



## Jeep JL Rubicon to Jeep TJ, LJ, XJ, ZJ, or MJ Front Axle Swap Kit Installation Instructions

Thank you for your purchase!

### Installation Notes:

- Installation of this kit requires a trained welder.
- No provisions are provided for steering, brakes, or a driveshaft, they are the responsibility of the end user.
- Refer to your factory service manual for information regarding the removal of any factory components.
- Kit includes brackets for the passenger and driver side of your jeep and will accommodate the mounting of your coil springs, shocks, track bar, steering stabilizer, and sway bar ends.
- The OEM shock bar pin will need to be pressed out. the bar pin will be replaced by the DOM sleeve. please see installation note 1a.
- Adjustable control arms are required and will need to be modified to fit the bolt hole size of the new axle.
- We recommend installing this kit on an empty axle housing to avoid damage to any heat sensitive parts.

### tools required:

- Welding machine with the capability to weld at least 3/8" thick steel.
- Grinder.
- Cutting torch, plasma cutter, or other appropriate cutting tool.
- Angle finder.
- Power drill.

## Contents of each box

Bill Of Materials For (BOM Part# and Description)			
QTY	Part Number	Etch Number	Description
2	B4W188211	211	TJ Front Axle Coil Spring Cap
2	B4W188210	210	TJ Front Axle Coil Spring Locator
4	B4W188207	207	TJ Front Axle Shock Tab
1	B4W188208	208	TJ Front Axle Steering Stabilizer Bracket
2	B4W375113	113	TJ Front Axle Sway Bar Bracket
2	50CNNE0Y/GC		1/2"-13 Nylon Lock Nut
2	50C275HCS8Y		1/2"x2-3/4" Grade 8 Bolt
2	DOM10822		Sleeve 1.375" L x .625 O.D. x .5 I.D.
1	B4W188A59	A59	JT TO TJ/XJ JT TO TJ/XJ Front Coil Spring Base Passenger
1	B4W188A60	A60	JT TO TJ/XJ Front Coil Spring Base Driver
1	B4W188A61	A61	JT TO TJ/XJ Track Bar Bracket

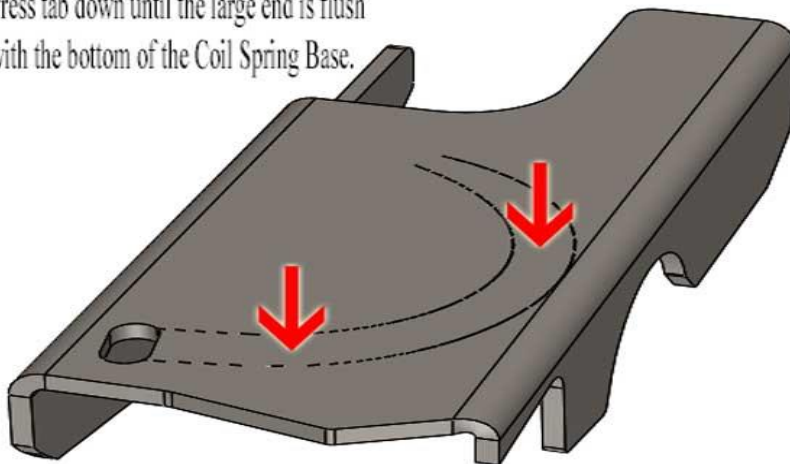
### Step:1

Remove the factory coil spring, shock, track bar, steering stabilizer, and sway bar brackets from the JL axle.

### Step:2

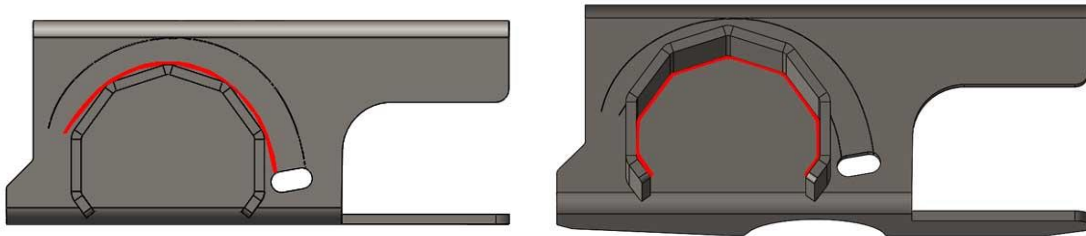
The coil spring seats on both Front Coil Spring Base Driver and Passenger need to be pressed down and welded. Press the tab down until the large end is flush with the bottom. Weld on the bottom of the base.

