

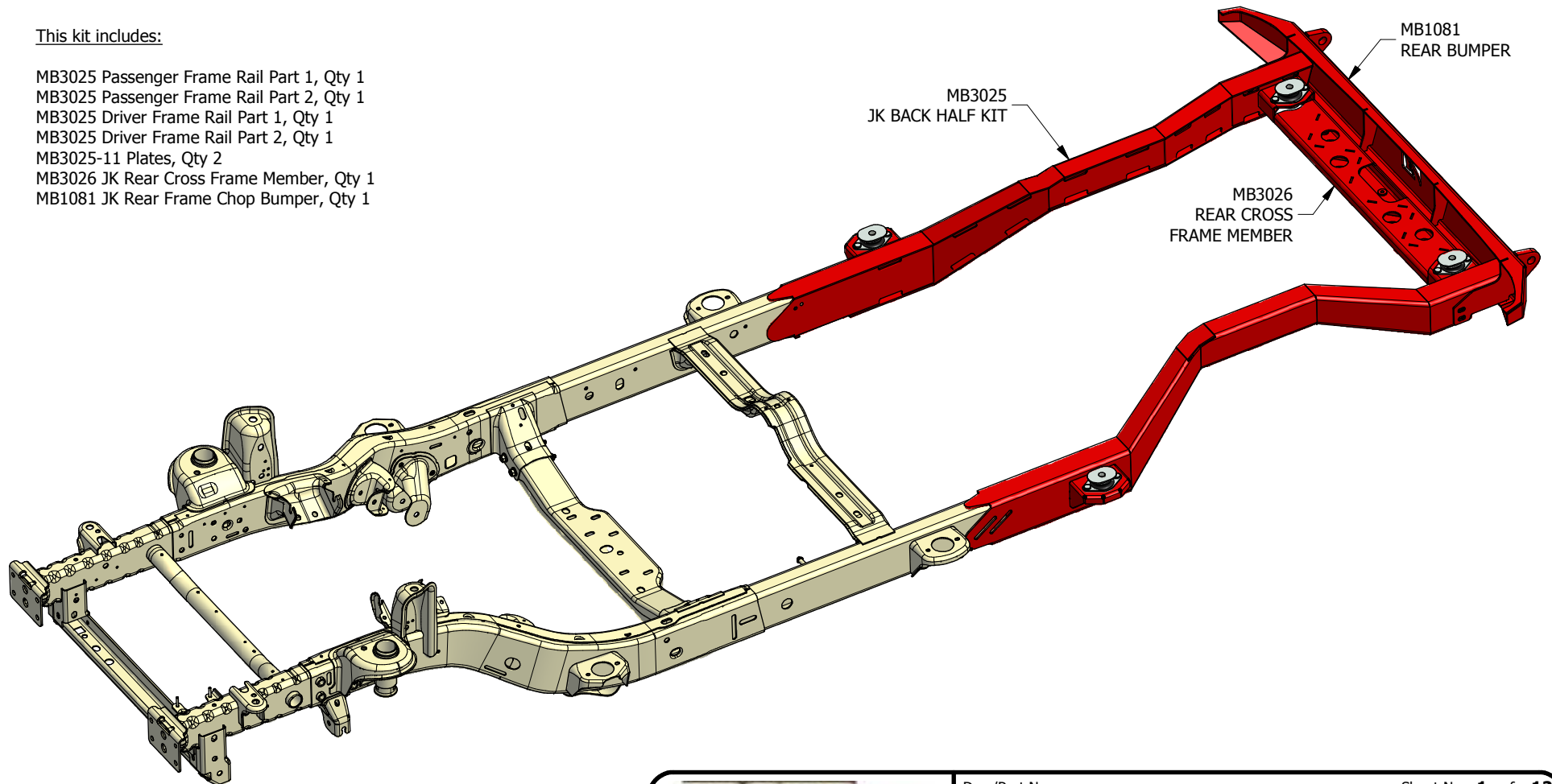
MB3025

JEEP JK BACK HALF KIT

INSTALLATION INSTRUCTIONS

This kit includes:

- MB3025 Passenger Frame Rail Part 1, Qty 1
- MB3025 Passenger Frame Rail Part 2, Qty 1
- MB3025 Driver Frame Rail Part 1, Qty 1
- MB3025 Driver Frame Rail Part 2, Qty 1
- MB3025-11 Plates, Qty 2
- MB3026 JK Rear Cross Frame Member, Qty 1
- MB1081 JK Rear Frame Chop Bumper, Qty 1



Dwg/Part No:
MB3025

Description:

Installation Instructions

Sheet No: **1** of **12**
Rev No: **0**

Mat'l:

