



**ART-204**  
**2003-2009**  
**TOYOTA 4 RUNNER**  
**Rear Frame Section After**  
**Rear Track Bar**

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

## Installation Instructions

- 1)** Jack up the rear of vehicle and support it on properly rated jack stands. Place rear jack stands under rear axle. Make sure the rear of vehicle is fully accessible.
- 2)** Support rear axle and remove wheel.
- 3)** Cut away the rusted area using a plasma cutter, reciprocating saw or torch.
- 4)** Position the kit into place and roughly mark the outline. Remove kit and grind the frame down to clean metal.
- 5)** Slide kit over frame and clamp. 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.
- 6)** 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.
- 7)** Prime and paint the repaired area. Use self-tapping screws to remount any brackets that were removed.