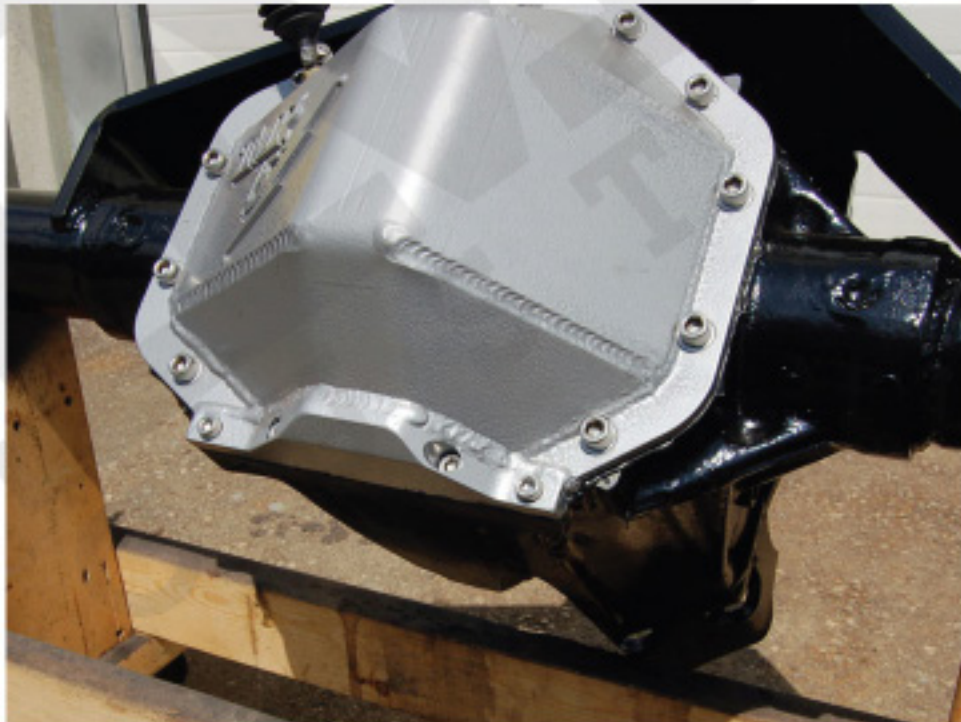


# **TMR**

**C U S T O M S**

## **15 BOLT CONVERSION**

**FITS GM/CORPORATE 14 BOLT AXLE WITH 10.5" RING GEAR  
& 6 BOLT REMOVABLE PINION SUPPORT**



**Serial #** \_\_\_\_\_

**INSTRUCTION MANUAL 1.1 page 1/6**

## **READ AND CLEARLY UNDERSTAND ALL INSTRUCTIONS BEFORE STARTING!**

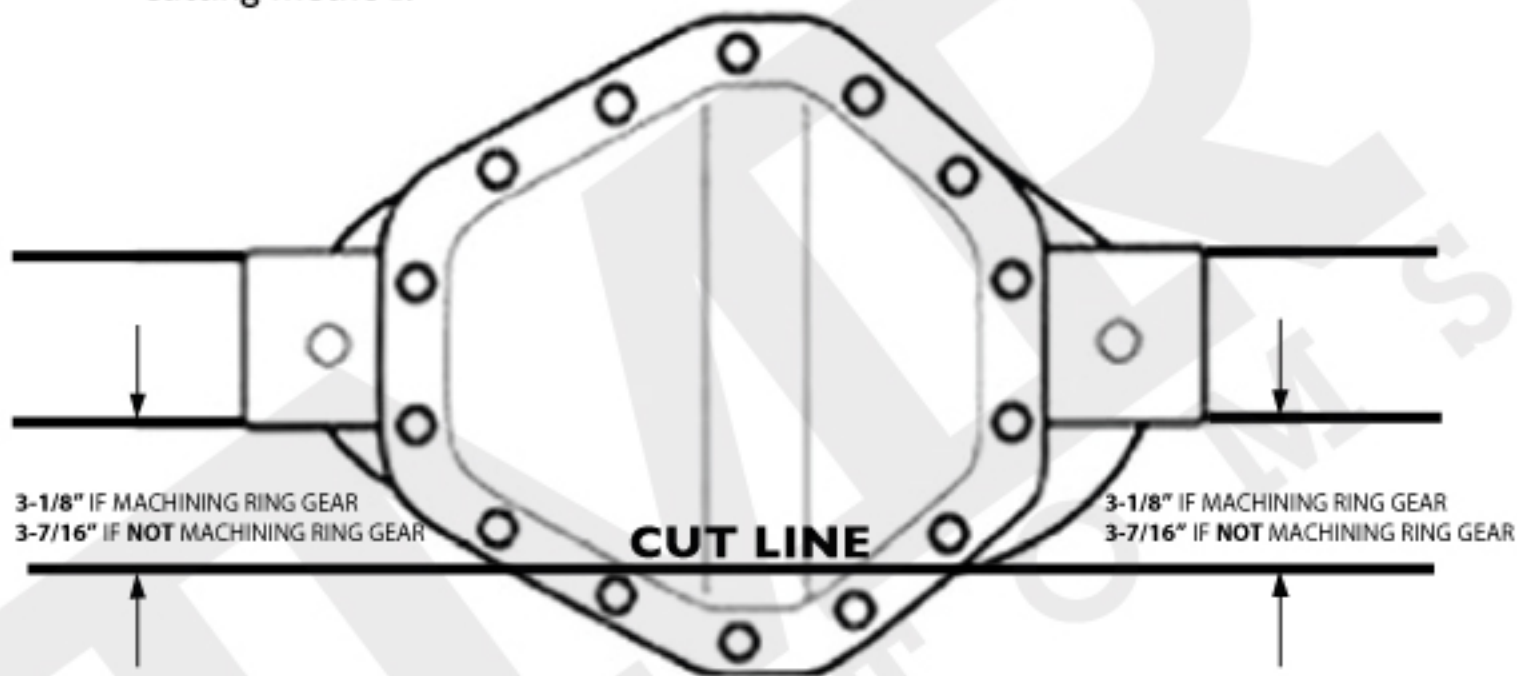
Step 1 : Drain gear oil from the housing into appropriate container.