STEP 1

PREPARATION

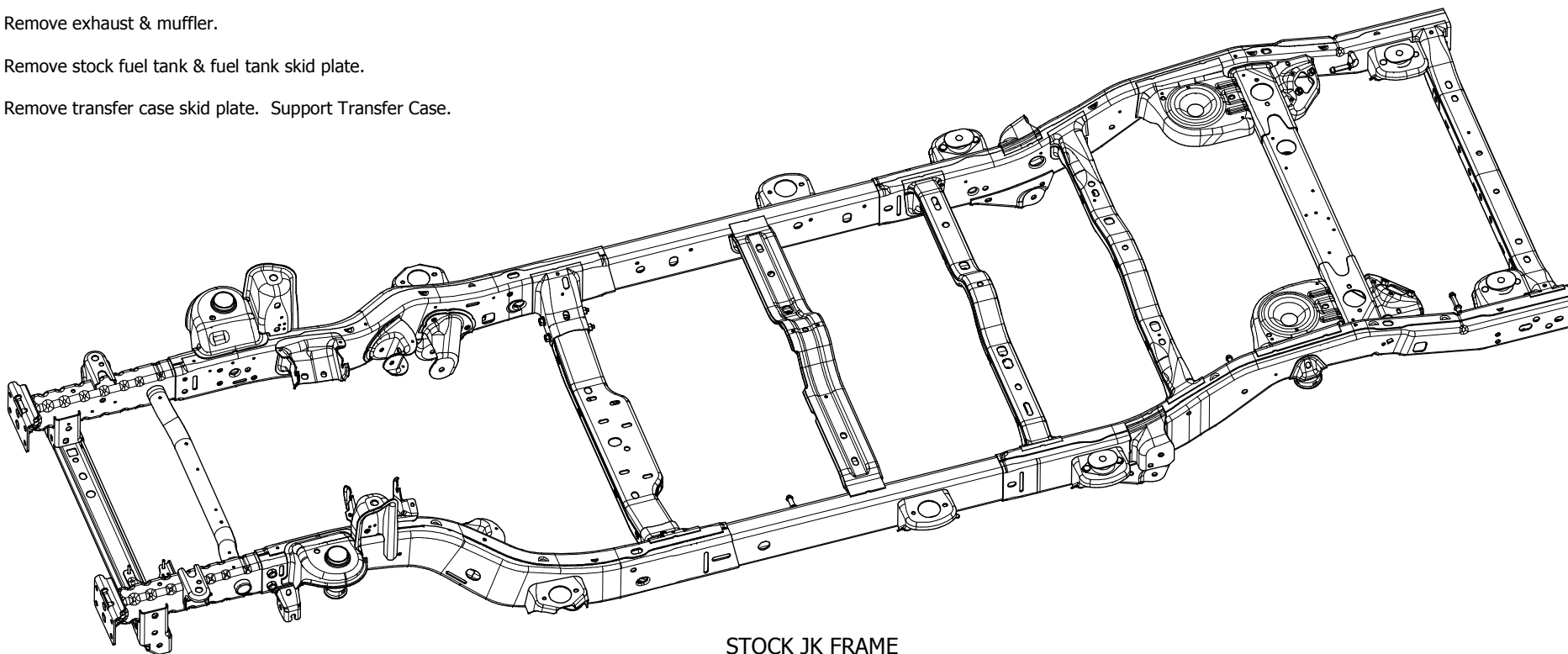
PREPARATION:

For simplicity & clarity, we only show the frame in these instructions.

These instructions show a 4 Door Jeep JK frame, however, the same process, cutting points & alignment points are identical with a 2 Door Jeep JK frame.

You **DO NOT** need to remove the body from the frame to install the Motobilt JK Back Half Kit MB3025. In fact, the stock body mounts will be used to locate the new frame rails during installation. The entire installation is intended to be done with a vehicle lift while the body remains on the frame.

1. Support the frame & body. You will be removing the rear portion of the frame, thus, the front & rear of the body must also be supported, as well as the frame.
2. Remove rear bumper.
3. Remove rear tires, rear driveshaft, rear axle & all rear suspension components.
4. Remove exhaust & muffler.
5. Remove stock fuel tank & fuel tank skid plate.
6. Remove transfer case skid plate. Support Transfer Case.



STOCK JK FRAME



Dwg/Part No:

MB3025

Description:

Installation Instructions

Sheet No: **2** of **12**

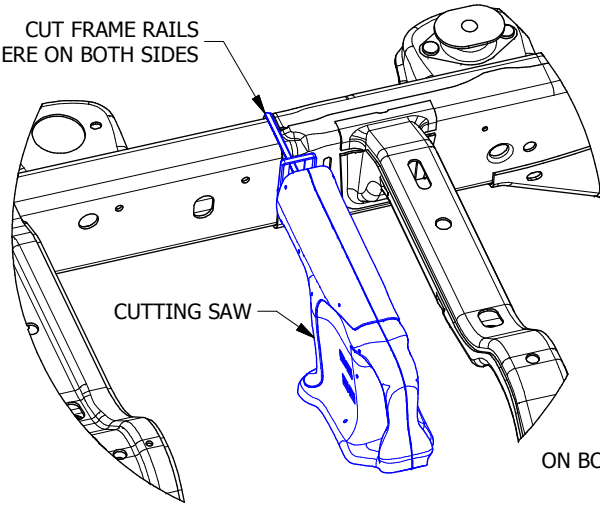
Rev No: **0**

Mat'l:

