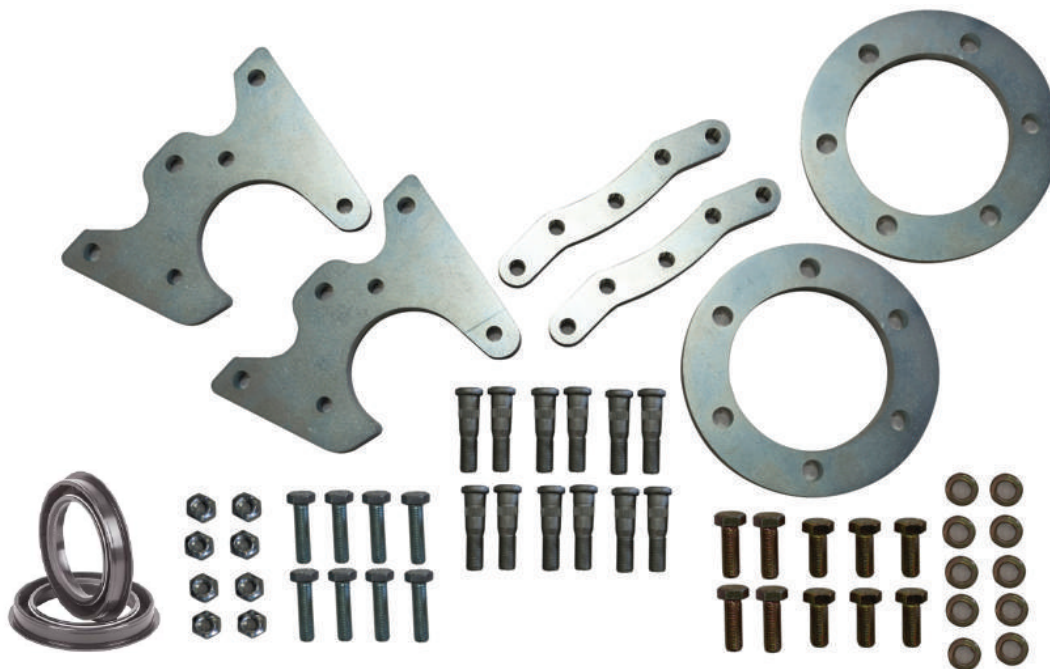


# INSTALL INSTRUCTIONS



## TOYOTA PICKUP AND 4RUNNER REAR ECONOMY DISC BRAKE KIT (304981-1-KIT)

### KIT CONTENTS



### PARTS INCLUDED:

- 12x Long Wheel Studs
- 2x M10-1.5x35mm Bolts
- 6x M10-1.5x40mm Bolts
- 8x M10-1.5 Lock Nuts
- 4x M12-1.25x35mm Bolts
- 6x M12-1.25x30mm Bolts
- 10x 1/2" Lock Washers
- 2x Brake Rotor Spacers
- 2x Axle Retainer Brackets
- 2x Caliper Brackets
- 2x Trail Safe Toyota Rear Axle Seals

### ADDITIONAL PARTS NEEDED

- 2 Toyota front brake rotors 1983 to 1985 (4wd only)
- 2 Toyota front brake calipers 1979 to 1985 (4wd only)



**304987-1-INS**

# INSTALL INSTRUCTIONS (CONT'D.)



## RECOMMENDED TOOLS

Hammer	Wrenches:
Jack	10mm
Jack Stands	12mm
Press	14mm
Bearing Puller	17mm
Seal Puller	19mm
Oil Pan	
Torque Wrench	
Brake Bleeder Kit	
Retaining Ring Pliers	

## CAUTION

1. Read all instructions completely and carefully before you begin. If anything is not clear, please call our tech support line at 1.877.4X4.TOYS or 559.252.4950 or email [tech@trail-gear.com](mailto:tech@trail-gear.com) before proceeding.
2. Check to make sure the kit is complete and that no parts are missing (refer to the Kit Contents Section on the first page of these instructions). If anything is missing, please contact Trail-Gear at 1.877.4X4.TOYS or 559.252.4950 or email [tech@trail-gear.com](mailto:tech@trail-gear.com).
3. Park vehicle on a clean, dry, flat, level surface and block the tires so the vehicle cannot roll in either direction.
4. This kit is for off-road use only. It is recommended that the installation steps below be performed by a competent mechanic. Buyers and users of this product hereby expressly assume all risks associated with the installation and use of this kit.

NOTE: WE RECOMMEND THAT YOU PURCHASE AND INSTALL NEW AXLE BEARINGS AND SEALS WHEN INSTALLING THIS KIT.



# INSTALL INSTRUCTIONS (CONT'D.)



## STEP 1

Jack up the rear of the vehicle and secure it on jack stands.

## STEP 2

Remove the wheels and drums from your vehicle.



## STEP 3

Disconnect the brake lines and e-brake cables.



