

# ART-119 Installation Instructions

## Frame to Body Mount Brackets



1997-2006 Wrangler TJ



Jeeps utilize rubber body bushings to mount the body to the frame, isolate road noise, and minimize vibrations.

The rubber-metal-rubber connection, plus water, dirt, and salt contributes to the rusting out of the top of the brackets. Our direct replacement body mount brackets are formed from 11 ga. steel. Sold as a set of 6.

**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 SafeTCap® installation.*

1. **IMPORTANT:** Read and understand the "General Instructions for Installing SafeTCap® Frame Repair Kits" before you begin.
2. If you are replacing all 6 body mounts, do one side at a time.
3. Jack up one side of the vehicle, use 2 jack stands to support it safely.
4. Lift the body tub slightly by placing a jack on the floor channel. This will take pressure off of the body mounts.
5. Extend a location line from the center of the body mount down the outside face of the frame and continue onto the bottom face of the frame. [Illustration - 1]
6. Measure and record the distance from the frame bottom to top surface of each mount.
7. Remove the old body mounts. Grind the area where the new body mount will be welded down to the bare metal.
8. Redraw your location lines.
9. Draw the height location lines for each mount. [Illustration - 1]
10. Set new body mounts on location marks and tack weld each mount in place.
11. Check location of new mounts, use rubber mounts and bolt into floor channel.
12. After adjustments, if needed, remove bolt and rubber mounts.
13. Finish welding body mounts all around. [Illustration - 2]
14. Paint or coat all body mounts and surrounding metal.
15. Reinstall rubber mounts and bolt to floor channel.
16. Remove jack on floor channel.

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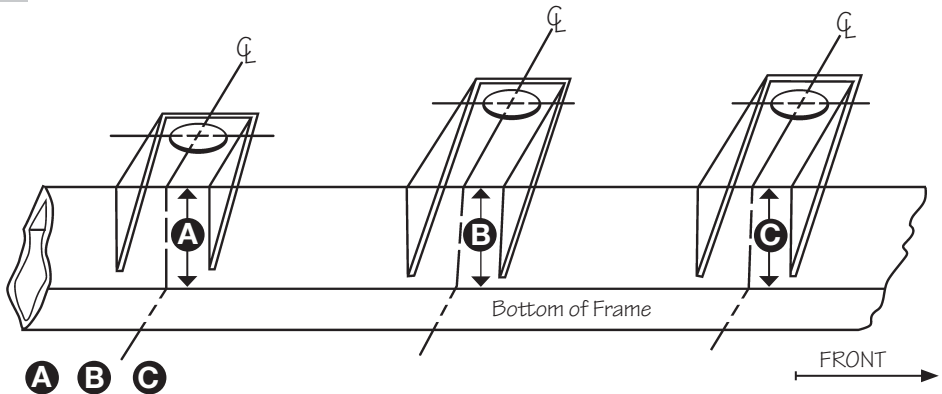
## Frame to Body Mount Brackets



1997-2006 Wrangler TJ

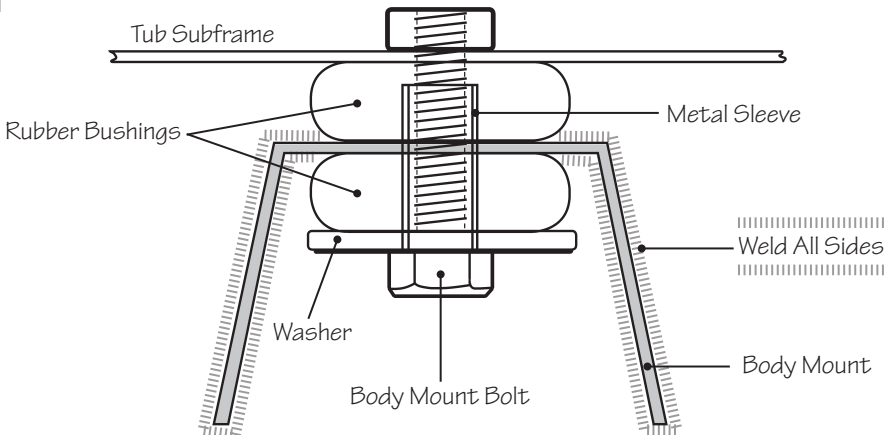
17. Tighten bolts.
18. Remove jack stands.
19. Lower Jeep to the floor.
20. Repeat the steps above on the opposite side.