STEP 2

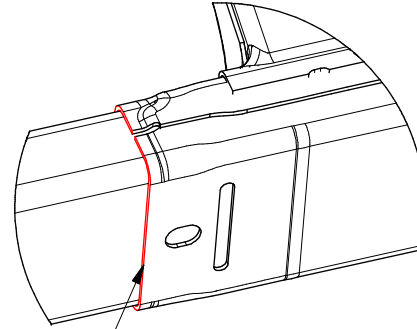
LOCATIONS OF FRAME CUTTING POINTS

CUT FRAME RAILS
HERE ON BOTH SIDES



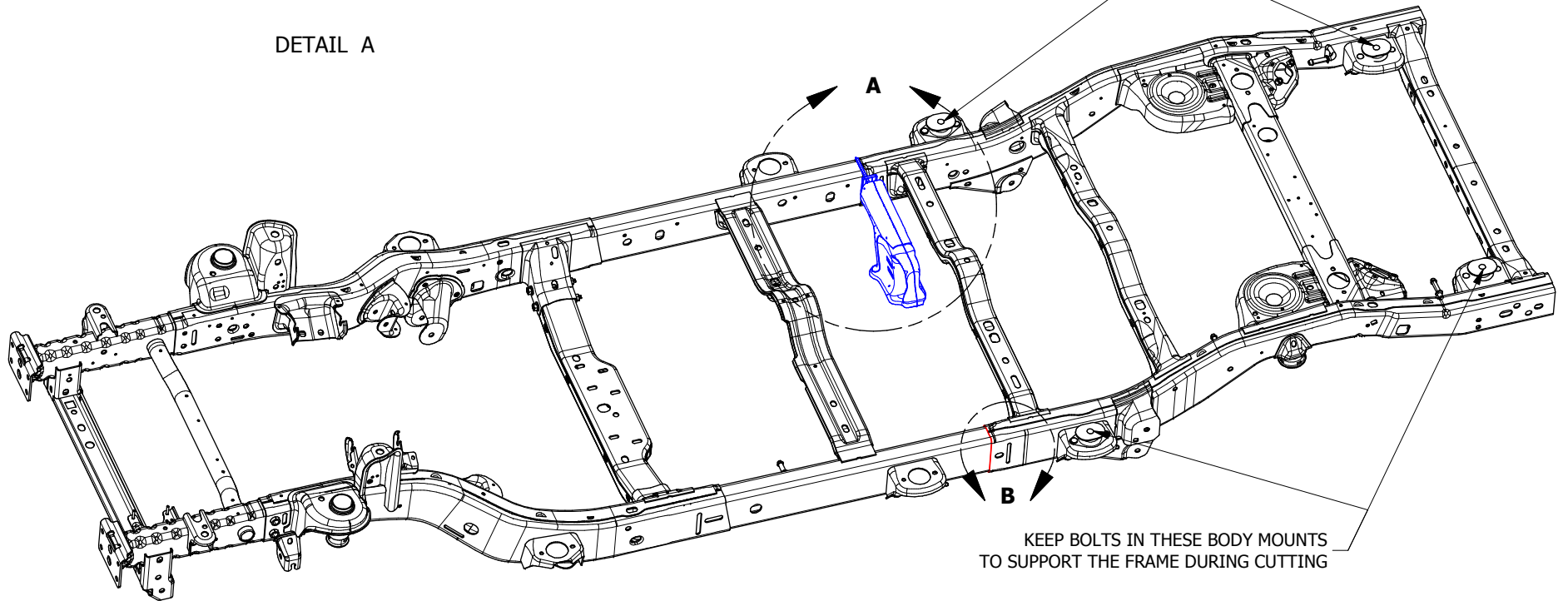
DETAIL A

USE THE EDGES OF THE
HYDROFORM STEEL AS CUTTING
POINT REFERENCES. SAME LOCATION
ON BOTH SIDES. NO MEASURING REQUIRED.



DETAIL B

KEEP BOLTS IN THESE BODY MOUNTS
TO SUPPORT THE FRAME DURING CUTTING



KEEP BOLTS IN THESE BODY MOUNTS
TO SUPPORT THE FRAME DURING CUTTING



Dwg/Part No:
MB3025

Description:

Installation Instructions

Sheet No: **3** of **12**
Rev No: **0**

Mat'l:

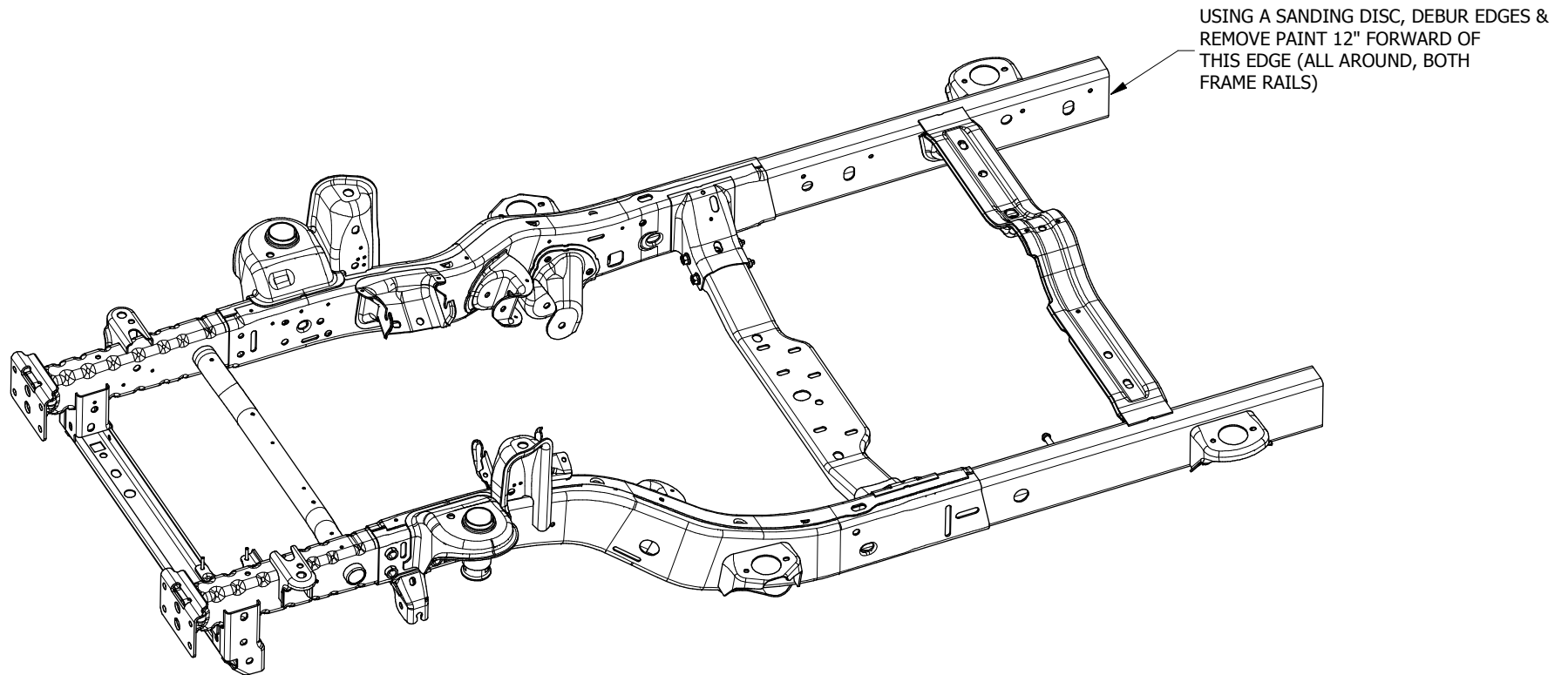
Unbolt the six (6) body mounts that support the rear portion of the frame.

Remove & discard rear portion of stock frame.

Prep ends of frame rails.

STEP 3

REMOVE REAR FRAME



Dwg/Part No:

MB3025

Description:

Installation Instructions

Sheet No: **4** of **12**

Rev No: **0**

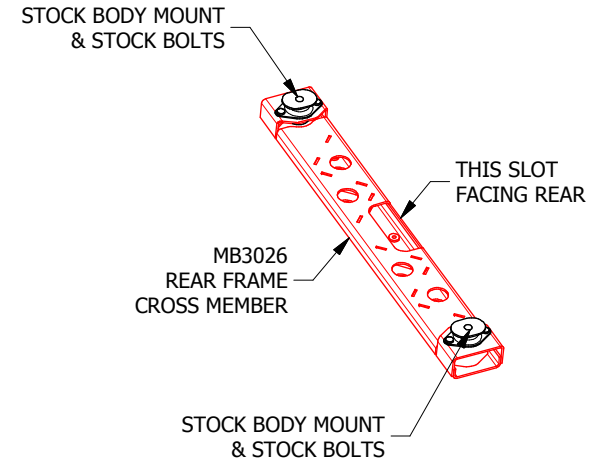
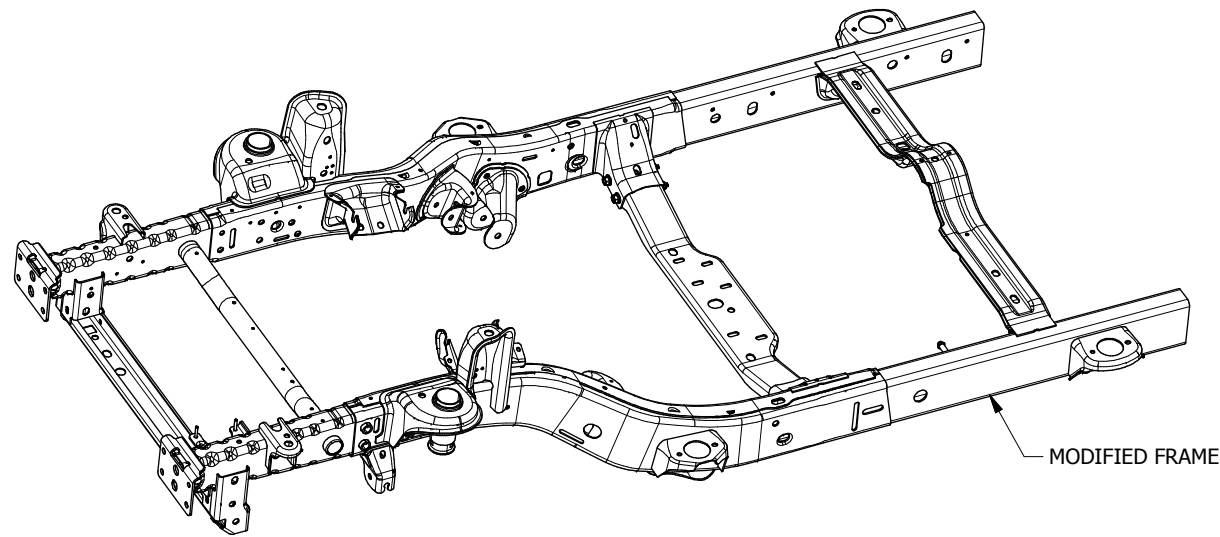
Mat'l:

STEP 4

Bolt two (2) stock body mounts to MB3026 Rear Cross Frame Member using the stock body mount nuts.

Use the long stock body mount bolts to then fasten MB3026 to the underside of body.

INSTALL MB3026 REAR CROSS FRAME MEMBER



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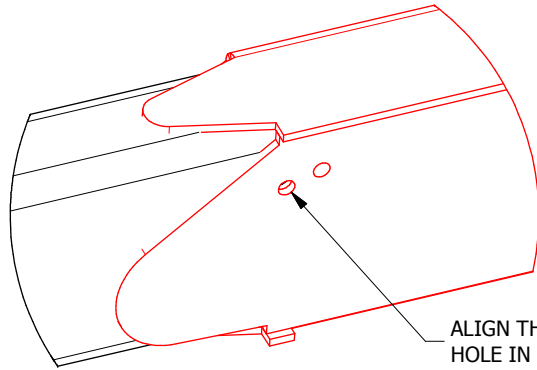
Installation Instructions

Sheet No: **5** of **12**
Rev No: **0**

Mat'l:

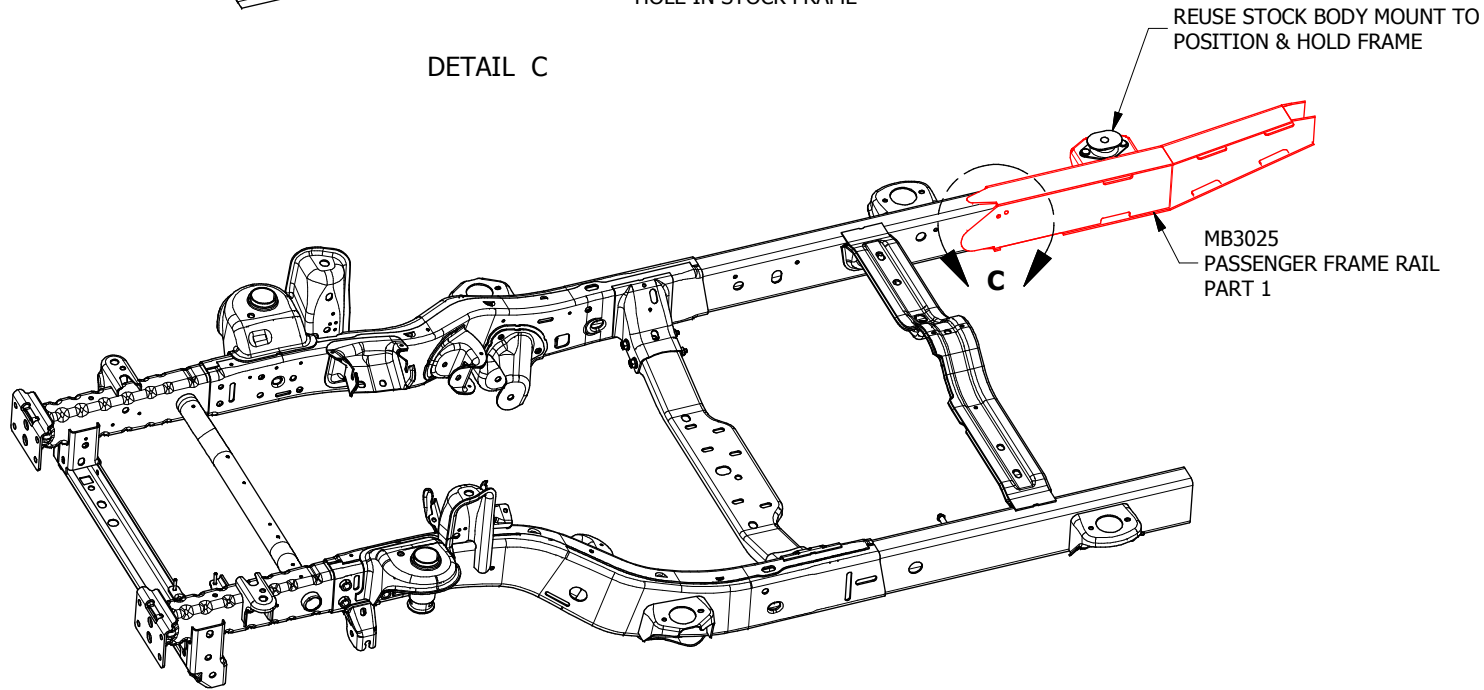
STEP 5

POSITION PASSENGER FRAME RAIL "PART 1"



