



# **ART-247 2001-2007 TOYOTA SEQUOIA MID REAR TRAILING ARM MOUNT SECTION**

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

## **Installation Instructions**

- 1)** Jack up the rear of the vehicle and use jack stands to support the frame allowing the rear end to hang free so the rear suspension is unloaded.
- 2)** Disconnect the lower control arm from the frame and any brake lines or cables attached to the inside of the frame.
- 3)** Measure the lower control arm mounts bolt hole center to a fixed point on the frame.
- 4)** Cut the original control arm mount from the frame.
- 5)** The ART-247 has a removable plate above the control arm mount. Check the integrity of the frame behind the body mount. If the frame is solid, this plate can be removed by continuing the cut lines and the kit can be installed without disturbing the body mount.
- 6)** Test fit your kit by sliding it up over the frame. Using the measurement taken in step # 3, make sure your kit control arm mount is in the proper position.
- 7)** Mark the entire outline of the kit on the frame, then remove the frame kit.
- 8)** Grind the frame down to clean, bare metal along the marked outline.
- 9)** Slide the kit back onto the frame. Tighten clamps to close any gaps, then check measurements.
- 10)** Tack weld the kit to the frame.
- 11)** Install the lower control arm.
- 12)** Weld your ART-247 to the frame.
- 13)** Coat your frame repair section with a rust inhibiting primer or paint, or undercoating.
- 14)** Re-Attach brake lines, fuel lines and fuel tank.