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**PART# WFO TOY-9504-CM**

**'95-'04 Tacoma Crossmember**

## BILL OF MATERIALS

PART #	DESCRIPTION	QTY.
WFO TOY-9504-CM-DRIVER Side	Toyota Crossmember, '95-'04, Welded Driver Side	1
WFO TOY-9504-CM-PASS Side	Toyota Crossmember, '95-'04, Welded Passenger Side	1
WFO TOY-9504-CM-CENTER	Toyota Crossmember, '95-'04, Welded Center Section	1
1/2-13 Bolt x 1.5" GRADE 8	½" Bolt	8
1/2" SAE Washer, GRADE 8	½" Washer	16
1/2-13 Nylock, GRADE 8	½" Nylock	8

### Tools Needed:

- 3/8" Socket Wrench
- 12mm Socket
- 14mm Socket & 14mm Wrench
- 3/4" Socket & Wrench
- Cut off wheel or torch
- Grinding Wheel
- Welder

*Approximate Install Time: 2 hours*

### Note:

- This is a Weld on crossmember.
- This crossmember can be installed prior to the IFS being removed.

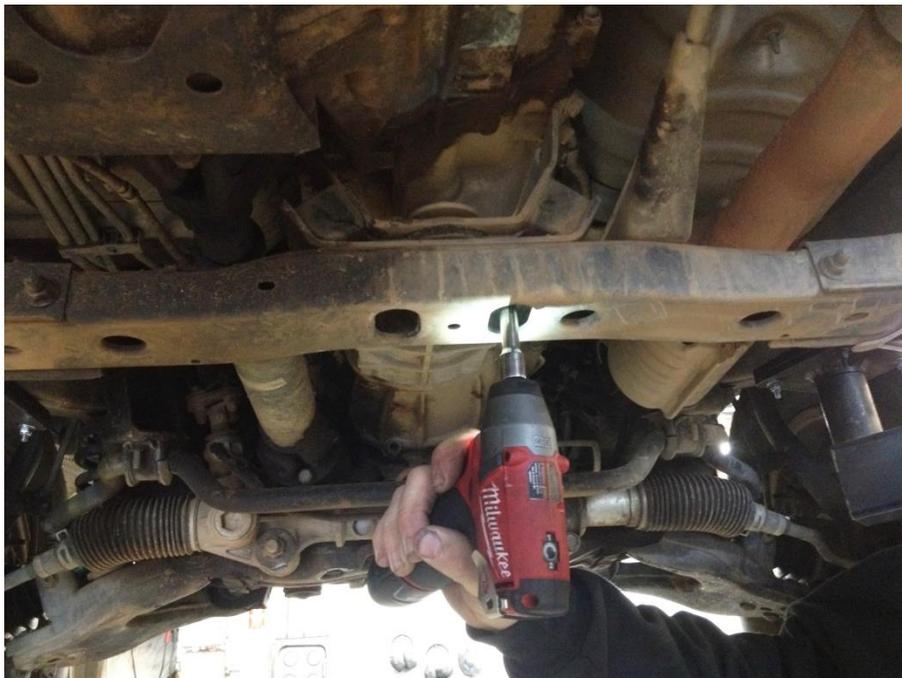
# '95-'04 Toyota Tacoma Crossmember Installation Instructions

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- 1.) Support the Transmission/Transfer case assembly at the rear of the output shaft so you can safely remove the stock crossmember.



- 2.) Remove the 4 center factory transmission bolts using a 12mm socket.



# '95-'04 Toyota Tacoma Crossmember Installation Instructions

- 3.) Remove the 4 factory bolts holding the center section onto the two frame brackets of the stock crossmember using a 14mm socket and wrench.
- 4.) Disconnect the factory rubber isolator from the exhaust tubing that is connected to the factory crossmember center section. You can leave it connected to the rear portion of the exhaust tubing.



- 5.) Pry off the factory center section of the crossmember. Temporarily save the factory center section because you will end up cutting off and reusing the factory exhaust hanger on your new WFO Crossmember on step 12.
- 6.) Cut off both factory crossmember brackets from the frame, using a cut off wheel or torch.  

NOTE: On the Driver Side, beware of the brake lines. You may want to move them up and out of the way.
- 7.) Grind the frame clean where you will be welding on the new WFO frame brackets. You will want to grind about 1" past the factory oval hole on the bottom of the frame. Our crossmember will sit slightly further back than the stock crossmember. (see photo on next page)

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- 8.) Using the supplied ½" Grade 8 bolts, Bolt together the new WFO Crossmember **before** you install it. You will lift it up into the vehicle in one piece.
- 9.) Raise the WFO Crossmember up into the vehicle, lining up the transmission mount and the rear key ways on the two WFO frame brackets so they fit into the oval holes on the frame.



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- 10.) Square up the new WFO Crossmember on the vehicle.
- 11.) Tack the two WFO side brackets on the frame.
- 12.) Grab the factory center section that you set aside earlier and unbolt the two bolts that are holding on the factory exhaust hanger, using a 12mm socket. You will need to cut down the factory exhaust hanger bracket so it fits onto the new WFO Center section. Draw a line just slightly past the bolt holes as shown below and cut.



- 13.) After you have cut the two bolt holes off, you can now set the revised exhaust hanger onto the new WFO Center section while it is mounted up in the vehicle making sure you can reattach the rubber isolator. Once you're pleased with the location you can tack it in place. After you weld on the two WFO frame brackets on the frame you may remove the center section so you can completely weld the exhaust hanger before painting.
- 14.) Begin welding the two WFO Side Brackets onto the frame. Weld as much of the side brackets as possible.
- 15.) After final weld, remove the center section so you can paint everything to prevent corrosion. Then Reassemble and Enjoy!