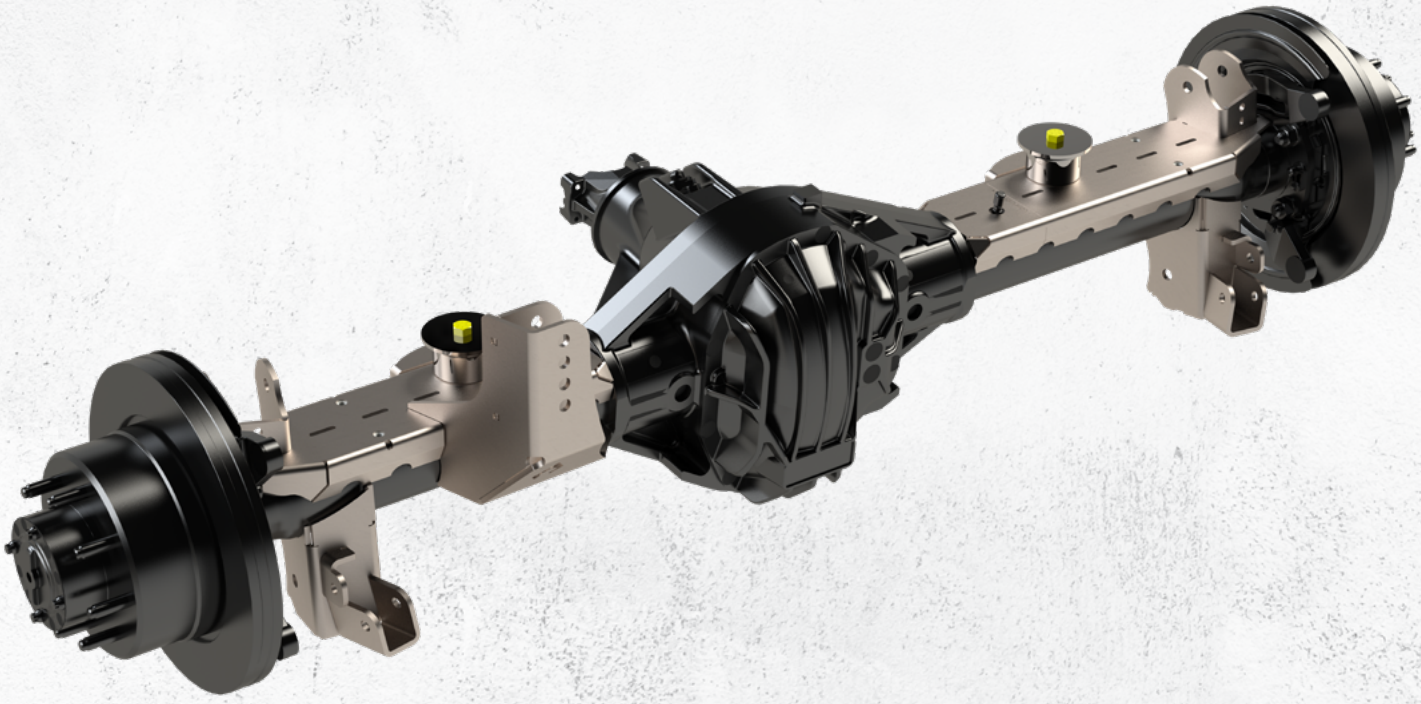
JL6980

UD80 JL REAR AXLE SWAP BRACKET'S



ESTIMATED INSTALLATION TIME

3-6 hours

REQUIRED TOOLS & SUPPLIES

- Welder
- Digital or analog angle finder
- Hammer & chisel (for breaking off tack welds)

REQUIRED SKILLS

- General Mechanics Skills

NOTES:

- Component appearance in instructions may vary from those received

CONTACT INFORMATION Info@artecindustries.com 585 N 700 W, Suite C North Salt Lake, UT 84054 855-278-3299

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.

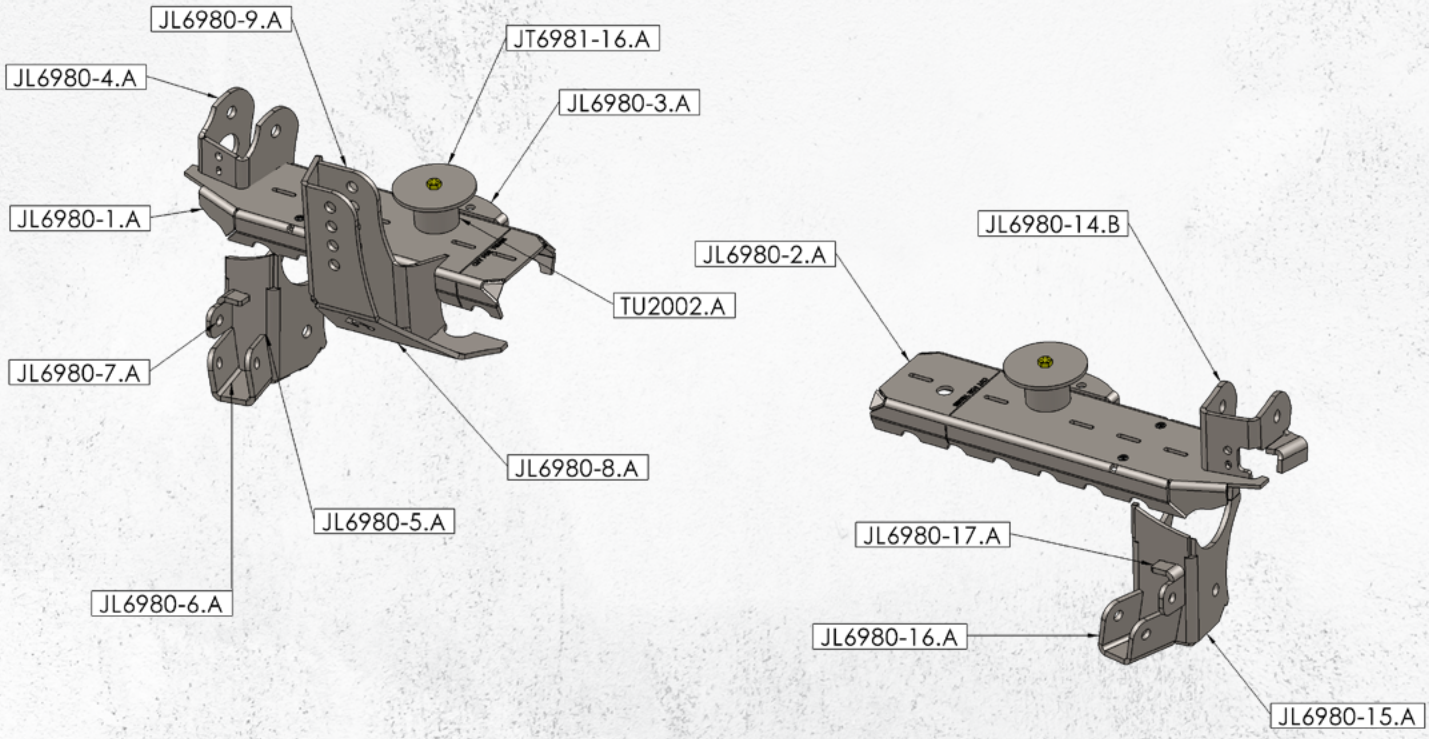
Modified vehicles won't perform identically to their stock counterparts. It's incumbent upon the vehicle owner to understand the alterations such modifications will bring to the vehicle's driving dynamics. These might encompass (but aren't limited to): changes in handling, braking, rollover angle, and 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.

JL6980 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.

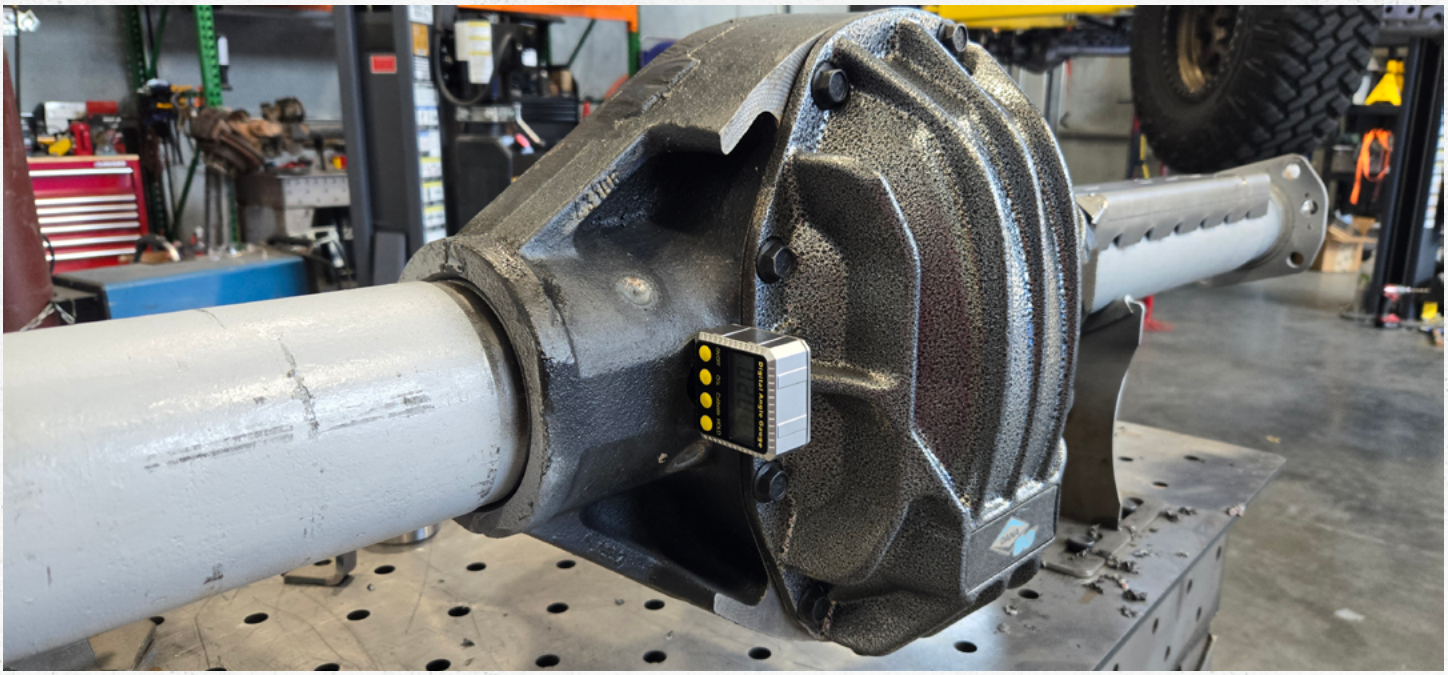


NOTE: The part numbers indicated above end in a "." and "letter" which indicate the revision number for the part. The etched part number on your physical parts do not need to match the above drawing revision exactly.

