

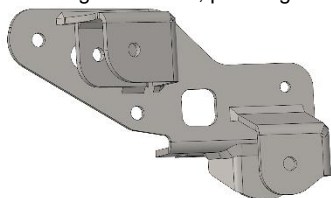
IRON ROCK OFF ROAD

JK 3.5" ROCK-LINK PRO
Lift Kit Instructions

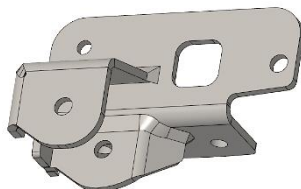
1-877-919-JEEP www.ironrockoffroad.com

Parts Checklist:

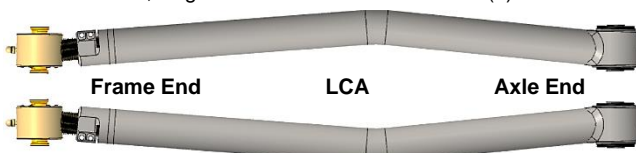
- ☐ Instructions
- ☐ Iron Rock Off Road Logo Decal 10001 (1)
- ☐ Rock-Link decal 13287 (2)
- ☐ Ironrockoffroad.com decal (1)
- ☐ 3.5" Front coil spring 96027 (2)
- ☐ 3.5" Rear coil spring 96028 (2)
- ☐ JK 0-8" front track bar 80000 (1)
- ☐ JK 0-8" rear track bar 80005 (1)
- ☐ Track bar threaded male end 92004 (2)
- ☐ Rear Track Bar Bracket 80064 (1)
- ☐ Front sway bar link 10.75" center to center 92146 (2)
- ☐ Rear sway bar link 10" center to center 80138 (2)
- ☐ JK Rear Bump Stop Spacer 2.5" 80058 (2)
- ☐ JK Front Bump Stop Spacer 2.75" 80049 (2)
- ☐ JK Rear Sway Bar Spacer 99077 (2)
- ☐ JK Rear Sway Bar Relocation Plate 80137 (2)
- ☐ JK Rear Coil Spring Retainer 80061 (2)
- ☐ Front Long arm mount, passenger side 80205 (1)



- ☐ Front Long arm mount, driver side 80204 (1)



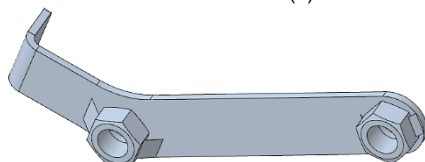
- ☐ Front LCA, bushing installed 77049 (2)
- ☐ LCA, Angled Threaded male end 91109 (2)



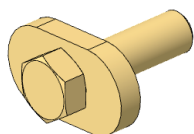
- ☐ Front UCA Passenger Side 80213 (1)
- ☐ UCA Front threaded male end 77054 (1)



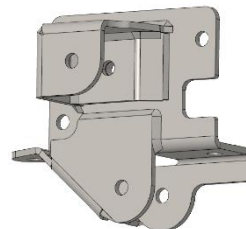
- ☐ Front 2 Hole Nut Plate 80219 (1)



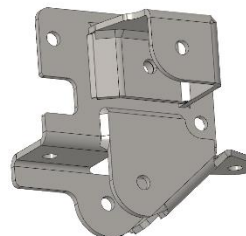
- ☐ Front Bolt Plate 80244 (2)



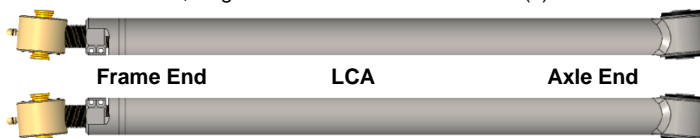
- ☐ Rear Long arm mount, driver side 80224 (1)



- ☐ Rear Long arm mount, passenger side 80229 (1)



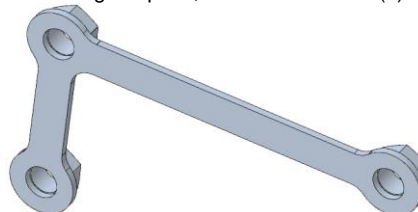
- ☐ Rear LCA, bushing installed 80238 (2)
- ☐ LCA, Angled Threaded male end 91109 (2)



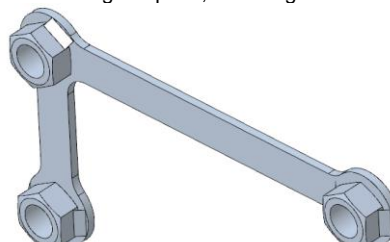
- ☐ Rear UCA Driver Side 80234 (1)
- ☐ Rear UCA Passenger Side 80235 (1)
- ☐ UCA threaded male end bushing installed, 80248 (2)



- ☐ Rear Long nut plate, Driver side 80241 (1)



- ☐ Rear Long nut plate, Passenger side 80242 (1)



- ☐ **#12 - Rear Sway Bar Spacer Hardware (1)**
 - ☐ 3/8 USS Flat Washer (4)
 - ☐ M10 x 60 hex bolt cl10.9 (4)
- ☐ **#21 - JK Front Coil Retainer Hardware (1)**
 - ☐ Top plate, thin, no notch 80162 (2)
 - ☐ 1/4" thick spacer, one notch 80163 (2)
 - ☐ Thin spacer, two notches 80164 (2)
 - ☐ 1/4" USS washer (2)
 - ☐ 5/16 x 1" Hex head bolt, gr8 (2)
 - ☐ 5/16-18 Serrated flange nut (2)
- ☐ **#65 - Adjustable LCA Clamping Hardware (4)**
 - ☐ 1/4"-28 x 1-1/8" socket head cap screw (4)
 - ☐ 1/4"-28 hex nut, gr8 (4)
- ☐ **#107 - Rear Track Bar Hardware (1)**
 - ☐ Track bar bushing sleeve 80003 (2)
 - ☐ Track bar bushing 80014 (4)
 - ☐ 7/8-14 Hex jam nut (1)
- ☐ **#127 - 2 5/8" 6 Bolt IRO Flex End Hardware (4)**
 - ☐ Inner race 91118 (2)
 - ☐ Thrust washer 91119 (2)
 - ☐ 2-5/8" Flex End Ball 91117 (1)
 - ☐ 10-32 x 1-3/4" Socket Head Cap Screw (6)
 - ☐ 10-32 Nylock Nut (6)
 - ☐ 1/4"-28 90° Grease zerk Fitting (1)
- ☐ **#166 - Front Track Bar Hardware (1)**
 - ☐ Track bar bushing half 80014 (4)
 - ☐ Track bar bushing sleeve 80003 (2)
 - ☐ Track Bar clamp 95044 (1)
 - ☐ 5/16-18 x 2 carriage bolt gr5 (1)
 - ☐ 5/16-18 hex flange nut (1)
- ☐ **#168 - 2 3/8" 8 Bolt IRO Flex End Hardware (3)**
 - ☐ Inner race 91139 (2)
 - ☐ Thrust washer 91138 (2)
 - ☐ 2-3/8" Flex End Ball 91140 (1)
 - ☐ 8-32 x 1-1/2" Socket Head Cap Screw (8)
 - ☐ 90 Degree 1/4"-28 Grease Zerk Fitting (1)
- ☐ **#195 - JK Rear Coil Retainer Hardware (1)**
 - ☐ Coil Spring Retainer Plate 85029 (2)
 - ☐ Upper Retainer Nut Plate 80146 (2)
 - ☐ 7/16 Flag nut with bend 80063 (2)
 - ☐ 7/16-14 x 2" Hex head bolt, gr8 (2)
 - ☐ 7/16-14 x 1" Hex head bolt, gr8 (2)
 - ☐ 7/16 SAE washer (2)
- ☐ **#196 - JK Rear Track Bar Bracket Hardware (1)**
 - ☐ M14 x 80 hex bolt, cl10.9 (1)
 - ☐ M14 nylock flange nut (1)
 - ☐ Spacer sleeve 80003 (1)
 - ☐ 3" U-bolt 80071 (2)
 - ☐ 3/8" serrated flange nut (4)

