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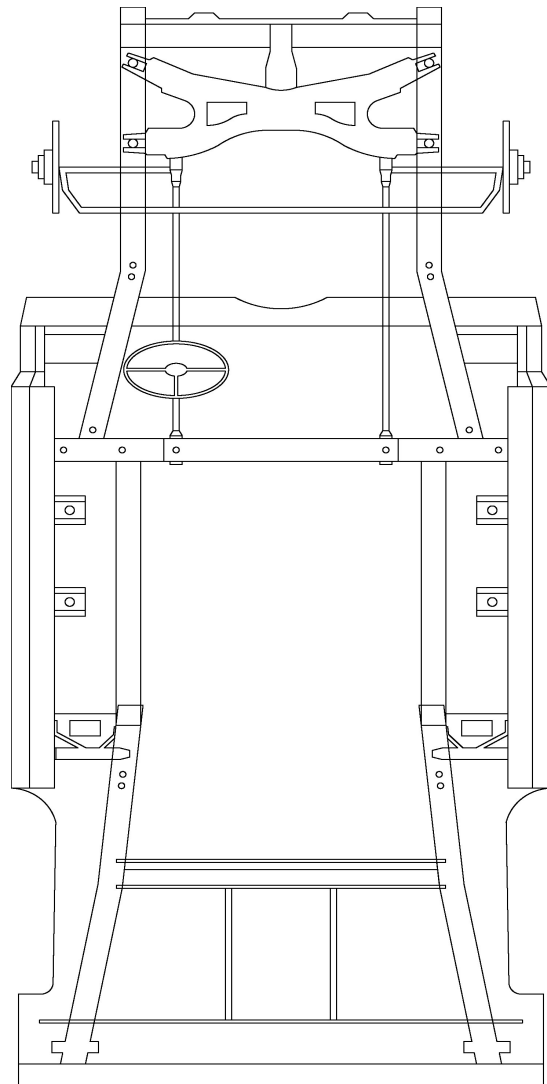
Installing Frame Repair Kits

1) **Safety Notes – Follow all instructions. Failure to follow instructions may result in property damage or serious or fatal injury. User assumes all liability.**

- a) Remove battery.
- b) If you are working within 24 inches of a fuel tank, remove tank. Check for leaking fuel on car. Clamp off or disconnect fuel line near tank. If tank leaks, remove it.
- c) Keep flammable materials at least 20 feet from the car.
- d) Remove interior panels and carpets that might burn in the area to be worked on.
- e) Keep fire extinguisher and water hose near car.
- f) Wear safety gloves and full eye protection.
- g) Use a fire watch person when torch cutting or welding on any car.

2) **Welding Styles**

- a) “Stick” or “Arc” welding is difficult for some people, but can produce a sound weld.
- b) “Mig” (wire fed) welding produces a very sound weld. We use a 220 volt machine with .035 wire (E7056) and a 75% Argon, 25% CO₂ gas mix.



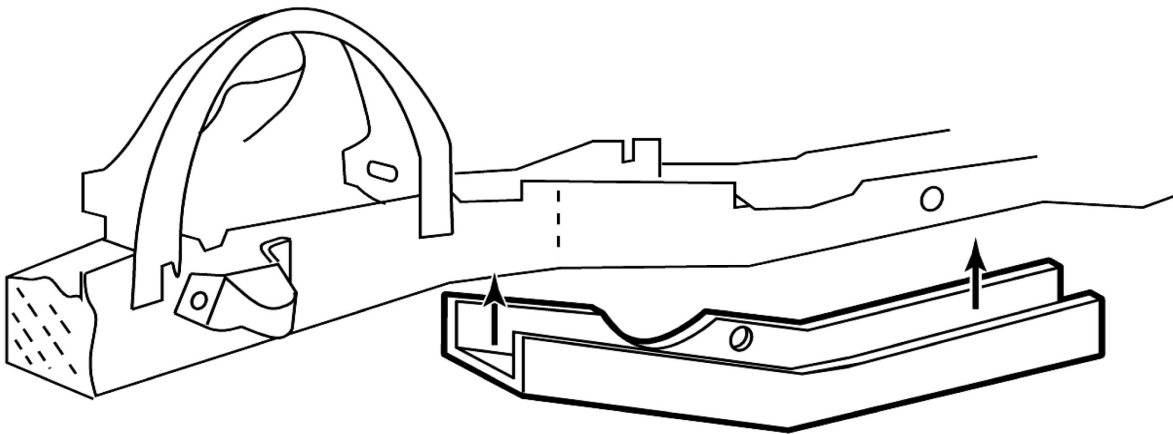
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3) Preparing a Car for New Frame Section & Kit Installation

- a) Support vehicle properly over a solid, level floor. Use good safety stands or a lift.
- b) Most of our kits are designed to slip over the frame and weld in place. This helps keep the original dimensions and locations, which can be lost when frames are completely removed. This technique provides superior strength and allows you to get the job done more quickly.
- c) The life of the repair can be extended by trimming or cutting back the rust. Allow at least ½” for overlap.
- d) Some frames have brackets, bump stops, etc. that might have to be cut off and welded back on after the kit is installed. Drill out spot welds on such parts for a clean cut.
- e) Our front frame kits have “K” nuts welded in, so you must cut off the bottom of your frame completely.
- f) Paint or rustproof frame repair.

4) Welding Notes

- a) Weld kit in place using a ½” to 1” long bead, spaced every 1”. You can weld the frame kit solid for maximum strength (high performance, racing, etc.). Allow some time for cooling and move around the part.
- b) Good welds require clean surfaces, so grind, scrape, or wire brush surfaces to be welded.
- c) Temperature should be at least 50 degrees.
- d) If in doubt, bring it to a professional welder, or have them inspect your work before coating.



Technical support is available Mon-Fri 8-430 EST at (800) 407.7024