Parts Checklist:

- ❑ Rear adjustable a-arm with bushings installed 92133B (1)
- ❑ WJ a-arm male end 92162 (1)
- ❑ WJ adjustable a-arm axle mount bracket 92163 (1)

#67 - Adjustable A-arm (1)

- ❑ 1 1/2-12 jam nut (1)
- ❑ M14 x 35 cl10.9 hex bolt (3)
- ❑ M14 x 100 cl10.9 hex bolt (1)
- ❑ M14 cl10.9 hex nut (1)
- ❑ 1/2" USS washer (5)

#127 - 2 5/8" 6 Bolt IRO Flex End Hardware

- ❑ Inner race 91118 (2)
- ❑ Thrust washer 91119 (2)
- ❑ Ball 91117 (1)
- ❑ 10-32 x 1-3/4" Socket Head Cap Screw (6)
- ❑ 10-32 Nylock Nut (6)
- ❑ 90 Degree ¼"-28 Grease Zerk Fitting (1)

Safety Warning:

***Important! Read before installation. ***

Knowledge of suspension component function is necessary for safe installation and post installation inspections. Be sure to re-torque all suspension components and lug nuts after the first 100 miles of use, and frequently inspect all safety critical suspension components.

Before you begin:

- ❑ Read all safety warnings.
- ❑ Read and understand installation instructions.
- ❑ Check all steering and suspension components for wear and replace as needed.
- ❑ 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 jack stands.
  - ❑ Basic hand tools.
  - ❑ Multi-purpose grease.
  - ❑ Angle finder (slope gauge).
  - ❑ High strength threadlocker adhesive such as Loctite red.
  - ❑ Anti-seize compound for bolts.
  - ❑ Cable ties (zip ties).

Installation:

1. With the Jeep on the ground and weight on the suspension, measure and record the pinion angle using an angle finder.
   Pinion angle: _____
2. Assemble flex end using the attached flex end instructions.
3. Thread 1 ½" jam nut all the way onto the male threads. Apply anti-seize compound to the male threads and thread male end all the way into the A-Arm as a starting point.
4. Lift rear of vehicle and support with tall jack stands under the unibody frame.
5. Ensure that the vehicle is safely supported.
6. Place a floor jack under the center of rear axle for support (do not lift vehicle).
7. Disconnect all brake lines and ABS wires from the a-arm.
8. Place a jack stand under the pinion to keep the axle from rotating.
9. Remove the a-arm and a-arm ball joint from the vehicle (no need to separate them)
10. Locate a-arm mounting bracket and hardware kit 64. Install the bracket on top of the axle with provided hardware. Use high strength threadlocker and a washer on each bolt. Torque bolts to 100 ft-lbs.
11. Install the a-arm, with the text facing up (legible from top side), into the factory mounts on the unibody side.
12. Torque the two front M12 bolts to 80 ft-lbs., and rear flex end mounting bolt to 120 ft-lbs.
13. Grease flex end grease zerk.
14. Attach brake lines, ABS lines, etc... to new A-Arm using cable ties.
15. Lower vehicle from jack stands.
16. Measure pinion angle and verify it is the same as the number recorded in step 1.
17. Adjust the length of the a-arm as needed to achieve desired pinion angle. If a shorter A-Arm length is needed, move the jam nut to the opposite side of the female threads (inside A-Arm instead of outside).
18. Tighten jam nut very tight.
19. With the vehicle on the ground (or jack stands under the axles), torque any remaining loose bolts to spec.

Final Safety Warning:

* Re-torque all fasteners including lug nuts 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.

Parts Checklist:

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

#127 - 2 5/8" 6 Bolt IRO Flex End Hardware

- ❑ Inner race 91118 (2)
- ❑ Thrust washer 91119 (2)
- ❑ Ball 91117 (1)
- ❑ 10-32 x 1-1/4" Socket Head Cap Screw (6)
- ❑ 10-32 Nylock Nut (6)
- ❑ 90 Degree ¼"-28 Grease Zerk Fitting (1)

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

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.
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, sliding the bolts through the holes.
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.
9. Snug up all of the bolts fairly tight.
10. Torque bolts evenly starting at one bolt using a crisscross pattern, like torqueing lug nuts. Torque all six bolts to 70 in/lbs., then to 85 in/lbs.
11. Install 90 Degree grease zerk 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.