Press tab down until the large end is flush with the bottom of the Coil Spring Base.



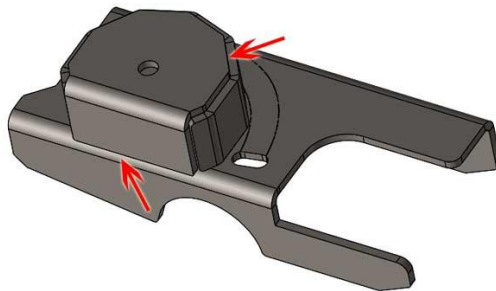
### Step:3

Locate the front coil spring locator, onto the front coil spring base driver. Align the coil spring locator with the edge of the arc on the front coil spring base driver. Once located weld around the inside of the front axle coil spring locator. Weld where indicated in red in the picture below. Repeat this step with the remaining front axle coil spring locator, and front coil spring base passenger.



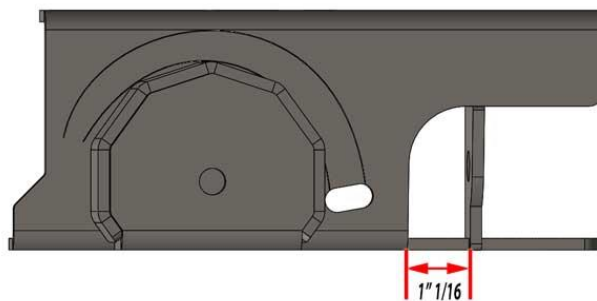
### Step:4

Locate the front axle coil spring cap on top of the front axle coil spring locator. Weld around the edge of the cap and along bottom of flange. Repeat this step for front coil spring base passenger.



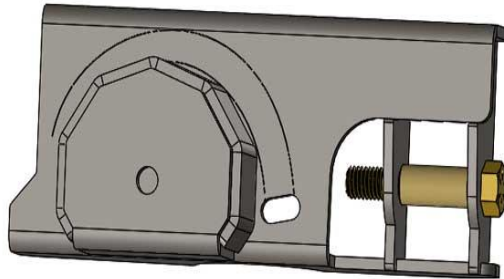
### Step:5

Locate the front axle shock tab onto the front coil spring base driver. Tack weld the tab  $1\frac{1}{16}$ " from the back surface of the base as pictured below.



## Step:6

To locate the second tab, use the DOM sleeve and hardware to position it alongside the tab that was welded on in step 5 and tack weld it in place.



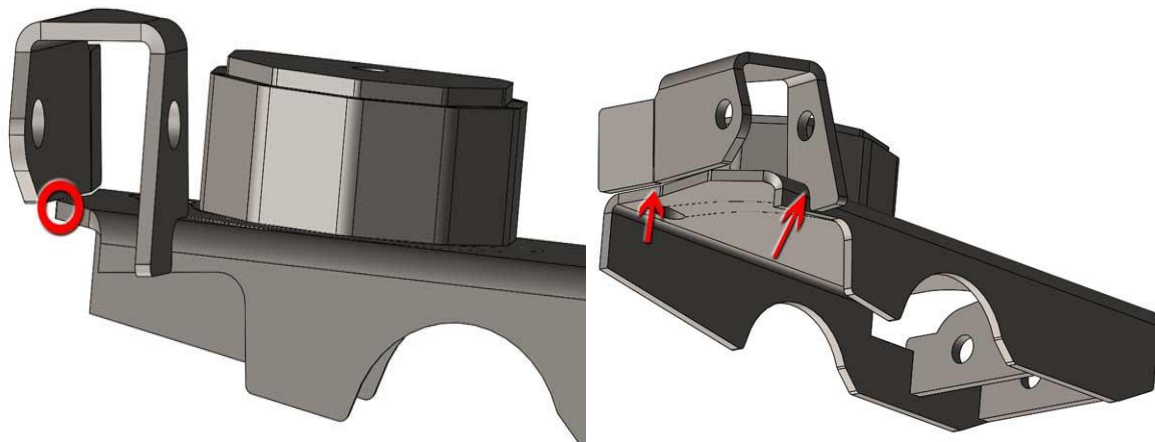
With fitment verified remove the hardware and Dom Sleeve before fully welding the tabs into place.

