



#### **NOTE:**

These are semi-universal instructions to represent the installation of any uniframe stiffener on any uniframe. Variations will exist between different sections and/or different platforms.



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

We recommend that all welds be performed by a certified welder. We recommend having a fire extinguisher close by.

#### **Before you begin:**

- 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:**

- Floor jack and a minimum of 5 jack stands
- Basic hand tools
- Angle grinder with grinding and sanding wheels
- Large C clamps
- Welder

#### **Dissassembly:**

1. Disconnect battery.
2. Lift front and rear of vehicle and support on jack stands under the axles.
3. Remove the four nuts that fasten the transfer case mount to the transfer case crossmember.
4. Raise the transfer case slightly and support with a jack stand.
5. Remove transfer case crossmember.
6. Move to the interior of the vehicle and remove the front and rear seats. Leave rear backrest in place.
7. Remove lower trim panels.
8. Pull back carpet.



#### **Uniframe Preparation:**

9. Hold up the stiffener to the uniframe and line up the crossmember mounting holes.
10. Using a floor jack with a piece of wood works well to conform the stiffener to the uniframe.
11. Mark the plug welding hole locations and around the outside of the stiffener.
12. Remove stiffener and remove any paint and undercoating from the marked areas.
13. You want to have the uniframe and floor down to bare metal to ensure a good quality weld.
14. Reposition stiffener and make sure it fits tight to the uniframe. C-clamps and a floor jack help with this.
15. Begin tack welding in place.
16. Plug weld side holes.
17. Slowly stitch weld around the uniframe with 1.5" of weld with a 3" gap.
18. Weld to the floor with a 1/4" weld and 2" gap.
19. Once finished, repeat for other side.
20. Clean up welds and paint or undercoat exposed metal to prevent rust.
21. Install transfer case crossmember.
22. Install transfer case mount nuts.
23. Lower vehicle.
24. Install carpet and lower trim panels.
25. Install front and rear seats.