



103100 – BRKT-K,SS4578,SST

Fender Mounting Instructions for Minimizer Series 9020, 4020, & TR4020

SS4578 Mounting Kit

Table 1- Bill of Materials

| ITEM NO. | PART NUMBER | DESCRIPTION | QTY. |
|----------|-------------|-----------------------------|------|
| 1 | PB5015 | BRKT,5015,STL,SWVL,4.25,BLK | 4 |
| 2 | 101461 | BRKT,TUBE,SST,26L | 4 |
| 3 | 100234 | BRKT,CNTR,PE,SPRSNGL,17 | 2 |
| 4 | PB5067 | BRKT,5067,STL,CNTR,ANGL | 2 |
| 5 | PBRDR111069 | HDWR,CAP,PE,BLK | 4 |
| 6 | 101546 | HDWR-K,4.5ASSY,RBZ | 4 |
| 7 | 101551 | HDWR-K,2.5ASSY,RBZ | 2 |
| 8 | 100212 | BRKT,CNTR,STL,BLK,16L | 2 |
| 9 | 101552 | HDWR-K,5069,RBZ | 2 |
| 10 | 101554 | HDWR-K,5071,RBZ | 2 |
| 11 | PB5053 | BRKT,5053,GLV,CLMP,TUBE | 2 |
| 12 | PB100H | HDWR-K,U-BLT,SST | 2 |
| 13 | 101558 | HDWR-K,TNDM-FNDR,RBZ | 1 |
| 14 | XBKT | BOX,32X8X7,CBRD,ECT44,MNZR | 1 |
| 15 | XLINER | BOX,20X7X0,CBRD,ECT32 | 2 |

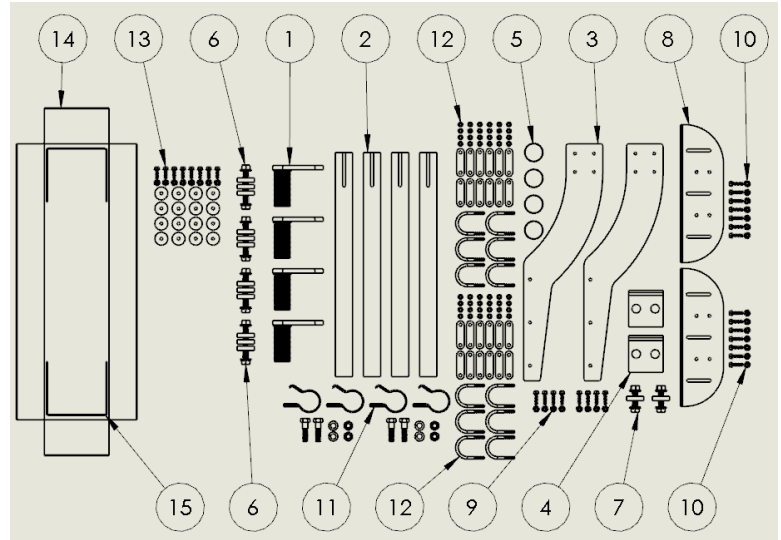


Figure 1

STEP 1

- A. Unpack all cartons and lay out parts shown in Figure 1.
- B. Reference Table 1 and Figure 1 above to identify the parts and confirm quantities.

STEP 2

- A. Lay the fenders out and clamp them together (Figure 2). This will make bolting them together much easier.
- B. Bolt the fenders together. A pack of 5/16 x 1" bolts, 5/16" nuts and 5/16" x 1- 1/2" fender washers is included in the kit. **Use three bolts per joint and torque bolts 10-15 ft-lbs.**



Figure 2

STEP 3

- A. Measure the suspension travel. This measurement is used to determine the clearance required between the fender and the wheel.
 - a. For air suspension systems, let the air out of the air bags.
 - b. For spring systems, measure from the stops on the springs to the bottom of the frame.

NOTE: For air suspensions with travel exceeding 6”:

In some cases a travel stop may need to be installed to reduce excessive clearance between fenders & tires. This will help with alignment and 5th wheel plate clearance. (Please call *Minimizer @ 800-248-3855* for questions regarding this issue).

- B. Raise the fenders $\frac{3}{4}$ ” over the maximum travel point of the suspension system. The purpose of the gap is to ensure the fender does not rub on the tire. A gap larger than $\frac{3}{4}$ ” may be necessary if using worn tires.

TIP: Establish the minimum gap distance required in Step 3B.

