

**289D-R**



**Other cab style may differ**

**ART-289**  
**ART-289D**  
**1999-2006**  
**(1500) Silverado/Sierra**  
**Mid Rear Frame Section**

**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 vehicle with a hyd. jack and use properly rated jack stands to support the frame and the rear axle.
- 2)** Remove the fuel tank and filler neck from the vehicle and store the tank a safe distance from the work area. Tie off and seal the open fuel lines using the "Fuel Line Safety Kit" provided.
- 3)** Unclip the fuel, Brake lines and any wires from the frame rails.

**Note: If you have xtra or reg cab the leaf spring bracket and support will need to be removed.**

- 4)** Grind the repair area removing all rust, debris, oils, dirt, you may need to mark the frame using the frame kit as a guide.

**5)** Prepare kit for installation onto the frame, configure the frame for your trucks specific rust or damage by removing plates between the cut lines.

**6)** Cut bottom of frame and any loose debris.

**7)** Slide the frame kit up over the frame from underneath and use clamps to hold the kit in place then tack weld every 2 to 4 inches.

**8)** Weld entire perimeter.

**9)** Rustproof the repaired area with a rust inhibiting primer or undercoat then re-attach any brackets or wiring back to the frame.