



TOYOTA TACOMA

FRAME REPAIR KITS

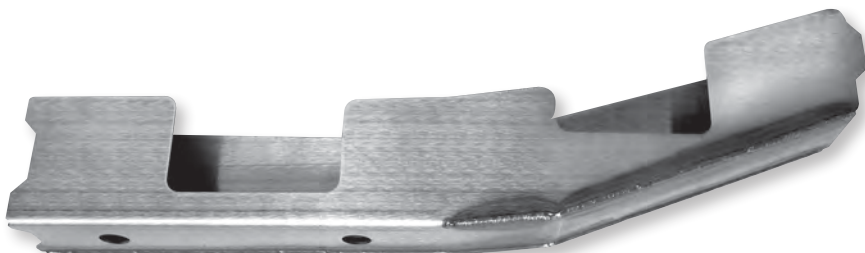
1998-2004

We Make it Easy to Make it Safe!

Installation Instructions TAC-157 & TAC-083 Mid-Frame Section

The SafeTCap® TAC-157 & TAC-083 are designed to repair the frame area forward of the rear tire around the rear spring mount. A version of the TAC-157 kit is made to fit every model TOYOTA TACOMA cab and drive combination. **The TAC-083 will fit all Xtra Cab models only.** Both kits are made from 11 gauge cold rolled steel, CNC cut and MIG welded in our USA plant. The TAC-157 kit includes an attached 7 gauge forward leaf spring mount. To install the TAC-157 or TAC-083 you will need to remove the leaf spring mount and fuel tank. If you are installing the ART-083, you will have to save the spring mount and reinstall it once the frame kit is in place. The bed can be left on. Versions of the TAC-157 & TAC-083 are available to repair the LEFT (driver), RIGHT (passenger), and BOTH sides (L&R Set).

CAUTION! *If you are not fully confident doing the installation yourself, have a professional welder install it, or at least have one inspect your repairs before you finish coat your SafeTCap® installation.*



TAC-083

Mid-Frame Section w/o Rear Forward Spring Mount

(Fits all Xtra Cab models only)



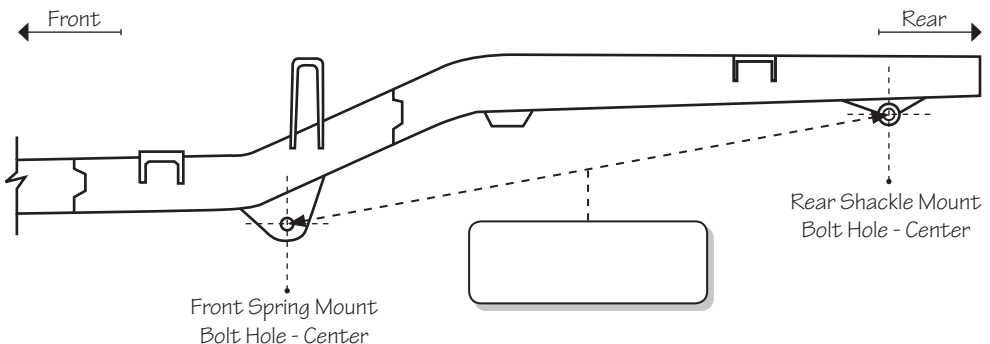
TAC-157

Mid-Frame Section w/Rear Forward Spring Mount

Installation Instructions

TAC-157 / TAC-083: Mid-Frame Section at Rear Forward Spring Mount Toyota Tacoma (1998-2004)

