



Jeep TJ and LJ Rear Triangulated Uppers Kit Installation Instructions

Thank you for your purchase.

Installation Notes:

- This kit is designed to be compatible with 1997-2006 Jeep Wrangler TJ and LJ models.
- Removal of the existing upper links, track bar, and their corresponding brackets is required.
- If you opt to use this in conjunction with a previously installed axle truss the builder needs to verify it is suitable for link suspension.
- This kit requires welding, automotive mechanical knowledge, and general fabrication skills, it should only be installed by qualified individuals with suspension geometry knowledge.
- The components of this kit will need to be painted or powder coated during installation.
- Refer to your factory service manual to remove any factory components.

Tools required:

- Welding machine with the capability to weld at least ¼" thick steel.
- Cutting torch, plasma cutter, or other appropriate cutting tool
- Various hand tools
- Grinder to prepare surfaces for welding.
- Tape measure
- Jack and jack stands



Possible Kit Combinations

| Bill Of Materials For B4WK12806 | | | |
|---------------------------------|----------------|-------------|--------------------------------------|
| QTY | Part Number | Etch Number | Description |
| 2 | B4W250898 | 898 | Truss Link Mounting Bracket 2W 1/2BH |
| 2 | B4WXMR12-14 | | RH Chromoly 7/8- 14 X 3/4" Heim |
| 2 | B4WXML12-14 | | - LH Chromoly 7/8- 14 X 3/4" Heim |
| 2 | 8751415175RHMS | | Tube Insert 7/8-14RH 1.5ID 1.75 OD |
| 2 | 8751415175LHMS | | Tube Insert 7/8-14LH 1.5ID 1.75 OD |
| 2 | JN87514RH | | RH 7/8-14 Jam Nut |
| 2 | JN87514LH | | LH 7/8-14 Jam Nut |
| 2 | DOM171548 | | DOM 1.75"X1.5"X48 |
| 4 | HMS128ZP | | 3/4-1/2 Hi misalignment Spacer |
| 1 | B4W250621 | 621 | TJ 4 Link RAUCAM |
| 1 | B4W250644 | 644 | TJ 4 Link RAUCAM Right |
| 1 | B4W250874 | 874 | TJ Dana 44 Rear 1 Piece Truss |
| 4 | 50NWSAFY | | 1/2" SAE Flat Washer Yellow Zinc |
| 4 | 50CNNE0Y/GC | | 1/2"-13 Nylon Lock Nut |
| 4 | 50C325HCS8Y | | 1/2"-13 x 3 1/4" Grade 8 Bolt |

| Bill Of Materials For B4WK12807 | | | |
|---------------------------------|----------------|-------------|--------------------------------------|
| QTY | Part Number | Etch Number | Description |
| 2 | B4W250898 | 898 | Truss Link Mounting Bracket 2W 1/2BH |
| 2 | B4WXMR12-14 | | RH Chromoly 7/8- 14 X 3/4" Heim |
| 2 | B4WXML12-14 | | - LH Chromoly 7/8- 14 X 3/4" Heim |
| 2 | 8751415175RHMS | | Tube Insert 7/8-14RH 1.5ID 1.75 OD |
| 2 | 8751415175LHMS | | Tube Insert 7/8-14LH 1.5ID 1.75 OD |
| 2 | JN87514RH | | RH 7/8-14 Jam Nut |
| 2 | JN87514LH | | LH 7/8-14 Jam Nut |
| 2 | DOM171548 | | DOM 1.75"X1.5"X48 |
| 4 | HMS128ZP | | 3/4-1/2 Hi Misalignment Spacer |
| 1 | B4W250621 | 621 | TJ 4 Link RAUCAM |
| 1 | B4W250644 | 644 | TJ 4 Link RAUCAM Right |
| 1 | B4W250875 | 875 | TJ Dana 35 Rear 1 Piece Truss |
| 4 | 50NWSAFY | | 1/2" SAE Flat Washer Yellow Zinc |
| 4 | 50CNNE0Y/GC | | 1/2"-13 Nylon Lock Nut |
| 4 | 50C325HCS8Y | | 1/2"-13 x 3 1/4" Grade 8 Bolt |

