** ART-099 1987-1995 Wrangler YJ Center Frame at Skid Plate Mount**

[**www.SafeTCap.com**](http://www.SafeTCap.com)

 **1-800-407-7024**

 **Installation Instructions 1/29/2018**

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1. IMPORTANT: Read and understand the “General Instructions for Installing SafeTCap Frame Repair Kits” before you begin.
2. Jack up all four corners of your Jeep and support the front and back ends safely on four quality jack stands., give yourself plenty of clearance and work space.
3. Unbolt and remove the skid plate, place a jack stand under the transfer case to support it.
4. Cut the rear brake cable brackets off the backside of the frame on the drivers’ side only.
5. Mark the area to be cut from the frame, leave a 1” overlap. [Illustration A]
6. Transfer marks from one of the original bolt hole locations to the frame above where you will be cutting, mark all three holes for accuracy. [Illustration A]
7. Cut and remove the rusted area, you can use a plasma cutter, sawzall, disc cutter or torch.
8. Place the kit into position and roughly mark the area where you will be welding.
9. Grind the areas clean that you have just marked, be thorough, a clean surface produces better welds.
10. Slide the ART-099 over the frame and line up your center marks with the mounting holes in the frame kit.
11. Use clamps and check to make sure the kit is in the correct location.
12. Once you have verified the location is correct, weld 1” long beads around the ART-099 perimeter, then weld solid.
13. Reattach brake cable brackets.
14. Paint or undercoat the repair and new frame components.
15. Bolt the skid plate & transmission back in place, lower the jack from the transfer case.
16. Double check that all your welds are solid.
17. Double check the skid plate bolts and transmission mounts are bolted tightly in place.
18. Lower your Jeep to the ground and hit the road!

***Illustration A***