

*Custom Automotive Products*

## ***H1 Hummer Fender Flare Installation Instructions***

Ver. 100514

There are many ways of installing Fender Flares, and some like to use their own particular method. The directions below are only one of those ways.

GT Flares are of Urethane construction, and as such are reasonably flexible to avoid damage from door swingers in the parking lots, cracks from temperature differences, and slight off roading mishaps, but they are not indestructible.

Do not allow anyone to open the hood using the front hood flare as a handle, it is not designed to be used in that manner, and could be cracked or broken loose if you do.

Installation of Urethane flares is best accomplished in a warm environment, not in freezing temperatures, but if you must install in those temps, it might be best to keep a small heat gun or hair dryer handy to slightly warm the flare during installation. DO NOT over heat the flare; room temperature is all that is needed!!!

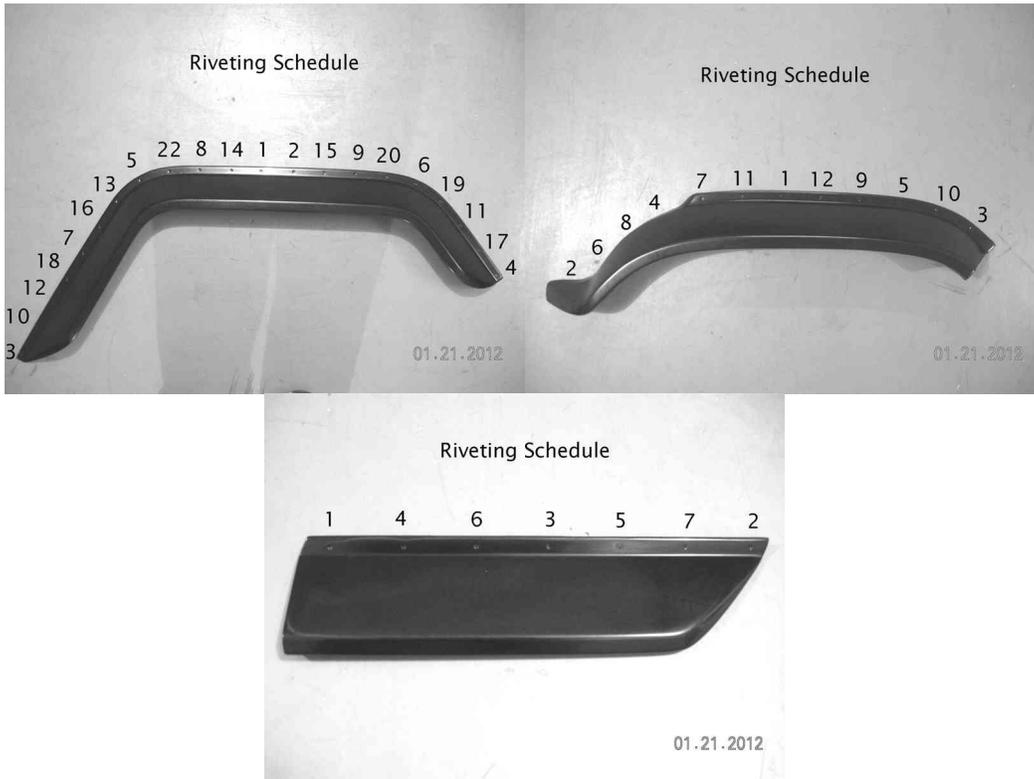
### ***INSTALLATION OVERVIEW***

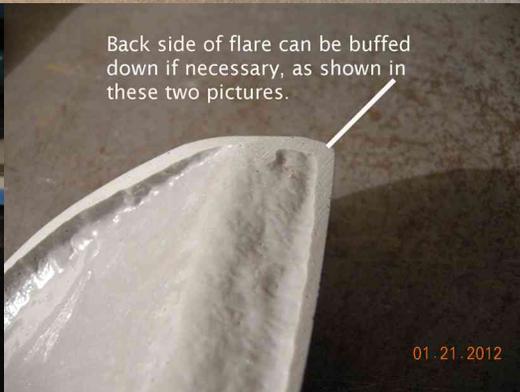
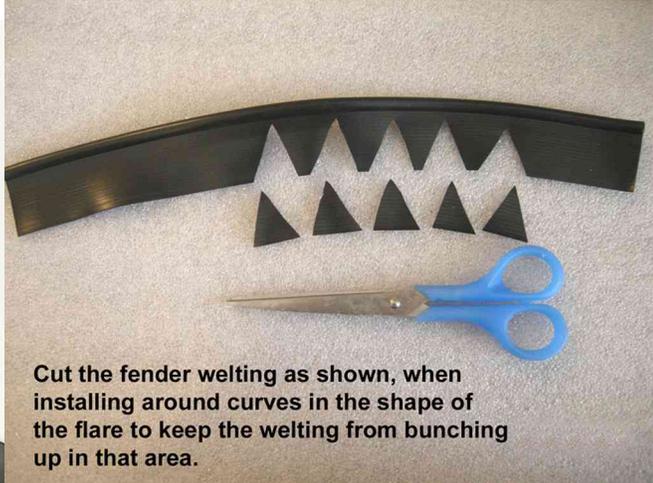
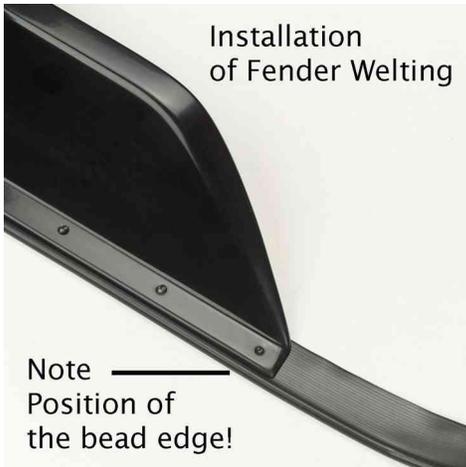
In short, drill out the marked holes in the flare, trim, rout, or cut out the portions of the flare to fit your specific truck as shown here, and on our website. After initial fit has been determined to be complete, it is time to paint the flares if you plan to do so. Now, install the flares using the black fender welting between the flare and the body, by pop riveting it to the truck. Please read the more detailed instructions and suggestions below before starting the installation procedure. You should have on hand the tools listed below to effect the installation.

