



**ART-243  
2000-2006  
TOYOTA TUNDRA  
MID/REAR FRAME SECTION**

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

## Installation Instructions

- 1)** Jack up the rear of vehicle and support the frame on properly rated jack stands.
- 2)** Measure the bump stop and note its location. Carefully remove the rivets holding it to the frame, try not to destroy the bump stop during removal, you will need to reinstall it after the ART-243 is welded on.
- 3)** Slide the ART-243 over the frame from the outside. Then, Mark the original frame with a sharpie or soapstone.
- 4)** Prep the repair area for welding by grinding the frame down to clean, bare metal along the marked outline on both the outer, and underside of the frame. Remove any rust or debris from inside the frame using a needle scaler or grinder.
- 5)** Slide the frame repair kit back over the frame. Then, tack weld the frame repair kit to your frame at all corners.
- 6)** Check all measurements to make sure the vehicle has stayed straight. Check the gap between bed and cab to make sure it is parallel. Then, weld all edges of the ART-243 100% to the original frame.
- 7)** Re-install the bump stop back to the frame using the measurements taken in step 2. Bump stop can be welded to the frame.
- 8)** Allow the weld to cool then re-attach any line & Clips. Rustproof the repaired area with rust inhibiting primer or undercoating.