

SPINDLE GUSSET KIT INSTALLATION INSTRUCTIONS

	<p>NOTICE</p> <p>Read instructions completely before installing this product. Refer back to the instructions frequently during installation.</p>		<p>CAUTION</p> <p>Flying Object Hazard. Fluid Splash Hazard. Wear safety glasses at all times when working on vehicle.</p>
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	<p>WARNING: Cancer and Reproductive Harm - www.P65Warnings.ca.gov</p>
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1. Safely support the vehicle by the frame using jackstands so the front suspension is at full droop. Remove the front wheel.
2. Remove the front caliper from the knuckle. Keep the brake line connected to the caliper and disconnect any brake line mounts connected to the knuckle. DO NOT let the caliper hang by the brake line, support the caliper with a piece of wire or zip tie.



3. Remove all brake line mounts, wheel speed sensors, and related wiring from the knuckle (if equipped).



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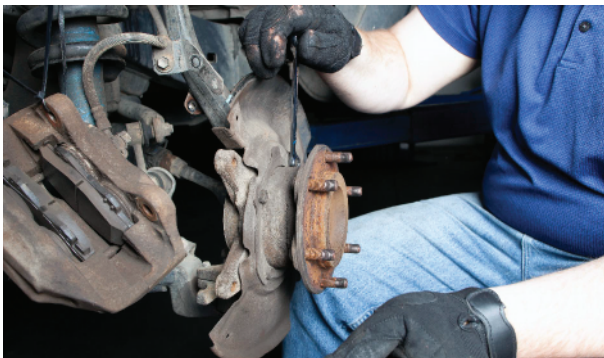
4. Remove wheel center caps (if equipped) and remove the rotor from the knuckle.



5. If the vehicle is equipped with 4WD, remove the dust cap exposing the axle nut. Remove the cotter pin and remove the axle nut using a 1 3/8" (or 35mm) socket.



6. Loosen but do not remove the four 12mm bolts that hold the brake disc dust cover on the knuckle.



7. Remove the cotter pin from the upper ball joint and loosen the upper ball joint nut.



8. Remove the upper ball joint from the upper control arm. (If your vehicle is equipped with a uniball-style upper control arm, loosen then remove the uniball bolt to separate the spindle from the upper control arm).



9. Remove the four 14mm bolts that attach the lower ball joint cradle to the knuckle.

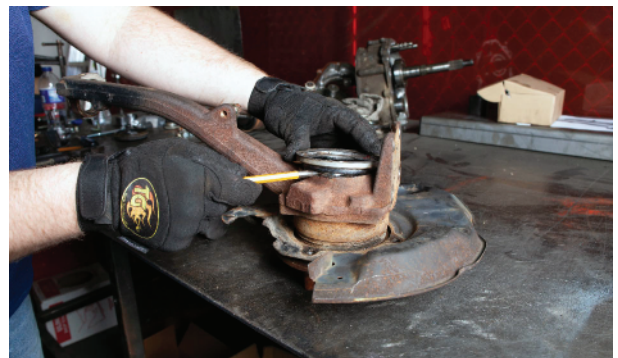


10. Using a dead blow hammer knock the axle out of the hub assembly. Move the knuckle to a work bench.

12. Remove the ABS sensor from the knuckle (if equipped).

11. Loosen the dust shield by unbolting the four 12mm bolts loosened earlier.

13. If equipped, remove the axle seal with a scraper. When reassembling, replace this seal if damaged.



14. Remove the snap ring holding in the upper ball joint and remove the upper ball joint from the knuckle. If your vehicle is equipped with a uniball style upper control arm retain the puck inside the upper control arm during welding.



15. Position the provided gusset on the knuckle and mark the areas where the gusset contacts the knuckle. Remove any paint, grease, or other contaminants around the marked areas and prep the knuckle for welding. Minor sanding of the gusset may be required to achieve the best fit on the knuckle. Be sure to place the upper part of the gusset where it will not contact the ball joint or uniball puck when they are installed in the knuckle.



16. Tack weld the gusset to the knuckle. After the pieces are tack welded together fully weld the gusset and the knuckle. Only weld about an inch at a time to prevent warping the knuckle and overheating the wheel bearing. Let the knuckle cool before moving onto the next section to be welded.

17. After the knuckle has cooled paint any exposed metal to prevent rust.





- 18.** Reinstall or replace if needed the dust shield, upper ball joint (if equipped), ABS sensor (if equipped), and axle seal (if equipped) following the appropriate Toyota Service Manual.
- 19.** Reinstall the knuckle onto the vehicle following the appropriate Toyota Service Manual.
- 20.** Double check to ensure all bolts are tightened to the factory torque specification.
- 21.** Replace the front wheel and torque the lug nuts.
- 22.** Repeat the process on the other side of the vehicle.