## SUGGESTED TOOL LIST

- [ *Pop Rivet gun, either hand or air operated.*
- [ *A Router, Small Hand Saw, Dremel Tool or Similar.*
- [ *Duct Tape, 2" Wide Masking Tape, or Similar.*
- [ *Small Sharpie Pen or other small point felt tip marking pen.*
- [ *Small drill motor.*
- [ *2 – 1/8" Drill Bits*
- [ *Count the pop rivets and measure the length of the fender welting.*
- [ *Count all parts to make sure you have the correct amount.*
- [ *A friend or assistant to help makes it a lot easier.*
- [ *In cold temperatures a heat gun or hair dryer to warm the flares.*

## RIVETING SCHEDULE FOR GT H1 FENDER FLARES





**INSTALLATION PICTURES WITH TRIMMING**  
**"SEE OUR WEBSITE FOR MORE PICTURES"**





***There is an alternate installation method, where the rear flares are placed slightly lower in the rear so that there is no need to trim the flares to clear the fuel filler or marker light. Alternate installation method for the front small flare parts it so simply use a hair dryer or heat gun to "Warm" the flare part and mold it over the rocker panel protection, if installed" and then rivet that part of the flare to the rocker panel flat area. Remember, when heating the flare to form it to the rocker panel, it should not be hot, only warm enough to form it over the rocker panel protection!!!***

