

IRON ROCK OFF ROAD

WJ Rear Axle Swap Bracket Kit

1-877-919-JEEP www.ironrockoffroad.com

Parts Checklist:

- Invoice
- Iron Rock logo decal (1)
- Bump stop cup 88140 (2)
- Left LCA mount 92189 (1)
- Right LCA mount 92190 (1)
- Over axle cradle gusset 92191 (1)
- Shock mount 92192 (2)
- Coil spring pad 92193 (2)
- Spring pad gusset 92194 (4)
- Spring pad gusset w/ E-brake 92195 (2)
- Sway bar mount 92196 (2)
- Coil retainer spacer 92199 (2)
- Right truss 92200 (1)
- Left truss 92201 (1)
- Over axle cradle 92202 (1)
- Coil spring retainer 85021 (2)
- Brake hose mount 92086 (2)

#28 - E-Brake Cable/Shocks Hardware (1)

- 1/4-20 x 1 hex bolt (2)
- 1/4-20 hex nut (2)
- 5/16-18 x 1 hex bolt (2)
- 5/16-18 hex nut (2)
- E-brake cable connector bracket 92085 (2)
- E-brake cable mounting plate 92084 (2)



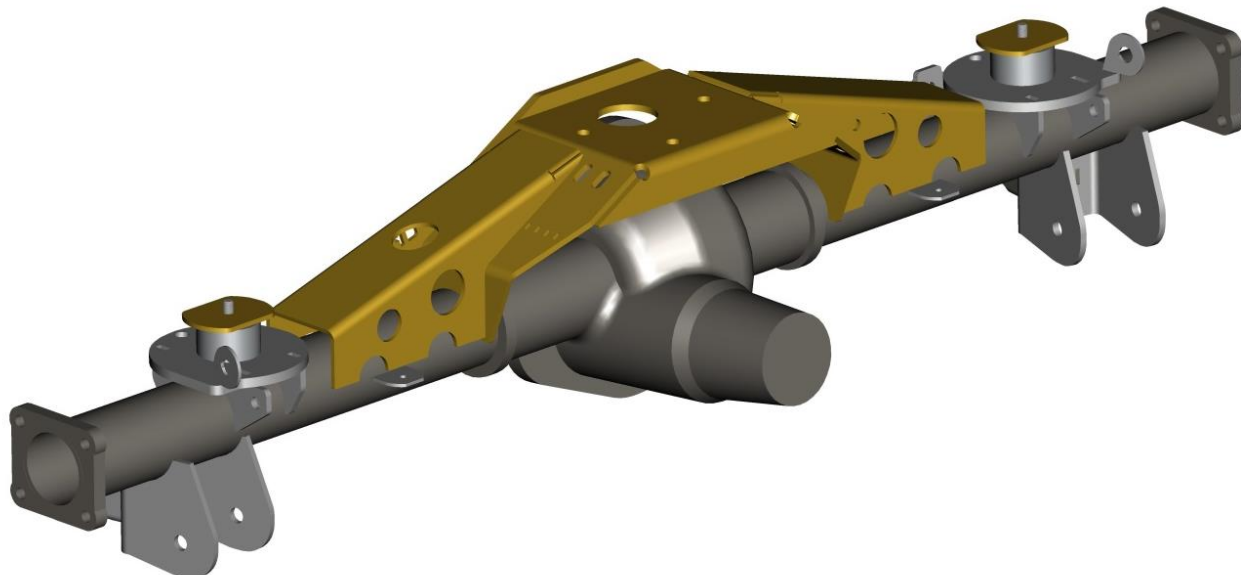
92085
E-brake Cable Connector

#121 - Shock/Coil Retainer Hardware (1)

- M12 x 70 cl10.9 hex bolt (2)
- M12 cl10.9 hex nut (2)
- M10 x 60 cl8.8 carriage bolt (2)
- M10 cl10.9 nylock nut (2)
- 3/8 USS washer (2)
- 7/16 USS washer (4)

#193 - WJ Rear Axle Cradle Hardware (1)

- M14-2.0 Plain hex nut (3)



Safety Warning: *Important! Read Before Installation.*****

We recommend that this system be installed by a qualified professional. Knowledge of suspension component function is necessary for safe installation and post installation inspections. We recommend that all welds be performed by a certified welder. A weld failure may result in serious injury or death, in addition to severe vehicle damage. Be sure to re-torque all suspension components after the first 100 miles of use, and frequently inspect all safety critical suspension components.