- ☐ **#197 - JK 0-3.5" SS Rear Brake Line Set 13838 (1)**
 - ☐ Rear brake hose LEFT 88160 (1)
 - ☐ Rear brake hose RIGHT 88161 (1)
 - ☐ Brake hose mounting brkt 88275 (2)
 - ☐ #10 x 1 self-drilling screw (2)
 - ☐ Brake Hose clip BQ3052 (2)
 - ☐ Copper washer BQ1016 (4)
- ☐ **#198 - JK 0-3.5" SS Front Brake Line Set 13839 (1)**
 - ☐ Front brake hose LEFT 88158 (1)
 - ☐ Front brake hose RIGHT 88159 (1)
 - ☐ Brake hose mounting brkt 88275 (2)
 - ☐ #10 x 1 self-drilling screw (4)
 - ☐ Brake Hose clip BQ3052 (2)
 - ☐ Copper washer BQ1016 (4)
- ☐ **#199 - JK Rear Bump Stop Spacer Hardware (1)**
 - ☐ 5/16-18 x 3/4 Serrated flange bolt, gr8 (4)
 - ☐ 5/16-18 Serrated flange nut (4)
- ☐ **#200 - JK Front Bump Stop Spacer Hardware (1)**
 - ☐ 1/2-13 x 2-1/2 Hex head bolt, gr8 (2)
 - ☐ 1/2 USS flat washer (2)
- ☐ **#201 - Sway Bar Link Hardware (1)**
 - ☐ 3/4" hourglass bushing 94025 (4)
 - ☐ 12mm sway bar bolt sleeve 92038 (4)
 - ☐ M12 x 65 Hex bolt cl 10.9 (2)
 - ☐ M12 Nylock nut (2)
 - ☐ 7/16 USS washer (4)
- ☐ **#220 - Rear Sway Bar Link/Relocation Hardware (1)**
 - ☐ 3/4" hourglass bushing 94025 (4)
 - ☐ 12mm sway bar bolt sleeve 92038 (2)
 - ☐ 1/2" short sway bar bolt sleeve 80140 (2)
 - ☐ 7/16 USS flat washer (12)
 - ☐ 1/2-13 x 1-1/2 hex bolt, gr8 (2)
 - ☐ 1/2-13 x 2-1/2 button head bolt (2)
 - ☐ M12 x 60 hex head bolt cl10.9 (2)
 - ☐ M12 nylock nut (2)
 - ☐ 1/2-13 Nylock flange nut, gr8 (4)
- ☐ **#279 - Long Arm Bracket Hardware - 15438 (1)**
 - ☐ One-Bolt Nut Plate 77052 (2)
 - ☐ M14 x 35 hex bolt, class 10.9 (5)
 - ☐ M14 x 90 hex bolt, class 10.9 (1)
 - ☐ M14 x 100 hex bolt, class 10.9 (2)
 - ☐ M14 nylock flange nut class 10.9 (3)
 - ☐ 9/16 F436 hardened washer (8)
 - ☐ 7/16 Serrated flange nut (2)
- ☐ **#280 - Long Arm Bracket Hardware - 15439 (1)**
 - ☐ Short M14 Nut Plate 77052 (3)
 - ☐ M14 x 35 hex bolt, class 10.9 (9)
 - ☐ M14 x 90 hex bolt, class 10.9 (2) UCA bolts
 - ☐ M14 x 100 hex bolts, class 10.9 (2)
 - ☐ M14 hex nut, class 8 (2)
 - ☐ 9/16" F436 hardened washer (10)



Shocks

- ☐ **Trail Tamer HD Hydro**
 - ☐ Front shock 79002 (2)
 - ☐ Rear shock 79005 (2)
- ☐ **Doetsch Upgrade (Optional)**
 - ☐ Front shock DT 8386 (2)
 - ☐ Rear shock DT 8371 (2)
- ☐ **#165 - JK Shock Hardware (1)**
 - ☐ Rear barpin GS-403261 (2)
- ☐ **Bilstein Upgrade (Optional)**
 - ☐ Front shock 33-230375 (2)
 - ☐ Rear shock 33-104652 (2)
- ☐ **#164 - JK Bilstein Shock Hardware (1)**
 - ☐ Rear barpin GS-403261 (2)
 - ☐ 12mm shock sleeve 404739 (4)



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

We recommend this system be installed by a qualified professional. Knowledge of suspension component function is necessary for safe installation and post installation inspections. Be sure to re-torque all suspension components after the first 100 miles of use, and frequently inspect all safety critical suspension components.

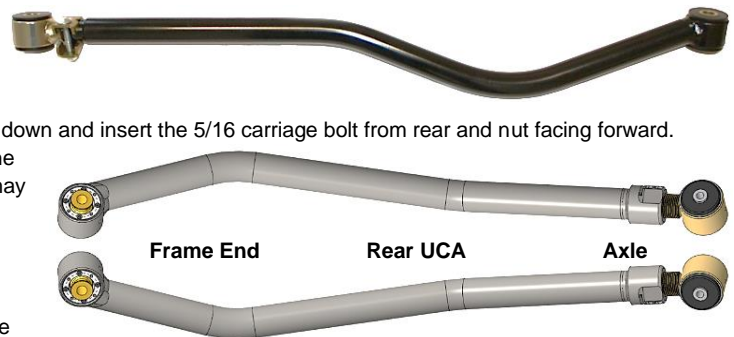
Before you begin:

- ☐ ***Ensure that all parts are present and in good condition using above shipping checklist. ***
- ☐ Read and understand all installation instructions.
- ☐ Tools required:
 - ☐ Floor jack and jack stands
 - ☐ Basic hand tools
 - ☐ Torque wrench
 - ☐ Angle grinder, Sawzall
 - ☐ Anti-seize compound
 - ☐ Multipurpose grease
 - ☐ Tape measure
 - ☐ 9/16" drill bit and drill



Prepare the parts for installation:

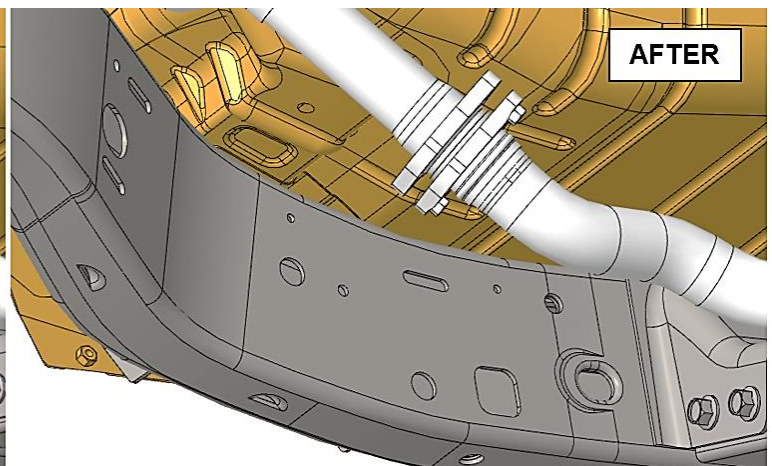
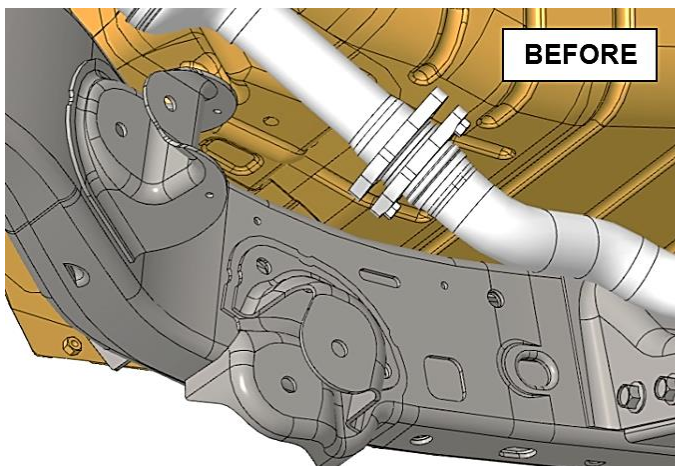
1. **Shocks:** Locate rear shocks and hardware kits.
2. Grind the outer corners on one end of the barpins to ease installation.
3. Grease and install the barpins into the top side of the rear shocks. Clamp the barpin vertically in a bench vise and lower the shock onto the barpin while rotating the shock back and forth. Be sure to grease the barpin and the shock bushing.
4. **Front Track Bar:** Locate front track bar, **HK #166** and track bar threaded male end.
5. Lubricate track bar bushings and bushing sleeves with multi-purpose grease and install into track bar and track bar threaded male end.
6. Slip clamping bracket onto adjusting end of track bar with the opening down and insert the 5/16 carriage bolt from rear and nut facing forward.
7. Use a light coat of anti-seize then thread the track bar male end into the track bar. Adjust to the length in the chart as a starting point. Length may need adjustment after a test drive.
8. Tighten the clamping bracket. Make sure the bracket opens rearward, and nut faces down.
9. **Adjustable Control Arms:** Using the instructions on the last pages, assemble the flex ends into the threaded male ends or arms. LCAs use 2-5/8" **HK #127**, UCAs use 2-3/8" **HK #168**.
10. Use a light coat of anti-seize then thread the male ends into the control arms and adjust to the lengths in the chart as a starting point.
11. Install the clamping bolts **HK #65** into the LCAs and UCAs, do not fully tighten at this time.

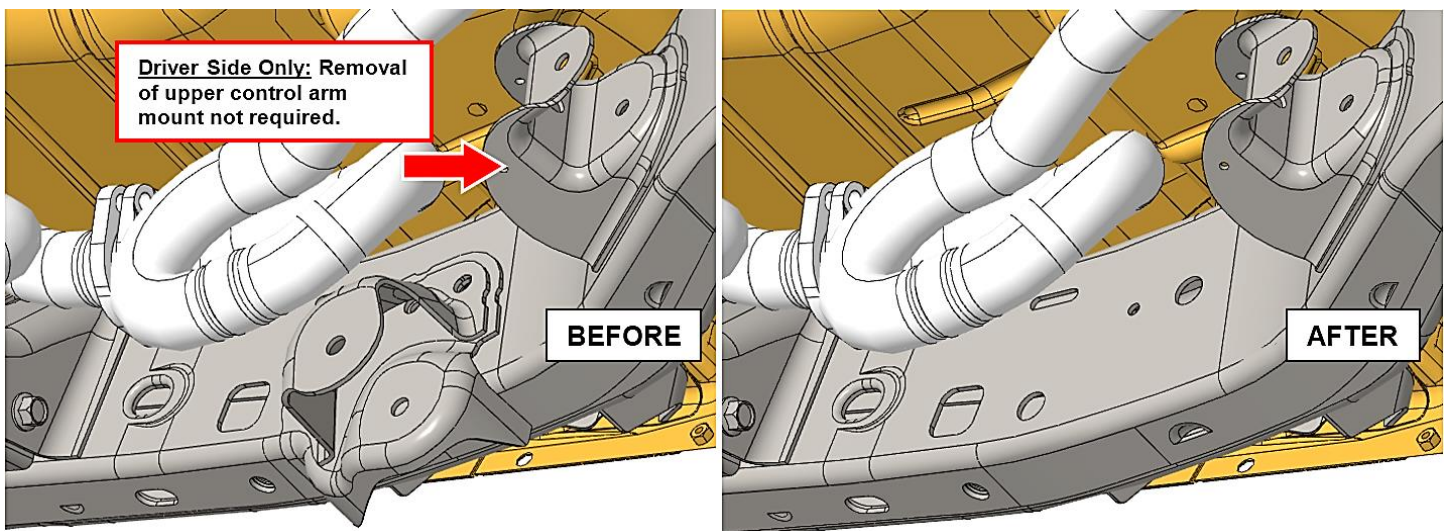


Front installation:

12. Lift front of vehicle and support with jack stands under frame rails.
**Tip: break lug nuts loose before lifting vehicle.
13. Remove front wheels
14. Remove front sway bar links.
15. Support the axle with jack stands and remove shocks.
16. Disconnect brake line from bracket on frame rail and cap the line.
17. Remove the front brake lines and brake hose brackets.
18. Remove front track bar.
19. Remove coil springs.
20. Remove the factory T-Brace from the frame. Save the M12 bolts for future use.
21. Remove the factory upper and lower control arms.
22. Cut off the front upper and lower control arm mounts from the frame. Do not cut into the frame. Ensure the frame is completely smooth, clean, and ready for painting. Remove the brackets in pieces. A combination of grinder, sawzall, hammer, and chisel is preferred.

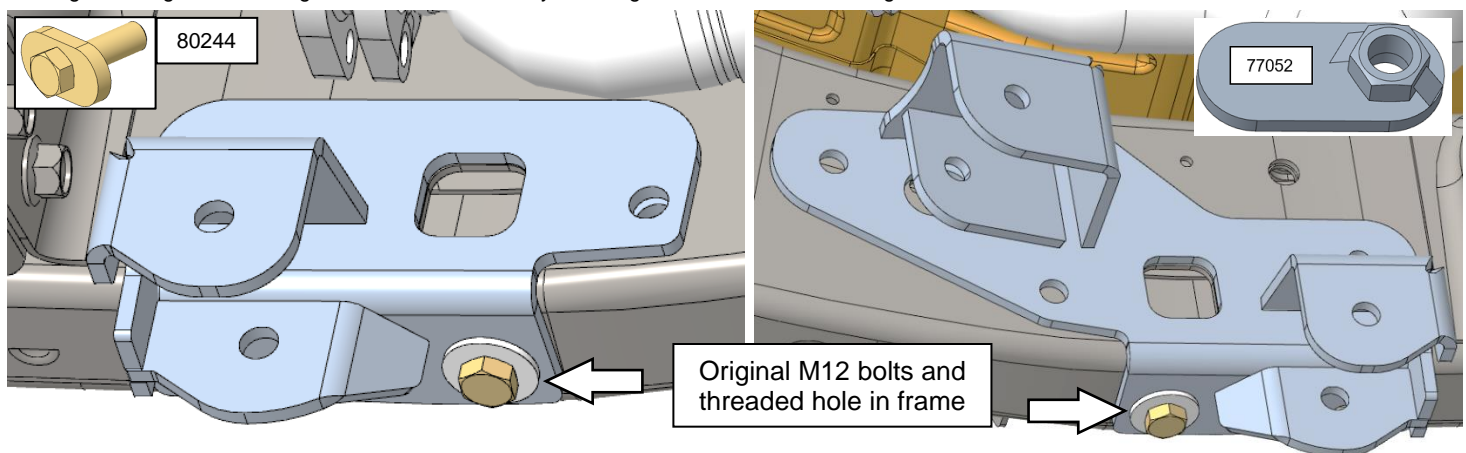
Track Bar & Control Arm Length (Center to Center)	
Front UCA (Upper Control Arm)	29-1/2"
Front LCA (Lower Control Arm)	32-1/2"
Rear UCA	32-3/8"
Rear LCA	34-3/8"
Front Track Bar	32-3/4"
Rear Track Bar	40-1/4"





23. **Long Arm Mounting Brackets:** Locate long arm brackets and HK #279.

24. Align the long arm mounting brackets on the frame by installing the OEM M12 bolts through the bracket and into the threaded hole in the frame.

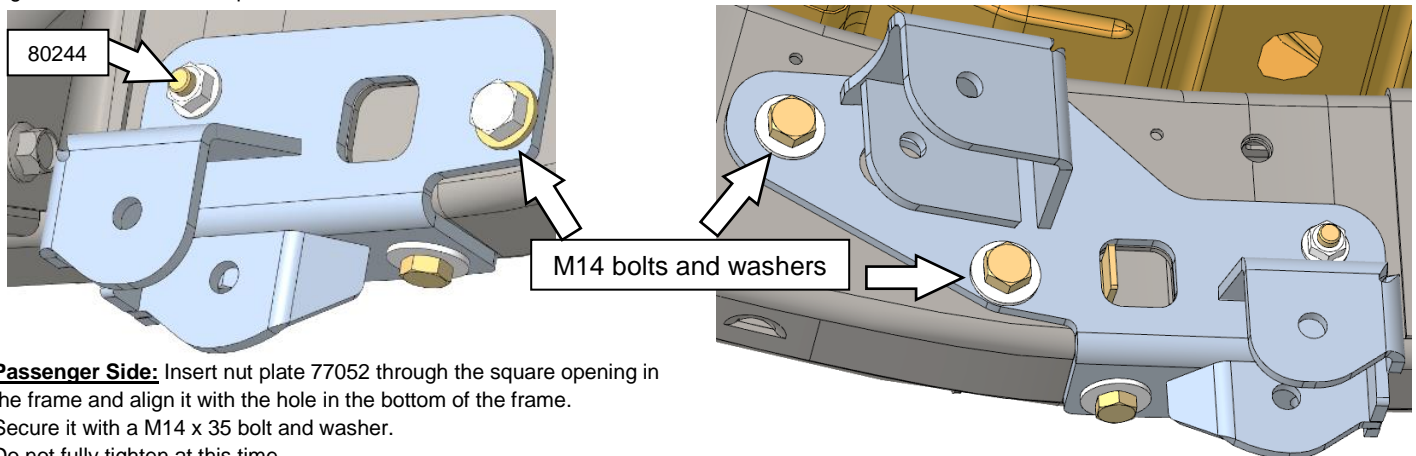


25. **Driver Side:** Insert nut plate 77052 through the square opening in the frame and align it with the hole in the side of the frame.

Secure it with a M14 x 35 bolt and washer. Repeat for the hole in the bottom of the frame. Do not fully tighten at this time.

26. Insert bolt plate 80244 through the outside of the frame using needle nose pliers or a socket on an extension. Place it the hole in the upper part of the bracket. Secure the bolt plate with a 7/16 serrated nut. Do not fully tighten at this time.

27. Tighten all hardware. Torque the M14 and M12 hardware to 100 ft-lbs. 7/16" hardware to 60 ft-lbs.



28. **Passenger Side:** Insert nut plate 77052 through the square opening in the frame and align it with the hole in the bottom of the frame.

Secure it with a M14 x 35 bolt and washer.
Do not fully tighten at this time.

29. Insert the two-hole nut plate 80219 through the square opening in the frame and align it with the holes in the side of the frame. Secure it with two M14 x 35 bolts and washers. Do not fully tighten at this time.

30. Insert bolt plate 80244 through the outside of the frame using needle nose pliers or a socket on an extension. Place it in the hole in the upper part of the bracket. Secure the bolt plate with a 7/16 serrated nut. Do not fully tighten at this time.

31. Tighten all hardware. Torque the M14 and M12 hardware to 100 ft-lbs. 7/16" hardware to 60 ft-lbs.

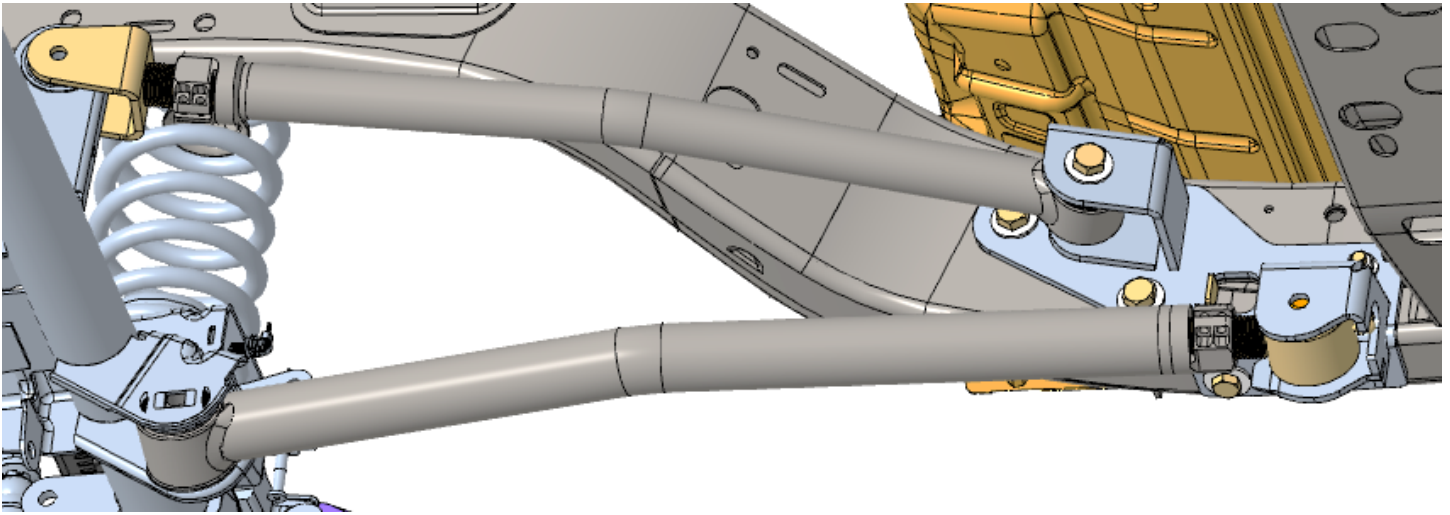
32. **Upper Control Arm:** Locate the upper control arm and M14 x 90 bolt, washer, and flange lock nut.

