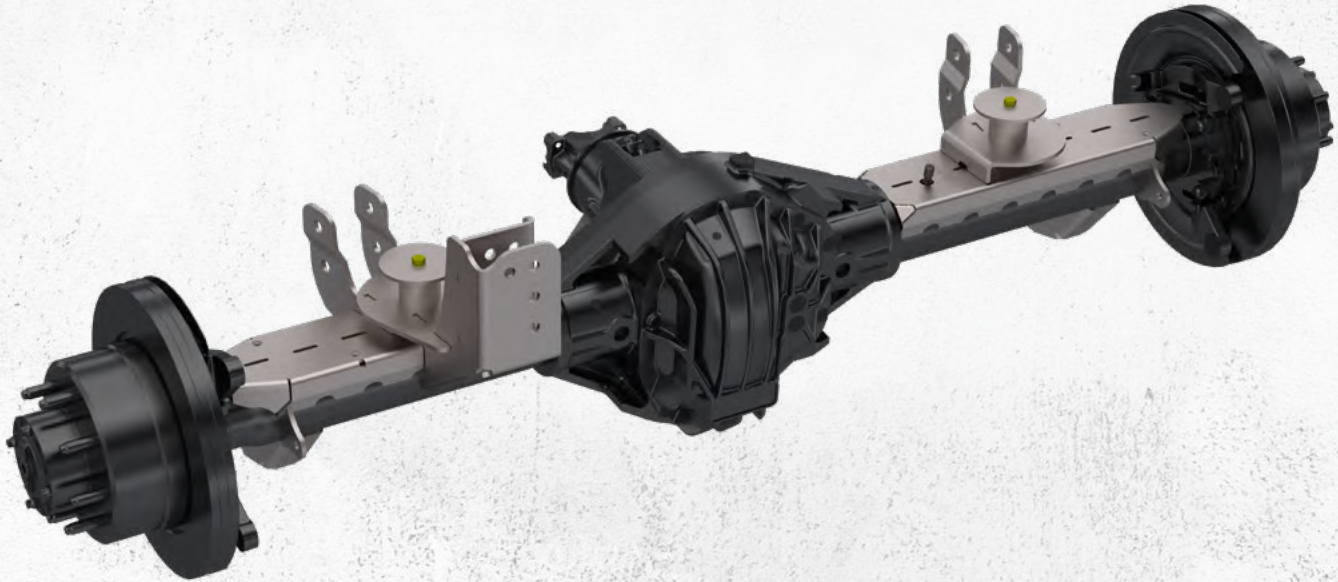




JT6981

UD80 REAR AXLE SWAP BRACKET'S FOR JT



ESTIMATED INSTALLATION TIME

3-6 hours

REQUIRED TOOLS & SUPPLIES

- Welder
- Digital or analog angle finder

REQUIRED SKILLS

- General Mechanics Skills

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.