## Step:7

Repeat steps 5-6 for TJ Front Coil Spring Base Passenger.

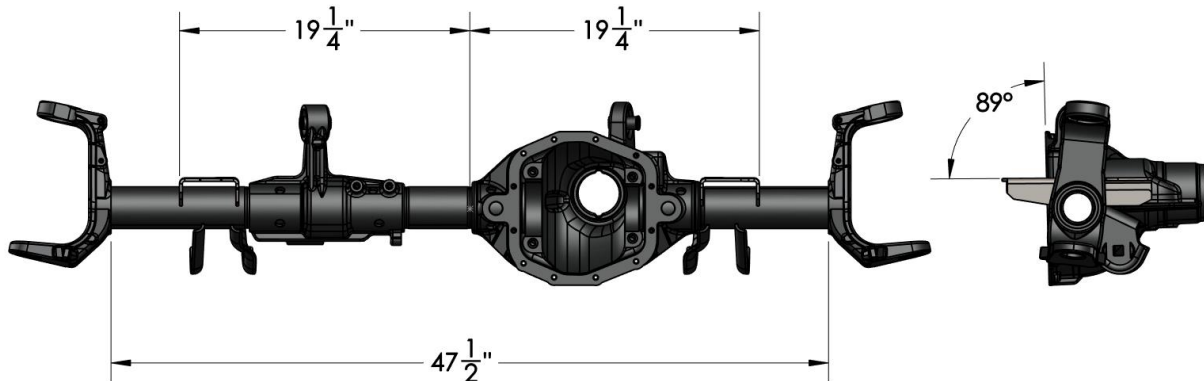
## Step:8

Locate and tack weld the front axle steering stabilizer bracket onto the front coil spring base passenger. The steering stabilizer bracket will make contact on the front edge coil spring base passenger. see picture.



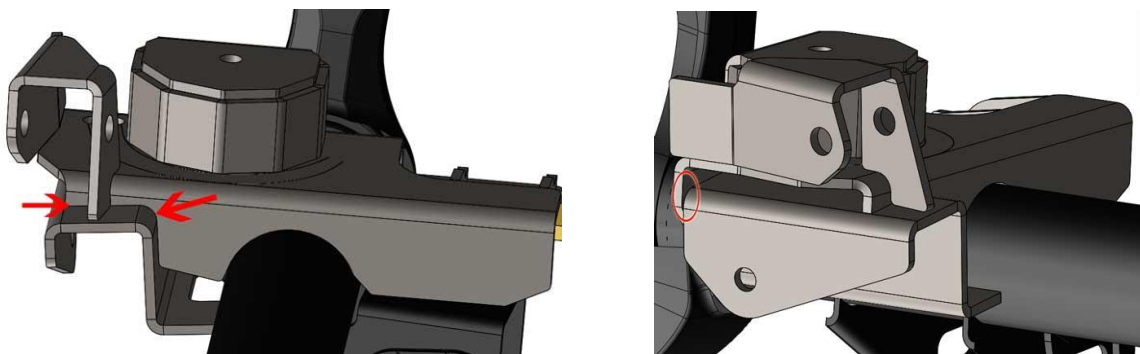
## Step:9

Locate the front coil spring base assemblies onto the axle. Refer to the dimensional drawing below. Measure the axle as shown below to verify width and mark the center. From the center to the outside of each spring base needs to be  $19\frac{1}{4}$ ". The top face of the spring base needs to be  $89^\circ$  from the differential cover mounting surface.



