



Custom Toyota Truck Tube Works

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Weld On Rock Slider Install Guide

Congratulations on purchasing your new 4x Innovations Rock Slider Set. Included in this manual is the 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:

For 60" to 74" Rock Sliders:

2 x Fully Welded Rock Slider Main Assemblies
2 x 9.5" Long Tubes Notched on One End
4 x 6" Long Tubes Notched on One End
6 x 4x4" Frame Support Plates
6 x Gussets

For 75" - 89" Rock Sliders:

2 x Fully Welded Rock Slider Main Assemblies
2 x 9.5" Long Tubes Notched on One End
6 x 7.5" Long Tubes Notched on One End
8 x 4x4" Frame Support Plates
8 x Gusset
For 90" Plus add 2 7.5" Legs, Frame Plates, and Gussets

Note: The mounting leg tubes come with most of the legs cut to length, and two other legs left long. The long leg is for certain trucks which require a different leg length. On the older mini trucks you will need this longer leg to be for the front leg, where the frame tapers in. For newer pickups and Tacomas you will need this longer leg for the rear leg. Newer 4Runners do not require this long leg and it can be trimmed to match the other legs after, confirm by fitting sliders to your truck which leg setup you will need, as explained in step 11.

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.



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List of Required Tools:

Welder capable of welding 1/4" Steel
White or Silver Permanent Marker
Hand Grinder with Cut Off, Grinding and Paint
Removal Wheels
Hammer

4x C-Clamp
3x Jack Stand or Other Holding Device
Tape Measure
Straight Edge
2x Welder's Magnet and/or Small Square

Installing the Rock Sliders

1. DO NOT PAINT ROCK SLIDERS UNTIL STEP 19.
2. Starting on the driver's side, check your frame for any items that may be in the way of the Rock Slider on the outside. On frames that are C-channel check the inside of the frame rail for wiring laying against the frame that may be damaged by the head of welding.
3. Position your jack stands with two along the length of the rocker panel split seam and one outside of the rocker panel.
4. Position the rock slider on the jack stands centered between the wheel wells and lift into place. Place the slider so there is a gap between the rocker panel and rock slider of at least 3/8". A larger gap is ok, a smaller gap may cause the body to rattle against the legs.
5. Set your desired tilt angle of the Rock Slider. If angling the slider upwards ensure there is at least a 1 inch gap between the outside edge of the rock slider and the bottom of your door when the door is open.
6. With the rock slider in place, measure back 6-10 inches from the front of the slider for the front leg and mark this position onto the frame. You do not want the front leg too close to any body mounts. The maximum allowable unsupported amount of slider hanging in front of the first leg is 12 inches.
7. Measure 6-10 inches from the back of the slider for the back leg and mark this location on the frame. The maximum allowable unsupported amount of slider hanging behind the back leg is 12 inches.



Figure 1. Rock Slider positioned and held in place with jack stands and clamps.



Figure 2. Rock Slider held in place with clamps for welding.



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8. Measure the distance between the front and rear mounting legs and mark the frame for the remaining legs. Space the remaining legs as evenly as possible while avoiding body mounts and other unusable areas of the frame.
9. Using clamps, hold the frame support plates to the frame in the marked locations. Do not clamp in the center of the plate, but be careful that the plate does sit flat on the frame.
10. Determine at this time if your front or rear mounting legs need to be longer than the rest of your mounting legs provided or if they can be cut to match.
11. **A.** If your front leg needs to be the long leg, start by setting the 2nd and farthest back leg in place. Hold them square to the rock slider and tac in place to the Rock Slider and Frame Plate.
B. If your rear leg needs to be the long leg, start by setting the first and 2nd to the back leg in place. Hold them square to the rock slider and tac in place to the Rock Slider and Frame Plate.
C. If you do not need either leg to be longer place the front and rear legs in place. Hold them square to the rock slider and tac in place to the Rock Slider and Frame Plate.
12. Mark the long leg to suit your application and trim accordingly.
13. Place the remaining legs in place and tac to the Rock Slider and Frame Plate.
14. Check the alignment and fit of the Rock Slider and all mounting plates and legs to ensure nothing shifted while being assembled.
15. Mark the location of frame plates onto the frame while the slider is still clamped in place.
16. Unclamp the frame plates/slider assembly and move to a work bench for welding.
17. Place the provided gussets between the frame plates and leg tubes. The gusset can go on either the top of the leg or on the bottom of the leg, depending on your application. Tac the gusset at each tip and at the center to help prevent weld warp.
18. Weld the slider mounting legs and frame plate joints.
19. This is a good time to paint the Rock Slider after it has cooled. Do not paint the frame mounting plates at this time as they still need to be welded to the frame.
20. After the paint on the Rock Slider has dried remove the frame paint from the marked area where the mounting plates will sit, making sure to clear at least 1 extra inch of paint from around the weld area. A paint removal wheel is a good tool for this.
21. Place the slider back onto the truck as before using clamps to hold the frame plates tight to the frame.
22. Double check fitment as required.
23. Weld the sides of the frame plates to the frame. Be sure to fully weld all the way around the plate.
24. Touch up the paint around the frame plates, or if opting to paint the slider on the truck mask off the truck and paint the slider at this time.

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