



**ART-170
FULL CENTER
FRAME SECTION
2007-2014
CHEVY SILVERADO
SIERRA 1500
EXT. CAB & CREW CAB**

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

**Repair one side at a time for reference. Always disconnect your negative cable
from battery terminal before welding to your vehicle.**

Installation Instructions

- 1)** Jack up the truck and place jack stands under the frame. Make sure the entire center frame between transfer case skid plate cross member, and rear cab mount is fully accessible.
- 2)** Remove the fuel tank and store in a safe location.
- 3)** Remove the brake control module from the frame along with the brake and fuel lines.
- 4)** Remove the emissions charcoal canister and canister frame mount from the frame and take measurements on its location for reinstallation later.
- 5)** Prepare the ART-170 to slide up onto the frame by opening the inside frame tabs with a pair of vise grips to allow the frame section to fit around the triangular cross member support plates on the underside of your frame.

- 6)** Use a paint marker or sharpie to mark the outline of the kit on the frame along the entire perimeter then remove the kit from the frame.
- 7)** Remove the bottom $\frac{3}{4}$ " of the original frame to allow the drain holes in kit to properly work.
- 8)** Grind any rust and corrosion from the repair area, using the marked outline grind the frame down to bare metal all along that outline, make sure the frame is clean and oil free.
- 9)** Drill any holes needed for reattaching the fuel and brake line brackets and also the electronic brake control module into the kit.
- 10)** Slide kit back up onto the frame and use large c-clamps.
- 11)** Tack weld the entire kit at all corners then every 4" to 6" in between.
- 12)** Weld the entire perimeter.
- 13)** Reattach and weld the Charcoal canister mounting plate onto the frame using the measurements taken earlier.
- 14)** Rustproof the entire repaired area with a rust inhibiting primer or undercoating.