Before you begin:

- Read all safety warnings.
- Read and understand installation instructions.
- Check all suspension components for wear and replace as needed.
- Contact Iron Rock Off Road with any questions before, during, or after installation.
- Ensure that all parts are present and in good condition using the included shipping checklist.
- Be sure you have the following tools and supplies:
 - Floor jack and jack stands
 - Basic hand tools
 - Welder
 - Angle finder
 - Measuring tape
 - Fabrication tools such as angle grinders and cut-off wheels
 - Source any necessary brake parts and driveline parts
 - Source any ABS/Locker wiring parts

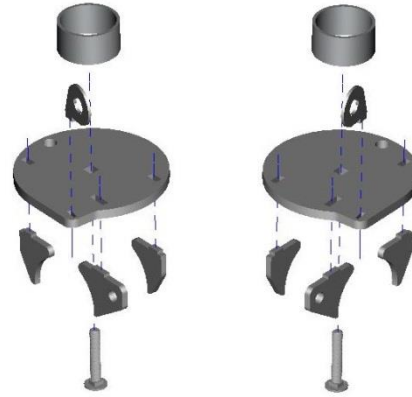


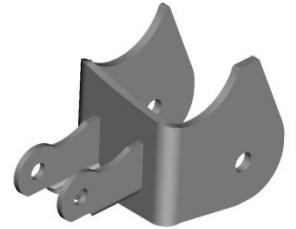
Fig.1

Inspect Donor Axle:

1. Check donor axle for straightness and bent axle shafts.
2. Check condition of ring and pinion and all bearings.
3. Verify that ring and pinion ratio matches your front axle assembly.

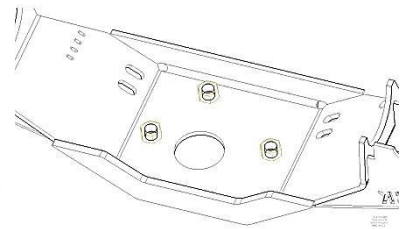
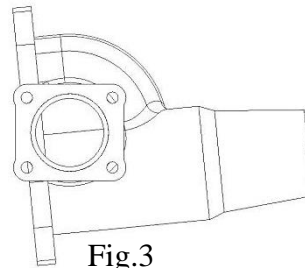
Prepare Donor Axle:

4. Remove all leaf spring, coil spring, control arm, and shock mounts.
5. Remove any remaining mounting brackets.
6. Be careful not to cut into the axle tube.
7. Grind off any weld leaving straight, smooth tubes.



Coil Buckets: (Figure 1)

8. Place 2 spring pad gussets into slots in coil plate, tack weld in place.
9. Place spring pad gusset with hole into slot in coil plate, tack weld in place from underside.
10. Place carriage bolt into center hole, tack weld in place.
11. Center coil retainer tube, tack weld in place on the inside of the tube.
12. Place brake hose bracket into slot in coil plate, tack weld in place.
13. Repeat with coil plate flipped over for opposite side.
14. Straighten any plates as needed.
15. Fully weld one side of each gusset plate (either side is fine).
16. Fully weld both sides of brake cable mount.
17. Weld coil retainer tubes on the inside. Two 1" stitch welds per tube is enough.
18. Strong tack welds are adequate for the carriage bolts.



Lower Control Arm Mounts: (Figure 2)

19. Place shock mount bracket into LCA bracket, tack weld in place.
20. Repeat for opposite side.
21. Fully weld each shock mount around the outside.

*****Refer to Figure 8 for set-up measurements*****

22. Support axle housing on jack stands.
23. Set pinion to 6.5 degrees pointing up (Figure 3).
24. Weld 3 M14 nuts to bottom of center truss. Weld 2 of 6 flats on each nut (Figure 4).
25. Place over axle cradle on top of bare axle housing and set at 0 degrees rotation (level). (Figure 5)
26. Center axle cradle side to side. Make sure X measurements are the same, fully weld to axle.
27. Place axle cradle gusset on back surface of cradle and position it so that the top surface is approx. 5/8" above the top surface of the cradle, tack weld in place.
28. ***If installing on a Ford 8.8, drill out etched hole on left truss for breather tube access*** (Figure 7).
29. Position right coil bucket, set at 0 degrees rotation and tack weld in place (Figure 6 & 8).
30. Repeat for left coil bucket.

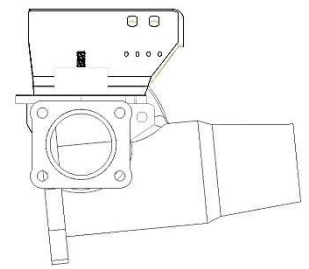
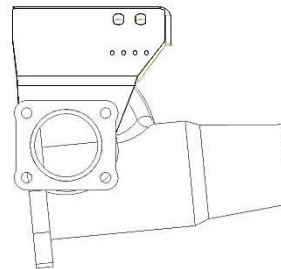


Fig.5

Fig.6

31. Position sway bar mounts on axle, rotate up to sit flush with the bottom of coil buckets, tack weld in place.
32. Position lower control arm mounts, set vertically at 0 degrees and tack weld in place.
33. Set side trusses flush to the axle cradle with lettering facing the rear, tack weld in place.
34. If you purchased the E-brake option, position E-brake cable retainer, tack weld in place (Figure 8).
35. With everything in place, fully weld brackets to axle. Use proper heat settings and alternate welding operations from front to rear and left to right. Perform one weld at left rear then one weld at left front, then right front, then right rear. Weld one side of each plate.

