



**Vehicle Fitment: 3rd Gen 4Runner, 1st Gen Tacoma
Heavy Duty Spindle Gusset Install Instructions**

Parts Included:

- (1) Driver Side Main Gusset
 - (1) Passenger Side Main Gusset
 - (2) Top Plate
 - (2) Small Bottom Gusset
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Tools Needed:

- Sander or Wire Wheel to clean spindle surfaces
 - MIG or TIG welder
 - Miscellaneous tools for removing the spindle from the vehicle (please follow the factory Toyota manual for removal instructions)
 - Spray Paint
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Installation

1. Remove the spindle from the vehicle. Please follow the factory Toyota manual for detailed instructions on removing the spindle from the vehicle. Once it is removed, you should only have the spindle as pictured. Leave the upper ball joint or uniball adapter in the top spindle hole for the time being. This will be removed later.



2. Place the gusset pieces on the spindle temporarily and mark areas that need to be cleaned. Refer to photos in the next steps if you are unsure of where to place the gusset parts. Remove gusset parts and remove surface rust, paint and grease from the spindle with any type of sander and degreaser in the areas that will be welded.



3. Place the MAIN GUSSET piece onto the spindle as pictured below.



4. Place the TOP PLATE at the top of the MAIN GUSSET (shown below). Once fitment is verified, tack the TOP PLATE to the MAIN GUSSET. Do not yet tack it to the spindle.



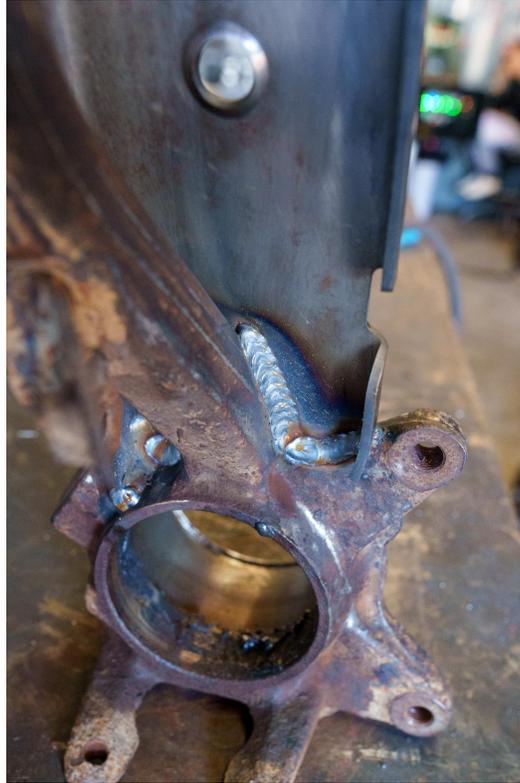
5. Now that these two parts are tacked together, align them so that the hole of the TOP PLATE is centered as perfectly as you can with the upper ball joint hole. Make sure that the hole of the TOP PLATE fits around your upper ball joint or uniball adapter. The spindle in the picture example below did not have an adapter in the spindle hole but usually you would want to still have it installed to verify fitment. Tack the gusset to the spindle so it does not move.



6. Remove the upper ball joint or uniball adapter. These parts should not be subjected to the heat from welding.
7. Fully weld the gusset to the spindle in all of the areas pictured below. *Note: the SMALL BOTTOM GUSSET should not have been added in and should not be welded or tacked in yet. This part will be added on after the MAIN GUSSET and TOP PLATE are fully welded in because parts of the MAIN GUSSET will not be accessible to weld once the SMALL BOTTOM GUSSET is welded on.*







8. Tack the SMALL BOTTOM GUSSET into place as pictured.



9. Fully weld the SMALL BOTTOM GUSSET.



10. Wait for the spindle to cool. Do not try to cool it with water. Once it is fully cool, paint the spindle with spray paint to prevent rust. Do not weld inside the upper ball joint hole or inside the wheel bearing area. Cover any bolt holes to prevent paint from getting into the threads.

11. Optional: Replace your wheel bearings while you have the spindle removed from the vehicle, especially if they have not been changed recently.

12. Follow the factory Toyota manual instructions to reinstall the spindle on to the vehicle.

13. Enjoy your new heavy duty spindle gussets!

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