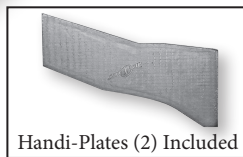
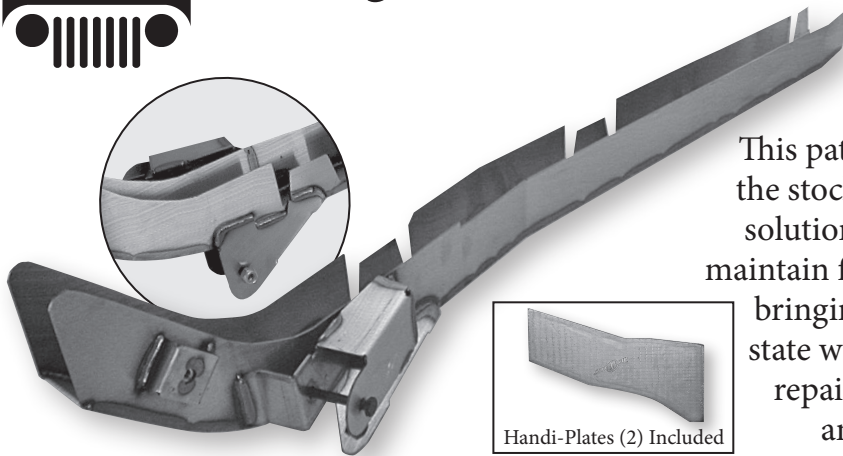


ART-131 Installation Instructions

Full Center Frame Section with Rear Trailing Arm Mounts



Wrangler TJ 1996-2003



Handi-Plates (2) Included



www.SafeTCap.com

Auto Rust Technicians

275 Niantic Ave., Cranston, RI 02907

(401) 944-4444 (800) 407-7024

www.autorust.com

We make it easy to make it safe!

This patented Safe-T-Cap™ kit is designed to slip over the stock frame providing you with the affordable DIY solution to serious frame rot issues. Safe-T-Cap™ kits maintain factory dimensions and mounting points while bringing your frame back to a strong, safe and secure state with new, mig-welded steel. Safe-T-Cap™ frame repair kits are guaranteed to fit factory stock frames and are designed and manufactured in the USA.

READ “Instructions for Installing” Safety Sheet BEFORE Starting the Repair!

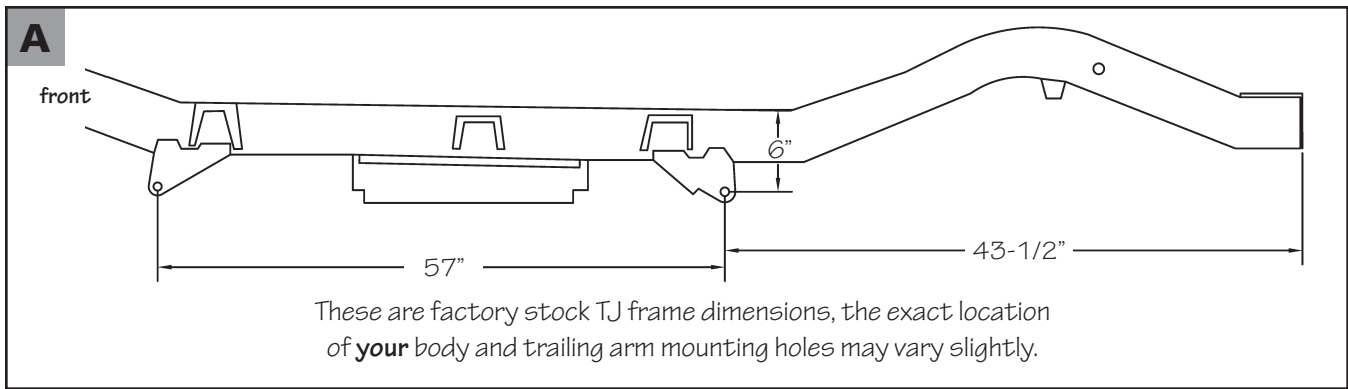
CAUTION! *If you are not fully confident doing the installation yourself, have a professional welder install it, or at least have one inspect your repairs before you finish coat your Safe-T-Cap™ installation.*

1. If you are repairing both driver and passenger sides - cut and repair one side at a time... safety first!
2. Jack up all 4 corners of your Jeep and support it on quality jack stands. Make sure the center of the Jeep is fully accessible.
3. Remove the skid plate and put a secure stand under transfer case and rear axle to support it. [Illustration - B]
4. Unbolt and remove the side steps and related support brackets, you will weld steps back on if you plan to re-use them.
5. If repairing the driver side (L); cut off the rear brake cable bracket. We have found when repairing the passenger side (R), frame access is much easier if the exhaust system is disconnected from the catalytic converter back.
6. Unbolt and remove the upper and lower trailing arms and tuck them out of the way, keep the rear end straight.
7. Transfer a mark from one of the original transfer case skid plate bolt hole locations to the frame above were you are cutting. Use a heavy marker, or paint. You will want this for reference later during assembly, mark all 3 of the holes for total accuracy. Lastly, measure the distance between hole centers of the front and rear trail arm mounts, be very precise and save that dimension.
8. Cut away the rusted area using a plasma cutter, reciprocating saw, or a torch. [Illustration - B]
9. Set the kit in place; roughly mark the area where you will be welding. Grind the areas clean where your marks are, taking it all down to bare, clean metal.
10. Slide kit over frame using precise measurements [Illustration - A] to position correctly. Use the included “Handi-Plates” above front trailing arm if required, or just add to give your frame additional strength. [Illustrations - B & C]
11. Make sure kit is in correct location. Double check your measurements and tack weld the Safe-T-Cap™ in place. Final inspect your set up, then weld all edges 100% solid. [Illustration - C]
12. Prime and paint the repaired area.
13. Mount and torque the trailing arm bolts to factory specs and remount the skid plate unit.
The Safe-T-Cap™ frame rail includes built-in weld nuts - we know the issues there.
14. Visually inspect that the repaired area is secure, safe, and solid. Test drive, then inspect after one day or one mile, then monthly.

