

## Heim Steering Kit Installation

**PT# 96098 (96-02 4Runner), PT# 96099 (96-04 Tacoma)**

**PT# 97099 (00-06 Tundra)**

**Factory manual is recommended for removal and re-installation of all factory components.**

### Stock Tie Rod Removal

1. Put truck on jack stands, remove front wheels.
2. Remove cotter pins from tie rod ends.
3. Remove tie rods.
4. Remove lower ball joints and clean surface for welding.

### Installation of Heim Steering Kit

1. (Tacoma only pt# 96099) Press in tapered sleeve to lower ball joint.  
(Tundra pt# 97099 / 4Runner pt# 96098) Drill out tie rod hole to 5/8". A drill press is preferable and should be done by an experienced technician or machine shop.
2. Sand surface on ball joint for welding of gusset.
3. Bolt heim joint and gusset to lower ball joint for mock up and then tack weld gusset to the ball joint.
4. Remove heim joint and fully weld gusset to ball joint.
5. Bolt and torque ball joint to spindle.
6. Bolt and torque ball joint to lower arm and install new cotter pin.
7. Assemble heim w/ jam nut and misalignment spacers to ball joint.
8. Torque 5/8" bolt to 90ft lbs.
9. Thread new tie rods to steering rack and onto heim.
10. Bolt wheels back on vehicle and torque.
11. Adjust alignment and tighten jam nuts.

