



**ART-244
2000-2006
TOYOTA TUNDRA
REAR FRAME SECTION**

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

Installation Instructions

- 1)** Jack up the rear of the vehicle and support the frame on properly rated jack stands. Make sure the rear of vehicle is fully accessible. Place jack stands 1 set before the rear axle and another set on the frame at the bump stop or just behind.
- 2)** Remove the spare tire, and the rear bumper from the frame. If your vehicle has a tow hitch cross member, it will also need to be removed from the frame.
- 3)** Remove the rear 2 bed bolts.
- 4)** Measure the location of the rear leaf spring hanger on the frame and take note for later use. Place a Hyd. Jack under the rear axle to support it during the removal of the rear spring hangers.
- 5)** Remove the rear leaf spring hanger from the frame by grinding the heads of the rivets down. Then, drill the remaining rivets from the frame.

6) Slide the ART-244 over the frame from the outside, make sure the rear end of the frame kit lines up with the original frame end. Then, mark the forward end of the ART-244 on the original frame.

7) 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.

8) Slide the frame repair kit back over the frame and use large C-clamps to firmly clamp ART-244 to the frame. Use welding clamps to close any gaps on the sides. Then, tack weld the frame repair kit to your frame at all corners.

9) Weld solid all around.

10) If any of the weld nuts in the original frame for mounting the rear bumper, spare tire cross member and the tow hitch cross member were rotted, damaged and/or needed to be removed from the original frame, then new weld nuts will need to be added to the ART-244 in the proper holes before rust-proofing the repaired area. Rustproof the repaired area with a rust inhibiting primer or undercoat then re-attach any brackets or wiring back to the frame.