



## JK Super Duty Steering Kit Installation Instructions

Thank you for purchasing our JK Super Duty Steering Kit.

### Installation Notes:

- This steering kit is designed to fit a 2007-2018 Jeep JK and JKU with a 2005-2016 Super Duty front axle with factory knuckles.
- This kit has been tested with our Super Duty truss axle swap kit; modification may be required to other manufacturer's axle swap kits.
- Refer to the factory service manual for removal of any factory components.

### Tools required:

- Welder with at least 3/8" capabilities
- Grinder
- Tape Measure
- Drill
- 3/4" Drill Bit
- Shim Stock .020" (A business card works well)
- 1 1/16" Wrench
- 1 1/8" Wrench
- 1 5/16" Wrench (X2)

## Contents of Box

Bill Of Materials for B4WK12766			
QTY	Part Number	Etch Number	Description
1	B4W375172	172	JK SD60 05-09 High Steer R Upper Tab
1	B4W375173	173	JK SD60 05-09 High Steer R Lower Tab
1	B4W250748	748	JK SD60 05-09 High Steer R Inner Gusset
1	B4W250749	749	JK SD60 05-09 High Steer R Outer Gusset
1	B4W375197	197	JK SD Steering L Knuckle Tab
1	B4W250839	839	JK SD Steering L Knuckle R Gusset
1	B4W250840	840	JK SD Steering L Knuckle L Gusset
1	JKSDDOMDL	NA	JK SD 60 Drag Link DOM
1	JKSDDOMTR	NA	JK SD 60 Tierod DOM
2	JN87514RH	NA	RH 7/8-14 Jam Nut
2	JN87514LH	NA	LH 7/8-14 Jam Nut
4	75NNE0Y/GC	NA	3/4 NyLock
1	75C325HCS8Y	NA	3.25" 3/4 Bolt
1	75C375HCS8Y	NA	3.75" 3/4 Bolt
1	75C425HCS8Y	NA	3/4-10X4.25 Hex Bolt Grade 8
1	75C700HCS8Y	NA	3/4-10 x 7 HHCS Grade 8 Zinc Yellow
1	DOM201243	NA	DOM Sleeve 1.25" OD x 3/4" ID x 2-11/16" L
2	875HXRH	NA	Heavy Wall Hex Tube Insert (7/8-14) For 1" I.D. Tubing
2	875HXLH	NA	Heavy Wall Hex Tube Insert (7/8-14) For 1" I.D. Tubing
1	XM14FR	NA	7/8 offset heim right
1	XM14FL	NA	7/8 offset heim left
1	B4WXMR14	NA	RH Chromoly 7/8- 14 X 7/8" Heim
1	B4WXML14	NA	LH Chromoly 7/8- 14 X 7/8" Heim
4	MS12932	NA	Misalignment Spacer 3/4" ID x 1-7/16" Wide
2	HMS1412NP	NA	7/8-3/4 Narrow High Misalignment Spacer RevB PAIR
1	HMS1412SW	NA	7/8-3/4 High misalignment safety washer RevB
2	B4WSDKI12L	NA	SD60 Knuckle Insert Long 3/4"
1	B4WSDKI12S	NA	SD60 Knuckle Insert Short 3/4"

