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## **Installation Notes: # 59697**

### **1996-2004 Tacoma, 1996-2002 4Runner & 2000-2006 Tundra**

### **Weld-On Spindle Gussets**

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.

#### **(Before you start disassembly)**

- Make sure the vehicle is secure and ready to work on.
- The vehicle suspension should be at max extension.
- Disconnect the negative (-) battery terminal at the battery.

#### **Disassembly:**

**Step 1: Stock Upper Control Arm:** Remove the upper ball joint clips from the castle nut. Loosen and remove the castle nut. Disconnect upper control ball joint clip and press ball joint out of spindle.

**Total Chaos Uniball upper control Arm:** Remove upper control arm bolt from spindle and lift out of the way. (Leave slug adapter in spindle during welding.)

**Step 2:** Using a marker, mark along the sides of the spindle. You may need to bend the outer dust shield out of the way to weld the bottom lower portion of the spindle gusset. (remove spindle gusset) Clean all paint off the spindle in the area that are marked. (paint must be removed completely for a quality weld.)

**Step 3:** (Re-install spindle gusset.) Tack the gusset into place. It's recommended to tack weld in a couple of spots on the top of the spindle, on the bottom of the spindle and a couple from top to bottom. Weld along complete top and down sides of the spindle. Weld the lower portion of the spindle gusset closest to the hub on both sides in and out. (It is recommended to weld in moderation, do not overheat the spindle. May cause distortion.) \*\*Recommended: Weld some on one spindle, then move to the other side and weld some.

**Step 4:** Paint the welded areas and new gusset itself. Re-install the upper ball-joint and torque nut to 65ft/lbs for stock UCA's and to 100ft/lbs for Total Chaos UCA's then re-install the clip through castle nut.

**Step 5:** Re-install wheels.

**\* Torque all lug nuts before driving.**

**\* Do a visual on Complete install before driving!!**

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

