



159 North Maple St. Unit J, CORONA CA 92880
P. 951-737-9682 F. 951-737-9006
WWW.CHAOSFAB.COM

Installation Notes: # 59699

2007-2021 Tundra Spindle Gussets

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

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: Remove the upper ball joint clips from the castle nut. Loosen and remove the castle nut.

Step 2: The hole in the spindle gusset plate will go over the threads of the ball joint.

Step 3: Snug the castle nut back down onto the treads to hold the spindle gusset in place.

Step 4: 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 5: (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. Remove the upper ball-joint from the spindle and lift the upper control arm out of the way. Weld along complete top and down sides of the spindle, also weld the bend seam. 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.) **Recommended: Weld some on one spindle, then move to the other side and weld some.

Step 6: Once spindle gussets are welded completely, add the rear patch in plate. This plate goes over the top of the gusset then against the spindle. (Adjust this plate to where it fits best before welding.) Tack in place then weld at this time.

Step 7: Paint the welded areas and new gusset itself. Re-install the upper ball-joint and torque nut to 85ft/lbs for stock UCA's and to 100ft/lbs for Total Chaos UCA's then re-install the clip through castle nut.

Step 8: Re-install wheels.

* Torque all lug nuts before driving.

* Do a visual on complete install before driving!!

