



ART-275R 99-06 (1500) REG CAB
ART-275 99-06 (1500) EXT.CAB
ART-275HD 01-10 (2500HD) EXT. / CREW CAB
SILVERADO/SIERRA
DRIVESHAFT SAFETY
CROSSMEMBER

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

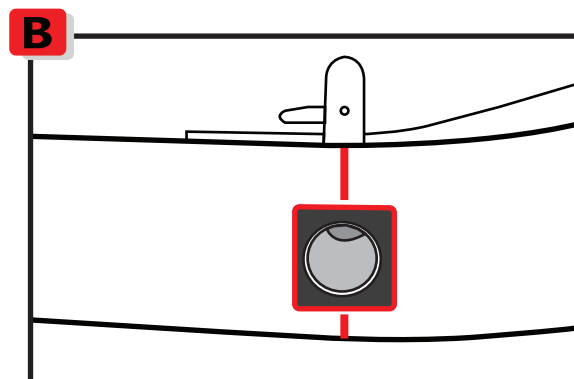
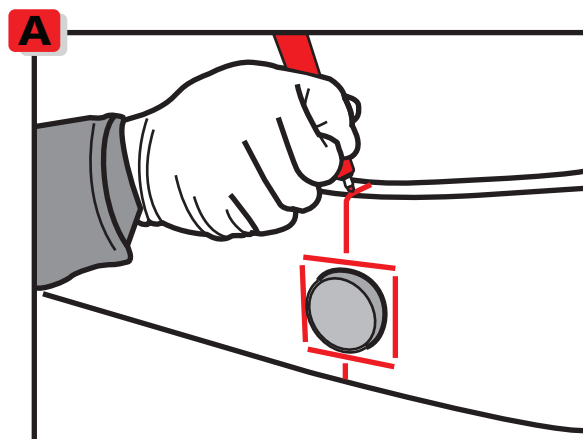
Repair one side at a time for reference. Always disconnect your negative cable from battery terminal before welding to your vehicle.

1) Support the truck using two jack stands under the rear axle. Make sure the frame is level from left to right, then add two more jack stands under the frame for extra stability.

2) Remove the fuel tank along with any attached lines or hoses. If your truck has two drive shafts, detach the drive shaft.

3) Mark the vertical center of the original crossmember on the inside face of both frame rails, and extend the mark down to the bottom edge of the frame. **(ILLUSTRATION A)**

4) Cut out and remove the old crossmember. Clean and grind the area where the new crossmember will be welded. On some models, the muffler may need to be removed to gain access.



- 5) Take note of how all lines and wires are routed before disconnecting or moving them.
- 6) You will need to cut the original exhaust hanger off and plan to reattach it to the new crossmember later.
- 7) Slide both inner plates onto the new crossmember, then carefully position the assembly in place over the driveshaft. Use the center marks on the inner plates to align it properly, then clamp it to the frame. **(ILLUSTRATION C)**
- 8) Tack weld the inner plates at all four corners to hold them in position. Repeat the same process with the outer plates.
- 9) Once you're satisfied with the placement, fully weld the crossmember and plates to the frame.
- 10) Finish by rustproofing the repaired area using a rust-inhibiting primer or undercoating.

