



TAC-233
2005-2015
2ND GEN TOYOTA TACOMA
MID/REAR FRAME
SECTION @ BUMP STOP

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

Installation Instructions

- 1)** Jack up the rear of vehicle and support the frame on properly rated jack stands so the rear axle hangs free and suspension is unloaded.
- 2)** Support the rear axle with a Hyd. Jack and disconnect both Driver and Passenger side shocks from the frame. Inspect each shock and the rubber boots, replace if necessary.
- 3)** Measure the bump stop and note its location. Carefully remove the rivets holding it to the frame, try not to destroy the bump stop during removal, you will need to reinstall it after the TAC-233 is welded on.
- 4)** For the Passenger Side: If the frame behind the shock mount is rusted out, measure its placement and remove it from the frame carefully so it can be welded back onto the frame after the TAC-233 is welded.

5) Prep the repair area for welding by grinding the frame down to clean, bare metal on the outer side, under side, and upper side of the frame. Remove all rust and/or debris from the frame using a needle scaler.

6) Slide the TAC-233 SafeTCap® frame repair kit over the frame from the outside and line up the slots around the rivets on the top and bottom, tap the TAC-233 onto the frame with a dead blow hammer until it sits flush against the original frame.

7) Tack weld the TAC-233 along the top and underside of frame.

8) 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 edges of the TAC-233 100% to the original frame.

9) For the Passenger Side: If you notched the TAC-233 around the shock mount, weld the edges of the frame kit to the frame.

10) Re-install the bump stop back to the frame using the measurements taken in step 3. Bump stop can be welded to the frame.

11) Rustproof the repaired area with rust inhibiting primer or undercoat.