- a. For an air suspension system, place a $\frac{3}{4}$ ” board on top of the tires after the air is released from the airbags (Figure 3). Place the fender on top of the board.
- b. For a spring suspension system, add $\frac{3}{4}$ ” to the measurement from Step 3A.

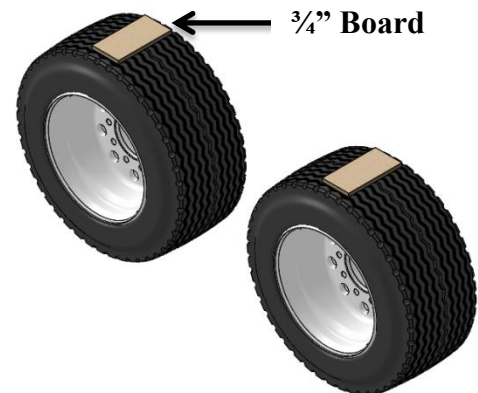


Figure 3

STEP 4

- A. Position the fenders exactly where they will be mounted.
 - a. Visually pick and mark the locations that the brackets will bolt or weld to the frame (depending on mounting kit).
- B. Try to use existing holes in the frame to bolt through. It is possible to remove any existing frame bolt and replace it with the supplied bolt in the bracket kit. If possible avoid placing brackets directly on suspension shackle mounting bolts.

Tip: It is common for the front bracket to align with the existing quarter fender holes and the rear bracket to align with the holes left from the mud flap hanger.

NOTE: Depending on the length of the truck frame and the placement of the mud flap hangers, the fender may tuck inside the mud flap hanger.

- C. Spacers are supplied to bring the steel swivel away from the frame in the event of any obstructions (Figure 4).
 - a. The ideal setup is to mount the steel swivel directly to the frame.

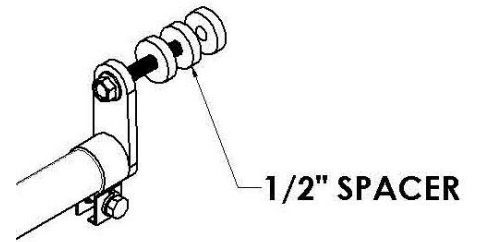


Figure 4

NOTE: Use spacers only when necessary.

- D. If possible, position the brackets on the leading edge of the fender within 15" of the bottom of the fender to avoid wind blowing the fender back into the tire (Figure 5).

Tip: If the front fender bracket is mounted higher than 15", refer to <http://www.minimizer.com/instructions.html> for suggestions on adding additional support

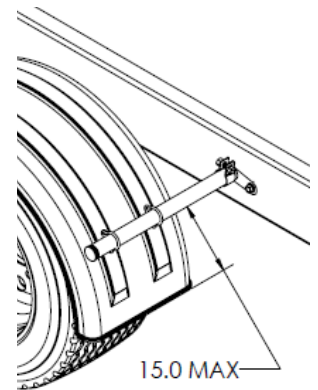
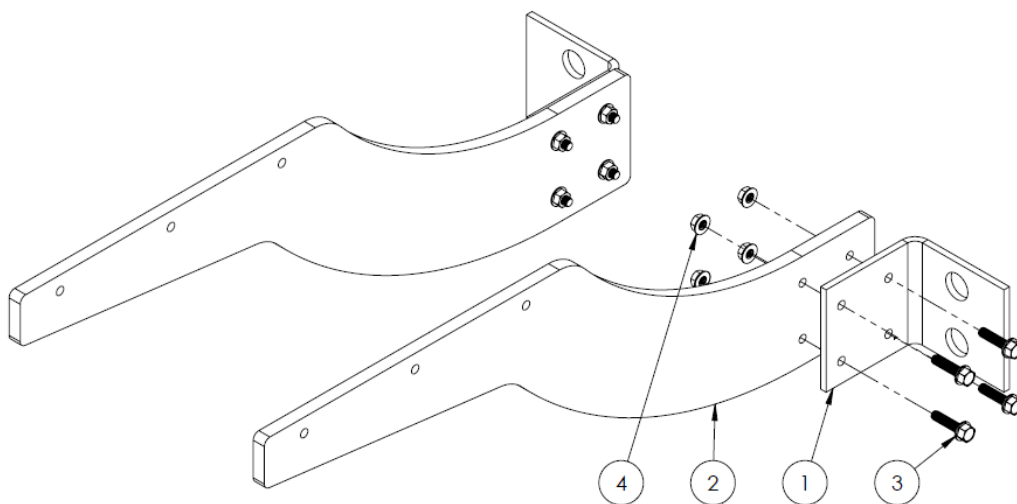


