Quick IS300 widebody installation guide

The Flowstate Widebody was designed on a **USDM IS300 sedan**. The front lip is made only for that bumper. Get a brand new one at carparts.com or find one on the used market. You can select a Sportcross Wagon rear quarter panel tail light/bumper trim path and that bumper needs one fastener for the lower rear corner of that overlay. Everyone will select side moulding profiles for different model years as seen in the product page gallery. The full 9pc wide body kit is designed to fit together with continuity. The width of the front lip & side skirts matches & flows into the fenders & quarter panels that are just as wide on the bottom as they are at the top dead center of the wheel arch. If you only buy our widebody fender & door/quarter panel flares there will be a gap that you would need to fill using DIY methods like spats, wide splitters, or canards on your existing narrow bumpers/skirts. The front & rear fenders are 50mm wider than stock. Shop car **wheel specifications**: REAR 18x10.5-19 265/35, FRONT 18x9-30 245/35 (stock arms) OR zero offset on a Parts Shop Max FLCA.

Materials & Tasks

*** Prerequisite -** fenders & bumpers need to be cut for clearance with a large radius for suspension & steering travel. Quarter panels need to be cut & radiused as well, & the gap must be closed by hammering, welding, & sealing with 3M 8115 panel bonding adhesive as demonstrated on our 4.5 million view Instagram reel @FlowStateAutomstion

1. Everyone must **paint or wrap** ABS for UV protection. Without UV protection, parts can fade & become brittle.

2. Standard solvent-based automotive **primer** or 2K sand-able primers will bite directly into raw ABS perfectly **without adhesion promoter**. At 3mm thickness, these panels are less flexible than typical bumper covers or urethane parts so there is **no need for flex additive** in the primer, paint or clear coat, & **wrap doesn't require primer**.

3. Prepare panels for primer or wrap with **600 grit wet or dry sand paper**, the standard for automotive coatings & wrap to adhere & **400 grit** will easily knock down any surface imperfections in these nice raw parts. Consider quarter rounding machine cut edges with a 1.5-3mm radius for the paint or wrap to lay nicely over the edges & especially on the iconic character line this kit highlights. The radius will catch the light on the surface beautifully.

4. We choose to attach panels to the vehicle using 3M double sided automotive panel tape for a smooth finish with no exposed hardware. There are 2 different panel tapes depending on the car being painted or wrapped..
- **3M 06382 automotive panel tape** will bond directly to your factory paint **OR**,
- **3M VHB 5952 tape** will bond to common vinyl wrap & PPF.

5. Apply adhesion promoter such as **3M 4298uv** where the tape is attached to the ABS panel for a bulletproof permanent install. ******* Do not apply adhesion promoter to the car paint or wrap because it will damage both finishes.

6. 99% **alcohol or wax & grease remover** will clean & prep the car before panel tape liner gets pulled. Wrap needs a more gentle 50% Isopropyl alcohol / distilled water mix.

7. The bottom of the front fenders & rear quarter panels have pre-drilled holes to attach the side skirts & front lip flanges securely with the **included M6 bolt plates, washers & flange nuts**. You can quickly install & remove nuts from the bottom with 1 tool. During initial mock up of the kit, before final installation, you can locate the 3D printed plates into the quarters & fenders & make sure the skirts/lip are lined up or see if holes may need to be ovalized. Mark the position of the 3D printed plates. Before final installation, degrease and use adhesion promoter on the ABS surface & attach the correctly positioned plates on your marks inside the panels by pulling of the red liner on the bolt plate's 3M paneltape. Once the plates are held in position, you can simply slide the skirts & lip up onto the bolts, being careful not to pop them out of their position in the plates.

8. Thin edges: The panel tape method works along the top & front edges of the rear door panel overlays & the top and rear of the quarter panel overlays, but there is no surface for taping the wide bottom edge of the door or the vertical parting line of quarter panel and door overlays, but there are a couple of great ways to attach these thin edges to the car. One trick is to use a 1" wide roll of clear PPF centered on the bottom & rear edge of the door panel overlay & the door itself. **Pro shield 3M 8mil PPF** rolls are sold as clear "door edge guards" on Amazon. **OR** for a permanent attachment to the OEM door and quarter, you can use **3M 8115 Panel Bonding adhesive** before doing body work & paint. Other methods like small aluminum DIY brackets could also be an easy solution.

9. Ideally, you will install this kit twice. Once for mockup of all panels so you can mark part position with a **grease pencil** & once again for final installation after finish is applied. Use the "dog ears method" for the 3M tape to mock up the position of the panels during the final install by fully pulling off the red tape liner & using firm, uniform pressure of at least 15 psi immediately across the entire bond line using a hard press for 60 seconds to initiate pressure-sensitive adhesive bond into the micro-texture of the substrate. 3M tapes take 1~3 days to fully cure. Use a **rubber J-roller** to guarantee even contact.

Of course there will be a full length YouTube video coming on this to show the above methods in great detail. We have posted short videos to @FlowStateAutomation on Instagram that are a great quick reference if you are in a pinch.
Let us know if you have any questions by call/text 1858-566-6969 mon-fri. 10:30-5:30pst or at maxusa@partsshopmax.com