



**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"
Metric Sockets	10—19mm
Wrenches	7/16"—1-3/8"
Torque Wrench	
Drills	1/4", 9/16"
Hammer	
Center Punch	
2-6" C-Clamps	

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. To Install Sub-Frame the vehicle front suspension must be in a normal position such as when the vehicle is parked on level ground.

**MOUNTING INSTRUCTIONS:**

1. Remove vehicle front bumper.
2. Remove existing left and right vehicle tie down brackets and replace with two (2) Front Mounting Brackets (#96001233). Secure using four (4) 3/8" x 3-1/2" Capscrews (#98009093) Washers, and Nylock Nuts provided.
3. Raise Sub-Frame Assembly (#96101512) to Front Mounting Brackets and secure with two (2) 5/8" x 2" Capscrews (#98009041) Washers, and Nylock Nuts provided.
4. Install Mounting Brackets (#96001171)RH, (#96001170)LH to the Sub-Frame Assembly support rail studs using 5/8" Nylock Nuts (#98009038) and Flat Washers provided.
5. Raise rear of Sub-Frame Assembly and secure Rear Mounting Brackets tight to vehicle frame rails and secure with C-clamps.

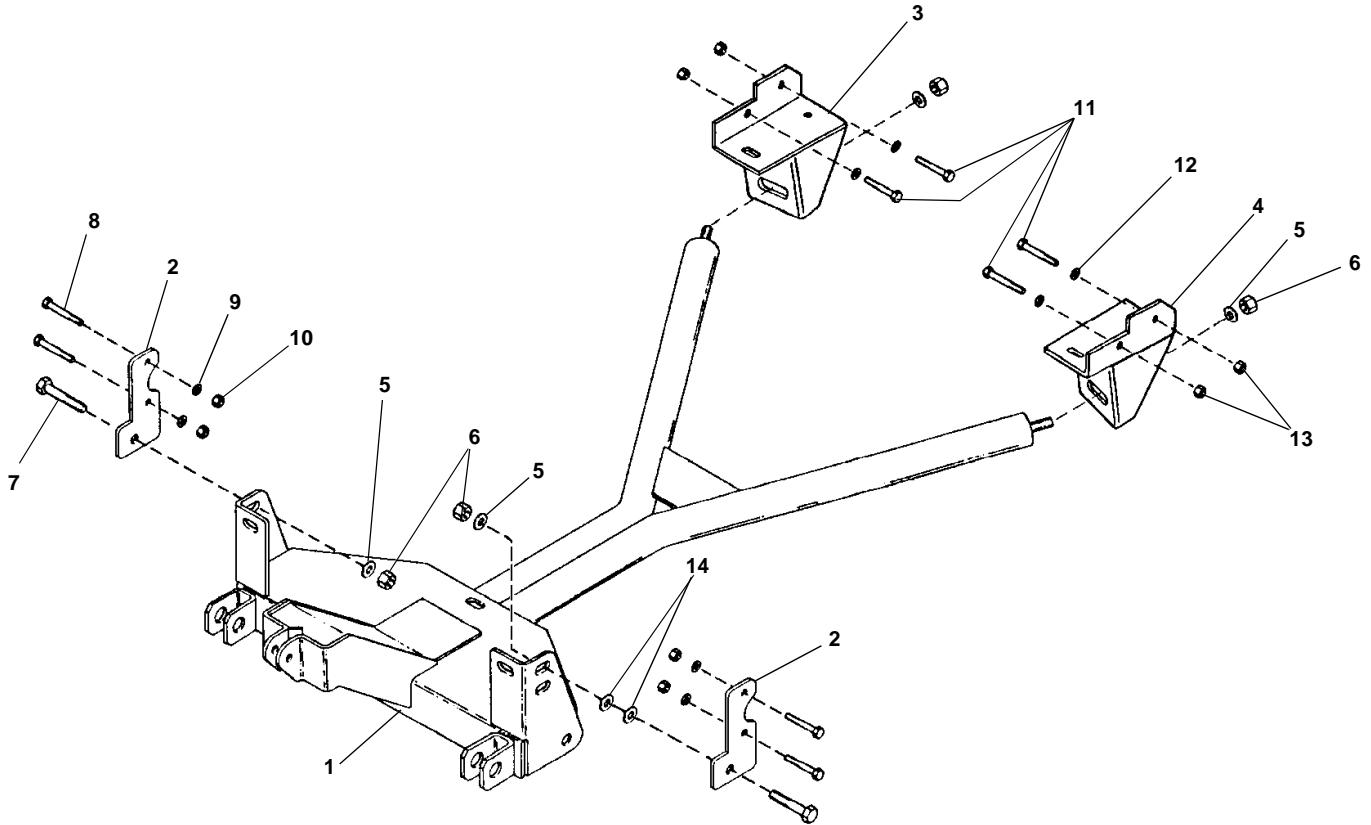


**CAUTION**

**Beware of brake and fuel lines secured to inside wall of frame rails when performing Step 6.**

6. Using holes in side of Rear Mounting Brackets as a template drill 1/4" the 9/16" holes though vehicle frame.
7. Secure Mounting Brackets to frame using four (4) 1/2" x 3-1/2" Capscrews (#98009036) Washers, and Nylock Nuts provided. Install Capscrews from frame side. See illustration.
8. Using the Torque Specification Chart above, torque all bolts starting at the rear and working forward.
9. Re-install vehicle front bumper.

**1986 & LATER SUZUKI 4 X 4 SAMURAI**  
**Sub-Frame Assembly & Installation Instructions**  
**Part No. 99004024 Sub-Frame (Complete) Includes Hardware**



ITEM	PART NO.	DESCRIPTION	QTY.
1	96101512	Sub-Frame Assembly .....	1
2	96001233	Bracket, Mounting, Front.....	2
3	96001171	Bracket, Mounting, RH.....	1
4	96001170	Bracket, Mounting, LH .....	1
5	98009039	Washer, Flat, 5/8" .....	4
6	98009038	Nut, Hex, Nylock, 5/8"-11NC .....	4
7	98009041	Capscrew, Hex Head, 5/8"-11NC x 2" .....	2
8	98009093	Capscrew, Hex Head, 3/8"-16NC x 3-1/2" .....	4
9	98009032	Washer, Flat, 3/8" .....	4
10	98009009	Nut, Hex, Nylock, 3/8"-16NC .....	4
11	98009036	Capscrew, Hex Head, 1/2"-13NC x 3-1/2" .....	4
12	98009011	Washer, Flat, 1/2" .....	4
13	98009013	Capscrew, Hex Head, 1/2"-13NC.....	4
14	98009028	Washer, Spacer .....	4

