



**ART-168**  
**2007-2014**  
**SIERRA 1500/SILVERADO 1500**  
**REAR FRAME SECTION W BUMP**  
**STOP MOUNT**

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

## Installation Instructions

- 1)** Jack up the rear of the vehicle and use properly rated jack stands to support the frame and remove rear wheels.
- 2)** Unbolt the Bump stop and get measurement of bump stop bolt hole center to a fixed point on your frame.
- 3)** Cut off the original bump stop mount from your frame.
- 4)** Test fit the ART-168 over the frame and mark the entire outline of the ART-168, Then remove the frame kit.
- 5)** Grind the frame down to bare metal.
- 6)** Slide the ART-168 up over the frame and use the measurement taken earlier to line up the bump stop bolt hole center, Use large C-clamps and close any gaps between the frame kit, Then tack weld in place.
- 7)** Weld the entire perimeter of the ART-168.
- 8)** Rustproof the repaired area to prolong the life of your frame.