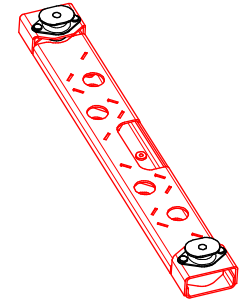
ALIGN THIS HOLE WITH HOLE IN STOCK FRAME

DETAIL C



REUSE STOCK BODY MOUNT TO POSITION & HOLD FRAME

MB3025 PASSENGER FRAME RAIL PART 1



Dwg/Part No:
MB3025

Description:

Installation Instructions

Sheet No: **6** of **12**

Rev No: **0**

Mat'l:

STEP 6

POSITION PASSENGER FRAME RAIL "PART 2"

ALIGN EDGES FROM "PART 1"
WITH EDGES FROM "PART 2"
THEN TACK WELD

INSIDE VIEW

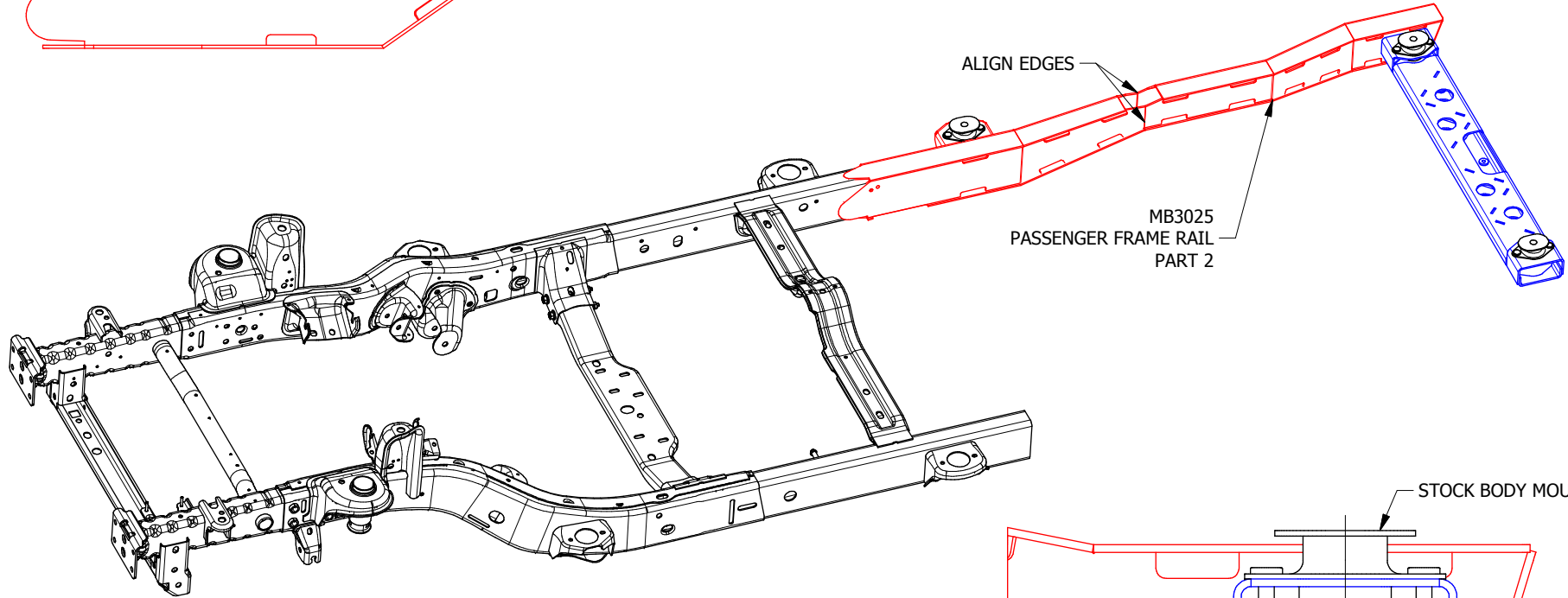
ALIGN EDGES

MB3025
PASSENGER FRAME RAIL
PART 2

STOCK BODY MOUNT

MB3026

NO WELD YET

