

TJ, XJ, MJ, Dana 30 Low Pinion Front Axle Truss Installation Instructions

Thank you for purchasing our axle truss!

Installation Notes:

- Removal of the passenger side front axle upper control arm mount is required
- Welding to the cast iron center section of the axle requires special procedures. If you are not familiar with these procedures we recommend having a shop that is familiar with cast iron welding requirements install this kit.
- Refer to the factory service manual for removal of any factory components
- We recommend removing the axle from the Jeep during installation
- Due to differences in castings, slight grinding may be required for proper fit

Tools Required:

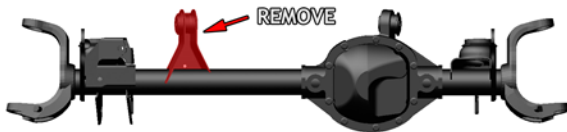
- Welding machine with the capability to weld at least ¼" steel
- Grinder
- Cutting torch, plasma cutter, or other appropriate cutting tool
- Angle finder
- Level

Step 1:

If removing the axle from the Jeep, remove it now. If not, unbolt the upper control arm from the axle on the passenger side. The track bar may also need to be unbolted from the axle to gain access.

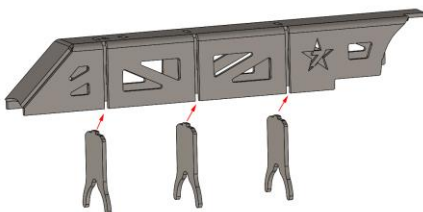
Step 2:

Using an appropriate cutting tool, remove the passenger upper control arm mount from the axle and grind the axle tube smooth.



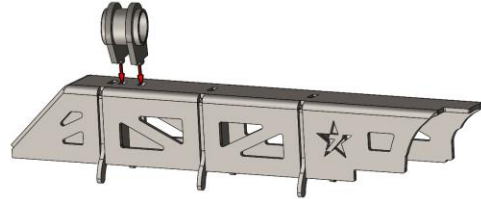
Step 3:

Place the 3 provided uprights in the slots, in the truss body and weld in place.



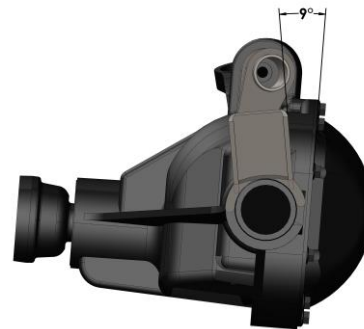
Step 4:

Place the upper control arm mount tabs on top of the truss, center the DOM sleeve and weld in place. The tabs should be installed so the DOM sleeve is pushed towards the front of the truss.



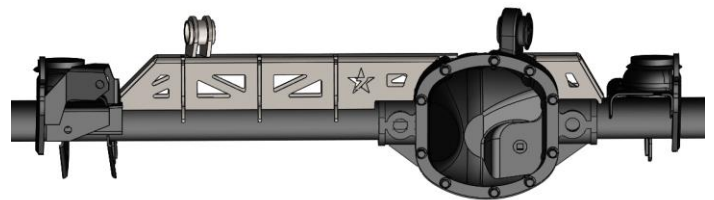
Step 5:

Place the assembly from step 4 on top of the passenger axle tube. The truss needs to be rotated back 9° in relation to the differential cover mounting surface. Tack weld in place.



Step 6:

Place the short side truss on the driver's side of the axle, rotate back 9° from the differential cover surface and tack weld in place.



Step 7:

All components should now be tack welded in place. It is now time to finish weld the truss, it is not necessary or recommended to weld the truss to the axle tube at every point of contact. We recommend making small 1"-2" long welds that are staggered with a 1"-2" gap between them. The axle tubes and all bracketry are steel and can be welded using common techniques and electrodes. When welding to the cast iron center section proper procedures need to be followed. If you are not familiar with the required procedures we recommend having a shop complete the welding.

Step 8:

After welding is complete and the axle has cooled install the two polyurethane bushings and inner sleeve in the upper control arm mount.

Step 9:

Install the axle back into the jeep, cycle the suspension, and check clearances to all components of the Jeep.

Congratulations you have completed the installation of your axle truss!

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