Step 2: Remove the differential cover from the housing.

Step 3: Remove the carrier, pinion gear and all bearings from the housing.

Step 4: If machining ring gear - disassemble the ring gear from the carrier and set aside. If not machining ring gear skip step 4.

Step 5: Make your initial cut at 6 degrees past horizontal using your preferred cutting method.



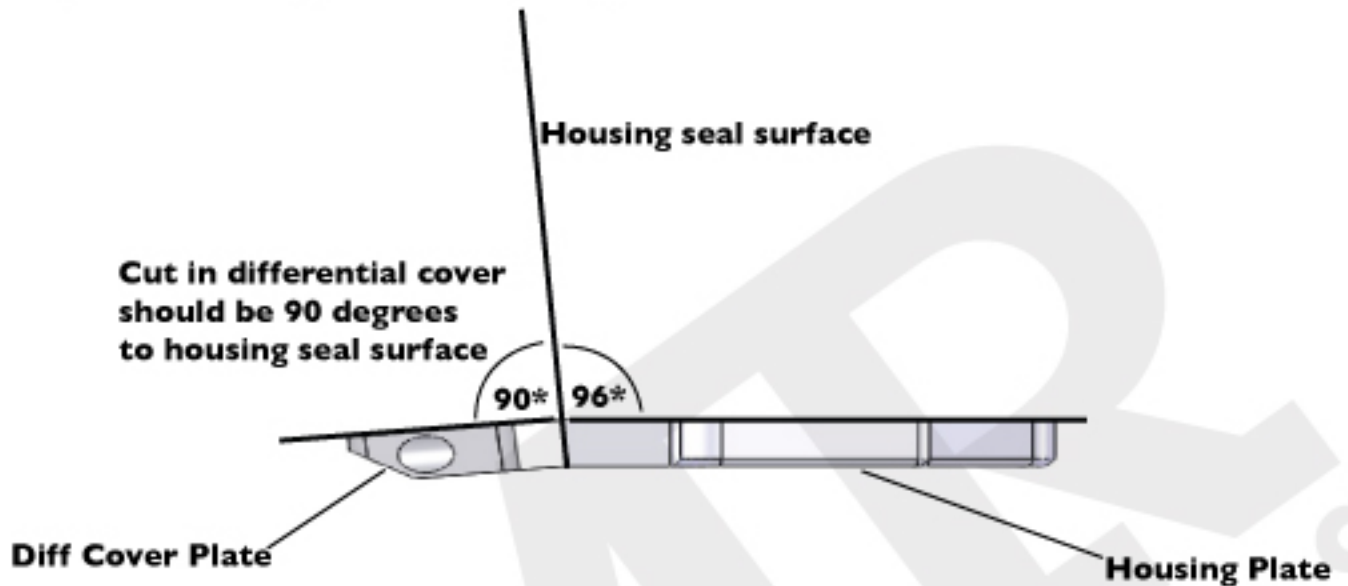
Final cut height must measure 3/16\" from housing cut to top of ring gear



