



36" Single Shock Trailing Arms Installation Instructions

Thank you for purchasing our 36" Single Shock Trailing Arms!

Installation Notes:

- These trailing arms require extensive amount of welding.
- Lay out all the parts you received and make sure you have everything that is listed below.

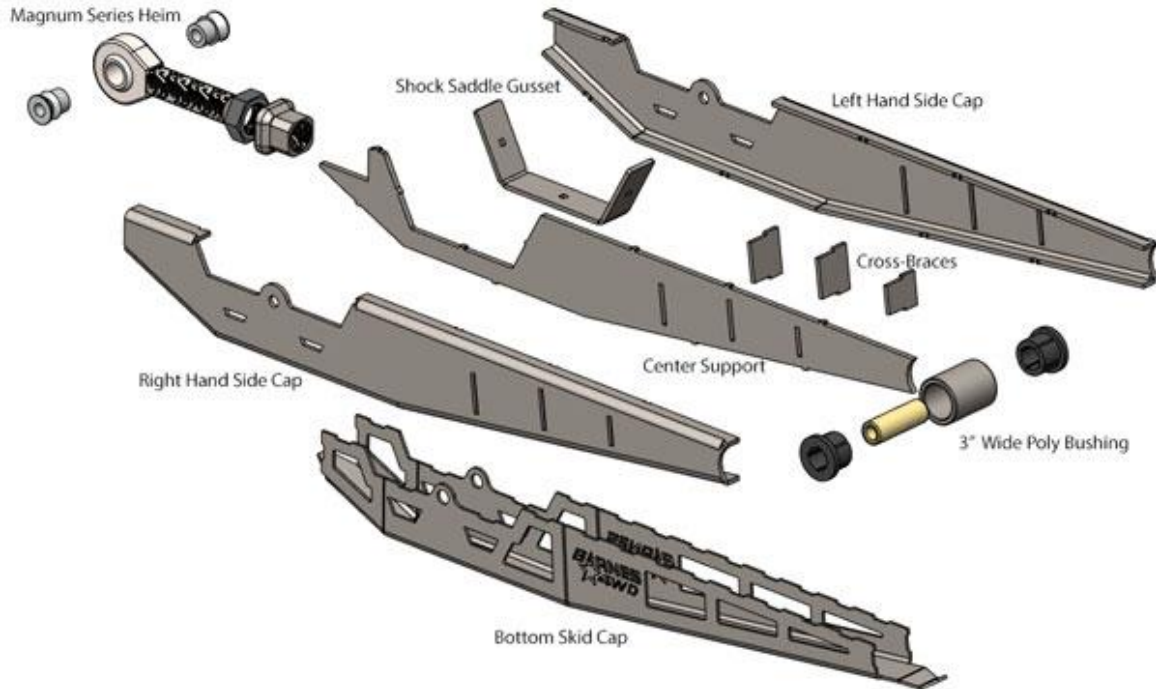
Tools required:

- Welding machine that has the capability to weld up to 1/4" thick steel
- Various Clamps
- Grinder
- Magnetic Right Angle or Square
- Hammer

Contents of each box

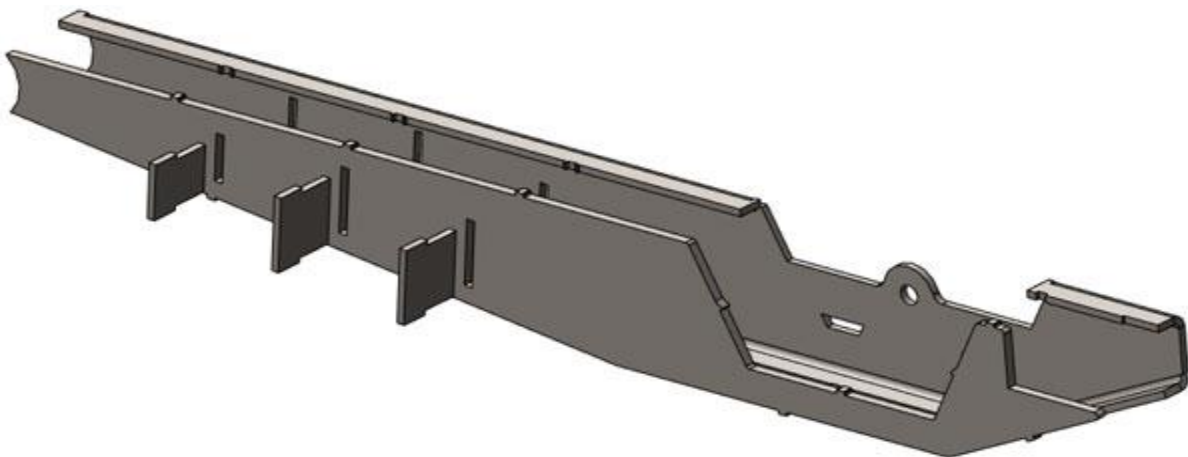
Bill Of Materials for B4WK12703 36" Single Shock Trailing Arm			
QTY	Part Number	Etch Number	Description
2	B4W188948	948 B	Left Hand Side Cap
2	B4W188949	949 B	Right Hand Side Cap
2	B4W188950	950 B	Shock Saddle Gusset
4	B4W188951	951	Big Cross Brace
2	B4W188952	952	Small Cross Brace
2	B4W250924	924	Center Support Plate
2	B4W125118	118 B	Bottom Skid Cap
2	50C325HCS8Y	N/A	1/2"-13 x 3.25" Bolt
4	50NWSAFY	N/A	1/2" SAE Washer
2	50CNNEOY/GC	N/A	1/2"-13 Nylock Nut