Figure 5

- E. Assemble the center bracket assembly (Figure 6).
 - a. Assemble a left hand and right hand arm assembly as shown in Figure 6.
 - i. **Note: the head of the bolt must be on the metal plate side.** Placing the serrated edges of bolt head against the plastic will damage the plastic arm.
 - ii. **Recommended torque for all 5/16" hardware is 10-15 ft-lbs.** Overtightening the hardware will damage the plastic arm and could cause it to fail.
 - iii. If the locknut is ever loosened after the initial installation it is highly recommended to replace the locknut.



| ITEM NO. | PART NUMBER | DESCRIPTION | QTY. |
|----------|----------------|--------------------------------|------|
| 1 | PB5067 | BRKT,5067,STL,CNTR,ANGL | 2 |
| 2 | 100234 | BRKT,CNTR,PE,ARM,SPRSNGL | 2 |
| 3 | I31C125BSF/RBZ | HDWR,HHCS,RBZ,SERR,5/16-18X1.2 | 8 |
| 4 | I31CNCF/RBZ | HDWR,NUT,RBZ,FLNG-LOCK,5/16-18 | 8 |

Figure 6

- b. Try to use existing holes in the frame to bolt through. It is possible to remove existing frame bolts and replace it with the supplied bolt in the bracket kit. If possible avoid placing brackets directly on suspension shackle mounting bolts. **Recommended torque for the 5/8 x 2-1/2" bolt with washer is 110-115 ft-lbs.**

F. Install center bracket as close where the two fenders join together as possible (Figure 7).

- a. Drill three 5/16" holes through the fender using the holes in bracket 100234 as a guide.
- b. Use three 5/16" x 1 1/4" bolts to bolt the center bracket and fender together.
- c. Use 5/16" fender washers and 5/16" nuts provided with the kit on the inside of the fender. **Recommended torque for all 5/16" hardware is 10-15 ft-lbs.**

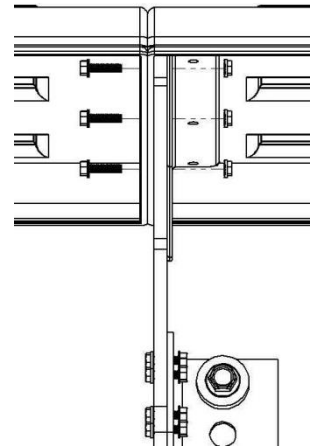


Figure 7

G. Some installations may not allow the center bracket to bolt through the end of the fender.

- a. In these cases use the formed steel angle (100212) to connect the fender to the center bracket assembly (Figure 8).
- b. Use three 5/16" x 1 1/4" bolts, washers, and nuts to bolt 100212 angle to the center bracket assembly. Do not tighten the bolts until the fender is level. **Recommended torque is 10-15 ft-lbs.**

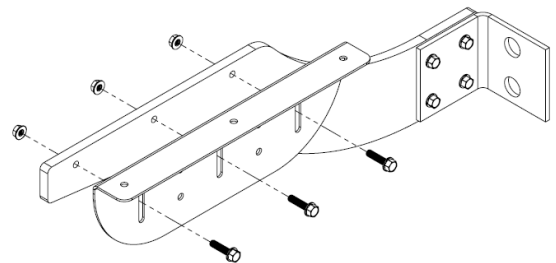


Figure 8

Tip: 100212 may also be used as a height adjustment for the end of the fender.

H. Drill three 5/16" holes through the fender using the holes in bracket 100212 as a guide (Figure 9).

- a. Install the 5/16" x 1 1/4" bolts through the fender and into the bracket.
- b. Use 5/16" nuts provided with the kit on the underside of the fender.
- c. **Recommended torque for all 5/16" bolts is 10-15 ft-lbs**

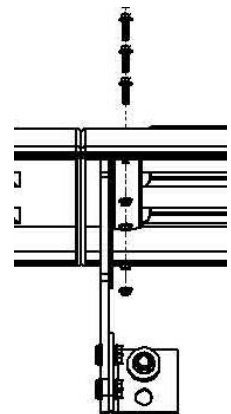


Figure 9

STEP 5

- A. Slide the stainless clamp (part number PB5053) and the mounting tube (part number 101461) onto the steel swivel (part number PB5015).

Place plastic end cap (PBRDR111069A) into the end of the mounting tube (Figure 10).

Tip: Make sure the slot on the mounting tube is facing down towards the ground.

