



**1. THINK SAFETY, ALWAYS WEAR SAFETY GLASSES WHEN PERFORMING THE OPERATIONS PRESCRIBED IN THESE INSTRUCTIONS**

**2. READ ALL INSTRUCTIONS CAREFULLY BEFORE ATTEMPTING INSTALLATION**

**ASSEMBLY TOOLS NEEDED:**

Impact Sockets	7/16"—1-3/8"
Wrenches	7/16"—1-3/8"
Torque Wrench	
Drills	1/4", 17/32"
Center Punch	
Hammer	
Two 6" C-Clamps	

TORQUE SPECIFICATIONS FOR STANDARD MACHINE HARDWARE					
Bolt Size	GR.2 Dry	GR.5 Dry	GR.8 Dry	Metric Size	GR.8.8 Dry
1/4"	66*	9	12	M8	17
5/16"	11	17	25	M10	35
3/8"	20	30	45	M12	60
7/16"	32	50	70	M14	95
1/2"	50	75	110	M16	155
9/16"	70	110	150		
5/8"	100	150	220		
3/4"	175	260	380		
7/8"	170	430	600		
1"	250	640	900		

NOTE: These torque values are to be used for all hardware. Unless otherwise specified, all torque values must meet this specification.  
NOTE: All torque values are in Ft.-Lbs unless otherwise stated  
\*In-Lbs

**INSTALLATION NOTES:**

1. Mount Sub-Frame assembly completely before tightening any bolts unless otherwise specified.
2. To Install Sub-Frame the vehicle front suspension must be in a normal position such as when the vehicle is parked on level ground.

**MOUNTING INSTRUCTIONS:**

1. Install Front Crossmember (#96101517) using existing holes directly in front of spring shackle mounts on bottom of vehicle frame rails. Secure using two (2) 1/2" x 1-1/2" Capscrews, (#98009010), Flat Washers, and Nylock Nuts provided.

*NOTE: Vehicles 1988 and later use existing metric capscrews and frame welded nut on passenger side.*

2. Raise Sub-Frame Assembly (#96101248) to Front Crossmember and secure with two (2) 5/8" x 2" Capscrews (#98009041) Washers, and Nylock Nuts provided.
3. Install Rear Brackets (#96001212)RH, (#96001211) LH, on Rail Studs and secure with Flat Washer and 5/8" Nylock Nuts provided.