33. Install the flex end of the upper control arm into the long arm mounting bracket then install the fork end onto the axle.

34. The arm is bent for frame and exhaust clearance; the clamping bolt points down.

35. Secure the upper control arm with the M14 x 90 bolt, washer, and flange lock nuts at the long arm bracket.

36. Use the factory M12 bolt and nut at the axle end. Torque the M14 bolts to 120 lb-ft. Do not tighten the M12 bolts at this time.

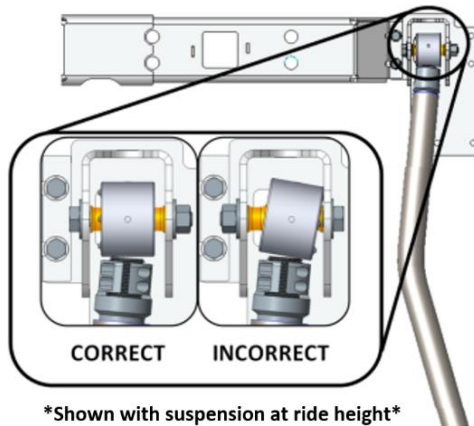
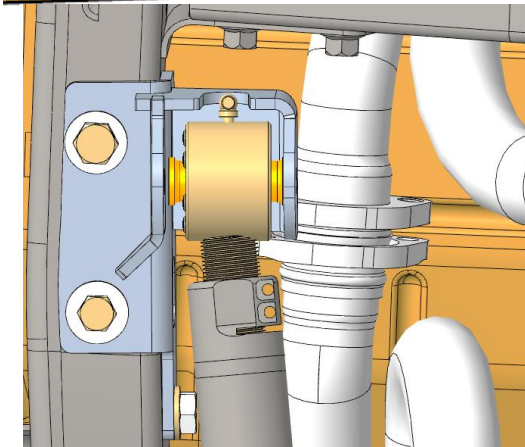
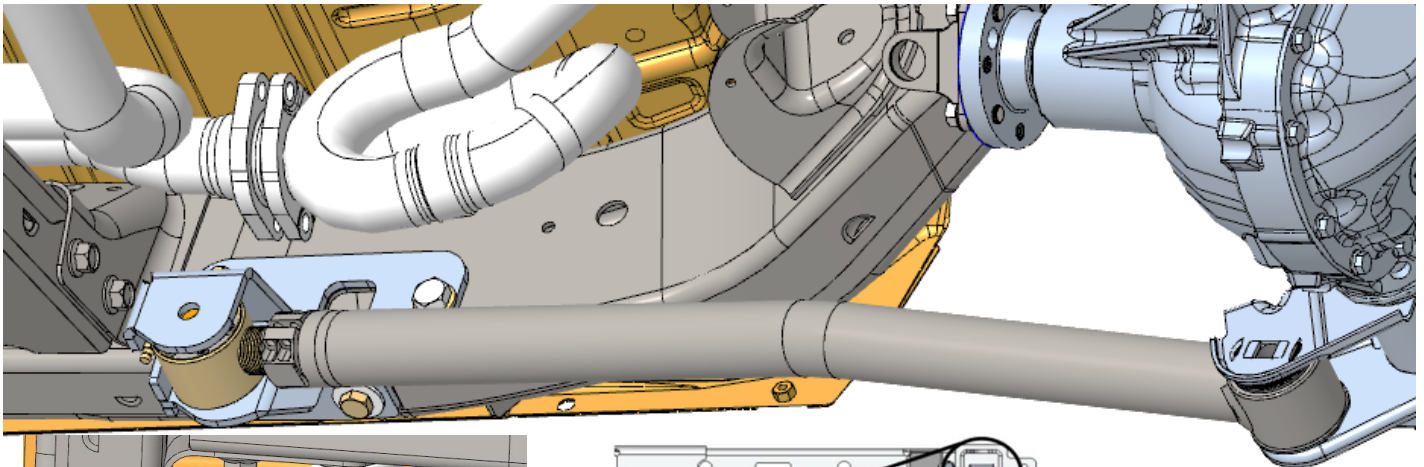


37. **Lower Control Arms:** Locate the lower control arms and the factory lower control arm bolts.

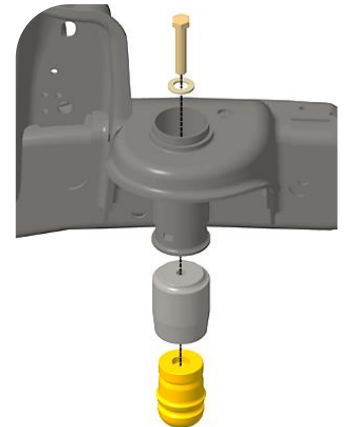
38. Install the rubber bushing at the axle then install the flex end at the frame. The LCAs are bent inward for tire clearance.

39. Torque bolts at the frame to 130 lb-ft. Do not tighten bolts at the axle at this time.

40. Ensure that the lower control arm flex ends are oriented. Install front upper bump stop extension using HK #200. See picture.



Shown with suspension at ride height



41. Install new coil springs.

42. **Front lower coil retainers:** place the 1/4" thick spacer (one notch) against the spring on the lower spring mount near the end of the coil spring.

The driver's side retainer mounts behind the spring, the passenger's side retainer mounts in front of the spring.

43. Using the spacer as a guide, mark the location of the bolt hole with a permanent marker.

44. Remove the spacer and drill an 11/32" hole.

45. Install the spacer and top plate with the provided 5/16 x 1" bolt, washer and nut.

The top plate should not sit flat on the spacer.

46. Repeat steps 4-8 for the opposite side spring mount.

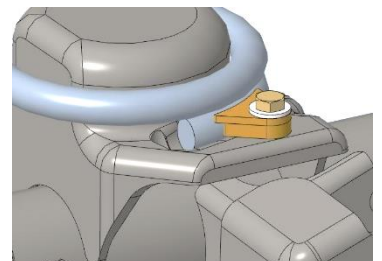
The driver's side retainer mounts behind the spring, the passenger's side retainer mounts in front of the spring.

47. Install new brake hose bracket on frame in factory location using factory bolt and a self drilling screw.

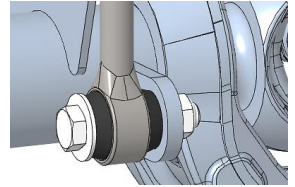
48. Install new brake hose on new bracket using **HK #198**.

Before tightening flare nut, be sure to twist brake hose into the best orientation to keep the hose away from the tire, spring, and shock.

49. **Re-route ABS wires as needed to allow full suspension droop.**

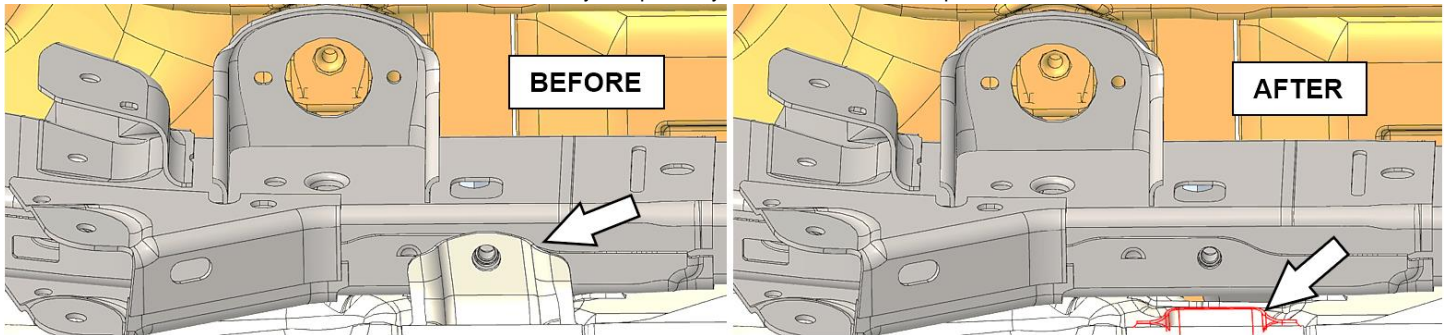


50. Install new shocks.
51. Assemble and install new front sway bar links using **HK #201**. Grease and install the hourglass bushings into the links then grease and install the sway bar link bolt sleeves into the bushings.
52. All front sway bar sleeves are the same (12mm I.D.). Use bolts from **HK #201** for the top bolt and reuse the original bolt for the lower.
53. Install new front track bar with threaded end to axle side. The clamp hangs down, bolt facing front.
54. Reinstall front wheels.
55. Lower vehicle onto ground.

