



**TAC-155U
1998-2004
TOYOTA TACOMA
REAR FRAME SECTION**

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

Installation Instructions

- 1)** Jack up the vehicle and support it on properly rated jack stands.
- 2)** Remove a tow bar bracket if attached to that section of the frame.
- 3)** Unbolt the 2 rear bed bolts on each side, this will allow sliding the kit into place much easier.
- 4)** Slide TAC-155U into position.
- 5)** Mark the kit and areas on the original frame to be welded.

6) Grind the frame where you will be welding all the way to bare metal.

7) Place TAC-155U into position and clamp it.

8) Test fit bumper brackets and bumper alignment. When satisfied with fit, tack weld the TAC-155U to the frame.

9) Remove bumper and brackets, then weld the TAC-155U solid.

10) Prime, paint or undercoat repair area.