



ART-202-R

**ART-202  
2003-2009  
TOYOTA 4-RUNNER  
TRAILING ARM MOUNT**

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

## Installation Instructions

- 1) Jack up and place rear jack stands under frame, behind rear axle.
- 2) Support rear axle and unbolt lower trailing arm at the frame end and swing out of the way. Measure from the trailing arm bracket bolt hole to two fixed reference points for locating new kit later.
- 3) Cut lower trailing arm bracket off.
- 4) Cut away the rusted area.
- 5) Position the kit into place and roughly mark the outline. Remove kit and grind the frame down to clean metal.
- 6) Slide kit over frame, clamp and bolt in lower trailing arm. Check measurements taken earlier to trailing arm bracket. Tack weld kit in place. If you are installing additional kits to frame, test-fit those now to make sure they all fit together properly.
- 7) Double check all measurements and check door gaps to make sure vehicle stayed straight, then weld all edges 100% solid. If you are adding additional kits, don't weld the ends yet.
- 8) Prime and paint the repaired area. Use self-tapping screws to remount the brackets that were removed.