### Step 1:

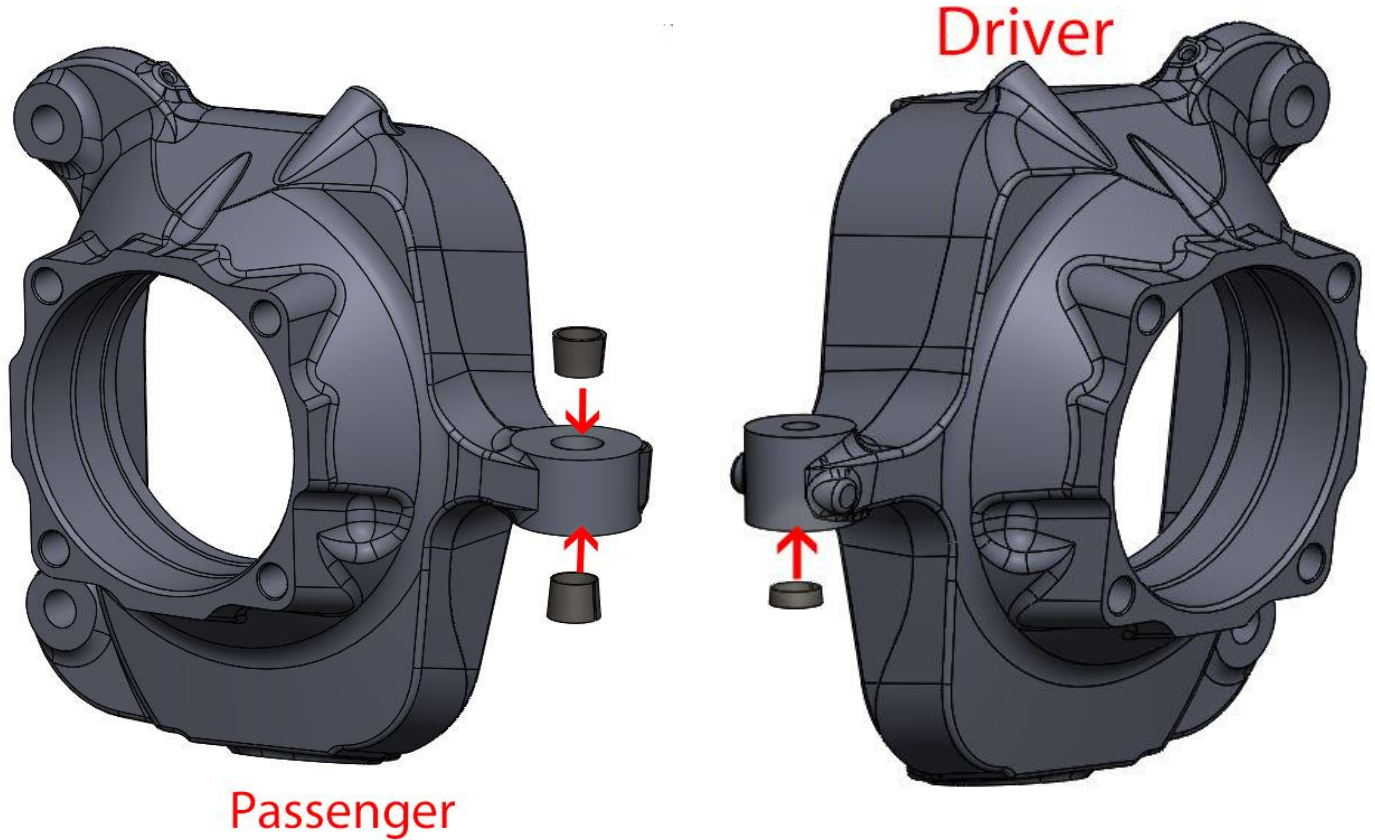
With a grinder remove any casting imperfections from the front of the Super Duty knuckles.

### Step 2:

Drill out the driver side knuckle and the pitman arm holes to 3/4"

