

JL4718

JL / JT HD CROSS-MEMBER KIT



ESTIMATED INSTALLATION TIME

1 hour(s)

REQUIRED SKILLS

- General Mechanics Skills

REQUIRED TOOLS & SUPPLIES

- 19mm wrench
- 18mm wrench
- 13mm wrench
- 1/2mm wrench
- 21mm socket
- 19mm socket
- 18mm socket
- 10mm socket
- Transmission jack / jack stand/ supporting device

NOTES:

- Component appearance in instructions may vary from those received

WARNING MESSAGES

This product demands a basic understanding of mechanical procedures and should only be installed by individuals proficient with mechanic's tools. Any tasks involving welding or cutting parts should be performed by trained professionals. Artec Industries disclaims responsibility for mishaps arising from improper installation, or any damage or accidents resulting from cutting or welding tasks. Exercise caution and seek professional help as required.

SAFETY

1. We've furnished a written installation guide, along with relevant details, to aid you in making safety-conscious decisions.
2. While these guidelines will highlight potential risks, it's crucial to exercise your personal judgment when performing any required steps.
3. Before initiating any tasks, it's essential to conduct a job safety analysis to identify specific hazards in your situation and take measures to eliminate or protect against them.
4. Before commencing the installation of this product, make sure you familiarize yourself with and fully understand all safety warnings and guidelines.

DISCLAIMERS

All Artec Industries products should be installed by a competent, certified individual following the intended installation instructions for each product. Incorrect installations not only nullify any warranties but could also lead to product damage or even damage to the vehicle it's installed on. Prior to installation, carefully read all provided instructions or manuals, and watch any associated videos. For any doubts or queries, reach out to Artec Industries before beginning the installation process.

Many products necessitate lifting and supporting the vehicle off the ground. It is the installer's responsibility to ensure this can be done safely and that the right equipment is at hand to carry out the installation. Artec Industries installation instructions presume the installer is competent to lift the vehicle safely and correctly.

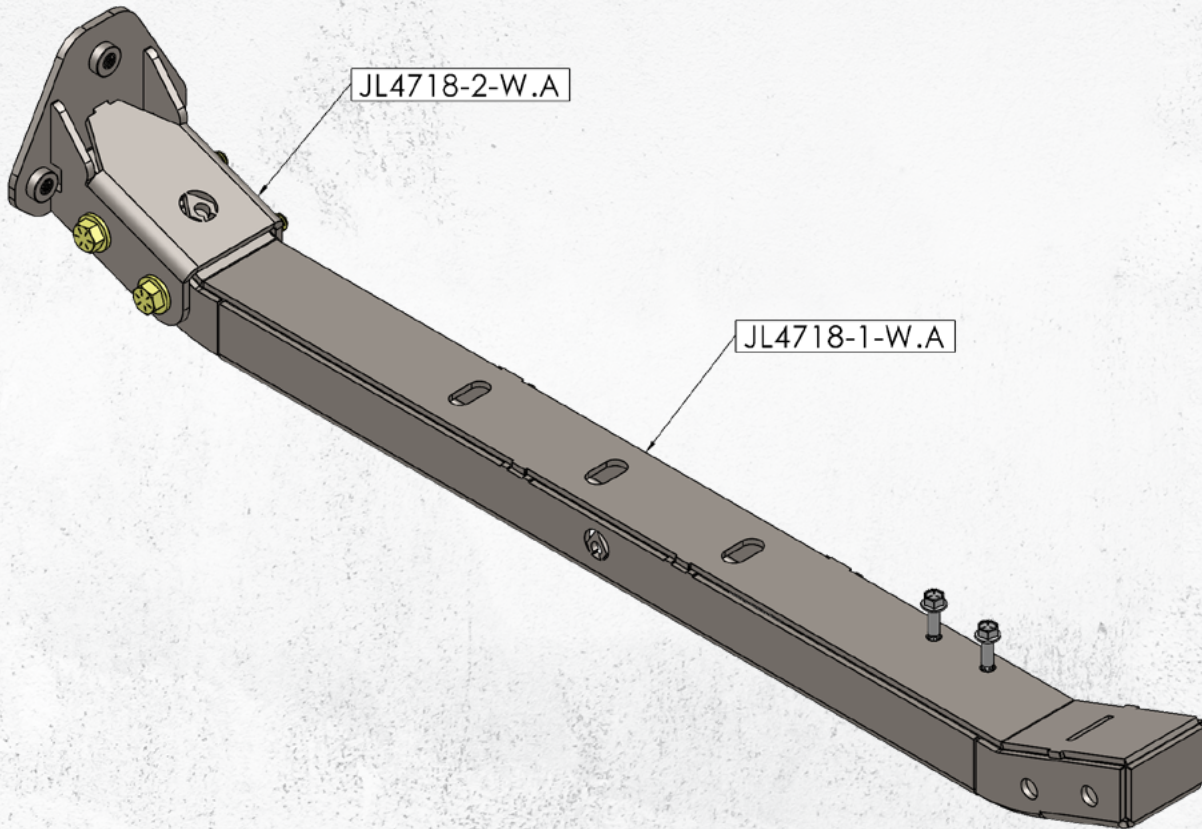
Modified vehicles won't perform identically to their stock counterparts. It's incumbent upon the vehicle owner to understand the alterations such modifications will bring to the vehicle's driving dynamics. These might encompass (but aren't limited to): changes in handling, braking, rollover angle, and potential incompatibilities with the factory-installed anti-lock braking systems, stability control systems, or traction control systems.

SPECIAL NOTES

- Unless otherwise noted, all hardware should be **LOOSELY** tightened by hand until the very end of installation when all components are attached.
- This kit requires the lowering of your fuel tank. If you are not comfortable completing this process, please seek an installer.

JL4718 PARTS BILL OF MATERIALS

Please confirm you have all the listed parts below **BEFORE** beginning your installation. If any parts are damaged or missing, **KEEP ALL ORIGINAL BOXES and PACKAGING** and contact us.

