



## **XJ Front Chassis Replacement Brackets Installation Instructions**

Thank you for purchasing our XJ Front Chassis Replacement Brackets!

### Installation Notes:

- A qualified welder is recommended to install these brackets.
- We recommend using a spot weld cutter to remove the spot welds on the factory brackets.
- We recommend placing the front axle on jack stands to keep the axle from moving. This will allow you to use the control arms to place the new brackets in their intended locations.
- Only work on one side of the vehicle at a time.
- Some gussets may need to be modified to fit your Cherokee frame.
- We recommend getting your vehicle aligned after installation.

### Tools required:

- 3/8" Spot Weld Cutter
- Welder
- Grinder with Cut-off wheel and Flap Disc
- 21 MM Socket and Wrench
- 15 MM Socket and Wrench
- 9/16" Socket and Wrench
- Plasma Cutter or Torch

## Contents of each box

Bill Of Materials For B4WK12803-XJ Front Chassis Replacement Brackets			
QTY	Part Number	Etch Number	Description
1	B4W125154	154 B	Front Lower Control Arm Outer Gusset Passenger Side
1	B4W125155	155 B	Front Lower Control Arm Inner Gusset Passenger Side
1	B4W125156	156 B	Front Lower Control Arm Rear Gusset Passenger Side
1	B4W125157	157 B	Front Lower Control Arm Inner Gusset Driver Side
1	B4W125199	199 B	Front Lower Control Arm Rear Gusset Driver Side
1	B4W125200	200 B	Front Lower Control Arm Outer Gusset Driver Side
2	B4W188A26	A26 B	Front Lower Control Arm Frame Bracket
2	B4W188A27	A27 B	Front Lower Control Arm Cam Bracket
1	B4W188A28	A28 B	Front Upper Control Arm Frame Bracket Passenger Side
1	B4W188A29	A29 B	Front Upper Control Arm Bracket Driver Side
4	37C150HCS8Y	N/A	3/8"-16 x 1.5" Hex Head Bolt Grade 8 Yellow Zinc
4	37NWSAFY	N/A	3/8" SAE Washer Yellow Zinc
4	94945A217	N/A	3/8"-16 Thin Nylock Nut Grade 8 Yellow Zinc

### Step 1:

With the front axle on jack stands and the rear tires scotched, remove the lower and upper control arms of ONLY one side of the vehicle. Carefully remove the factory brackets.

\*Note: Make sure to drill out all the spot welds and grind down all the other welds before trying to remove the brackets, you can and will rip the frame.

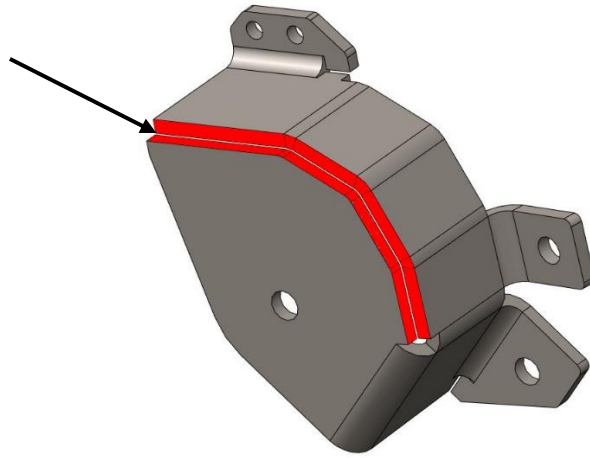


### Step 2:

With the factory brackets removed, make sure the frame is ground smooth and flat where the new brackets will be located. Make sure the gusset from the frame that tied into the inside of the factory lower control arm bracket is ground back like in the pictures above.

### Step 3:

Weld up the seam on the new upper control arm bracket.



### Step 4:

Place the factory bolt through the frame, upper control arm, and the new upper control arm bracket. Rotate the bracket until the angled cut on the bottom flange is close to being parallel to the bottom of the frame.

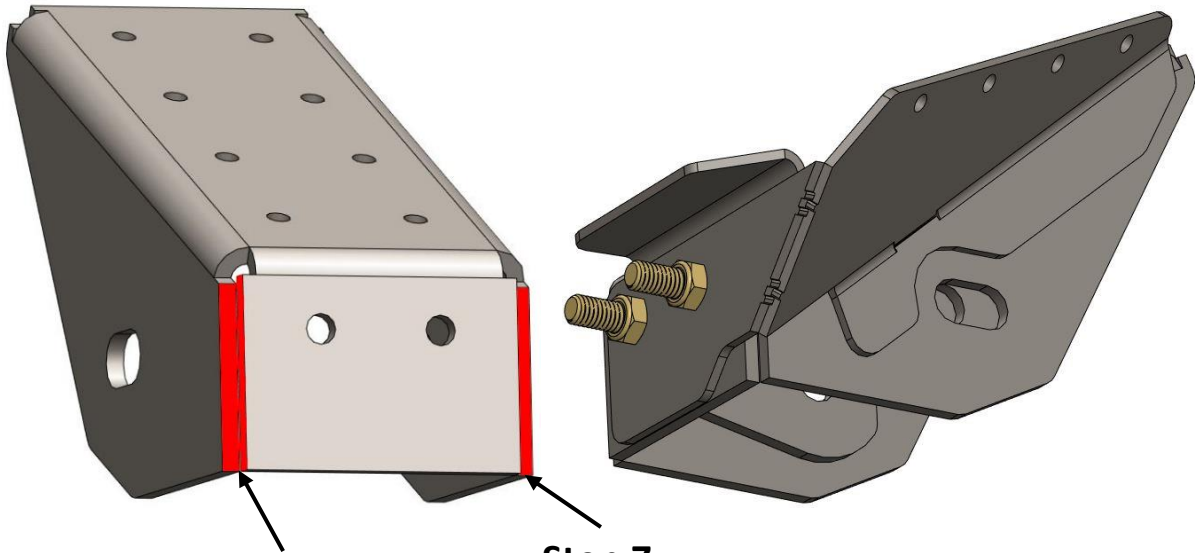


### Step 5:

Tighten the nut until the new bracket is snug up against the frame. Tack the new bracket in place. Check to make sure the bracket is still sitting flat everywhere and weld the bracket in place. Make sure to fill in all the spot weld holes and around each flange.

## Step 6:

Weld up the two seams on the new lower control arm bracket. Using the etch marks as a guide, place the new lower control arm outer gusset on the new bracket. Place the new cam bracket inside the lower control arm bracket and use the provided hardware to bolt the new rear gusset in its location, lining up with the tabs on the outer gusset. Tack the gussets together and onto the lower control arm bracket.



## Step 7:

With the new gussets tacked in place, bolt the new lower control arm bracket on to the control arm. If the axle has not moved, you should be able to swing the control arm and bracket up to the frame and fit it right in place. If it seems the axle has moved, the front of the bracket should be about 2-1/16" off the cutout in the frame.



### Step 8:

Clamp the bracket on to the frame with both outer and rear gussets sitting on the frame. Place the new lower control arm inner gusset on to the frame and control arm bracket. Once the new inner gusset is sitting flat on the frame and control arm bracket, tack each gusset and control arm bracket to the frame.



### Step 9:

With all the gussets and bracket sitting flat on the frame, fully weld the bracket and gussets to the frame. Make sure to fill each plug weld hole and fully weld the gussets to the bracket.

### Step 10:

Fully tighten each control arm bolt and the cam bolts.

Repeat this process for the other side of the vehicle.

# **Congratulations! You have finished the installation of the Barnes 4WD Jeep XJ Front Chassis Replacement Brackets**

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