

General Instructions (cont.)

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, humps, 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.safetecap.com. To obtain warranty service, please call us toll free at 1-800-407-7024.

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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FRAME REPAIR KITS

We Make it Easy to Make it Safe!

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ART-136 Installation Instructions

Rear Upper Track Bar Bracket Jeep 1997-2006 Wrangler TJ

The SafeTCap® ART-136 is a replacement for the OEM rear axle track bar bracket on the Jeep Wrangler TJ. The bracket is made from 7 gauge HR PO steel, CNC cut, bent, and MIG welded in the USA. The hardware to remount the track bar is included with the bracket. To install this part you will have to disconnect the track bar. You will have to replace the track bar if it becomes necessary to cut the original due to a frozen torque bolt. To install the ART-136 you simply cut off the old mount and weld the new mount in the footprint of the old mount.

ATTENTION: The SafeTCap® ART-136 is designed as an OEM replacement and is not designed to be used on modified or lifted suspensions. When ordering this part you may also be interested in the SafeTCap® ART-146 for the other end of the track bar.

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.



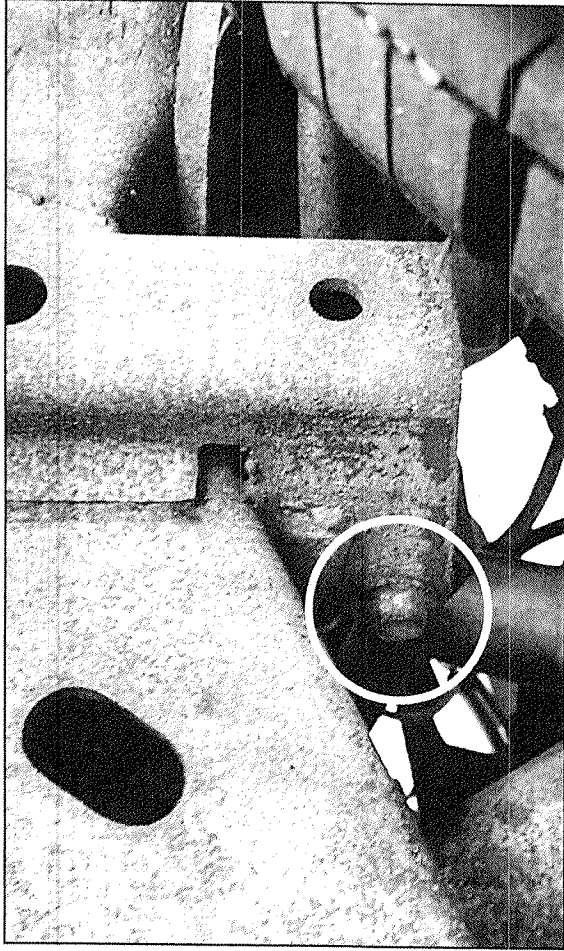
(Patent Pending)

1. **IMPORTANT:** Read and understand the "General Instructions for Installing SafeTCap® Frame Repair Kits" before you begin.
2. Jack rear tires off the ground. Chock front tires. Use jack stands placed directly on the frame forward of the lower trailing arm mount.
3. Remove rear tires.
4. Take measurements from the original track bar mount bracket to a reference point on the frame. This could be a body mount bracket, a bolt hole or a line drawn on the frame by the installer. These measurements will serve to locate the new ART-136 bracket.
5. Disconnect the track bar from the bracket. *If you can't remove the torque bolt, it may be easier to cut the track bar and replace it with a new one.*
6. Cut and remove the old mount.
7. Grind the area to be welded to bare metal.
8. Make location marks on the frame using the measurements from step 4.
9. Place the new ART-136 on the location marks and reattach the track bar temporarily.
10. If the fit is correct, tack weld the SafeTCap® ART-136 bracket to the TJ frame.
11. Remove track bar.
12. Weld bracket solid.
13. Paint or coat repair.
14. Reattach track bar.
15. Remount rear wheel and torque wheel nuts to factory ft. lbs. specifications.
16. Check repair after test drive, check repair, and bolt tightness frequently.

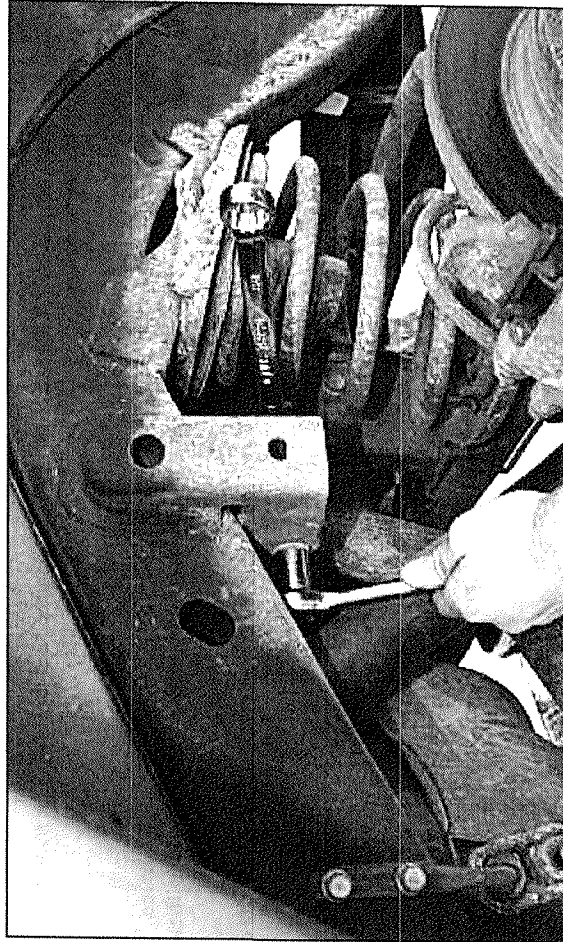


ART-136 Installation Instructions

Rear Upper Track Bar Bracket • 1997-2006 Wrangler TJ



Due to the location and high factory torque spec. this fastener can be extremely difficult to remove. Liberally apply penetrating oil to the track bar mounting bolt and nut in advance of its removal.



Remove the bolt and flag nut using a 21mm socket and/or wrenches, a breaker bar may come in handy. The SafeTCap® ART-136 kit comes with a new bolt and nut for reinstallation on the track bar bracket. Tighten the track bar bolt to 125 ft.-lbs. Reinstall the wheels and tighten the lug nuts to factory/wheel mfg. specifications. Remove the jack stands, lower the Jeep to the ground and you are good to go

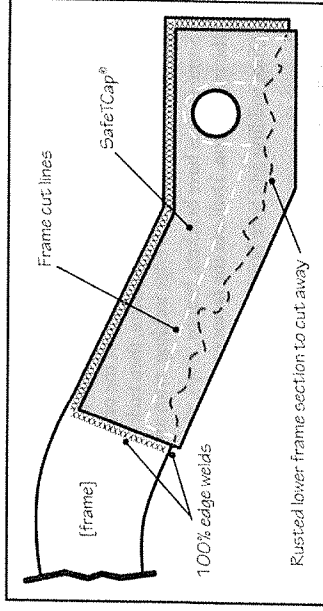
General Instructions for Installing SafeTCap® Frame Repair Kits

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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