

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 (523-217) Chevrolet Silverado 1500, 2500 Exc HD 2006–2000

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
- Permanent marker
- C-clamps or vice grips
- Handheld torch
- Paint scraper
- Flap wheel disc
- Welding torch
- Spray paint



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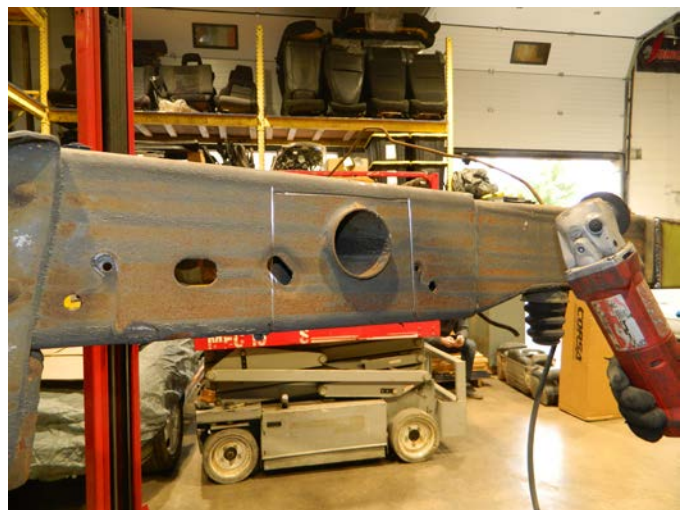
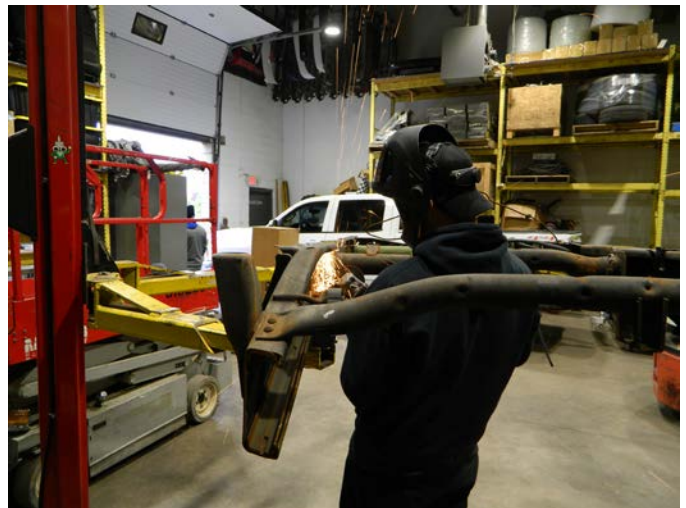
Instructions

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 crossbar on the frame, on both sides of the frame.

NOTE: Do not fully cut and remove the crossbar yet.



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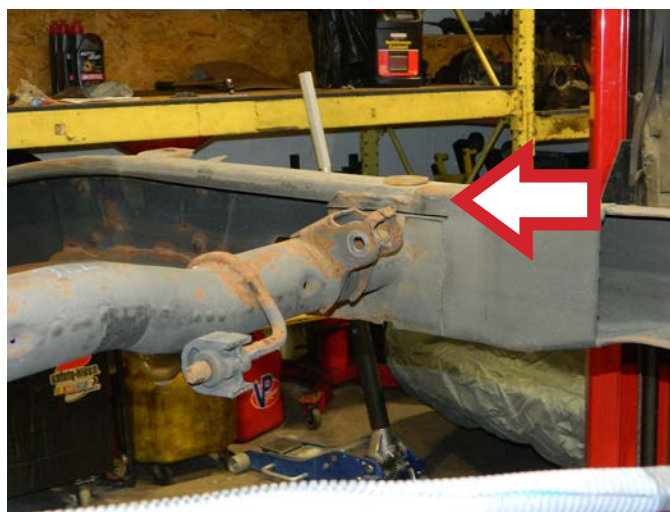
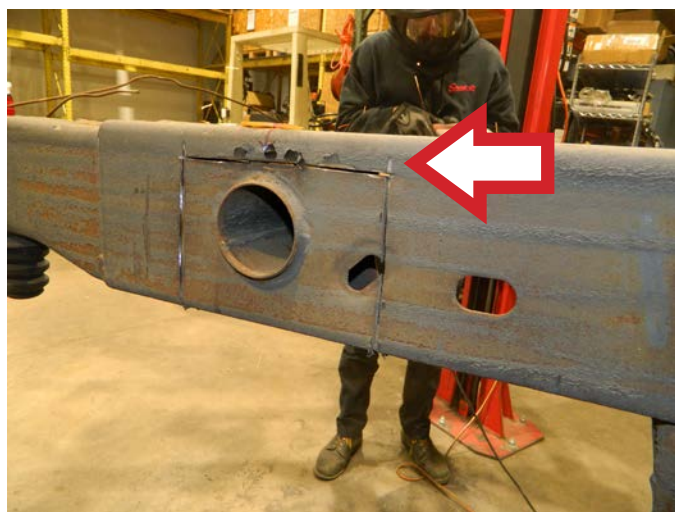
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STEP 3: Before completely removing the crossbar, mark off where the center of the tube goes with a permanent marker, to accurately place the replacement tube later.



STEP 4: Using a cutting wheel, finish cutting around the bottom and inside of the ends of the crossbar on the frame, on both sides of the frame. Once complete, the cut will go up and over the tube on the outside and inside of the frame, on both sides of the frame.