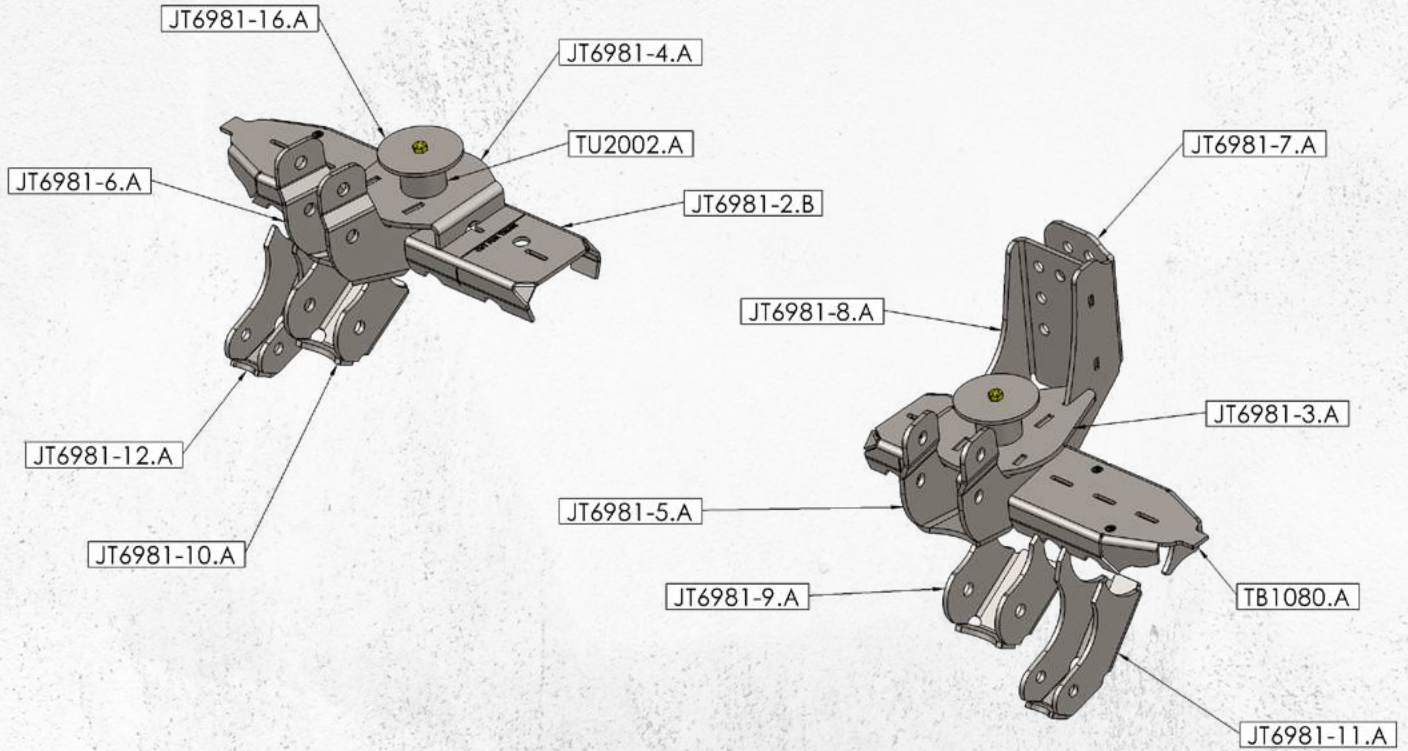
Modified vehicles won't perform identically to their stock counterparts. It's incumbent upon the vehicle owner to understand the alterations such modifications will bring to the vehicle's driving dynamics. These might encompass (but aren't limited to): changes in handling, braking, rollover angle, and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

JT6981 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.

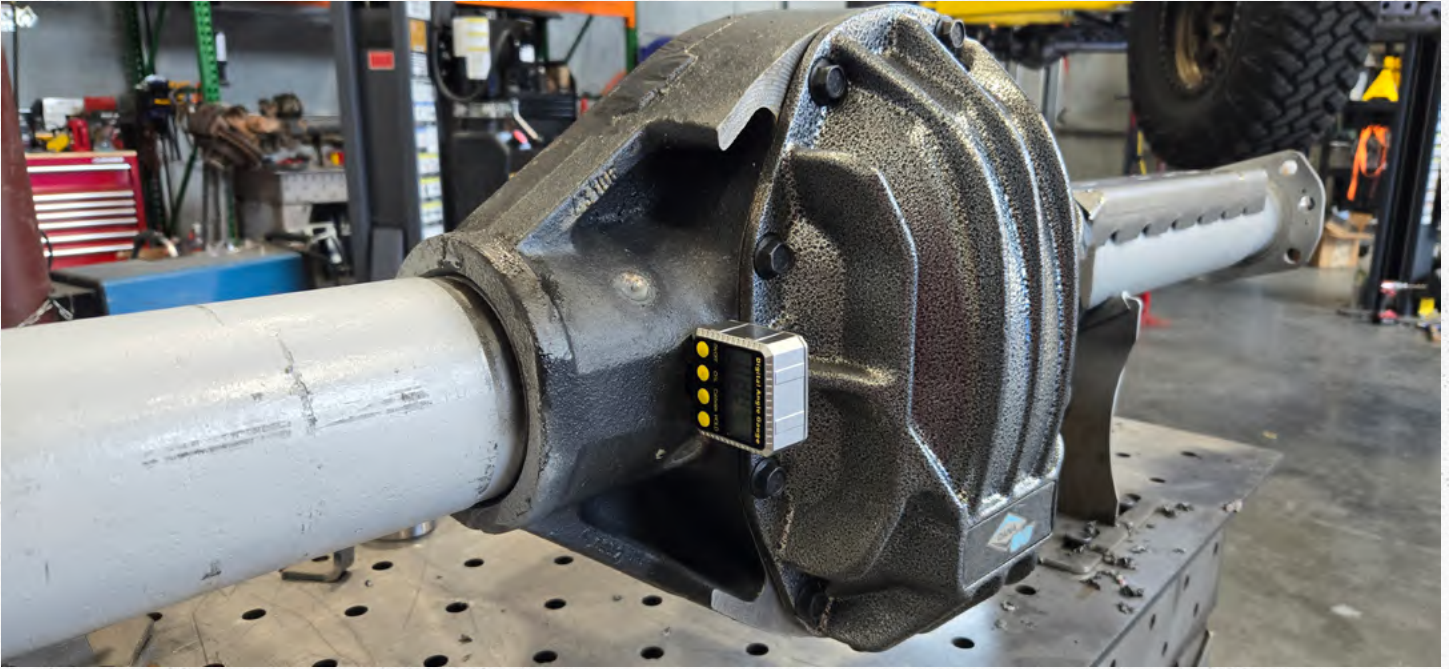


NOTE: The part numbers indicated above end in a “.” and “letter” which indicate the revision number for the part. The etched part number on your physical parts do not need to match the above drawing revision exactly.

