



**4331 EUCALYPTUS AVE. ~~ CHINO, CA 91710
909-597-7800 Fax 909-597-7185**

**FTR10015
RHINO FRAME GUSSET KIT**

PARTS LIST:

Qu a	Part #	Description
2	FT95050	Frnt. Arm Pivot Gusset, Frnt Pivot
2	FT95051	Frnt. Arm Pivot Gusset, Rear Pivot
2	FT95052	Frnt. Frame Gusset
1	FT95053	Frnt. Lower Gusset Drv.
1	FT95055	Frnt. Lower Gusset Pass
4	FT95054	Rear Arm Pivot Gusset
2	FTR10015 i	Instruction Sheet

TOOL LIST:

- Assorted Metric & Standard Wrenches
- Torque Wrench
- Floor Jack
- Jack Stands
- Mig Welder
- Die Grinder w/ sanding discs

WARNING

**THE GUSSETS PROVIDED WITH THIS KIT ARE A WELD-ON INSTALLATION. ONLY AN
EXPIRENCED CERTIFIED WELDER SHOULD COMPLETE THIS INSTALLATION.**

**READ ALL INSTRUCTIONS THOROUGHLY FROM START TO FINISH BEFORE BEGINNING
INSTALLATION.**

**CHECK ALL PARTS INCLUDED IN THIS KIT TO THE PARTS LIST ABOVE BEFORE BEGINNING
INSTALLATION OF THIS KIT. IF ANY PARTS ARE MISSING, CONTACT FABTECH AT 909-597-7800.**

**DO NOT ALTER THE FINISH OF THESE COMPONENTS, EXAMPLE- CHROMING, ZINC PLATING OR
PAINTING. CHANGING THE FINISH CAN CAUSE STRUCTURAL FATIGUE OF COMPONENTS.**

INSTALLATION INSTRUCTIONS:

1. Disconnect the negative terminal on the battery. With the Rhino on level ground, set the emergency brake. Jack up the front and rear of the Rhino and support the frame rails with jack stands. **NEVER WORK UNDER AN UNSUPPORTED VEHICLE!** Remove the front and rear tires.
2. With the front and rear upper and lower control arms, brakes, hubs, inner and outer tie rod, and front CV axles removed from the Rhino, use a sander and clean the frame where the new gussets are going to be welded. SEE PHOTO BELOW.

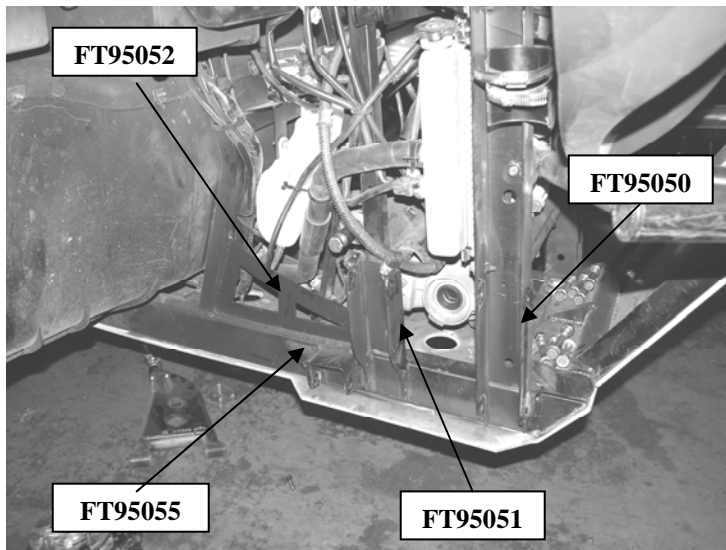


Photo of Passenger front

ONLY AN EXPERIENCED CERTIFIED WELDER SHOULD COMPLETE THIS INSTALLATION

3. Working from the passenger side, locate the factory upper and lower control arm bolts with hardware, and Front Arm Pivot Gussets (FT95050 front pivot & FT95051 rear pivot). Position the gussets onto the front of the frame in the appropriate locations and insert the factory hardware. Only tighten the hardware enough to locate and hold the new gussets in place. Tack weld the gussets on the corners. Remove the hardware and completely weld the gussets to the frame. SEE PHOTO IN NEXT COLUMN.

