

## Tac-232X Xtra Cab



## Tac-232D Double Cab



# TAC-232 2005-2015 2ND GEN TOYOTA TACOMA MID FRAME SECTION

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

## Installation Instructions

- 1)** Jack up the side of vehicle to be repaired and support it on properly rated jack stands. Make sure the center of vehicle is fully accessible.
- 2)** If you are repairing both sides, cut & repair one side at a time keeping one side intact and assembled as a reference/measuring point.
- 3)** Remove fuel tank and safely store at least 20ft away from the work area and any cutting, grinding or welding sparks.
- 4)** Note: You don't need to remove cab mount or cab mount bushing from the vehicle to install the TAC-232. Unless the frame behind the cab mount and bed mount. Is rusted.
- 5)** Take measurement of the spring mounts bolt hole center to a fixed point on the frame for later use.
- 6)** Remove spring mount by cutting the heads of the rivets off and drill out the remaining rivets.
- 7)** Our TAC-232X & 232D have cut lines corresponding to the cab/bed mount and fuel tank filler neck mount that can be removed if needed. Simply continue the cut lines until its removed.

**8)** Slide the SafeTCap® frame repair kit over the frame from underneath and make sure the rivet heads sit through the corresponding holes on the TAC-232.

**9)** Mark the outline of the frame repair kit on the frame with a sharpie, paint marker or soapstone. Then, remove the frame kit.

**10)** Prep the repair area for welding by grinding the frame down to clean, bare metal along the marked outline on both the outer, and underside of the frame. Remove any rust or debris from the frame using a needle scaler.

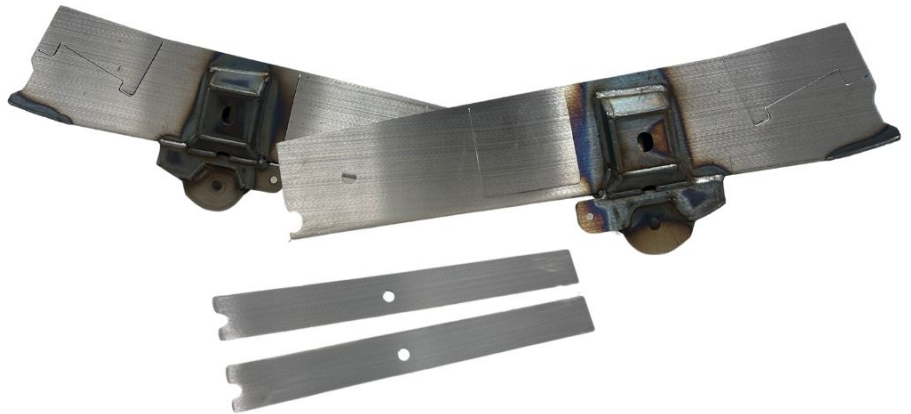
**11)** Slide the frame repair kit back over the frame and use large C-clamps to firmly clamp TAC-232 to the frame. Use welding clamps to close any gaps along the side. Then, tack weld the TAC-232 along the top and underside of frame, and space tack welds at least every 2 to 3 inches.

**12)** Check all measurements to make sure the vehicle has stayed straight. Check the gap between bed and cab to make sure it is parallel. Then, weld all perimeter edges 100%.

**13)** Rustproof the repaired area with a rust inhibiting primer or undercoat.

## ***FORWARD LEAF SPRING HANGER ATTACHED***

***TAC-232X-1***



***TAC-232D-1***