1. Using a 1/8" drill bit, drill out the pre-marked dimpled insets on each of the 6 fender flare pieces. These instructions assume that you are starting with the rear flare pieces first, then the larger of the front two flares, then finally the smaller lower front fender well piece.
2. Per pictures on our website, place the flares against the body in their respective location, adjust accordingly, then tape the flare in place at several points along the body, but do not cover the drilled holes. When you can see that the flare is level, and visually in the correct spot, mark the areas that must be trimmed, per the pictures on our website, mark the top 2 center holes in the flare you previously drilled, then make a few small marks on the body in four locations so that after you trim the flares, you can quickly put the flare back in the same spot to verify that flare is in the same location, and check to see if you have trimmed the flare to clear any areas of interference. You may want to cut very little at a time to make sure you don't cut too much away from the flare part. REMEMBER, you can always cut more, but cannot replace what you've already cut off!!

3. Once you are satisfied with the fit of the flare in its specific location, drill the top 2 center holes at the marks you made previously, but only those 2 holes. The flare can now be painted to match the truck, or proceed with the installation if you are going to install them in their gloss black finish. During the fit installation process, it may be necessary to buff off some excess urethane on the back of the flare to make a tighter, closer, and more even fit against the body. See Pictures Included.
  
4. Now that the flare fits properly, and is trimmed to clear things such as the marker lights, fuel openings, rocker panel protection, grille guards, etc., cut the black fender welting to the appropriate length of the flare part. Hold the welting in a small area of the flare at the center top of the flare, so that you will have no more than 1" excess at each end of the flare. Using an Awl, or other small pointed object, or the nail end of the pop rivet, and insert that tool through the hole in the flare and through the black fender welting. Take the pop rivet and insert it through the hole in the flare and through the welting so that the pop rivet end is holding the welting in the correct location, which is with the round beaded part of the welting sitting tightly against the top edge of the flare. Now holding the flare, welting and pop rivet, insert the head of the pop rivet into the appropriate hole in the body, but do not fasten the rivet at this time. Move the welting around to clear, and tape the flare in place using the marks you made earlier to be certain that the flare is in the correct location on the truck, is level and fits according to the pictures on our website. If not, then you may have the pop rivet in the wrong hole. Readjust and check for fit. If the flare is level and in the correct location on the vehicle, repeat the process for the next rivet hole that you previously drilled. Again check for level and fit, and if the flare is located properly, then set both those pop rivets with your rivet tool, remove any tape on the flares and you are ready to finish the installation of all pop rivets on that flare.
  
5. Now that you have the top 2 rivets installed, you can check the fit of the flare, put the welting behind the remaining part of the flare, tape it in place if necessary, then move the end of each flare into place, double check the location, then drill the hole at the end of the flare through the body, punch a hole through the welting as before and set that pop rivet. Go to the other end of the flare and repeat that process.

6. You now have the top 2 rivets set and the end rivets set. Mark and drill the remaining holes one at a time, but split the difference left between all rivets as you pop them into place to make sure you don't end up with part of the flare lifting up because you started the rivets and just went in a straight line up the flare. See the riveting diagram!
7. Once you have the rear flares installed, next go to the larger of the two front flares, which is the one that fits on the hood of the truck. Again, make sure you check the alignment and see the riveting diagram.
8. Next to the smaller of the two front flare pieces, align per the pictures, so that it fits in line with the hood flare piece, and follow the riveting diagram for that part. Once done you should have a fit and finish exactly the same as the pictures shown. When fitting the smaller front flare part to the body, you will want to make absolutely sure that you check the alignment of that part to be certain it lines up with the hood flare piece, is in a straight line from the hood flare piece, and there is approximately 1/2" minimum clearance between the two parts. If not, then you could end up with the hood flare piece hitting the body flare part as the hood moves while off roading.

It is extremely important that you take your time, and do not rush this project, and you will end up with a perfect installation. If you rush the install, you may end up with one that does not look as well as you might like.

If you have any questions, please call GT at 1-949-394-1578 or email us at [hummerproducts@cox.net](mailto:hummerproducts@cox.net) before proceeding, we want you to be completely satisfied with our flares and your installation.

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