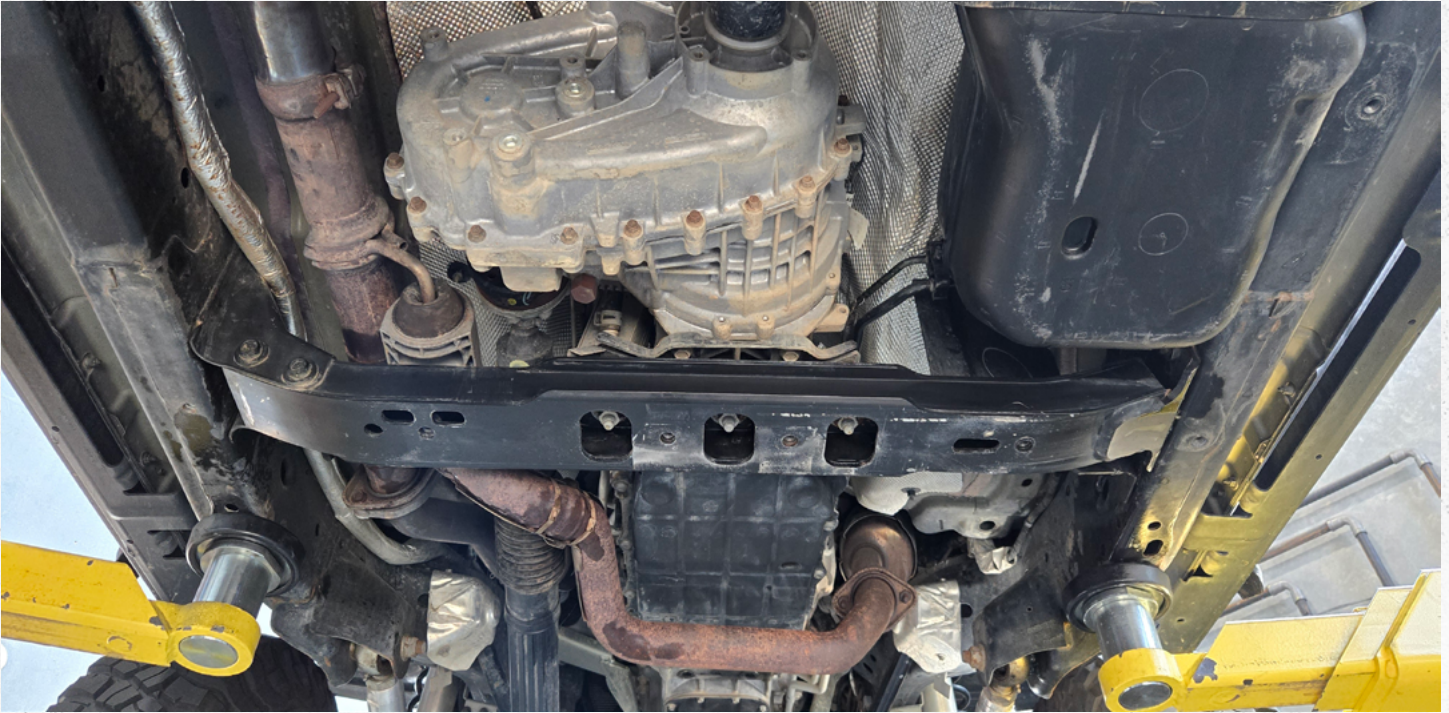


NOTE: The part numbers indicated above end in a “.” and “letter” which indicate the revision number for the part. The etched part number on your physical parts do not need to match the above drawing revision exactly.

JL4718 BILL OF MATERIALS

ITEM NO.	DESCRIPTION	QTY.
A	3/8" x 1.5 Countersink Allen Head Bolt - Zinc	4
B	.375" Countersunk Aluminum Washer	4
A	1/2"-13 x 4.75" Long Hex Head Cap Screw	2
B	1/2"-13 Nylock Lock Nut	2
C	1/2" F436 Flat Washer Type1 Yellow Zinc	4
F	5/16-18 x 1.75in Zinc-Plated Grade 5 Steel Flanged Hex Head Screws	2

ASSEMBLY INSTRUCTIONAL GUIDE



Step 1:

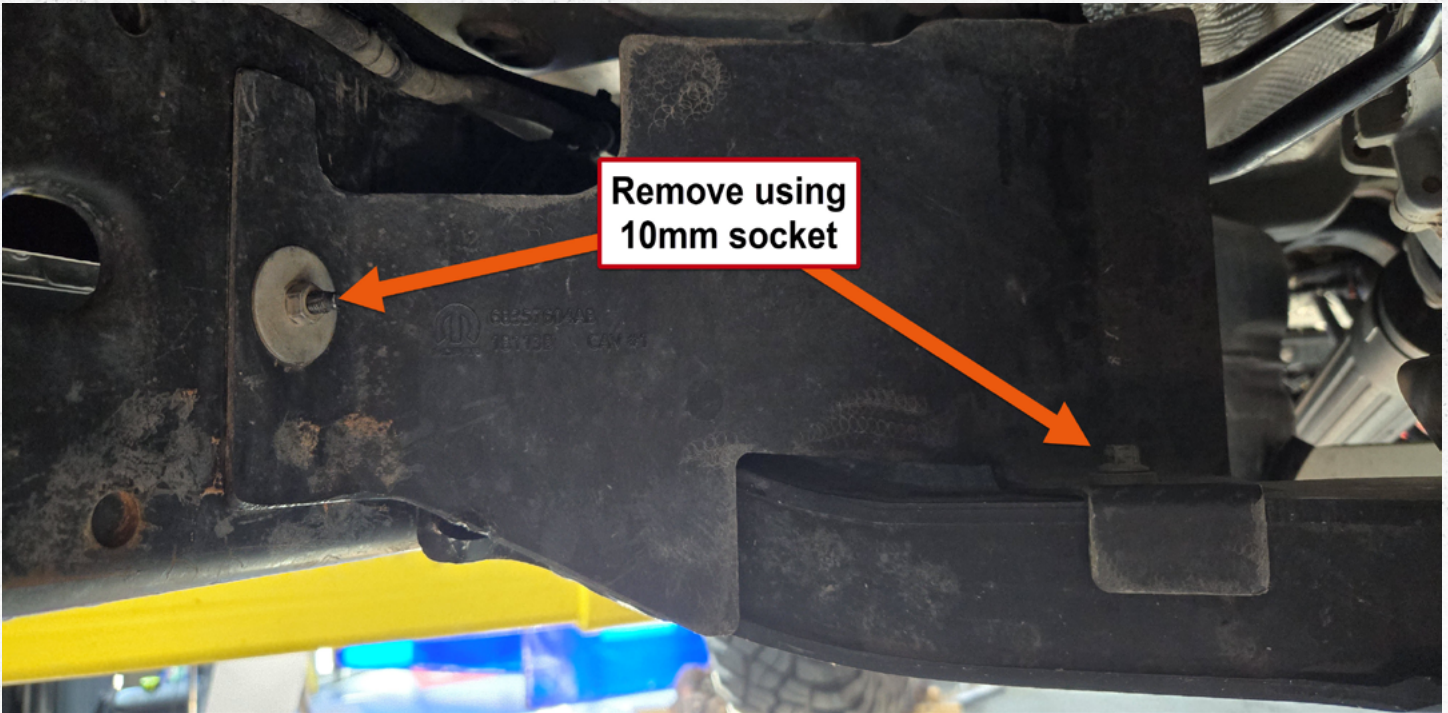
Remove any aftermarket or factory skid plates from the vehicle. This vehicle has our JLU belly pan which we have uninstalled using a 7/32" hex bit.



