



ART-151
1998-2006
FORD RANGER
SPARE TIRE CROSSMEMBER

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

Installation Instructions

- 1)** Jack up the rear of the vehicle with a hyd. Jack and use properly rated jack stands to support the rear axle.
- 2)** Remove the spare tire, rear bumper, and rear 2 bed mount bolts. *Removing the pick-up trucks bed is optional, but we suggest leaving the bed attached to the frame as it will keep the frame rails straight.
- 3)** Cut all rivets and/or bolts holding the original spare tire mount to the frame. Then, remove the cross member from between the frame rails.
- 4)** Detach the spare tire hoisting mechanism from the original cross member and remove the emissions canister from the cross member if its attached.
- 5)** Test fit the ART-151 by sliding it between the frame rails from the rear. Make sure to remove the ½" hex cap screw from the ART-151 before test fitting. The ½" weld nuts should end up in the rear lower end of the ART-151 to bolt the rear bumper onto the frame.
- 6)** Attach each of the 4 frame plates to each leg of the cross member and slide them against the inside of the frame rails.

7) Mark the locations of the frame plates on the frame with a paint pen, marker, or soapstone.

8) Remove the ART-151 and frame plates from the frame and grind the marked areas down to clean bare metal. Use a needle scaler to remove any rust buildup that may be inside the frame rails.

9) Once all 4 marked areas are rust free, re-install the ART-151 and all 4 frame plates. Screw in the new rear bumper bolts to the ART-151, this will keep the ART-151 in place while welding.

10) Ensure the ART-151 is in the correct location. Then, tack weld all 4 frame plates to the frame and cross member.

11) Double check the ART-151's placement on the frame. Weld all frame plates to the frame then to the ART-151.

12) Allow the ART-151 welds to cool off. Coat the repaired area and the new cross member with either primer or a rust protective coating.