



Jeep TJ, LJ, XJ, MJ, ZJ, Front Axle Inner C Gussets Installation Instructions

Thank you for purchasing our Inner C Gussets!

Installation Notes:

- This kit is designed to fit a Dana 30 or Dana 44 axle found in a TJ, LJ, XJ, MJ, or ZJ
- Welding is required to install this product
- Care needs to be taken while welding not to overheat the ball joints or other axle components
- Due to variations in castings some grinding may be required
- The steering will need to be cycled through its entire range to verify clearance to all components

Tools required:

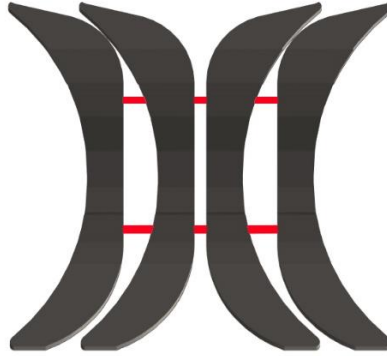
- Welder with the capability to weld at least 1/4" thick steel
- Grinder

Contents of kit

Bill Of Materials For (BOM Part# and Description)			
QTY	Part Number	Etch Number	Description
1	B4W250380	380B	TJ Inner C Gusset Right REV B

Step 1:

The gussets in this kit will arrive as one piece, they will need to be cut or broken apart and the tabs ground flat. Refer to the image below for the areas to remove.



Step 2:

Place each gusset on the inner C of the axle one on the front side and one on the backside, refer to the images below for proper placement. Mark the areas where the gusset will contact the C and remove any paint or rust in preparation for welding.



Step 3:

Tack weld the gussets in place on the inner c's. Cycle the steering from lock to lock in both directions to verify clearance to all components of the axle. If interference is encountered grinding or slightly shifting the gusset may be required to eliminate interference.

Step 4:

Fully weld the gussets into place. Use care to ensure that the ball joints or any other axle components are not overheated during welding. Apply the paint of your choice to all bare metal areas to prevent corrosion.

Congratulations you have completed the installation of this product!

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