***Depending on the kit you bought, you will be receiving (2) 3" wide poly bushings and 2 Magnum series heims with 2 jam nuts, 2 square tube inserts, and 2 pairs of high misalignment spacers.**



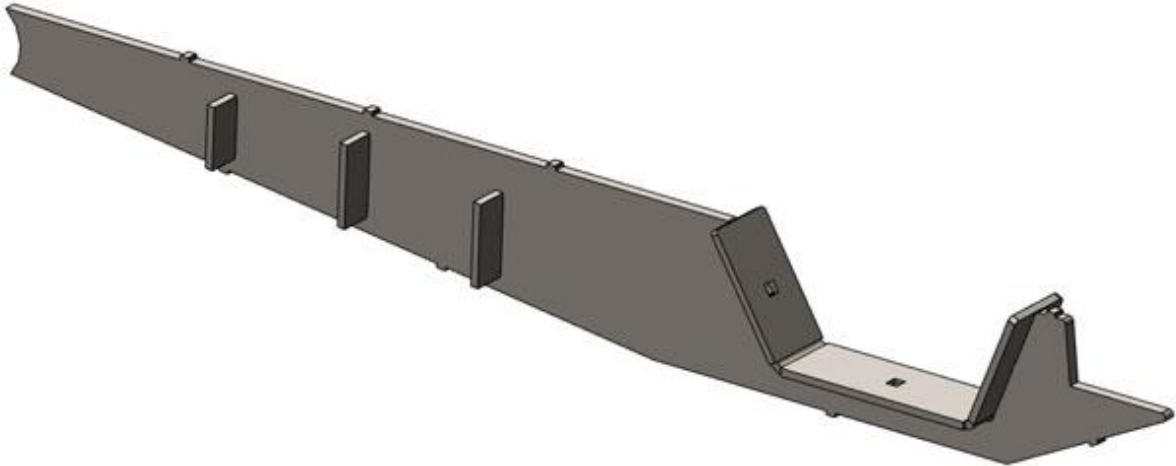
Step 1:

Lay the right-hand side cap on a flat surface and place the center support plate within the side cap. Take the cross-bracing tabs and place them in their corresponding slots through the center support plate and into the side cap. Using a magnetic right angle or square, tack each tab to the center support plate. Take the left-hand side cap and place it on top of the center support plate to make sure the cross-bracing tabs lineup within their corresponding slots and the side caps come together completely. The cross-braces can be fully welded to the center support if desired, just make sure the tabs stay straight.



Step 2:

Take the shock valley gusset and place it within the cutout in the center support plate. Key the bent plate into one of the tabs and slightly tap the other side to make it key into the center support plate. Tack the shock support in place. The holes for the tabs can be filled and ground smooth now if desired.



Step 3:

With the cross-braces and shock valley gusset welded in place, take the center support section and place it into the right-side cap. Take the left side cap and place on top of the center support plate, making sure the cross braces lineup into their corresponding slots and the two halves come together completely. Use a spacer to set the shock width and clamp the two halves together to hold the trailing arm in the designated width.



Step 4:

Check to make sure the square tube insert fits in its designated spot and tack the two halves together in various spots where the two caps come together.

