



RUST BUSTER

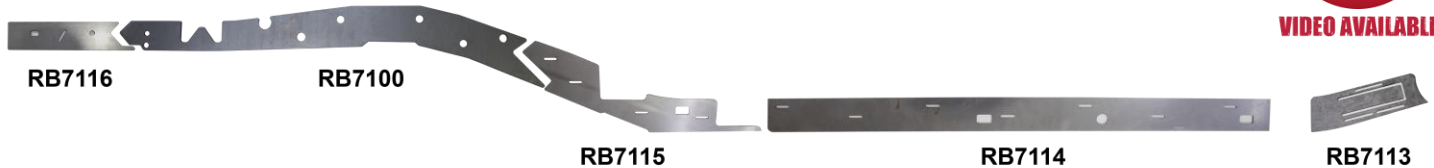
FRAMEWORKS

RB7100, RB7113, RB7114, RB7115, RB7116

Toyota® 95-04 Tacoma
Front-to-Rear Frame Stiffeners



VIDEO AVAILABLE



RB7116

RB7100

RB7115

RB7114

RB7113



RB7116 REAR FRAME STIFFENER



RB7100 OVER-AXLE FRAME STIFFENER



RB7115 MID FRAME STIFFENER



RB7114 UNDERCAB FRAME STIFFENER



RB7113 FRONT FRAME STIFFENER

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

- [Pg. 3] **RB7113** Front Frame Stiffener
- [Pg. 4] **RB7114** Undercab Frame Stiffener
- [Pg. 5] **RB7115** Mid-Frame Stiffener
- [Pg. 6] **RB7100** Over-Axle Frame Stiffener
- [Pg. 7] **RB7116** Rear Frame Stiffener

QTY

- 2
- 2
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- 2
- 2



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F R A M E W O R K S

RB7100, RB7113, RB7114, RB7115, RB7116

Toyota® 95-04 Tacoma Front-to-Rear Frame Stiffeners

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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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.



BED REMOVAL IS NOT REQUIRED, BUT RECOMMENDED

[Removing the hitch and rear bumper is required. Removing the bed grants complete welding access to the top most edges of the stiffeners, but it's not required]

Remove your vehicle's wheels depending on which section of the frame you're working on. **RB7114 Undercab Stiffeners** will not require wheels to be removed.

If you're working with parts **RB7100** or **RB7116**, you will need to remove your exhaust hanger bracket on the driver's side with a 12mm socket.





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F R A M E W O R K S

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Toyota® 95-04 Tacoma Front-to-Rear Frame Stiffeners

4) RB7113 FRONT FRAME STIFFENERS

With a body clip remover, remove any wheel well liners that prevent access to the frame.



Hold the part up to the frame and take note of its coverage. Clean the frame of any rust and debris, revealing bare metal.

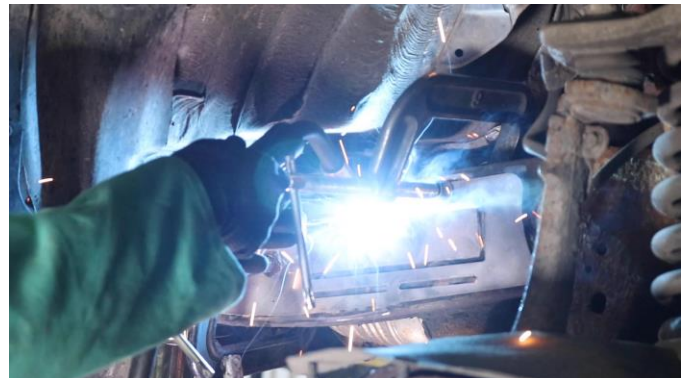


Replace the part, centering it between the two brackets, and C-clamping it to the frame.



COAT THE WORK AREA WITH A WELD-ABLE PRIMER PRIOR

Begin welding around all edges, and along the weld slots.





