



ART-203
2003-2009
TOYOTA 4 RUNNER
REAR FRAME SECTION
AT REAR SHOCK AREA

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)** Support rear axle and remove wheels, coil springs, and shocks.
- 3)** Mark the centerline of bump stop bracket on upper frame and cut off.
- 4)** Cut away the rusted area.
- 5)** Position the kit into place and roughly mark the outline. Remove kit and grind the frame down to clean metal.
- 6)** Slide kit over frame and clamp. Tack weld kit in place. Position bump stop bracket and tack in place. If you are installing additional kits to frame, test-fit those now to make sure they all fit together properly.
- 7)** Double check all measurements and check door gaps to make sure vehicle stayed straight, then weld all edges 100% solid.
- 8)** Prime and paint the repaired area. Use self-tapping screws to remount the brackets that were removed.