

INSTALL INSTRUCTIONS: FRAME REPAIR KIT

ATTENTION: Refer to the appropriate shop manual for your vehicle to obtain specific service procedures for this part. If you do not have a service manual or lack the skill to install this part, it is recommended that you seek the services of a qualified technician. Pay special attention to all cautions and warnings included in the shop manual. Read and follow all instructions carefully.

INSTALL OF FRAME REPAIR KIT (523-218) Chevrolet Silverado 1500, 2500 Exc HD 2006–1999

General Tech Tips:

- Disconnect and remove battery.
- Remove fuel tank and clamp, or disconnect fuel lines. Double check for leaking fuel.
- Ensure fire extinguisher is available.
- Wear proper safety protection.
- **NOTE:** Our paint is a weldable primer.

**PLEASE WEAR SAFETY
GLASSES!**

Tools required for installation of frame repair kit:

- Cutting wheel
- C-Clamps
- Permanent marker
- Handheld torch
- Paint scraper
- Grinding wheel
- Welding torch



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Instructions

NOTE: The photos included show work done on a frame that has been removed from the body. Although this looks somewhat different than work done on a frame attached to the truck body, the steps will remain the same.

STEP 1: Remove the truck bed, safely raise the vehicle off the ground, and suitably support the vehicle. **NOTE:** CONSULT THE VEHICLE'S OWNER'S MANUAL OR SHOP MANUAL TO DETERMINE THE PROPER WAY OF RAISING AND LOWERING YOUR VEHICLE.

STEP 2: Using a cutting wheel, cut around the top and sides of the ends of the rear crossbar on the frame.



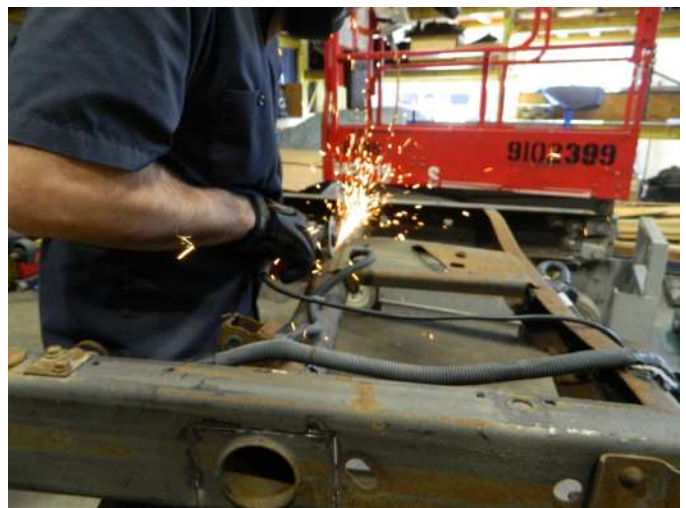
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STEP 3: Once complete, the cuts around the ends of the crossbar will look like those shown in the photos. **NOTE:** Do not cut the frame completely in half (note that the top of the frame is not cut in the photos). Make sure the vehicle frame is properly supported, because the frame will want to twist or bend when the cross-member is removed.



STEP 4: Using a cutting wheel, cut the bed support from the crossbar.



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STEP 5: Once complete, remove the crossbar from the frame.



STEP 6: Place the replacement crossbar in place of the removed one.



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STEP 7: Hold the replacement crossbar in place to the frame with c-clamps.



STEP 8: Using a permanent marker, mark off the section of the frame around where the crossbar attaches to the frame, so you can clean down to the bare metal for a proper and strong weld.



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STEP 9: Remove the replacement crossbar and the c-clamps. Then, using a handheld torch and paint scraper, clean down to the bare metal where the crossbar will attach to the frame, for a proper and strong weld.



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STEP 10: Using a grinding wheel, clean the edge of the bed support to prepare it for welding.