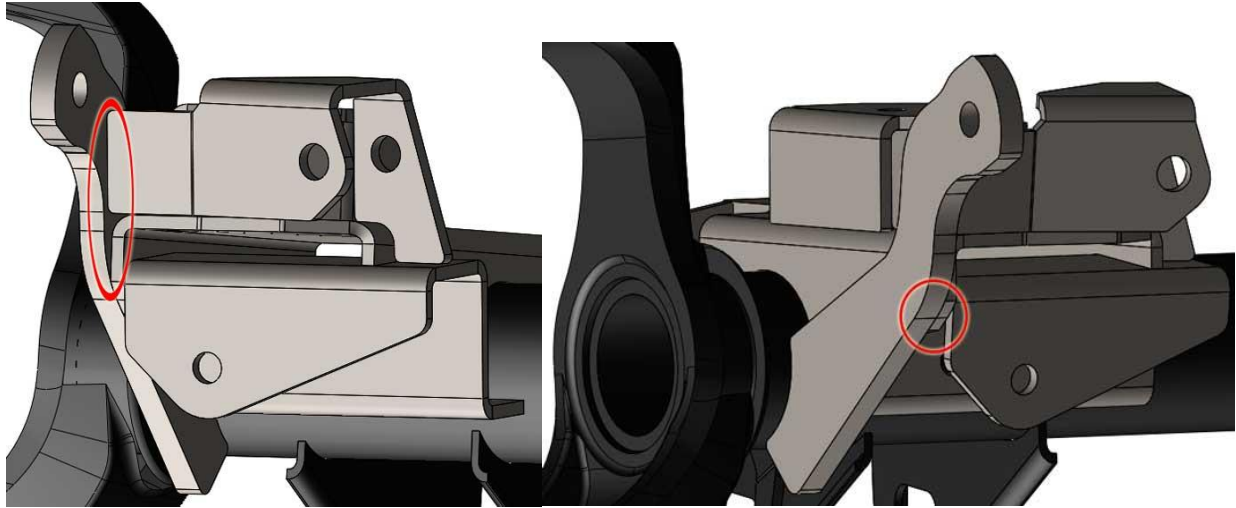
## Step:10

Locate the front axle track bar bracket to the front coil spring base passenger. The axle track bar bracket will insert in the cutout on the coil spring base passenger and contact the axle tube. Slide the TJ front axle track bar bracket until it contacts the side of the front coil spring base passenger. With location satisfied tack weld the front axle track bar bracket into place.



## Step:11

Locate the front axle sway bar bracket onto the axle. It will contact the side of the front coil spring base passenger, and the flange of the front axle steering stabilizer bracket. Rotate the front axle sway bar bracket on the axle until it is flush with the edge of the front coil spring base passenger. (See picture below) Tack weld the front axle sway bar bracket into place. Repeat this step for the driver's side. Please note that on the driver's side there is no steering stabilizer bracket.



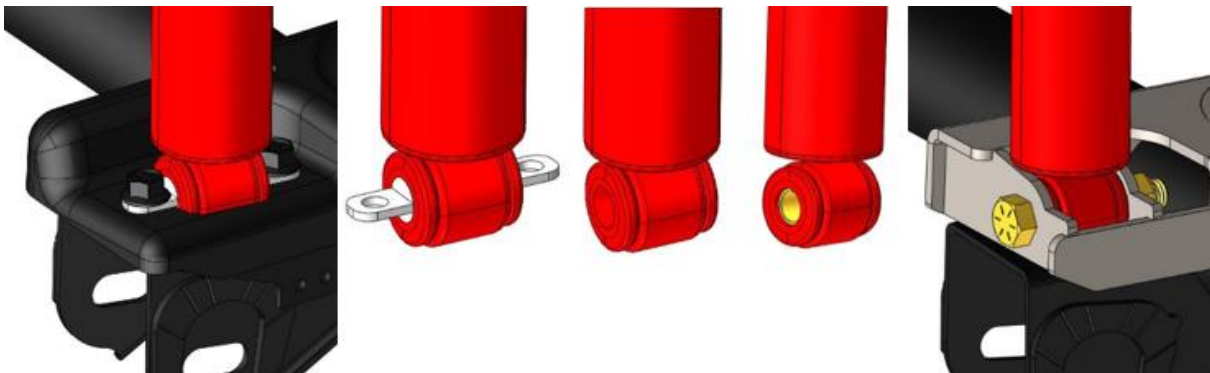
## Step:12

Install the JL axle into the vehicle according to the factory service manual and supplementary installation note below. Once installed test full bump and droop verifying clearance then fully weld the brackets into place.

**(Installation Note: The OEM Shock Bar Pin will need to be pressed out. The Bar Pin will be replaced by the DOM Sleeve used in step 6)**

### Installation Note 1A:

The bar pin on the OEM shocks will need to be pressed out. Unbolt the shocks from the OEM location. Then Press out the Bar Pin.



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