



**ART-201  
2003-2009  
TOYOTA 4 RUNNER  
MID FRAME SECTION  
BEHIND TRANS CROSSMEMBER**

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

## Installation Instructions

- 1)** Jack up the front & rear of vehicle and support it on properly rated jack stands. Place rear jack stands under frame, behind rear axle. Make sure the center of vehicle is fully accessible.
- 2)** If you are repairing both sides, cut & repair one side at a time keeping one side assembled as a reference/measuring point.
- 3)** Unbolt and remove any brackets that are in the way.
- 4)** If your vehicle is equipped with the X-Relative Absorber System, you will have to notch kit around valves or remove valves and re-mount.
- 5)** Cut away the rusted area.
- 6)** Position the kit into place and roughly mark the outline. Remove kit and grind the frame down to clean metal.
- 7)** Slide kit over frame, clamp and tack weld kit in place. If you are installing additional kits to frame, test-fit those now to make sure they all fit together properly.
- 8)** Double check all measurements and check door gaps to make sure vehicle stayed straight, then weld all edges 100% solid. If you are adding additional kits, don't weld the ends yet.
- 9)** Prime, paint or undercoat the repaired area.