



TAC-158 1996-2004 TOYOTA TACOMA CENTER FRAME SECTION

IMPORTANT: Read and understand the General Instructions
Before Installing SafeT-Cap® Frame Repair Kits

Installation Instructions

- 1)** Jack up the front & rear of vehicle and support it on properly rated jack stands. Place rear jack stands under the rear axle. Make sure the center of vehicle is fully accessible.
- 2)** The TAC-158 Center Frame repair kit caps the frame starting at the rear transmission cross member, and ends before the forward fuel tank cross member.
- 3)** If you are repairing both sides, cut & repair one side at a time keeping one side assembled as a reference/measuring point.
- 4)** Remove any brackets, wiring, and/or lines from the frame and move them out of the way.
- 5)** Slide the frame repair kit over the frame and make sure the gaps between the cab mount is evenly spaced. Mark the outline of the frame repair kit on your frame and remove the frame kit.
- 6)** Grind the frame down to clean metal all along the marked outline of the frame repair kit. You may want to remove the lower section of the original frame to allow our drain hole to properly function.
- 7)** Slide the frame repair kit back over the frame and clamp into place, make sure close any gaps then tack weld frame repair kit to your frame.
- 8)** If you're installing additional frame repair kits, test fit those kits now to make sure everything will fit together properly.
- 9)** Check measurements and door gaps to make sure the vehicle has stayed straight, then, weld all edges 100%. If you're installing additional frame repair kits, do not weld the ends yet.
- 10)** Prime and/or paint the repaired area, then re-attach any brackets, wiring and/or brake lines back to the frame and make sure to secure them.