



DMZ Fab & Race Prep

Thank you for purchasing the **DMZ-75014, weld on motor mount perch gusset kit** for the 2005 and early 2006 Tacoma Prerunner and 4x4. This kit is designed to strengthen the area below the motor mount perches on 05 and early 06 Tacoma Prerunner and 4x4 trucks and prevent the frame cracking / cave in that happens on these models. It is also an absolute necessity if yours already broke and you need to repair it properly, so it won't break again.

The installation of this kit does require mechanical, grinding, and welding skills, however, it is not difficult if you can weld and have basic mechanical skills. If you do not have the skills or ability complete this installation on your own, it might be best to contact a reputable shop that can complete the installation for you.

While these are not step by step instructions, the following notes and pictures should answer most installation questions you will have.

Steering shaft : It is necessary to remove the lower portion of the steering shaft for access to the drivers side perch on both Prerunner and 4x4 trucks. *(See factory manual if you need detailed instructions)*

Front Differential : It is highly recommended to remove the front differential on 4x4 vehicles to properly gain access for paint removal and welding. *(See factory manual if you need detailed instructions)*

Battery : It is highly recommended to disconnect the battery before welding on any vehicle.

Paint removal : Once you have access to the motor mount perch area, hold the gussets in their approximate position and mark around them for paint removal. You will have to remove all the paint from the area to be welded to get a sound weld. A right angle pneumatic die grinder with a roloc pad works nicely. *(See pics below for positioning reference)*

Installation : Every frame can be slightly different, but the gussets are designed to allow for slight factory variations. You may have to grind down some of the factory weld below the perches to get the gussets to be tight enough to the frame for welding. Once you are happy with the fit, position the gusset plates as shown and tack them on.

Welding : Be sure to weld the entire perimeter of both gussets and the additional reinforcement for the drivers side mount! Be sure to wear proper protection and follow all normal safety precautions while welding. Remember, you will be welding overhead and sparks could fall on you and cause serious burns.

Wrapping up : Clean and paint the gussets and welded area to prevent rusting. Reinstall any previously removed components following the factory manual and factory torque specifications. Test drive vehicle in a safe area to check your mechanical work.

Drivers side gusset and reinforcement plate installed.



Passenger side gusset installed.



Questions? : For any questions regarding this DMZ product or the installation thereof, please contact DMZ Fab & Race Prep at (951)371-8500 or email us at tim@dmzfab.com.