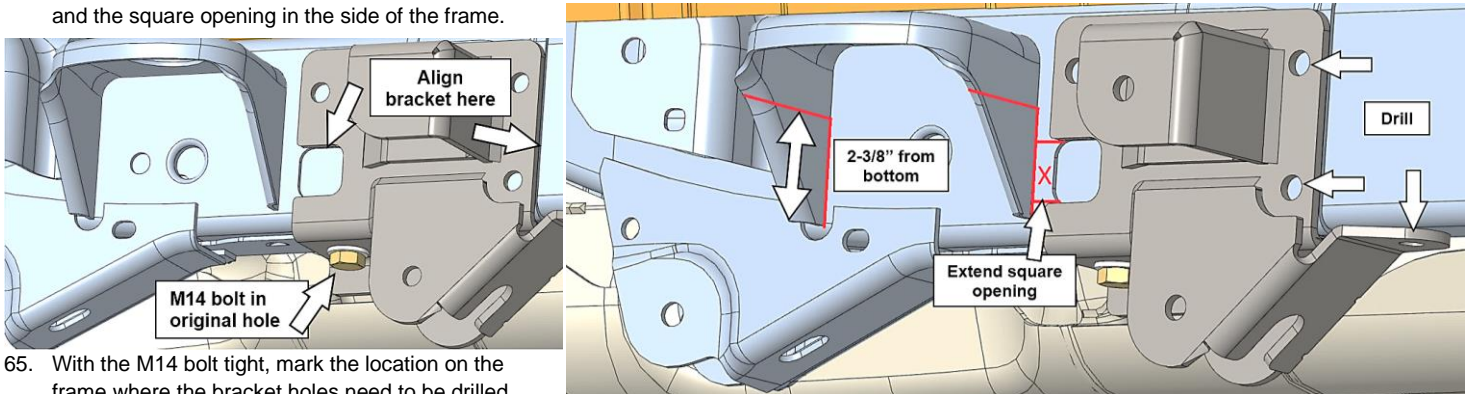


Rear installation:

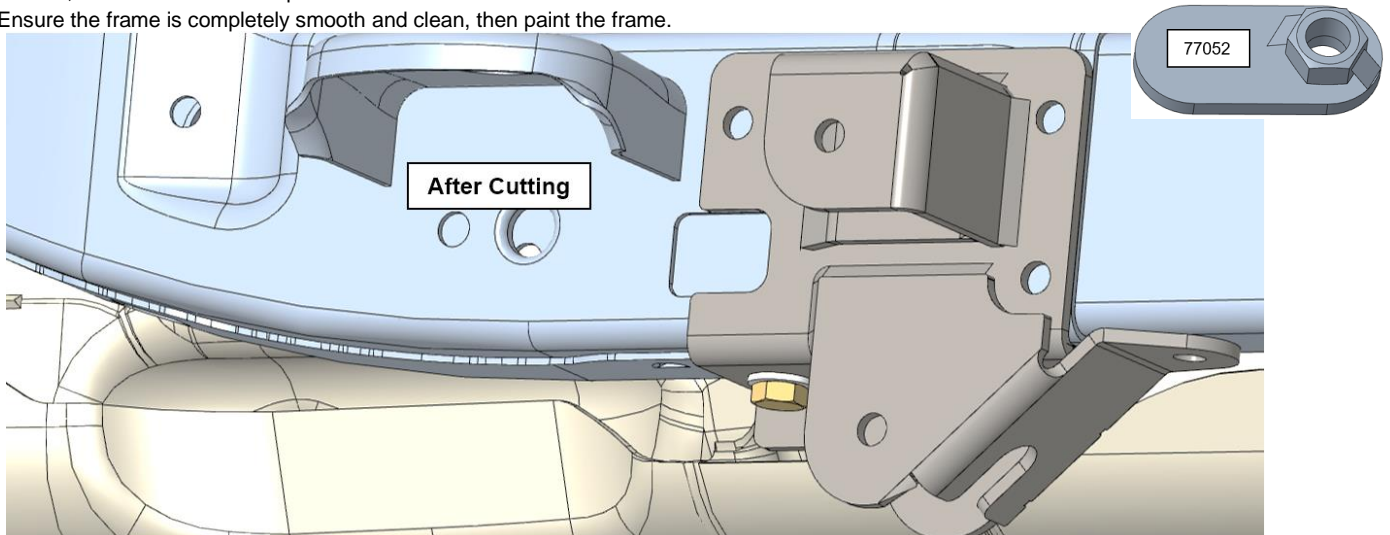
56. Lift rear of vehicle and support with jack stands under frame rails.
**Tip: break lug nuts loose before lifting vehicle.
57. Remove rear wheels.
58. Remove sway bar links.
59. Remove coil springs.
60. Remove the rear track bar.
61. Support the rear axle with jack stands and remove the factory upper and lower control arms.
62. **Passenger Side:** Remove the factory M12 bolt from the gas tank skid plate, in front of the body mount. Cut off the gas tank skid mount as shown.
63. Remove the nut from inside the frame. Thread the factory bolt part-way into the nut then hit it upward with a hammer until it breaks free & remove.



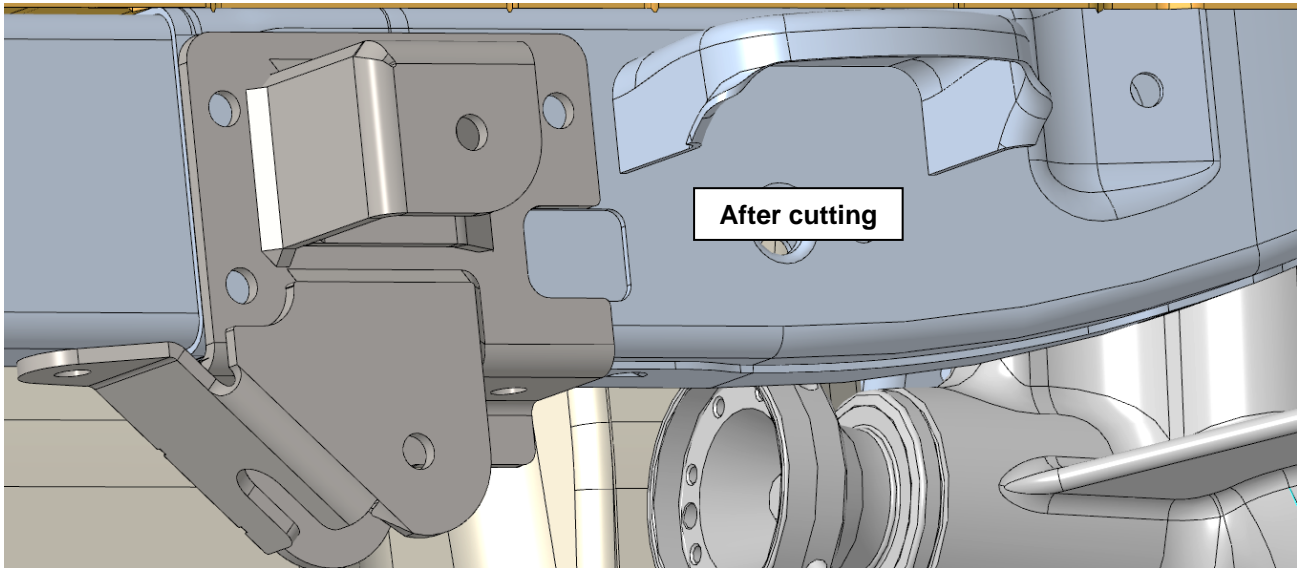
64. Install the long arm bracket on the frame using nut plate 77052 and a M14 x 35 bolt from **HK #280**. Align the bracket with the seam on the frame and the square opening in the side of the frame.



