



ART-167
2007-2014
SILVERADO/SIERRA 1500
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.
- 2)** Remove the rear tires, spare tire, rear bumper. Unscrew the rear 2 bed bolts.
- 3)** Measure the distance from the leaf spring hangers to the end of the frame and take note, this measurement will be needed.
- 4)** You should support your rear axle with a hydraulic jack under the differential before disconnecting the rear leaf springs, use the jack to hold the weight of the differential so the rear suspension is not hanging.
- 5)** Cut the heads off the 4 rivets holding the leaf spring hangers.
- 6)** Slide the ART-167 over the frame. Line up the holes for the leaf spring hanger and up to the end of the frame. Make a mark with a sharpie.
- 7)** Grind the frame to clean, bare metal.

8) Tack weld the ART-167. Check the kits position using measurements taken earlier.

9) After ensuring the kit is in proper position, weld the entire inner and outer edge.

10) Allow the welds to cool, then, re-attach the leaf spring hanger to the frame by lining up the holes in the frame and the ART-167, using measurements taken earlier check that the spring hangar is aligned correct. Leaf spring hangar position should be identical on both driver and passenger sides.

11) You can tack weld the spring hangars to the frame in addition to the hardware provided. Install the 7/16" – 14 x 1" gr.8 HCS with washer and flanged nut to secure the hangar to the frame. Torque each bolt to approximately 63ft/lbs.

12) Coat the repair areas with a rust preventative primer or an undercoat.