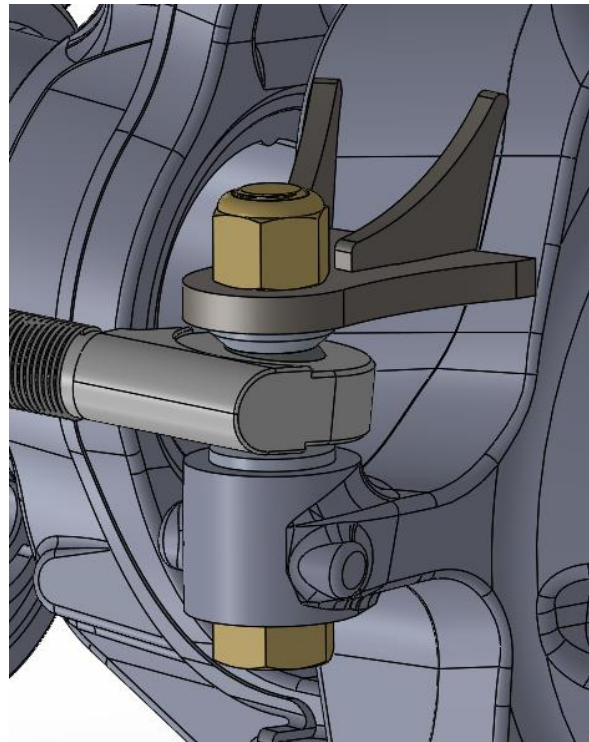
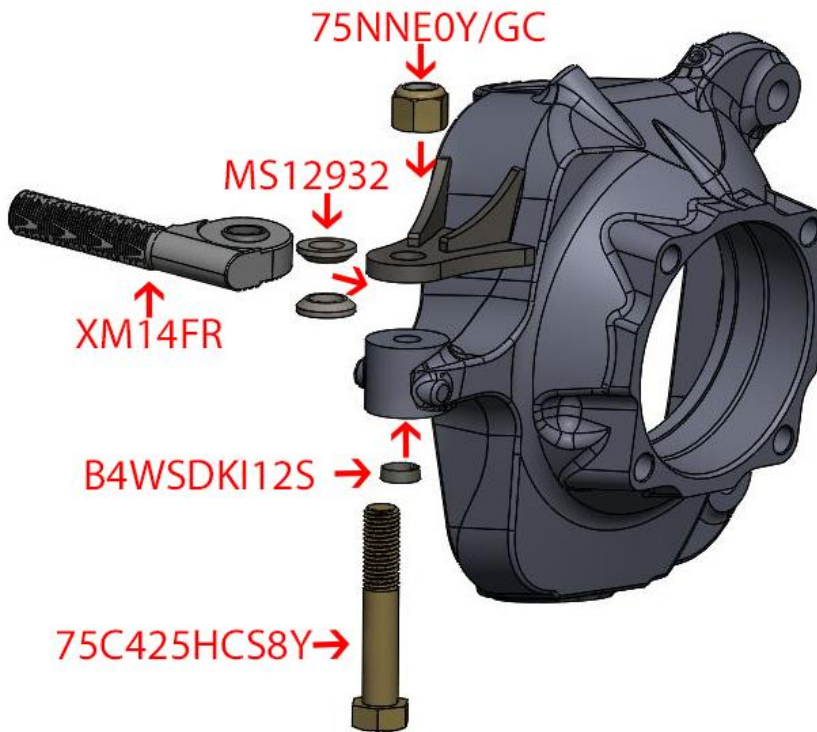
### Step 3:

Install the 2 long knuckle inserts into the passenger side knuckle and the short insert into the driver side knuckle from the bottom.



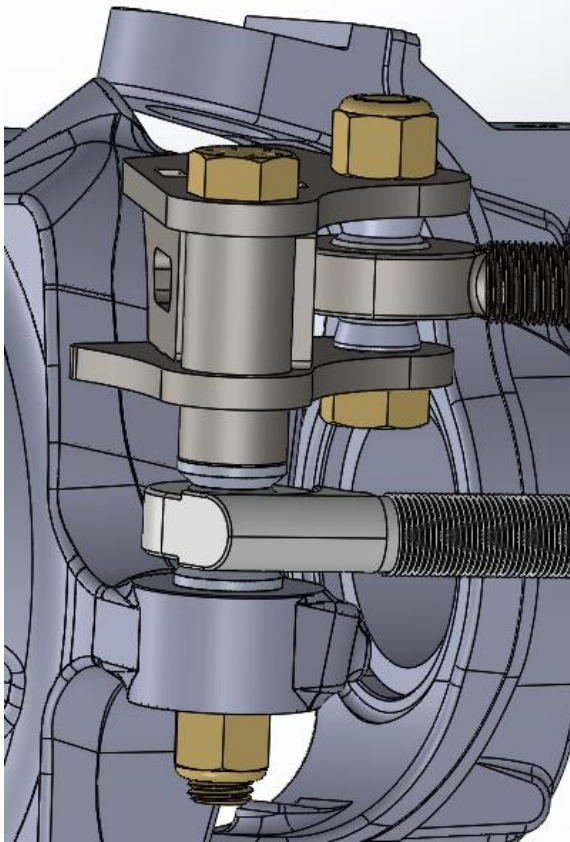
## Step 4:

Assemble the driver side knuckle as shown below. Making sure to shim between the misalignment spacer and the knuckle. Tack weld the arm together and the arm to the knuckle.



