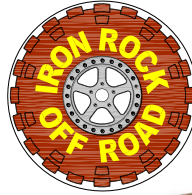


Dana 30/44 Inner Axle Tube Sleeve Kit Installation Instructions



Iron Rock Off Road, Inc.

952-210-7185

Website: www.ironrockoffroad.com

E-mail: Contactus@ironrockoffroad.com

Shipping Checklist:

Box 1 (36x4x4)

- Instructions
- Invoice
- Iron Rock Off Road logo decal (1)
- Driver Side Tube Sleeve (1)
- Passenger Side Tube Sleeve (1)

Safety Warning: *Important! Read before installation.*****

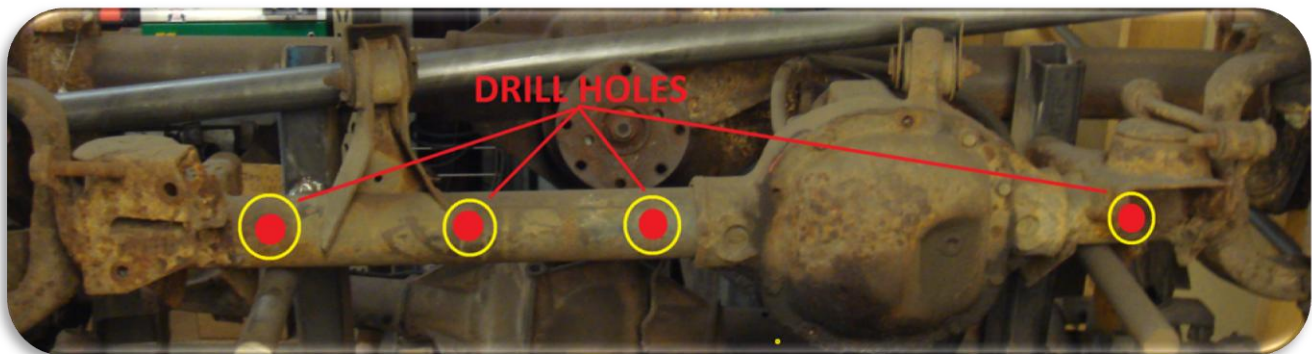
We recommend that these inner axle tube sleeves are welded by a certified professional.

Before you begin:

- o Read all safety warnings.
- o Read and understand installation instructions.
- o Contact Iron Rock Off Road with any questions before, during, or after installation.
- o **Ensure that all parts are present and in good condition per attached shipping checklist!**

Installation:

1. Lift vehicle and place securely on jack stands.
2. Remove front tires.
3. Remove brake calipers, brake rotors, and wheel bearing hub assembly. No need to separate axle shafts from hub assembly.
4. Remove differential cover and let fluid drain.
5. Using a number stamp or center punch, mark the bearing caps to ease re-installation. (When bearing caps are being re-installed they must be in the same position and location as where they came from)
6. Remove the 4 main bearing cap bolts and main caps from the differential housing.
7. Remove differential carrier. (Note: using a pry bar and combination wrench to pry the carrier out is an easy way to remove the carrier, **be sure to not damage gear set during removal!**)
8. Clean axle tubes by spraying the axle tubes with brake parts cleaner, then push shop towels through to the center of the differential using a piece of tubing, or even a broom stick. If replacing inner axle seals, remove them now. (NEW inner axle seals are recommended, but not required)
9. Once tubes are thoroughly cleaned mark the axle tubes to be drilled front and back. 3 holes front and back on the long side tube, 1 hole front and back on the short side tube.
10. Drill axle tubes with 1/2" or 5/8" drill. (**Hole location is not critical, place the holes wherever suits your needs best**)



11. Slide tube sleeves into axle tubes until flush with outside edge of tube. (Tip: using a large hammer and block of wood drives the sleeves in very easily.)
12. Be sure tube sleeves do not contact inner axle seals.
13. Weld in all holes and weld sleeves to the outer edge of the axle tubes.
14. Install new inner axle seals now if you wish to do so.
15. Re-install differential carrier, main caps, and torque the 4 main cap bolts to 55 ft/lbs.
16. Re-install differential cover, axle shafts, wheel hubs, brake rotors, and brake calipers.
17. Re-install front tires, torque lug nuts, and lower the Jeep back onto the ground.
18. Re-fill differential with appropriate gear lube.

Adjustments and Safety Inspection:

19. Check all components for clearance for suspension to fully cycle up and down. Make adjustments as needed.
20. Go for a short test drive.

* Re-torque all fasteners, including lug nuts, after 100 miles, and frequently inspect all safety critical suspension components.