



**1. THINK SAFETY, ALWAYS WEAR SAFETY GLASSES WHEN PERFORMING THE OPERATIONS PRESCRIBED IN THESE INSTRUCTIONS**

**2. READ ALL INSTRUCTIONS CAREFULLY BEFORE ATTEMPTING INSTALLATION**

**ASSEMBLY TOOLS NEEDED:**

Impact Sockets: 7/16" – 1-3/8"  
Wrenches: 7/16" – 1-3/8"  
Torque Wrench:  
Drill Bits: 1/4", 1/2"  
Center Punch and Hammer  
Two (2) C-Clamps

TORQUE SPECIFICATIONS FOR STANDARD MACHINE HARDWARE					
Bolt Size	GR.2 Dry	GR.5 Dry	GR.8 Dry	Metric Size	GR.8.8 Dry
1/4"	66*	9	12	M8	17
5/16"	11	17	25	M10	35
3/8"	20	30	45	M12	60
7/16"	32	50	70	M14	95
1/2"	50	75	110	M16	155
9/16"	70	110	150		
5/8"	100	150	220		
3/4"	175	260	380		
7/8"	170	430	600		
1"	250	640	900		

NOTE: These torque values are to be used for all hardware. Unless otherwise specified, all torque values must meet this specification.  
NOTE: All torque values are in Ft-Lbs unless otherwise stated  
\*In-Lbs

**INSTALLATION NOTES:**

1. Mount Sub-Frame assembly completely before tightening any bolts unless otherwise specified.
2. Vehicle front suspension must be in normal position (as with vehicle on the ground) to install sub-frame assembly.

**MOUNTING INSTRUCTIONS:**

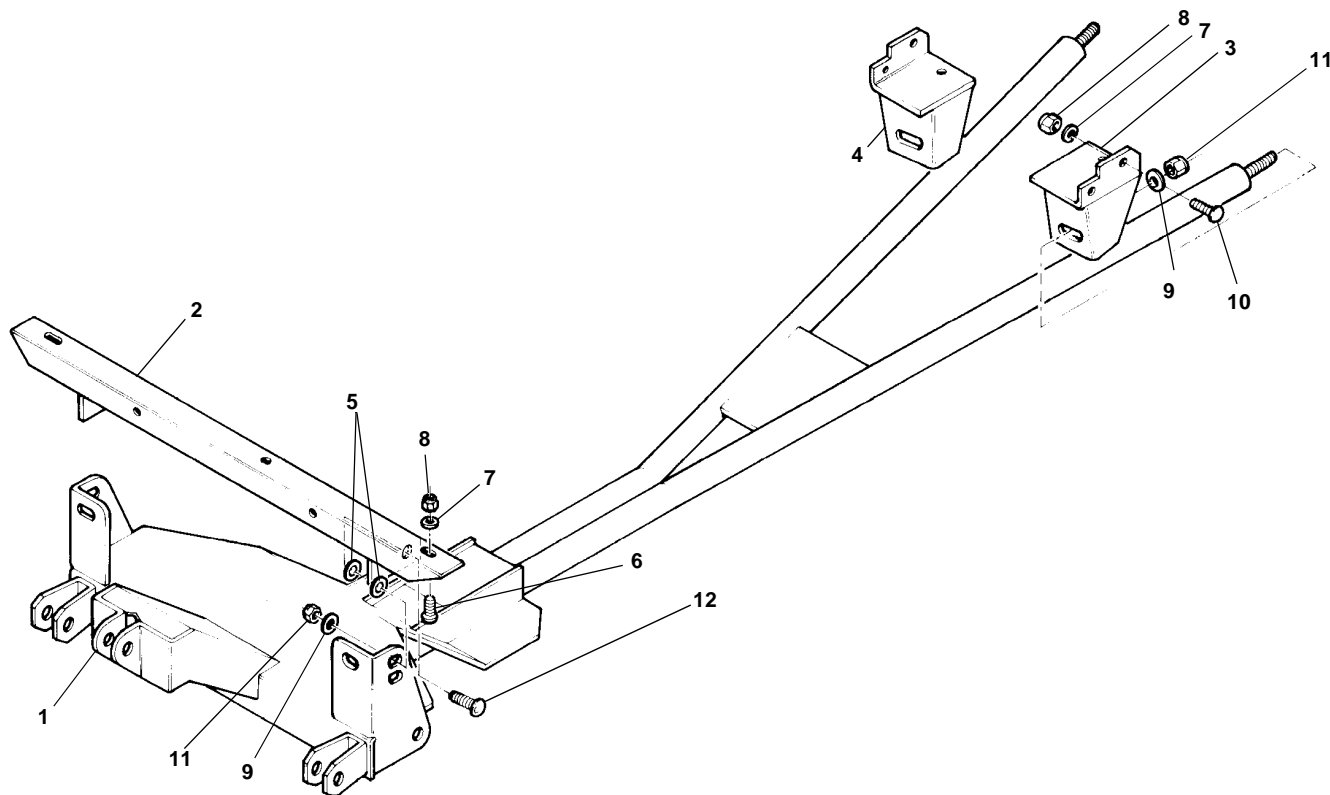
1. Remove existing vehicle left and right bumper bolts.
2. Enlarge vehicle lower lip bumper bolt holes to 1/2" Diameter and install Front Crossmember (#96001198) using 1/2" x 1-1/2" Capscrews (#98009010), Washers and Nylock Nuts provided.
3. Using center hole in Front Crossmember (#96001198) as a template, drill 1/2" hole through lower lip of vehicle front bumper and secure with 1/2" x 1-1/2" Capscrew (#98009010), Washer and Nylock Nut provided.
4. Raise front of Sub-Frame Assembly (#96101351) and align front Sub-Frame mounting holes with Front Crossmember (#96001198) mounting holes. Secure with 5/8" x 2-1/2" Capscrews (#98009259), Washers and Nylock Nuts provided.
5. Attach Support Rail Brackets (#96001304)RH, and (#96001303)LH to Sub-frame Support Studs with 5/8" Nylock Nuts (#98009038) and Washers provided.
6. Raise LH and RH Support Brackets to vehicle frame rails and clamp with two C-clamps.