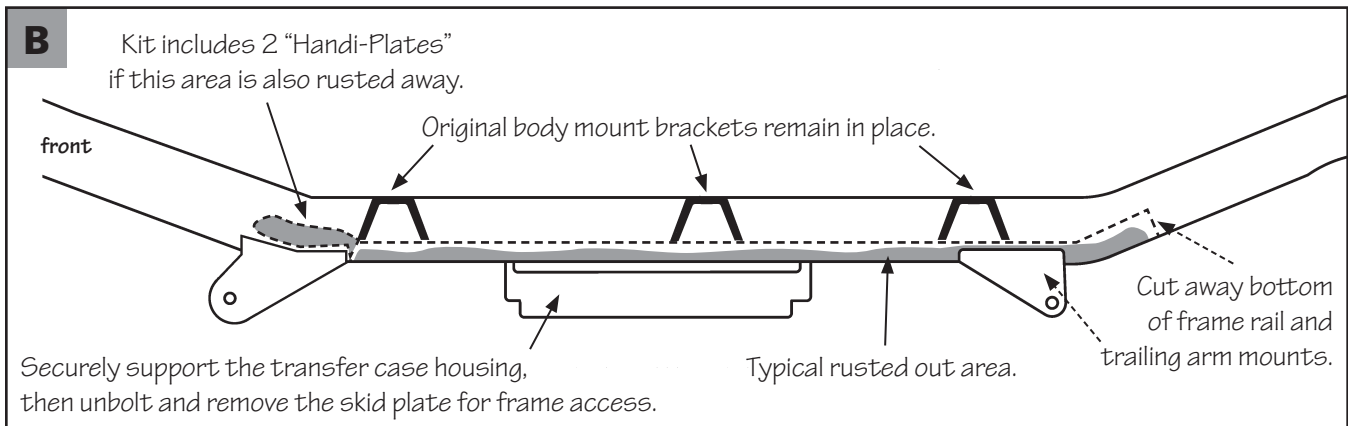
Thank you for using our Safe-T-Cap™ products. We appreciate your business.

SAFE-T-CAP™
frame repair kits

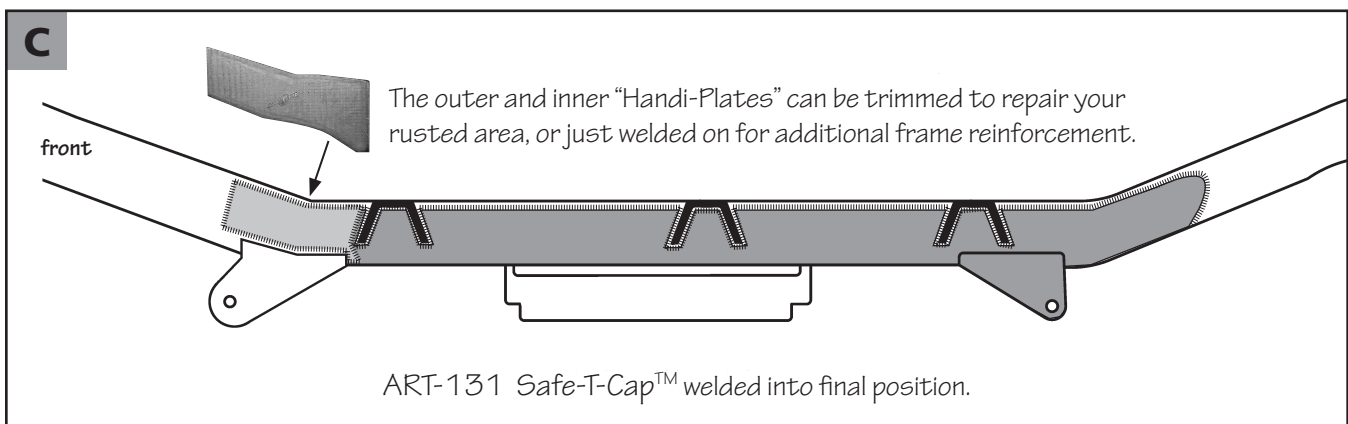
We Make it Easy to Make it Safe!



Start by measuring the distance between hole centers of the front and rear trailing arm mounts, be as accurate as possible and write it down. These measurements are key for achieving the factory correct alignment of the Safe-T-Cap™.



Use your new Safe-T-Cap™ as a guide and marker or chalk out a basic fit placement, then cut out frame 1 inch below the reference lines. Grind the remaining area clean and position the Safe-T-Cap™ in place with measurements referenced in Illustration - A.



Fit Safe-T-Cap™ tight up into frame. Measure again and tack weld corners in place. Once satisfied with position and appearance, weld all edges 100% solid. Move the bead area around to avoid overheating.



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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