



**TAC-230  
2005-2015  
2ND GEN  
TOYOTA TACOMA  
FRONT FRAME SECTION**

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

## **Installation Instructions**

- 1) Jack up the front of vehicle and support it on properly rated jack stands. Make sure the section of vehicle that is being repaired is fully accessible.
- 2) Remove any brackets, wiring, exhaust, and fuel/brake line clips from the frame and carefully move them out of the way noting their location. You may need to drill holes in the frame kit to reattach fuel/brake line clips after installation.
- 3) Finish cut and the tab bent down to match the angle of the cross member end so the frame kit fits tightly against underside of the frame.
- 4) Note: It is best to remove the bottom ½" of the original frame within the covered area to allow the frame to drain properly through the SafeTCap® drain hole. Make sure to allow at least ¾" overlap where the frame kit meets the original frame.
- 5) Slide kit over the frame from underneath and evenly space the frame kit around the cab mount and the Transmission crossmember end. Mark the outline of the kit on the frame. Then, remove the frame kit.
- 6) Prep the repair area for welding by grinding the frame down to bare metal along the marked outlines.
- 7) Slide kit back over the frame and use large C-clamps to firmly clamp kit to the frame. Tack weld the frame kit to your frame.
- 8) Weld all perimeter edges 100%.
- 9) Re-attach the brake and fuel lines. You may need to drill ¼" holes to attach the brake/fuel line clips to the frame.
- 10) Rustproof the repaired area with a rust inhibiting primer or undercoat.