



**frame repair kits**

*We Make it Easy to Make it Safe!*



**Auto Rust Technicians**

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# Instructions for Installing Safe-T-Cap™ Frame Repair Kits

*General automotive welding safety, metal preparation,  
and frame repair guidelines to achieve long-lasting results – safely.*

**Attention! For your safety follow all instructions. Failure to follow instruction may result in property damage or serious or fatal injury. User assumes all liability.**

## A. Vehicle Preparation

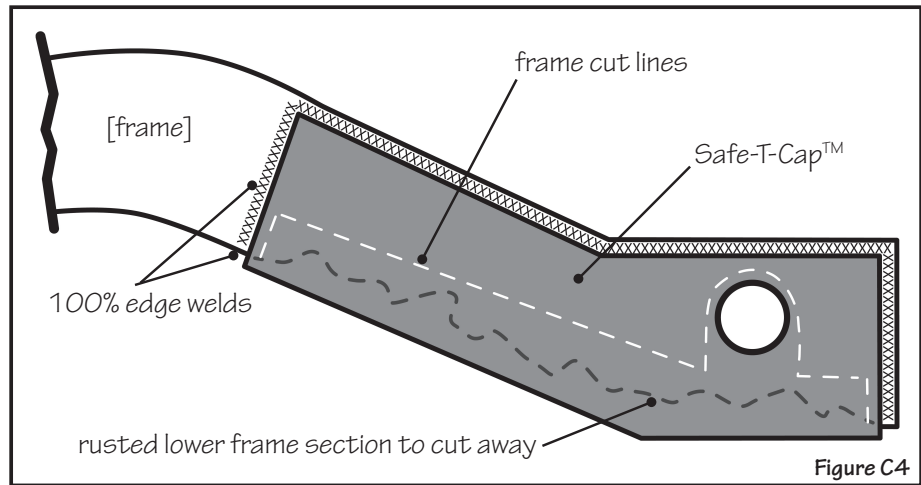
1. Disconnect the battery.
2. Check for fuel leaks; tank > lines > engine.
3. Repair or replace any leaky fuel lines before proceeding any further.
4. If the fuel tank leaks, remove it before, repair/replace after installation is complete.
5. Remove fuel tank if within 24 inches of the welding/repair area.
6. Keep flammable materials at least 20 feet from the vehicle.
7. Remove interior panels, seats, padding and carpets in the cabin area above work area.
8. Keep a fire extinguisher and water hose close by, use water for any fabric fires.
9. ALWAYS use a Fire Watch Person when cutting or welding on a vehicle. In case of emergency have a phone near by for a 911 call.

## B. Welding & Safety

1. Take safety precautions by wearing eye protection, gloves, sturdy boots, etc.
2. “Stick” or “arc” welding is difficult for some, but capable of producing a sound weld. For best old/new metal results, use 6011, 3/32 or 1/8 inch welding rods.
3. “MIG” welding produces a very sound weld. At Auto Rust Technicians we use 220v units with .035 wire (E7056) with a 75% Argon/25% CO2 gas mixture.
4. If you are a welding novice, test your welds by joining two pieces of 1/8 inch thick scrap metal together and then try to break them apart – solid welds will not break!
5. Quality welds require clean surfaces; so grind, scrape or wire brush surfaces to be welded – the minimum frame temperature for welding is 50 °F.
6. Weld kit in place using 1/2 inch to 1 inch long beads every 1 inch, then weld seams solid.
7. If in doubt about the techniques, equipment and outcome of the project, hire a professional welder/installer. You can always have us install it for the “Factory Installation” results at a fair cost. If travel/distance is an issue, we have many local installation shops throughout the states that we can recommend.

## EQUIPMENT LIST

- Jack Stands/Ramps/Lift
- Quick Line Disconnect
- Eye & Ear Protection
- Work Gloves
- Fire Extinguisher & Water
- Cutting Wheel or Torch
- Grinder or Sander
- Locking Pliers or Clamps
- Welder: Mig or Stick
- Paint & Undercoat



## C. Installing the New Frame Kit

1. If you are installing a right/left pair, repair one side keeping a reference/measuring point.
2. Support vehicle completely over a solid, level floor. Use good quality, weight-rated, safety jack stands, ramps or ideally – a hydraulic lift.
3. Most of our kits are designed to slip over the original frame after the bottom of the frame rust is cut back, and weld in place. This helps duplicate the original dimensions, and location points, which can be lost if sections are completely removed. This overlapping Safe-T-Cap™ technique is the way we have been successfully repairing frames for over 37 years, providing superior strength while allowing you to complete the job safely and quickly.
4. The bottom of the frame must be cut off and area ground to clean metal – at least half way up the frame. With this method the frame rust is not contaminating your new frame section. The minimum remaining can be no less than 1 inch of the original frame for the Safe-T-Cap™ kit to overlap and perform as designed. Measure, fit, measure, then tack weld Safe-T-Cap™ at key points, the final installation requires complete 100% edge welding. **[See Figure C4]**
5. Some frames have brackets, bumps, and stops, etc. to be cut off and reused in order to complete the installation, drill out spot welds on such parts for easy removal.
6. Once welding and wire brushing is finished, brush or spray primer, then paint or undercoating.
7. Inspect the repair monthly.

## D. Business Opportunities

Safe-T-Cap™ products are Registered Trademark Designs developed by Revision Automotive Corporation in response to hundreds of cars, Jeeps and trucks that have required frame rot repairs. All kits/parts have been designed, manufactured, tested and installed in our Cranston, Rhode Island, USA facility – Auto Rust Technicians.

*Auto Rust Technicians is always looking for high quality regional repair facilities to recommend for installations. If you are a repair shop and would like to be on our installation referral list, please call 800-407-7024 or email me direct at [jerry@autorust.com](mailto:jerry@autorust.com)*



**Warranty Notice:** Safe-T-Cap™ Frame Repair Kits are precision made to fit FACTORY STOCK FRAME dimensions and WILL NOT FIT as designed on any MODIFIED or ALTERED FRAMES. We offer NO GUARANTEE of fit on MODIFIED, ALTERED or OFF-ROAD vehicles. NO PRODUCT RETURNS on kits that have been altered in any manner from OUR PATENTED DESIGNS. Our repair kits are designed for NORMAL USAGE/WEAR set to factory specs.

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