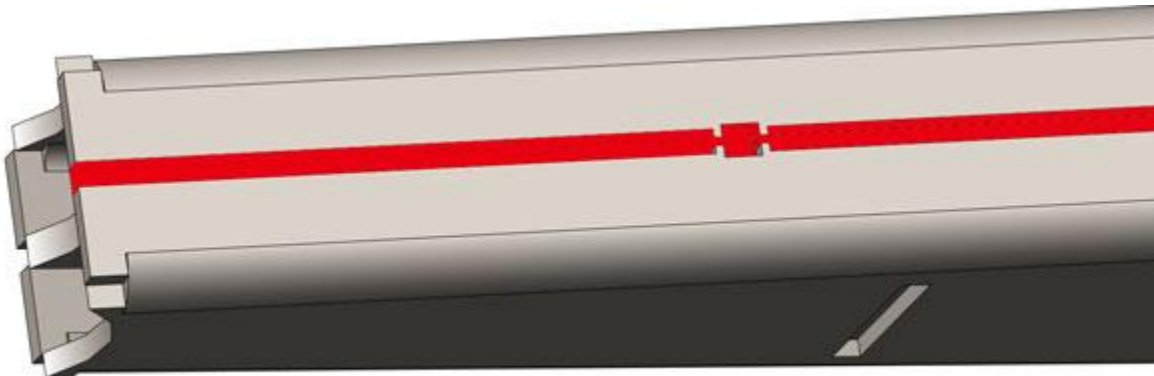
Step 5:

With the trailing arm tacked together, start welding the cross-bracing slots on each side of the arms. Alternating sides should help minimize warpage.



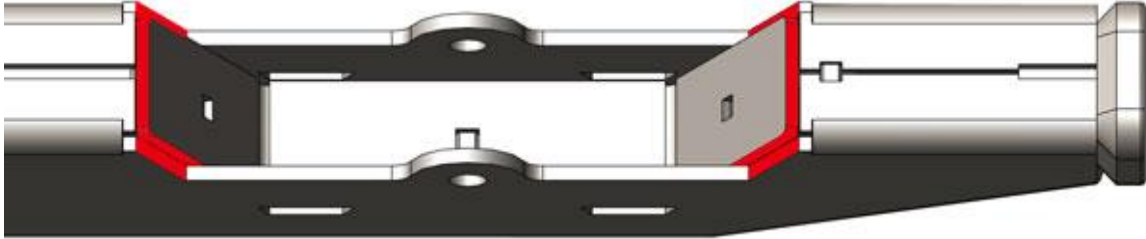
Step 6:

You can now start welding the gap in the middle of the arm. Alternate between the three seams and make small runs to help minimize the heat being penetrated in one certain area. Make sure you are penetrating the center support plate and the two side caps at the same time. When welding the small seam on the top side, go ahead and weld the square tube insert in place.



Step 7:

Fully weld up the shock valley gusset now. Fully weld around the top of the gusset on each side cap and you can stitch weld around the inside of the gusset.



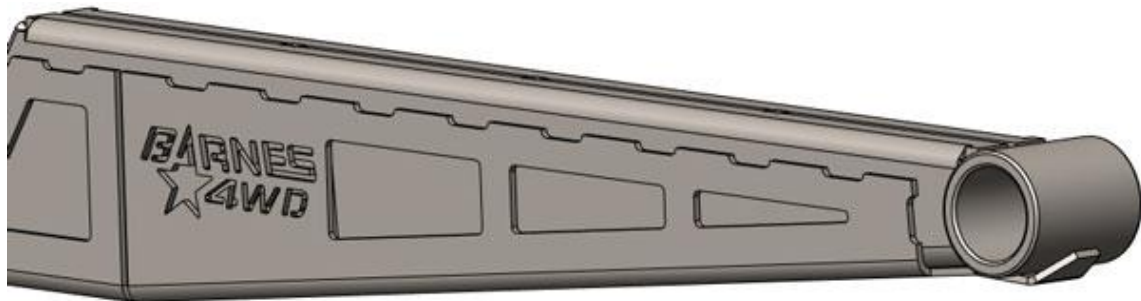
Step 8:

Now you can slide the skid onto the trailing arm. You might have to grind down the welds for the cross-bracing slots and the very bottom seam. Make sure the shock mount holes lineup and the drain holes are not being blocked.



Step 9:

Stitch weld the skid to the trailing arm around the edges. Place the outer sleeve to the poly bushing in the center of the trailing arm and weld it to the side caps and skid.



Step 10:

Paint or powder coat the trailing arm. Assemble the poly bushing and heim joint and mount the trailing arm.



**Congratulations you have completed the installation of your
36" Single Shock Trailing Arm!**

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