated in the document, the associates may perform the installation steps in any order to make the installation as efficient as possible while maintaining consistent quality.
Care must be taken while installing this accessory to ensure damage does not occur to the vehicle. Use approved guidelines to insure a quality installation.

These guidelines can be found in the “Accessory Installation Practices” document.

A. Installation Preparation

1. Verify that the part is for the correct vehicle model and that it fits the vehicle properly.

2. During installation, the vehicle, the part, and the tape MUST be between 60° and 110° F for proper adhesion. Failure to maintain proper installation procedure may result in the part not functioning correctly.

3. Inspect the vehicle for damage prior to installing the Fender Flares.
   i. Paint: Prepare part surfaces per Toyota paint standards. Do not use lacquer thinner or enamel reducer as a degreaser.

4. Install Edge Trim.
   i. Peel red plastic liner from adhesive strip. (Fig. A1)
   ii. Apply to the edge of the flares, starting at one end of the outside of the flare and working to the other. (Fig. A2)
   iii. Apply to the edge of the Outer Door Piece, starting at one end of the outside and working to the other. Stop edge trim at bottom edge of door.
5. Make sure that all Front Flare, Rear Main Flare, and Rear Door Piece installation surfaces are free of dirt and/or grease. (Fig. A4, A5, A6)
   
i. Use a clean, lint-free cloth and isopropyl alcohol-based cleaner.

B. Install Inner Door Piece Part
1. Install #8 Spring U-Clip over holes in Inner Door Piece. Three locations. (Fig. B1 and B2)
2. Start to peel red vinyl liner from tape at top of Inner Door Piece, folding tabs toward the outer curvature of the part and ensuring that inner liner is behind the outer liner. (Fig. B3)
3. Start to peel white vinyl liner from tape at bottom of Inner Door Piece, folding tabs toward the outer curvature of the part and ensuring that inner curvature is behind the outer liner. (Fig. B4)

**NOTE: PROPER ALIGNMENT OF INNER DOOR PIECE IS CRITICAL TO CORRECT FIT AND ALIGNMENT OF OUTER DOOR PIECE.**

4. Open rear door and position Inner Door Piece on door.

5. At top of part, align Inner Door Piece such that the breakaway tab hooks over the door lip. (Fig. B5)

6. Pull gasket up to expose edge of door. Align Inner Door Piece Indexing Bump with edge of door. (Fig. B6)

7. At bottom of part, align Inner Door Piece to nest snugly to lower curvature of the door. (Fig. B7)

8. Ensure that tape tabs are accessible, top and bottom. (Fig. B8)
9. Pull red tape liner on the left (tape closest to edge of door). (Fig. B9)

10. Pull remaining red tape liner and press the Inner Door Piece firmly to ensure proper tape adhesion. (Fig. B10)

11. Pull white tape liner at the top (tape closest to the edge of the door). (Fig. B11)

12. Pull remaining white tape liner and press the Inner Door Piece firmly to ensure proper tape adhesion. (Fig. B12)

13. Clamp the Inner Door Piece Clamp Fixture over the Inner Door Piece. (Fig. B13 & B14)

Note: Clamping fixture is only for PIO installation at this time.
C. Install Front Flare

1. Using a 10mm socket wrench, remove factory bolt at front underside of wheel well. Save for reinstallation. (Fig. C1 and C2)

2. Using a pry tool, remove two plastic factory fasteners. (Fig. C3 and C4)

3. Using a 3 mm Allen Wrench, remove two factory screws from rear of wheel well. Save for reinstallation. (Fig. C5 and C6)
4. Using a pry tool, remove two plastic factory fasteners at top of wheel well and one at lower rear of wheel well. (Fig. C7 and C8)

5. Pull wheel well liner out from behind fender lip. (Fig. C9)

6. Install Mylar Tab over factory hole locations behind wheel well liner. Two locations. (Fig. C10)

7. Slide #10 U-Clip over factory hole locations behind wheel well liner. Two locations. (Fig. C11)

8. Using awl to poke hole through Mylar Tab using Clip installed in Step 7 as a guide. (Fig. C12) With clip installed, tuck liner back in.
9. Identify left side and right side Front Flare Inner Pieces. Parts are marked with an "L" for left side and an "R" for right side.

