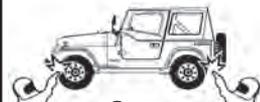


# ART-124 Installation Instructions

## Rear Trailing Arm Mount Frame Kit



1997-2006 Wrangler TJ



www.SafeTCap.com

We Make it Easy to Make it Safe!



FRAME REPAIR KITS



ART-124-L  
ART-124-R

This patented Safe-T-Cap™ kit is designed to slip over the stock frame providing you with the affordable DIY solution to serious frame rot issues. Safe-T-Cap™ kits maintain factory dimensions and mounting points while bringing your frame back to a strong, safe and secure state with new, mig-welded steel. Safe-T-Cap™ frame 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 Safe-T-Cap™ installation.

1. IMPORTANT: Read and understand the “General Instructions for Installing Safe-T-Cap™ Frame Repair Kits” before you begin.
2. Jack up all four corners of your Jeep and support it safely on four quality jack stands. Add two more under the rear bumper/crossmember if possible. (Skip this step if you are working on a lift)
3. Remove both rear wheels.
4. Using a floor jack, support the rear axle assembly. Place jack under differential housing.
5. Unbolt and remove the upper and lower trail arms. Repair one side at a time, this will keep rear end in the factory correct position and not allow it to twist... *safety first.*
6. Allow a minimum of one-inch overlap. [See illustration – B]
7. Cut away the rusted area using a plasma cutter, reciprocating saw, or a torch. [See illustration – B]
8. Set the kit in place; roughly mark the area you will be welding, then remove kit.
9. Grind the areas clean where your marks are, and grind down to clean metal.
10. Slide kit over frame using measurements from illustration A to position it correctly.
11. Make sure kit is in correct location. Double check your measurements; from the forward trailing arm mount to the NEW rear lower trailing arm mount is 57". Measure and tack it in place. Final inspect your set up, then weld all edges solid. [See illustration – C]
12. Prime and paint the repaired area.
13. Install upper and lower trailing arms using supplied bolts and use Loctite® or equivalent on all nuts.
14. Double check that all your welds are solid. Make sure all the trailing arm bolts are tightened. Visually inspect that the repaired area is safe and solid.
15. Mount wheels, lower Jeep and test drive.
16. Inspect after one day or one mile, then monthly.

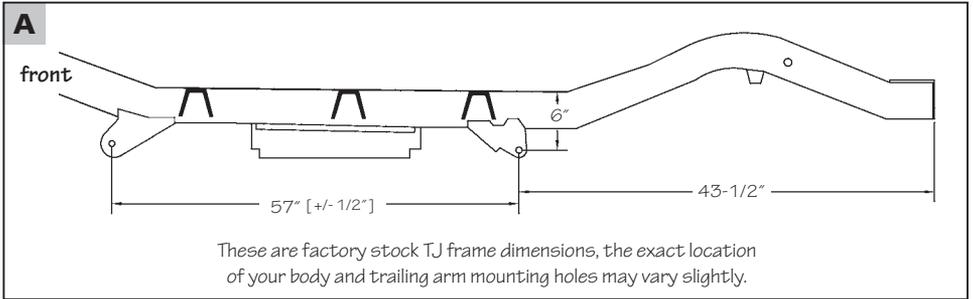
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# ART-124 Installation Instructions