1. **IMPORTANT:** Read and understand the “General Instructions for Installing SafeTCap® Frame Repair Kits” before you begin.
2. The first phase of preparations for installing the TAC-157 and TAC-083 are the same.
3. Run the fuel level down close to empty to make the removal of the fuel tank easier.
4. Determine if your frame is strong enough to withstand the vehicle being lifted. Tacomas have been known to jack knife while being lifted. Look for frame cracks that extend from the top to bottom of frame and rot holes that take out a major portion of the frame side.
5. If you are repairing both sides of your vehicle work on only one side at a time. This will also make it easier to stabilize the frame if both sides are weakened from rust or stress cracks.
6. This SafeTCap® kit is designed to be installed with the bed left on. This helps to stabilize the frame, if you decide to remove the bed, close attention will have to be paid to insure that the frame doesn't twist, or become fixed in a bent position. If you do remove the bed it is a good idea to reinstall it on the frame after tack welding the TAC-157 or TAC-083 in position, to check the gap between the bed and cab and to insure the bed and cab are still parallel to each other.
7. You now need to jack both rear wheels off the ground until you have enough room to remove the fuel tank from beneath the truck. Placement of the jack forward of the rear leaf spring mount works well. Support the vehicle on jack stands, place two more jack stands at the extreme rear of the frame. If you need to support the vehicle further, there are two cross members that may help, provided they are solid, and don't show signs of rust or corrosion.
8. Remove the fuel tank, label the ends of all lines and wires, and remove the tank to a safe distance from the vehicle.
9. Remove the tire on the repair side.
10. Remove the forward spring bolt; pry the spring from the spring mount. *This is a good time to replace the spring mount bolt and bushings.*
11. If you are installing the TAC-083 you will have to cut off the spring mount and save it. Once the TAC-083 is installed you will have to weld it back on.
12. Before removing the spring mount take a measurement from the front spring mount bolt center to the rear shackle mount bolt hole center. Write your measurement down, this will insure that the SafeTCap® is in the correct location. (steps 13-25 on pg. 4)



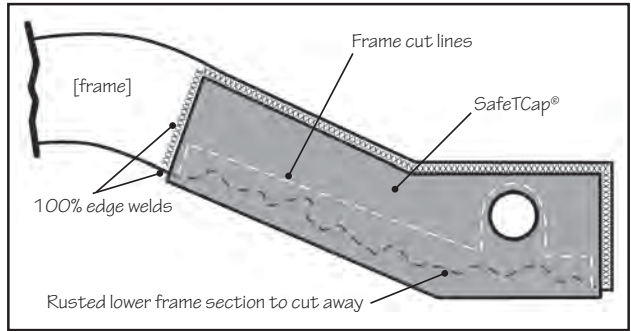
General Instructions for Installing SafeTCap® Frame Repair Kits

General automotive welding safety, metal preparation, and frame repair guidelines to achieve long-lasting results – safely.

Attention! For your safety follow all instructions. Failure to follow instruction may result in property damage or serious or fatal injury. User assumes all liability.

EQUIPMENT LIST

- Jack Stands/Ramps/Lift
- Quick Line Disconnect
- Eye & Ear Protection
- Work Gloves
- Fire Extinguisher & Water
- Cutting Wheel or Torch
- Grinder or Sander
- Locking Pliers or Clamps
- Welder: Mig or Stick
- Paint & Undercoat



VEHICLE PREPARATION

1. Disconnect the battery.
2. Check for fuel leaks; tank > lines > engine.
3. Repair or replace any leaky fuel lines before proceeding any further.
4. If the fuel tank leaks, remove it before, repair/replace after installation is complete.
5. Remove fuel tank if within 24" of the welding/repair area.
6. Keep flammable materials at least 20' from the vehicle.
7. Remove interior panels, seats, padding and carpets in the cabin area above work area.
8. Keep a fire extinguisher and water hose close by, use water for any fabric fires.
9. ALWAYS use a Fire Watch Person when cutting or welding on a vehicle. In case of emergency, call 911 immediately.

