

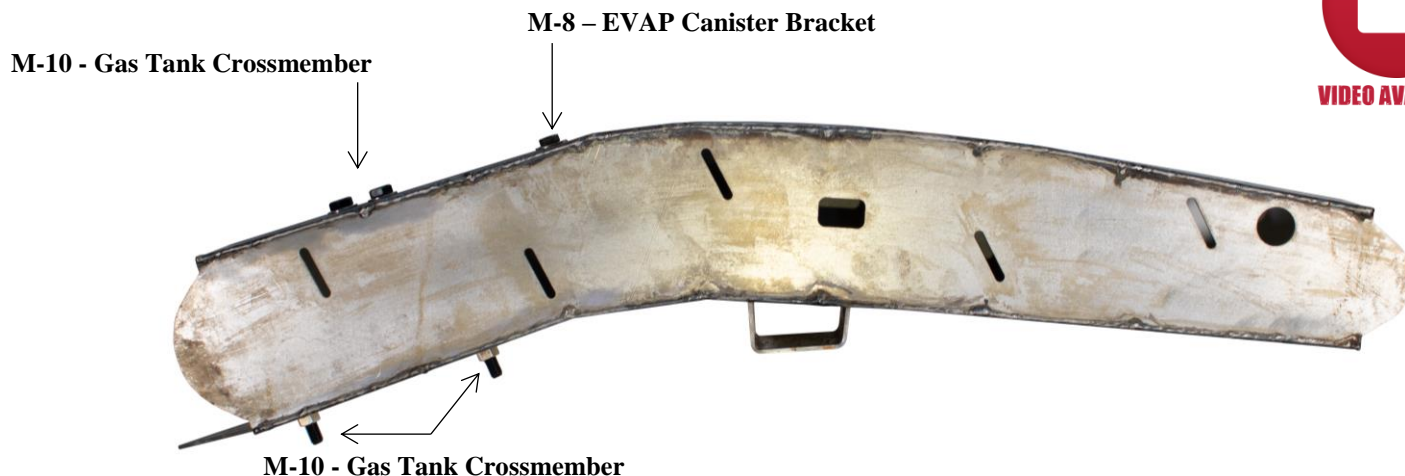


RUST BUSTER

F R A M E W O R K S

RB7108R & RB7108L

**Toyota® 95-04 Tacoma
Over-Axle Frame Section**



REQUIRED TOOLS

- Jack Stands or Lift
- Mig Welder
- Paint/Primer
- Locking Pliers
- Hand Grinder
- Cutting Wheel or Torch
- Welding Gloves
- Welding Hood/Shield
- Ear & Eye Protection
- Sockets & Ratchet
- Fire Extinguisher & Water

KIT CONTAINS

- Over-Axle Frame Section
- M10 Flange Nut
- M10 Flange Bolt
- M8 Lock Nut
- M8 Washer
- M8 Bolt
- Fuel Neck Filler Bracket Not Included**

QTY

- 1
- 4
- 4
- 1
- 1
- 1



RUST BUSTER

F R A M E W O R K S

RB7108R & RB7108L

**Toyota® 95-04 Tacoma
Over-Axle Frame Section**

1) **PREPARING YOUR VEHICLE**

Begin by disconnecting your battery prior to starting your installation.

Inspect your vehicle for leaking fuel lines, fuel tank and engine components. If you have fuel leaks repair all leaks prior to starting your installation. If your fuel tank is near your welding area **remove your tank prior to welding.**

Remove all combustible items above the work area such as seats, carpets, padding, etc.

Keep all flammable materials away from the vehicle work area.

2) **PREPARING YOUR WORKSTATION**

Keep a fire extinguisher and water close by in the case of fire and make sure you always have a designated "Fire Watch" to assist during the cutting or welding phases.

Abide by all apprenticed welding safety standards and practices.

Always use appropriate welding eye protection, ear protection, and work and fire safety gloves during the installation and within the work area.



WARNING!