JT6981 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



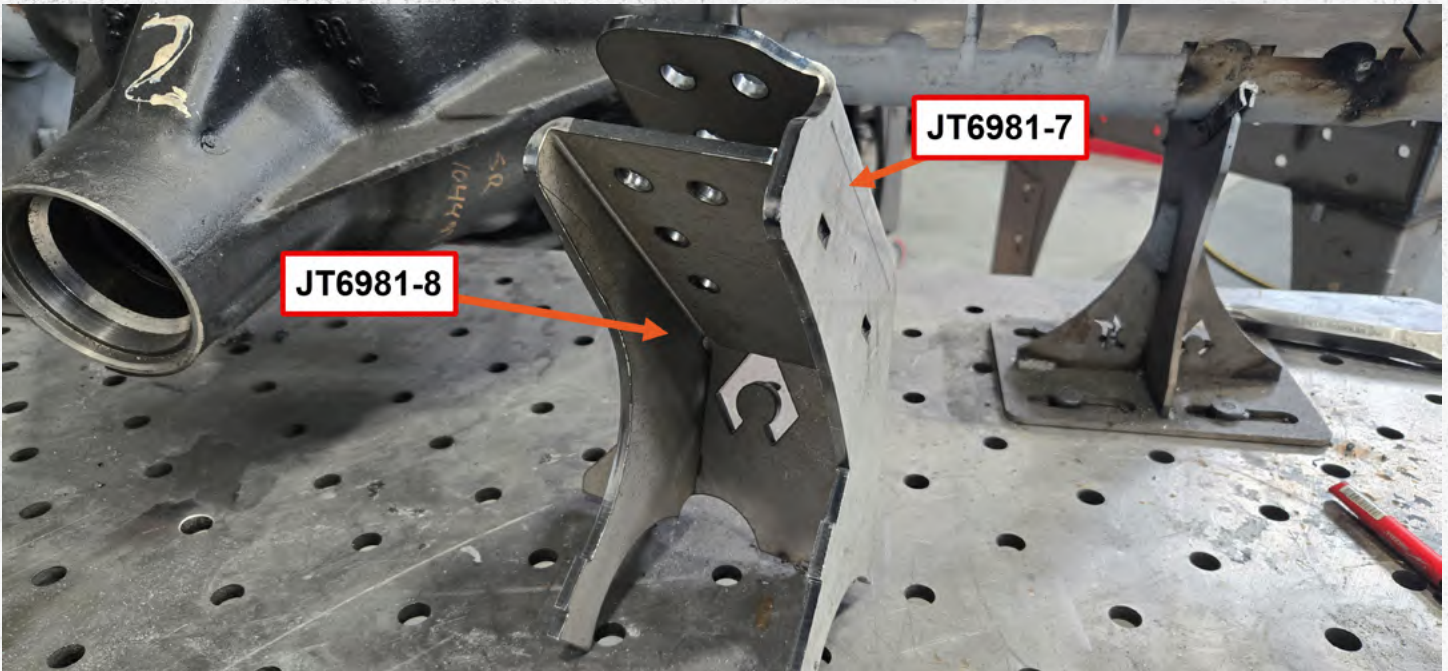
Step 1:

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.



