2005-up Ford Super Duty Dana 60 Low Profile Axle Truss Installation Instructions:

Thank you for purchasing our Low Profile Axle Truss!

Installation Notes:

- This truss requires the removal of all factory brackets on the axle.
- Trimming of the center casting of the axle is required, and trimming of the inner c's may be required.

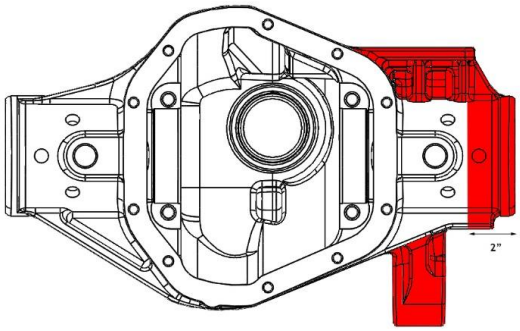
Tools Required:

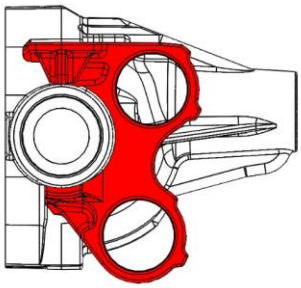
- Welding machine with the capability to weld at least 5/16" thick steel.
- Cutting torch, plasma cutter, or other appropriate cutting tool
- Tape measure

Step 1:

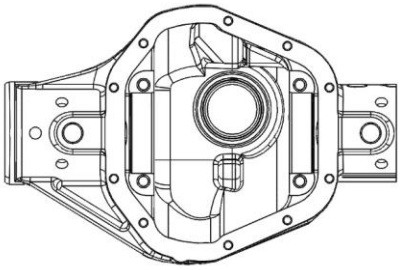
2005-Up Axles

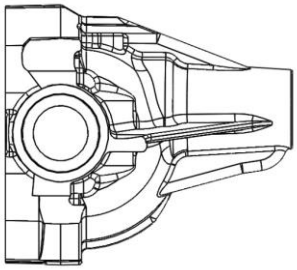
The casting on the Dana 60 axle will need to be trimmed. The cast section of the radius arm bracket on the driver's side will need to be removed, as well as a short section of the casting where the tube enters the center section. See images below for the areas to trim. The end of the casting where the driver tube enters the center section will need to be trimmed back 2". After trimming the casting grind all edges smooth.





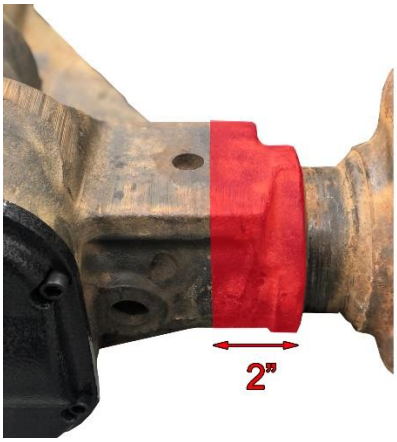
Your axle center section should look like the images below after trimming and grinding.





1999-2004 Axles

The casting on the driver's side short axle tube will need to be trimmed back 2". Additional trimming may be required on the webbing to provide clearance for the shock bracket.

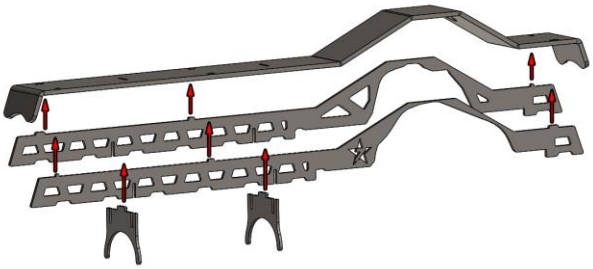


Step 2:

Remove any other factory bracketry on the axle. After removal is complete your axle should look like the image below.

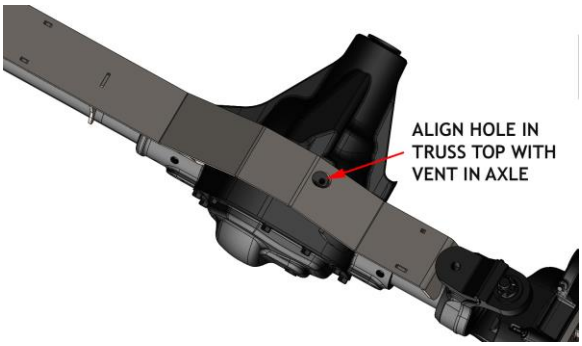
Step 3:

Assemble the components of the axle truss. The truss is designed so that it can only be assembled in one orientation. Place the side plates in the slots in the truss top and place both uprights in the slots on the side plates. Place tack welds in several spots to hold the assembly together.



Step 4:

Place the assembly from step 3 on the axle. Some trimming of the casting on the inner c's may be required for clearance to place the truss on the axle. Rotate the truss around the axle until the hole in the truss top lines up with the vent in the top of the axle housing. Measure from the inner c's to the ends of the axle truss, move the truss until these two measurements are equal. After the truss is located weld the truss in place. It is not necessary to weld all seams completely, make small staggered welds, and do not concentrate heat in one area any more than necessary.



Congratulations, you have completed the installation of your new low profile truss!