



## SD D60 8x6.5" Pattern Drill Jig Installation Instructions

Thank you for purchasing our SD D60 8x6.5 Pattern Drill Jig!

### Installation Notes:

- This kit is designed to be used on 2005-up Ford Superduty Dana 60 axles to convert your lug pattern to 8x6.5"
- The brake rotor holes can be enlarged to 13/16" to fit over the new lug pattern. The rotor is hub centric and will center itself during installation
- While the unit bearing can be drilled by hand, we highly recommend drilling on a milling machine or drill press
- The original wheel studs can be reused, or new studs installed
- On some unit bearings some material will need to be removed from the body of the unit bearing to gain clearance to install the wheel studs in their new location

### Tools required:

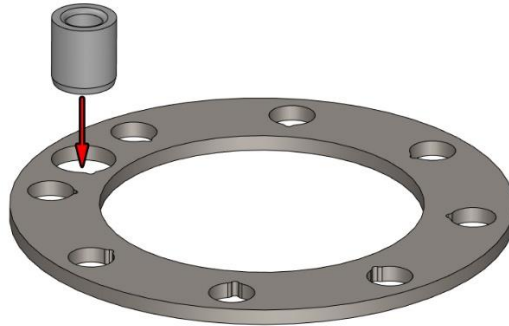
- 19/32 drill bit
- 13/16" drill bit
- Drill motor, drill press, or milling machine
- Shop press

## Contents of kit

Bill Of Materials			
QTY	Part Number	Etch Number	Description
1	3671N18	NA	Press-Fit Drill Bushing 0.600 ID, 1" OD, 7/8 Long 19/32 Drill
1	B4W250528X	528X	SD 60 8-6.5" Lug Pattern Jig
2	B4W188906	906	SD 60 Drill Jig Spacer
4	KSPM14X1.5	NA	M14-1.5 Open End Lug Nut

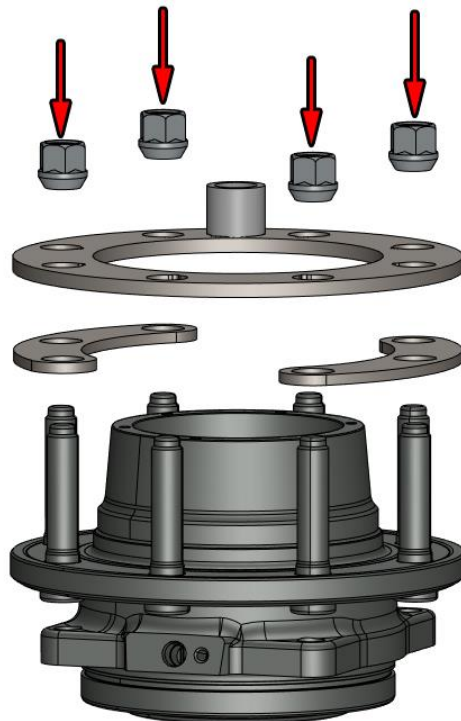
### Step 1:

Press the provided drill busing into the large hole on the lug pattern jig until flush with the opposite side.



### Step 2:

Assemble the components of the jig onto the unit bearing. Take care to install the spacers under the lug nuts to avoid warping the jig. Tighten the lug nuts to secure the jig on the unit bearing, do not overtighten lug nuts or damage to the jig or the nuts may occur and affect accuracy.



### **Step 3:**

Insert the 19/32" drill bit into the drill bushing and drill the first hole. We recommend a low RPM and a quality cutting oil.

### **Step 4:**

Disassemble the jig and index all components to the next location and repeat until all 8 holes are drilled.

### **Step 5:**

Press out the original studs and press them into the newly drilled holes. Some unit bearings may require clearance to be ground or machined in the body to allow the studs to be pressed.

### **Step 6:**

The stud holes in the brake rotor now need to be enlarged to 13/16" to allow the brake rotor to fit over the new lug pattern. The rotor is hub centric and will center itself on the unit bearing with the enlarged holes.

**Congratulations you have completed converting you unit bearing to 8x6.5 lug pattern!**

#### Professional Services Disclaimer:

The content of all pages of this website (collectively, the "Website"), such as text, graphics, images, information and other material (collectively, "Content") is for informational purposes only. Any information furnished on this Website is not intended nor implied to be automotive advice and is not intended to replace personal consultation with a qualified automotive service technician, mechanic, or similar automotive professional.

Barnes 4WD has not examined the Content for accuracy, timeliness, completeness, appropriateness, or helpfulness. Barnes 4WD does not endorse any specific tests, products, procedures, opinions, or other information that may be mentioned on this Website. Your reliance upon information and Content obtained by you at or through this Website is solely at your own risk. IN NO EVENT SHALL BARNES 4WD BE LIABLE OR OTHERWISE RESPONSIBLE FOR ANY DAMAGE OR INJURY (INCLUDING DEATH) TO YOU, OTHER PERSONS, OR PROPERTY ARISING FROM ANY USE OF ANY PRODUCT, INFORMATION, IDEA, OR INSTRUCTION CONTAINED IN THE CONTENT.

BARNES 4WD DOES NOT MAKE ANY REPRESENTATION OR WARRANTY, EXPRESS OR IMPLIED, AT LAW OR IN EQUITY, WITH RESPECT TO ANY PRODUCT FEATURED ON THE WEBSITE, INCLUDING WITHOUT LIMITATION WITH RESPECT TO MERCHANTABILITY, FITNESS FOR ANY PARTICULAR PURPOSE, VALUE, VALIDITY, OR ENFORCEABILITY, AND ANY AND ALL SUCH OTHER REPRESENTATIONS OR WARRANTIES ARE HEREBY EXPRESSLY DISCLAIMED.