INSTALLING THE NEW FRAME KIT

1. If you are installing a right/left pair, repair one side at a time, keeping a reference/measuring point.
2. Support vehicle completely over a solid, level floor. Use good quality, weight-rated, safety jack stands, ramps or ideally – a hydraulic lift.
3. Most of our kits are designed to slip over the original frame after the bottom of the frame rust is cut back, and then welded in place. This helps duplicate the original dimensions, and location points, which can be lost if sections are completely removed. This overlapping SafeTCap® technique is the way we have been successfully repairing frames for over 40 years, providing superior strength while allowing you to complete the job safely and quickly.
4. The bottom of the frame must be cut off and area ground to clean metal – at least half way up the frame. With this method the frame rust is not contaminating your new frame section. The minimum remaining can be no less than 1/2" of the original frame for the SafeTCap® kit to overlap and perform as designed. Measure, fit, measure, then tack weld SafeTCap® at key points, the final installation requires complete 100% edge welding, with an assistant acting as a Fire Watch.
5. Some frames have brackets, bumps, stops, etc. that need to be cut off and reused in order to complete the installation. Drill out the factory spot welds on these for cleanest removal.
6. Once welding and wire brushing is finished, brush or spray primer, then paint or undercoating.
7. Inspect the repair yearly.

TAC-157 & TAC-083 Installation Instructions (con't.)

13. Mark out the outline of your SafeTCap® on the frame of your Tacoma. Mark the area to be removed. Leave the recommended overlap as described in the *General Instructions*. Not less than 1/2 inch.
14. Cut and remove the rusted out portion of the frame.
15. Grind the area to be welded down to bare metal.
16. Place SafeTCap® into position, check measurements. Clamp.
17. For the TAC-157 install, check leaf spring fit to new spring mount.
18. For the TAC-083 install, determine spring mount position, tack weld mount to the TAC-083, and test fit the leaf spring.
19. When satisfied with the fit, tack weld the frame kit, recheck measurements and then weld solid.
20. Paint or coat the repair.
21. Reinstall fuel tank.
22. Reinstall leaf spring.
23. Reinstall Tire.
24. Lower to ground.
25. Good to go.

SAFETCAP® ONE YEAR LIMITED WARRANTY

What Does This Limited Warranty Cover?

This warranty covers any SafeTCap® product defect or malfunction in your new frame repair component.

How Long Does The Coverage Last?

This warranty lasts one (1) year from the date of purchase and is nontransferable.

What Will SafeTCap® Do?

SafeTCap® will replace any defective part at no charge. You must pay shipping and all labor charges to remove and reinstall the defective part.

What Does This Limited Warranty Not Cover?

This limited warranty applies to the SafeTCap® frame repair components only, and covers any defects in materials and workmanship on the component. SafeTCap® is not responsible for product failure due to improper installation, or installation on modified frames and vehicles with non-standard retrofitted suspensions. SafeTCap® is not responsible

for the quality of the installation, or for any issues that may arise beyond the scope of repair for which the part was intended. Consequential and incidental damages are not recoverable under this warranty. Some states do not allow the exclusion or limitation of incidental or consequential damages, so the above limitation or exclusion may not apply to you.

How Does State Law Apply?

This warranty gives you specific legal rights; you may also have other rights which vary from state to state.

How Do You Get Warranty Service?

In order to be eligible for service under this warranty, you must return the SafeTCap® registration card provided, within 30 days of receipt. You may also register your SafeTCap® online at www.safetcap.com. To obtain warranty service, please call us toll free at 800-407-7024.



We Make it Easy to Make it Safe!

SafeTCap®

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www.safetcap.com

(USA)

SafeTCap® products are designed and developed by SafeTCap Inc. in response to hundreds of vehicles that have required frame rot repairs. All kits/parts have been developed, manufactured, tested and installed at our Cranston, Rhode Island, USA facilities.

We accept returns within 30 days of receipt of product. Buyer pays return shipping and is subject to a 10% RESTOCKING FEE. To return an order customers need to call 1-800-407-7024 to obtain a RETURN AUTHORIZATION NUMBER. We do not accept returns that have been modified or altered, in any way, from the factory shipped component.

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