ART-131 & ART-131-4 1997-2006 WRANGLER TJ FULL CENTER SECTION W/TRAILING ARM MOUNTS

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IMPORTANT: Read and understand the General Instructions
Before Installing SafeTCap® Frame Repair Kits
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Installation Instructions

1) Jack up all four corners of your Jeep and support it on quality jack stands. Make sure the center of the Jeep is fully accessible.

2) Remove the skid plate and put a secure stand under the transfer case and rear axle to support it.

3) Unbolt the upper and lower trailing arms and tuck them out of the way, keep the rear end straight.

TIP: to prevent the rear axle from springing backwards, we at Auto Rust Technicians use a ratchet strap attached to the rear axle and front wheel lower trailing arm mounting bracket.

4) Transfer a mark from one of the original transfer case skid plate bolt hole locations to the frame above where you are cutting. Use a heavy marker, or paint. You will want this for reference later during assembly, mark all three of the holes for total accuracy. Lastly measure the distance between hole centers of the front and rear trailing arm mounts, be very precise and save the dimension.

5) Cut away the rusted area.

6) Set the kit in place; roughly mark the area where you will be welding. After removing the kit cut and grind the areas clean where your marks are, taking it all down to bare, clean metal.
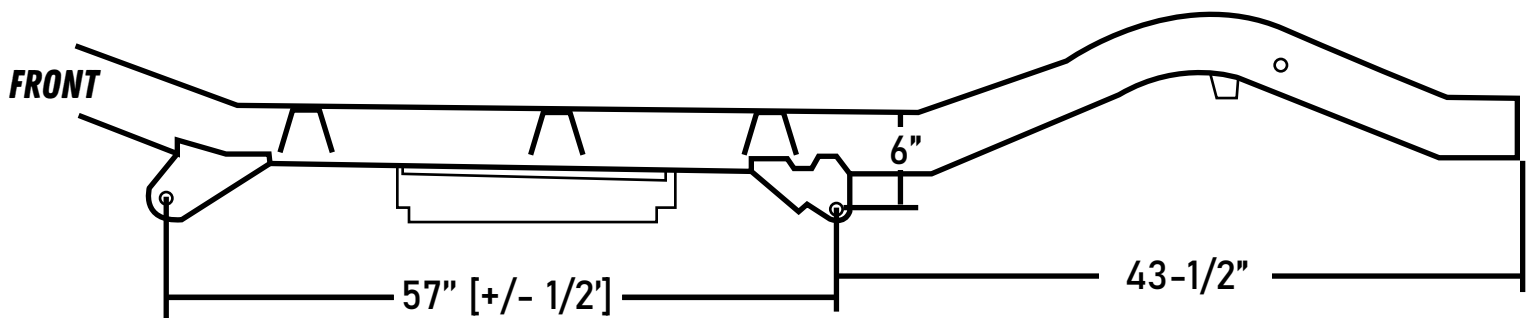
7) Slide kit over frame using measurements [see illustration – A] to position correctly. Use the included "Handi-Plates" above front trailing arm if required.

8) Make sure kit is in correct location. Double check your measurements and then tack weld . Final inspect your set up, then weld all edges 100% solid.

TIP: Use skid plate as check before welding.

9) Prime and paint the repaired area.

10) Mount and torque the trailing arm bolts to factory specs (55 ft lbs) and remount the skid plate unit using the bolts and washers provided.

FRONT

57" [+/- 1/2']

6"

43-1/2"

THESE ARE FACTORY STOCK TJ FRAME DIMENSIONS, THE EXACT LOCATION OF YOUR BODY AND TRAILING ARM MOUNTING HOLES MAY VARY SLIGHTLY.