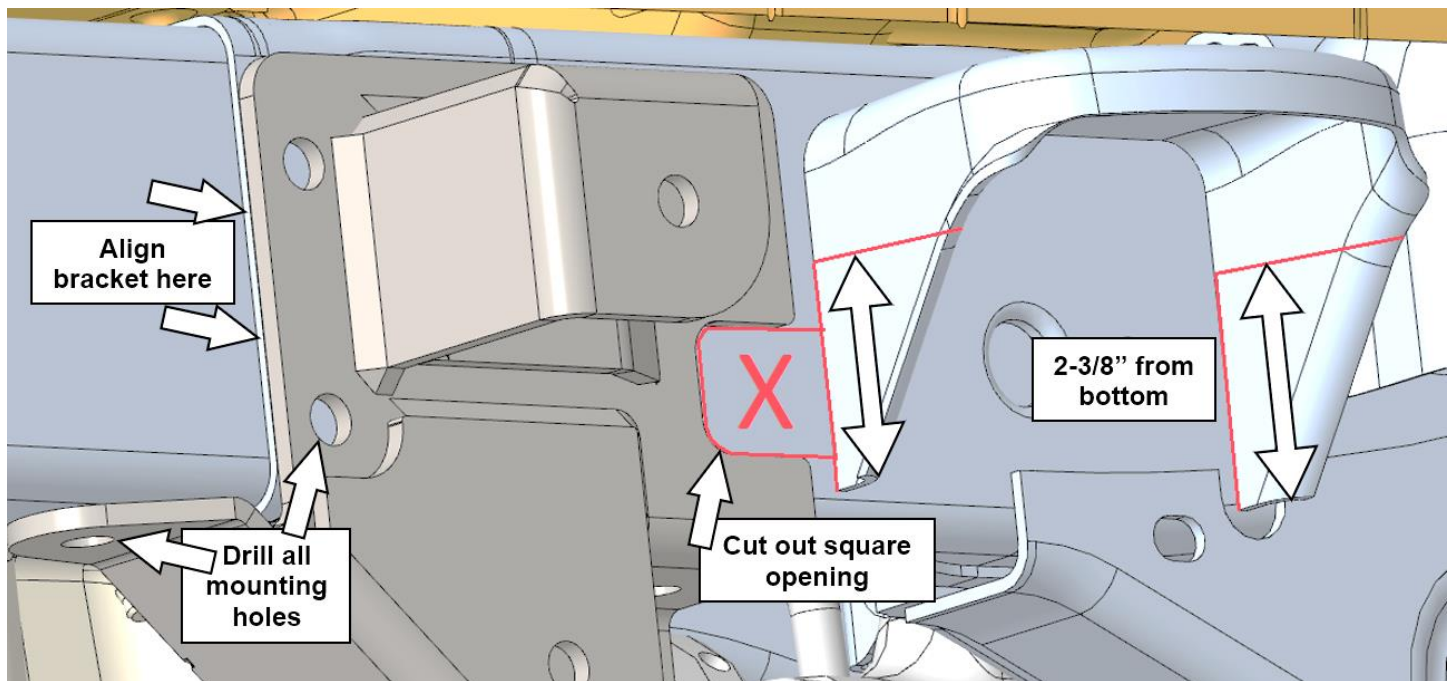
65. With the M14 bolt tight, mark the location on the frame where the bracket holes need to be drilled.
66. Measure up 2-3/8" from the bottom of the body mount and mark a horizontal line to trim the body mount. The square opening also needs to be extended to the location of where the body mount is on the frame. Drill out the new corners of the square, cut out the shape with a grinder, finish the shape with a carbide burr on a die grinder.
67. Remove the bracket and drill the holes through only the outside surface of the frame. Be sure to remove any sharp edges from the drilled holes.
68. Cut off the upper and lower control arm mounts from the frame. Remove brackets in pieces. Do not cut into the frame. A combination of grinder, sawzall, hammer and chisel is preferred. Use caution near the fuel tank!
69. Ensure the frame is completely smooth and clean, then paint the frame.



70. **Driver side:** Align the long arm bracket with the seam on the frame just like on the passenger side.
71. Mark the location on the frame where all the bracket mounting holes need to be drilled.
72. Using the bracket as a template, mark the location on the frame where the square hole needs to be cut.
The square hole should extend to the location of the body mount. Drill out the corners of the square, cut out the shape with a grinder, finish the shape with a carbide burr on a die grinder.
73. Measure up 2-3/8" from the bottom of the body mount and mark a horizontal line to trim the body mount.

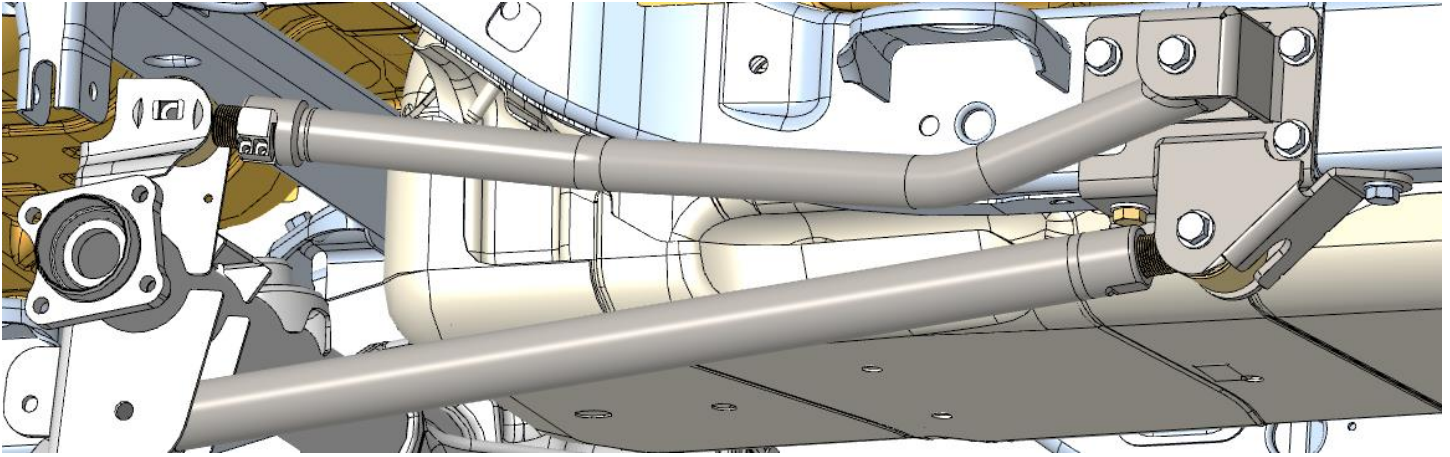


74. Remove the bracket and drill the holes through only the outside surface of the frame. Be sure to remove any sharp edges from the drilled holes.
75. Cut off the upper and lower control arm mounts from the frame. Remove brackets in pieces. Do not cut into the frame. A combination of grinder, sawzall, hammer and chisel is preferred.
76. Ensure the frame is completely smooth and clean, then paint the frame.



77. **Long Arm Mounting Brackets:** Install the long arm brackets on the frame using 77052 nut plates, M14 x 35 bolts, and washers from **HK #280**. Align the short 77052 nut plates with the holes on the bottom of the frame. Do not tighten at this time.
78. Place a long M14 nut plate through the square hole in the frame. The plate should sit flat against the inside of the frame. Align the long M14 nut plate with the holes in the bracket. Thread M14 x 35 bolts with F436 washers into each nut in the nut plate before fully tightening.
79. Torque all M14 hardware to 100 ft-lbs.
80. **Upper Control Arms:** Locate the upper control arms, M14 x 90 bolts, and F436 washers.
81. Install the flex end of the UCA into the long arm bracket using the M14 bolt, then install the rubber bushing end onto the axle with the original bolt. The arm is bent down and outward for frame clearance, the clamping bolts point down.

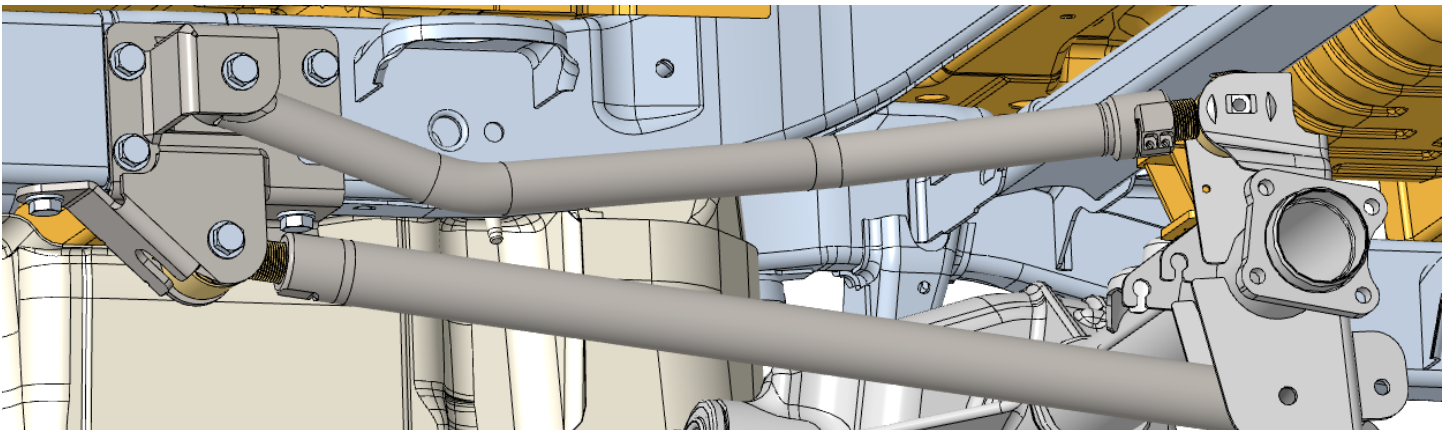
82. Torque the UCA bolts at the frame to 120 lb-ft. Do not tighten the axle side rubber bushing bolts at this time.



83. **Lower Control Arms:** Locate the lower control arms, new M14 x 100 bolts, F436 washers, and nuts

84. Install the flex end at the frame then install the rubber bushing at the axle. Use the new M14 bolt, F436 washer and nut at the frame. The LCA clamping bolts face inward. The flex joint male end is angled to match the angle of the LCA mount on the frame.

