



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	

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. 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 skid plate and tow hook. Retain hardware.
2. Remove the two lower bolts from the bumper mounting brackets.
3. Locate Mounting Brackets (#96101567)RH, (#96101570)LH to the bumper mounting brackets and skid plate mounting holes. Secure with existing skid plate mounting bolts and two (2) M12 Metric Capscrews (#98009054) and Flat Washers provided.

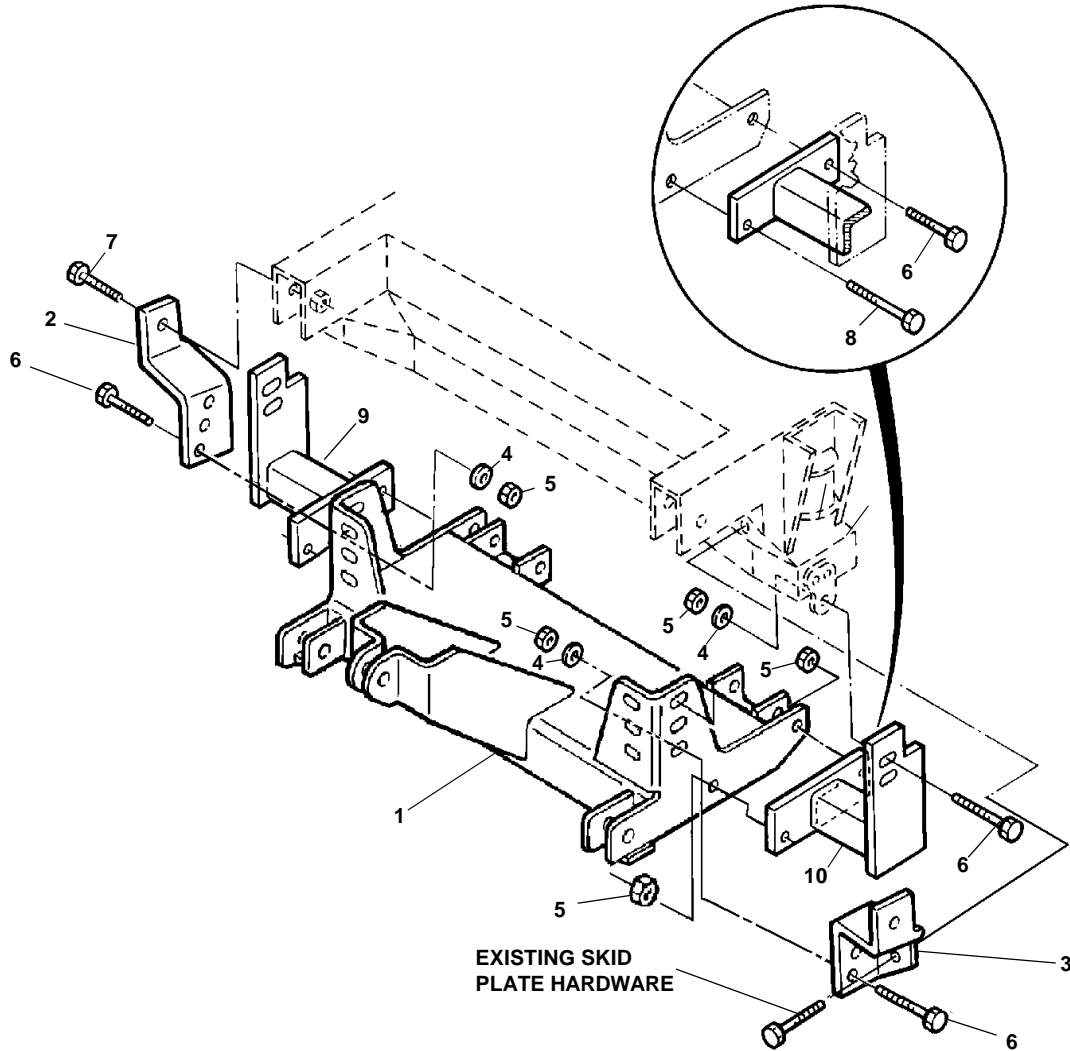
NOTE: It is recommended that Loctite® or similar thread locking material be used on the Metric Capscrews during installation.

4. Fasten Rear Supports (#96101572)RH and (#961015730)LH to Sub-Frame Assembly (#96100294) with two (2) 5/8" x 2" Capscrews (#98009041), two (2) 5/8" x 3-1/2" Capscrews (#98009042), Washers, and Nylock Nuts provided.

NOTE: Notch in Rear Supports must face to rear of vehicle.

5. Raise Sub-Frame Assembly to Bumper mounting brackets and secure with four (4) 5/8" x 2" Capscrews (#98009041) Washers, and Nylock Nuts provided.
6. Insert two (2) 5/8" x 2" Capscrews (#98009041) in holes of Rear Supports aligned with rear holes formerly used for vehicle hold down brackets. Secure with Nylock Nuts provided.
7. Using the Torque Specification Chart above, torque all bolts starting at the rear and working forward.

1987—91 ISUZU 4X4 TROOPER
Sub-Frame Assembly & Installation Instructions
Part No. 99004040 Sub-Frame (Complete) Includes Hardware



ITEM	PART NO.	DESCRIPTION	QTY.
1	96100694	Sub-Frame, Nose Piece (96100294)	1
2	96101567	Bracket, Mounting, RH	1
3	96101570	Bracket, Mounting, LH	1
4	98009039	Washer, Flat, 5/8"	6
5	98009038	Nut, Hex, Nylock, 5/8"-11NC	6
6	98009041	Capscrew, Hex Head, 5/8"-11NC x 2"	8
7	98009054	Capscrew, Hex Head, M12 - 1.75 X 40	2
8	98009042	Capscrew, Hex Head, 5/8"-11NC x 3-1/2"	2
9	96101572	Support Assembly, Rear Right	1
10	96101573	Support Assembly, Rear Left	1