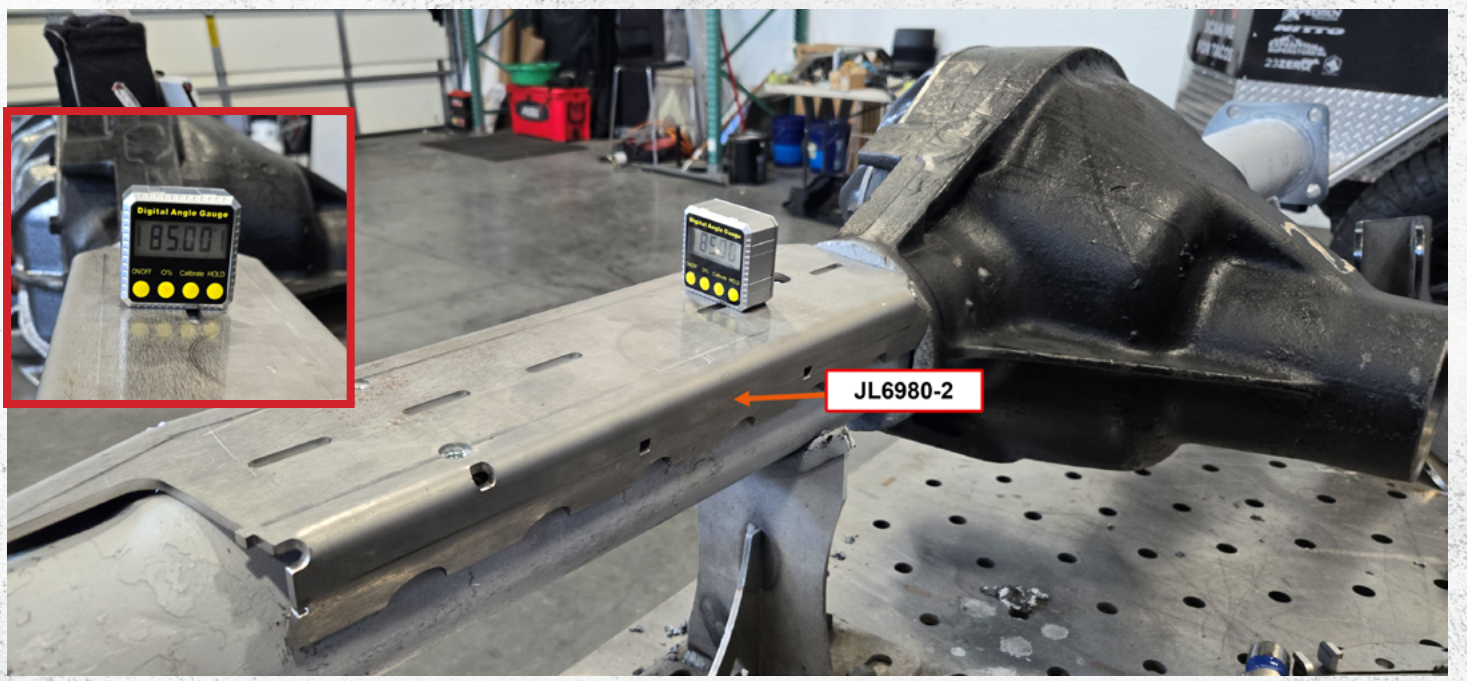
JL6980 BILL OF MATERIALS

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	HW0058	3/8"-16 x 1.0" Long Grade 8 Hex Head Cap Screw Yellow Zinc	2

INSTRUCTIONAL GUIDE



Step 1:
Using a digital or analog angle finder, place the angle finder on the flat 90 degree surface on the face of the pumpkin. Zero out your angle finder at this location.



Step 2:
On the passenger side of the axle, place bracket **JL6980-2** and set the angle finder to 85 degrees tilting the bracket towards the pinion or front of the vehicle.

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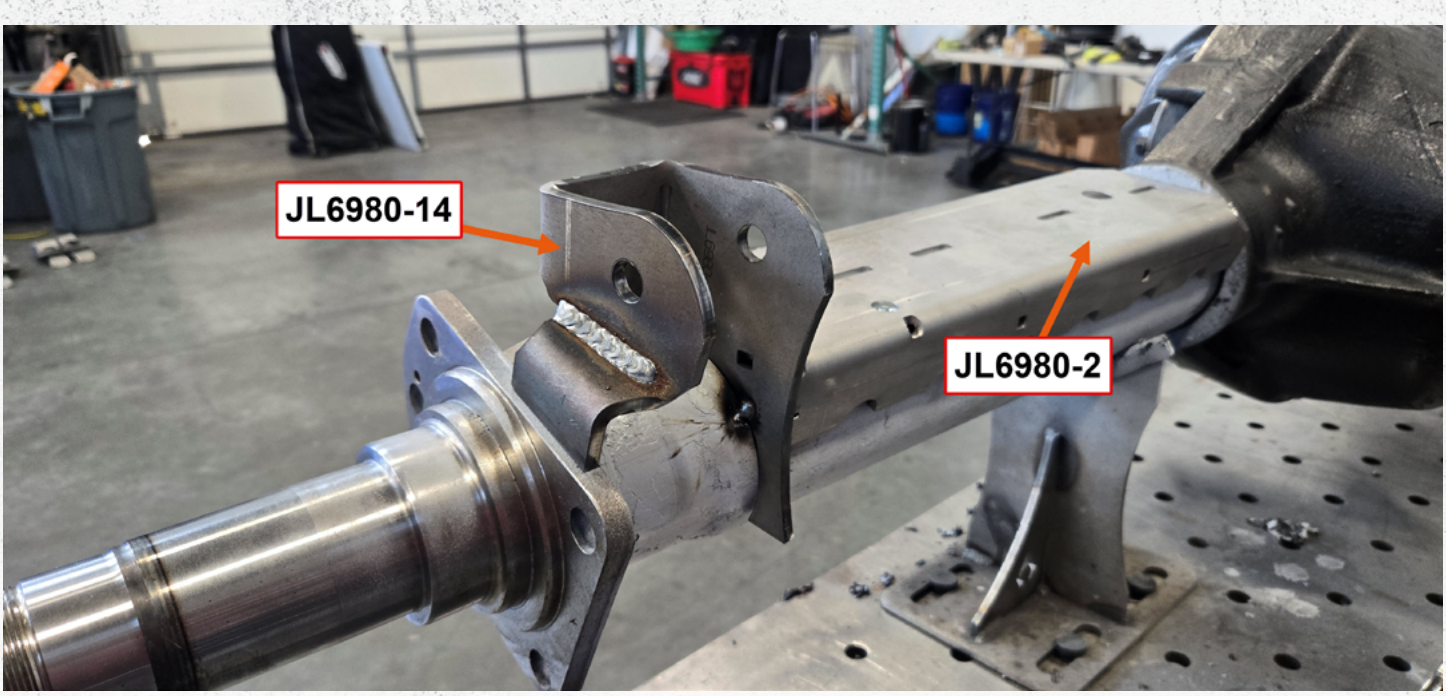
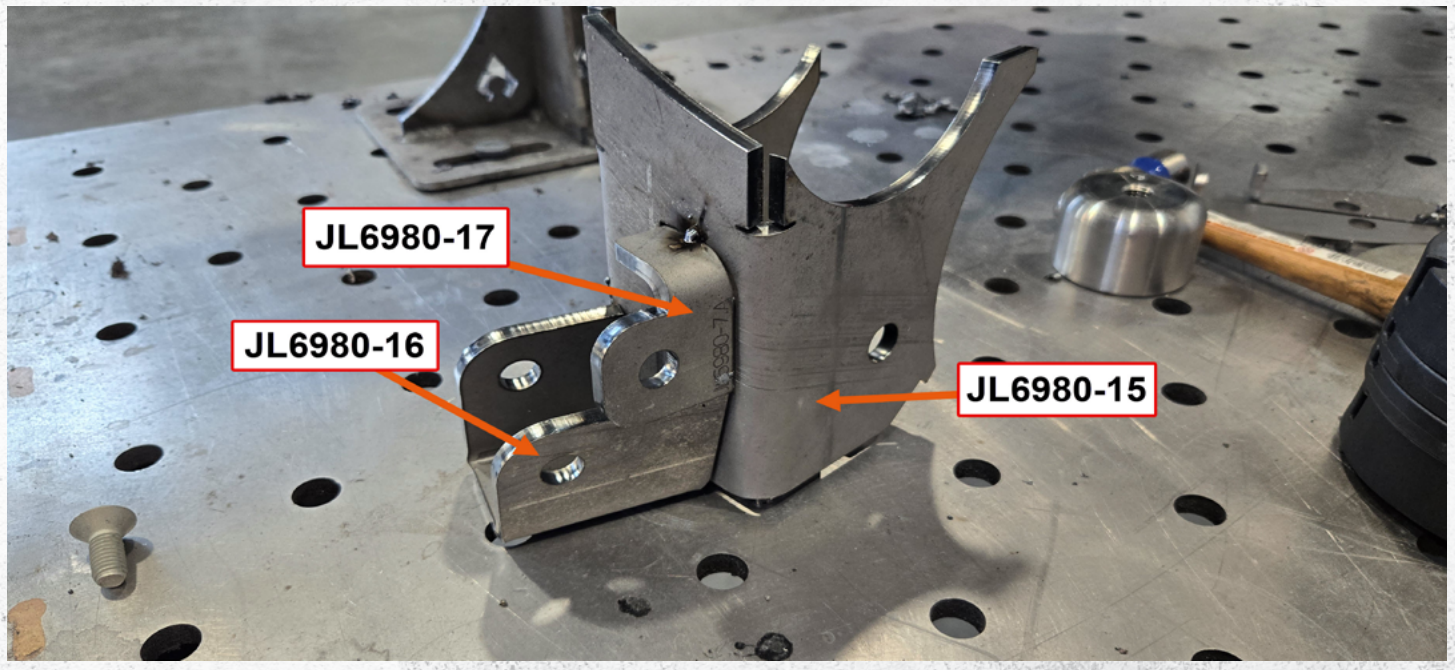
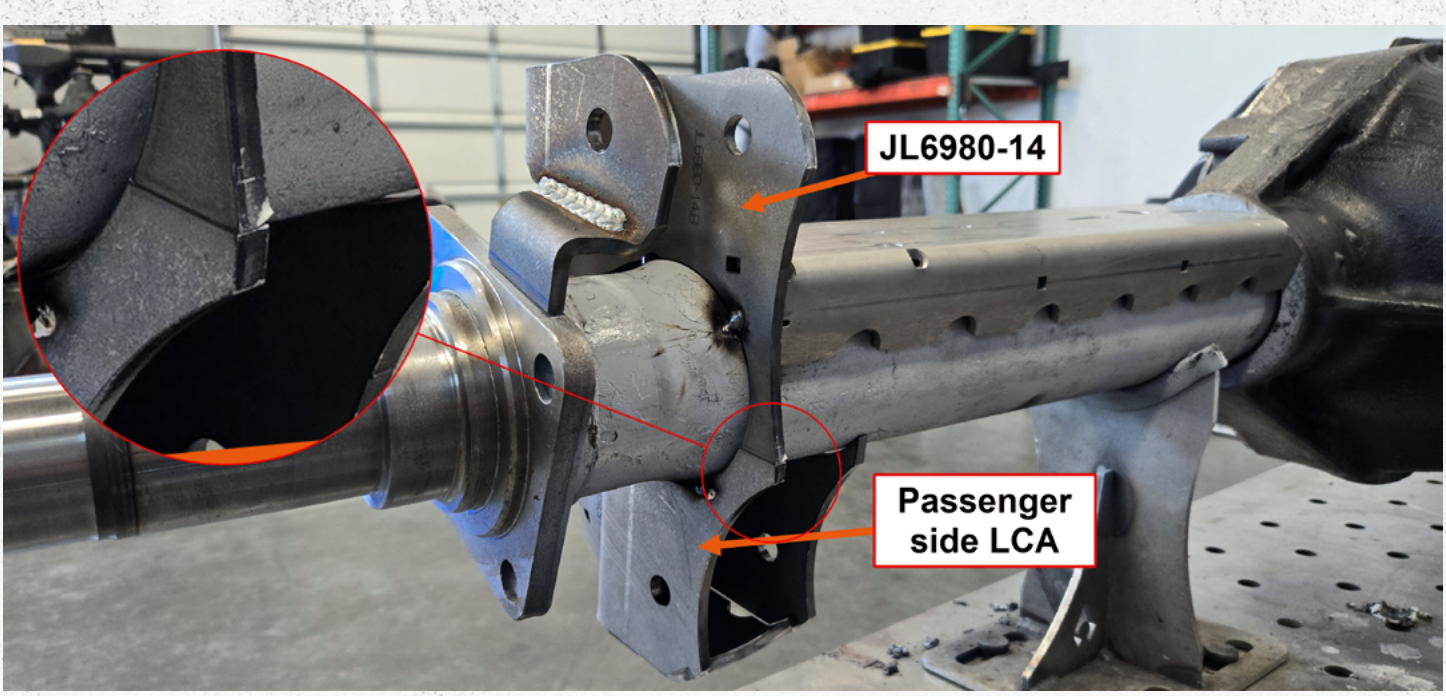


