



**RUST
BUSTER**
FRAMEWORKS

RB7117

**Toyota® 95-04 Tacoma
Gas Tank Crossmember**



REQUIRED TOOLS

Jack Stands or Lift
Paint/Primer
Locking Pliers
Hand Grinder
Cutting Wheel or Torch
Ear & Eye Protection
Sockets & Ratchet
Fire Extinguisher & Water

KIT CONTAINS

M10 Hex Bolt
M10 Flange Nut

QTY

8
8



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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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3) PREPARING FOR YOUR INSTALL



REPLACE CAP ONCE BED HAS BEEN REMOVED

Remove your vehicle's bed. We show how to do this in an instructional video which can be found on our [website](http://www.rustbuster.com) or [YouTube.com/RustBusterFrameworks](https://www.youtube.com/RustBusterFrameworks).

Support your gas tank with a jack or jack stand.

Disconnect your EVAP canister from its power harness, unbolt it from the crossmember, and set it aside, while retaining its hardware if not replacing it.



With an exhaust fork, remove the exhaust from the isolators.



With a 13mm socket, remove the bolt retaining the gas tank strap, and set it aside if not replacing it.



With a 13mm socket and wrench, remove the 4 bolts from each frame rail, freeing the crossmember. Remove the crossmember.





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(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/CLEAN

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

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



Ensure that the exhaust hangers point to the rear and that the frame holes line up.

5) INSTALL

With the included 8 bolts and nuts, begin installing the part into the frame rails.



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 strap.
Reinstall your exhaust isolators.
Reinstall your EVAP canister.
Reinstall your bed.

