

IRON ROCK OFF ROAD

TJ Long Arm Exhaust Instructions

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

Parts List:

- Instructions
- Tailpipe 98009 (1)
- Front pipe 98010 (1)
- Cat to muffler pipe 98008 (1)
- 2-1/4" Catalytic converter 94035 (1)
- Flo Pro Muffler 4024 (1)
- Exhaust hanger plate 98011 (1)
- #154 - TJ Long Arm Exhaust Hardware kit (1)**
 - 2-1/4" Exhaust clamp HPC225BP1 (1)
 - O₂ Sensor hole plug (1)
 - 7/16-14 x 2-1/4" Hex bolt gr8 (1)
 - 7/16 USS washer (2)
 - 7/16-14 Nylon hex nut (1)



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

We recommend that all welds be performed by a skilled welder. An exhaust leak could cause harmful gases to creep into the vehicle's cabin while in operation and cause serious harm or death.

Before you begin:

- This exhaust system is designed for use with the Iron Rock long arm suspension system but will work with most short arm suspension systems.
- Read all safety warnings.
- 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 using the included shipping checklist.
- Be sure you have the following tools and supplies:
 - Sawzall or exhaust tubing cutter
 - Basic hand tools
 - Welder and related supplies

Installation:

1. Lift front and rear of vehicle and support with tall jack stands under the frame.
Tip: Break lug nuts loose on the ground.
2. Ensure that the vehicle is safely supported.
3. Remove rear tires.
4. Make sure your rear axle is centered and the approximate pinion angle is set.
5. Allow the suspension to droop fully.
6. Cut crossover pipe 1" behind the bend that curves around the oil pan, leaving 1" of straight pipe.
7. Disconnect all hangers and remove exhaust system that has been cut loose.
8. Slip the front pipe on all the way. Do not force on.
The jog bend brings pipe straight toward center of the Jeep as a starting point.
9. Install O₂ sensor into the cat or plug if not needed.
10. Slip cat onto the front pipe with the O₂ bung towards the rear.
11. Slip the short, angled pipe into the cat with the bend facing towards the center of the Jeep.
12. Slip the muffler on with the open end of internal bumps (sound baffles) facing towards the engine.
13. Support the muffler with a jack stand.
14. Ensure the rearmost exhaust hanger is present and connected to the frame.
15. Place the 7/16 bolt through the factory rubber exhaust hanger and hanger plate with a washer on each side and tighten until snug. Hanger plate and nut on the inside, rubber hanger on the outside.
16. Slip the tailpipe into the muffler with the welded end towards the front.
17. Place the exhaust clamp onto the tailpipe from the rear. Remove the nuts and push the threaded ends of the U-bolt into the triangular exhaust hanger. Install the nuts finger tight.
18. Position exhaust with 3/8" gap (one finger) clearance on all sides everywhere.
19. Ensure there is adequate clearance for driveshaft, upper control arms, and shocks at full



stuff (suspension fully compressed).

20. Tighten clamp/hanger enough to prevent it from moving but not tight enough to crush tailpipe.
21. Tack weld front pipe to cat, cat to middle pipe, and middle pipe to muffler.
22. Remove muffler, middle pipe, cat, and new front pipe. Fully weld outside of the Jeep.
23. Install and check clearances.
24. Tack weld remaining joints.
25. Check clearances again. Remember 3/8" minimum, plus room for moving suspension and drivetrain parts.
26. Fully weld exhaust system. Remove exhaust hanger to lower exhaust if needed.
27. Connect O2 sensor.
28. Run engine and check for leaks.
29. Install rear tires.
30. Lower vehicle from jack stands.
31. Torque lug nuts to factory spec.