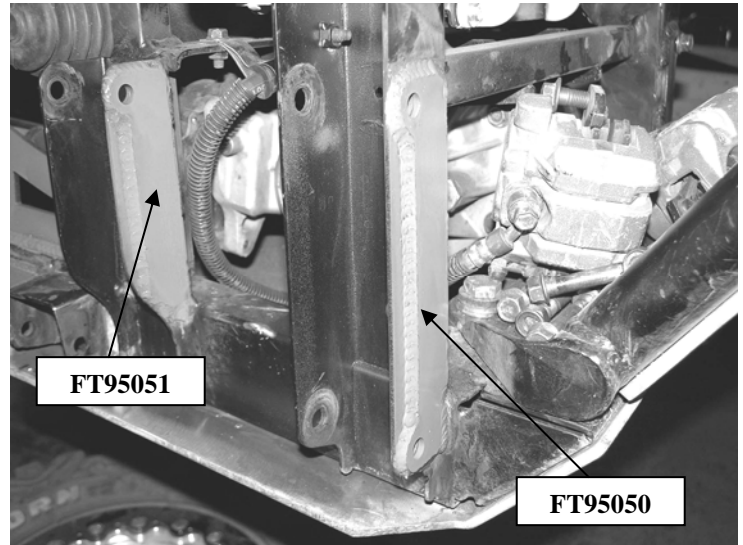


Photo of Passenger front

4. Locate FT95052 Front Frame Gusset. Position the gusset onto the frame and weld the entire front of the gusset to the frame. SEE PHOTO BELOW.

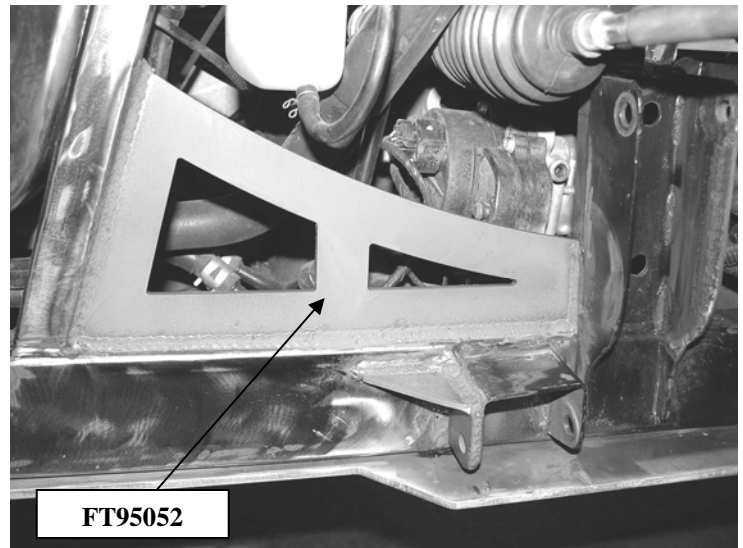
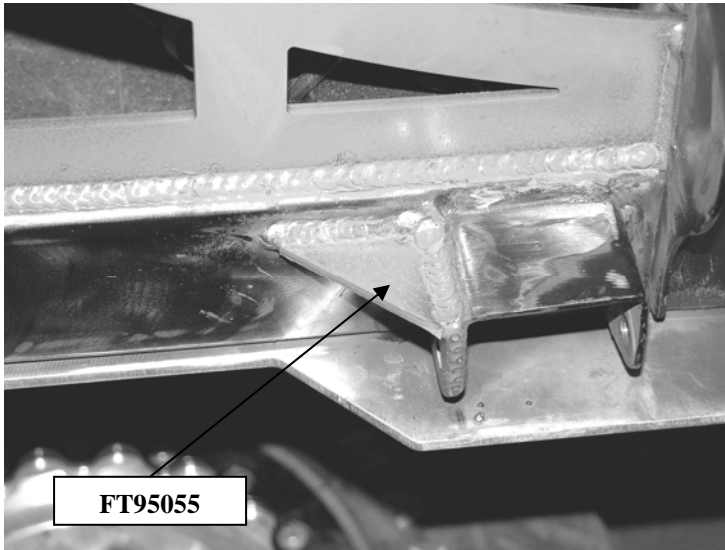


