

Installation Instructions

General automotive welding safety, metal preparation and Frame repair guidelines to achieve long lasting results – safely.

IMPORTANT: For your safety follow all instructions. **Failure to follow instruction** may result in property damage or serious fatal injury. User assumes all liability.

Vehicle Preparation

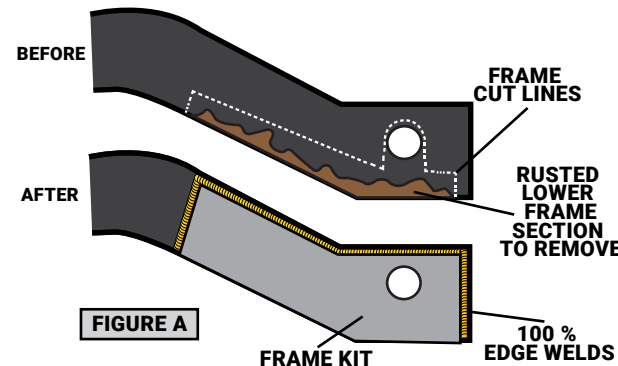
- 1) Disconnect the Battery.
- 2) Check for fuel leaks; tank / fuel lines / engine.
- 3) Replace or repair any leaks in the fuel system before proceeding any further.
- 4) Remove tank prior to install.
- 5) Keep flammable materials at least 20 feet from the vehicle.
- 6) Remove interior panels, seats, insulation padding and carpets in the cabin above work area.
- 7) Keep a fire extinguisher and water hose close by, use water for any fabric fires.
- 8) ALWAYS use a fire watch person when cutting or welding on a vehicle. Keep a cell phone nearby in case of an emergency call 911.

Welding & Safety

- 1) Always wear safety glasses and gloves.
- 2) "Stick" or "Arc" welding use 6011, 3/32 or 1/8 inch welding rods.
- 3) "MIG" we use 220v Mig Welders with .035 wire (ER70-S) with a 75% Argon/25% CO2 Shielding gas mixture.
- 4) Quality welds require clean surfaces.
- 5) Weld kit in place using 1/2 inch long beads every 3 inch, then weld seams solid.

Installing Your Frame Repair Kit

- 1) If you are installing a right/left Set, Make sure to repair one side at a time, keeping the other side intact for reference/measuring point.
- 2) Support the vehicle completely over a solid, level floor. Use good quality, weight-rated, safety jack stands or ramps.
- 3) Most of our SafeTCap® frame repair kits are designed to slip over the original frame from underneath and weld in place. This overlapping Safe-T-Cap® technique is the way we have been successfully repairing frames for over 47 years, providing superior strength.
- 4) The bottom of the frame must be cut off and area ground to clean metal. With this method the frame rust is removed and is not contaminating your new frame section. The minimum remaining can be no less than 1 inch of the original frame for the Safe-T-Cap® frame kit to overlap and perform as designed. Measure, fit, tack weld the SafeTCap® at key points, Then complete 100% edge welding. **See Figure A**
- 5) Some frames have brackets, bump stops, etc. which need to be cut off and reused in order to complete the installation, drill out spot welds on these parts for easy removal.
- 6) Once welding and wire brushing is finished, brush or spray primer, then paint or undercoating.



Equipment List

Hydraulic jack/ Jack Stands
Quick line disconnect(Fuel)
Eye & Ear Protection
Work Gloves
Fire Extinguisher & Water
Plasma Cutter or Torch
Grinder/ Sander/ Cutting Wheel
Locking Pliers/ Large Clamps
Welder: Mig or Stick
Paint & Undercoat



**CHECK OUT OUR
ebay STORE!**

If you're a licensed and insured automotive repair shop seeking installation referrals from SafeTCap, give us a call at 800-407-7024 or email us at office@autorust.com.



Need Help?



WWW.AutoRust.com



1800 407 7024



office@autorust.com



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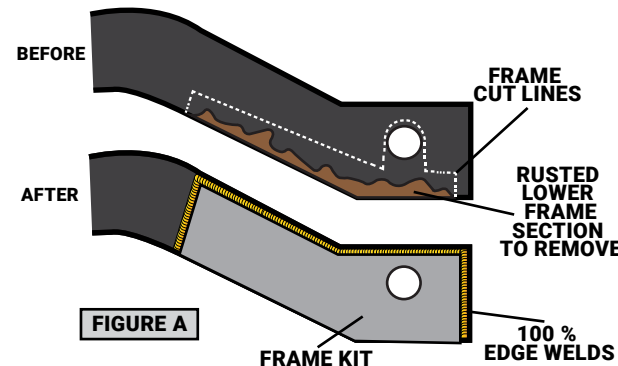
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