FLEET ENGINEERS

Installation Sheet #INS-07034

Spray Master® Single SRX-22/Double DRX-22 Radius Installation Instructions

Patent 7384071

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).

Double Radius

Single Radius

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.
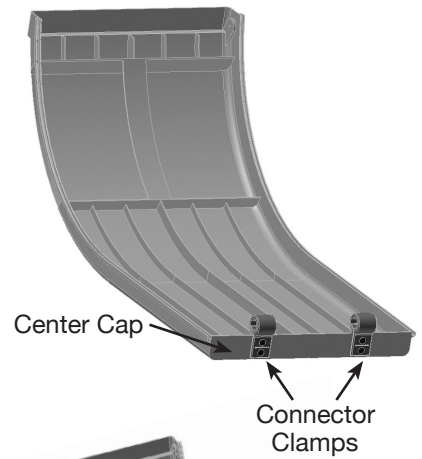
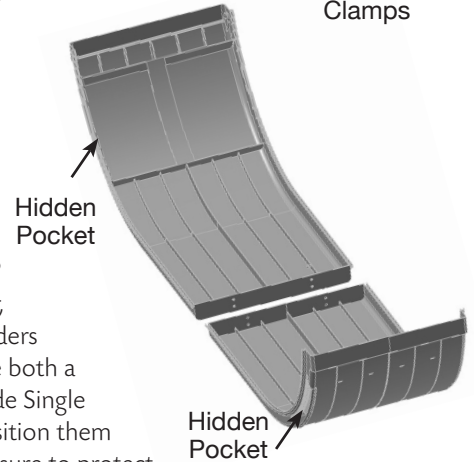**Left hand (roadside) shown**

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.
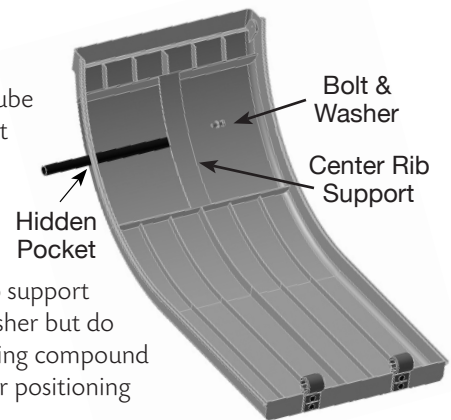
Center Cap

Connector Clamps

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. Both hidden pockets must face the same way - if not, you have either two roadside or two curbside fenders. Align the holes of the center caps of each fender together and slide the two center connector clamps into position over the two sets of holes on the fender center cap surface. Secure the connector clamps with 2" bolts and lock nuts. Torque to 16 ft. lbs.

Hidden Pocket

Hidden Pocket

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.

Bolt & Washer

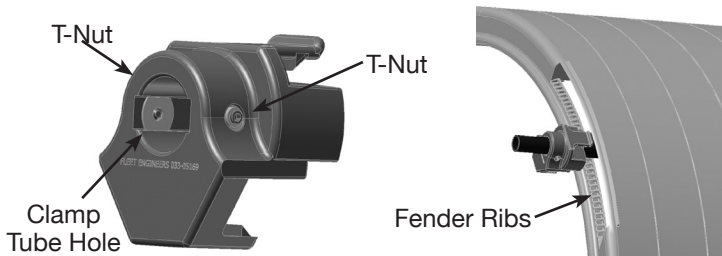Center Rib Support

Hidden Pocket

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.

T-Nut

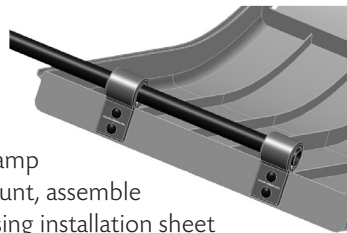**T-Nut**
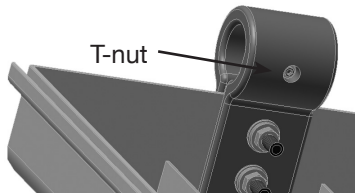
Clamp Tube Hole

Fender Ribs

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.

T-nut

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.
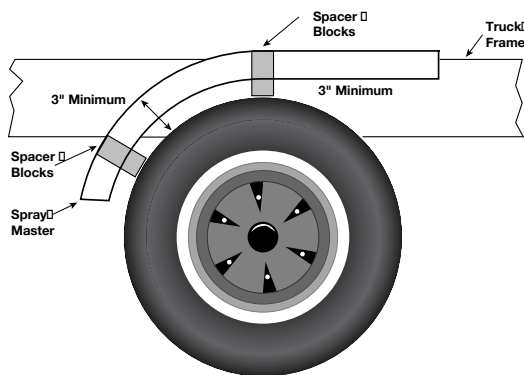
Step 5

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).
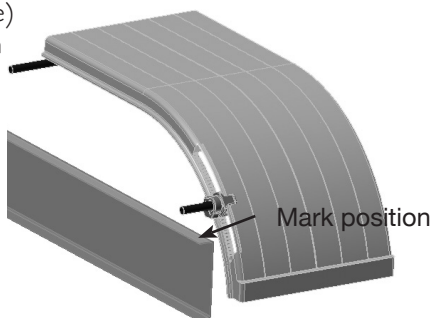
NOTE:

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

Spacer Blocks

Truck Frame

3" Minimum

3" Minimum

Spacer Blocks

Spray Master

Step 6

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.
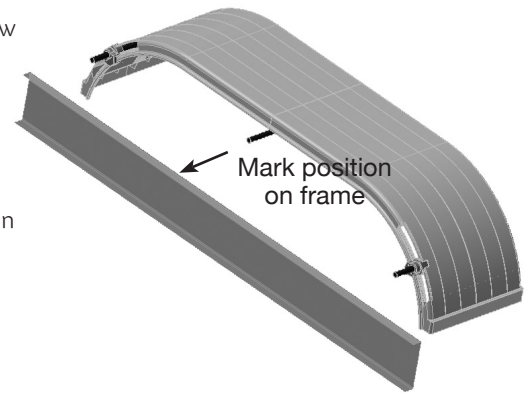
Mark position

Step 6A

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 an new hole.

NOTE:

Be sure to follow truck or trailer manufacturers recommended procedures for drilling any required holes in the frame.
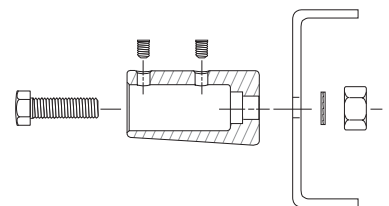
Mark position on frame

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. +/− 3in. lbs. or 4 ft. lbs. *CAUTION: Do not over tighten.* Install end caps on center mount tube per installation sheet INS-20014. Peal plastic off fender reflectors.

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.