

177X-S



**ART-177**  
**2004-2008**  
**FORD F-150**

## **CENTER FRAME SECTION**

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

## **Installation Instructions**

- 1)** Jack up and support the repair side of vehicle leaving the area between tires clear.
- 2)** Remove any brackets or line clamps for access to repair area.
- 3)** Mark areas to be cut away.
- 4)** Cut out marked areas and grind surrounding areas clean to prepare for welding.
- 5)** Install new Safe T Cap and clamp in place.
- 6)** Double-check positioning and tack weld in place.
- 7)** Weld solid all around the new part. Re-attach any brackets that were cut off.
- 8)** Coat repair area with paint or undercoating.