

ART-42 Installation Instructions

Rear Frame Section/Shackle Mount



Wrangler YJ 1987-1995



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!

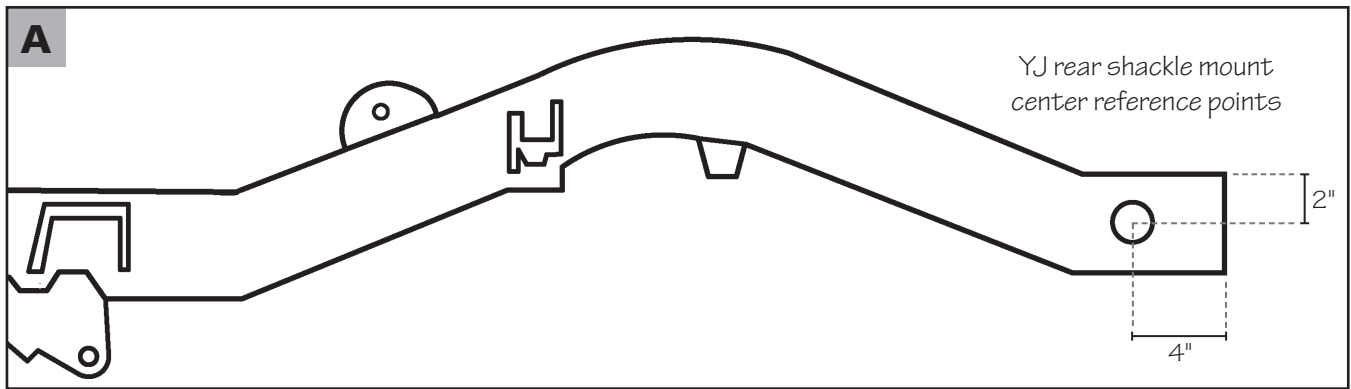
CAUTION! If you are not fully confident doing the installation yourself, have a professional welder install it, or at least have one inspect your repairs before you finish coat your Safe-T-Cap™ installation.

1. Position floor jacks or other solid supports under the center section of the frame.
2. Disconnect rear upper shackle mounting hardware and pivot down the leaf spring.
3. If you are repairing both driver and passenger sides - repair one side at a time... *safety first!*
4. Frames may have brackets, bump stops, etc. that might have to be cut off and welded back on after the Safe-T-Cap™ is installed. Drill out spot welds on such parts for a cleaner cut and final finish.
5. Use the Safe-T-Cap™ as a guide and mark out lower section of frame it will be covering. [Illustration – B]
6. Cut away the rusted area using a plasma cutter, reciprocating saw, or a torch; leaf spring mounting sleeve and the lower part of the frame – all rust back to the rear crossmember. Allow a minimum of 1 inch overlap of frame and Safe-T-Cap™. [Illustration – C]
7. Set the Safe-T-Cap™ in place; mark the area where you will be welding. [Illustration – B]
8. Grind the frame and rear crossmember attachment area down to bare, clean metal.
9. Slide kit over frame referencing your measurements and factory specifications. [Illustration – A]
10. Make sure kit is in correct location. Double check your measurements and tack the Safe-T-Cap™ in place. Final inspect your set up, then weld all edges 100% solid to frame and rear crossmember. [Illustration – D]
11. Prime and paint the repaired area.
12. Reinstall leaf spring shackle mount.
13. Visually inspect that the repaired area is secure, safe, and solid.
14. Test drive, then inspect after one day or one mile, then monthly.

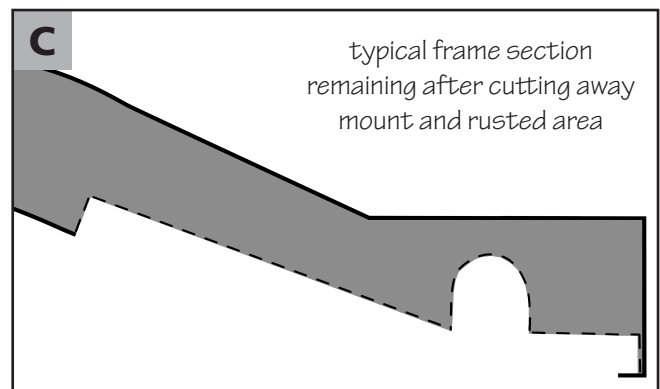
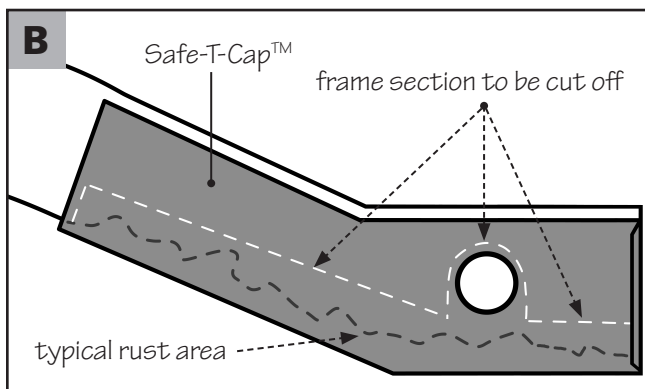
Thank you for using our Safe-T-Cap™ products. We appreciate your business.

SAFE-T-CAP™
frame repair kits

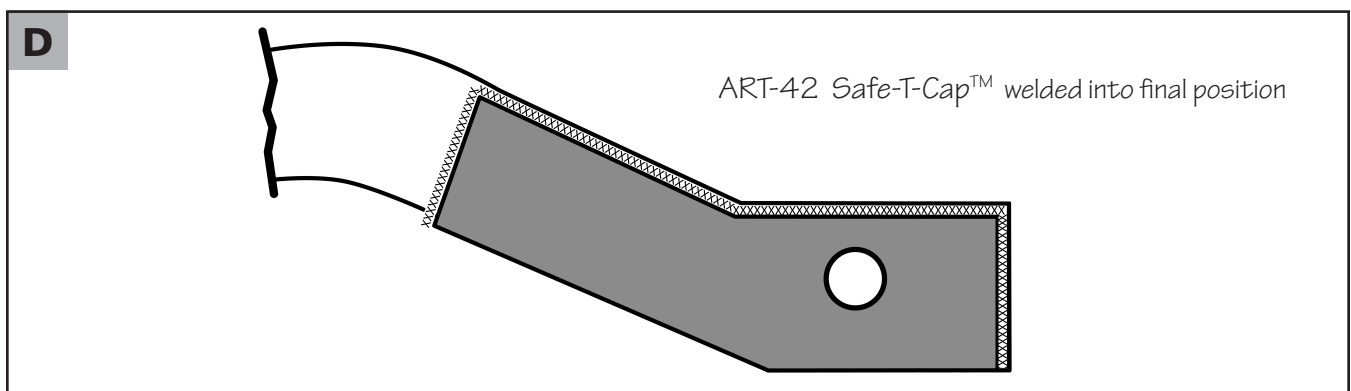
We Make it Easy to Make it Safe!



Start by measuring the distance center of the shackle mount to end of the rear crossmember, your frame may vary slightly from the factory specs above. Accurate measurements are key for factory correct alignment of your new Safe-T-Cap™ and proper suspension performance.



Use your new Safe-T-Cap™ as a guide and marker or chalk out a basic fit placement, keep a 1 inch minimum overlap of frame to Safe-T-Cap™. Grind clean the remaining frame and rear crossmember attachment area, then position the Safe-T-Cap™ with measurements referenced in Illustration - A.



Fit Safe-T-Cap™ tightly up and back into frame. Measure again, 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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