



**ART-205**  
**2003-2009**  
**TOYOTA 4 RUNNER**  
**REAR CROSSMEMBER**

**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)** Cut away the rusted area.
- 3)** Position the kit into place and roughly mark the outline. Remove kit and grind the frame down to clean metal.
- 4)** 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.
- 5)** Weld all edges 100% solid.
- 6)** Prime and paint the repaired area.