



ART-240 2000-2006 TOYOTA TUNDRA FRONT FRAME SECTION

**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. Make sure the center of vehicle is fully accessible.
- 2)** Remove the front sway bar from the frame by disconnecting the sway bar links. Then, unbolt the sway bar mounts on both driver and passenger side. Inspect sway bar bushings, replace if necessary.
- 3)** Remove any brackets, wiring, exhaust, and fuel/brake lines from the frame and move them out of the way noting their location. You may need to drill holes in the frame kit to reattach fuel/brake line clips after installation.
- 4)** The ART-240 has 2 cut lines where the front cab mount is mounted. Determine if your original front cab mount needs to be replaced or if the metal behind the cab mount is rotted. If the cab mount is not being replaced, then remove the plate by continuing the cut lines so the frame kit is notched around the cab mount.
- 5)** Measure the location of the original sway bar mount, then cut the sway bar mount from the frame. Also remove any rusted and corroded sections.

6) Slide the frame repair kit over the frame from underneath and evenly space the frame kit around the cab mount and the Transmission cross member end. Mark the outline of the frame repair kit on the frame. Then, remove the frame kit.

7) Grind the frame down to clean, bare metal along the marked outline on both the inner and outer sides of the frame.

8) Slide the frame repair kit back over the frame and use large C-clamps to firmly clamp ART-240 to the frame. Use welding clamps to tighten any gaps on the sides. Then, tack weld the frame repair kit to your frame at all corners.

9) The ART-240 frame kit comes with a replacement sway bar mount. Using the measurements taken earlier, tack weld the new sway bar mount to the frame. Before fully welding the new sway bar mount double check its placement on the frame.

10) Check measurements and door gaps to make sure the vehicle has stayed straight, then, weld all edges 100%.

11) Prime or rust proof the repaired area, then re-attach any brackets, wiring and/or brake lines back to the frame and re-install the sway bar.