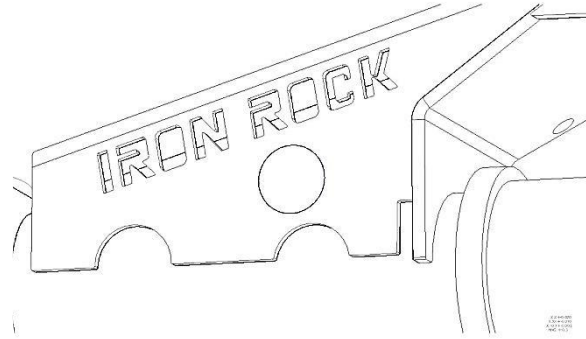
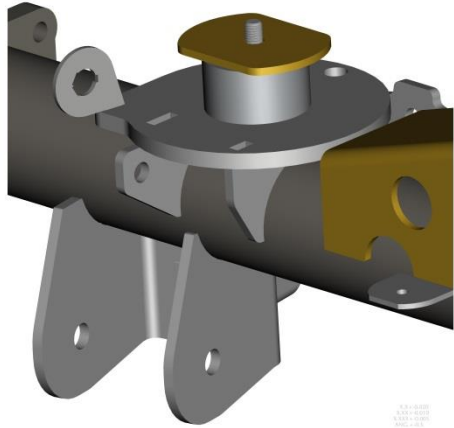


Fig.7

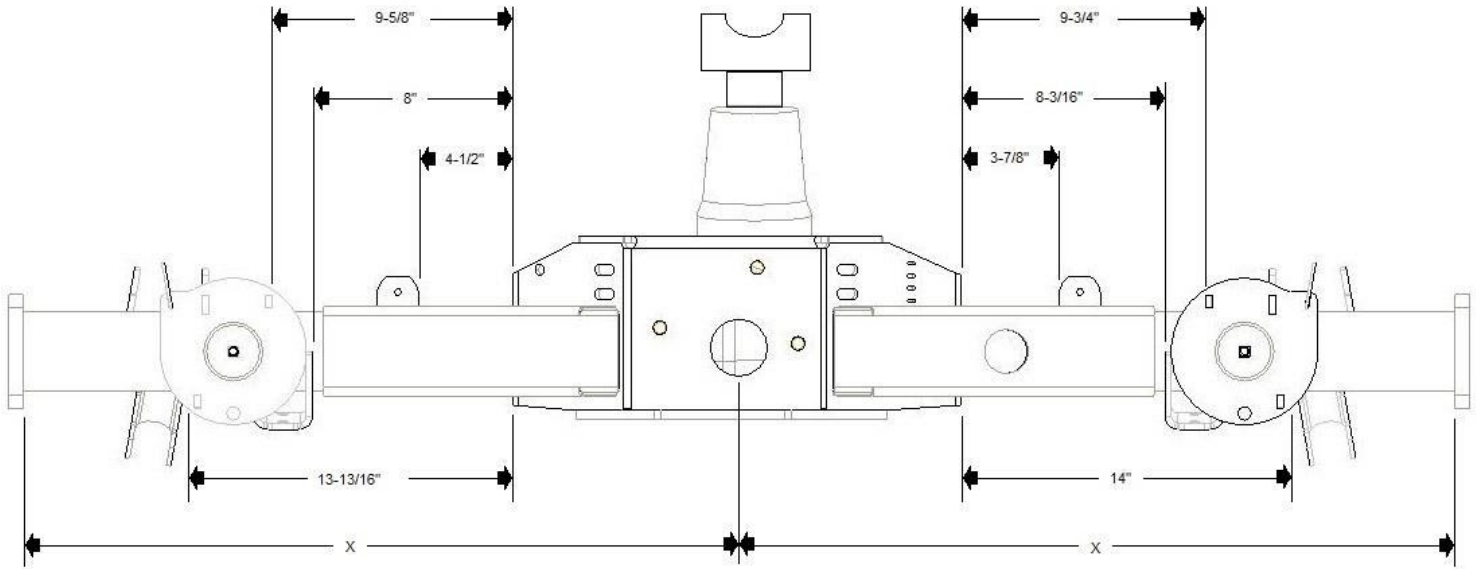


Fig.8