



Custom Toyota Truck Tube Works

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## 2005-2021 Tacoma Bolt on Slider Install Guide

Congratulations on purchasing your new 4x Innovations Bolt on Sliders. Included in this manual are package contents, surface coating recommendations, and installation procedures. This document consists of a guide and is not an absolute instruction manual. Professional installation and attention to details is required.

### Package Contents:

- |                              |                                |
|------------------------------|--------------------------------|
| 1 x Driver Side Slider       | 10 x 1/2 G8 Spiral Lock Washer |
| 1 x Passenger Side Slider    | 8 x 3/8-16 x 1/2 G8 Bolt       |
| 1 x Driver Rear Frame Brace  | 8 x 3/8-16 x 1 G5 Bolt         |
| 3 x Inner Frame Brace        | 3 x 3/8-16 x 1.5 G5 Bolt       |
| 9 x Frame Backer nut         | 11 x 3/8 Flat Washer           |
| 1 x Small Frame Backer nut   | 11 x 3/8 Lock Washer           |
| 1 x 1/2-13x1 Grade 8 Bolts   | 2 x 3/8-16 Nut                 |
| 9 x 1/2-13x1.5 Grade 8 Bolts | 2 x M10x1.25x35 Bolt           |
| 10 x 1/2-13 flat washer      |                                |



Figure 1 – 1311300 Kit Contents

### Caution:

1. Installation must be performed by qualified professional mechanic.
2. Always wear proper Personal Protective Equipment, including but not limited to Closed Toed or Safety Shoes, Safety Glasses, Hearing Protection.
3. Working around vehicles is inherently dangerous. You and the installer are responsible for your actions. Take general care while working on a vehicle.



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**Coatings:** Note: For optimum coating performance follow coating manufacturer's instructions.

A. On the quick and easy: Simple spray paint.

This method is an economical method to coat your new sliders. Any top quality spray paint rated for metals can be used. In our shop we use Rustoleum Professional Metal paint.

B. POR-15 or similar moisture cured polymers:

These professional coatings are highly durable and can be touched up if scratched. They are available online, usually directly from the manufacture.

### Preparing Your Tacoma:

1. Remove the frame plug and bolt shown in Figure 2



Figure 2 – Driver side prep 1

2. Remove 2 nuts in the side of the frame and bolt in the bottom of the frame shown in Figure 3



Figure 3 – Driver side prep 2

3. Remove the bolt holding the brake lines to the frame. Remove the bolt holding the frame fill cup and remove the frame fill cup. Loosen the plastic brake line clip from the frame shown in Figure 4.

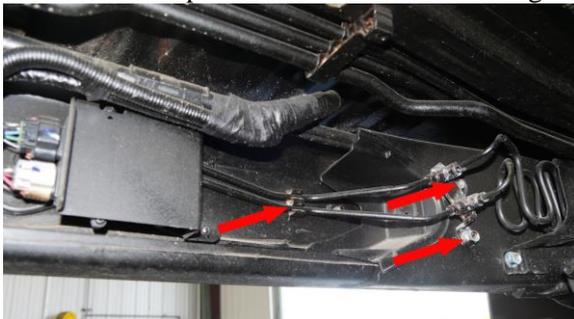


Figure 4 – Driver side prep 3

4. Loosen the plastic brake line clip shown.



Figure 5 – Driver side prep 4

5. Remove the frame plug and bolts shown in Figure 6. The bolts hold the dust cover over the electronics box. Also unbolt the electronics box from the frame.



Figure 6 – Passenger side prep 1

6. Remove the bolt in the bottom of the frame and the inner frame fill cup on the passenger side.



Figure 7 – Passenger side prep 2



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## Installing The Sliders:

1. Starting with the driver side, insert one square nut into the front cross member through the hole on the lower outside area of the cross member.
2. Place one of the 3 inner frame braces up and over the front from the inside of the frame at the end of the front box section of the frame.
3. Place the driver rear inner frame brace (the one with the notch cut out of the side) in place. Place the lower edge of this brace inside the frame for now.
4. Gather 3 more regular square nuts and the one smaller square nut, 1 of the M10 metric bolts, and 4 1/2-13x1.5 bolts and 1 1/2-13x1 bolt, flat washers and lock washers.
5. Put a lock washer and then flat washer onto each of the 1/2" bolt
6. With the help of a friend put the slider up to the truck. You will have to wiggle it to get it to slide over the rivets that are on the side of the frame.
7. Hold the slider in place with the M10 bolt that goes in the hole in the bottom of the frame from preparation step 2 above. Do not tighten the bolt yet.