**CAUTION**

**Beware of brake and fuel lines secured to inside wall of frame rails when performing Steps 4 & 5.**

4. Raise Sub-Frame Assembly and align Rear Brackets with vehicle frame. Secure to frame with 6" C-Clamps.

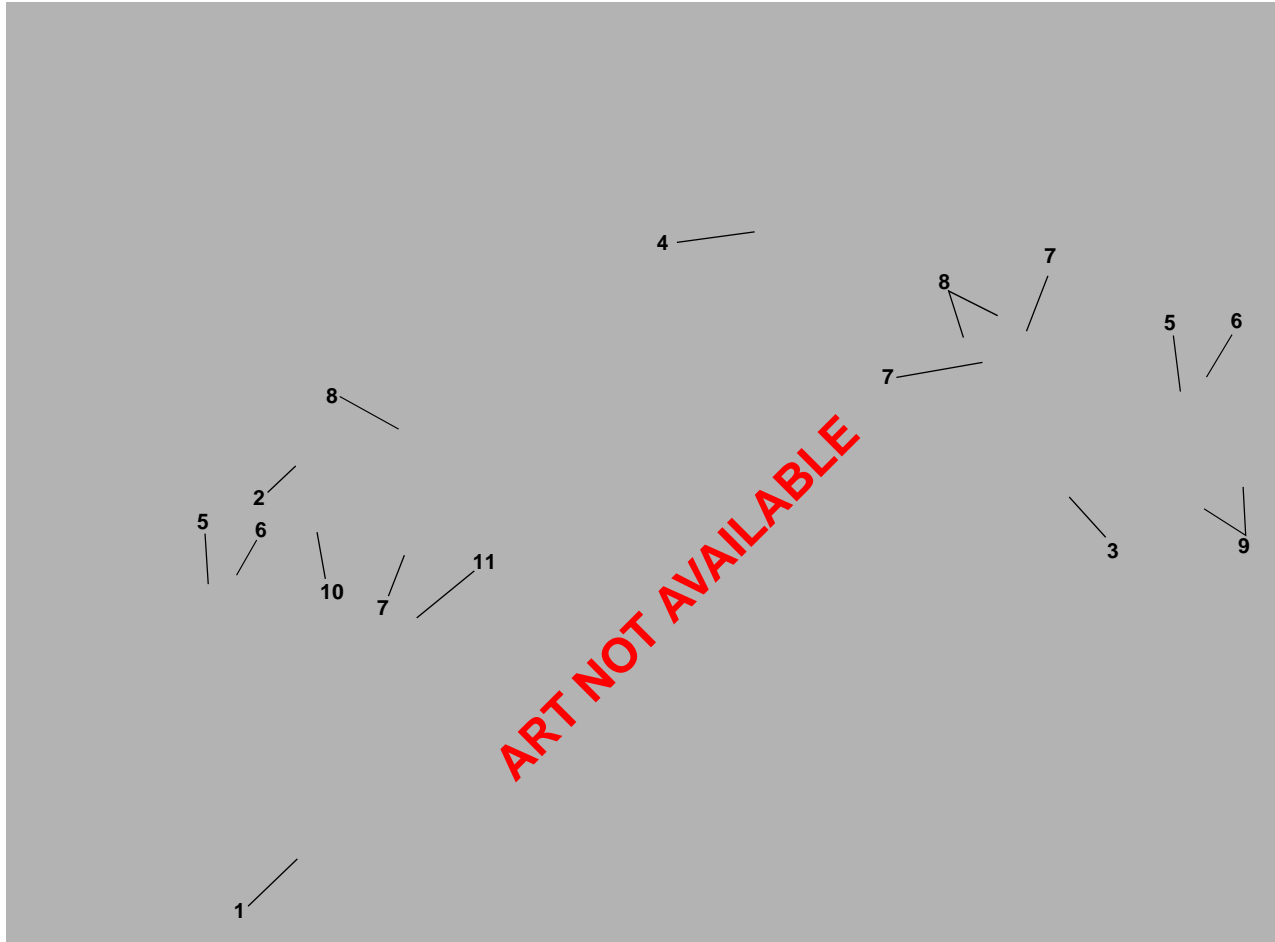
*NOTE: Remove transfer case shield if it interferes.*

5. Using bracket as a template, drill four (4) 1/4" pilot holes then drill to 17/32" through the inner wall of vehicle frame and secure with four (4) 1/2" x 3-1/2" Capscrews (#98009036), Washers and Nylock Nuts provided.

*NOTE: On 1988 and later vehicles it will be necessary to remove catalytic converter to perform the drilling operation.*

6. Using the Torque Specification Chart above, torque all bolts starting at the rear and working forward.

**1984 — 1990 TOYOTA 4X4 LANDCRUISER**  
**Sub-Frame Assembly & Installation Instructions**  
**Part No. 99004038 Sub-Frame (Complete) Includes Hardware**



ITEM	PART NO.	DESCRIPTION	QTY.
1	96101248	Sub-Frame Assembly .....	1
2	96101517	Crossmember, Front .....	1
3	96001211	Bracket, Rear, LH .....	1
4	96001212	Bracket, Rear, RH.....	1
5	98009039	Washer, Flat, 5/8" .....	4
6	98009038	Nut, Hex, Nylock, 5/8"-11NC .....	4
7	98009011	Washer, Flat, 1/2" .....	8
8	98009013	Nut, Hex, Nylock, 1/2"-13NC .....	6
9	98009036	Capscrew, Hex Head, 1/2"-13NC x 3-1/2" .....	4
10	98009041	Capscrew, Hex Head, 5/8"-11NC x 2" .....	2
11	98009010	Capscrew, Hex Head, 1/2"-13NC x 1-1/2" .....	2



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