NOTE:
These instructions for installing Spray Master® fenders are intended to be a general guide to help the installer. Because of the large number of possible mounting configurations, the installer is responsible for the installation design and for providing adequate clearance around the tire carrier (i.e. tire clearance, trailer clearance, etc.) This product may not fit all truck models or types of suspensions. Check truck or trailer manufacturer for suspension travel specifications. Modifications to the brackets and/or the fenders may be required. Any modifications are at the discretion, responsibility and risk of the installer and may void warranty.

The figures below show the general locations of mounts on single and double radius fenders (E = end mount / C = center mount).

NOTE:
The Spray Master® single radius fender is not universal; there is a left hand fender (roadside) and right hand fender (curbside). The “hidden pocket” opening is always positioned towards the vehicle frame.

Step 1
Position the fender upside down, making sure to protect the top side from getting scratched, etc. Take two center connector clamps and, with the square holes facing outward, slide over the fender center cap. Align with the holes in the fender and secure with 2” bolts and lock nuts. Torque to 16 ft. lbs.

Step 1A
For Double Radius Fender Only (if mounting Single Radius, go to step two). To make a Spray Master® Double Radius Fender, two Single Radius fenders sets are required. Take both a roadside and a curbside Single Radius fender and position them upside down, making sure to protect the top side from getting scratched, etc.

Step 2
Slide a hidden mount tube with the threaded insert end first, through the hidden pocket opening over to the center rib support. Attach to the center rib support with a 1.5” bolt and washer but do not engage thread locking compound yet, just start bolt up for positioning purposes.

Step 2A
If installing a double radius fender, do step two to both fenders.

Step 3
Insert two T-nuts into each hidden end mount clamp from inside clamp tube hole. Hold T-nuts in place while sliding over the mounting tube. Do not slide hidden end mount clamp over ribs on fender. See illustration on other side.

Step 3A
If installing a double radius fender, do step three to both fenders.
On the frame side of the fender, position the hidden END mount clamp (with tube) as necessary to select an existing hole or mark a space on the frame to drill a new hole. Make sure the tube is square to the frame and mark the position of the hidden end mount clamp on the fender.

**NOTE:**
Flap weights are not recommended and may void the warranty. Painting Spray Master® fenders IS NOT recommended and may void the warranty. If painting is desired use Valspar Plastic Enamel for best results.

**Step 6**

If installing a double radius fender, do step six to both ends of fenders.

**Step 7**

Adjust the center mount tube to select an existing hole if available, or mark a space on the frame to drill a new hole.

**NOTE:**
Be sure to follow truck or trailer manufacturers recommended procedures for drilling any required holes in the frame.

**Step 8**

Remove fender from over tires and drill hole(s) if necessary. Engage hidden mount teeth of clamp onto the hidden pocket teeth of the fender and push firmly until they seat over top and bottom ribs. A tap or two with a soft faced hammer may be needed. Torque bolt at center rib support to 38 ft. lbs.

**NOTE:**
If clamp removal or reposition is necessary, an outward tap with a soft faced hammer will disengage it from the ribs.

**Step 9**

Mount tube casting sleeve to the truck frame at the end mount location. See installation sheet INS-03028.

**Step 10**

Position the fender back on the vehicle and connect the END and CENTER mounts to the vehicle. Check to make sure the fender is centered over the tires. (In a few cases it may be necessary to shorten the hidden mount end tube. If this is the case, be sure to cut the non threaded insert end only!) Tighten all bolts to proper torque. Install the set screws in both the center connector clamps and hidden end mount clamps and tighten to a maximum torque of 48 in. lbs. +/- 3 in. lbs. or 4 ft. lbs. **CAUTION: Do not overtighten.** Install end caps on center mount tube per installation sheet INS-20014. Peal plastic off fender reflectors.

**Step 4**

Insert a T-nut into each of the two center mount connector clamps from inside the tube hole. Select either a bent tube or the Master Multi-Mount straight tube for the center mount.

**NOTE:**
The bent tube uses either a 1.37 or a 1.87" tube opening connector clamp while the Master Multi-Mount center mount uses a 1.37" tube opening connector clamp). Take the mounting tube selected and slide through both connectors while holding the T-nuts in the connector clamp in place. If using the Multi-Mount, assemble castings to the straight tube using installation sheet INS-03029 for position purpose only.

**Step 5**

Flip fender back over and position over tires. If installing a Double Radius Fender, watch for “pinched” finger at center connection. Use 2 x 4 blocks or other suitable spacers to achieve desired clearance around tires. (S.A.E. recommendation is 3” minimum).

**NOTE:**
If you have an air suspension, make sure there is tire clearance when the suspension is deflated.