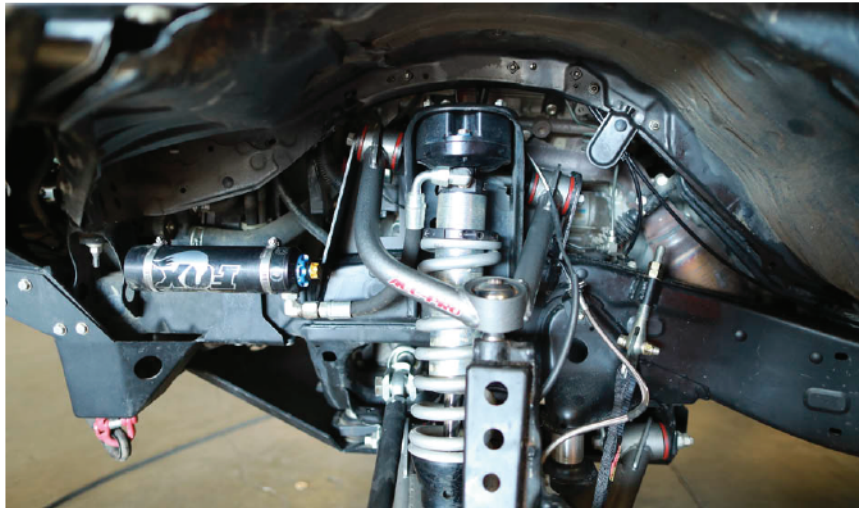


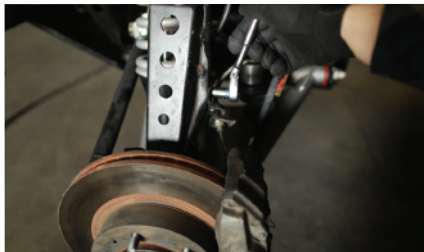


INSTALLATION INSTRUCTIONS FOR KITS AP-307649, AP-307662, AP-307787, AP-307792, COIL BUCKET GUSSETS

	NOTICE Read instructions completely before installing this product. Refer back to the instructions frequently during installation.		CAUTION Flying Object Hazard. Fluid Splash Hazard. Wear safety glasses at all times when working on vehicle.
WARNING: Cancer and Reproductive Harm - www.P65Warnings.ca.gov			



1. Safely support the vehicle by the frame using jackstands or a car lift so the front suspension is at full droop. Remove the front wheel.
2. Unbolt the ground strap, brake line junction block, and brake line mount on the spindle to allow easier access around the coil bucket.



AP-307649-INS

3. Unbolt the upper control arm from the frame mount and orient the control arm/spindle assembly so that it is not in the way. On applicable models, make sure that the spindle is not being supported by the ABS wire.

- For Tacoma's, the upper control arm bolt removes forwards.
- For Tundra's, the upper control arm bolt removes rear wards.

Note: On some models it may be necessary to remove the airbag sensors, wire harness tab, and A/C tab to remove the upper control arm bolt. It may be necessary to remove the wire protection tray and mounting bracket shown below on some models.

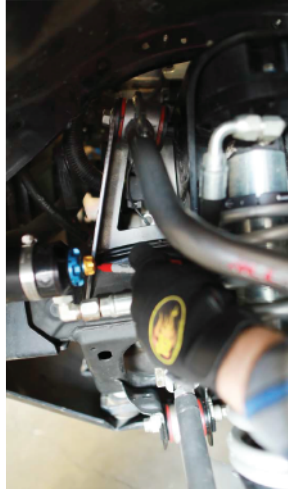


4. Slide the upper control arm bolt through the holes in the front and rear brackets as shown. Make sure to orient any washers and spacers previously used for mounting the upper control arm in the same way when bolting the brackets to the shock tower. See photos for reference.



5. Make sure that neither of the brackets are coming into contact with any brake lines or electrical wiring. If the brackets are contacting any factory welds that are not allowing the brackets to sit flush against the frame, sand down the bracket accordingly.

6. With front and rear brackets in place tighten the upper control arm bolt. Once tight, make sure that the brackets are sitting flush against the frame. Using a paint pen or sharpie, mark along where the brackets contact the frame and shock tower.



7. Remove the brackets. Remove any paint, grease, or other contaminants from the areas outlined and prep the surfaces for welding. If you think you will be unable to apply paint to the engine side of the brackets once they are welded in, paint the engine sides of the brackets at this time. Again make sure that any areas that will be welded on are free from paint and other contaminants.



8. With the frame and brackets free from paint, grease, and other contaminants around the welding areas reassemble the brackets as done before ensuring that any washers or spacers originally used to mount the control arm are in the same orientation. In order to ensure the brackets do not warp during welding, remove the upper control arm inner sleeves and reinstall the sleeves, washers/spacers, and upper control arm bolt. **DO NOT** attempt to weld the brackets in place while the urethane bushings in the control arms are installed, otherwise they will melt. Tighten the upper control arm bolt.



9. Tack the front and rear brackets in place.

10. Weld the brackets to the frame and shock tower as shown.



11. After the welds have cooled, paint the welded/bare areas to prevent rust.



12. Reassemble the upper control arms with new bushings if needed. Grease the control arm bushings, inner sleeves, and the insides of the brackets. Reinstall the upper control arm and upper control arm bolt.





- 13.** Tighten any loosened bolts to the appropriate torque spec found in a Toyota factory service manual.
- 14.** Double check to ensure that all bolts are tight.
- 15.** Reinstall the front wheel. Torque all lug nuts to the appropriate torque spec found in a Toyota factory service manual.
- 16.** Repeat this process on the other side of the vehicle.