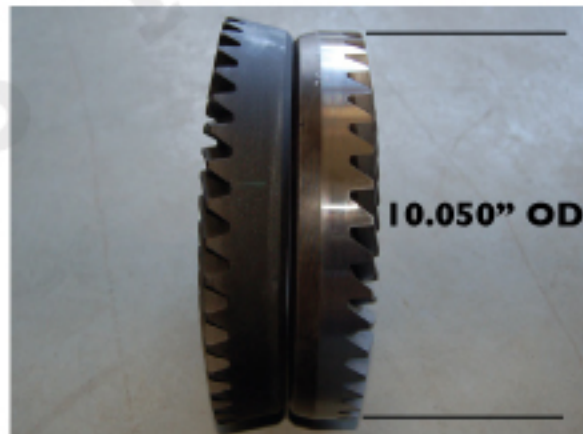
Final cut height must measure 3-1/8\" from cut to top of axle tube if machining ring gear.

Final cut height must measure 3-7/16\" from cut to top of axle tube if not machining ring gear.

Step 6: Bolt the differential cover to the housing and cut the differential cover down at 90 degrees to the housing so the height of the diff cover matches up evenly with the height of the housing.



Step 7: If machining ring gear - turn the ring gear down to 10.050" in diameter via your preferred cutting method. If not machining ring gear skip step 7.





Step 8: Install the ring gear, carrier and bearings into the housing.

Step 9: Install the modified differential cover onto the modified housing.



Step 10: Bolt together the supplied diff & housing shave plates together using the supplied fasteners.

Step 11: Place the shave plates onto the differential cover/housing and align the mating surfaces. Tack weld the shave plates to the diff housing and diff cover.



Step 12: Check for any clearance issues and modify housing/differential cover/shave plates if required.

Step 13: Remove the ring gear, carrier and bearings from the housing.

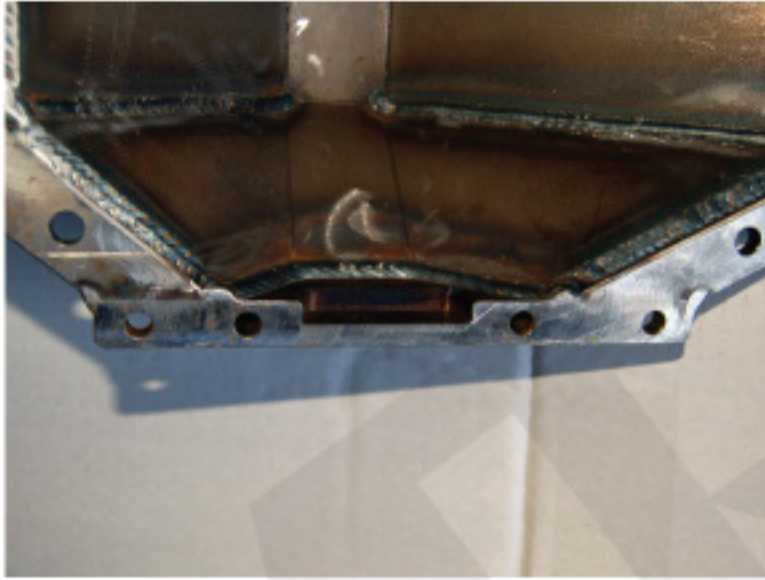
Step 14: Preheat the housing and bottom housing plate until it reaches approximately 400 Degrees.

Step 15: Fully weld the bottom housing plate to the housing on the inside first via your preferred method. We have had excellent results using ER70 MIG wire.

Step 16: Fully weld the bottom housing plate on the outside of the housing.

Step 17: Wrap the housing in an appropriate welding blanket or submerge in sand and allow the housing to slowly cool down overnight.

Step 18: Fully weld the bottom diff cover plate to the modified diff cover both inside and out.



