



RUST BUSTER

F R A M E W O R K S

RB7101, RB7102, RB7103

**Toyota® 95-04 Tacoma
Rear Frame Rail Kit**



RB7102L or RB7102R



RB7101



RB7103



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

RB7101

Rear Shackle Mount Brackets

QTY

2

RB7102L

Rear Frame Rail (Left)

1

M12 Hex Bolt

2

M12 Lock Nut

2

M10 Hex Bolt

5

M10 Flange Nut

5

RB7102R

Rear Frame Rail (Right)

1

M12 Hex Bolt

2

M12 Lock Nut

2

M10 Hex Bolt

5

M10 Flange Nut

5

M8 Hex Bolt

2

M8 Flange Nut

2

M8 Flat Washer

2

RB7103

Rear Frame Rail Insert

2

BUSHINGS NOT INCLUDED



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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.**



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FRAMEWORKS

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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.

[Choose only one side to work on at a time, for purposes of retaining frame alignment]

Support your rear axle with a jack stand. With a 19mm socket, remove your shackle from the shackle mount, and remove the bushing.

[If you wish to retain these, we recommend you sand blast and coat the shackles in a primer, and refrain from damaging the bushing, prior to reinstalling them]



With a 17mm socket, remove the shock from the upper mount.



With a 14mm socket, remove the 5 bolts securing your spare tire crossmember.





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Hold the new part up to the frame and take note of its frame coverage. Begin cutting and removing your vehicle's shackle mount, bed mount bracket, and any unwanted metal.

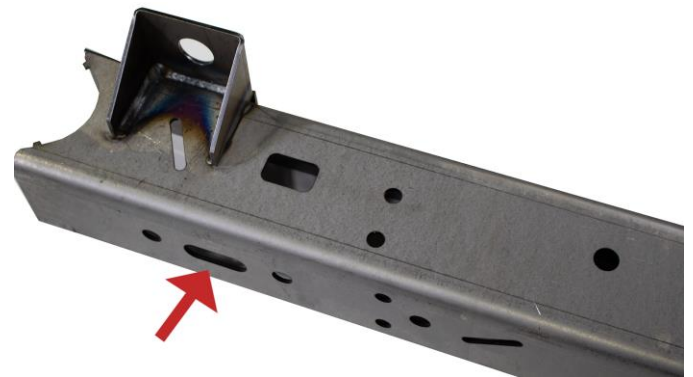
[If you did not purchase a new Shackle Mount and/or Frame Rail Insert, and wish to retain your vehicle's factory parts, we recommend you sand blast and coat them in a primer prior to reinstalling it. Please see Step 7 for weld options with your Rail Inserts]



Attempt to push the new part onto the rail. Take note of any difficulties, and continue to clean the frame, revealing bare metal.



The shown opening is intended for water drainage. Before continuing, we recommend you remove any existing metal around it to prevent future rust development.



(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.



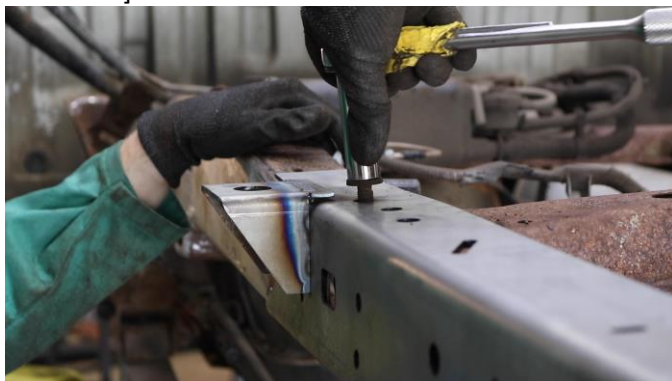
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With the included hardware, begin installing the new rail onto the frame. Doing so will help to properly align the part. [If you purchased the Driver's side Frame Rail, 2 M8 bolts, washers, and nuts are included to replace the exhaust hanger hardware]



6) **INSTALL/REINSTALL THE SHACKLE MOUNT**

Using the Frame Rail's underside holes for alignment, C-clamp the shackle mount to the rail.



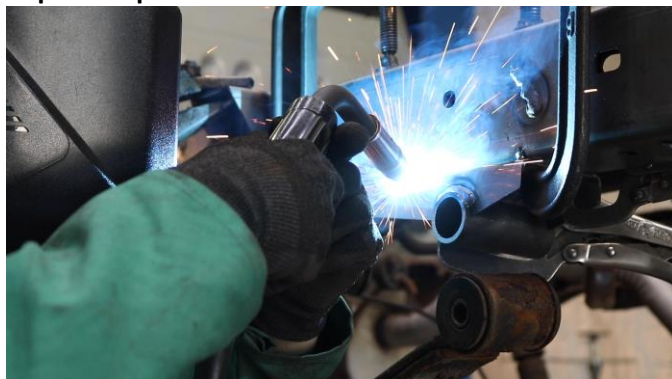
Repeat steps 4 and 5

4) **WELD**

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

C-clamp the part to the frame and, while following proper welding procedures, begin welding the part.

100% weld around all edges.



5) **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.



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7) **INSTALL/REINSTALL THE FRAME RAIL INSERT**

There are three options available for installation/reinstallation of your Inserts:

1. Cut and remove the factory insert and reinstall it
 2. If you purchased RB7103 Frame Rail Inserts, cut and remove the factory insert, and install the new part in its place
 3. If you purchased RB7103 Frame Rail Inserts, install the new part over the factory insert, further supporting the rail
- If you wish to reinstall your factory insert, reference the opposite side's rail for positioning.
 - If you purchased RB7103, please see the image below for positioning.
 - If you purchased RB7103 and wish to install over your factory insert, align the new part by centering it on the two large frame holes.



Repeat steps 4 and 5



8) **REASSEMBLE YOUR VEHICLE**

- Reinstall your shock.
- Reinstall your bushings.
- Reinstall your shackles.
- Reinstall your exhaust hanger (Driver's side only).

