



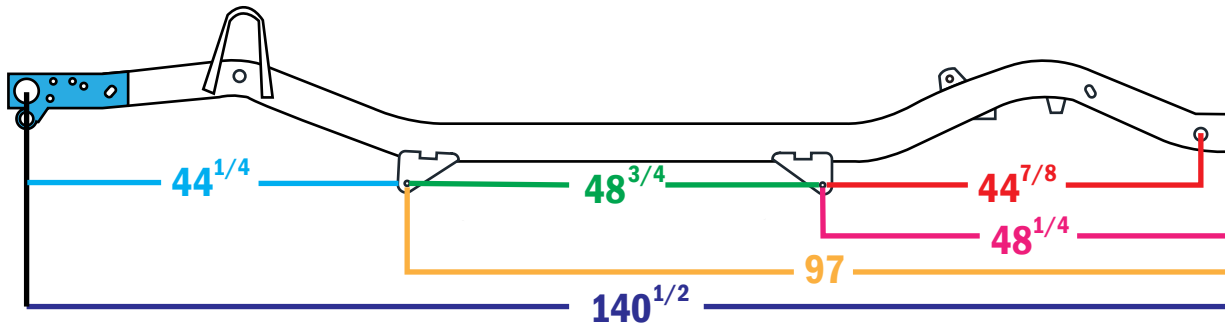
ART-102-R

**ART-102
ART-102EX
1987-1995
WRANGLER YJ
FRONT SHACKLE &
STEERING BOX MOUNT**

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

Installation Instructions

- 1)** Support the Jeep on a solid, level surface using heavy-duty jack stands. Support the Jeep by the frame so the suspension hangs freely—this will make it easier to lower the front leaf spring.
- 2)** Remove the front bumper and any body panels attached to the frame section being repaired.
- 3)** If repairing the driver-side frame rail, remove or unbolt the steering box and move it away from the work area. Lower the sway bar out of the way.
- 4)** Remove the bracket that connects under the frame to the steering box.
- 5)** Remove the front shackle bolt and mount bushing if you're not replacing them.
- 6)** Lower the front leaf spring out of the way to create a clear work area.



7) Take several reference measurements before cutting. The new section must be installed to match factory specs: 28-1/4" between frame rails and level frame bottoms. Factory diagrams show a 14" cut from the frame rail and 44-1/4" for leaf spring mount locations.

8) Brace the frame before cutting. Weld one brace laterally across the frame and another vertically to prevent any movement. If the engine is still installed, it will help keep the frame steady, but bracing is still necessary.

9) Cut the frame starting from the tubular radiator support, extending back 14", stopping just before the panhard bar bracket. One ear on the bracket will need to be removed to fit the kit. If rust extends beyond the kit area, you'll need to fabricate additional repair sections.

10) Cut carefully in sections to relieve pressure and help ensure a better fit. Remove all cut sections and grind down the factory welds near the radiator support. The tube will slide into the kit just like the factory frame section did.

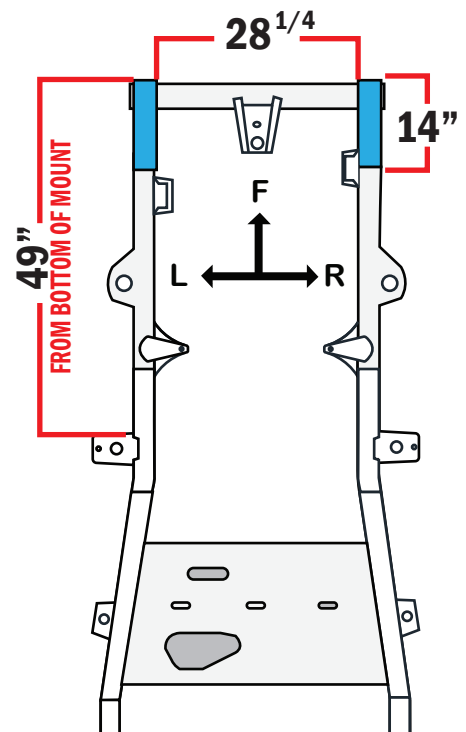
11) Clean all contact surfaces on the frame and the kit to prepare for fitment and welding.

12) Fit the kit in place, clamp it securely, and support it from underneath. Use a 4' level to ensure proper alignment, both vertically and horizontally.

13) Measure the distance between the new frame rail and the opposite side. It must be exactly 28-1/4". Take your time and adjust the kit as needed. Once measurements are verified, tack weld the kit in place. Double-check measurements before proceeding.

14) Once the kit is correctly positioned, weld all contact points. Avoid overheating by running 1-2" beads at a time and alternating areas. Focus on achieving strong, smooth welds. This is the most critical part of the installation.

15) Reinstall the leaf spring, steering box, panhard bar, and any other frame-mounted components. Rustproof the repaired area with a rust inhibiting primer or undercoat.



**DRIVER SIDE
ART-102-L**

**DO NOT CUT AWAY
PANHARD BAR
MOUNTING BRACKET**

**CAREFULLY CUT AROUND
RADIATOR SUPPORT TUBE**

**REMOVE AND REUSE
LOWER STEERING BOX MOUNT BRACKET**

**CUT FRAME HERE
EXACTLY 14" FROM END**