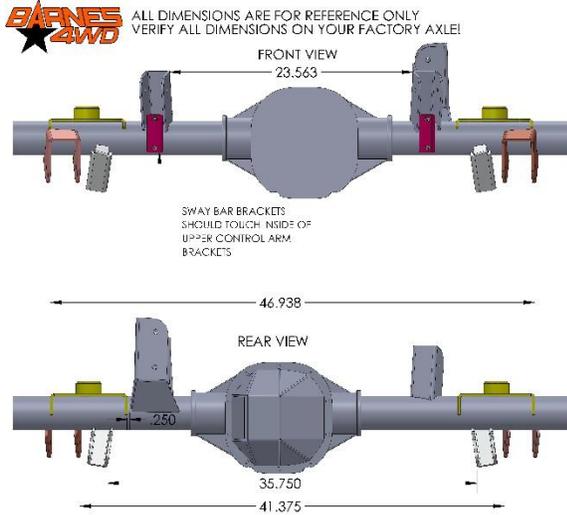


Installation Instructions:

Jeep TJ 8.8 Swap Kit



- Installation of product requires a competent welder!
- Refer to your factory service manual for information regarding removal of the factory rear axle.
- Due to variances in lift kits, axle models, and other suspension modifications, all bracket locations need to be verified off from your currently installed axle!
- An adjustable track bar is recommended.
- This kit contains no provisions for brake line, driveshaft, and emergency brake modifications. They are the responsibility of the end user.

Tools Needed

- Welding machine with the capability of welding at least 1/4" thick steel
- Tape measure
- Angle Finder
- Appropriate safety equipment

Step 1:

Measure the pinion angle of the existing axle in the Jeep. This angle is usually between 12°-17° but will vary with different amounts of lift. Record this number, all brackets will be welded to the 8.8 based off from this information. Take your 8.8 and secure it on jack stands or by other method with the same pinion angle as the axle currently in the jeep. You do not want the pinion angle of the 8.8 to change at any point during installation.

Step 2:

Find the center of the axle, measure from the backing plate flanges on either end of the axle to find center. Base all measurements to locate new brackets on the axle using this centerline measurement.

Step 3:

Locate the position of the upper control arm brackets using your factory axle for reference. Tack weld the brackets in place.

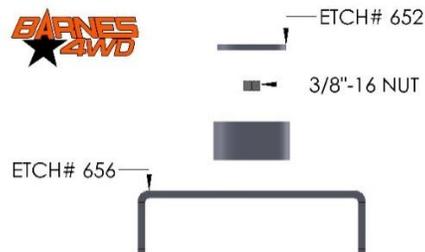
Step 4:

Measure the position of the track bar bracket on your factory axle. Place the new track bar bracket on the axle in the same location. The track bar bracket should contact the back of the upper control arm bracket when placed perpendicular to the ground. If it does not contact, the upper control arm brackets may need to be rolled forward or back on the axle tube slightly.

Step 6:

Now it is time to assemble the coil spring mounting bracket. There are 4 parts to each bracket, 1 base piece (etch# 656), 1 DOM sleeve, 1 3/8"-16 nut, and 1 cap (etch# 652). Place the nut on the cap and weld it in the center. Place the cap and nut assembly on the top of the DOM sleeve, center and weld in place. Now place the cap, nut, DOM sleeve assembly on top of the base and weld in place. The DOM sleeve should slide in the hole provided in the base. Refer to image below for assembly order.

Repeat this step for the other coil spring bracket.



Step 7:

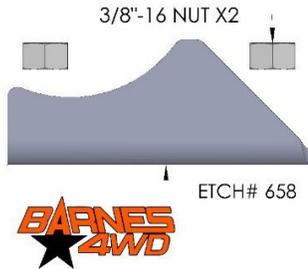
Place the coil spring brackets on the axle tube. Using your factory axle measure the location of the coil spring brackets. Level the coil spring brackets on the axle (do not change the pinion angle of the axle!). Tack the brackets in place when the location has been verified.

Step 8:

The lower control arm brackets now need to be installed. Using your factory axle measure the location of the stock lower control arm brackets (remember to measure from the inside of the brackets, the brackets provided in this kit are thicker than the factory brackets). Place the provided lower control arm brackets in the proper location, the brackets should angle in towards the center of the Jeep when properly placed. Tack the lower control arm brackets in place.

Step 9:

The sway bar brackets now need to be assembled. You will need 2 of the provided 3/8"-16 nuts and one of the brackets per assembly. Place the nuts on the bracket at the center of the two holes and weld into place. Do this for both brackets. Image below shows assembly order.



Step 10:

Using your factory axle for reference measure the location of the sway bar brackets. Place the sway bar brackets on your 8.8 and tack into place. They sway bar brackets will generally contact one side of the upper control arm brackets when properly positioned.

Step 11:

Measure the location of the shock brackets on your factory axle. Use this measurement to locate the brackets on the 8.8. If your Jeep has been lifted the brackets may need to be rotated up to provide clearance for the shock to the coil spring bracket. Tack the brackets in place when properly located.

Step 12:

Install the axle in the Jeep and cycle the suspension to check for clearance to all parts of the jeep and the axle. Depending on the amount of lift you have a new hole may need to be drilled in the track bar bracket to properly center the axle in the Jeep.

Step 13:

Remove the axle and finish welding all brackets in place. Make small welds and move around on the housing to avoid pulling or warping the axle.

Step 14:

Finish the axle with the paint of your choice and install the axle in the Jeep.

Congratulations!

You are now finished installing your TJ 8.8 axle swap kit.

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