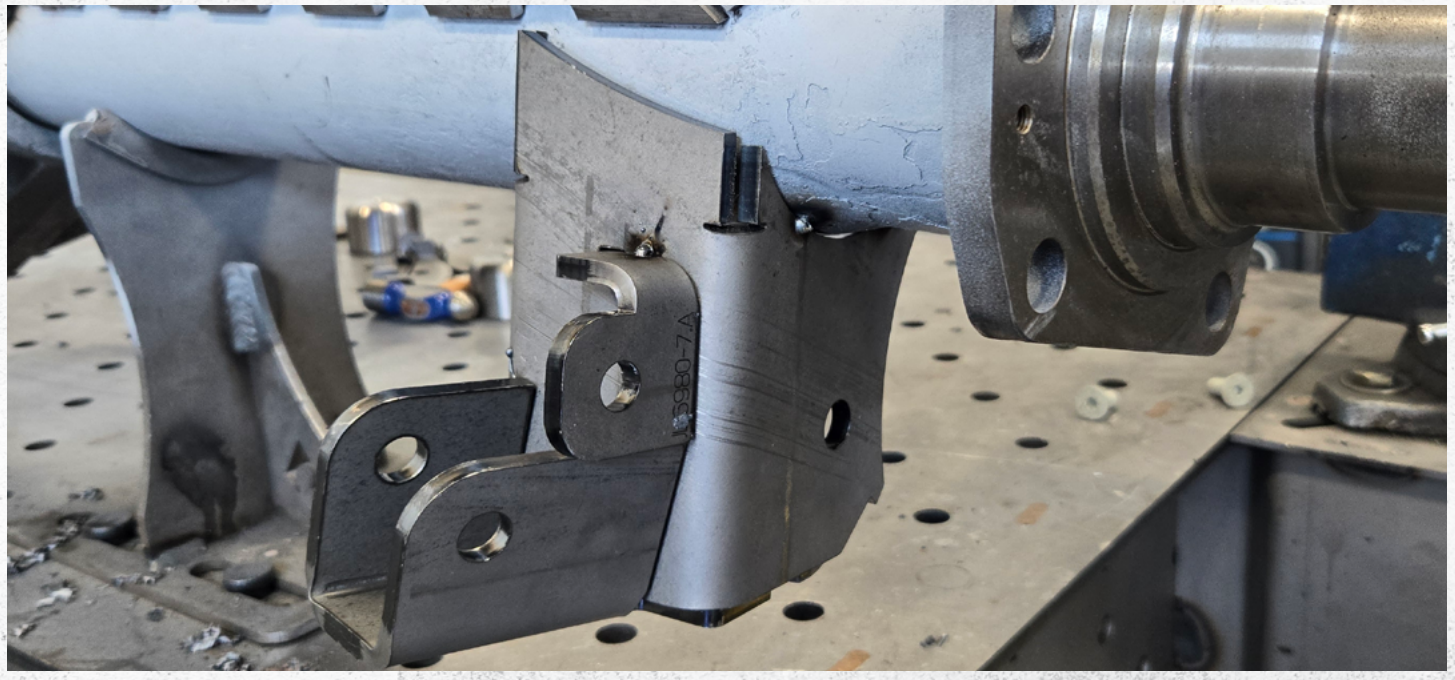
Step 3:
Moving back to the passenger side, install bracket **JL6980-14**. This bracket should sit flat on top of the brake backing plate bracket and key into bracket **JL6980-2**



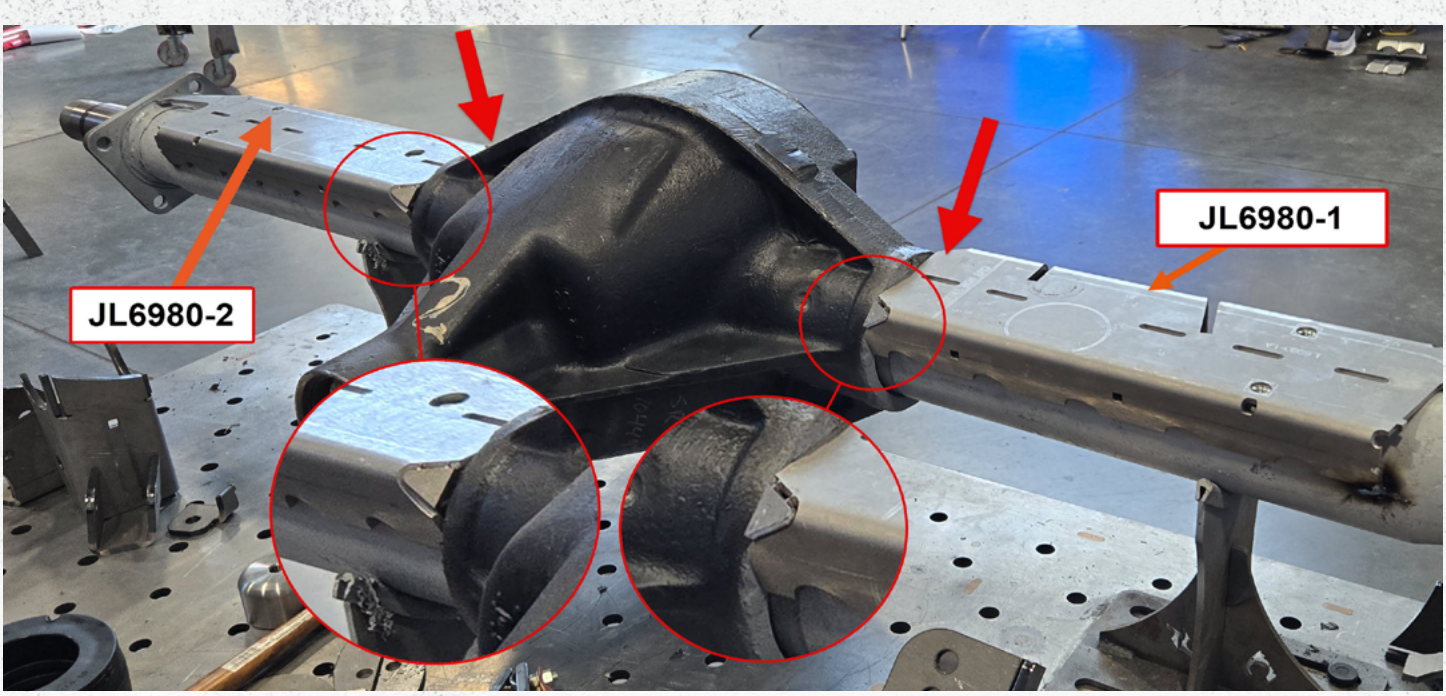
Step 4:
Assemble the passenger side LCA and shock bracket using brackets **JL6980-15, JL6980-16,** and **JL6980-17**



