

JK 14 Bolt Swap Tone Rings

Thank you for purchasing Barnes 4WD JK 14 Bolt Swap Tone Rings

Installation Notes:

- Refer to your factory service manual for information regarding the removal of any factory components.
- This product is designed to fit 2007-2018 Jeep Wrangler JK and Jeep Wrangler JKU with a 14 Bolt 1999-2006 GM single rear wheel with disk brakes.
- It is important to know which tone rings will be needed depending on what front axle you are using 1999-Present Super Duty axles will have a 60 tooth tone ring. Factory JK or aftermarket JK axles will have a 52 tooth tone ring.
- The 14 Bolt Hubs will have to be machined down to accept the tone rings.
- Brackets and Tone rings should be painted before installation

Tools Required:

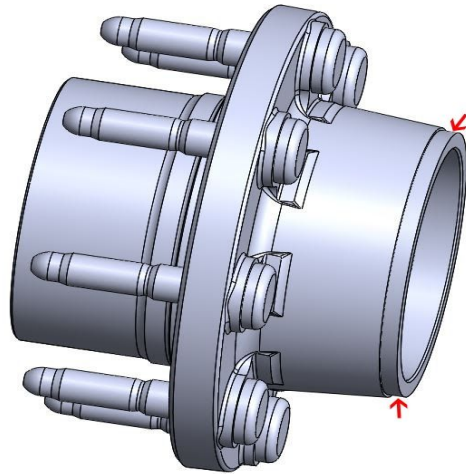
- Hand Drill with a 3/4" hole saw
- Die Grinder
- Hand tools

Step 1:

Disassemble the hubs on the 14 bolt along with the parking brake shoes and remove the bearings that are inside the hubs.

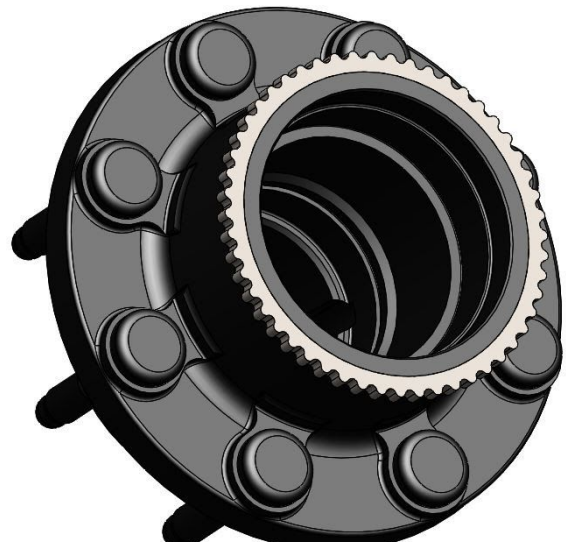
Step 2:

Take the hubs to a machine shop with the tone rings to have the hubs machined down to accept the tone rings. The rings should be a tight press fit once assembled. Measure the inside diameter of tone rings that you receive. The hubs should be machined to a diameter of .001 to .0015" over the inner diameter of the tone rings. The rings should sit flush with the end of the hub. The hubs should look like the picture below.



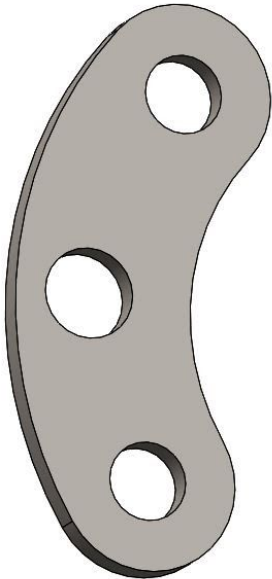
Step 3:

Once the hubs have been machined down for the tone rings press the rings onto the hubs as shown in the picture below. A locking compound may be applied if the hubs were over machined.