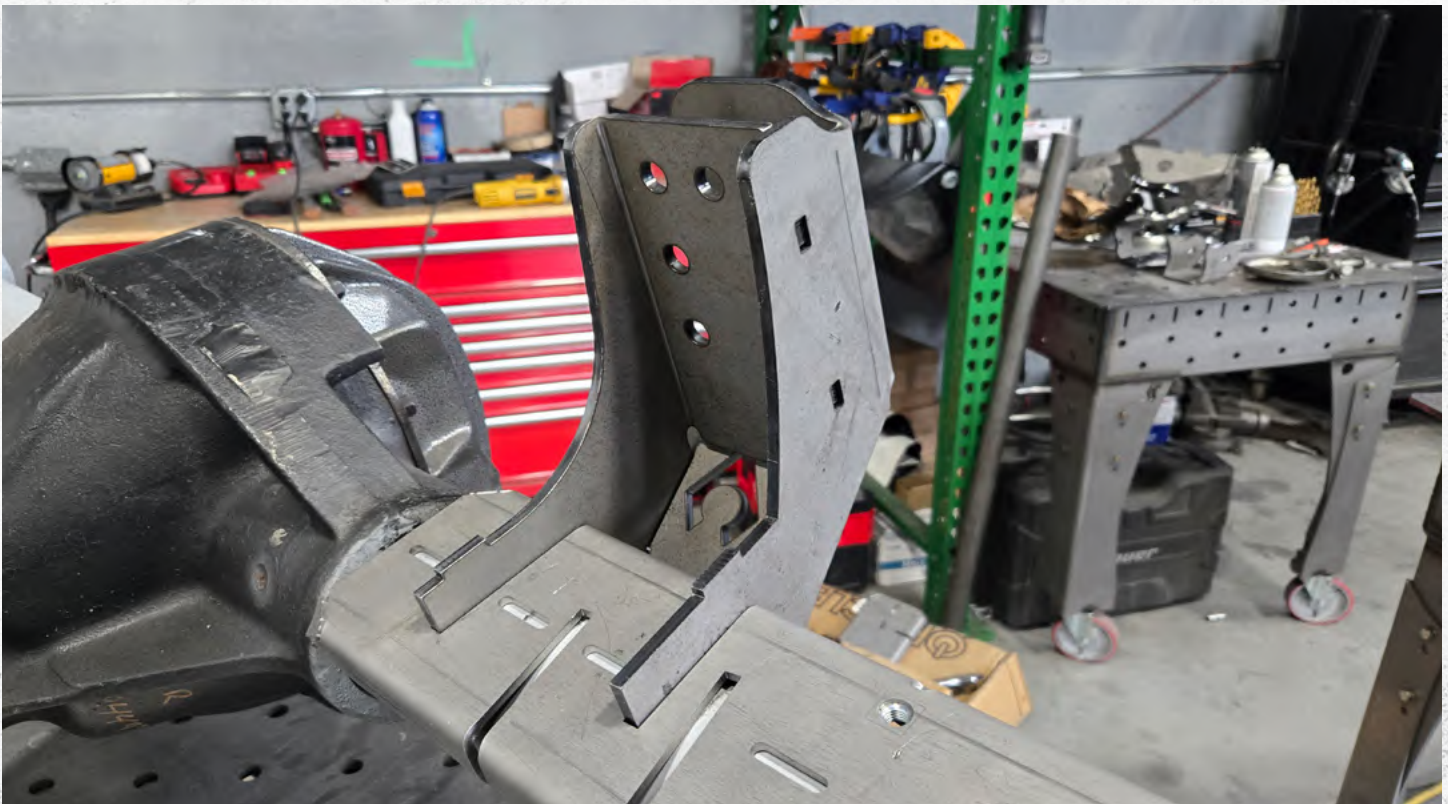
Step 2:

On the driver side of the axle, place bracket **JT6981-1** and set the angle finder to 85 degrees tilting the bracket towards the pinion or front of the vehicle.



Step 3:

Assemble the track bar bracket using **JT6981-7** and **JT6981-8**.