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.



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



STEP 6: Place the replacement crossbar in place of the removed one. Hold the replacement crossbar in place to the frame with c-clamps or vice grips. Then, using a permanent marker, mark off the section of the frame around where the crossbar attaches to the frame (on both sides of the frame).



STEP 7: Remove the replacement crossbar and the c-clamps or vice grips. Then, using a handheld torch and paint scraper, clean down to the bare metal where the crossbar will attach to the frame, on both sides of the frame, for a proper and strong weld.



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STEP 8: If necessary, using a flap wheel disc, sand the outside of the frame to clean for welding, on both sides of the frame.



STEP 9: Using c-clamps or vice grips, place the outer plates to the outside of the frame, on both sides of the frame.



STEP 10: Using a welding torch, weld the outer plate to the outside of the frame on both sides of the crossbar.



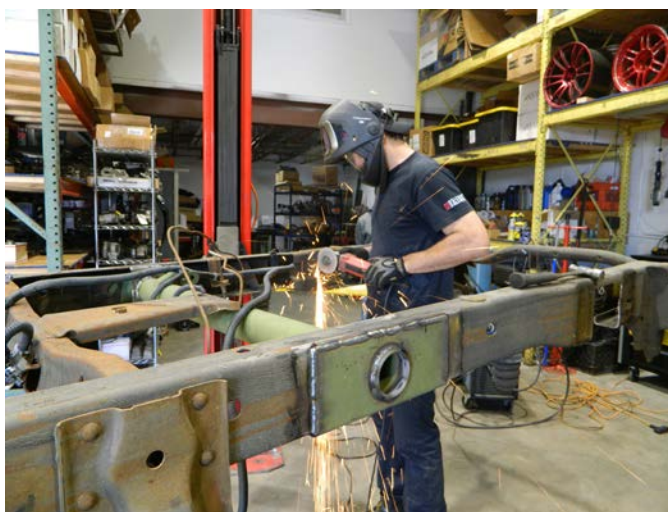
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STEP 11: Hold the tube and inner plates in place on both sides of the frame. Then, using a permanent marker, mark off the section of the frame around the inner plates (on both sides of the frame), so you can clean the frame underneath the inner plates down to the bare metal.



STEP 12: Remove the tube and inner plates from the frame. Then, using a flap wheel disc, sand the inside of the frame to clean for welding, on both sides of the frame.



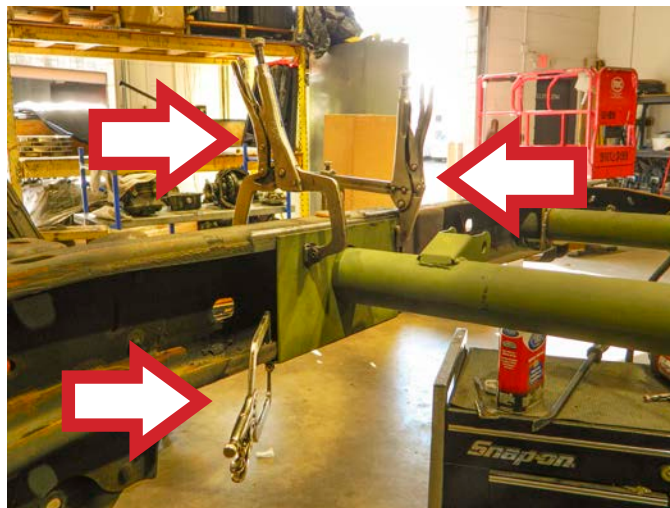
STEP 13: When you are finished, the inside of the frame on both sides should be clean as shown.



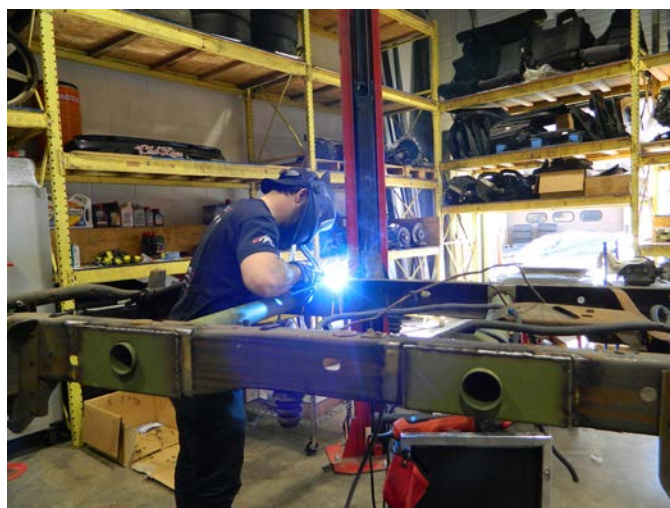
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STEP 14: Replace the inner plate and tube, and hold in place using c-clamps or vice grips.



STEP 15: Using a welding torch, weld the inner plate to the inside of the frame, on both sides of the frame. Then, weld around the tube to the inner and outer plates, on both sides of the frame.



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STEP 16: When finished, the weld on the inner and outer plates and around the tube should look like the photos shown.



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STEP 17: Once the tube is in place, attach the included exhaust hanger in the same location as the OE.



STEP 18: Be sure to paint all bare metal surfaces to prevent any rust or corrosion.



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STEP 19: 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.