### Step 5:

Assemble the passenger side knuckle as shown below. Making sure to shim between the tie rod misalignment spacer and arm and the draglink misalignment spacer and arm. Tack weld the arm together and the arm to the knuckle.



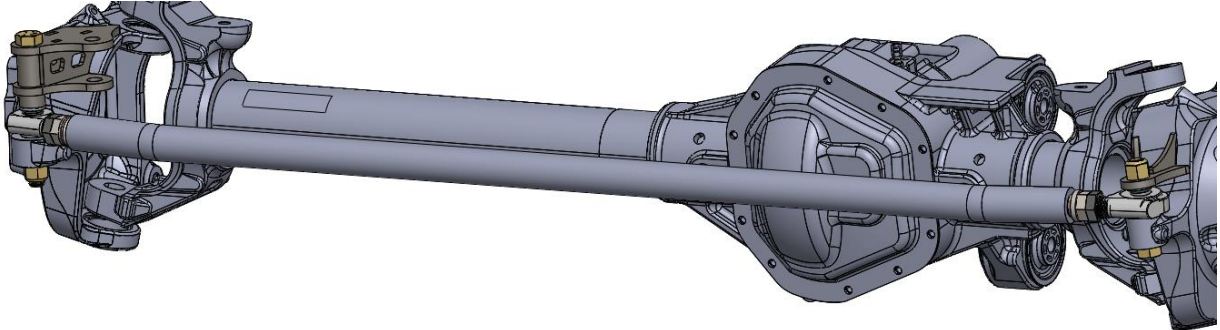
### Step 6:

Weld the tube inserts into the tie rod making sure to have one left hand thread and one right hand thread. The left hand thread will have a groove cut into the insert.



### Step 7:

Let welds cool before threading in heims. Install the tie rod on the axle. Align the axle making sure there are equal number of threads showing on each side of the tie rod.



### Step 8:

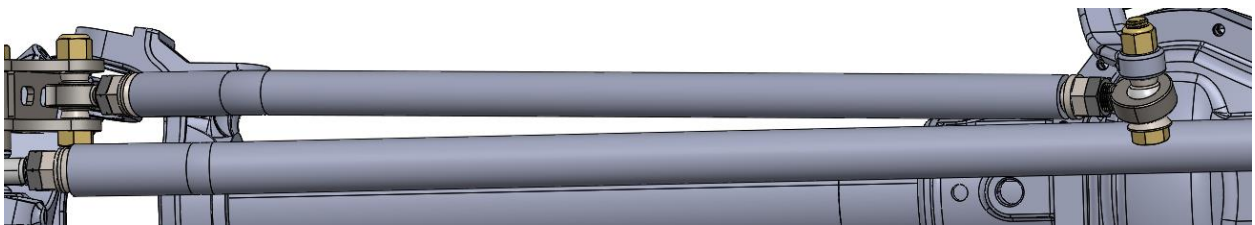
Center the steering wheel and pitman arm at ride height. Measure the distance between the passenger knuckle and pitman arm. Compare the measurement of the draglink. Depending on your pitman arm and the location of steering box the draglink tubing may need to be trimmed.

### Step 9:

Weld the tube inserts into the draglink making sure to have one left hand thread and one right hand thread. The left hand thread will have a groove cut into the insert.

### Step 10:

Let welds cool before threading in heims. Install the draglink to the axle and pitman arm with the safety washer on the bottom.



### Step 11:

Cycle the suspension and steering to check for any clearance issues.

## **Step 12:**

Remove the draglink and tie rod. With the heim joints, misalignment spacers, and shims installed fully weld the arms together and to the knuckles.

## **Step 13:**

Reinstall the draglink and tie rod on the axle and have an alignment performed.

# **Congratulations! You Have finished the installation of the Barnes 4wd JK Super Duty Steering Kit.**

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