Step 2:

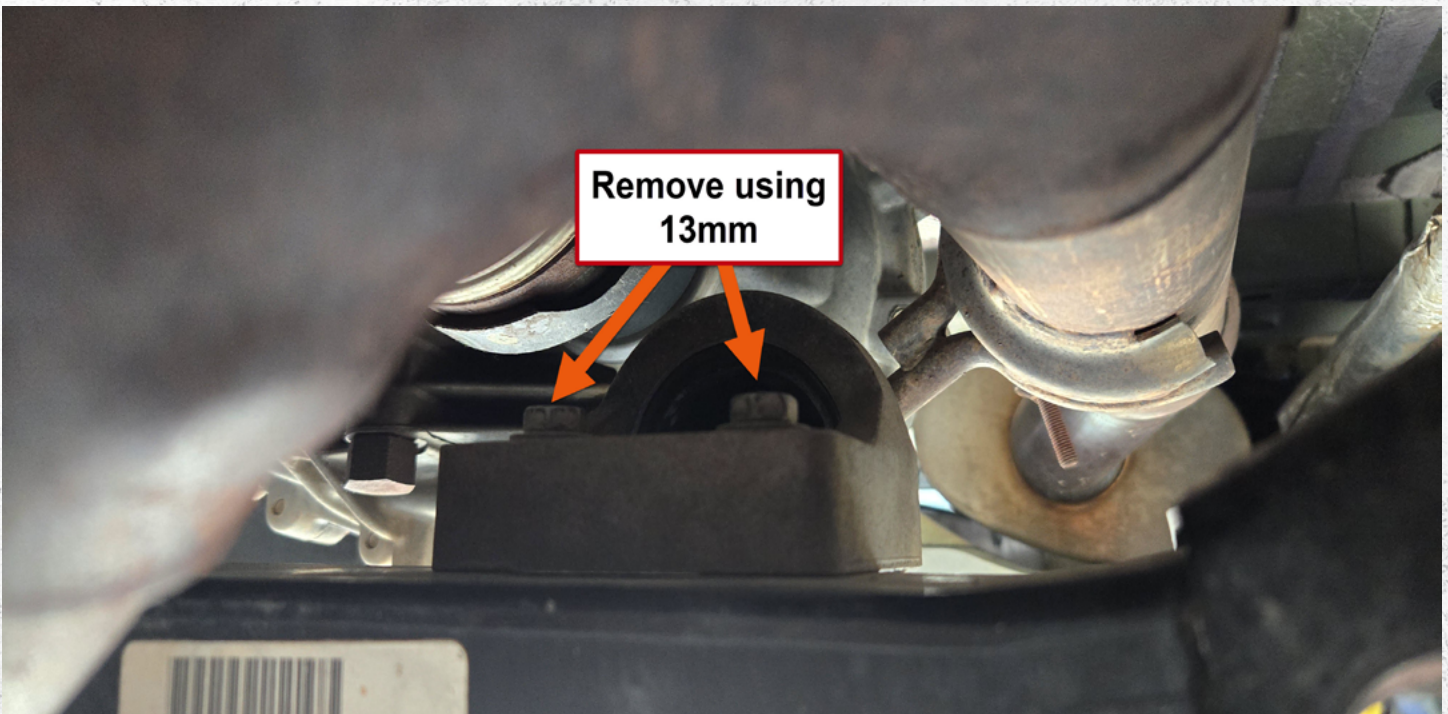
Support the transmission for removal of the factory cross-member.

ASSEMBLY INSTRUCTIONAL GUIDE



Step 3:

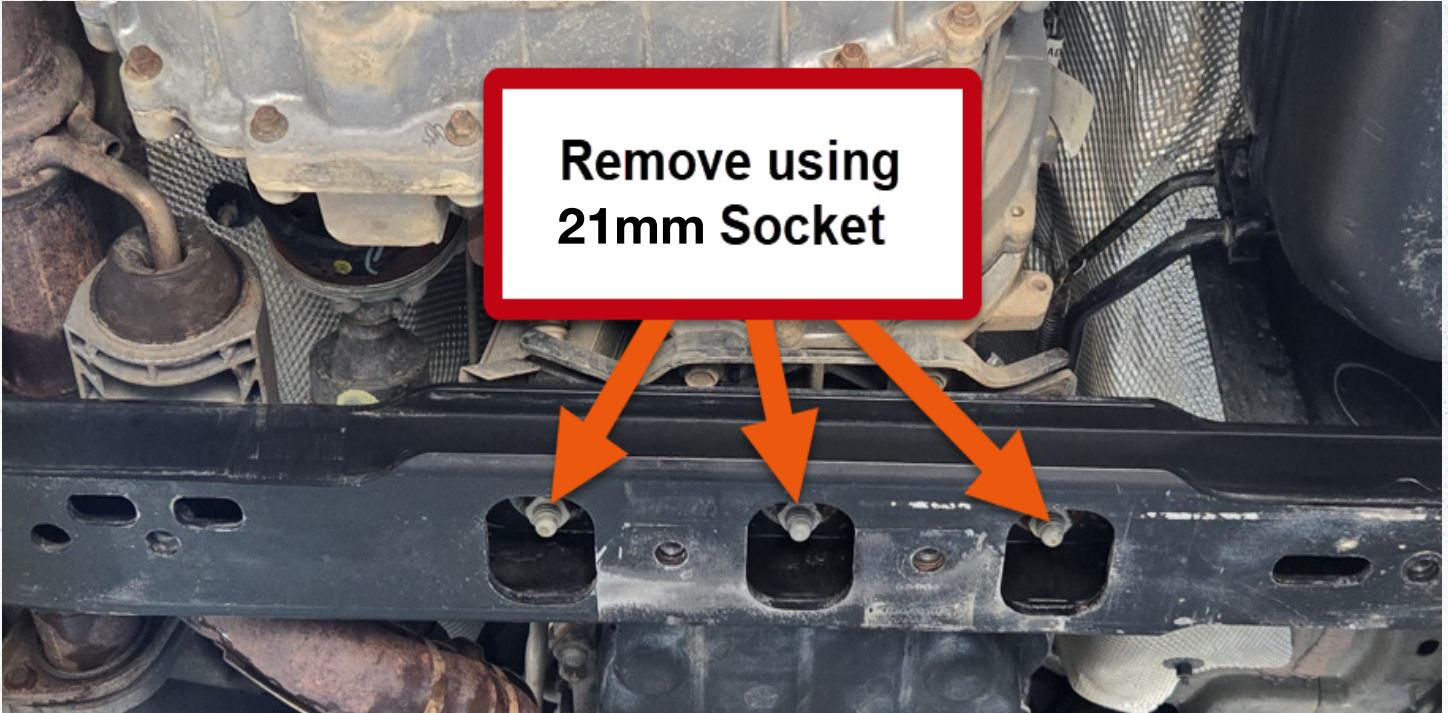
Remove the two pieces of hardware supporting the head shield on the passenger side of the cross-member using a 10m socket or wrench.



