



**ART-150**  
**1999-2006**  
**1500/2500**  
**SILVERADO/SIERRA**  
**FORWARD FUEL TANK SUPPORT**  
**CROSSMEMBER**

**IMPORTANT:** Read and understand the General Instructions  
**Before** Installing SafeT-Cap® 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 element by an angle of 74 degrees. [Illustration - A]
- 4) Next, remove the old crossmember.
- 5) Grind area to be welded where the inside mount plate meets the top and bottom of the frame.
- 6) Make a note of where all lines and wires are routed. Most will run above the cross member.
- 7) Line up the center marks on the inside end plates with the center line of the original crossmember marked on the frame. [Illustration - A]
- 8) After clamping the mounting plates into position, recheck the center mark alignment and tack weld plates to the inside of the frame rails.
- 9) 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.

- 10) Determine if your original crossmember is mounted directly to the top of the frame, or sits on top of a bracket that elevates it off the frame by approximately 1" [Illustration - B]. This will determine which height line to use on the inner mount plate to set the ART-150 on. [Illustrations B]
- 11) Position the ART-150 on the marks that match your model, clamp to the inner mount plates. [Illustration - C] making sure the bottoms of both T-strap brackets are parallel.
- 12) Tack weld in place and remove the clamps. Then test fit fuel tank.
- 13) Once satisfied with the position and fit of the new crossmember, weld the ART-150 solid to the mount plates and the mount plates to the top and bottom of the frame. Note: Some models have EVAC components welded to the crossmember, you will need to reinstall it before you remount the fuel tank.
- 14) Rustproof the repaired area with rust inhibiting primer or undercoat.
- 15) Reattach all hoses, lines, and fuel tank.