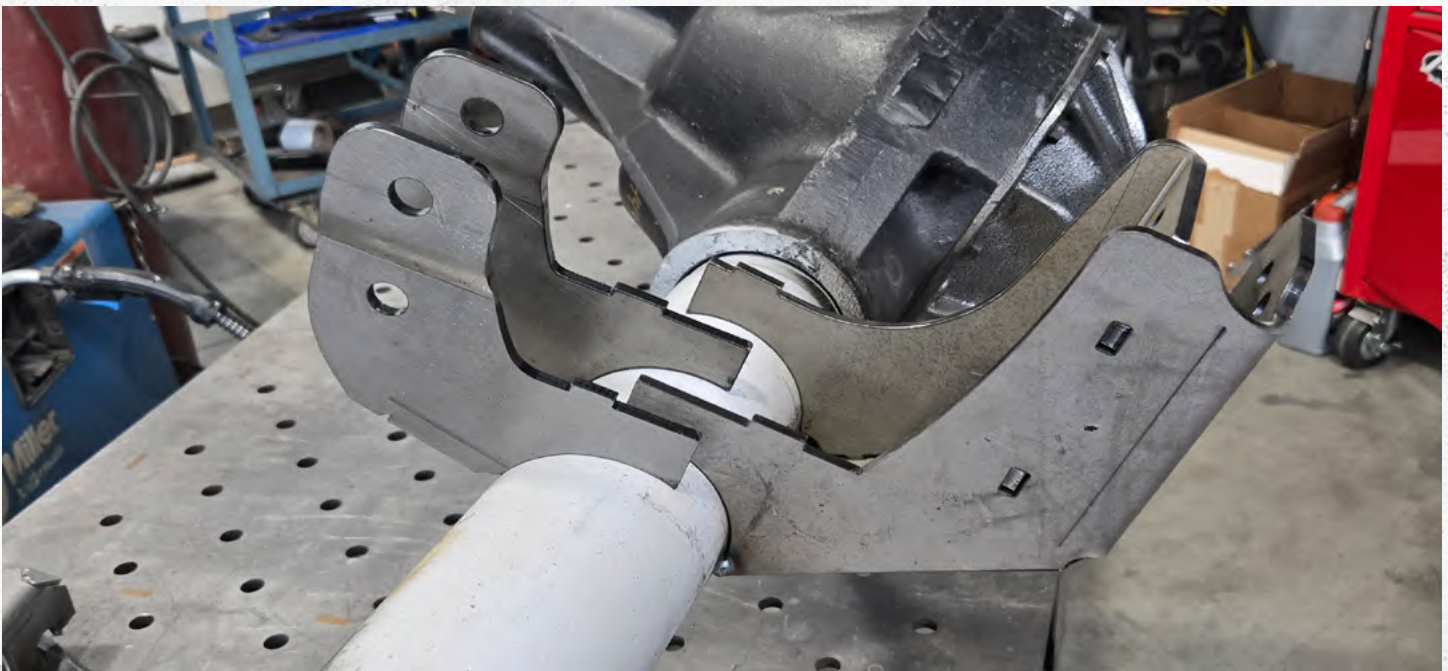
Step 4:

Install the assembled track bar bracket into **JT6981-1**. Place a temporary tack.



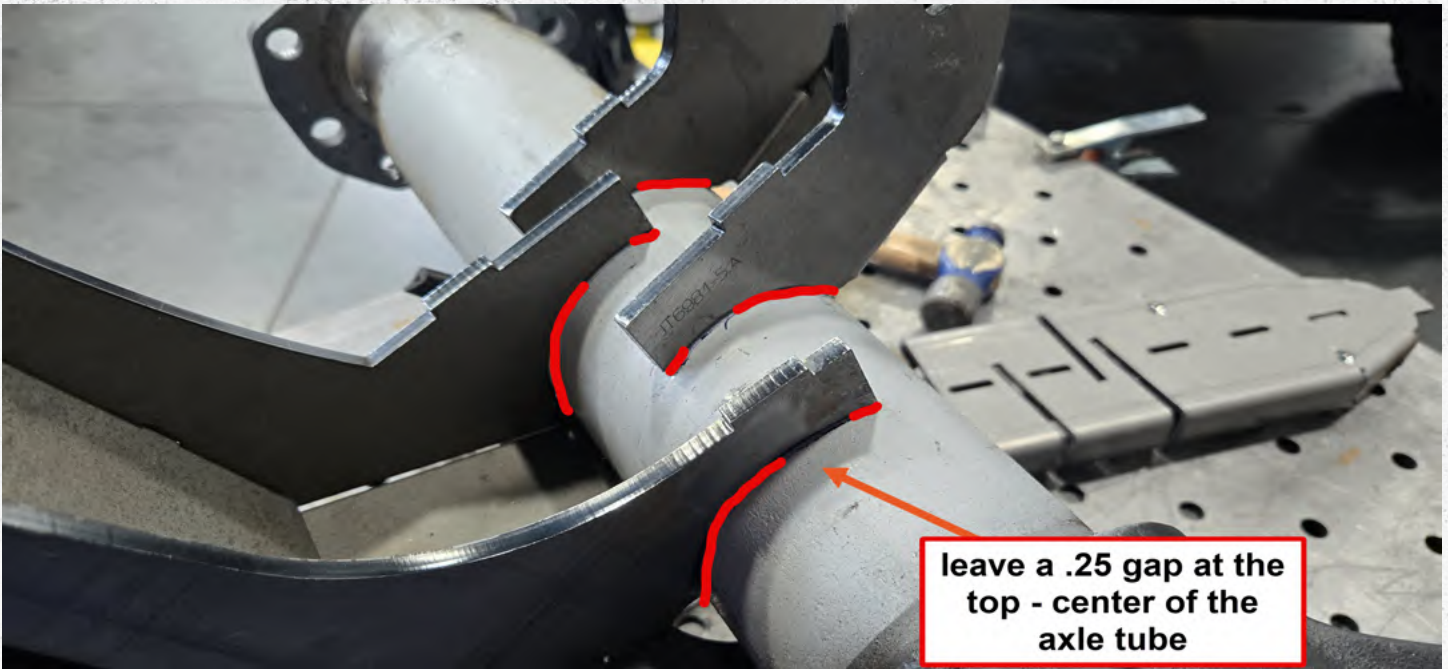
Step 5:

Install **JT6981-5** which also keys into the **JT6981-1** bracket. Place a temporary tack.