Step 4:

On the driver side of the vehicle, remove the two bolts supporting the exhaust hanger using a 13mm wrench.

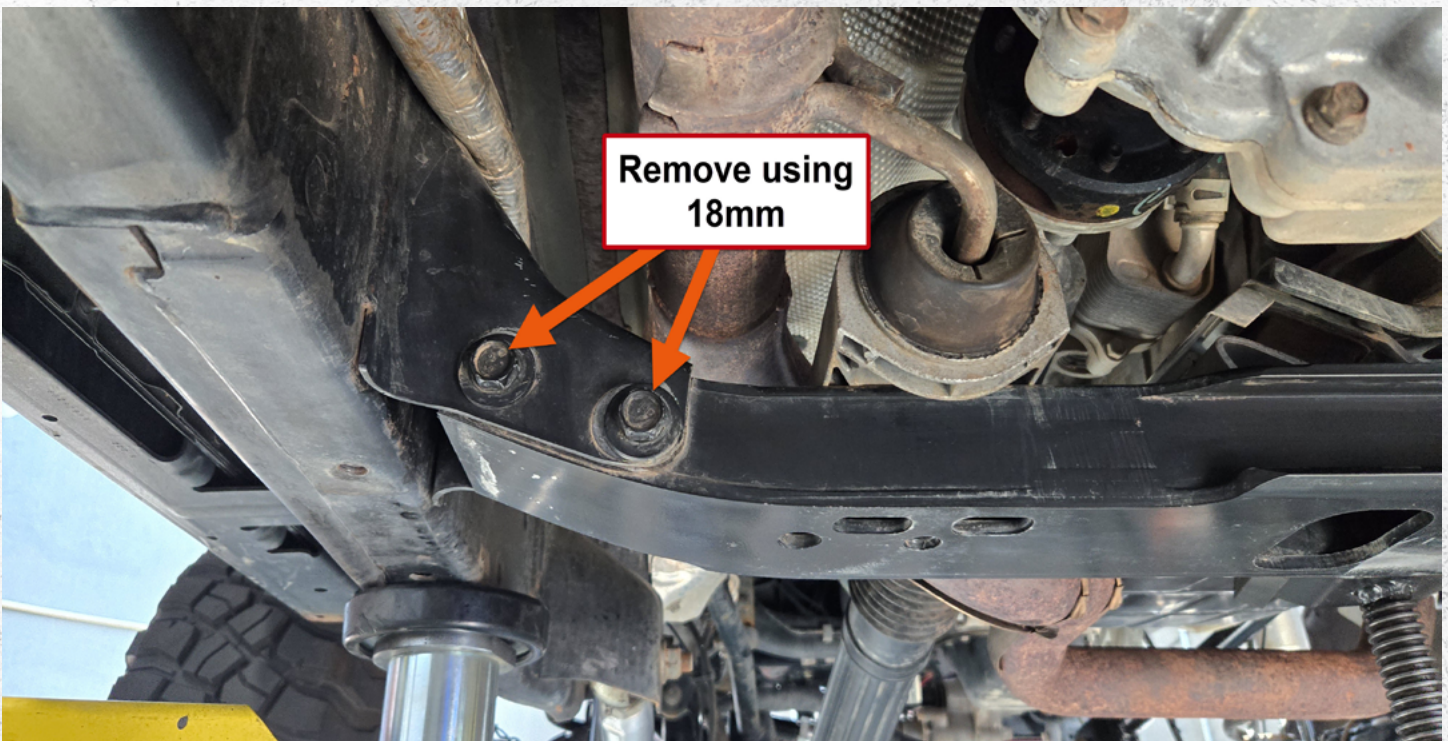
ASSEMBLY INSTRUCTIONAL GUIDE



Remove using
21mm Socket

Step 5:

Remove the three nuts from the transmission support bracket using a 21mm socket.