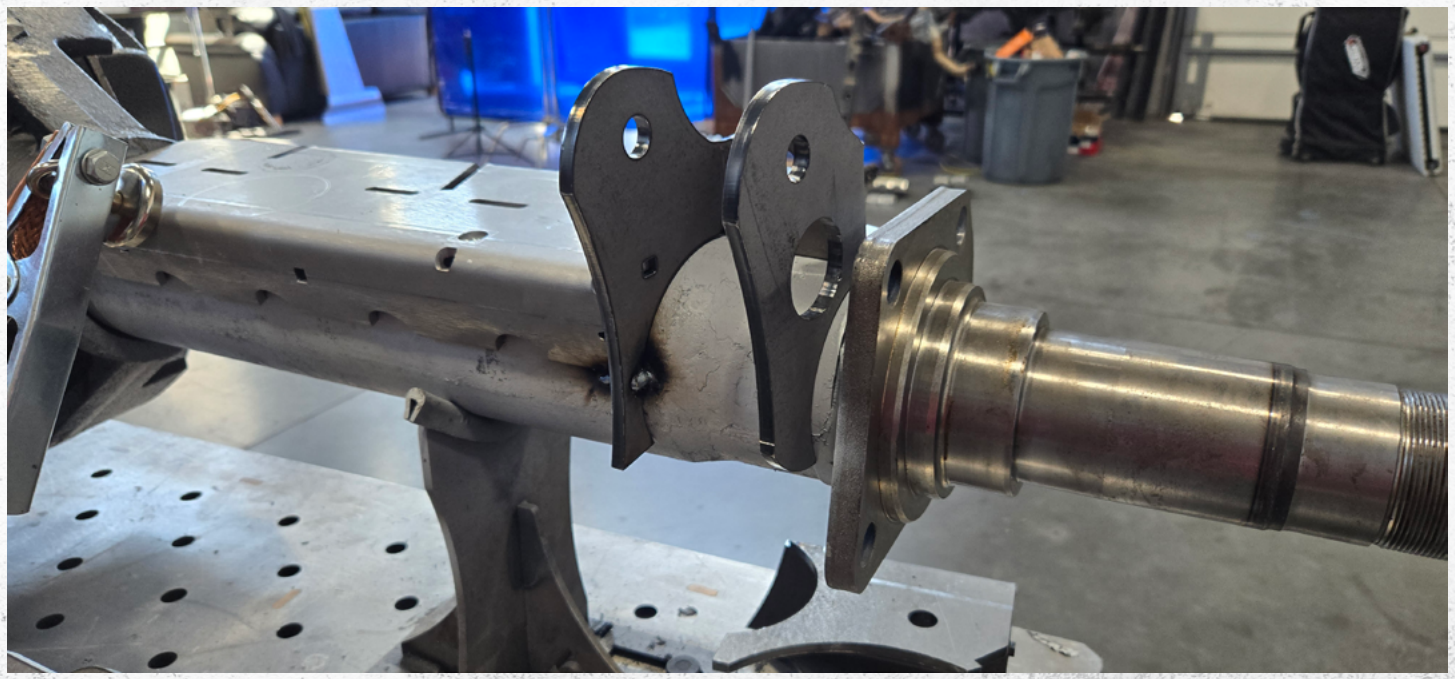
Step 5:
Install the assembled passenger side LCA and tack it into place. Note that the LCA bracket lines up parallel with the UCA bracket as show in the image above.



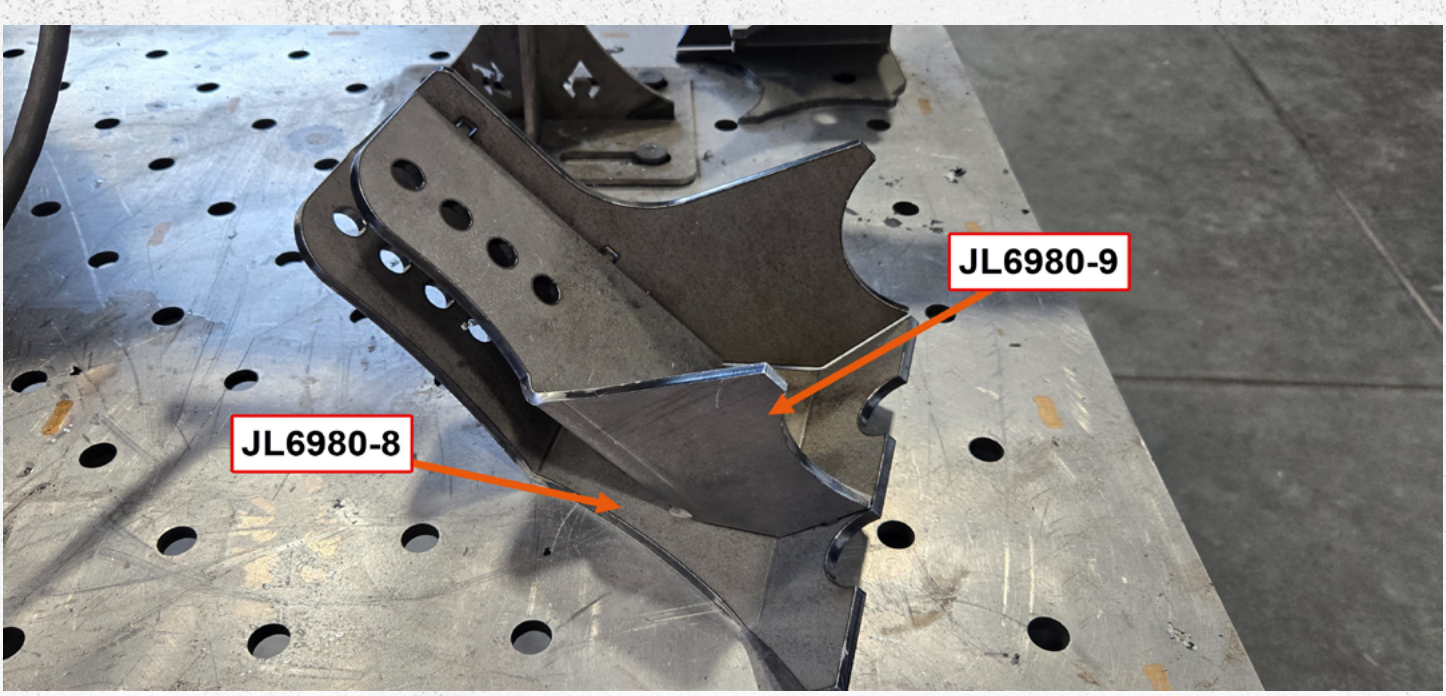
Step 6: (additional view)



Step 7:
Repeat step two onto the driver side of the vehicle using bracket **JL6980-1.** You can now hammer down the “ears” on **JL6980-1** and **JL6980-2.**

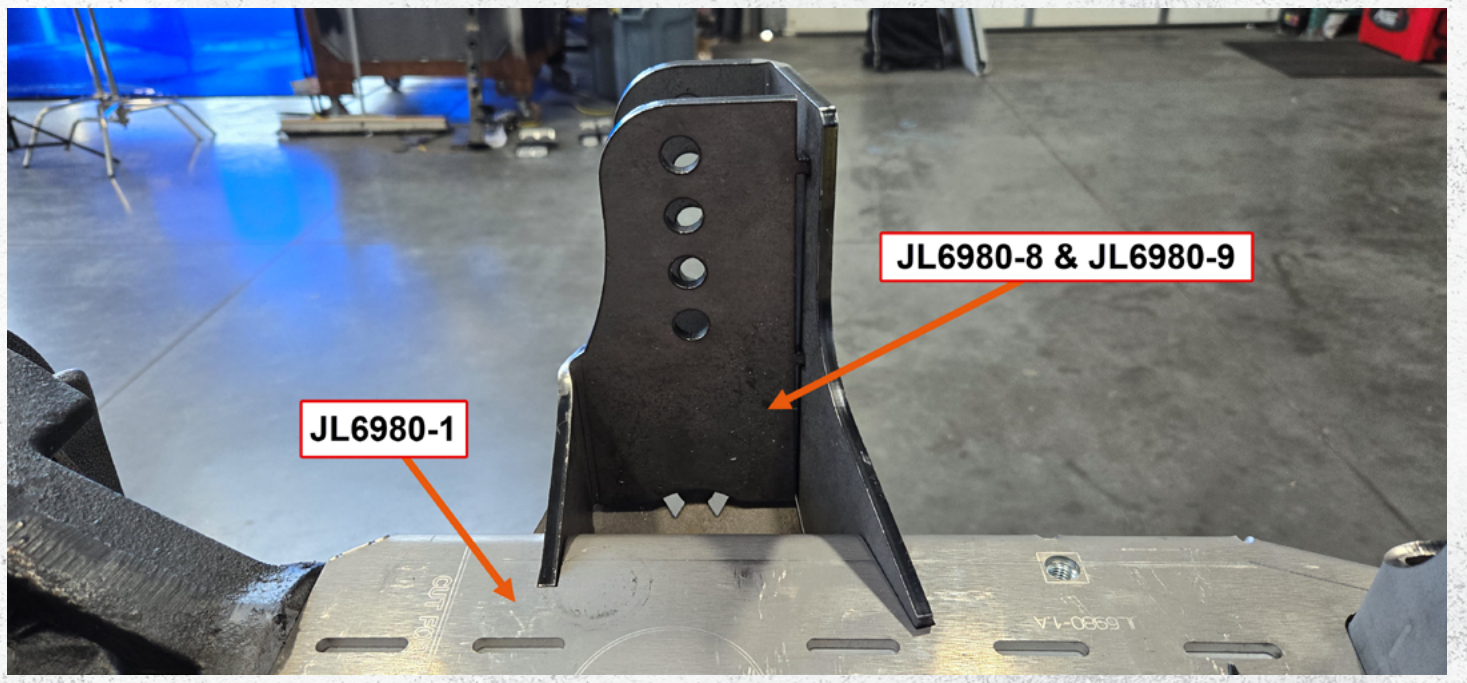


Step 8:
Repeat step two onto the driver side of the vehicle using bracket **JL6980-1**