Figure 8 – Inserting square nut into the cross member



Figure 9 – Driver Front Inner Frame Brace in place



Figure 10 – Driver Rear Inner Frame Brace in place



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8. The small square nut goes behind the electrical box.
9. You can insert the front square nut by reaching up into the frame.
10. The square nut in the front cross member can be put into place by reaching a finger through the hole in the back side of the transmission cross member.
11. Install the two remaining square nuts in the large holes in the middle and back of the main mounting plate.
12. Slide the front inner frame brace back into place and secure with 2 3/8x1/2 bolts on the inside of the frame and 2 3/8x1 bolts nuts and washers going up through the outside flanges.
13. Slide the rear inner frame brace into place and secure the same way as the previous step.
14. Bolt the electrical box back into place
15. Tighten all slider bolts (70 ft.lbs for 1/2" bolts and 40 ft.lbs for 3/8" bolts).
16. Replace the front frame fill cup, front brake line mounting bracket, plastic brake line clips and outer wiring harness mounting bracket.



Figure 11 – Driver electrical box Square nut position

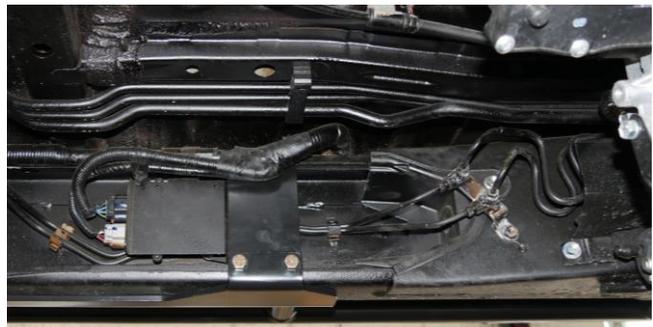


Figure 12 – Driver Front Done

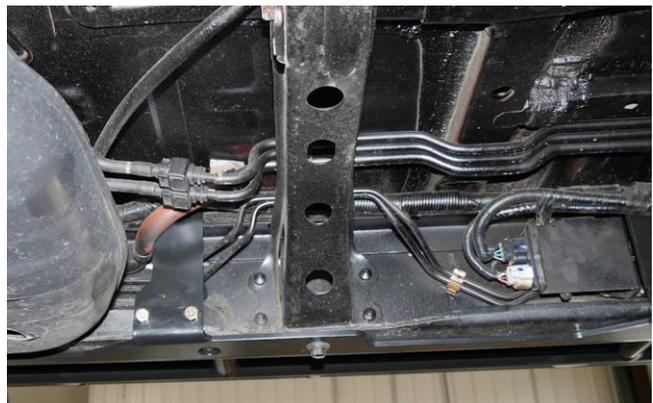


Figure 13 – Driver Rear Done



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17. The passenger side installs much the same way. Place a large square nut in the cross member as done on the driver side.
18. Place the front inner frame brace over the frame slightly forward of the position shown in Figure 14.
19. Place the rear inner frame brace over the frame slightly rearward of the position shown in Figure 15.
20. Gather the remaining 4 large square nuts, 1 of the M10 metric bolts, and 5 ½-13x1.5 bolts and flat washers and lock washers.
21. Put a lock washer and then flat washer onto each of the ½" bolt
22. With the help of a friend put the slider up to the truck. You will have to wiggle it to get it to slide over the rivets that are on the side of the frame.
23. Hold the slider in place with the M10 bolt that goes in the hole in the bottom of the frame from preparation step 2 above. Do not tighten the bolt yet.
24. You can insert the front square nut by reaching up into the frame.
25. The square nut in the front cross member can be put into place by reaching a finger through the hole in the back side of the transmission cross member.
26. Install the three remaining square nuts in the large holes in the middle and back of the main mounting plate.
27. Slide the front inner frame brace back into place and secure with 2 3/8x1/2 bolts on the inside of the frame and 2 3/8x1 bolts nuts and washers going up through the outside flanges.
28. Slide the rear inner frame brace into place and secure the same way as the previous step. This inner brace tends to run tight. A clamp may be needed to squeeze the slider tight against the frame for proper alignment.
29. Tighten all slider mounting bolts.
30. Reattach the electrical box and reinstall its cover
31. Reattach the frame cup.
32. Congratulations You're done! Enjoy you new Rock Sliders!



Fig 14 – Passenger Front Done



Fig 15 – Passenger Rear Done