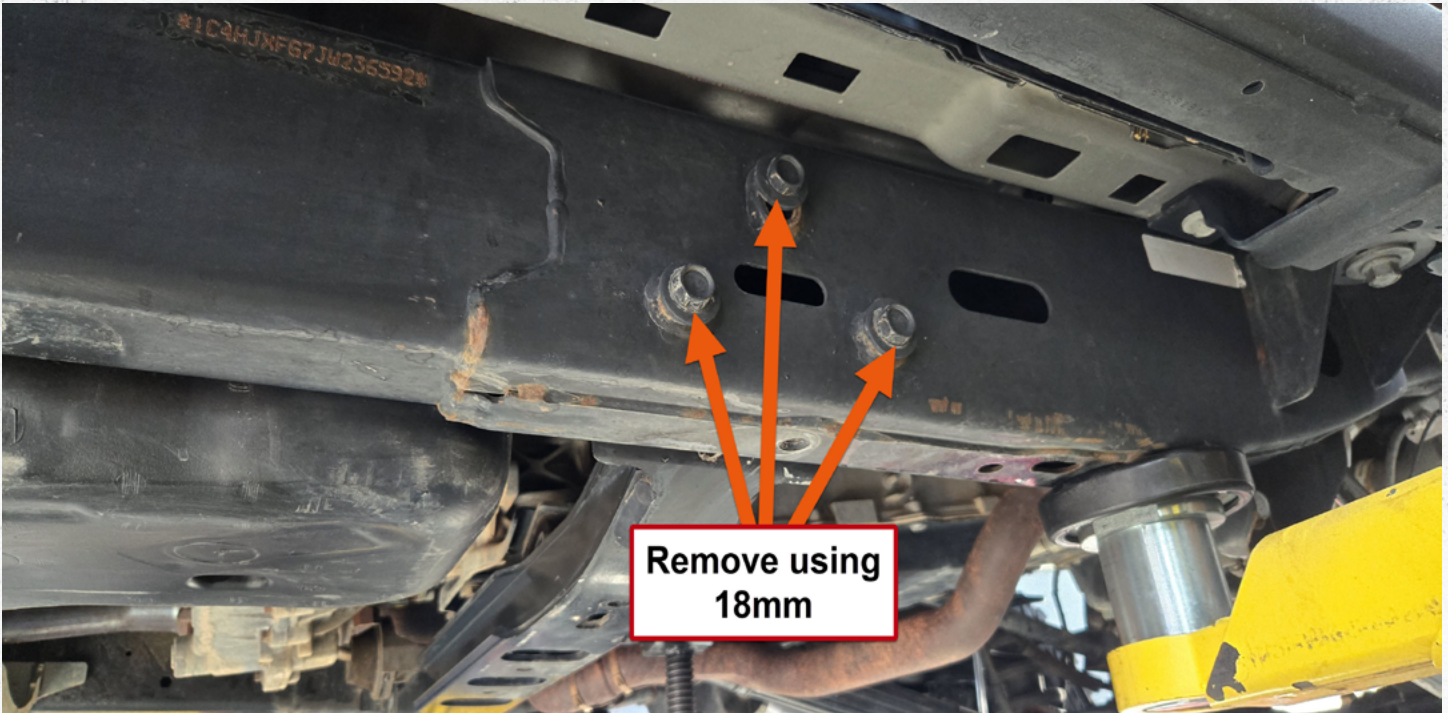


Remove using
18mm

Step 6:

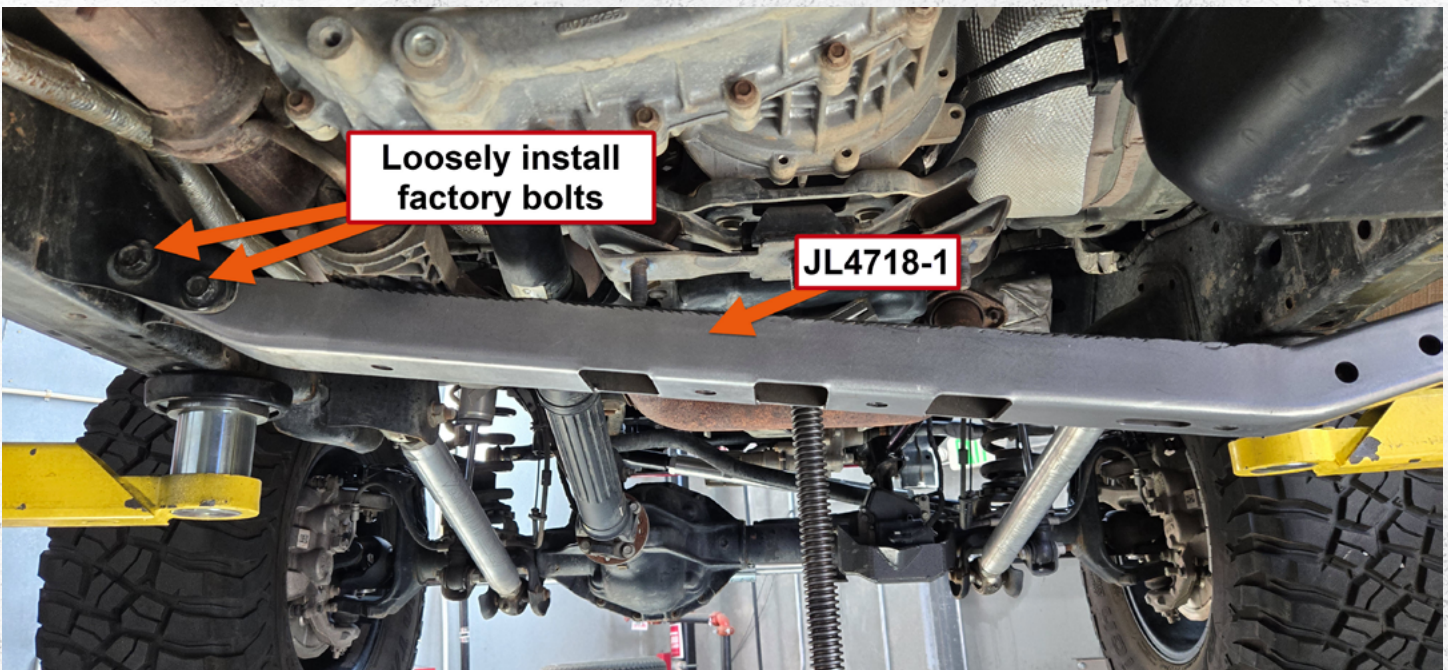
Remove the two factory bolts from the cross-member on the driver side of the vehicle using an 18mm socket and wrench.

ASSEMBLY INSTRUCTIONAL GUIDE



Step 7:

Remove the three bolts holding in the cross-member using an 18mm socket.