## STEP 4

Using a 14mm wrench remove the 4 nuts that secure the bearing pocket in place.



## STEP 5

Slide axle assembly from the housing. Ensure a drip pan is in place as some gear oil may leak from the housing.





# INSTALL INSTRUCTIONS (CONT'D.)



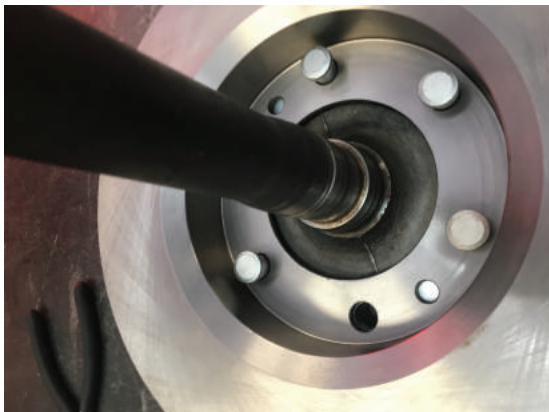
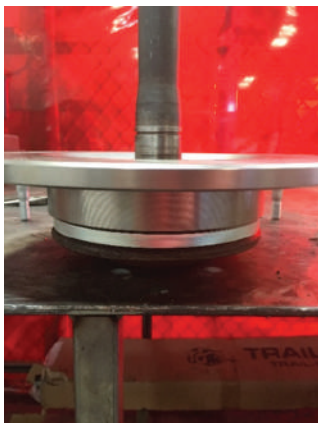
## STEP 6

If you are installing new Trail-Gear chromoly axles, bearing pockets and bearings skip to step 8. If you are reusing your axle shafts, bearings and bearing pockets, remove the bearing retaining ring from the axle.



## STEP 9

Slide the spacer ring onto the axle followed by the brake rotor. Attach these components by installing long wheel studs (provided) using a press.



## STEP 7

The drum brake assembly and backing plate should be removed with a press and a bearing puller according to your Toyota factory service manual. If you do not have the correct tools or mechanical experience to complete this step we advise that you find a qualified automotive shop.

## STEP 8

Press out the 4 studs holding the bearing pocket to the backing plate. Remove the old bearing and seal from the bearing pocket if you plan on installing new ones.



## REASSEMBLY

NOTE: PRIOR TO REASSEMBLY ENSURE THAT JOINING FACES ARE CLEAN AND FREE OF DEBRIS TO ENSURE PROPER ALIGNMENT

## STEP 10

Using a press and the proper tooling, install the bearing pocket assembly, and seal ring on the axle.



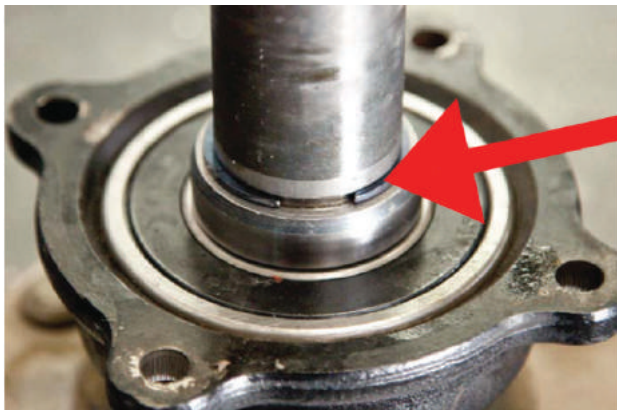


# INSTALL INSTRUCTIONS (CONT'D.)



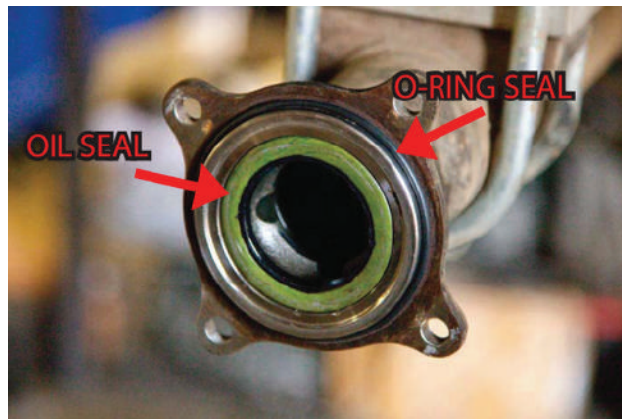
## STEP 11

Install c-clip securely into groove. Take care to ensure that c-clip is completely seated in the groove.



## STEP 12

Remove the old oil seal from the axle housing and install new Trail Safe seal. If you plan to install a new O-ring do so at this time.



## STEP 13

Slide the axle assembly into axle housing. Use care to avoid damaging the oil seal.



## STEP 14

Using 3 of the provided M10-1.5x40mm bolts and lock nuts, attach the axle retainer bracket to the axle as shown. Install one M10-1.5x35mm bolt and lock nut in the remaining hole to finish securing the axle assembly and tighten.