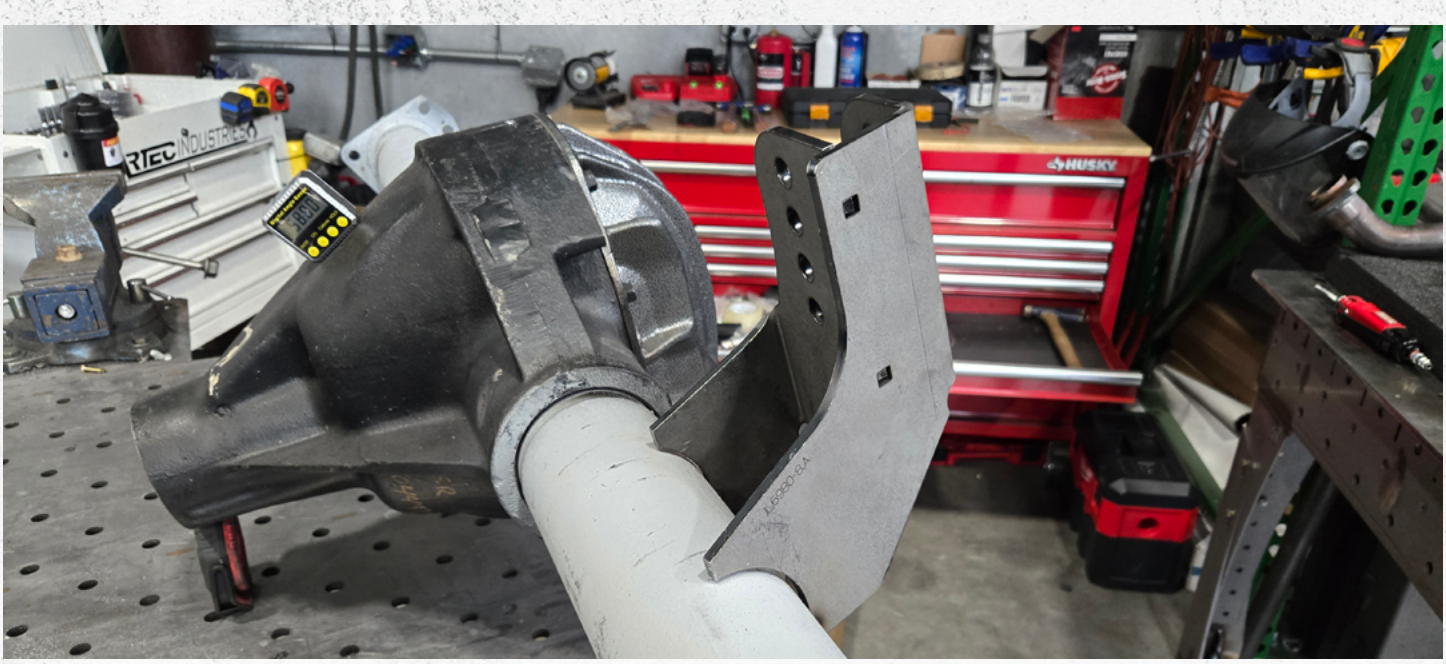


Step 9:
Assemble the track bar bracket using **JL6980-9** and **JL6980-8.**

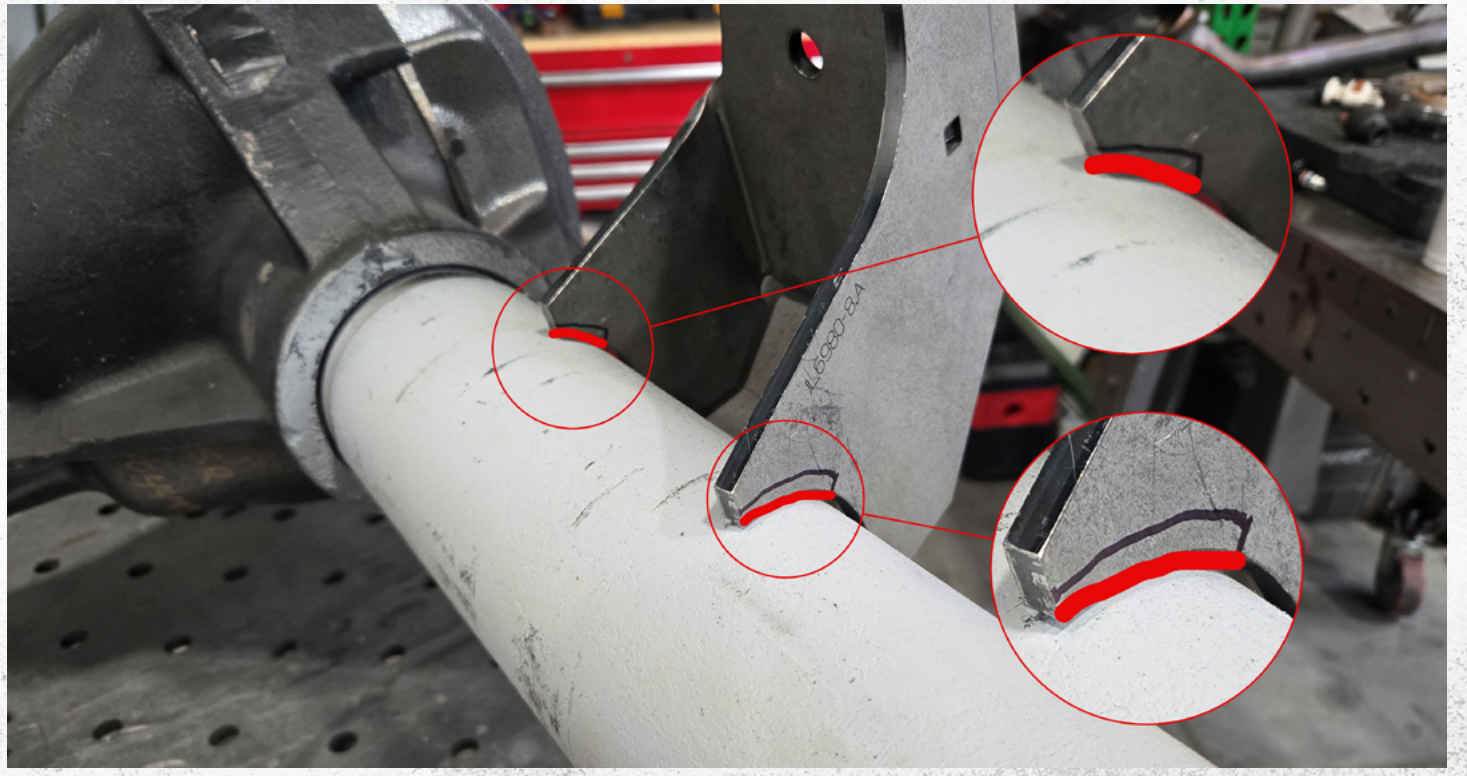
Do not fully weld the track bar bracket, use a small tack to hold the pieces together during mock up.



Step 10:
Install the assembled track bar bracket onto the driver side of the axle. If these pieces do not line up with the corresponding slots or if there are any other fitment issues, please reach out to us at **artecindustries.com**

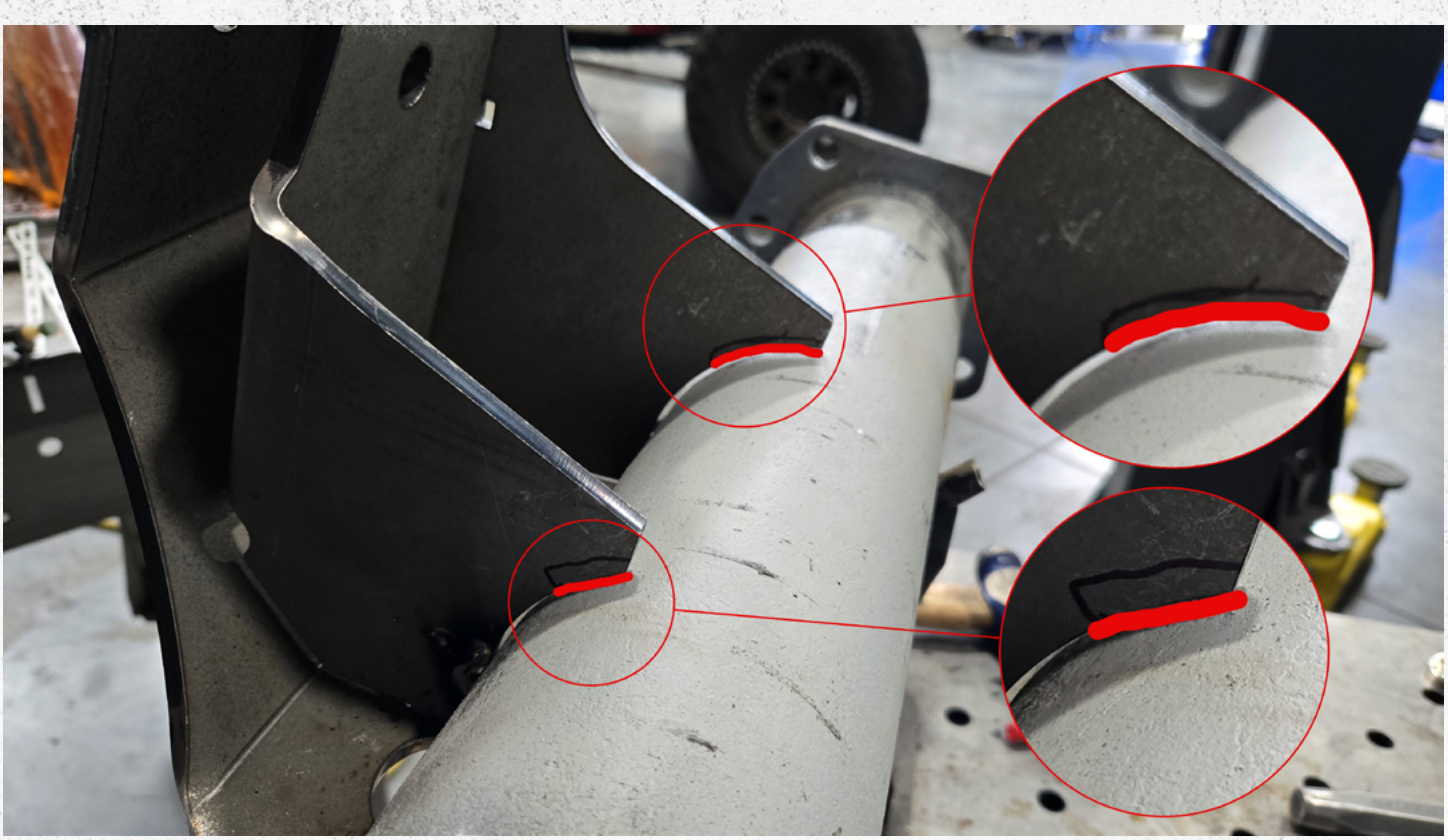


Step 11:
Remove **JL6980-1** leaving the track bar assembly tacked into place.



