



ART-139-3
**Rear Fuel Tank Support &
Shock Mount Cross Member**
STANDARD BED
(2011-2018)HD
(2nd Gen)

IMPORTANT: Read and understand the General Instructions
Before Installing SafeT-Cap® Frame Repair Kits

Installation Instructions

- 1)** Support the truck on at least two heavy duty jack stands under the frame just before the rear axle, two additional jack stands on the frame after the rear axle will add extra stability and support.
- 2)** Remove the fuel filler hose.
- 3)** Disconnect the Passenger side rear shock from the upper mount bracket.
- 4)** Disconnect the fuel lines.
- 5)** Unbolt the fuel tank straps.
- 6)** Lower the fuel tank from the frame and move the fuel tank away from the vehicle. Cover the fuel tank with a fire proof blanket to protect it from welding or grinding sparks.
- 7)** Mark the vertical center line of the original cross member on the outside face of both the left and right frame rails. Extend the line to the underside and top of each frame and up the inner side.

8) Make marks on the outside of your frame to ensure correct positioning of the new crossmember by placing the ART-139-3 outside frame plates over the original cross member tube ends and tracing the end plates on the outside frame face. Mark the area around the original cross tube to be cut on both the inside and outside of the two frame rails.

9) Next, remove the old cross member by cutting the frame around the 3.5" tube inside and outside on both sides of the frame.

10) Inspect your ART-139-3 repair kit and prepare to position it so that the shock mount is on the passenger side of the truck, on top of the tube and facing the rear bumper. The fuel tank mounts are facing down on the driver's side of the truck.

11) Slide the loose inner mount plate onto the ART-139-3 until it's against the center fuel bracket. Make sure the plate is oriented the same as the passenger plate.

12) Next slide the cross member through the driver side inner frame towards the outside.

13) Lifting the passenger side up, aligning it with the hole in the passenger inner frame, and slide it through the frame until the inner mount plate is flat against the truck frame.

14) Place the outside end plate onto the cross member tube ends and clamp the entire assembly onto position by lining the plates up with the end plate outline and center line marks.

15) The fuel brackets has to be tacked in place with a measurement of 11.750 from inside to inside of each fuel tank brackets. **SEE PIC**

16) Check the fit, make sure shock mount and gas tank mounting brackets are positioned correctly.

17) When satisfied with cross member position, tack weld the inner and outer frame plates to the frame and tube. Double check position, then weld entire perimeter of the inner and outer frame plates and tube

18) Remove exhaust hangers from the old cross tube and weld it on the new ART-139.

19) Prime, paint, and/or rustproof your new ART-139 SafeTCap® Frame Repair Kit.

