

Jeep JK Dana 44 to TJ Rear Axle Truss Swap Kit Installation Instructions

Thank you for purchasing our Jeep JK to TJ
Axle Swap Kit!

Installation Notes:

- Installation of this product requires a trained welder
- This kit is designed to install a Dana 44 rear axle out of a 2007-2018 Jeep Wrangler JK or JKU in a 1997-2006 Jeep Wrangler TJ or a 2003-2006 Jeep Wrangler LJ
- Refer to the factory service manual for your particular model of vehicle for removal or installation of any OEM components
- An adjustable rear track bar is recommended
- This kit contains no provisions for brake lines, driveshafts, or emergency brake modifications. They are the responsibility of the end user.

Tools Needed

- Welding machine with the capability of welding at least 1/4" thick steel
- Tape measure
- Angle Finder
- Level
- Appropriate safety equipment
- Clamps

Step 1:

Remove all of the OEM brackets off from the JK Dana 44 that you are going to swap into your jeep

Step 2:

You will need to establish the existing pinion angle of the axle in your vehicle. This

number will be unique to your Jeep, depending on the amount of lift you have, type of rear driveshaft, and several other factors. This number usually ranges from 10-20 degrees. With vehicle sitting level and at ride height measure the pinion angle of your existing axle with an angle finder. After removing only the driveshaft, place an angle finder on the front flat face of the pinion yoke, and record this number.

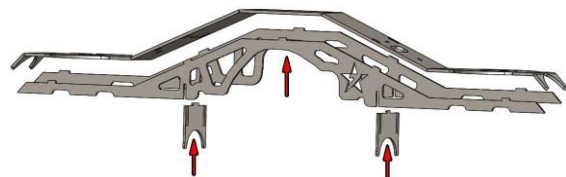
Step 3:

Place the JK Dana 44 on a sturdy work surface. Place the axle at the same pinion angle as the axle in your Jeep. Three jack stands can be used, one under each axle tube and one under the pinion to hold the pinion angle.



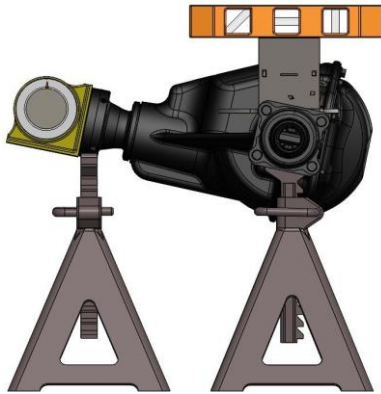
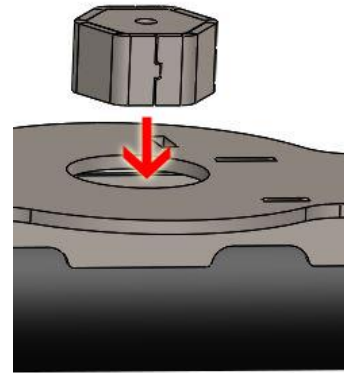
Step 4:

Assemble the truss top, 2 sides and 2 uprights. Each part is keyed so that it will only go together in the correct orientation. After the parts have been assembled tack weld them together.



Step 5:

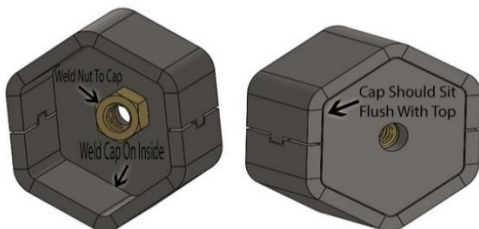
Place the truss assembly from the last step on top of the axle. Place a level on top of the truss and level the truss top. Also measure from the flange on each end of the axle to the end of the truss. These measurements should match in order to center the truss on the axle. After the truss is leveled and centered, tack weld the truss to the axle tubes.



Step 6:

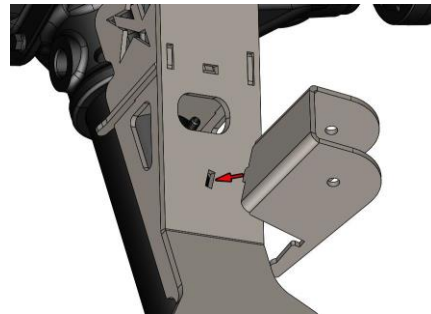
Assemble the coil springs centers. The caps will need to have a $\frac{3}{8}$ " nut centered on the hole in the cap and welded in place. The assembly will then need to be welded to the provided center halves. The top of the cap should sit flush with the top of the halves. After positioning properly weld in place.

After assembling both coil spring centers place them in the holes in either end of the truss and weld in place.



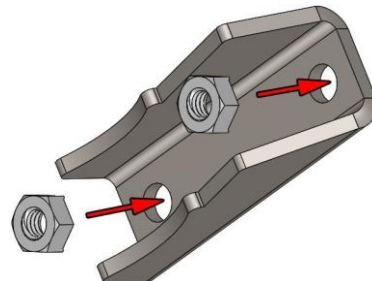
Step 7:

It is now time to install the upper control arm mounts on the truss. The brackets are keyed to sit in slots on top of the truss. The brackets should be angled out (away from the pinion) when installed properly. Insert the key on the bracket in the slot on the truss top and tack weld in place. Repeat this step for the opposite side.



