



Custom Toyota Truck Tube Works

•52 Means Drive Suite 110  
•Platteville, WI 53818  
•Phone: (608) 348-4880  
•Web: <http://4xinnovations.com>  
•Email: [Adam@4xinnovations.com](mailto:Adam@4xinnovations.com)

## 2005 - Current Tacoma Bolt On Rock Slider Install Guide

Congratulations on purchasing your new 4x Innovations Rock Slider Set. 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's Side Rock Slider Assembly	10 x 1/2 x 1 1/2" Hex Bolts
1 x Passenger's Side Rock Slider Assembly	10 1/2" Flat Washers
2 x Nut Plate with Long Handles	10 x 3/8 x 1 1/2" C.S. Bolts
2 x Nut Plate with Short Handles	6 x 3/8" Washers
6 x Nut Plates	6 x 3/8" Nuts

### Caution:

1. This installation should be performed by a qualified professional.
2. Always wear proper Personal Protective Equipment, including but not limited to Closed Toed or Safety Shoes, Safety Glasses, Hearing Protection, Face Shield, and Gloves.
3. Always have a fire extinguisher in reach while working in and around your vehicle. Interior panels are made from vinyl and other plastics which burn VERY easily; under carriages can be covered in oil and road grime which also burns easily.
4. Working around vehicles is inherently dangerous. You and the installer are responsible for your actions. Take general care while working on a vehicle.

**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 Rock 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. Most are formed as multi part primer, color, and top coats that are abrasion, and heat resistant. They are available online, usually directly from the manufacture.
- C. Powder Coating:  
Powder coating consists of spraying a powdered paint onto the parts and baking the powder to the part. This process must be performed by a qualified business to have proper adhesion. This process is typically costly. Powder Coat is stronger than typical paint but WILL get scratched on a rock slider and offers little possibility for quality touch up once scratched. 4x Innovations does not recommend powder coating rock sliders because of this fact.

### List of Required Tools:

White or Silver Permanent Marker	5/16 inch Drill Bit
Hammer	3/8 inch Drill Bit
Small Pry Bar	1/2 inch Drill Bit
Hand Drill	3/8x16 Tap and Tap Wrench
Ratchet with 12mm and 3/4" Sockets	Thread Cutting Lubricant
7/32 inch Hex Key Wrench or Socket	2x C-Clamp
Center Punch and/or 3/8" and 1/2" Transfer Punch	Anti-Seize



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## Installing the Rock Sliders

1. DO NOT PAINT ROCK SLIDERS UNTIL STEP 16.
2. Starting on the driver's side, remove the wiring harness mounting plate located about in the middle (front to back) of the frame rail using a 12mm wrench. Set the bracket on the top of the frame to keep it out of the way during the installation process.
3. Remove the bolt on the bottom of the frame holding the bottom of the transmission cross member.
4. Inside the frame rail, CAREFULLY use a pry bar to remove the brake lines from the plastic holder that is located half way between the carrier bearing support cross member and the transmission cross member.
5. By hand, CAREFULLY spread these lines apart around the hole located just behind the clip. Reinstall lines into factory clip.
6. Locate 5x 1/2" x 1 1/2" bolts, 3 nut, 1 long handle nut plate, 1 short handle nut plate and the driver's side rock slider. Also locate center or transfer punch, hammer, and jack stands.
7. Position the rock slider onto the frame of the truck so that the slider is positioned between the wheel wells. The rock slider should sit on the frame so that the holes on the front of the rear bracket will line up with the 2 rear most rivets on the carrier bearing support cross member.
8. Hold the rock slider in place with 2 bolts on the side of the frame, and 2 clamps to the bottom of the frame.
9. Check the rock slider for alignment on the frame, front to back alignment with the body, clearance between the bottom of the split seam and the rock slider and clearance between the bottom of the door and the rock slider when the door is opened.



Figure 1. Passenger side front mount. Note it is recommended to use the forward most mounting hole for the front bolt, which requires drilling the side of the frame.



Figure 2. Passenger side rear mount, shown with optional spring skid mount.



Figure 3. Inside driver's side frame rail, behind transmission cross member, brake line modification.



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10. Using a marker or transfer punch mark the 4 lower holes that need to be drilled. One hole will line up with the lower transmission cross member bolt.
11. Using a marker or transfer punch mark the rear hole on the side of the frame. It is also recommended to drill the farthest forward hole on the side of the frame. The second hole back can be used but is not as strong.
12. Center punch the center of each hole location to prevent the drill bit from walking.
13. Remove the rock slider and drill the holes. The side holes need to be drilled to 1/2". For the bottom holes, the forward most two holes need to be drilled to 5/16" and the remaining holes drilled to 3/8". You will need to drill through the threads for the lower carrier bearing cross member bolt.
14. Thread the forward most lower hole for a 3/8"x16 bolt.
15. Repeat steps 1-3 and 6-14 on the passenger side.
16. Test fit both rock sliders and check for alignment of the drilled holes. Repair drilled holes if required.
17. Paint the rock sliders by desired method. also touch up paint on the surfaces of the newly drilled holes in the chassis.
18. Install rock sliders using 5 1/2inch bolts along the side, placing the washer between the bolt head and slider mounting plate. Use 5 countersunk bolts along the bottom placing the washer between the frame and the nut. For the forward most bolt use the nut plate with the long handle. For the second bolt from the front use the nut plate with the short handle. When tightening the front two bolts, allow the handle rods to push against the frame to prevent rattles. Use 5 countersunk bolts along the bottom placing the washer between the frame and the nut. For the bottom bolt that goes through the transmission cross member place a new nut on top of the factory nut that is welded to the inside of the frame.
19. Reinstall the wire harness brackets on each side.

Congratulations You're done! Enjoy you new rock sliders!