POSITION UNDERSIDE OF PLATE
ON FRAME RAIL TO BE FLUSH WITH
UNDERSIDE OF MB3026Dwg/Part No:
MB3025

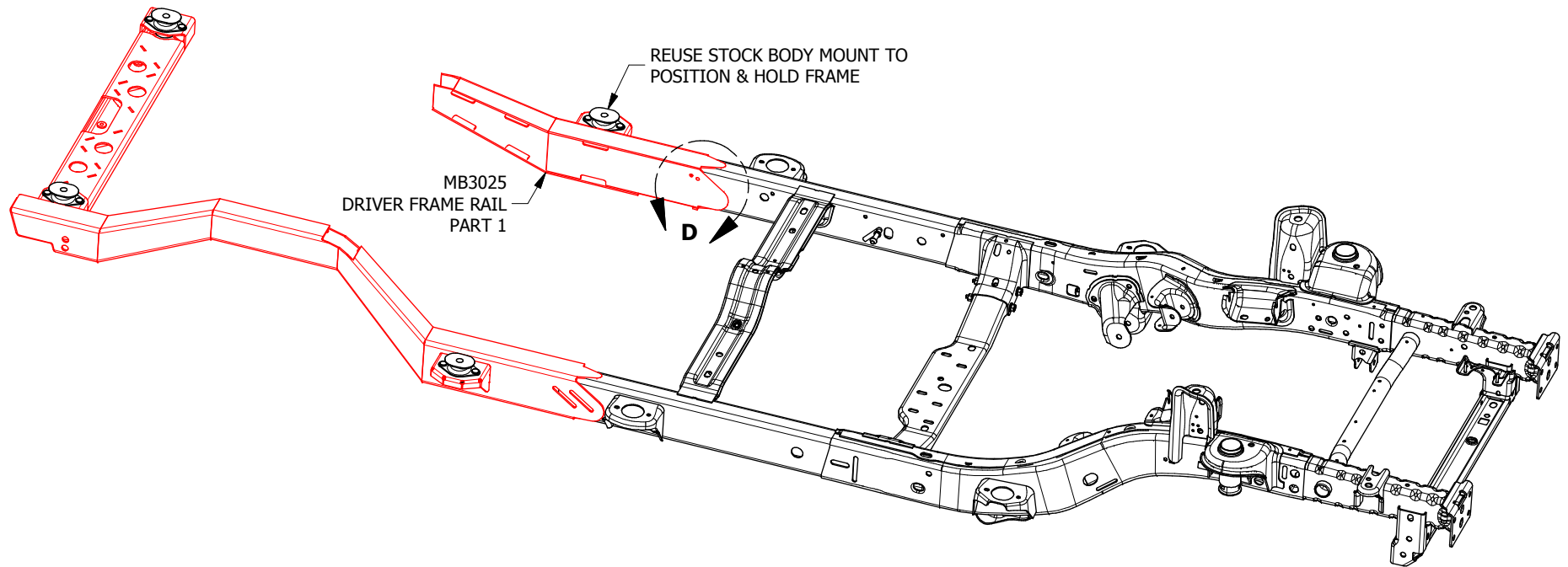
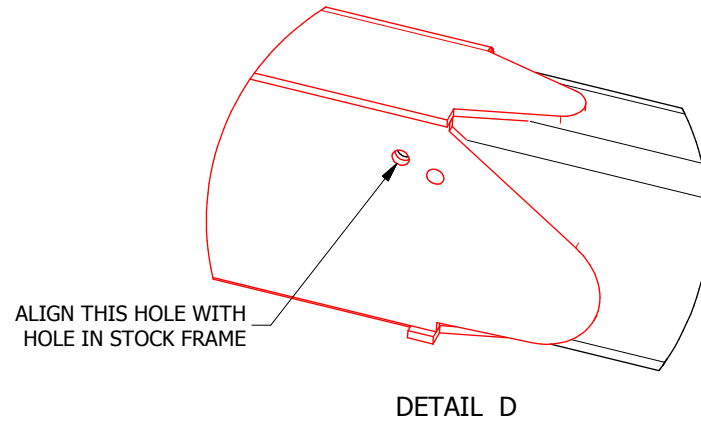
Description:

Installation InstructionsSheet No: **7** of **12**
Rev No: **0**

Mat'l:

STEP 7

POSITION DRIVER FRAME RAIL "PART 1"



Dwg/Part No:
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Description:

Installation Instructions

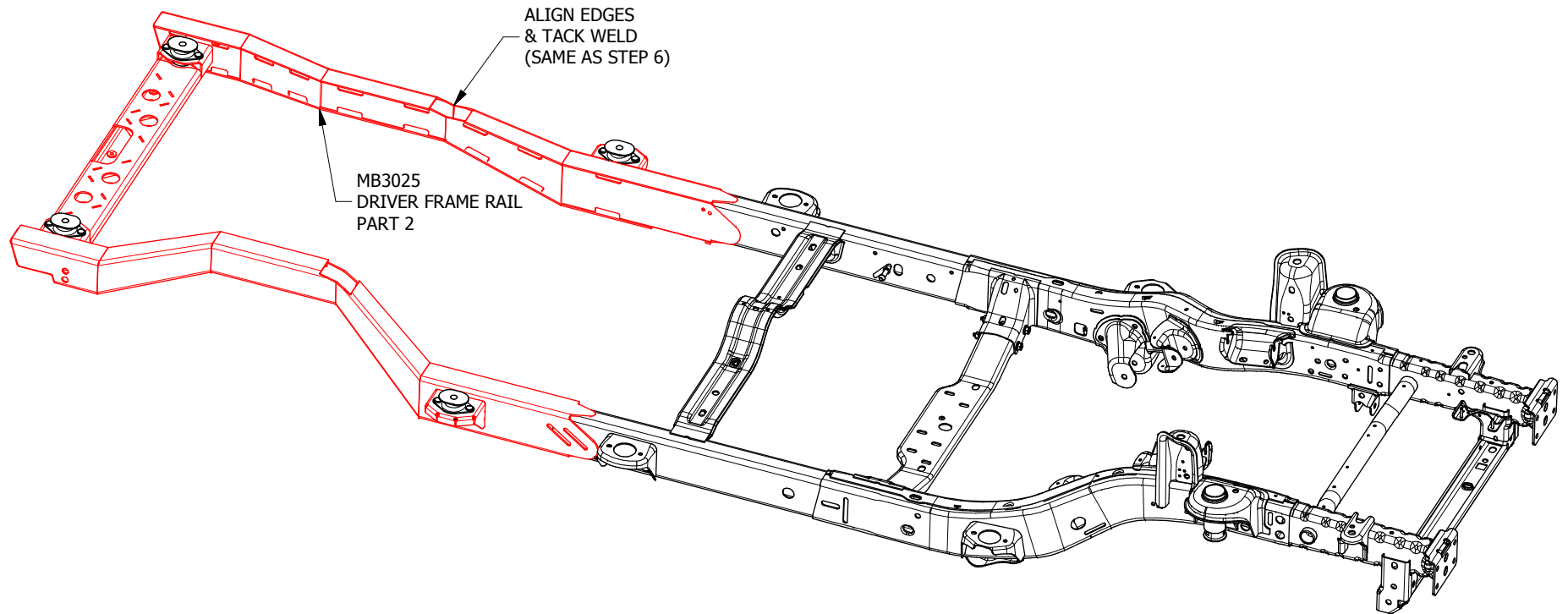
Sheet No: **8** of **12**

Rev No: **0**

Mat'l:

STEP 8

POSITION DRIVER FRAME RAIL "PART 2"



Dwg/Part No:

MB3025

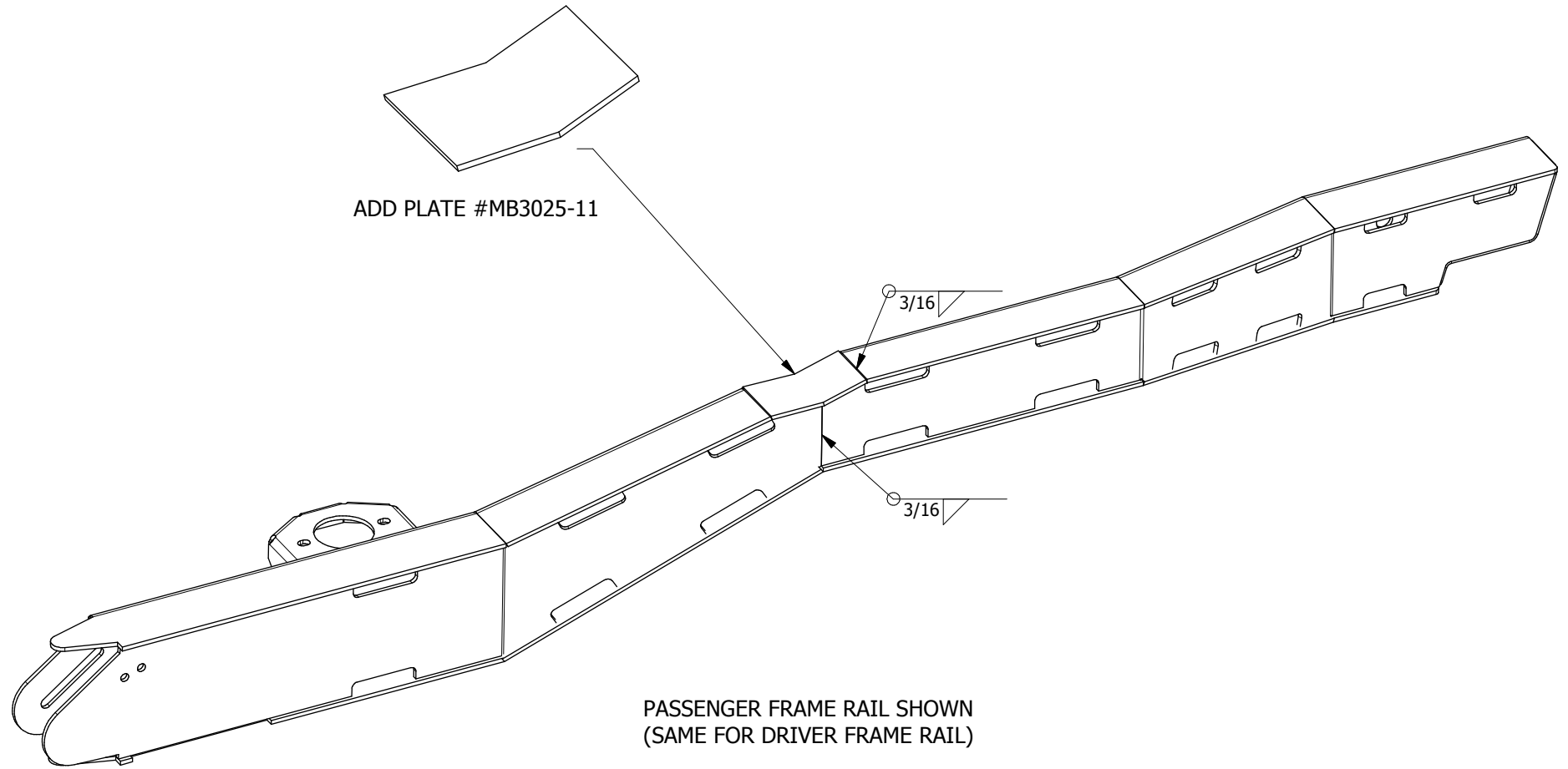
Description:

Installation InstructionsSheet No: **9** of **12**Rev No: **0**

Mat'l:

STEP 9

REMOVE BOTH FRAMES & FULLY WELD



Dwg/Part No:
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Description:

Installation Instructions

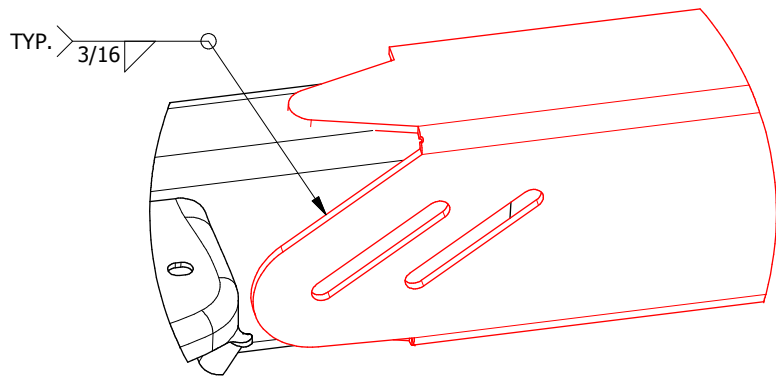
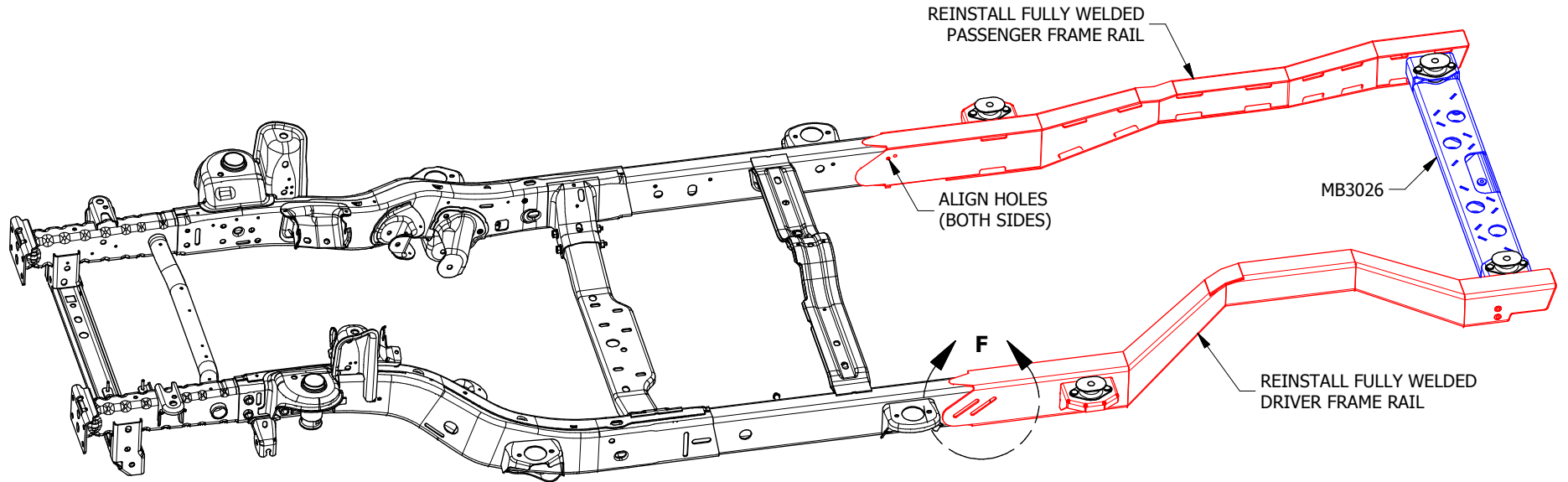
Sheet No: **10** of **12**

