



ART-265LB
1999-2006
SILVERADO/SIERRA
FORWARD LEAF
SPRING HANGER
ALL CAB STYLES

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

**Repair one side at a time for reference. Always disconnect your negative cable
from battery terminal before welding to your vehicle.**

- 1)** Jack up the rear of the truck, use quality jack stands with the proper weight rating and place jack stands under the frame, 1 before the rear axle and 1 after, allowing the rear end to hang free. Use the hyd. Jack under the differential to take the weight off the rear end.
- 2)** Disconnect the leaf spring from the leaf spring mount and lower the axle with a hydraulic jack to move the spring away from the repair area.
- 3)** Measure the original mounts bolt hole center from a fixed point nearby on the frame. Horizontal and lateral measurement.
- 4)** Drill and remove rivets holding the original spring mount and bracket to the frame, then remove the original mount.
- 5)** Grind any rust and corrosion from the repair area, make sure the frame is clean and oil free.
- 6)** Pre bolt up the support bracket with 2 bolts, Place the mount onto the frame and using the measurements taken earlier set the new spring mount into position and tack weld the corners. Then tack weld the mount to the support bracket.
- 7)** Tighten up support bracket. Then, Double check its placement. You can dry fit the leaf spring mount. Placement must be exact to original.
- 8)** Weld the entire perimeter of the mount.
- 9)** Allow the repair area to cool, then rust proof the repair area. Reinstall the leaf spring to the mount with the new hardware provided and torque bolt to 148lbs ft.