



**ART-249**  
**2001-2007**  
**TOYOTA SEQUOIA**  
**REAR SECTION AT**  
**BUMP STOP**

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

## Installation Instructions

- 1) Jack up the front & rear of vehicle and support it on properly rated jack stands. Place rear jack stands under frame, behind rear axle. Make sure the center of vehicle is fully accessible.
- 2) Support rear axle and remove wheel.
- 3) Remove coil springs, shocks, and bump stop.
- 4) Cut away the rusted area using a plasma cutter, reciprocating saw or torch.
- 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 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.
- 7) Double check all measurements and check door gaps to make sure vehicle stayed straight, then weld all edges 100% solid.
- 8) Prime and paint the repaired area.