If you are unsure on how to perform the installation or how to operate any of the required tools listed above, it is **HIGHLY** advised that you enlist the work of a certified welder/installer.

Failure to follow proper safety precautions and instructions may result in serious injury. **The user assumes all liability when installing the product.**



RUST BUSTER

F R A M E W O R K S

RB7108R & RB7108L

Toyota® 95-04 Tacoma Over-Axle Frame Section

3) PREPARING FOR YOUR INSTALL

Lift or Jack your vehicle, and support it with jack stands.



LIFT IS NOT REQUIRED, BUT RECOMMENDED

Remove your vehicle's hitch, rear bumper, and bed. For a tutorial on how to do this, please visit www.youtube.com/rust_buster_frameworks for a step-by-step guide and walkthrough.



Remove your vehicle's wheels on the side you're working on.

Only on the Driver's side, with an 11mm socket, remove the brake proportioning valve. Follow the valve's arm and with a 12mm and 13mm socket, remove its bolt, freeing the device.





RUST BUSTER

F R A M E W O R K S

RB7108R & RB7108L

Toyota® 95-04 Tacoma Over-Axle Frame Section

With a 14mm socket, remove the 4 bolts retaining the gas tank crossmember, and any plastic retaining clips.



Hold the part up to the frame and take note of its coverage. Mark off any sections you wish to cut off, while leaving enough to weld back on to.

Note: The Driver and Passenger shock mount sits within this part. If you wish to replace it with our part (RB7109L & RB7109R), please follow its own installation instructions. Otherwise, you may need to modify the existing mount, or the Over-Axle Section before the following steps.

(OPTIONAL): Coat the part with a weld-able primer or other rust inhibitor prior to installation to help prevent or reduce the risk of rust formation.

4) **CUT**

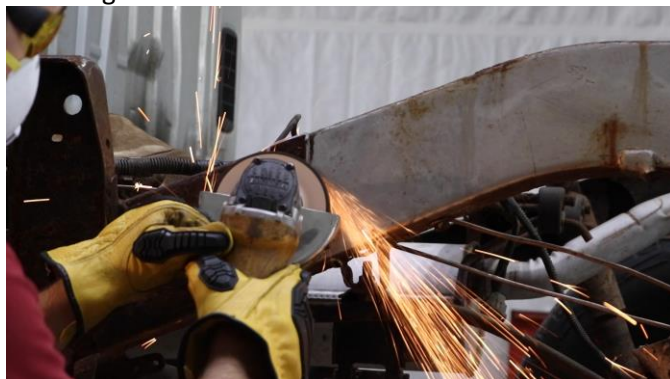
Begin cutting away any material, while avoiding damage to the shock mount. Cut away the existing bump stop bracket.



Note: Our part does not replace the filler neck bracket. If you wish to reuse it, we recommend you remove and clean the part free of rust.



Begin cleaning the frame of any rust and debris, revealing bare metal.





RUST BUSTER

F R A M E W O R K S

RB7108R & RB7108L

Toyota® 95-04 Tacoma Over-Axle Frame Section

Push the part into place, using the angle and crossmember bolt holes for alignment.

Our Driver's side part features a hole marking the location of the shock mount bolts. If you wish to replace the shock mount as well, this hole will need to be cut out, and the mount's instructions to be followed for a complete installation.



Coat the part and area with a weld-able primer prior

5) WELD

Remove any remaining potential fire hazards on both the vehicle and surrounding area.

Use a jack stand or C-clamps to hold the part into place. While following proper welding procedures, begin welding the part.



Reinstall your Fuel Filler Neck Bracket.

100% weld around all edges.

6) PAINT AND PROTECT

If you chose not to protect your part in (Step 3), coat the part and work area with a primer or other rust inhibitor to help prevent or reduce the risk of rust formation.

7) REASSEMBLE YOUR VEHICLE

Reinstall your gas tank crossmember with the included hardware.



Coat the part and area with a weld-able primer prior

Reinstall your EVAP canister using the included hardware.

Reassemble your vehicle.