



ART-120 & ART-120EX 1998-2006 FORD RANGER REAR FRAME SECTION SHORT & LONG BED

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

Installation Instructions

- 1)** Jack up the rear of the truck and support the frame with properly rated jack stands. Place the jack stands under the frame just after the rear axle.
- 2)** Remove the rear tires, the spare tire, rear bumper, and trailer hitch cross member (if truck is equipped). Unscrew the rear 2 bed bolts, they're located inside the bed of the truck.
- 3)** Measure the distance from the leaf spring hangers to the end of the frame and take note, this measurement will be needed.
- 4)** You must support your rear axle with a hydraulic jack under the differential before disconnecting the rear leaf springs, Do not jack up the rear axle, just use the jack to hold the weight of the differential so the rear suspension is not hanging.
- 5)** Then, carefully cut the heads off the 4 rivets holding the leaf spring hangers to the frame. You do not need to remove the leaf spring from the hanger, it is easier to leave it mounted to the hanger.

6) Slide the ART-120 over the frame, line up the holes for the leaf spring hanger, and line up to the end of the frame. Make a mark with a sharpie or paint marker on the original frame where the ART-120 overlaps, then remove the frame kit.

7) Grind the frame to clean, bare metal an inch before and after the marked line where the ART-120 overlaps.

8) Slide the ART-120 back over the frame and line up the leaf spring hangar holes and the end of the frame. Clamp the frame kit tightly to the frame.

9) Tack weld the ART-120's forward inside and outside edge to the original frame. Check the ART-120's position using measurements taken earlier.

10) After ensuring the ART-120 is in proper position, weld the entire inner and outer edge of the ART-120 to the frame.

11) Coat the repair areas with a rust preventative primer or an undercoat.