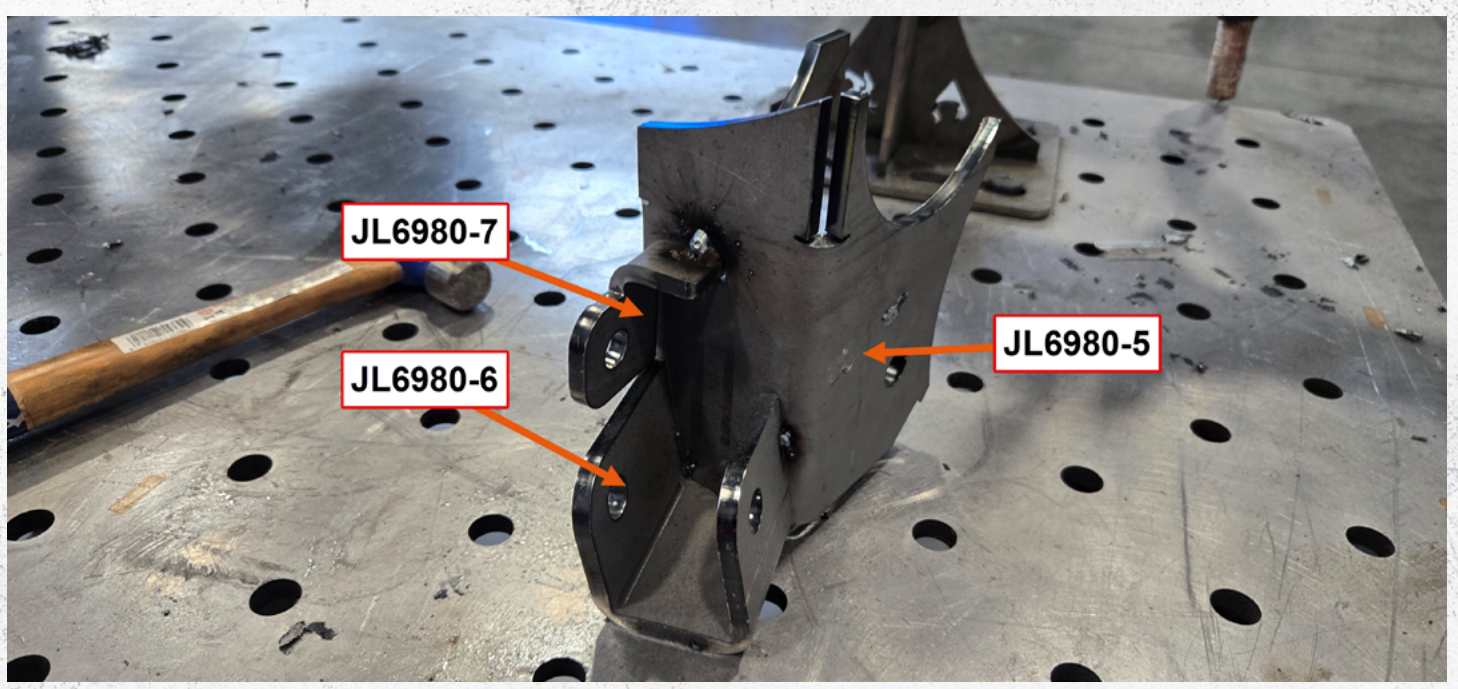
Step 12:
Weld the track bar along the highlighted path shown in the image above. Welding this section is not possible once **JL6980-1** is welded into place.

Weld is roughly 1.25” long on the side closest to the pumpkin and roughly 2” on the side furthest from the pumpkin.

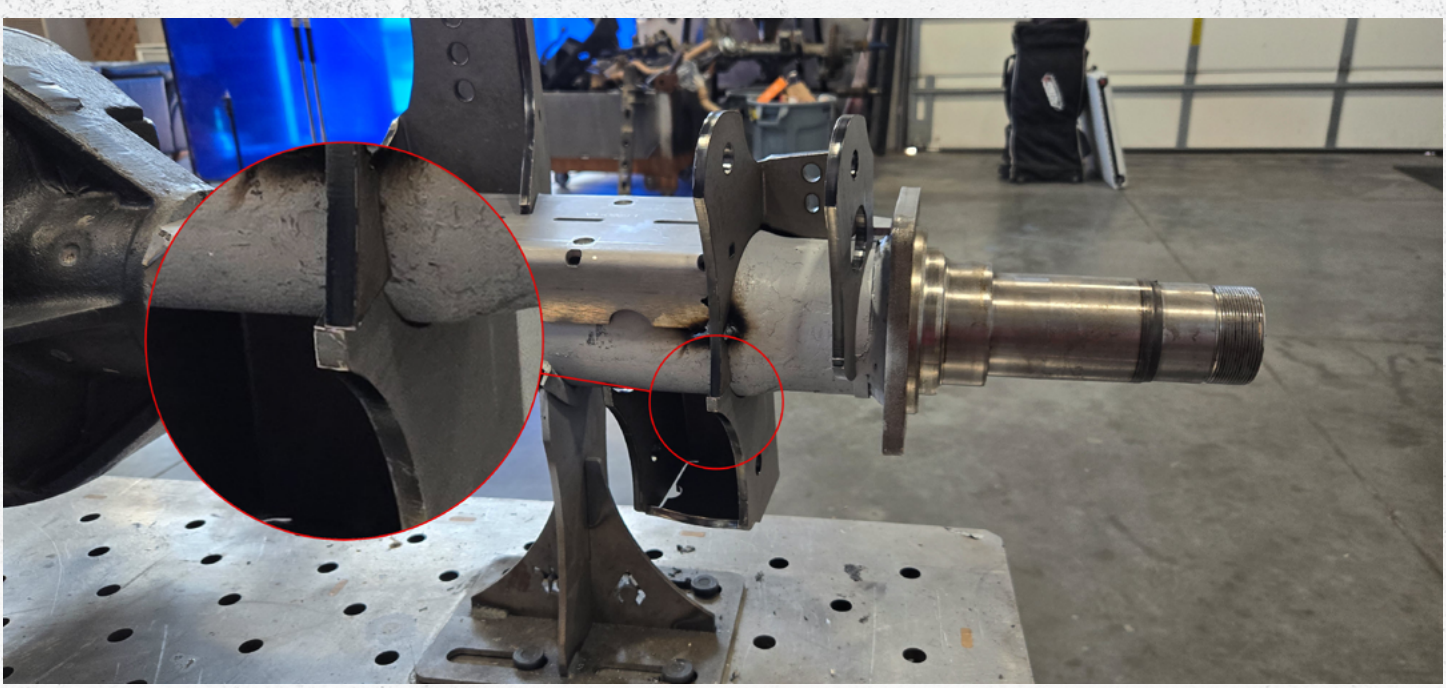


Step 12: (inside view)
Weld the track bar along the highlighted path shown in the image above. Welding this section is not possible once JL6980-1 is welded into place.

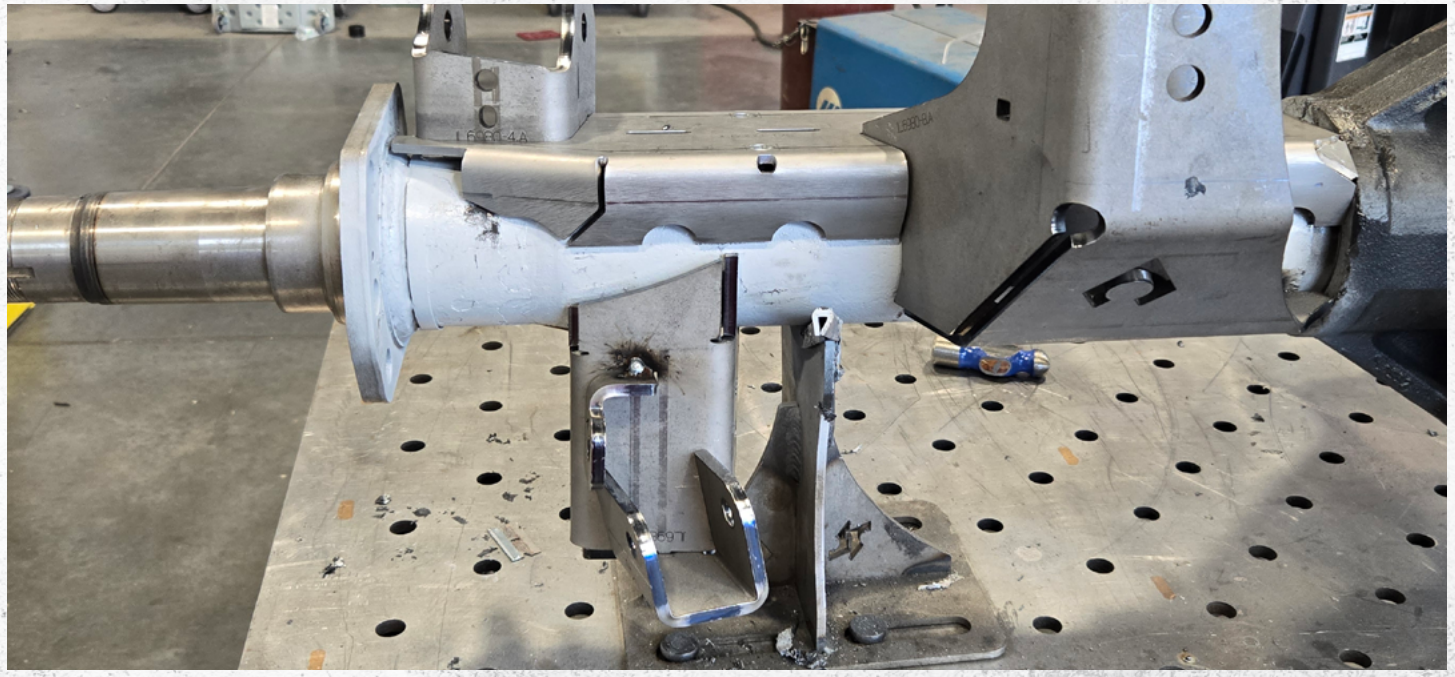
Weld is roughly 1.25” long on the side closest to the pumpkin and roughly 2” on the side furthest from the pumpkin.



