

**ART-150-1  
ART-150-2  
ART-150-3  
1500/2500  
SILVERADO/SIERRA  
FOWARD FUEL TANK  
SUPPORT CROSSMEMBER**

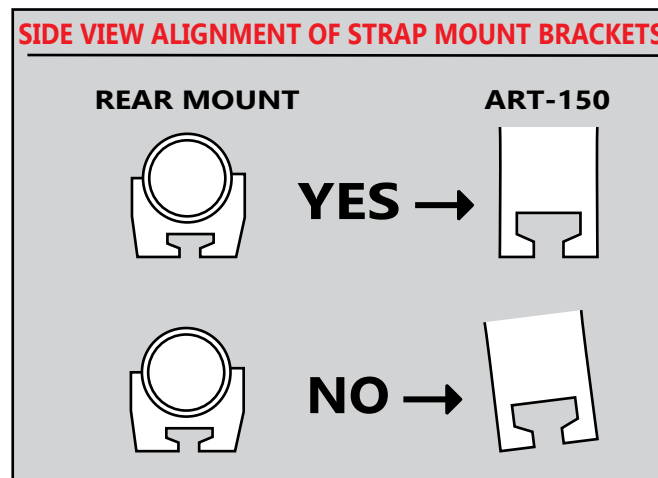
**IMPORTANT:** Read and understand the General Instructions  
**Before** Installing SafeTCap® Frame Repair Kits

## **Installation Instructions**

- 1)** Support the truck on two heavy duty jack stands under the rear axle. Create enough room to work safely. Level the frame left to right. Two additional jack stands on the frame will add extra stability and support.
- 2)** Remove fuel tank and any lines and hose attached.
- 3)** Mark the vertical center of the original crossmember on the inside face of both left and right frame rails. Once center is marked, extend it to the bottom frame.
- 4)** Next, remove the old crossmember.
- 5)** Grind area to be welded.
- 6)** Make a note of where all lines and wires are routed. Most will run above the cross member.

**7)** You are now ready to place the ART-150 crossmember into position. Make sure the fuel tank strap mount (M10-1.5x75mm mounting bolt included) is on the driver side.

**8)** Position the ART-150 , clamp to the frame making sure the bottoms of both T-strap brackets are parallel.



**9)** Tack weld in place and remove the clamps. Then test fit fuel tank.

**10)** Once satisfied with the position and fit of the new crossmember, weld the ART-150 solid.

**Note:** Some models have EVAC components welded to the crossmember, you will need to reinstall it before you remount the fuel tank.

**11)** Rustproof the repaired area with rust inhibiting primer or undercoat.

**12)** Reattach all hoses, lines, and fuel tank.