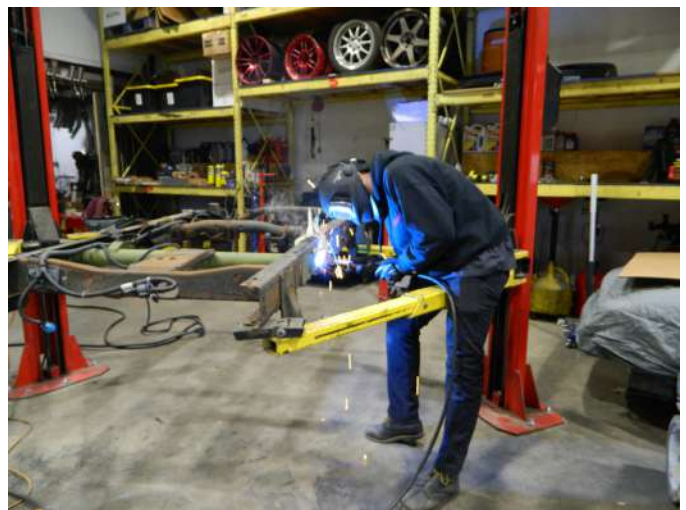
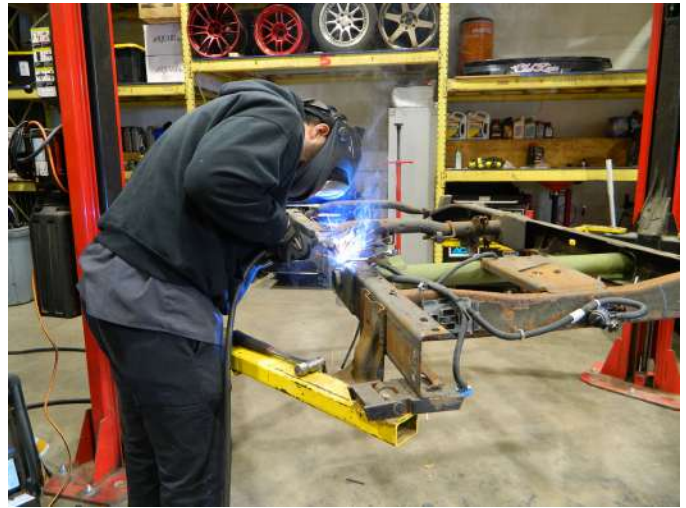
STEP 11: Put the replacement crossbar back in place to the frame with c-clamps.



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STEP 12: Using a welding torch, weld the outer plate to the outside of the frame on both sides of the crossbar.



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STEP 13: On both ends of the crossbar, put the upper supports into place. Then, using a welding torch, weld a tack to both upper supports to hold them in place.



STEP 14: Using a grinding wheel, clean the edges of the lower supports to prepare them for welding.



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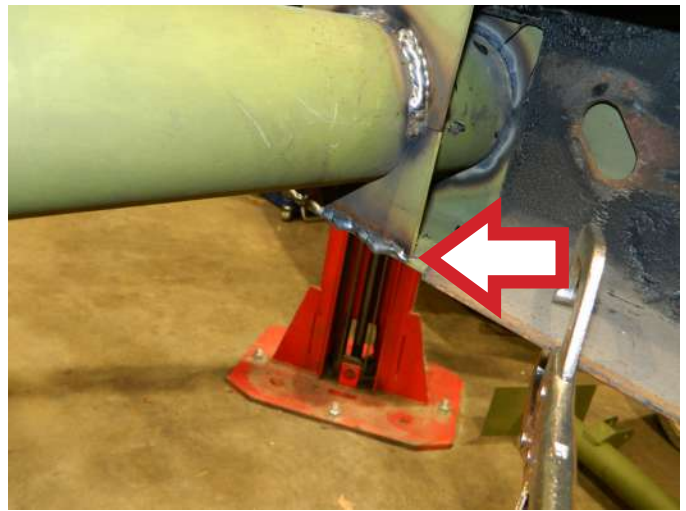
STEP 15: On both ends of the crossbar, put the lower supports into place.



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STEP 16: Using a welding torch, weld the upper and lower supports to the frame and each other, and weld the tube to the outer plate, on both ends of the crossbar. In addition, weld the tube to the bed support.



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STEP 17: Paint any bare metal to help prevent corrosion.

STEP 18: Safely lower the vehicle. **NOTE:** CONSULT THE VEHICLE'S OWNER'S MANUAL OR SHOP MANUAL TO DETERMINE THE PROPER WAY OF RAISING AND LOWERING YOUR VEHICLE.