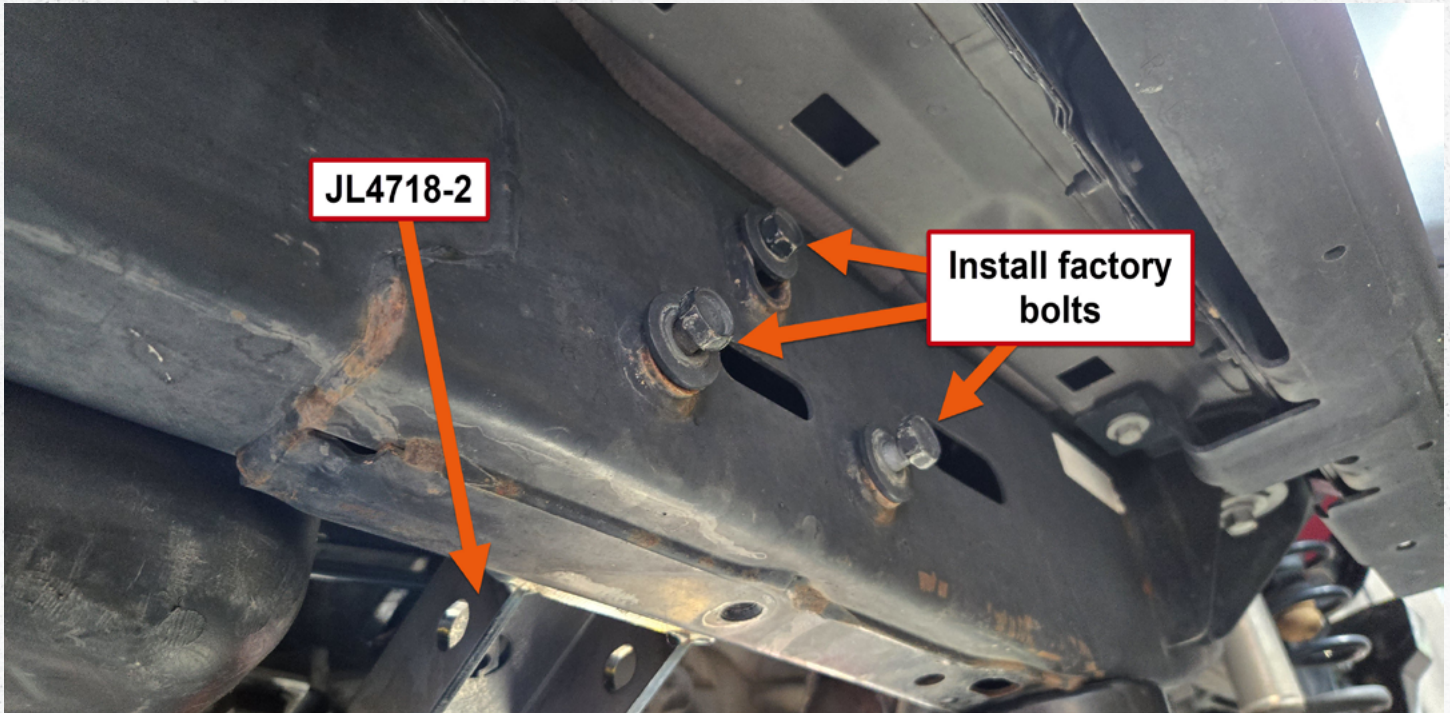


Step 8:

Install the cross-member **JL4718-1** starting on the driver side of the vehicle using the factory bolts.

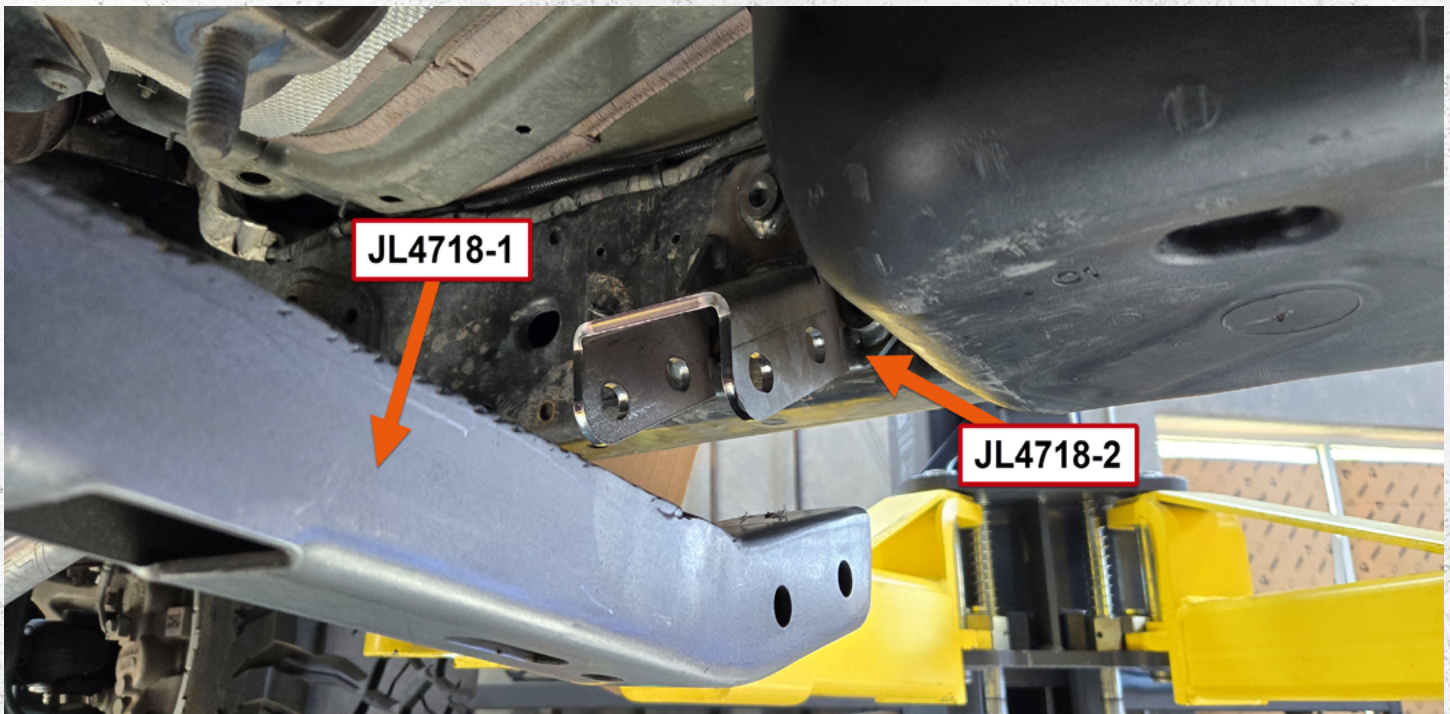
Orientate the cross-member so that the two Pem holes are on the driver side of the vehicle.

