



ART-216
1996-2002
TOYOTA 4 RUNNER
FRONT FRAME SECTION

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

Installation Instructions

- 1)** Jack up the front of vehicle and support it on properly rated jack stands under frame. Make sure the front of vehicle is fully accessible.
- 2)** Remove the front sway bar from the frame by disconnecting the sway bar links, then unbolting the sway bar mounts on both driver and passenger side. Inspect sway bar bushings, replace if necessary.
- 3)** Slide the SafeTCap® frame repair kit over the frame from underneath and evenly space the frame kit around the cab mount. Mark the outline of the frame repair kit on the frame. Then, remove the frame kit.

4) Prep the repair area for welding by grinding the frame down to clean, bare metal along the marked outline on both the inner and outer sides of the frame.

5) This frame kit comes with a plate for the frame above the sway bar mount. This plate should be installed before the ART-216 is welded to the frame.

6) Slide the frame repair kit back over the frame. Then, tack weld the frame repair kit to your frame.

7) Weld all edges 100%. If you're installing additional frame repair kits, do not weld the ends yet.

8) Prime and/or paint the repaired area, then re-attach any brackets, wiring and/or brake lines back to the frame and make sure to secure them.