Rev No: **0**

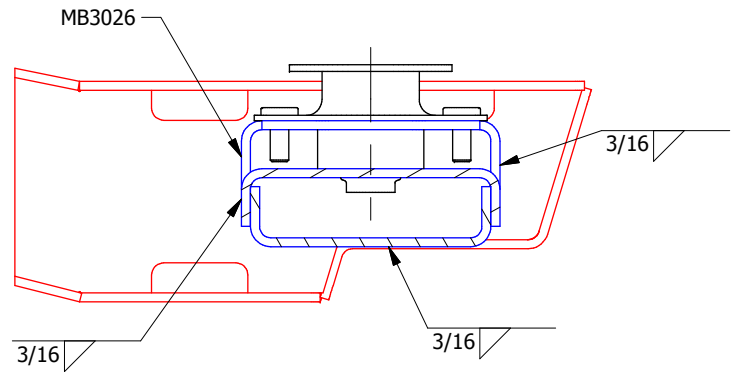
Mat'l:

STEP 10

INSTALL WELDED FRAME RAILS



DETAIL F



FULLY WELD MB3026 TO BOTH FRAME RAILS



Dwg/Part No:
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Description:

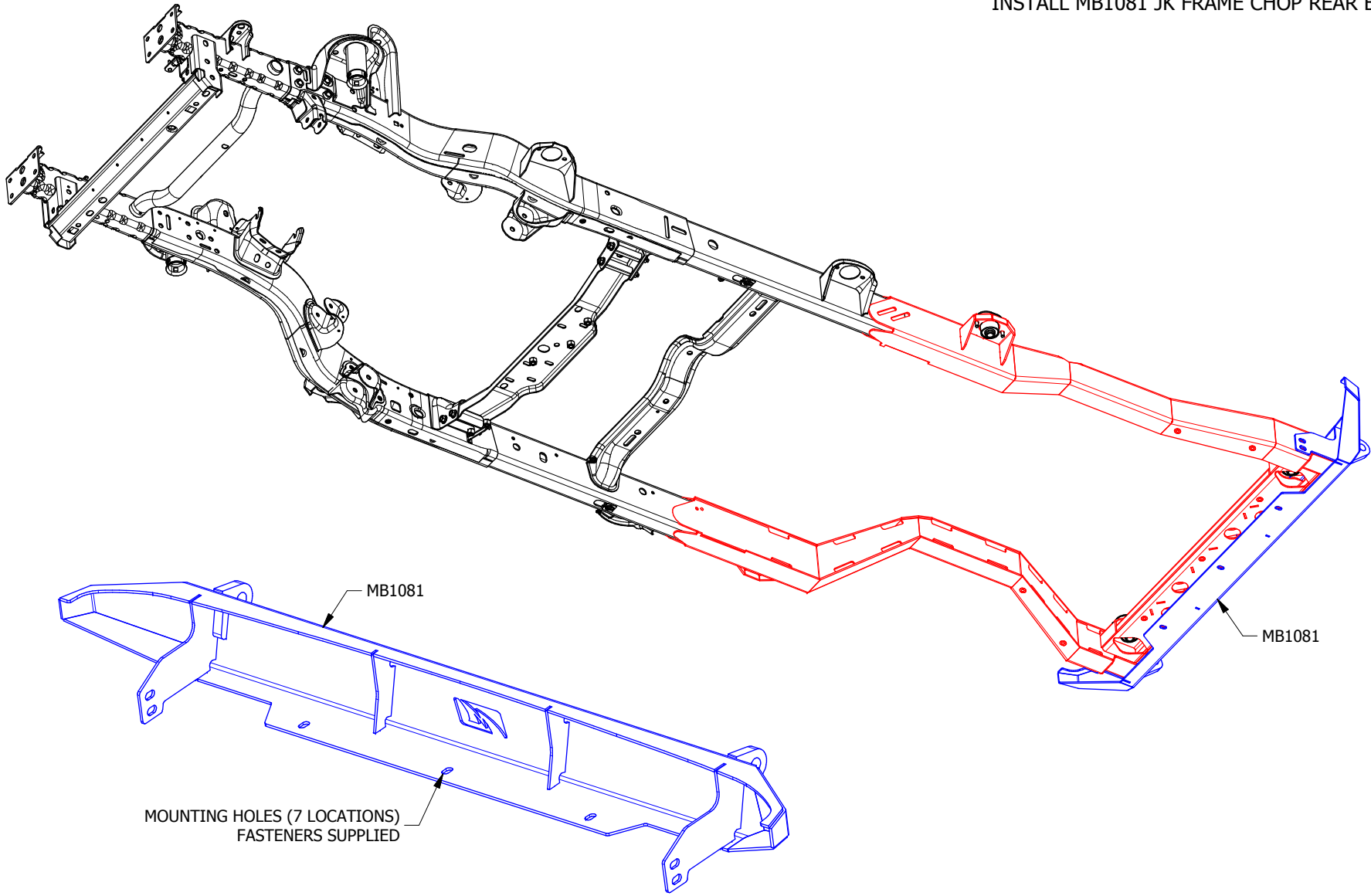
Installation Instructions

Sheet No: **11** of **12**
Rev No: **0**

Mat'l:

STEP 11

INSTALL MB1081 JK FRAME CHOP REAR BUMPER



Dwg/Part No:
MB3025

Description:

Installation Instructions

Sheet No: **12** of **12**

Rev No: **0**

Mat'l: