



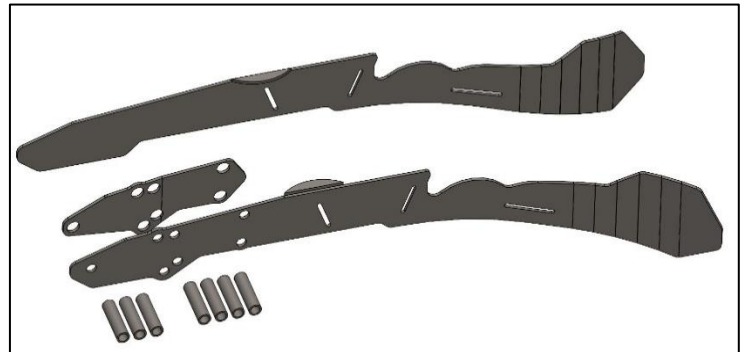
## INSTALLATION INSTRUCTIONS

Part #	Description
WFO FPT-0515-TG Or WFO FPT-0515-PSC	Frame Plates for 05 – 15 2nd Gen Toyota Tacoma, 03 – 09 4 <sup>th</sup> Gen 4 Runner

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Phone: 530.268.9494    www.wfoconcepts.com

### WFO Frame Plates

BILL OF MATERIALS		
WFO FPT-0515-D	Qty. 1	Driverside Plate
WFO FPT-0515-P	Qty. 1	Passengerside Plate
WFO FPT-0515-IFP	Qty. 1	Driver Inner Frame Plate
WFO FPT-0515-C	Qty. 2	Top Filler Cap
Tube Sleeves	Qty. 3 or 4	Toyota or PSC Box Sleeves
Hardware	Qty. 3 or 4	Toyota or PSC Box Bolts
TOOLS NEEDED		
Jack Metric and Standard Socket Set Metric and Standard Wrench Set Impact Gun Cutoff wheels / Sawzall / Plasma Cutter Drill and Drill Bits Center Punch Grinder Welder Semi-Flat Black Spray Paint Tape Measure		



### WARNING!

- \*\*\* Read all instructions thoroughly from start to finish before beginning the job! If these instructions are not properly followed, severe frame, suspension, tire, or body damage may result to the vehicle!
- \*\*\* WFO Concepts recommends that you exercise extreme caution when working under vehicles supported by jack stands.
- \*\*\* WFO Concepts recommends all installation to be performed by a professional shop/service technician. Product failure due to improper installation will not be covered under WFO's warranty policy.

### TECH NOTES:

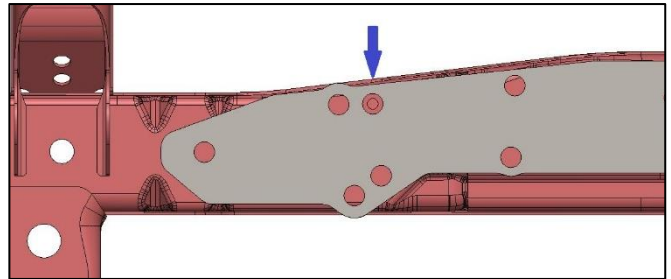
- 1) These directions are for the Frame Plates Only. 3 Sleeves and hardware come with the OEM Toyota IFS Steering Box. 4 Sleeves and hardware come with the PSC Box.
- 2) Take extreme caution while removing factory brackets from frame. And not to damage surrounding items, hoses, or wire harness'.
- 3) WFO Suspension Components should be installed on a well-supported vehicle. Either supported by using appropriately rated jack stands under the front and rear frame rails OR by using an automotive lift.
- 4) These frame plates require removal of factory mounted suspension brackets. Returning back to stock suspension will **not** be possible.

## INSTRUCTIONS:

1. Due to non-modified and modified trucks/4 runners, it is up to you to unbolt and remove all suspension components from frame.
2. Take a cutoff wheel, torches, or plasma cutter and start removing the factory suspension brackets off frame. Grind completely clean afterwards. The cleaner you prep the frame of any old paint the better your frame plates will come out.



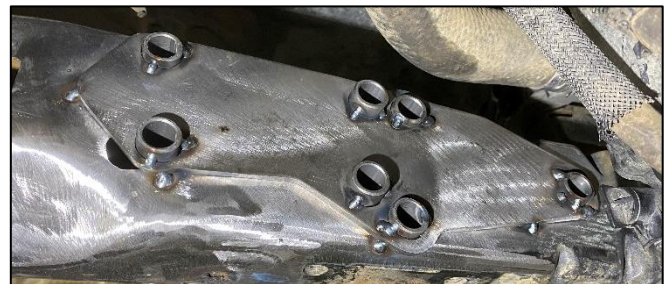
1. Once both sides are clean and prepped, locate the Driverside inner and outer frame plates. One of the 7 holes will locate on 1 of the holes in the frame. The 2 pictures below show the hole referenced. It's roughly 7-5/8" back from the body mount. Position and clamp frame plate to frame with a few C-clamps.



2. The front 3 holes in the frame plate are for the OEM Toyota IFS Steering Box, and the rear 4 holes are for the PSC Box. Mark with a sharpie or use a center punch to mark the holes for drilling. The other set of holes you can either leave or eventually fill by welding them.

**\*\*\* Note – Purchasing a long 1/4" drill bit will help drilling the frame plate sleeves much easier. You can find them on Amazon. The frame is wider than most normal sized drill bits can reach. Also, a Step Bit that goes up to 3/4" will help in tight places on the inside of the frame \*\*\***

3. Start by using a smaller drill bit and work your way up to 3/4". Lining up the holes for the inner frame plate is not easy. So, take your time when drilling all the way through the frame. It's best to start with one hole to the 3/4" drill bit size, attach the back plate, and mark the centers of the remaining holes. If you have a 90° drill, this will make the job a lot easier on the inside. Once you have a small pilot hole for the inside plate holes, transferring the outer holes will make the job a lot smoother. Once the initial small holes are drilled, use a step bit or drill bit, to open up the holes to the desired 3/4" bushing sleeve size. Locate the correct sleeves for the box used. OEM Toyota IFS Steering Box will have (1) 2-7/8" & (2) 3-1/8" long sleeves. The PSC Box will have (4) 3-3/8" long sleeves. Mock up the sleeves in the frame. (The image below shows all 7 holes drilled and sleeved for reference only.) **Putting a chamfer on the outer side of the tube will help when welding.**

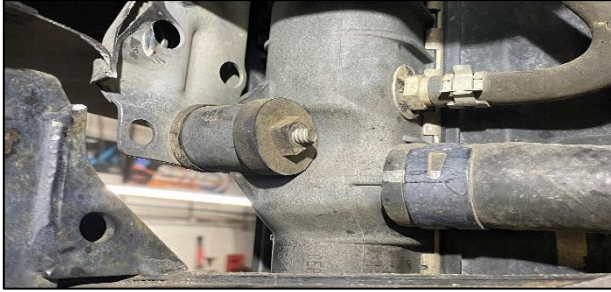




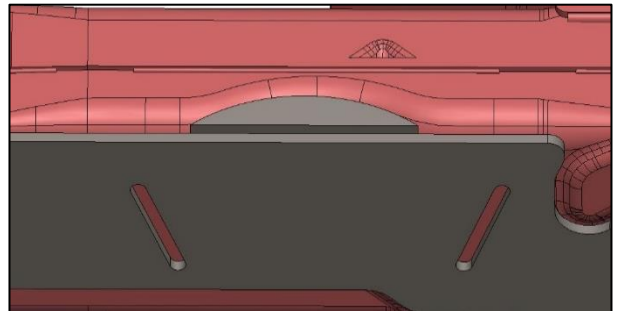
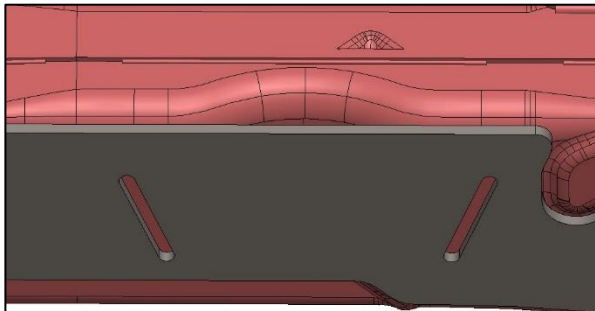
4. Mock up your chosen box to test if the sleeves line up. The Toyota box has ½" Bolt Hardware that will go from **outside** to the inside. The PSC Steering Box will have M12 Bolt Hardware that will go from the **inside** to the outside and thread into the box. If the bolts don't go in smooth, you will have to open up the holes that the sleeves go through so they line up better. A die grinder works best here. You want the box and sleeves to almost "float" back and forth, meaning you don't want your bolts and sleeves in a bind when tightening them down. This could cause premature stress on the steering box and could result in cracking box housing!

*\*\*\* Note if running a Toyota IFS Steering Box; we have located the box as far forward as possible to help steering geometry as well as you are able to push the axle more forward so you can run bigger tires. By doing this the box will have interference issues with your radiator. Removing the lower Driverside mount will be needed. An air saw can make quick work of this.*

**BE CAREFUL TO NOT CUT INTO THE RADIATOR! \*\*\***



5. Once the steering box of your choice bolts up without bind, you can remove and tack the frame plate on. We recommend tacking it about every 6" – 8" around the perimeter. Repeat with the opposite side. Supplied with the plates are 2 curved pieces. These go in the divot which was where the strut tower was. Refer to the pictures below on where to place it.



6. Fully weld frame plates. Don't just burn 1 entire plate, jump from one side to the other, and front to back. Welding no more than 6" at a time. Once fully welded, grind the outer faces of the frame sleeves smooth, the steering boxes need to sit flat up against the frame. (Picture below has all 7 holes installed for reference only)





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