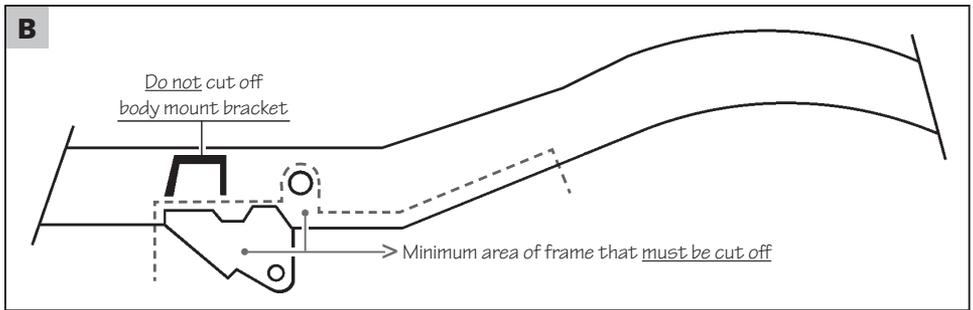
## Rear Trailing Arm Mount Frame Kit



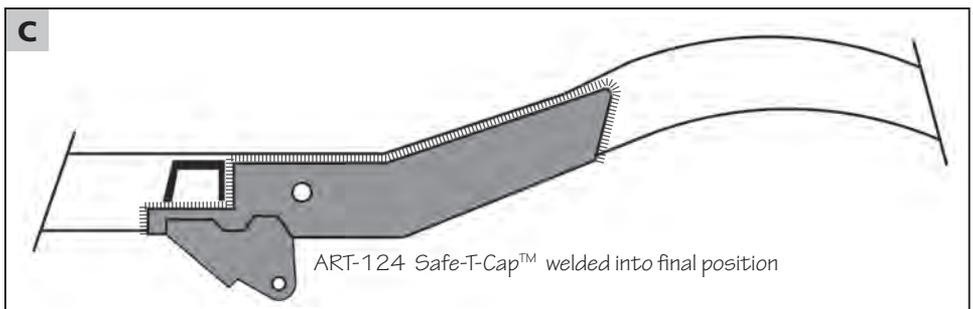
1997-2006 Wrangler TJ



Start by measuring the distance between holes centers of the front and rear trailing arm mounts, be as accurate as possible and record for exact fit. These measurements are key for factory correct alignment of your new Safe-T-Cap™ and proper suspension performance.



Use your new Safe-T-Cap™ as a guide and marker or chalk out a basic fit placement, then cut out frame 1" below the reference lines. Grind the remaining area clean and position the Safe-T-Cap™ in place with measurements referenced in illustration A.



Fit the Safe-T-Cap™ tight up into frame. Measure again and tack weld the corners. Once satisfied with final position and appearance, weld all edges 100% solid. Move your welds around to avoid possible overheating.

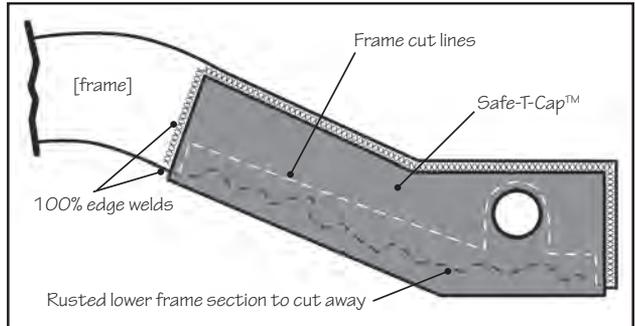
# General Instructions for Installing Safe-T-Cap™ Frame Repair Kits

*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 (E7056) 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.

> continued on page 4

# 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 weld in place. This helps duplicate the original dimensions, and location points, which can be lost if sections are completely removed. This overlapping Safe-T-Cap™ technique is the way we have been successfully repairing frames for over 38 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" of the original frame for the Safe-T-Cap™ kit to overlap and perform as designed. Measure, fit, measure, then tack weld Safe-T-Cap™ at key points, the final installation requires complete 100% edge welding.
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.

## SAFE-T-CAP™ ONE YEAR LIMITED WARRANTY

### What Does This Limited Warranty Cover?

This warranty covers any defects or malfunctions in your new Safe-T-Cap™ 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 Safe-T-Cap™ Do?

Safe-T-Cap™ 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 Safe-T-Cap™ frame repair components only, and covers any defects in materials and workmanship on the component. Safe-T-Cap™ is not responsible for product failure due to improper installation, or installation on modified frames and vehicles with non-standard

retrofitted suspensions. Safe-T-Cap™ is not responsible for the quality of the installation, or for any issues that may arise beyond the scope of repair for which the part was intended.

Consequential and incidental damages are not recoverable under this warranty. Some states do not allow the exclusion or limitation of incidental or consequential damages, so the above limitation or exclusion may not apply to you.

### How Does State Law Apply?

This warranty gives you specific legal rights; you may also have other rights which vary from state to state.

### How Do You Get Warranty Service?

In order to be eligible for service under this warranty, you must return the Safe-T-Cap™ registration card provided, within 30 days of receipt. You may also register your Safe-T-Cap™ online @ [www.safetecap.com](http://www.safetecap.com). To obtain warranty service, please call us toll free @ 800-407-7024.



**FRAME REPAIR KITS**

*We Make it Easy to Make it Safe!*

Safe-T-Cap™

1550 Elmwood Ave.

Cranston, Rhode Island 02910

(401) 944-4444 (800) 407-7024

[www.safetecap.com](http://www.safetecap.com)

(USA)

Safe-T-Cap™ 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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