Photo of Passenger front

5. Locate FT95055 Front Lower Gusset and the stock rear lower control arm hardware. Position it onto the frame and the lower rear control arm mount and insert the factory hardware and tighten only enough to hold the gusset in place. Tack weld the gussets on the corners. Remove the hardware and completely weld the gussets to the frame. Weld the entire top and side of the new gusset. Once all the new gussets are cooled, paint all of the bare metal areas. SEE PHOTO ON NEXT PAGE.



6. Repeat steps three through five on the driver side.
7. Locate the Rear Arm Pivot Gussets FT95054 and the factory arm hardware. Position the gussets onto the rear of the frame in the appropriate locations and insert the factory hardware. Only tighten the hardware enough to locate and hold the new gussets in place. Tack weld the gussets on the corners. Remove the hardware and completely weld the gussets to the frame. Once all the new gussets are cooled, paint all of the bare metal areas. SEE PHOTOS IN NEXT COLUMN.

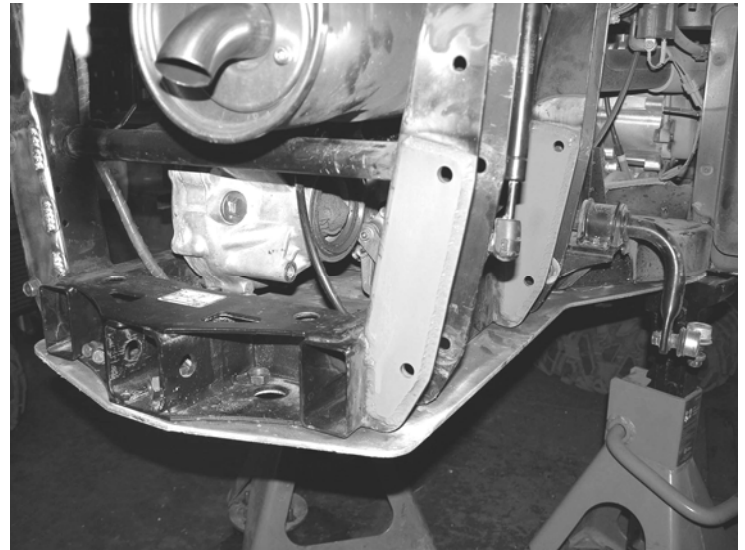


Photo of passenger rear

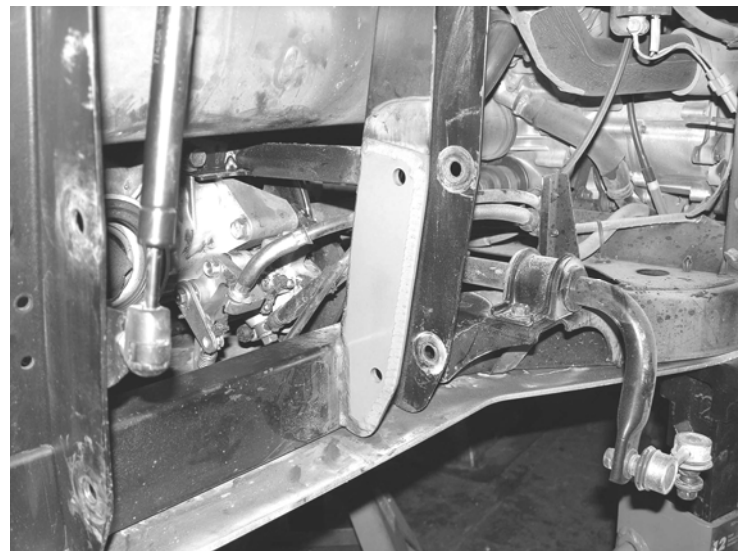


Photo of passenger rear

8. Re-Assemble the front and rear suspension of the Rhino. Check all hardware for proper torque and re-check after 10 miles of driving.

