



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

**IMPORTANT:** Read and understand the General Instructions  
**Before** Installing SafeT-Cap® 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.