### 1 Location marks and measurements to install ART-119 mount brackets



- Extend the location lines from the center of the body mount onto the frame
- Accurately measure the height distance of each mount

### 2



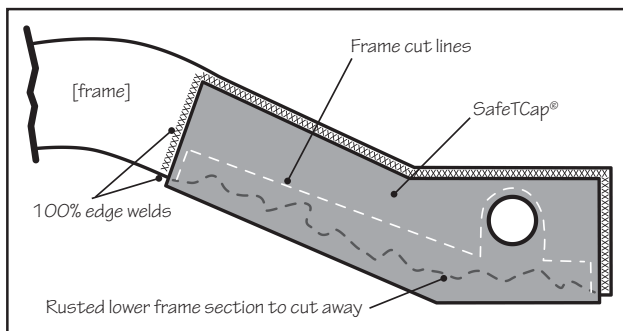
# General Instructions for Installing SafeTCap® Frame Repair Kits

*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.**

## 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



## 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" of the welding/repair area.
6. Keep flammable materials at least 20' 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, call 911 immediately.

## 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" 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. Quality welds require clean surfaces; so grind, scrape or wire brush surfaces to be welded – the minimum frame temperature for welding is 50°.
5. Weld kit in place using 1/2" to 1" long beads every 1", then weld seams solid.
6. If in doubt about the techniques, equipment and skills needed for a safe and successful installation call (800)407-7024 for an appointment to install your kit at our Cranston, R.I. location, or to obtain a list of installers near you.

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# General Instructions (con't.)

## INSTALLING THE NEW FRAME KIT

1. If you are installing a right/left pair, repair one side at a time, 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 then welded in place. This helps duplicate the original dimensions, and location points, which can be lost if sections are completely removed. This overlapping SafeTCap® technique is the way we have been successfully repairing frames for over 40 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 1/2" of the original frame for the SafeTCap® kit to overlap and perform as designed. Measure, fit, measure, then tack weld SafeTCap® at key points, the final installation requires complete 100% edge welding, with an assistant acting as a Fire Watch.
5. Some frames have brackets, bumps, stops, etc. that need to be cut off and reused in order to complete the installation. Drill out the factory spot welds on these for cleanest removal.
6. Once welding and wire brushing is finished, brush or spray primer, then paint or undercoating.
7. Inspect the repair yearly.

## SAFETCAP® ONE YEAR LIMITED WARRANTY

### What Does This Limited Warranty Cover?

This warranty covers any SafeTCap® product defect or malfunction in your new frame repair component.

### How Long Does The Coverage Last?

This warranty lasts one (1) year from the date of purchase and is nontransferable.

### What Will SafeTCap® Do?

SafeTCap™ will replace any defective part at no charge. You must pay shipping and all labor charges to remove and reinstall the defective part.

### What Does This Limited Warranty Not Cover?

This limited warranty applies to the SafeTCap® frame repair components only, and covers any defects in materials and workmanship on the component. SafeTCap® is not responsible for product failure due to improper installation, or installation on modified frames and vehicles with non-standard retrofitted suspensions. SafeTCap® is not responsible for the quality of the

installation, or for any issues that may arise beyond the scope of repair for which the part was intended.

Consequential and incidental damages are not recoverable under this warranty. Some states do not allow the exclusion or limitation of incidental or consequential damages, so the above limitation or exclusion may not apply to you.

### How Does State Law Apply?

This warranty gives you specific legal rights; you may also have other rights which vary from state to state.

### How Do You Get Warranty Service?

In order to be eligible for service under this warranty, you must return the SafeTCap® registration card provided, within 30 days of receipt. You may also register your SafeTCap® online at [www.safetcap.com](http://www.safetcap.com). To obtain warranty service, please call us toll free at 1-800-407-7024.



*We Make it Easy to Make it Safe!*

**SafeTCap®**

1550 Elmwood Ave.

Cranston, Rhode Island 02910

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

[www.safetcap.com](http://www.safetcap.com)

(USA)

SafeTCap® products are designed and developed by SafeTCap Inc. in response to hundreds of vehicles that have required frame rot repairs. All kits/parts have been developed, manufactured, tested and installed at our Cranston, Rhode Island, USA facilities.

We accept returns within 30 days of receipt of product. Buyer pays return shipping and is subject to a 10% RESTOCKING FEE. To return an order customers need to call 1-800-407-7024 to obtain a RETURN AUTHORIZATION NUMBER. We do not accept returns that have been modified or altered, in any way, from the factory shipped component.

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