

Phoenix Customs - Fender Bracket Installation Sheet

Phoenix Customs would like to take this opportunity to say thank you for purchasing our fender brackets. Please read the entire instruction sheet prior to beginning the installation.

Note: It is recommended that removal of fender mounts should be performed by someone experienced with a die grinder and cut off wheel, as fender can easily be damaged.

Step 1: Remove front fender. This will require the removal of calipers and front wheel. (See figure 1 and 2)

Note: Remove the four alum spacers between forks and fender. These will not be reused.

Step 2: Mask off both sides of fender to prevent scratches. Do not cover the bottom rivets as measurements will be taken from these rivets. (See figure 3)

Note: A die grinder with a cut off wheel will be used in Steps 3 and 4 as portion of each fender mount will be removed.

Note: Have someone help secure fender while cutting.

Step 3: Using the die grinder scribe a line along the top of the hump just where it transitions to fender mount, as shown in figure 4 and 5. Continue to make passes along scribed line while being **VERY** careful not to break through to fender. When cut is almost through fender mount, stop and proceed to step 4.

Note: For fenders without this hump in the mounts, cut the fender mounts off flush with bottom edge of fender and drill holes through fender and the factory fender bracket. Then Proceed to note 6.



Figure 1



Figure 2



Figure 3

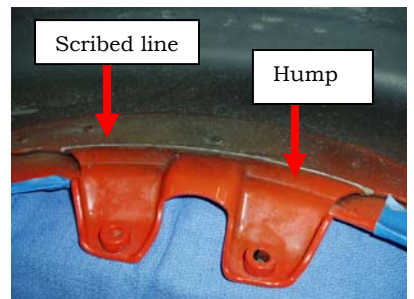


Figure 4

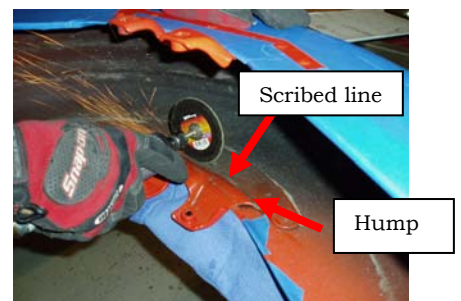


Figure 5

Fender Bracket Installation Sheet – Continued

Step 4: Attempt to bend mount back and forth until it snaps off. If mount does not bend easily it may be necessary to repeat cutting passes (step 3) to get cut sufficiently thin to allow mount to bend. (See Figure 6, 7 and 8)

Note: When bending mount back and forth be **VERY** careful not to actually bend the fender skin.

Step 5: Repeat on opposite side of fender.

Step 6: Remove sharp edges by grinding cuts smooth. (See figure 9)

Note: Again be **VERY** careful not to grind into the fender skin as it could burn or bubble the paint.

Note: The location given of these holes will lower fender approximately .750 ($\frac{3}{4}$ ") and tilt fender forward 4 degrees.

Caution: Holes can be drilled to any position, but great care must be taken to ensure that back of fender will not interfere with regulator or oil cooler when forks are compressed or handle bars are turned, as this would cause loss of control.

Step 7: Using a scale or straight edge against bottom edge of rivets scribe a line, as shown in figure 10.

Step 8: Draw a parallel line exactly .250 ($\frac{1}{4}$ ") above previous drawn line, as shown in figure 11.

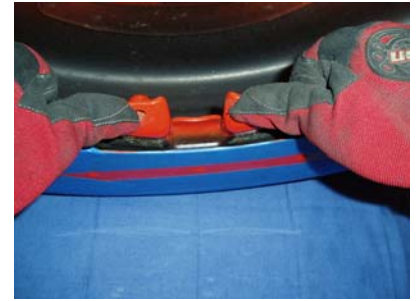


Figure 6



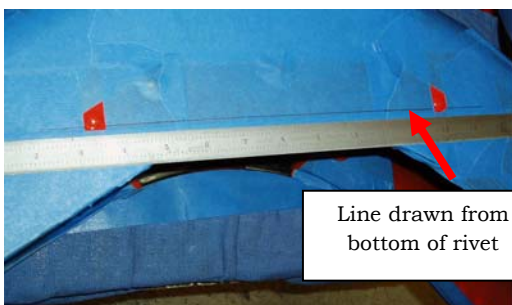
Figure 7



Figure 8

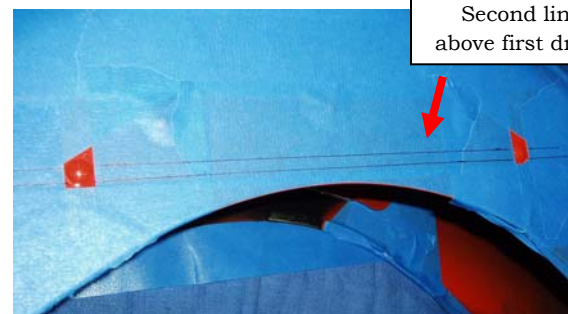


Figure 9



Line drawn from
bottom of rivet

Figure 10



Second line .250
above first drawn line

Figure 11

Fender Bracket Installation Sheet – Continued

Step 9: From the inside edge of each bottom rivet mark an intersecting line at 3.150, as shown in figure 12.

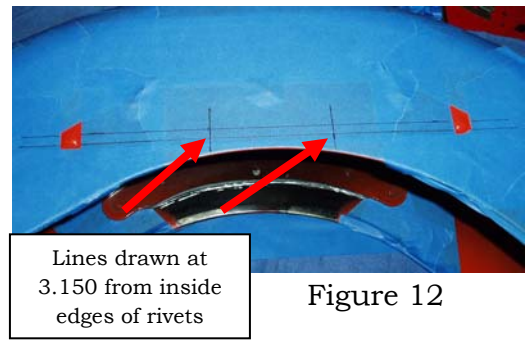


Figure 12

Note: After intersecting lines are made the distance between the two center lines **MUST** be **EXACTLY 3"**, as shown in figure 13.

