



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) 6" 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 vehicle front bumper.

 **CAUTION**

Beware of brake line on back side of crossmember when performing Step 2.

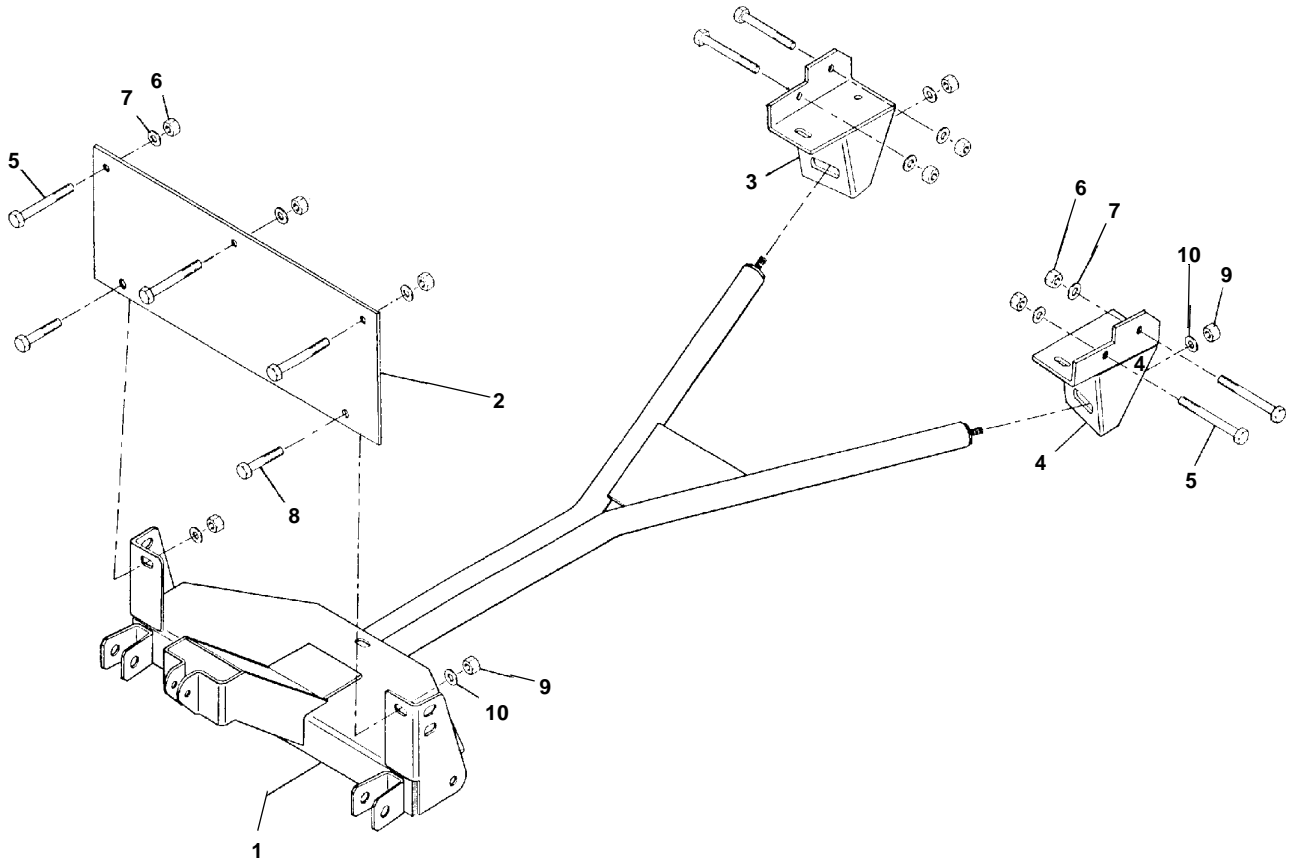
2. Locate existing 9/16" hole in center of front vehicle #1 crossmember. Using it as a template, drill a 9/16" through the second wall of the crossmember.
3. Using center hole in front vehicle front crossmember, attach Front Crossmember (#96101539) with a 1/2" x 3-1/2" Capscrew (#98009036), Washer and Nylock Nut. Tighten until snug.
4. Level the Front Crossmember on front vehicle crossmember. Using the outside holes in the Front Crossmember as a template, centerpunch and drill 1/4" then 1/2" holes through vehicle crossmember, attach Front Crossmember to vehicle crossmember with 1/2" x 3 1/2" Capscrews (#98009036), Washers and Nylock Nuts provided.
5. Attach Sub-Frame (#96101531) to Front Crossmember with 5/8" x 2" Capscrews (#98009041), Washers and Nylock Nuts provided.
6. Attach and Support Brackets (#96001171) RH, (#96001170) LH, to Sub-Frame Support Studs with 5/8" Nylock Nut (#98009038) and Washers. Clamp LH and RH Support Brackets to vehicle frame rails with two 6" C-clamps.

 **CAUTION**

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 Nut provided.
8. Re-install front bumper.
9. Using the Torque Specification Chart above, torque all bolts, start at the rear and work forward.

1976 - 1983 JEEP 4X4 CHEROKEE AND WAGONEER
1984 - 1990 JEEP 4X4 GRAND WAGONEER
1976 - 1988 JEEP 4X4 J10 - J20 PICKUP
Sub-Frame Assembly & Installation Instructions
Part No. 99004042 Sub-Frame (Complete) Includes Hardware



ITEM	PART NO.	DESCRIPTION	QTY.
1	96101531	Sub-Frame Assembly	1
2	96101539	Crossmember, Front	1
3	96001171	Bracket, Right Support.....	1
4	96001170	Bracket, Left Support	1
5	98009036	Capscrew, Hex Head, 1/2" X 3-1/2"	7
6	98009013	Nut, Self-locking, 1/2"	7
7	98009011	Washer, Flat, 1/2"	7
8	98009041	Capscrew, Hex, Head, 5/8" X 2"	2
9	98009038	Nut, Self-locking, 5/8"	4
10	98009039	Washer, Flat, 5/8"	4