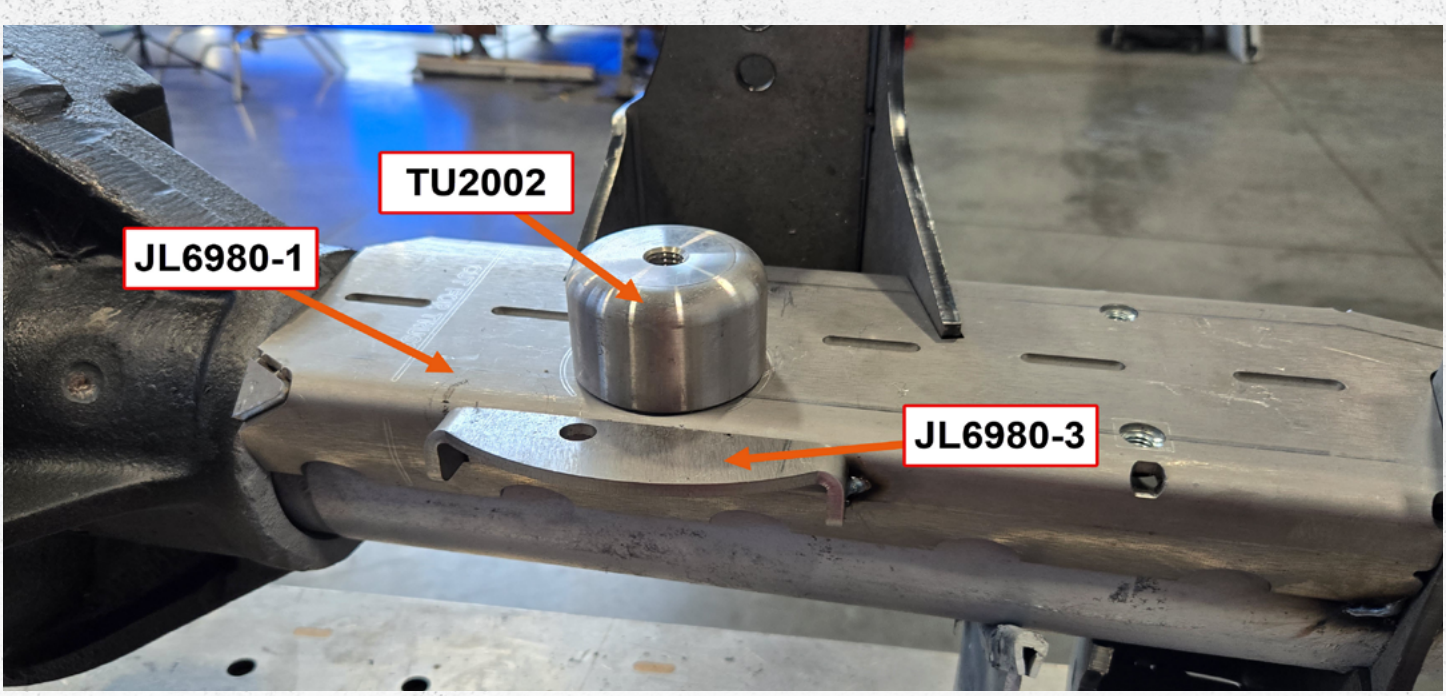
Step 13:
Assemble the driver side LCA and shock bracket using brackets **JL6980-5, JL6980-6,** and **JL6980-7**



Step 14:
Install the assembled Driver side LCA and tack it into place. Note that the LCA bracket lines up perpendicular with the LCA bracket.

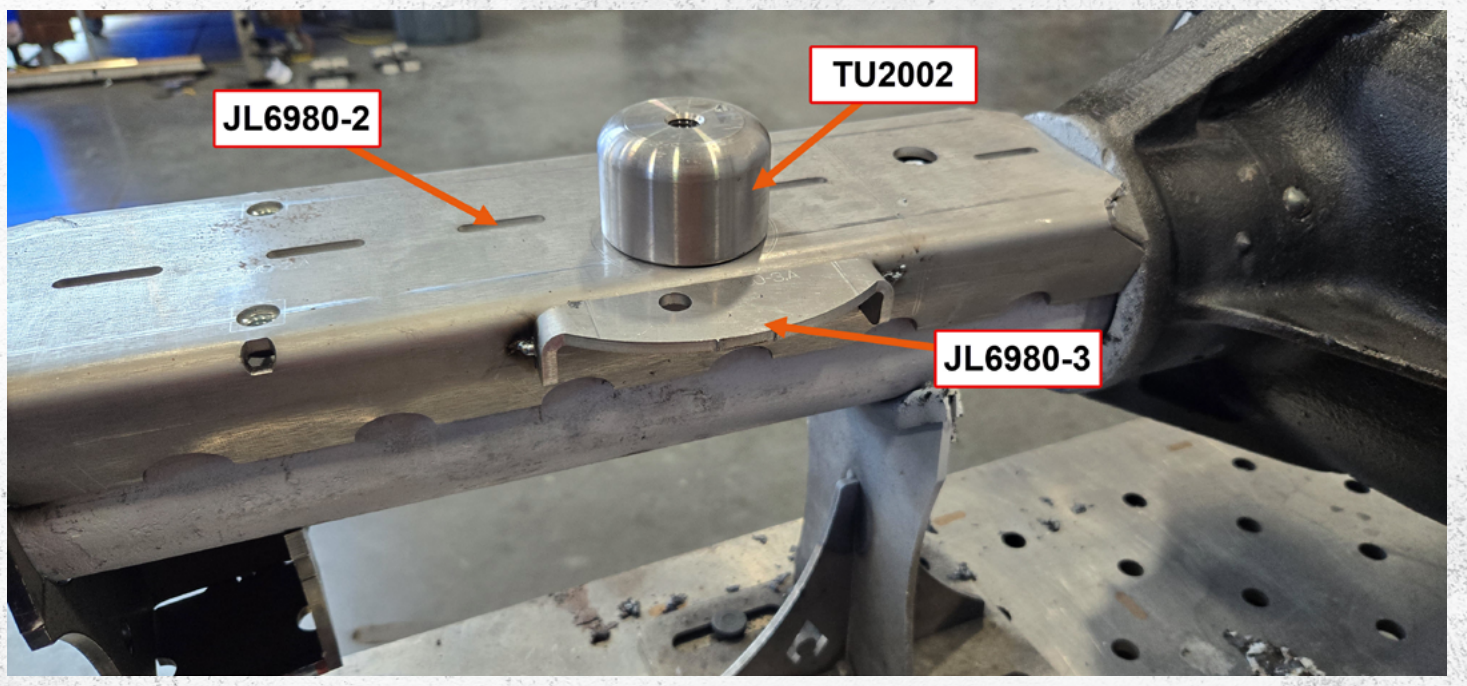


Step 14: (additional view)