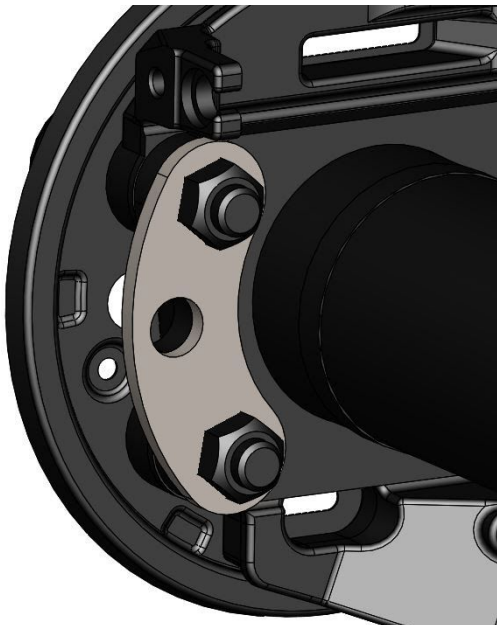
Step 4:

With a $\frac{3}{4}$ " hole saw drill out the hole that is in the supplied drilling guide to $\frac{3}{4}$ ". Remove the drill pilot before moving on to step 5.



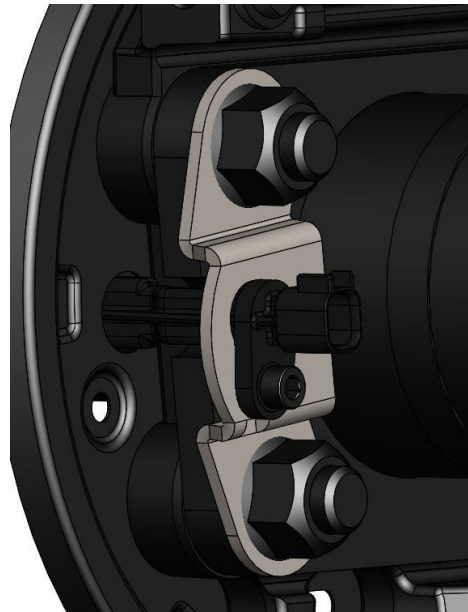
Step 5:

Install the drill guide on the 14 bolt in the location shown below and drill the $\frac{3}{4}$ " hole through the axle flange and backing plate as shown in the picture below. Make sure you have the drill guide positioned the right way where you will not be drilling through the parking brake hold down pins.



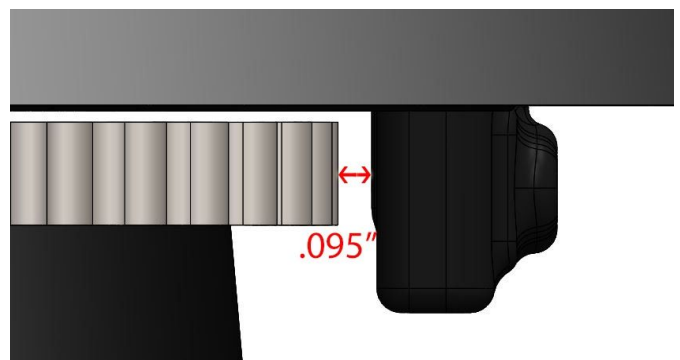
Step 6:

Assemble the abs sensors on to the bracket and the axle as shown in the picture below.



Step 7:

Reassemble the bearing into the hub and test fit the hub onto the axle to get the spacing between the tone ring and the sensor correct. The spacings should be around $.095$ " which is about 5 business cards thick. Additional grinding may be required to get the proper gap.



Step 8:

Remove the hub and reinstall the brake shoe components on the 14 bolt.

Step 9:

Reassemble the hub on the axle with the brakes installed. Note: prying the parking brake shoes away from the axle may be necessary for the tone ring to fit behind them during installation.

Step 10:

Repeat steps 5 through 9 on the opposite side of the axle.

We recommend using the Jscan app to tell if the wheel speed sensors are working.

Congratulations! You have Completed Installation of your Barnes 4WD JK 14 Bolt Swap Tone Rings

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