**Beware of brake and fuel lines secured to inside wall of frame rails when performing Step 7.**

7. Using holes in sides of LH and RH Support Brackets as templates, centerpunch and drill 1/4" then 1/2" holes into vehicle frame rails. Secure Support Brackets to frame rails with 1/2" x 3-1/2" Capscrews (#98009036), Washers and Nylock Nuts provided.
8. Using the Torque specification chart above, torque all bolts, start at the rear and work forward.
9. **Remember** After 5 to 10 hours of snowplow usage, re-torque all capscrews!

**1972 - 1986 JEEP 4X4 CJ5, CJ6, AND CJ7**  
**Sub-Frame Assembly & Installation Instructions**  
**Part No. 99004012 Sub-Frame (Complete) Includes Hardware**



ITEM	PART NO.	DESCRIPTION	QTY.
1	96101351	Sub-Frame Assembly .....	1
2	96001198	Crossmember, Front .....	1
3	96001303	Bracket, Rear Mounting, LH .....	1
4	96001304	Bracket, Rear Mounting, RH .....	1
5	98009028	Washer, Spacer .....	4
6	98009010	Capscrew, Hex Head, 1/2" -13 NC x 1 1/2" .....	3
7	98009011	Washer, Flat, 1/2" .....	7
8	98009013	Nut, Hex Head, Nylock, 1/2"-13 NC .....	7
9	98009039	Washer, Flat, 5/8" .....	6
10	98009036	Capscrew, Hex Head, 1/2" -13 NC x 3 1/2" .....	4
11	98009038	Nut, Hex Head, Nylock, 5/8" -11NC .....	6
12	98009259	Capscrew, Hex Head, 5/8" -11 NC x 2-1/2" .....	4