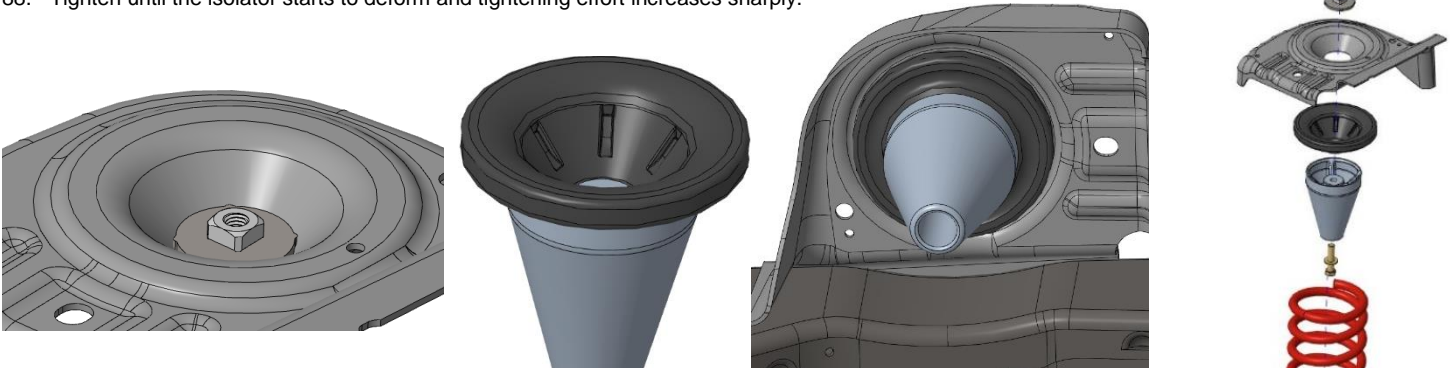
85. Torque LCA bolts at the frame to 130 lb-ft. Do not tighten rubber bushing bolts at the axle at this time.



86. **Retainer Cone:** Position the nut plate on top of the coil spring mount with the nut facing up.

87. Place the upper isolator on top of the retainer cone then place it up onto the coil spring mount. Secure with 7/16 x 2" bolt and washer.

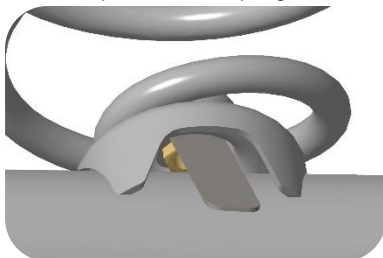
88. Tighten until the isolator starts to deform and tightening effort increases sharply.



89. Install the springs into the Jeep by positioning them over the retainer cones and lower spring mounts on the axle.

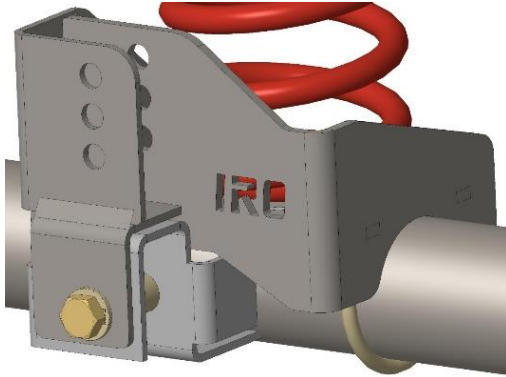
90. Insert the 7/16 flag nut into the lower spring mount from the bottom side and align it with the hole in the lower spring mount.

91. Insert the retainer plate into the spring. Add a small amount of anti-seize to the 7/16 x 1" bolt and torque to 54 lb-ft.



92. Install new rear track bar bracket over factory track bar bracket. Secure with U-bolts, 3/8" serrated flange nuts, M14 x 80 bolt, nylock nut and spacer sleeve from **HK #199**.

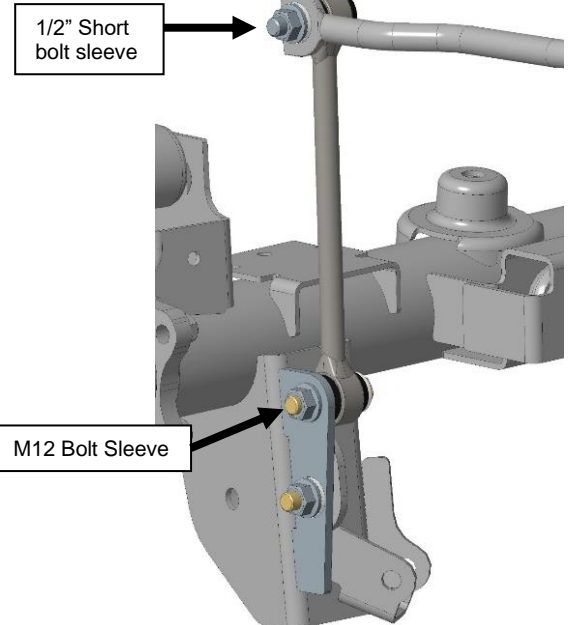
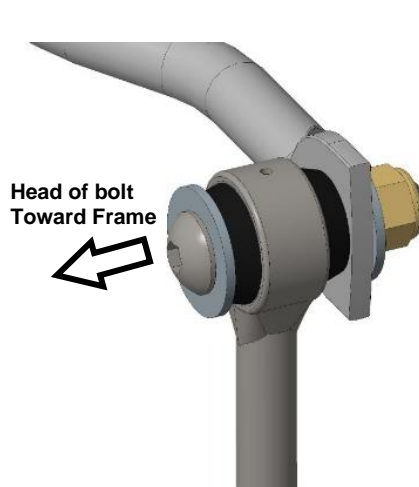
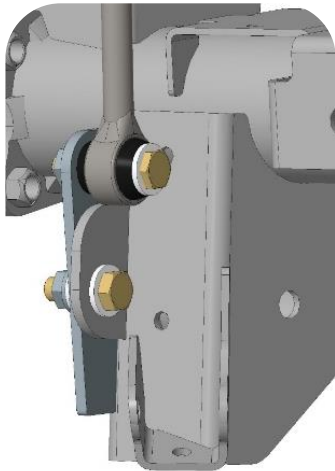
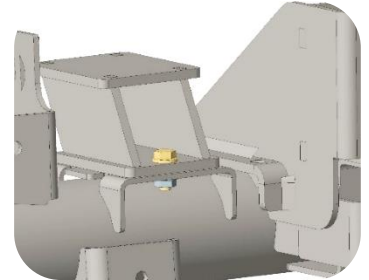
93. Install new track bar into rear track bar bracket (middle hole) using the factory track bar bolt and flag nut. Tighten jam nut very tight.



94. Remove rear brake hose from the frame and caliper then remove the brake hose bracket.
95. Install new brake hose bracket on the frame in the original hole using the factory hardware as shown. Angle the bracket to line up with the brake line and use the self tapping screw to secure it.
96. Attach the new braided brake hose to the caliper with the factory bolt and new copper washers.
97. Tighten the brake line into the braided hose. Orient the new braided brake hose inward to avoid moving suspension parts and the tire, secure it to the bracket with the clip provided.

Re-route ABS wires as needed to allow full suspension droop.

98. Install rear bump stop spacers using **HK #199**. The slant should point forward.
*For ease of installation: it is recommended that the rear axle be set at ride height and the upper control arm bolts be torqued before install of the rear bump stop spacers.
99. Install rear sway bar drop spacers on the frame: Loosen one side of the sway bar, do not remove the bolts, then remove bolts from the opposite side and install the spacer using **HK #12**.
100. Install rear sway bar relocation brackets on the outside of the original sway bar mount using 1/2 x 1-1/2 bolts from **HK #220**.
101. Assemble new rear sway bar links using **HK #220**. Grease and install the hourglass bushings into the links then grease and install one 1/2" short bolt sleeve and one M12 long bolt sleeve into each rear sway bar link. The short bolt sleeve is for the top of the sway bar link.
102. Use the M12 x 60 hex head bolts for the bottom of the sway bar links. Use the 1/2 x 2-1/2 button head bolts for the top of the sway bar link. See photos.



103. Install new shocks.
104. Reinstall rear wheels.
105. Lower vehicle onto ground.

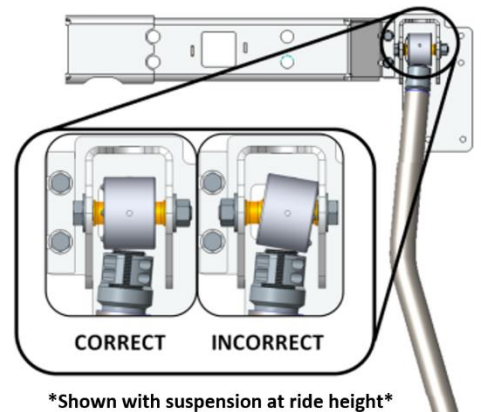
Final Torque and Adjustments:

106. Raise vehicle and reposition jack stands under the front and rear axles.
107. Temporarily install a tire on one side.
108. Verify that the axle is centered as desired front to rear. Check caster before adjusting.
109. Check caster angle. Using a laser level or string level, set the front axle level to the rear axle (left side and right). Bounce the Jeep up and down to ensure the suspension is in resting position (at exact ride height). Place the angle finder under the axle "C" (or on top of the upper ball joint). Ensure the angle finder is parallel to the Jeep front to rear. This is your caster angle. See chart for desired setting.
110. Adjust control arms to the desired position.
111. To adjust axle front to rear, adjust upper and lower control arms by the same amount. 12 turns equal one inch.
112. To adjust only caster, adjust only the upper control arms (3 turns equals roughly 2 degrees).
113. To adjust both, adjust both at the same time.