RETORQUE ALL NUTS, BOLTS AND LUGS AFTER 50 MILES AND PERIODICALLY THEREAFTER.

For technical assistance call: 909-597-7800

Product Warranty and Warnings-

Fabtech provides a Limited Lifetime Warranty to the original retail purchaser who owns the vehicle, on which the product was originally installed, for defects in workmanship and materials.

The Limited Lifetime Warranty excludes the following Fabtech items; bushings, bump stops, ball joints, tie rod ends, limiting straps, cross shafts, heim joints. These parts are subject to wear and are not considered defective when worn. They are warranted for 60 days from the date of purchase for defects in workmanship.

Take apart shocks are considered a serviceable shock with a one year warranty on leakage only. Service seal kits are available separately for future maintenance. All other shocks are covered under our Limited Lifetime Warranty.

Fabtech does not warrant any product for finish, alterations, modifications and/or installation contrary to Fabtech's instructions. Alterations to the finish of the parts including but not limited to painting, powdercoating, plating and/or welding will void all warranties. Some finish damage may occur to parts during shipping which is considered normal and is not covered under warranty.

Fabtech products are not designed nor intended to be installed on vehicles used in race applications or for racing purposes or for similar activities. (A "RACE" is defined as any contest between two or more vehicles, or any contest of one or more vehicle against the clock, whether or not such contest is for a prize). This warranty does not include coverage for police or taxi vehicles, race vehicles, or vehicles used for government or commercial purposes. Also excluded from this warranty are sales outside of the United States of America.

Installation of most suspension products will raise the center of gravity of the vehicle and will cause the vehicle to handle differently than stock. It may increase the vehicle's susceptibility to a rollover, on road and off road, at all speeds. Extreme care should be taken to operate the vehicle safely at all times to prevent rollover or loss of control resulting in serious injury or death. Fabtech front end Desert Guards may impair the deployment or operation of vehicles equipped with supplemental restraining systems/air bag systems and should not be installed if the vehicle is equipped as so.

Fabtech makes every effort to ensure suspension product compatibility with all vehicles listed in the catalog, but due to unknown auto manufacturers production changes and/or inconsistencies by the auto manufacturer, Fabtech cannot be responsible for 100% compatibility, including the fitment of tire and wheel sizes listed. The Tire and Wheel sizes listed in Fabtech's catalog are only a guideline for street driving with noted fender trimming. Fabtech is not responsible for damages to the vehicle's body or tires.

Fabtech's obligation under this warranty is limited to the repair or replacement, at Fabtech option, of the defective product only. All costs of removal, installation or re-installation, freight charges, incidental or consequential damages are expressly excluded from this warranty. Fabtech is not responsible for damages and/or warranty of other vehicle parts related or non related to the installed Fabtech product. This warranty is expressly in lieu of all other warranties expressed or implied. This warranty shall not apply to any product that has been subject to accident, negligence, alteration, abuse or misuse as determined by Fabtech.

Fabtech suspension components must be installed as a complete system including shocks as shown in our current catalog. All warranties will become void if Fabtech parts are combined and/or substituted with other aftermarket suspension products. Combination and/or substitution of other aftermarket suspension parts may cause premature wear and/or product failure resulting in an accident causing injury or death. Fabtech does not warrant products not manufactured by Fabtech.

Installation of Fabtech product may void the vehicles factory warranty; it is the consumer's responsibility to check with their local vehicle's dealer for warranty disposition before the installation of the product.

It is the responsibility of the distributor and/or the retailer to review all warranties and warnings of Fabtech products with the consumer prior to purchase.

Fabtech reserves the right to supercede, discontinue, change the design, finish, part number and, or application of parts when deemed necessary without written notice. Fabtech is not responsible for misprints or typographical errors within the catalog or price sheet.