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DANA 25/27 and DANA 30 Disc Brake Instructions

Start on the left side (Driver Side)

1. Remove your drum, hub, bearings, backing plate, and spindle bolts or studs.

Dana 30: Remove your spindle and then remove the studs.

Dana 25/27: Remove your spindle bolts (spindle can stay on).

Dana 30: Install new studs, grease inner spindle bearing, and then install spindle. Dana 30 will require slight grinding on the bracket to clear the knuckle.

2. Install caliper mounting bracket and make sure your bracket is properly clocked for which axle you have (see below). Caliper brackets should be installed with the offset towards the frame.

Dana 30: Bottom caliper bolt location; position in the 3 o'clock position on driver and 9 o'clock on passenger side. **If not clocked correctly the calipers will not clear the knuckle.**

Dana 25/27: Bottom caliper bolt location; position in the 2 o'clock position on the driver side and 10 o'clock position on the passenger side. **If not clocked correctly the calipers will not clear the knuckle.**

3. Install bolts or nuts, and tighten to approximately 30-40 ft-lbs.

Dana 30: Use bolts provided:

Dana 25/27: Use bolts and lock washers provided.

4. Pack 2 bearings with grease. **(You can skip steps 4, 5, 6, and 7 if you have left your hub intact.)**
5. Apply grease to the inner and outer races and hub wall of hub and rotor.
6. Place greased bearing on the inner side of hub and rotor.
7. Install hub seal carefully. The seal should sit flush. If you push it in too far it will press against the bearing.
8. Lightly grease up the outer spindle, and then install hub first. Next install the rotor over the hub.
9. Place the second greased bearing over spindle and push it on until it is seated.
10. Install your spindle washer, nut, and tighten. Then install the second nut and tighten.
11. Place loaded left caliper assembly over rotor. Make sure the bleeder is at the top. **Note: Our calipers are interchangeable for left or right side; simply switch the bleeder screw and banjo bolt for the proper location. Bleeder should be at the top.**

12. Slide caliper bolts through caliper, guide them with your fingers to make sure they carefully line up with the holes as they are turned in.
13. Tighten caliper mounting bolts to 20-25 ft-lbs. No grinding is required for clearance.
14. Install caliper hose to caliper. Do not tighten yet. Connect the other end to your 3/16 brake line. Now tighten both ends.
15. Reinstall your locking hubs. It is recommended to use lithium grease in the hubs, not wheel bearing grease. Hint: Install a 7/16-20 bolt on the end of the axle shaft and pull outward to help reinstall the axle retaining clip when installing your locking hub. In some case you will not be able to reinstall the axle retaining clip which is not actually needed. The locking hubs will be held on securely with the six bolts.
16. Complete, now repeat all steps on the right side.

Note: Some early Dana 25s and Dana 27s used short studs, part number A474. If you are installing wheel spacers you will need longer studs, use part number 610080 which are sold on the site. If you are not using wheel spacers, use part number 945451. It is also not necessary to use left hand studs any longer.