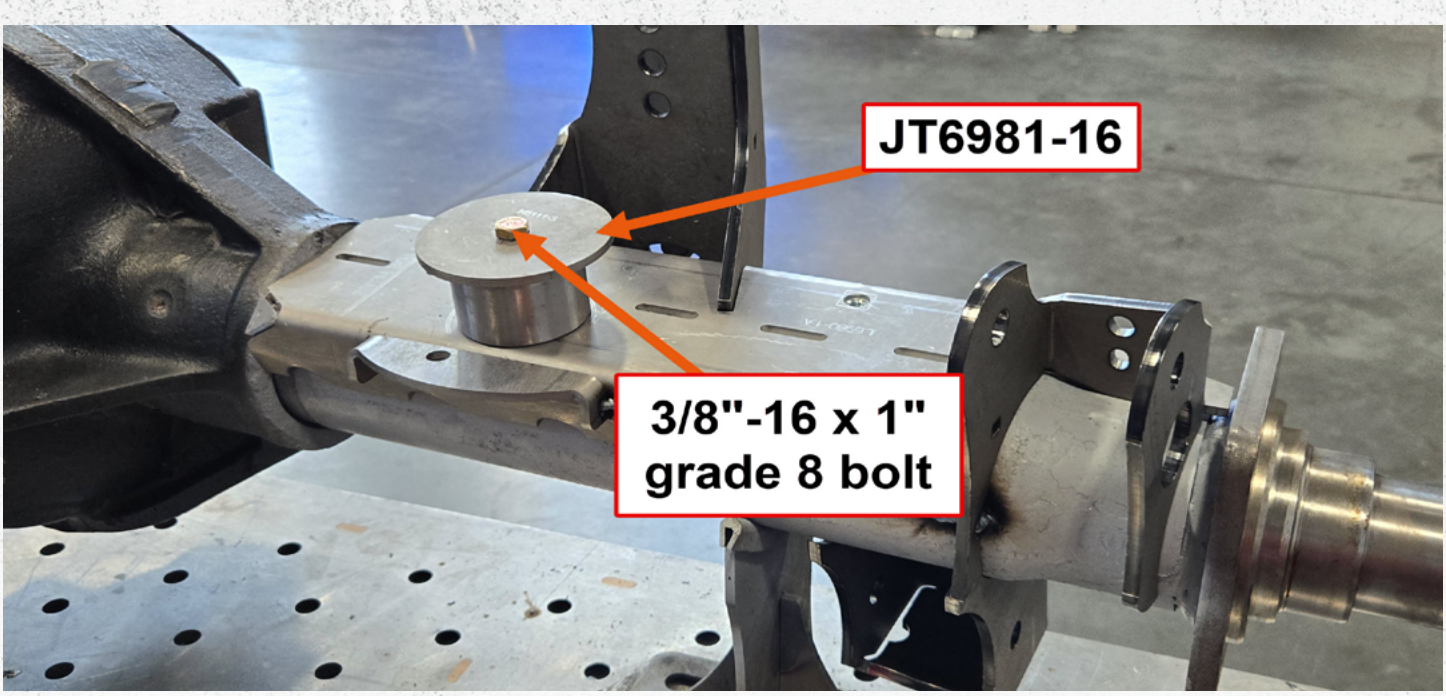


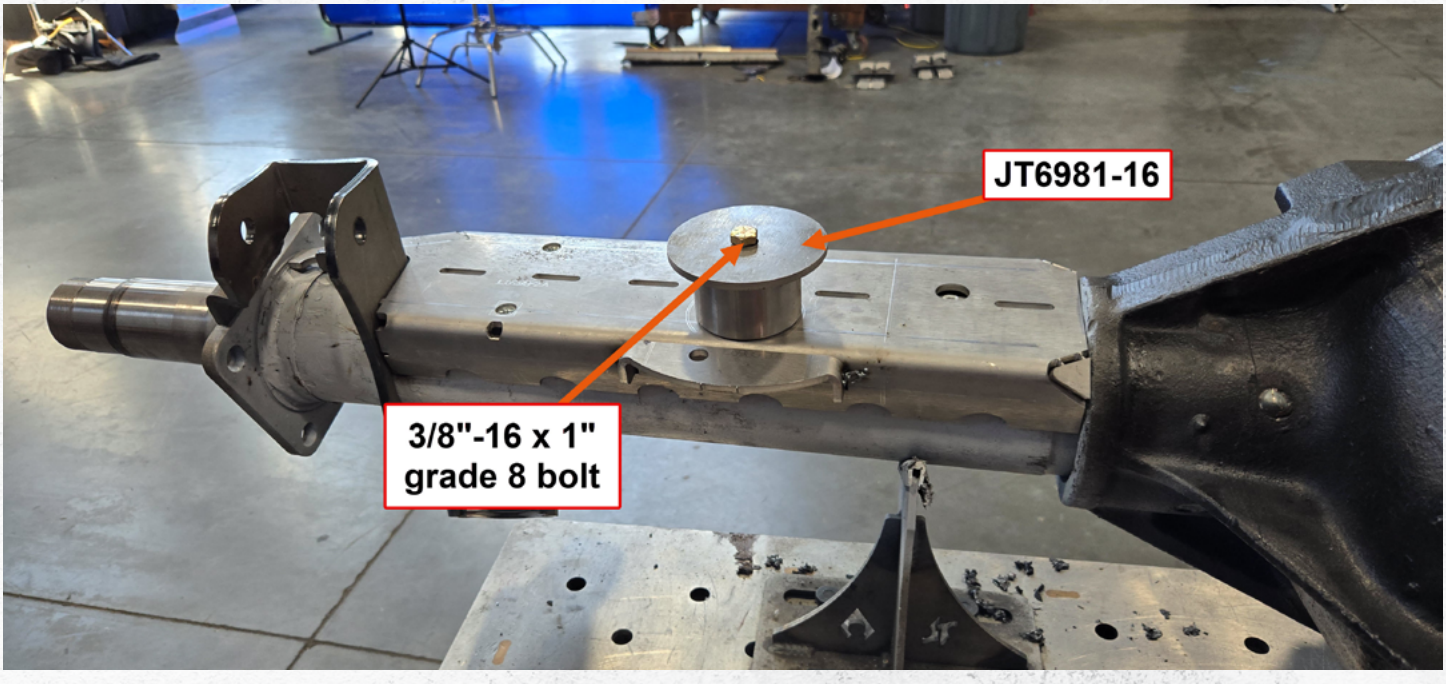
Step 15:
Install **TU2002** and tack it into place, this spring perch will be located concentric with the etched circle on the both the **JL6980-1** and **JL6980-2** brackets.

Place a tack to hole **JL6980-3**, this bracket keys into two holes on both the **JL6980-1** and **JL6980-2** brackets and should be level with the bracket surface.

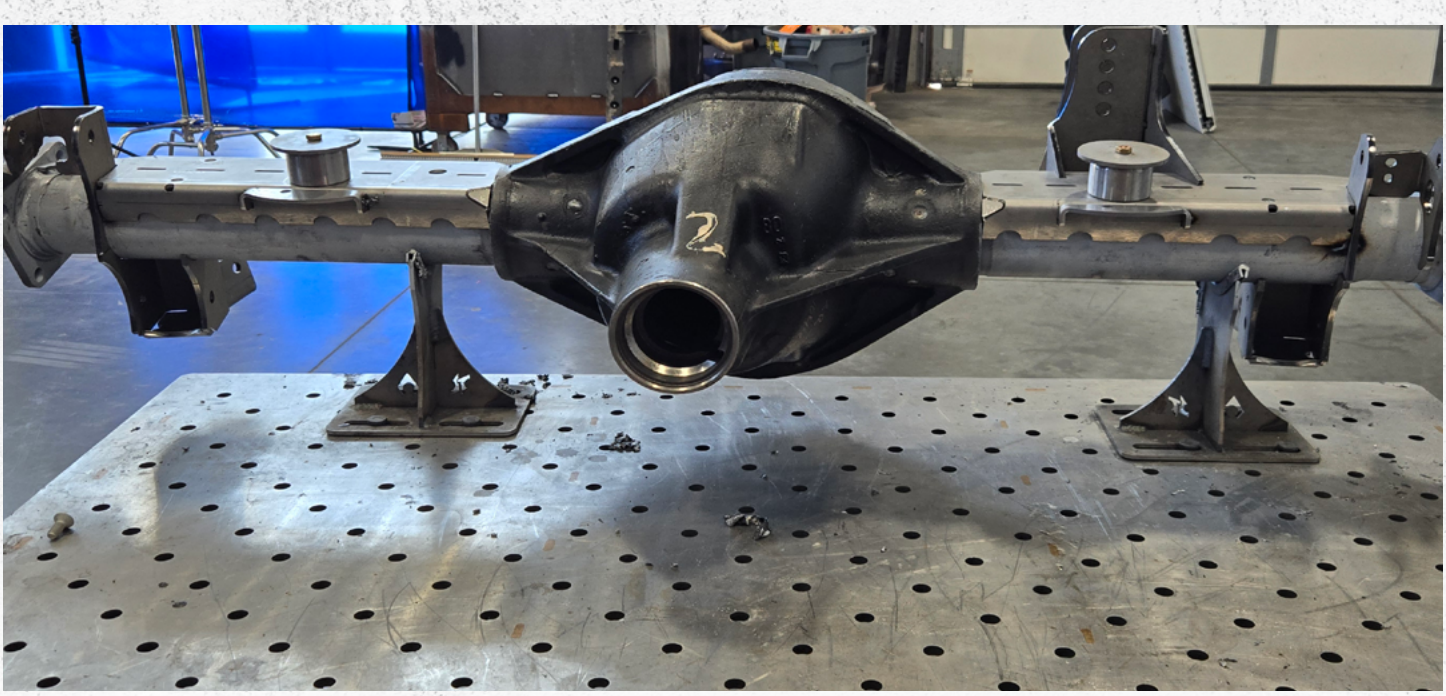


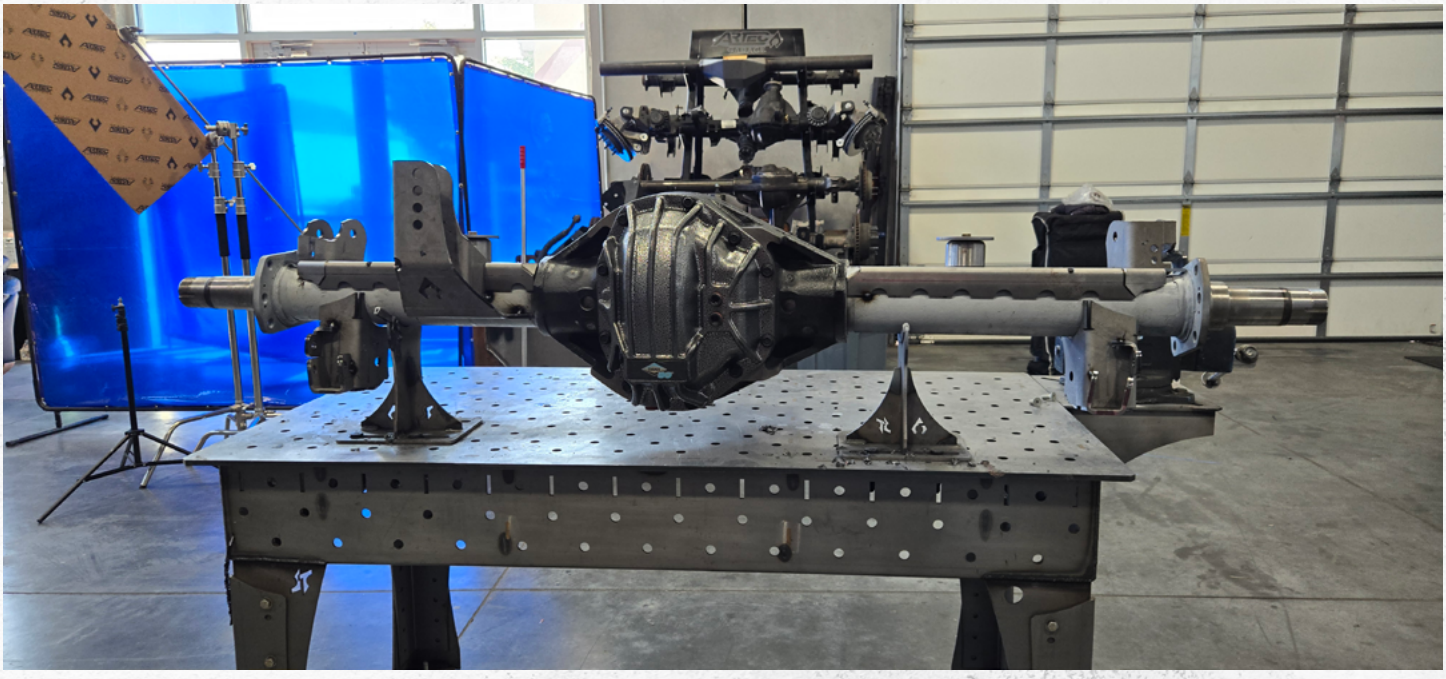
Step 16:
Repeat step 15 onto the opposite side of the axle.





Step 17:
Shown in the above images is the spring retainer kit including two **JT6981-16** and two **3/8”-16 x 1”** grade 8 bolts. These components should be installed after the springs are set into place.





Step 18:
Finish welding the UD80 truss and paint any bare metal before installing into the vehicle.

Welding advice is provided on the next page!!!

Welding to an axle:

- **Weld in short sections to avoid warping brackets or the axle**
- **Avoid welding in one spot for to long**
- **Preheat the axle using a torch to ensure the best material adhesion**
- **Properly clean the surface prior to welding**
- **Allow the axle to cool properly using items such as a welding blanket.**

CONCLUSION

Congratulations on finishing the installation for your Artec Industries JL UD80 swap kit. 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.