



ART-221
1996-2002
TOYOTA 4 RUNNER
REAR FRAME SECTION

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

Installation Instructions

- 1)** Jack up the rear of vehicle and support the frame on jack stands. Make sure the rear of vehicle is fully accessible.
- 2)** Remove the rear wheels and lower the spare tire, also remove the trailer hitch cross member from the frame, if equipped.
- 3)** Determine whether you will need to remove or splice the rear body mount from the frame or if you will remove the corresponding notch plate from the ART-221. Also for the spare tire cross member.
- 4)** Slide ART-221 up onto the frame from underneath until there is no gap between the bottom of original frame. Then outline the ART-221.
- 5)** Remove the frame kit, then, grind the frame down to clean metal along the entire marked line. Remove any rust within the marked outline.

6) Clamp the ART-221 firmly against the original frame ensuring there is no gaps along the edges.

7) Tack weld the ART-221 to the frame at the corners. Then remove the clamps.

8) Check fitment, then weld the frame kit to the original frame.

9) If you notched the body mount and/or cross member make sure to weld the perforated cut lines for each removable plate, and also weld the cross member to the ART-221 and body mount.

10) Prime and/or paint the repaired area, then re-attach any brackets, wiring and/or brake lines back to the frame and make sure to secure them.