



**TAC-157 & ART-83  
1996-2004  
TOYOTA TACOMA  
MID FRAME SECTION AT  
FORWARD REAR SPRING MOUNT**

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

## **Installation Instructions**

- 1)** We've designed these frame repair kits to be installed with the bed of the truck left on. This also helps to keep the frame stable and straight during installation. You can continuously check the gap between the cab and bed to make sure the frame hasn't shifted or weakened during the install.
- 2)** Jack up the rear of the vehicle until you have enough room to remove the fuel tank. Support the vehicle on properly rated jack stands. Putting the jack stands under the frame about 7 inches forward of the rear cab mount on each side works well, and also put two more jack stands under the rear ends of the frame for support. The rear axle must hang free to remove the forward rear leaf spring mount.
- 3)** Remove the forward spring bolt, and pry the spring from the mount.
- 4)** Measure the forward spring mount bolt hole center to rear spring shackle mount bolt center.

**5)** Cut the spring mount from the frame along with any rusted lower section. Do not cut more than half of the lower portion of frame. After cutting spring mount off, slide the SafeTCap kit onto the frame and position it using the measurement taken, mark the entire outline of the frame kit, This will help so you don't remove too much of the original frame.

**6)** If you're installing the TAC-083, cut the forward rear spring mount from the frame as close to the mount as possible without cutting into it.

**7)** Grind your original frame clean.

**8)** Slide the SafeTCap® kit onto the frame and position. Clamp onto the frame and close any gaps.

**9)** Tack weld it to the frame till its securely in place. Re-check measurements of the spring mount.

**10)** Weld the frame repair kit solid to the frame.

**11)** Reinstall the leaf spring and coat the frame with a rust inhibiting primer or undercoat.

**12)** Reinstall fuel tank and rear tires. Lower to the ground and check the gap between cab and bed.