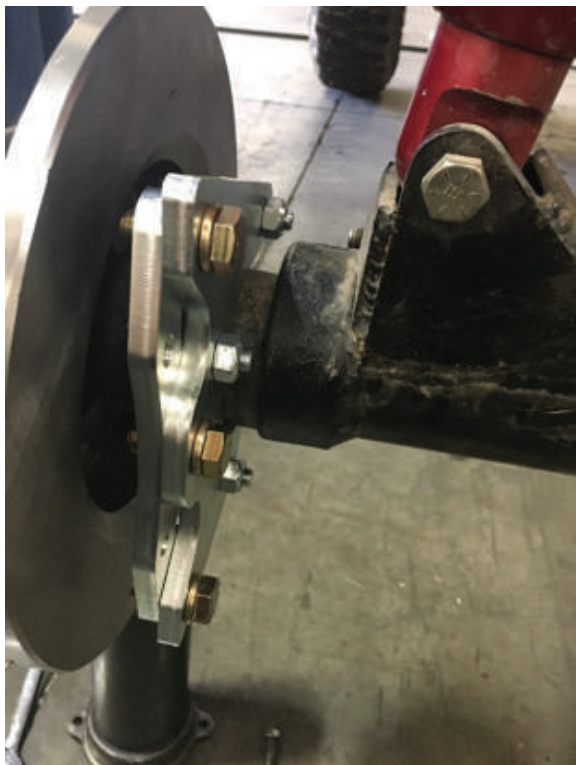


# INSTALL INSTRUCTIONS (CONT'D.)



## STEP 15

Attach the caliper bracket to the axle retainer bracket using 3 M12-1.25x30mm bolts and lock washers. The threaded caliper bracket sits between the axle retainer bracket and the rotor.



## STEP 16

Note: There are right and left side calipers, ensure that bleeder valve is on top and brake line attachment is on bottom during installation.

Slide the caliper (with pads) over the rotor and attach to the caliper bracket using 2 M12-1.25x35mm bolts and lock washers.



## STEP 17

Attach brake lines to the new calipers. OEM brake line may need to be re-shaped in order to install on disk brake calipers.

## STEP 18

Install wheels and torque lug nuts.

## STEP 19

You are now ready to bleed the brakes. You must use fresh DOT approved brake fluid and bleed the system in accordance to the vehicles manufacturer's recommendations.

	<p><b>⚠ DANGER</b></p> <p><b>Brake Failure Hazard.</b> Do not proceed until the brakes have been properly bled. Improperly bled brakes may result in a collision causing severe injury or death.</p>
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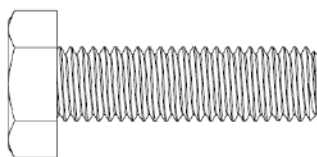
# INSTALL INSTRUCTIONS (CONT'D.)



## REPLACEMENT PARTS



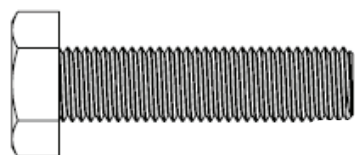
140392-1: Wheel Stud, M12-1.5x52.5mm



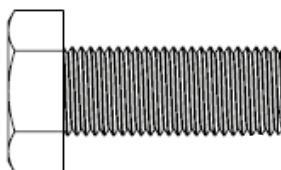
140247-1: Bolt, M10x1.5x35mm



301086-1: Trail-Safe Seal, Rear Axle, Toyota



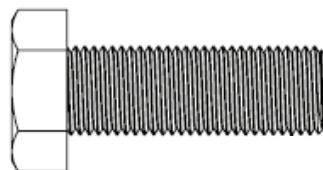
140248-1: Bolt, M10x1.5x40mm



120079-1: Bolt, M12-1.25x30mm



TB-EDBSK-001: Brake Rotor Spacer



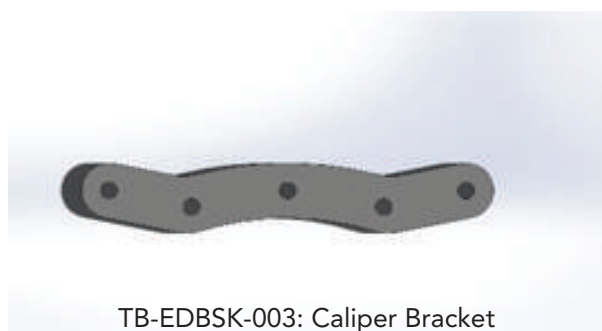
304950: Bolt, M12-1.25 x 35mm



140249-1: Nut, Toplock, M10x1.5



TB-EDBSK-002: Axle Retainer Bracket



TB-EDBSK-003: Caliper Bracket



303429: 1/2" Lock Washer