**Installation Instructions**

**IMPORTANT: Read and understand the “General Instructions for Installing SafeTCap® Frame Repair Kits” before you begin. Repair one side at a time for reference.**

1. Jack up the rear of the truck, use quality jack stands with the proper weight rating and place jack stands under the frame, 1 before the rear axle and 1 after, allowing the rear end to hang free. Use the hyd. Jack under the differential to take the weight off the rear end.
2. Disconnect the leaf spring from the leaf spring mount and lower the axle with a hydraulic jack to move the spring away from the repair area.
3. Measure the original mounts bolt hole center from a fixed point nearby on the frame. Horizontal and lateral measurement.
4. Cut the welds holding the original spring mount to the frame, be careful not to cut too much into the frame, then remove the original mount.
5. Inspect the frame at and around the original mount location to make sure it can withstand being welded to and is thick enough to allow for proper weld penetration.
6. Grind any rust and corrosion from the repair area, make sure the frame is clean and oil free.
7. Place the ART-171 onto the frame and using the measurements taken earlier set the new spring mount into position and tack weld the corners.
8. Double check its placement, you can even dry fit the leaf spring mount. Placement must be exact to original.
9. Weld the entire perimeter of the ART-171, allow time between welds for cooling, so you don’t focus too much heat in any one area at a time.
10. Allow the repair area to cool, then rust proof the repair area.
11. ****Reinstall the leaf spring to the ART-171 with the new hardware provided and torque bolt to vehicle spec. **148lbs ft .**
12. Reinstall rear wheel and lower vehicle to the ground, unless installing the other side.
13. Test Drive vehicle, then double check suspension.

 **We make the Kits, that Fit!**

**Note:** Pictures in this installation instruction sheet are for demonstration purposes only and may not actually reflect the identical make, model and year of the vehicle you are working on.