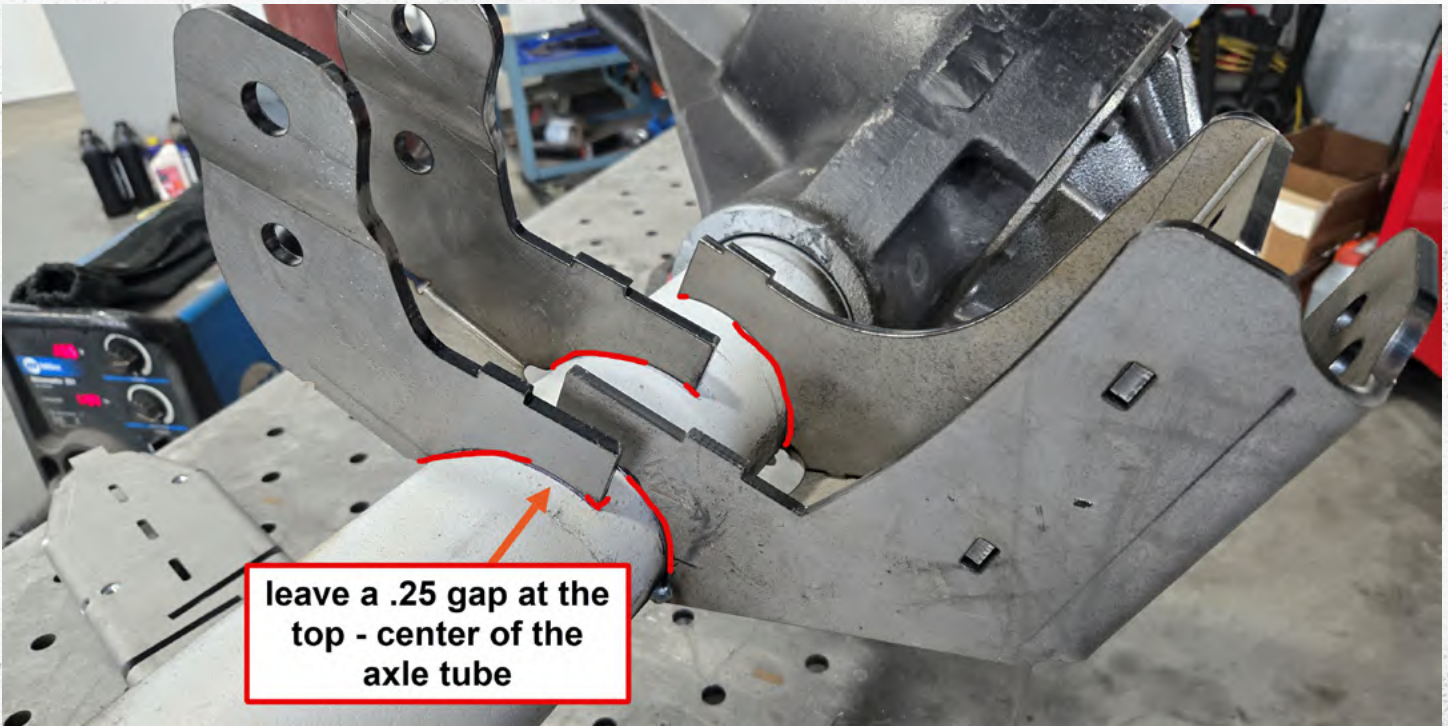


Step 6: (additional view)