ASSEMBLY INSTRUCTIONAL GUIDE



Step 9:

Install the **JL4718-2** bracket using the three factory bolts that were removed from the passenger side of the frame.



Step 9: (Additional view)

ASSEMBLY INSTRUCTIONAL GUIDE



Step 10:

Install two grade 8 1/2" x 4.75" bolts with zinc washers and nylon lock nuts.



Step 10: (Additional view)

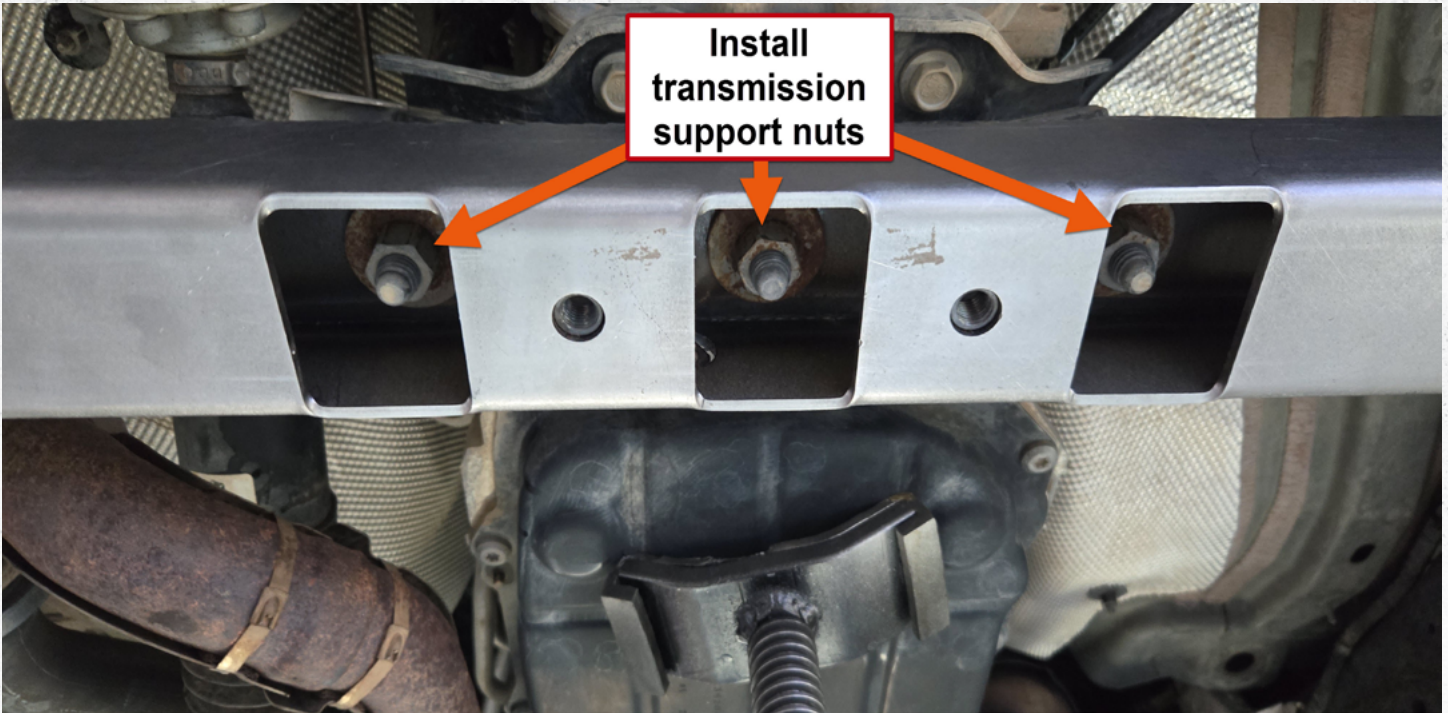
ASSEMBLY INSTRUCTIONAL GUIDE



Step 11:

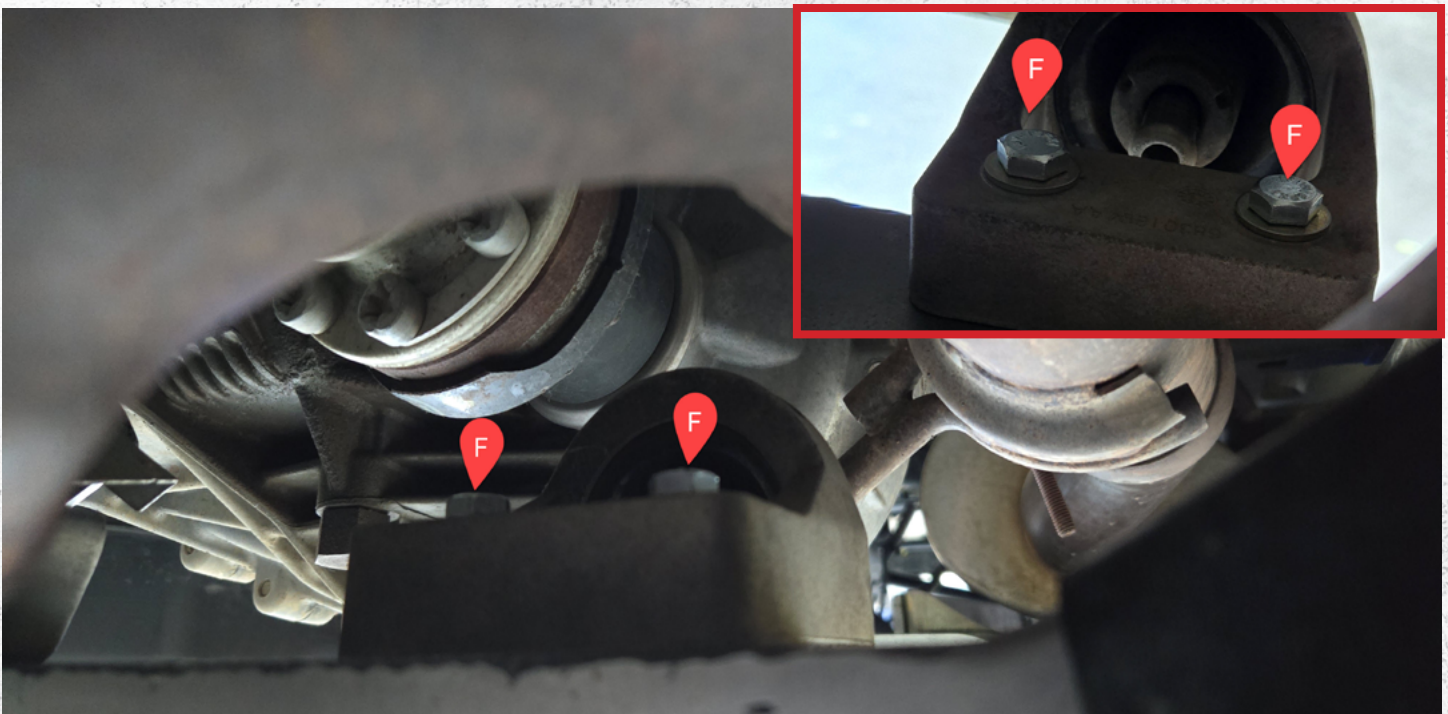
Tighten all of the hardware supporting the cross member. The 1/2" grade 8 bolts can be tightened using a 19mm socket and wrench.