Caster Angle (Starting point)	
Lift Height	Caster
2.5"	7°
3.5"	6.5°
4" or more	5°



114. **Caster angle may need to be adjusted after a test drive to eliminate driveline vibrations.**
115. With the vehicle weight on the suspension, tighten the upper control arm bolt to 90 lb-ft. and lower control arm bolts at the frame to 130 lb-ft.
116. Torque the upper and lower control arm clamping bolts to **140 in-lb.** Be sure to go back and forth between both bolts to ensure even clamping.
117. Install tires and wheels. Torque lug nuts to spec. (Typical specification is 85-115 ft-lbs., depending on your wheels)
118. With the axles positioned front to rear and caster set, check the axle position left to right. Adjust the track bars to center the axles under the vehicle. Tighten jam nut very tight.
119. With the vehicle weight on the suspension, check steering wheel alignment. The draglink **must** be adjusted to center the steering wheel before driving the vehicle. Failure to do so will cause an error with the factory traction control system and will result in odd handling and decreased performance.
120. Recheck all fasteners and torque any remaining loose nuts or bolts to spec.
Check all components for clearance for suspension to fully cycle up and down and wheels to turn lock to lock. Pay special attention to brake lines, axle vent hoses, and ABS wires.
Reposition as needed by bending the brackets, relocating, or extending hoses and wiring.



Final Safety Warning:

121. * Re-torque all fasteners after 100 miles, and frequently inspect all safety critical suspension components. It is the responsibility of the installer to be sure all fasteners are properly tightened after installation and to ensure the owner knows his/her ongoing responsibility. It is the responsibility of the owner of the vehicle to be sure all safety critical components are inspected frequently, especially after off road or other demanding use.



IRON ROCK OFF ROAD

**2-5/8" IRO Flex End (6 bolt)
Assembly Instructions**

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

Fits All Iron Rock Off Road Long Arm Systems, WJ A-Arms, and Build Your Own Flex End Assemblies.

Before you begin:

- Read and understand installation instructions.
- Contact Iron Rock Off Road with any questions before, during, or after installation.
- **Ensure that all parts are present and in good condition per attached shipping checklist!**
- Have these tools handy:
 - 5/32" Allen head socket
 - 3/8" open end wrench
 - Inch-lb. torque wrench
 - Multipurpose grease/grease gun

Parts Checklist:

- ☐ Outer housing, weld on (may already be attached to your existing control arm)

#127 - 2-5/8" IRO Flex End (6 bolt)

- ☐ 2-5/8" flex end race 91118 (2)
- ☐ Thrust washer 91119 (2)
- ☐ 2-5/8" flex end ball 91117 (1)
- ☐ #10-32 nylock nut (7)
- ☐ #10-32 x 1-3/4" socket head cap screw (6)
- ☐ 90° 1/4"-28 grease zerker fitting (1)

Assembly:

1. Insert two #10-32 socket head cap screws into one thrust washer and one plastic race. Spherical bore of race facing away from thrust washer. (Figure 1)
2. Install this small assembly into the flex end housing. The races are a light press fit, use a wide punch and hammer to assist you if needed.
3. Apply a thin coating of multi-purpose grease to the mating surfaces of the ball and both races.
4. Place the ball in the race (inside the flex end). The ball should perfectly fit the contour of the race. (Figure 2)
5. Insert the other race onto the ball so that the spherical bore is contacting the ball. Once again, the races are a light press fit, use a hammer and wide punch if needed. (The two screws should be through one washer and both races at this point)
6. Insert the second thrust washer on top of the flex end housing, sliding the bolts through the holes. (Figure 3)
7. Start nylock nuts on the two bolts that are in the flex end assembly. Hold the nut and turn the bolt.
8. Insert the remaining four cap screws through the remaining holes and install nuts. (Figure 4)
9. Snug up all of the bolts fairly tight.
10. Torque bolts evenly, starting at one bolt and continuing using a crisscross pattern. Torque all six bolts to 70 in-lbs., then to 85 in-lbs.
11. Install 90° grease zerker fitting so that it is easily accessed in the vehicle.
12. Grease flex end until grease comes out of the races around the ball.
13. Re-torque bolts to 85 in-lbs. after 5 minutes.



Figure 1

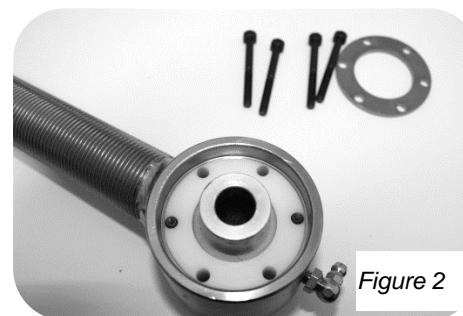
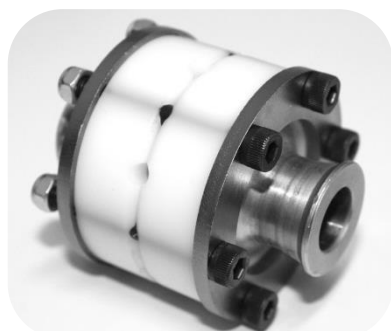


Figure 2



**Reference Only* Complete joint shown fully assembled without housing*

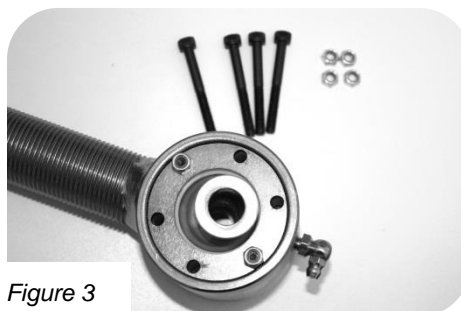


Figure 3

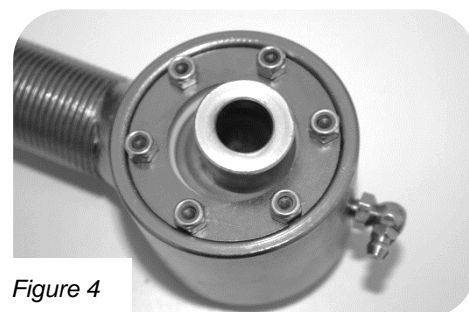


Figure 4

IRON ROCK OFF ROAD

2-3/8" IRO Flex End (8 bolt)
Assembly Instructions

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

Before you begin:

- Read and understand installation instructions.
- Contact Iron Rock Off Road with any questions before, during, or after installation.
- **Ensure that all parts are present and in good condition per attached shipping checklist!**
- Have these tools handy:
 - 9/64" Allen head socket
 - 3/8" open end wrench
 - Inch-lb. torque wrench
 - Multipurpose grease/grease gun

Parts Checklist:

- ☐ Outer housing, weld on (may already be attached to your existing control arm)

#168 - 2-3/8" IRO Flex End (8 bolt)

- ☐ Inner race 91139 (2)
- ☐ Thrust washer 91138 (2)
- ☐ Ball 91140 (1)
- ☐ #8-32 x 1-1/2" socket head cap screw (8)
- ☐ 1/4"-28 90° grease zerk fitting (1)
- ☐ 1/4"-28 straight grease zerk fitting (1)

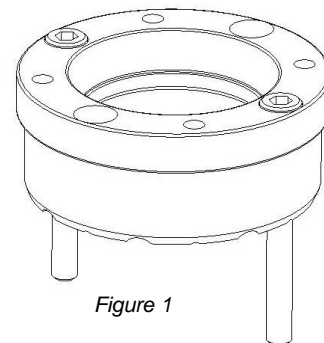
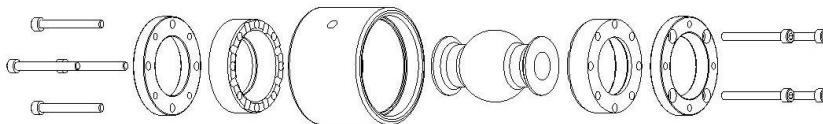
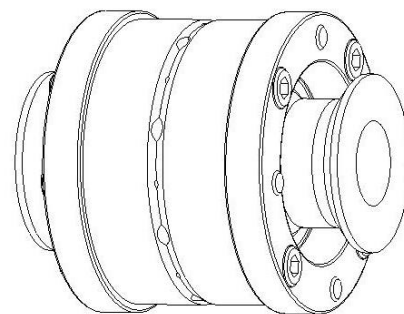


Figure 1

Assembly:

1. Insert two #8-32 socket head cap screws into one thrust washer and one plastic race. Spherical bore of race facing away from thrust washer. (Figure 1)
2. Install this small assembly into the flex end housing. The races are a light press fit, use a wide punch and hammer to assist you if needed.
3. Apply a thin coating of multi-purpose grease to the mating surfaces of the ball and both races.
4. Place the ball in the race (inside the flex end). The ball should perfectly fit the contour of the race.
5. Insert the other race onto the ball so that the spherical bore is contacting the ball. Once again, the races are a light press fit, use a hammer and wide punch if needed. (The two screws should be through one washer and both races at this point)
6. Insert the second thrust washer on top of the flex end housing, aligning the bolts with the threaded holes.
7. Start threading the two bolts into the threaded holes of the thrust washer. Do not fully tighten at this time.
8. Insert the remaining cap screws through the remaining holes and get them started in the threaded washer.
9. Snug up all of the bolts fairly tight. Go back and forth, rechecking each bolt several times to ensure even clamping
10. Torque bolts evenly starting at one bolt using a crisscross pattern, like torqueing lug nuts. Torque all eight bolts to 50 in-lbs., then to 55 in-lbs.
11. Install 90° grease zerk fitting so that it is easily accessed in the vehicle.
12. Use a grease gun to grease the flex end through the zerk fitting. This will be difficult due to the tight tolerances in the flex joint assembly.
13. Re-torque bolts to 55 in-lbs.



**Reference Only* Complete joint shown fully assembled without housing*