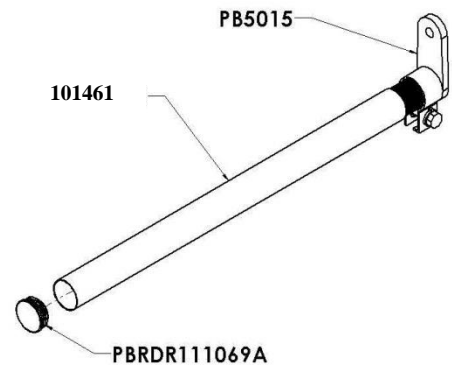


Figure 10

STEP 6

Once the brackets are placed in position with the fender, securely tighten the 5/8" x 4-1/2" bolts that go through the PB5015 steel swivel to attach the swivel securely to the frame (Figure 11). **Recommended torque is 160-170 ft-lbs.**

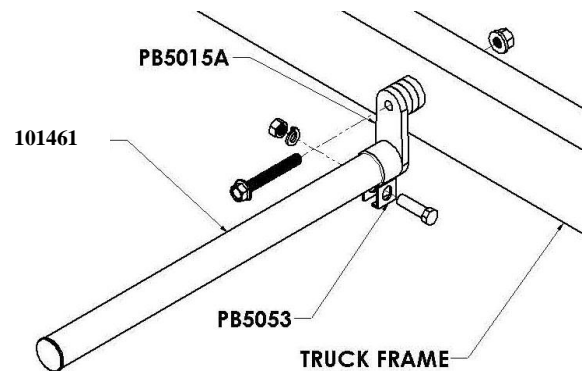


Figure 11

STEP 7

Position the tube clamp 1/4" away from the end of the stainless tube. **The recommended torque for tightening the stainless clamp is 30 ft. lbs.** Figure 12 shows an over-tightened tube clamp and Figure 13 shows a properly tightened tube clamp. **Over tightening the tube clamp will cause the clamp to make uneven contact and cause the tube to loosen up over time.**

Over-tightened clamp



Figure 12

Properly tightened clamp



Figure 13

STEP 8

- A. Attach the bracket 101461 to the fender.
 - a. Drill 5/16" holes through the fender using the holes in the fender washers as a guide.
 - b. Install the 5/16" x 2 1/2" x 3 1/2" U-bolts through the bracket and into the fender. Use two U-bolts per fender bracket tube. The kit contains four extra sets of U-bolts, washers, and nuts.
 - c. Use two fender washers per U-bolt.
 - d. Place one washer on the inside and outside of the fender.
 - e. Make sure the fenders are square and aligned (Figure 14). Twists or bows in the fender will fatigue the material over time.
 - f. Tighten the U-bolts. **Recommended torque is 75-90 in-lbs. Do not exceed recommended torque.**

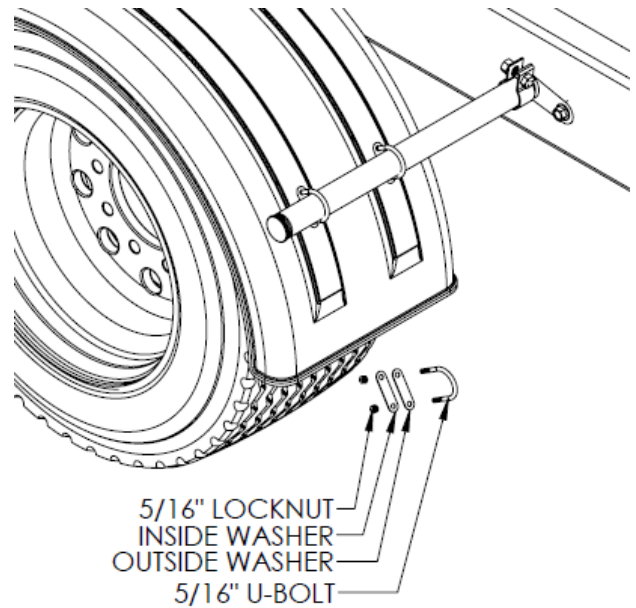


Figure 14

STEP 9

- A. For trucks with air suspension, raise and lower the suspension one final time to confirm that there is adequate clearance between the fenders and wheels.
- B. Recheck all brackets and bolts to ensure they are tightened to the recommended torque.

NOTE: ONCE FENDERS ARE IN SERVICE, OCCASIONALLY CHECK TORQUE ON THE 5/8" X 4-1/2" HEX BOLTS IN THE FRAME TO MAKE SURE THEY DO NOT LOOSEN OVER TIME.