



INSTALLATION INSTRUCTIONS



COMPONENT: CAM TAB GUSSETS

PART #: 59860, 59860-10FJ, 59870, 59960

REQUIRED TOOLS

- Drill
- Hammer
- Sander or grinder
- Welder
- Chisel or air chisel

IMPORTANT

- This procedure will require cutting, grinding and welding to your chassis. Removing your battery ground/power is recommended. TOTAL CHAOS suggests that only qualified and experienced fabricators perform this installation.
- Place vehicle securely on jack stands. Make sure the front wheels are not contacting the ground. Chock both rear wheels of the vehicle to secure it from rolling back. Remove the front wheels and tires.

ON MOST TOTAL CHAOS CAM TAB GUSSETS, ALL FOUR FRONT PIVOT PLATES WILL HAVE A LARGER OVAL FOR THE ECCENTRIC BOLT. THE REAR PIVOT PLATES WILL HAVE A SMALLER OVAL.*



**FRONT PIVOT CAM TAB
(LARGER HOLE)**



**REAR PIVOT CAM TAB
(SMALLER HOLE)**



**OVERLAY
COMPARISON**

*On the 59960 Cam Tab Gussets for the 96-04 Tacoma & 96-02 4Runner the ovals are the same size.

STEP 1

Remove lower control arms and proceed to drill out the spot welds on all eight factory cam tabs.



STEP 2

Using a chisel or air chisel remove the factory cam tabs from the frame.

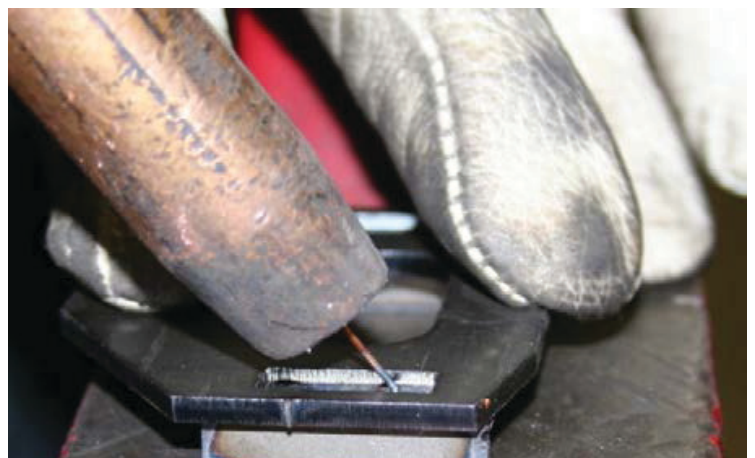
**STEP 3**

Hammer the two tabs into the two holes in the gusset.

NOTE: You may have to flip the bracket over to get the tabs to stick.

**STEP 4**

Weld the tab on the back of the gusset.



STEP 4 CONTINUED**STEP 5**

Sand the back weld on the gusset flush.

**STEP 6**

Weld the outer side of the two front tabs.

Repeat steps 3-6 on the remaining seven gussets.



STEP 7

Use a sander to remove all paint and clean the surface in preparation for welding.

**STEP 8**

Ensure the lower control arm eccentric bolts fit and rotate correctly in the new cam tabs as well as the frame prior to welding.

**STEP 9**

Snug up the cam bolts and tack the four corners of the cam tabs.



STEP 9 CONTINUED**STEP 10**

Once properly set, remove bolt and alignment cam and weld both sides of the tab to the frame. After all eight cam tabs are installed, spray paint surface black and reassemble lower control arm cam bolts.



NOTE: On some models the plate hangs beyond the frame. This is completely fine. Weld a portion of the backside to ensure the plate is in place.





CAM TAB GUSSET INSTALLATION IS COMPLETE!



FOR INSTALL QUESTIONS OR CUSTOMER SERVICE INQUIRIES:

Call 951.737.9682 or email info@chaosfab.com