



# INSTALLATION INSTRUCTIONS

**Tacoma Solid Axle Swap**

**Part # TACO-SAS-001**

## Notice to Dealer / Consumer

**Important! Read all instructions before attempting any work on the vehicle.**

**Disclaimer Notice:** Installing this suspension system on any vehicle implies that you are in agreement with the following term and conditions with respect to that vehicle, the vehicle owner, and any or all occupants of said vehicle at any time:

- Sky Manufacturing is not responsible and cannot be held responsible for any conditions of said vehicle, including but not limited to the following: 1) Any and all adverse behavior, premature failure, or breakage caused by oversized tires and wheels, improper installation, failure to follow instructions, or any general negligence caused by installer or owner of said vehicle. 2) Any breakage or premature failure caused by racing or driver negligence. 3) Any incident determined to be caused by an increase in height in said vehicle's center of gravity. 4) Any incident determined to be caused by improper installation. 5) Any incident determined to be caused by a failure of materials.
- Sky Manufacturing is to be held harmless by the installer of this suspension component, owner of said vehicle, and any parties related directly or indirectly to said vehicle or owner of said vehicle. Sky Manufacturing is to be held harmless by all parties mentioned during the course of any and all circumstances or incidence resulting from the installation of this suspension component.

It is not the intention of Sky Manufacturing that said vehicle be modified for use on public highways sanctioned by the Department of Transportation, or any state or local governing body. Vehicle owner accepts sole responsibility for ensuring that said vehicle is not in violation of local, state, or federal laws or vehicle code. Please check local vehicle laws and regulations before modifying your vehicle.

**By installing this kit or having this kit installed on your vehicle, you are implying that you agree to the above terms and conditions. Please do not install this system if you do not agree.**

### **WARNING:**

**Vehicles modified for Off-road use may handle differently and vehicle may roll-over.**

Vehicles modified for off-road use are generally do not improve in cornering or maneuverability on the highway, therefore it is imperative to familiarize yourself and all operators with the specific driving characteristics of the vehicle. Failure to operate in a safe and conservative manner may cause you, your passengers, and/or third parties to suffer serious injury or even death if control is lost.

Always wear your seatbelt and shoulder harness. Seatbelts not only help to protect occupants from injury but also keep the driver behind the wheel and in control when operating in rough terrain. Always remain on trails and observe conservation techniques while operating your vehicle.

There are no specific directions to install this product due to the number of combinations of springs, axles, lifts etc. possible. Professional installation is recommended. This kit requires knowledge of suspension design, fabrication and welding skills.

**If you lack those, do not purchase this kit!**

## Tacoma Solid Axle Swap

Inventory all parts.

Disonnect battery.

Lift and support the vehicle properly.

Disconnect drive shaft, brake lines, sensors etc from front end.



Remove the front suspension and all front suspension brackets.





Grind the frame smooth and clean and mock up frame reinforcement plates. Mark steering box location



Drill holes and install frame tubes.



Tack Frame tubes in place





Check Fitment of steering box to frame



Check Frame plate lines up with frame tubes



Weld up frame plates





Frame plates installed



Weld in front frame rail reinforcement



Measure leaf springs for axle placement and measure for front spring hanger placement.

A good starting point to the spring hanger is to measure a straight line from front cab mount bolt to eye of hanger bolt for 45.5 inch measurement. Next measure back 45.250 inches, this will be the upper shackle hanger eye if you are using our 3F springs

Make sure it is square and tack in place

Placement of the hanger will depend upon the springs you choose and how far forward you want the axle as well as tire size you want to be able to fit.





Measure back from the spring hanger to determine shackle hanger location. The dimension from eye to eye of the spring hanger to shackle hanger should be about 1/2" less than the length of your leaf spring (eye to eye straight across) to ensure a decent shackle angle. This will vary depending upon your spring choice and front hanger placement. Trim body mount out of the way and mark for cuts.





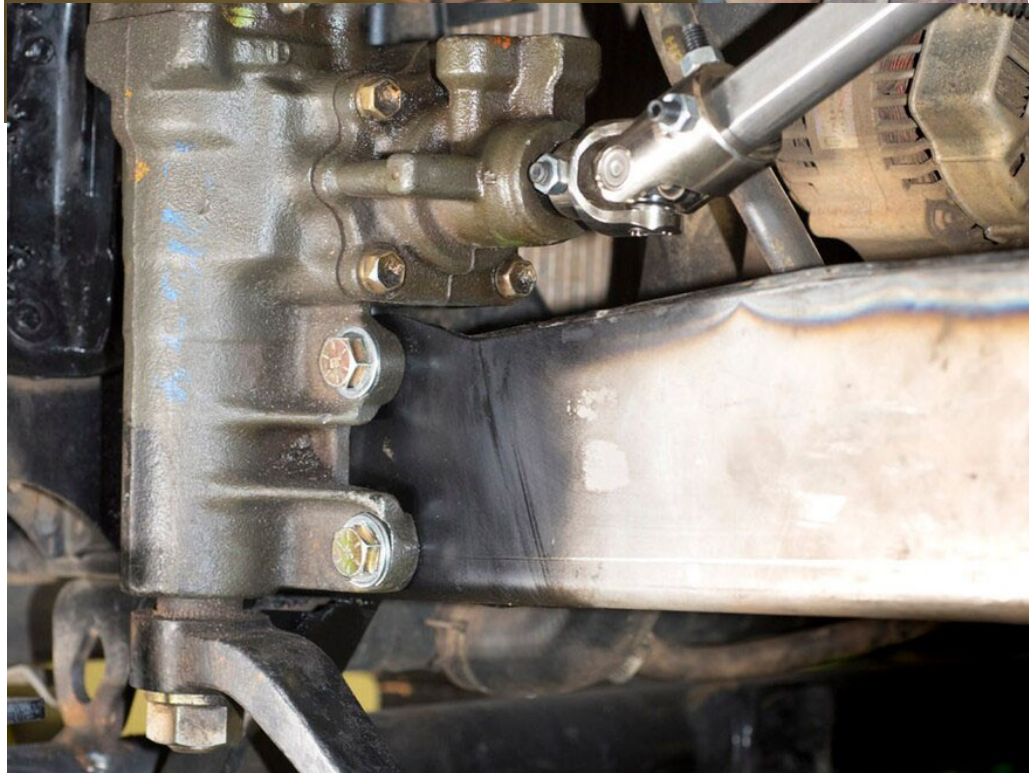
Line up shackles with springs and hanger to 31.5" on center and tack in place.



Install axle to springs and measure everything to ensure axle is square and all brackets are where they are supposed to be



Mock up steering to ensure it aligns with the axle properly





Somewhere in this process install your rear sump oil pan for axle clearance



With the axle in set it down on the weight of the truck to be sure the shackle angle is correct and everything is where it is supposed to be.



You can see in this install the axle was pushed forward significantly. This improves approach angle and gives room for big tires without modifying the firewall





Once everything is exactly where it needs to go weld it up



Install shock hoops and paint it all





Reinstall axle, springs and put together steering.  
Torque all fasteners by torque charts



We always use our flat pitman arm  
and as you can see without bump stops  
it still just barely clears the spring on  
up travel





Install drive shaft



Flex test to measure for shocks and check for clearance issues.



Do an alignment.





**Go wheelin!**

