



**ART-220  
1996-2002  
TOYOTA 4 RUNNER  
REAR FRAME SECTION @  
BUMP STOP**

**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. Allow the rear axle to hang free so the suspension is unloaded. Remove the rear tires.
- 2)** Disconnect the rear sway bar links from the frame on both driver and passenger sides. Take sway bar down and remove it from the rear axle.
- 3)** Put a jack under the rear axle to support it and disconnect the shock. Then, Remove the coil spring.
- 4)** Unbolt the bump stop and save for later use.
- 5)** Take measurements of the sway bar link bracket, fuel tank strap bracket, and bump stop to ensure placement of the ART-220 is correct when aligning.
- 6)** Remove the fuel tank strap bracket, sway bar link bracket, and bump stop mount from the frame and grind flat to the frame.
- 7)** Grind all edges down to clean bare metal.
- 8)** Slide the ART-220 onto the frame from underneath and clamp the frame kit to the frame.
- 9)** With the measurements taken earlier make sure that the ART-220 is aligned and properly placed on the frame. Tack weld the ART-220 to the frame.
- 10)** Double check measurements, then weld the entire perimeter of the Art-220 both inside the frame and outside.
- 11)** Allow welds to cool. Prime and/or paint the repaired area.