ASSEMBLY INSTRUCTIONAL GUIDE



Step 12:

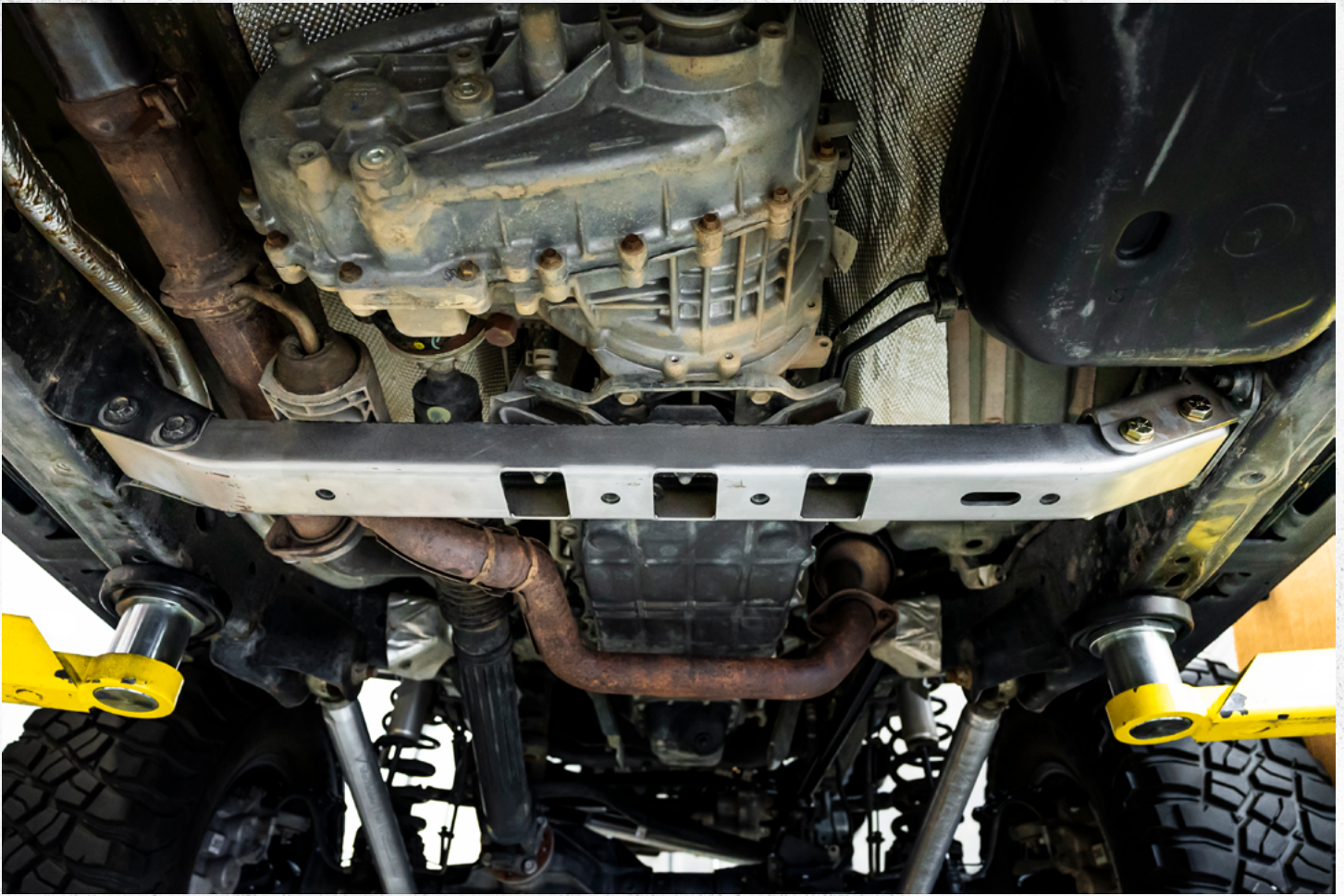
Re install the three nuts holding the transmission support bracket to the cross-member and tighten to spec.



Step 13:

Install the two provided 5/16-18 x 1.75" flange bolts to secure the exhaust flange to your new cross-member.

You have finished the installation, you may re install your factory skid plates using the new 3/8 hardware with countersunk aluminum washer. (Green A, B in the BOM).



CONCLUSION

Congratulations on finishing the installation for your Artec Industries HD cross-member. Before driving your vehicle, inspect all bolts to ensure they are properly tightened.

If you used a vehicle lift, take proper care to ensure you lower your vehicle safely.

Now take your vehicle out and enjoy the outdoors in confidence.

MAINTENANCE / CARE

- After 500 miles, inspect all components and hardware to ensure they are properly fastened.
- If driving during the winter where salt is used on the roads, thoroughly and frequently wash underside of vehicle to prevent salt based corrosion.
- If removal of skid panels is required for vehicle maintenance, and bolts will not loosen, tap the bolt heads with a small sledge hammer using moderate force. This will allow the threads to loosen.
- Spray wax or similar products can be used to create a protective barrier on raw metals to protect against long term corrosion.