



**ART-115**  
**1997-2006**  
**WRANGLER TJ**  
**REAR FRAME SECTION**

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

## Installation Instructions

- 1)** Support vehicle properly over a solid, level floor. Place jack on the frame ahead of the rear wheels.
- 2)** Remove gas tank skid plate.
- 3)** Un-attach fuel lines from gas tank and seal fuel lines. Remove gas tank and place away from work area.
- 4)** Cut away the bottom of the frame.
- 5)** Slide kit into place and mark outline onto frame.
- 6)** Grind the frame down to clean metal all along the marked outline of the frame repair kit.
- 7)** Place kit into position and tack weld in place.
- 8)** Weld all edges 100%. If you're installing additional frame repair kits, do not weld the ends yet.
- 9)** Rustproof the repaired area with rust inhibiting primer or undercoat.