



**TAC-234**  
**2005-2015**  
**2ND GEN TOYOTA TACOMA**  
**REAR FRAME SECTION**

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

## Installation Instructions

- 1)** Jack up the rear of the vehicle and support the frame on properly rated jack stands. Make sure the rear of vehicle is fully accessible. Place jack stands 1 set before the rear axle and another set on the frame at the bump stop or just behind.
- 2)** Remove the spare tire, and the rear bumper from the frame. If your vehicle has a tow hitch cross member, it will also need to be removed from the frame.
- 3)** Remove the rear 2 bed bolts.
- 4)** Measure the location of the rear leaf spring hanger on the frame and take note for later use.
- 5)** Place a Hyd. Jack under the rear axle to support it during the removal of the rear spring hangers.
- 6)** Remove the rear leaf spring hanger from the frame by grinding the heads of the rivets down, then drilling the remaining rivets from the frame.

**7)** Slide the TAC-234X/D over the frame from the outside, make sure the rear end of the frame kit lines up with the original frame end. Then, mark the forward end of the TAC-234 on the original frame.

**8)** Remove the TAC-234 from the frame and grind the frame down to clean, bare metal at least 2" inches before and after the marked line on the frame as well as the upper and lower edge of the original frame.

**9)** Slide the frame repair kit back over the frame and clamp into place, then tack weld.

**10)** Weld the upper and lower inner edges of the TAC-234 to the frame, then weld the forward edge of the 234 to the frame.

**11)** Using the measurements reattach the rear spring hanger to the frame by either bolting it to the frame or welding the spring hanger to the TAC-234 Frame Kit. If you have disconnected the rear leaf spring from the Spring hanger, re-connect the leaf spring to the spring hanger and torque to specification.(89ft-lbs)

**12)** If any of the weld nuts in the original frame for mounting the rear bumper, spare tire cross member and the tow hitch cross member were rotted, damaged and/or needed to be removed from the original frame, then new weld nuts will need to be added to the TAC-234 in the proper holes before rustproofing the repaired area.

**13)** Prime and/or paint the repaired area, then Reinstall the 2 rear bed bolts, any wiring and clips to the frame, the rear bumper, the tow hitch cross member and spare tire.