10. Install #10 U-Clips at two locations on Front Flare Inner Piece. (Fig. C13 and C14)

11. Hold front flare inner piece in wheel well with angled hole locations aligned with clips installed on wheel well lip in Step 6. Using a #2 Phillips Screwdriver, install #10 x 5/8" Phillips Truss Screws through front flare inner piece, through wheel well liner, and into clip. (Fig. C15)

12. Make sure that the corners of the Inner Piece are mounted flush with the sheet metal.

13. Hold flare to vehicle. Start #10 x 5/8" Phillips Truss Screws through two uppermost locations with #2 Phillips Screwdriver. Do not tighten. (Fig. C16 and C17)
14. Using a #2 Phillips Screwdriver, install #14 x 3/4" Phillips Truss Tapping Screws through two frontward locations inside wheel well. Do not tighten. (Fig. C18 and C19)

15. Start factory bolts removed in Step 3 using a 3mm Allen Wrench. Do not tighten. (Fig. C20 and C21)

16. Using a 10 mm socket wrench, reinstall factory bolt removed in Step 1 by threading through flare. (Fig. C22)

17. Install a Tuflock through flare and into sheet metal of wheel well where rear and lowermost panel retainer was removed in Step 4. (Fig. C23)
18. Once all hardware is started, check flare for proper positioning. Apply pressure at each fastening point and tighten all screws and bolts. (Fig. C22)

D. Install Rear Main Flare

1. Hold flare to fender. Rotate the bottom of the flare ½" away from vehicle and mark two Clip locations with a grease pencil on the fender even with flare holes. (Fig. D1 and D2)

2. Remove flare from fender. Center a supplied Mylar Tab over each mark made in Step 1. (Fig. D3)

3. Install one #10 Long U-Clip over each Mylar Tab. (Fig. D4)
4. Using a 5/16" drill bit, drill two holes in wheel well lip at rear of wheel well. Use lowest dimple and third lowest dimple in wheel well lip as a guide. (Fig. D5)

5. Install #10 U-Clips at each of the locations drilled in Step 4.

6. Hold flare to vehicle and start #10 x 5/8" Phillips Truss Screws through flare and into clips installed in Step 3 & Step 5 using #2 Phillips Screwdriver. Four locations. (Fig. D6) Apply pressure at each fastening point, and tighten all screws.

E. Install Outer Door Piece Part

1. Break plastic tab off of Inner Door Piece. (Fig. E1)

2. Remove Inner Door Piece Clamp Fixture.

3. Position Outer Door Piece over Inner Door Piece, checking for proper alignment of top of Outer Door Piece with the edge of the door. (Fig. E2)

4. Using a #2 Phillips Screwdriver, start supplied #8 x 3/4" Washer Pan Head Screws through Outer Door Piece and into clips installed on Inner Door Piece. Three locations. (Fig. E3)
5. Close door and check for proper alignment between Door Piece and Rear Main Flare then apply pressure at each fastening point and tighten all Door Piece screws. (Fig. E4)

6. At bottom front of Door Piece, using the hole in part, use a drill with 1/4” drill bit to drill through sheet metal. (Fig. E5)

7. Install a Tuflock through hole drilled in Step 12. (Fig. E6)
Checklist: These points MUST be checked to insure a quality installation.

Vehicle Function Check:

Accessory Function Check

☐ Check Rubber Molding for Gaps
☐ Check All Hardware
☐ All Flares

Look For:

☐ 1mm or Less for Gaps
☐ Proper Fit and Tightness
☐ Proper Alignment

Part Number List:

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Color</th>
<th>Code</th>
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<tr>
<td>00016-48140-02</td>
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<td>00016-48140-11</td>
<td>Magnetic Gray</td>
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