



**ART-140
ART-140-2
REAR SHOCK MOUNT
CROSSMEMBER**

ART-140
(1999-2006) 1500

ART-140-2
(2007-2014) 1500

**IMPORTANT: Read and understand the General Instructions
Before Installing SafeTCap® Frame Repair Kits**

**Support the truck on two heavy duty jack stands, create as much room as possible
to work safely.**

Installation Instructions

- 1)** Remove both rear tires, and the spare tire.
- 2)** Disconnect the driver side shock from the shock mount on the rear cross member.
- 3)** If your vehicle has an exhaust hanger welded to the rear cross member, carefully cut off the exhaust hanger as close to the cross tube as possible, save for reuse with rubber bushing.
- 4)** Unbolt the grounding wire from the spare tire mount plate.
- 5)** Carefully cut the weld connecting the spare tire mounting plate to the rear cross member.

- 6)** Use the kit outer plates to make location marks on the outside of the frame.
- 7)** Cut out the original cross member.
- 8)** Grind the frame down to clean metal on both sides.
- 9)** Put the passenger side inner plate onto the kit then slide the kit through the inner hole on the passenger side frame, enough for the other end of the cross member to go through the inner hole on the drivers side frame, until the pre-welded driver side plate is in position firmly against the driver side inner frame.
- 10)** Using the location marks on the frame from step 6, line up the center notches on the pre-welded, driver side inner plate to the location marks and clamp the cross member to the frame.
- 11)** Slide the loose plate to the passenger side inner frame and line up the center notches to the location marks.
- 12)** Check the location of the shock mount and overall alignment of the cross member.
- 13)** Once satisfied with placement of the kit, put the outer plates on each end of the cross member tube and tack weld
- 14)** Weld all plates to the frame and tube completely.
- 15)** Re-attach ground wire to the spare tire mounting plate.
- 16)** Rustproof the repaired area with rust inhibiting primer or undercoat.