



## ART-218 1996-2002 TOYOTA 4-RUNNER

**IMPORTANT:** Read and understand the General Instructions  
**Before** Installing SafeTCap® 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.

Note: The nearest body mount bolt just forward of the control arm mount is a good measuring point. You will need this measurement to properly align the ART-218 frame repair kit.



- 4)** Cut the original control arm mount from the frame.

**5)** The ART-218 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 ART-218 can be installed without disturbing the body mount.

**6)** Test fit your ART-218 by sliding it up over the frame. Using the measurement taken in step # 3, make sure your ART-218's control arm mount is in the proper position.

**7)** Mark the entire outline of the ART-218 on the frame, then remove the ART-218 frame kit.

**8)** Grind the frame down to clean, bare metal along the marked outline.

**9)** Slide the ART-218 back onto the frame. Tighten clamps to close any gaps, then check measurements.

**10)** Tack weld the ART-218 to the frame.

**11)** Install the lower control arm to the ART-218 mount.

**12)** Weld your ART-218 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.