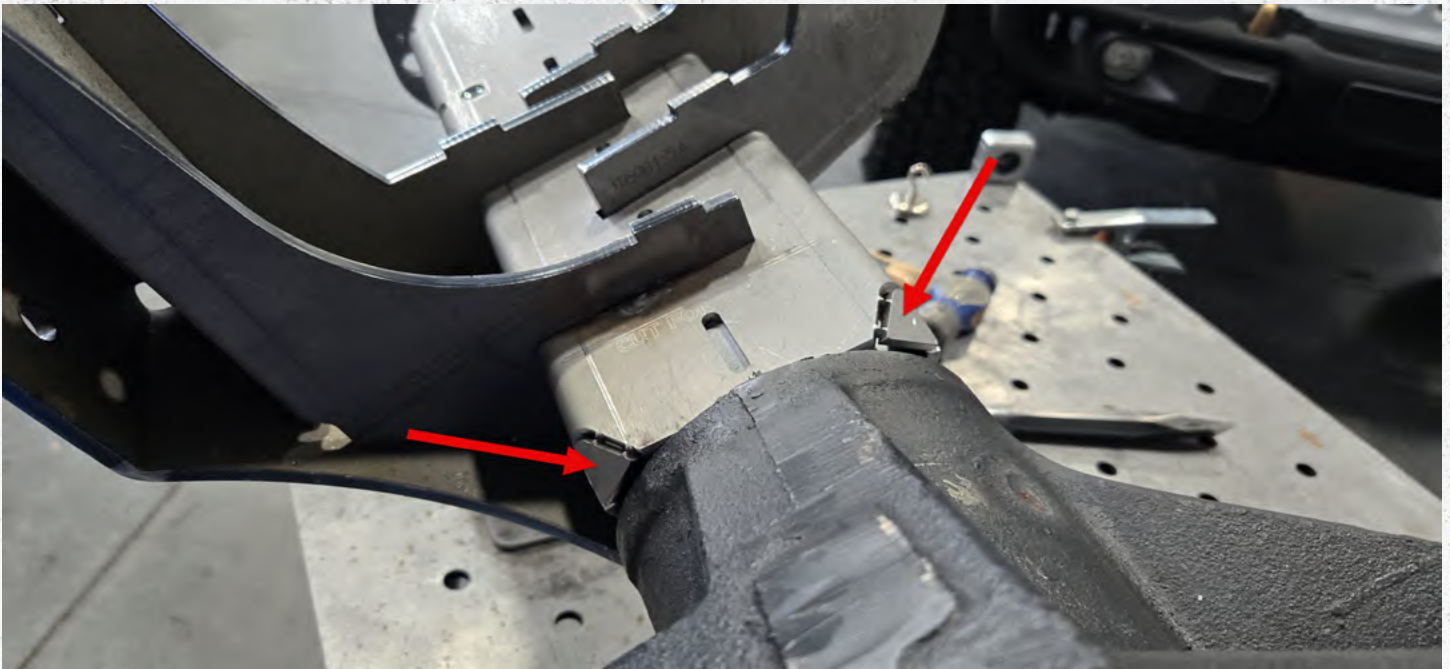
Remove the **JT6981-1** bracket leaving **JT6981-5** and the assembled track bar bracket in place. This will allow you to make a structural weld that you cannot access after the top is welded to the axle.



Step 7:
Weld along the red lines shown above.

