

Single Cylinder Bracket Kit Mounting instructions

Remove pinion yoke. Remove dust shield. Cut the flange off of the yoke. Clean-up and reinstall yoke.



Remove three bolts from the pinion flange. Install and tighten the cylinder bracket (stamped "T" UP) w/ provided spacers and new 3 1/2 bolts w/ lock washers.



Top view



Front view

Remove three bolts from the side carrier cover. Install and tighten the side bracket (stamped "T" UP) w/



Side view

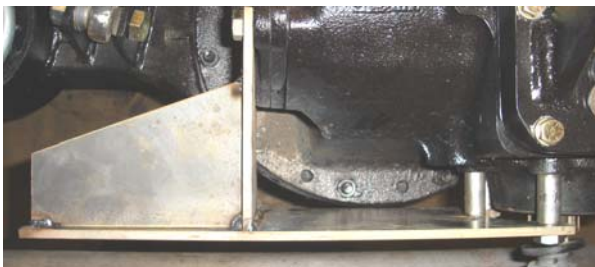
new 2" bolts and lock washers.

Use clamps to properly align cylinder bracket and side bracket. Tac-weld into place.



Side view

Tac-weld gussets into place. (1/2" from top and bottom).



Top view



Side view

Finish welding out all accessible joints on brackets and gussets.

While kit is cooling install your **high steer arms**.



Remove steering arm.



Remove studs from steering knuckle.



Remove bolts and top plate from opposite knuckle.



If your axel has them, be sure and retain the spacers under the old arm and under the top plate.



Spacer



spacer shown w/ top plate for size comparison

Install high steer arms with new bolts & lock washers provided. Torque to 130-140 ft/lb.



Position clamps just to the inside of the hose mounts and tape cylinder to protect from welding splatter.



Find center of axel and mark on cylinder bracket. Center the cylinder and clamps on the cylinder bracket, align top of cylinder clamps **FLUSH** with top of cylinder bracket. Tac-weld into place.



Remove cylinder and finish welding cylinder mounts to the cylinder bracket.



Allow kit to cool before removing.

Remove kit and finish welding any missed joints. Allow to cool.

Re-install kit and mount cylinder. Adjust shaft for an equal amount on each side. (approx. 4 1/2")



Install a clevis into each cylinder shaft end. Be sure that you align them threaded side down.



Install provided rod end w/ jam nut and threaded insert into the clevis (left hand) and high steer arm (right hand). Leave approx. 3/8" of thread exposed for adjustment.



Left hand threads



right hand thread

Measure between threaded insert "shoulders", both sides should be equal if the toe is properly set. Cut provided tubing pieces, to length, for both sides. (Approx. 8")



Remove threaded inserts from rod ends and tac-weld into tubing. Weld out and allow to cool.



Re-install rod ends, align knuckles for proper toe adjustment, and tighten down jam nuts.



Final product!!