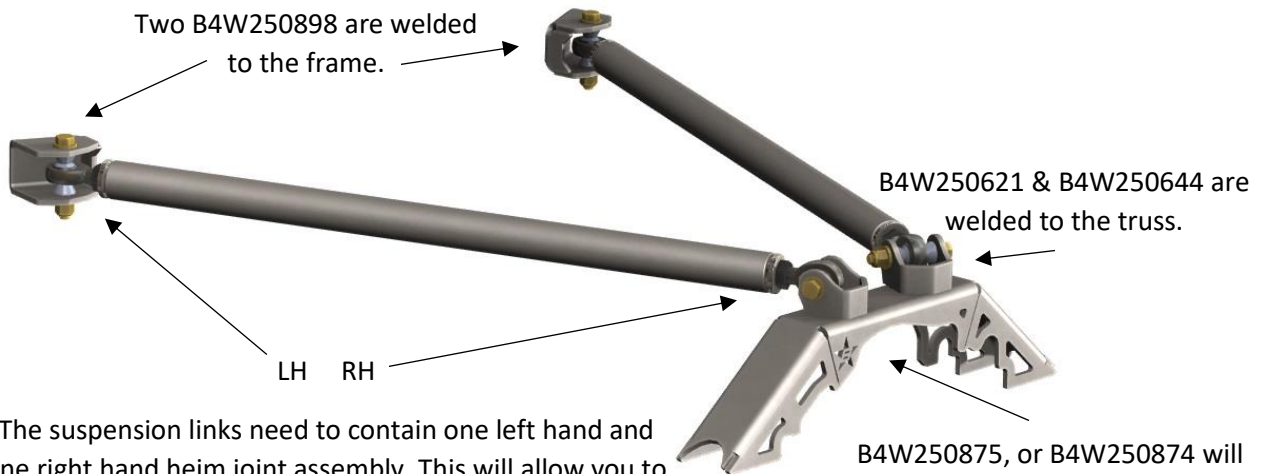
| Bill Of Materials For B4WK12805 | | | |
|---------------------------------|----------------|-------------|--------------------------------------|
| QTY | Part Number | Etch Number | Description |
| 4 | B4W250898 | 898 | Truss Link Mounting Bracket 2W 1/2BH |
| 2 | B4WXMR12-14 | | RH Chromoly 7/8- 14 X 3/4" Heim |
| 2 | B4WXML12-14 | | - LH Chromoly 7/8- 14 X 3/4" Heim |
| 2 | 8751415175RHMS | | Tube Insert 7/8-14RH 1.5ID 1.75 OD |
| 2 | 8751415175LHMS | | Tube Insert 7/8-14LH 1.5ID 1.75 OD |
| 2 | JN87514RH | | RH 7/8-14 Jam Nut |
| 2 | JN87514LH | | LH 7/8-14 Jam Nut |
| 2 | DOM171548 | | DOM 1.75"X1.5"X48 |
| 4 | HMS128ZP | | 3/4-1/2 Hi Misalignment Spacer |
| 4 | 50NWSAFY | | 1/2" SAE Flat Washer Yellow Zinc |
| 4 | 50CNNE0Y/GC | | 1/2"-13 Nylon Lock Nut |
| 4 | 50C325HCS8Y | | 1/2"-13 x 3 1/4" Grade 8 Bolt |

Installation Notes

This kit is intended to convert rear TJ long arm suspension to triangulated 4 link suspension. This process eliminates the need for a rear track bar. Due to the variation in aftermarket kits these installation notes are for reference only, the installation, suspension modification, link length, separation and triangulation is at the discretion of the builder.

