 **Installation Instructions**

**IMPORTANT: Read and understand the “General Instructions for Installing SafeTCap® Frame Repair Kits” before you begin.**

1. Jack up the rear of the vehicle with a hyd. Jack and use properly rated jack stands to support the rear axle.
2. Remove the spare tire, the rear bumper, and the rear 2 bed mount bolts. \*Removing the pick-up trucks bed is optional, but we suggest leaving the bed attached to the frame as it will keep the frame rails straight.
3. Cut all rivets and/or bolts holding the original spare tire mount to the frame, then, remove the cross member from between the frame rails.
4. Detach the spare tire hoisting mechanism from the original cross member, and remove the emissions canister from the cross member if its attached.
5. Test fit the ART-151 by sliding it between the frame rails from the rear. Make sure to remove the ½” hex cap screw from the ART-151 before test fitting. The ½” weld nuts should end up in the rear lower end of the ART-151 to bolt the rear bumper onto the frame.
6. ****Attach each of the 4 frame plates to each leg of the cross member and slide them against the inside of the frame rails.
7. Mark the locations of the frame plates on the frame with a paint pen, marker, or soapstone.
8. Remove the ART-151 and frame plates from the frame and grind the marked areas down to clean bare metal. Use a needle scaler to remove any rust buildup that may be inside the frame rails.
9. **** Once all 4 marked areas are rust free, re-install the ART-151 and all 4 frame plates, screw in the new rear bumper bolts to the ART-151, this will keep the ART-151 in place while welding.
10. Ensure the ART-151 is in the correct location, then, tack weld all 4 frame plates to the frame and cross member.
11. Double check the ART-151’s placement on the frame, then, weld all frame plates to the frame then to the ART-151.
12. Allow the ART-151 welds to cool off, and coat the repaired area and the new cross member with either primer or a rust protective coating.
13. Connect the spare tire hoisting mechanism to the ART-151 and bolt it in.
14. Reinstall the rear 2 bed bolts and the rear bumper.
15. If you removed the emissions canister from your original spare tire cross member, attach the emissions canister to the ART-151. You may need to either, drill and bolt the emissions canister to the new cross member, or tack weld the canisters bracket to the ART-151. Self-tapping screws is another option.
16. Double check all bolts are tight and wiring is secured to the cross member and the frame, and re-connect your spare tire to the cross member.
17. You’re done!

## We Make the Kits, that Fit!

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