

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 defects or malfunctions in your new SafeTCap® frame repair product, which has been manufactured from quality cold-rolled steel at our facility in Cranston, R.I., U.S.A.

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



FRAME REPAIR KITS

We Make it Easy to Make it Safe!

SafeTCap®

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www.safetecap.com

SafeTCap® products are Registered Trademark. Designs developed by Revision Automotive Corporation in response to hundreds of cars, jeeps and trucks that have required frame rot repairs. All kits/parts have been designed, manufactured, tested and installed in our Cranston, Rhode Island, USA facility - Auto Rust Technicians.

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.

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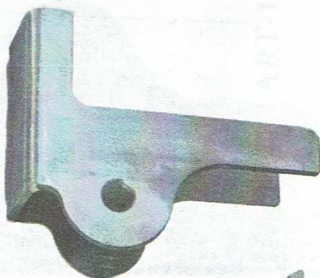
ART-141 • ART-141-HD • ART-147 Upper Rear Shock Mount Brackets 1999-2006 Silverado/Sierra 1500 • 2500HD



ART-147

ART-141

ART-141HD



SafeTCap® kits are the affordable DIY solution to serious frame rot issues. SafeTCap® kits maintain factory dimensions and mounting points, making your frame strong and safe again. Our repair kits are guaranteed to fit factory stock frames and are designed and manufactured in the USA.

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.

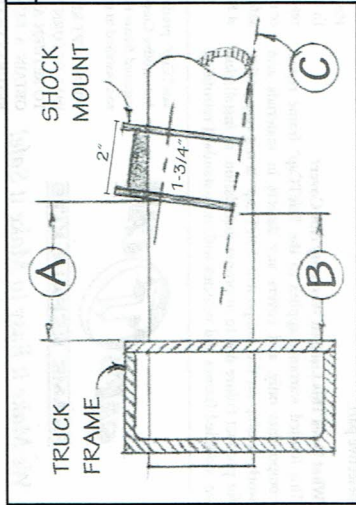
1. **IMPORTANT:** Read and understand the "General Instructions for Installing SafeTCap® Frame Repair Kits" before you begin.
 2. Jack the vehicle up by the frame; allow the rear axle to hang down so that the shocks are fully extended. Use jack stands for stability.
 3. Unbolt the shock at the old mount, (if still there).
 4. Before removing the old shock mount, take measurements as shown in the illustrations on page 2.
 5. Once the old shock mount has been removed, grind the area to be welded down to bare metal, being careful to preserve the location marks.
 6. Place the new shock mount into position.
 7. Next, tack weld the shock mount bracket in place and test fit the shocks bolt hole position.
 8. If the fit is acceptable, remove the shock and fully weld the shock mount to the crossmember.
 9. Recheck fit.
 10. Paint or coat repair.
 11. Reinstall shock absorber and tighten.
 12. Remove jack stands.
 13. Lower truck to the ground.
 14. Drive safe.

ART-141 / ART-141-HD / ART-147 Installation

Upper Rear Shock Mount Brackets

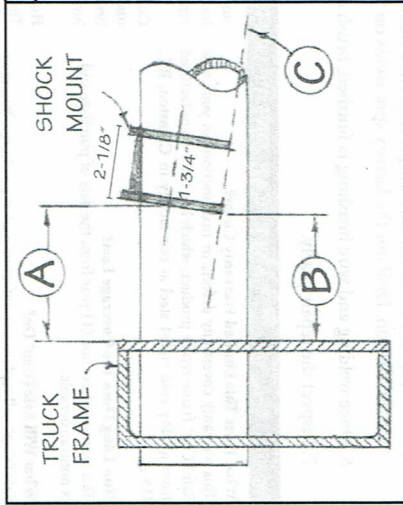
1999-2006 Silverado/Sierra 1500 • 2500HD

Measurements A, B, & C to be taken and used for location of new brackets



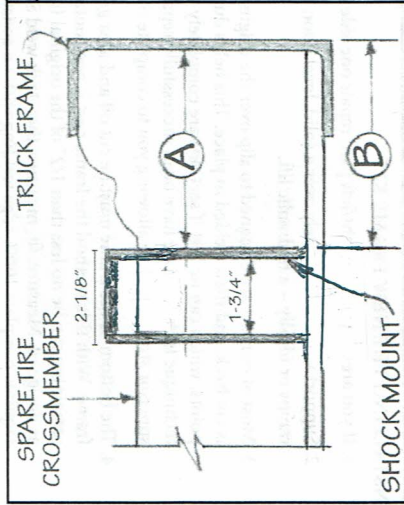
- ART-141**
FITS MODELS: 1500 & 2500 NON-HD
- (A) - BOLT HOLE CENTER TO FRAME
 - (B) - BOTTOM EDGE TO FRAME
 - (C) - BOTTOM ALIGNMENT

[View Position: Behind Crossmember]



- ART-141-HD**
FITS MODEL: 2500 HD
- (A) - BOLT HOLE CENTER TO FRAME
 - (B) - BOTTOM EDGE TO FRAME
 - (C) - BOTTOM ALIGNMENT

[View Position: Behind Crossmember]



- ART-147**
FITS MODEL: 2500 HD
- (A) - MEASURE FROM BOLT HOLE CENTER TO INSIDE OF FRAME
 - (B) - MEASURE FROM BOTTOM CONTACT POINT OF SHOCK MOUNT WITH SPARE TIRE CROSSMEMBER TO OUTSIDE SURFACE OF FRAME

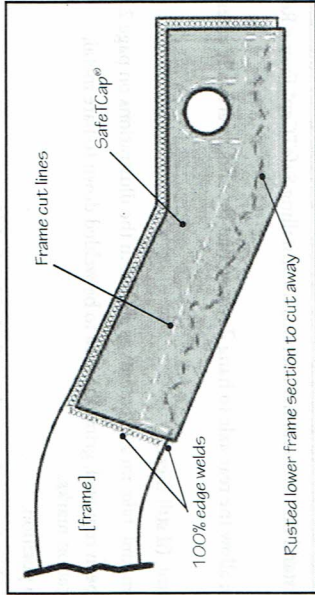
[View Position: Front of Crossmember]

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 (ER70S-6) 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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