Step 19: Tack weld the optional TMR 15 BOLT logo plates to the differential cover.

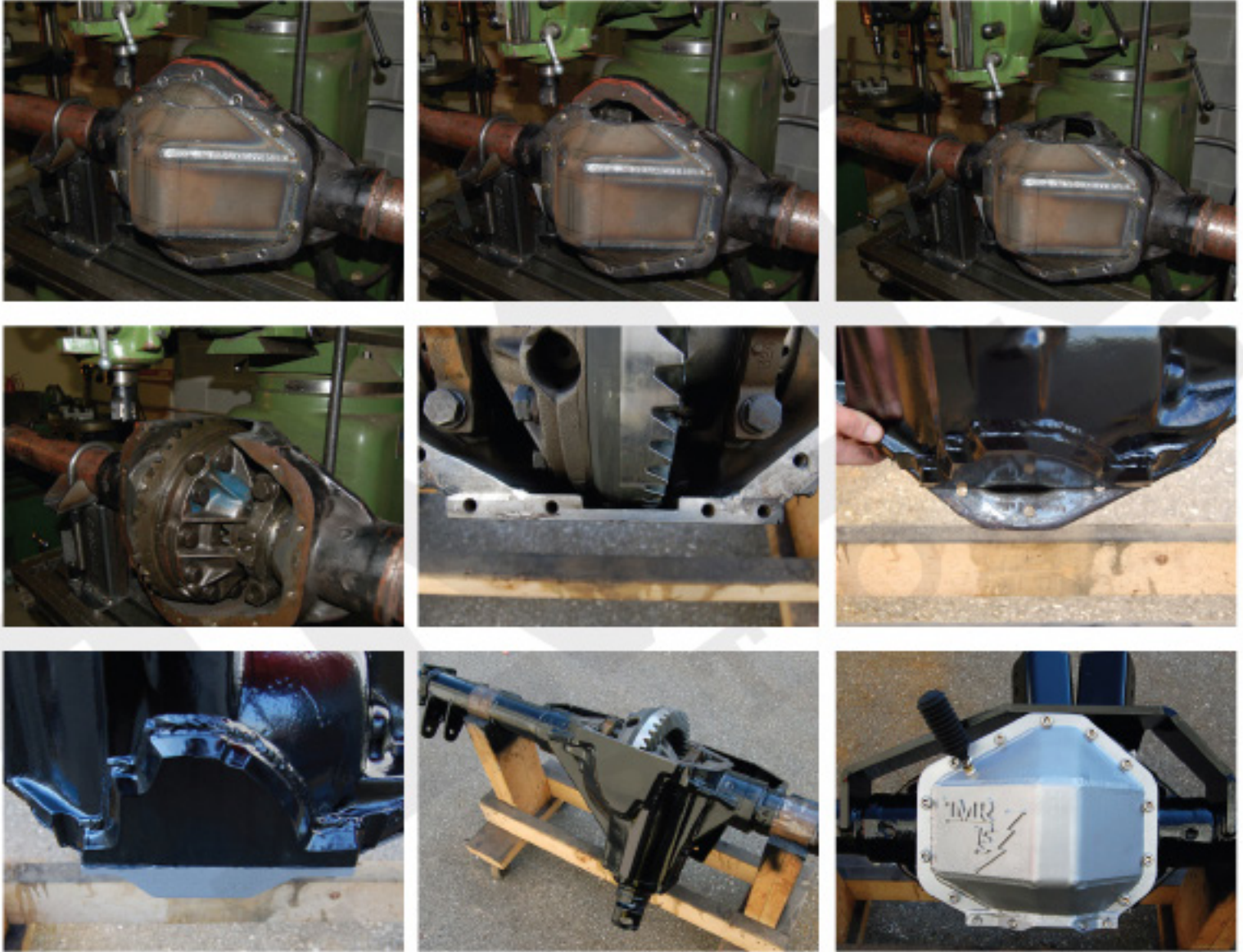


Step 20: Properly install the gear set via manufacturers specifications.

Step 21: Seal the housing using Permatex "Right Stuff" Gasket Maker and torque cover bolts to factory specifications, paint outside of housing & diff cover, fill with gear oil.



# ADDITIONAL PHOTOS



**TMR CUSTOMS 15 BOLT CONVERSION IS  
INTENDED FOR OFFROAD USE ONLY!**

**INSTRUCTION MANUAL 1.1 page 6/6**



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