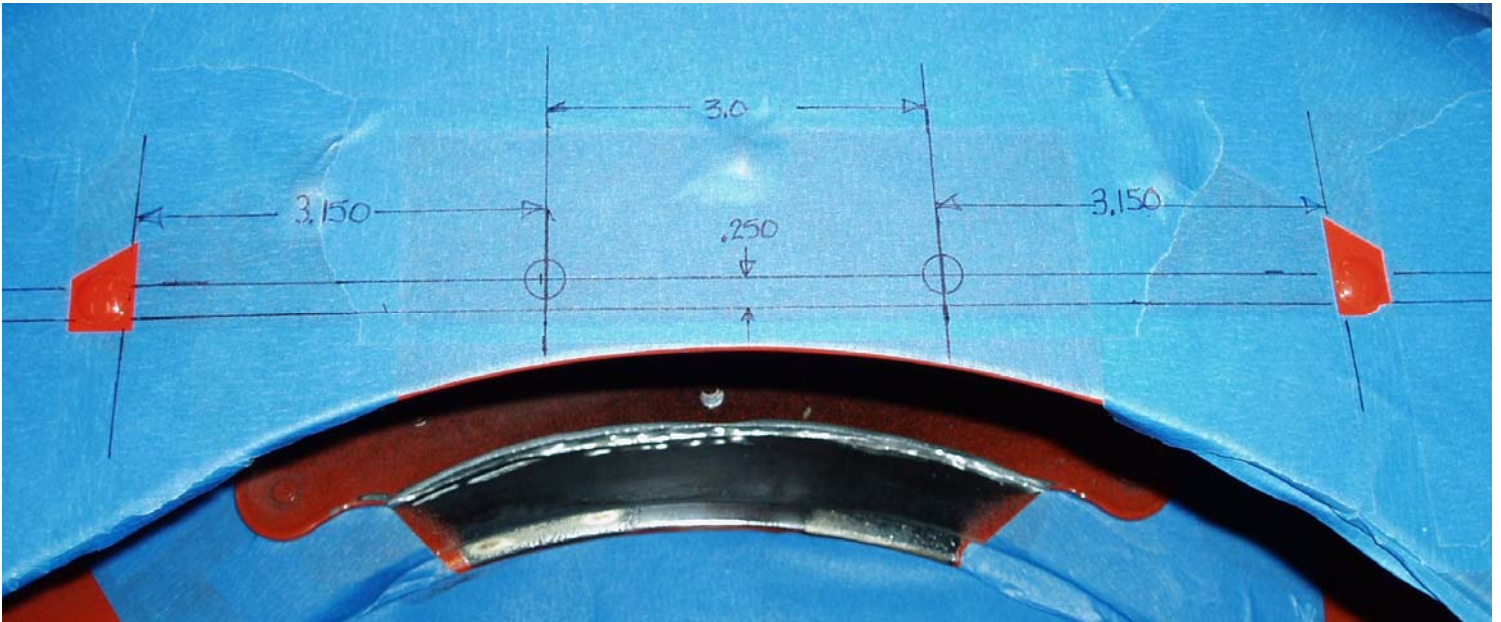


Figure 13

Step 10: Double check all previous dimensions and pre drill holes as shown using center drill or $1/8$ drill. Then open holes up to $5/16$ diameter. For best results a unibit should be used. (See figure 14 and 15)

Step 11: Repeat step 10 on opposite side of fender.

Step 12: Deburr drilled holes on the inside and outside of fender, as shown in figure 16.

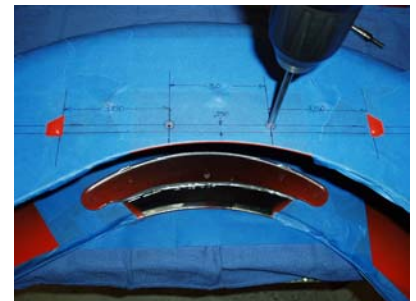


Figure 14

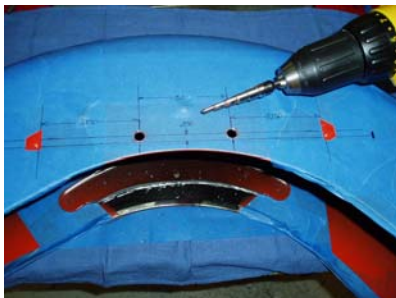


Figure 15



Figure 16

Fender Bracket Installation Sheet – Continued

Step 13: Clean area around the inside of mounts and spray with primer and then paint area to prevent surface rust.

Step 14: After paint dries remove masking tape and install new Phoenix Customs brackets using the supplied $\frac{5}{16}$ x $\frac{1}{2}$ " hex bolts with washers. Install bracket with the long side towards rear of fender, as shown in figure 18. For now bolts to be finger tight only.

Note: Apply a small amount of **BLUE** loctite on $\frac{5}{16}$ bolts prior to installing them.

Step 15: Re-install fender using the supplied $\frac{5}{16}$ x $1\frac{1}{4}$ " Allen bolts. **Tighten** bolts securely.

Step 16: **Tighten** the four $\frac{5}{16}$ x $\frac{1}{2}$ " bolts from step 14.

Step 17: Re-install front wheel, calipers and axle in this order, as calipers must be installed prior to axle.

Step 18: **Tighten** all bolts on caliper, axle and bottom of forks.



Figure 17 – Fender ready for new brackets



Figure 18



Figure 19 - Assembly Complete

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