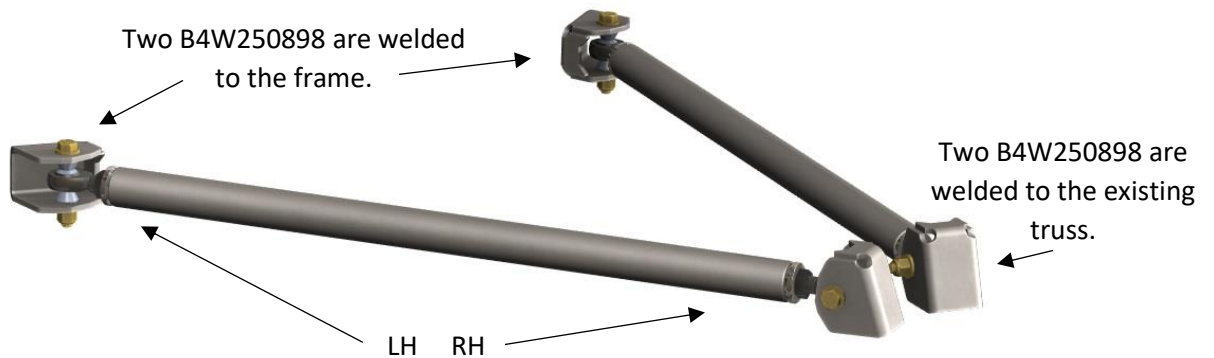
- The frame location needs to be clear of all paint, link brackets, break, fuel, or vent lines and made ready for welding.
 - A suitable axle truss needs to be installed and made ready for welding.
- At least 20 degrees of triangulation is required per link to properly locate the rear axle.
 - Refer to the following diagrams for reference during your installation.

If you opted to purchase a kit with our axle truss included your assembly is shown below.



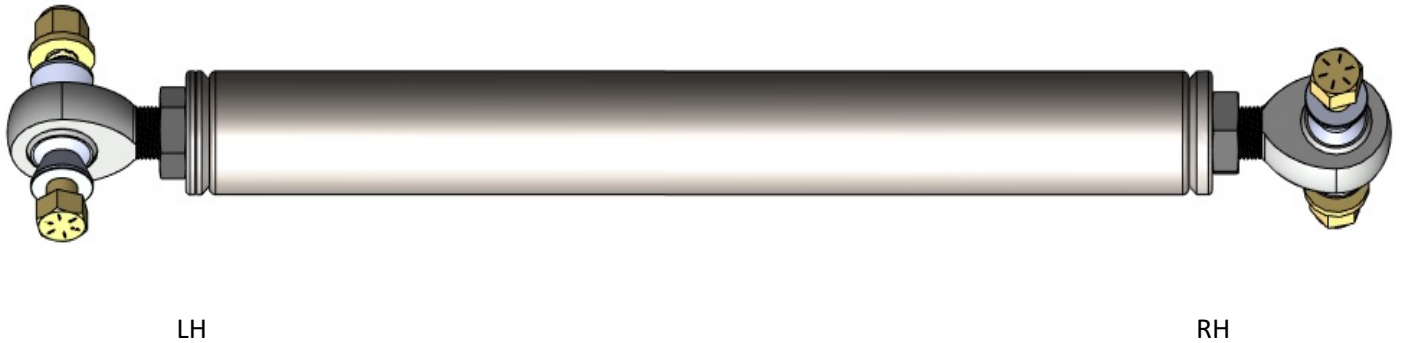
The suspension links need to contain one left hand and one right hand heim joint assembly. This will allow you to adjust the length of the link by twisting the DOM tubing once it is installed in the bracketry. A detailed view is provided below.

If you purchased a kit without our axle truss included your assembly is shown below.



The suspension links need to contain one left hand and one right hand heim joint assembly. This will allow you to adjust the length of the link by twisting the DOM tubing once it is installed in the bracketry. A detailed view is provided below.

Suspension link Detailed View



The suspension links need to contain one left hand and one right hand heim joint assembly. This will allow you to adjust the length of the link by twisting the DOM tubing once it is installed in the bracketry. Each heim joint assembly should contain 1 Heim, 1 Jam Nut, 1 tube insert and 2 spacers. The left hand tube inserts and jam nuts can be identified by the groove machined on their exterior.

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