



TAC-156U
1996-2004
1ST GEN TOYOTA TACOMA
REAR FRAME SECTION
AT REAR BUMP STOP

IMPORTANT: Read and understand the General Instructions
Before Installing SafeTCap® Frame Repair Kits

Installation Instructions

- 1)** Place two jack stands in front of the rear forward spring mounts and two additional stands behind the repair area. An additional jack under the rear axle is recommended.
- 2)** Remove the bump stop, save it to reinstall after the repair is complete.
- 3)** The TAC-156U is a "C" shaped cap which can go directly over your frame from the outside without any removal of the damaged area.
- 4)** Place kit over your frame and mark the Position.

5) Remove kit and grind the area to be welded down to clean, Bare Metal.

6) Place kit back into position and tack weld in place. If you have removed the bed, it is a good idea to place it back on the frame temporarily to insure everything lines up before you weld the repair solid.

7) If satisfied with the fit , weld the new repair kit all around.

8) Reattach bump stop.

9) Rustproof the repaired area with rust inhibiting primer or undercoat.