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FRAMEWORKS

RB7100, RB7113, RB7114, RB7115, RB7116

Toyota® 95-04 Tacoma Front-to-Rear Frame Stiffeners

5) **RB7114 UNDERCAB STIFFENERS**

Hold the part up to the frame. The orientation can be determined by the location of the frame holes (See diagram on the cover). Take note of its coverage, and begin to clean the frame of any rust and debris, revealing bare metal.




Replace the part, using the center frame hole as an alignment reference point, and C-clamp it to the frame.



Begin welding around all edges and weld slots. You will need to C-Clamp as you weld in order to shape the stiffener to the frame.



 **COAT THE WORK AREA WITH A WELD-ABLE PRIMER PRIOR**





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6) RB7115 MID-FRAME STIFFENERS

Hold the part up to the frame and take note of its coverage. Clean the frame of any rust and debris, revealing bare metal.



Replace the part, using the bed and body mount brackets as alignment reference points, and C-clamp it to the frame.



COAT THE WORK AREA WITH A WELD-ABLE PRIMER PRIOR

Begin welding around all edges and weld slots.



COAT THE WORK AREA WITH A WELD-ABLE PRIMER PRIOR





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FRAMEWORKS

RB7100, RB7113, RB7114, RB7115, RB7116

Toyota® 95-04 Tacoma Front-to-Rear Frame Stiffeners

7) RB7100 OVER-AXLE FRAME STIFFENERS

With a body clip remover, remove any wheel well liners that prevent access to the frame. On the Driver's side, remove the vehicle's 2 exhaust hanger bracket bolts with a 12mm socket. The passenger is clear.



Hold the part up to the frame and take note of its coverage. Clean the frame of any rust and debris, revealing bare metal.



Replace the part, using existing bolt holes and body mount brackets as alignment reference points, and C-clamp it to the frame.

Begin welding around all edges and weld slots.





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FRAMEWORKS

RB7100, RB7113, RB7114, RB7115, RB7116

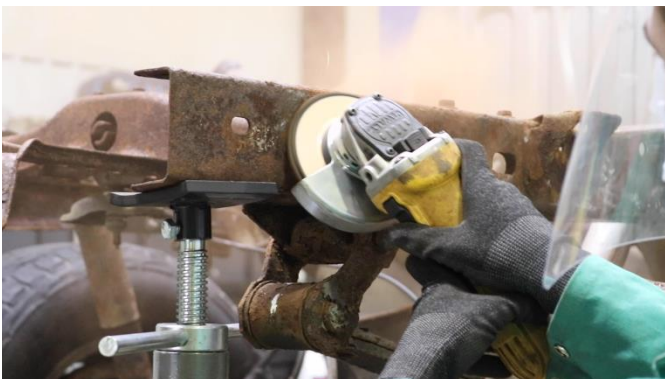
Toyota® 95-04 Tacoma Front-to-Rear Frame Stiffeners

8) RB7116 REAR FRAME STIFFENERS

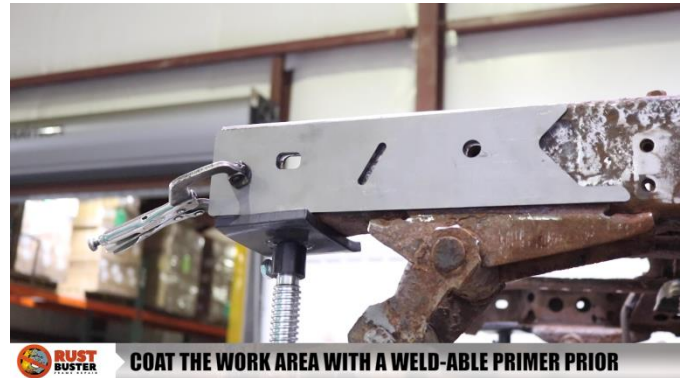
On the Driver's side, remove the vehicle's 2 exhaust hanger bracket bolts with a 12mm socket. The passenger is clear.



Hold the part up to the frame and take note of its coverage. Clean the frame of any rust and debris, revealing bare metal.



Replace the part, using the existing bolt holes as alignment reference points, and C-clamp it to the frame.



Begin welding it, around all edges.