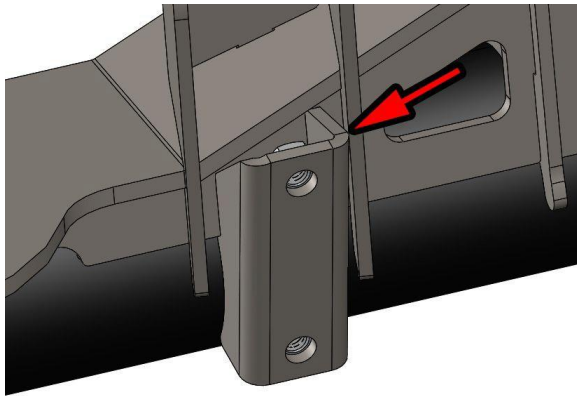
Step 8:

The sway bar brackets now need to have the 4 provided nuts welded in place on the backside of each bracket over each hole.



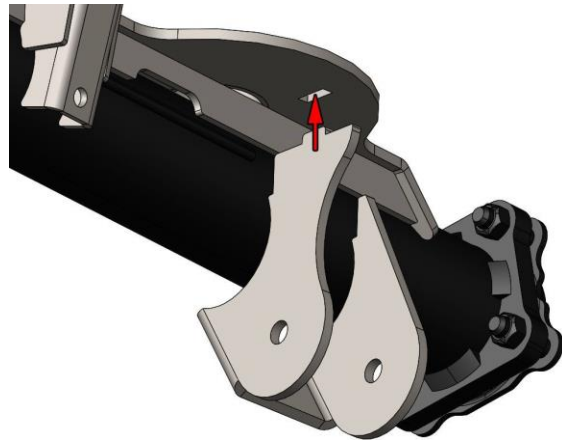
Step 9:

After the nuts have been welded in place on each bracket. Place the bracket on the axle inside the upper control arm mount. Slide the bracket down the axle tube towards the pinion until it contacts the inside of the upper control arm bracket. Tack weld the bracket in place. Repeat this for the opposite side.



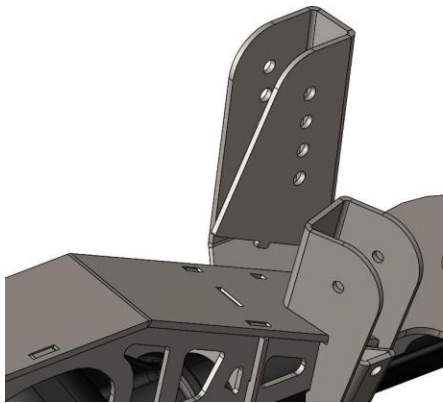
Step 11:

Install the lower control arm mounts. The lower control arm mounts will be angled in towards the pinion when installed correctly. The inside leg of the bracket has a key that will install in a slot in the truss top. Tack weld in place after the bracket has been placed properly. Repeat this for the opposite side.



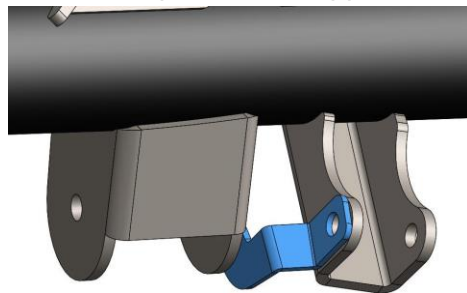
Step 10:

The track bar bracket now needs to be installed on the truss. The bracket is keyed and the truss top has a slot that the key will insert into. Insert the bracket in the slot, rotate until the bottom edge of the bracket contacts the axle tube, and tack weld in place.



Step 12:

The shock brackets are now ready to be installed. Two templates have been provided to properly locate the shock brackets. The shock brackets should angle out away from the pinion. Place the template on the side of the lower control arm bracket and align the holes, place the shock mount on the tube and rotate until the hole lines up with the template and the shock bracket. Tack weld the bracket in place, and repeat for the opposite side.



Step 13:

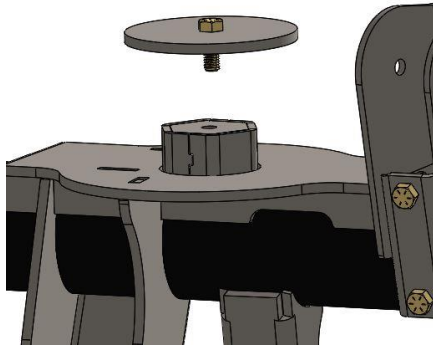
Install the axle in the Jeep without the springs and cycle the suspension. Check for clearance to all components. Depending on the amount of lift on your Jeep the rear track bar bracket may need to be trimmed.

Step 14:

Remove the axle and finish welding all components. Paint the axle the color of your choice.

Step 15:

Install the axle in the Jeep. Coil spring retainers and hardware have been provided that will need to be installed during installation of the axle.



Congratulations you have completed the installation of your rear axle truss!

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