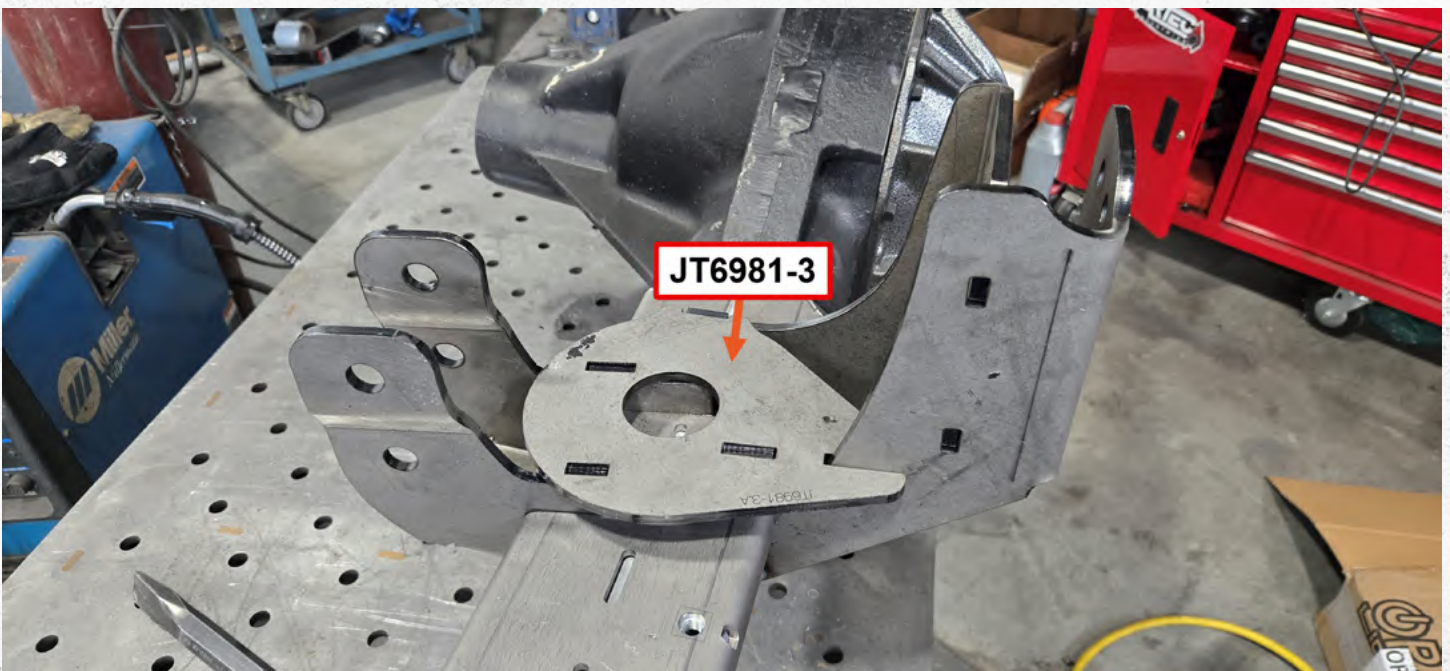


Step 8:
Weld along the red lines shown above.



Step 9:

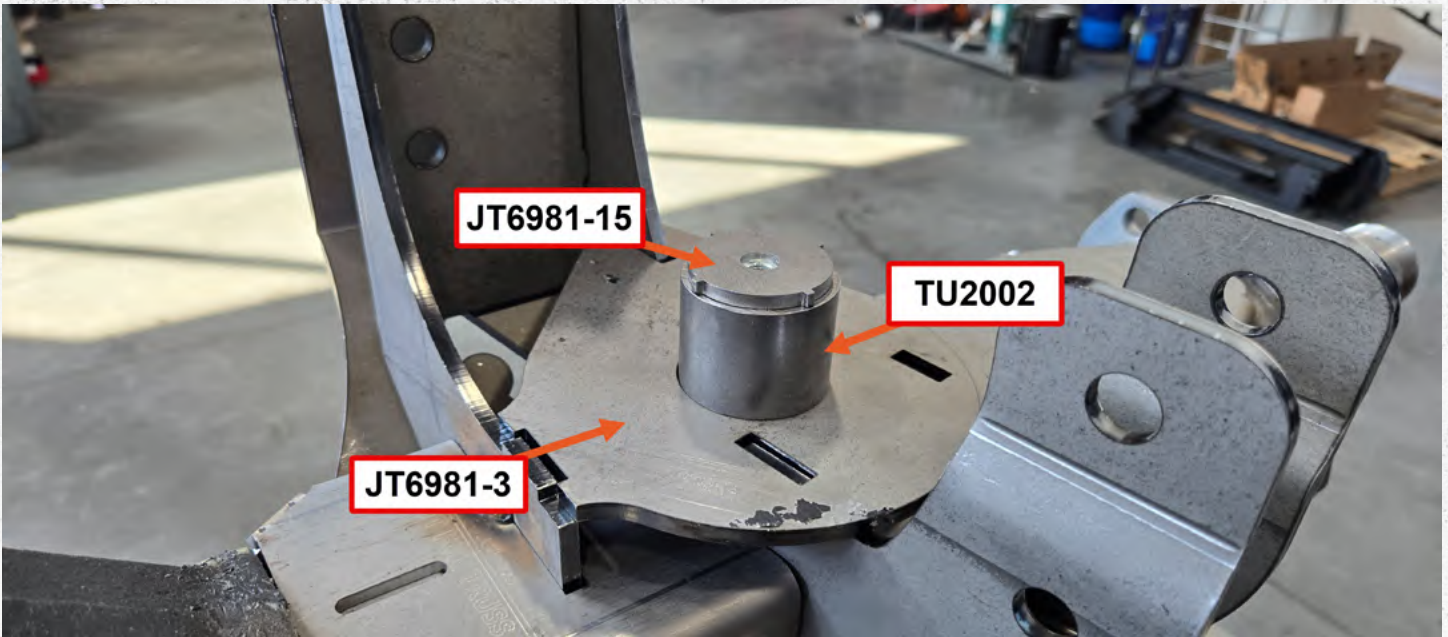
Reinstall the **JT6981-1** bracket and hammer the “ears” down.



Step 10:

After welding JT6981-5 and the assembled track bar bracket. Install the **JT6981-3** bracket, this will key into the UCA and track bar bracket.

Once the spring pad is in place, fully welding the JT6981-5 and the assembled track bar bracket will not be possible.



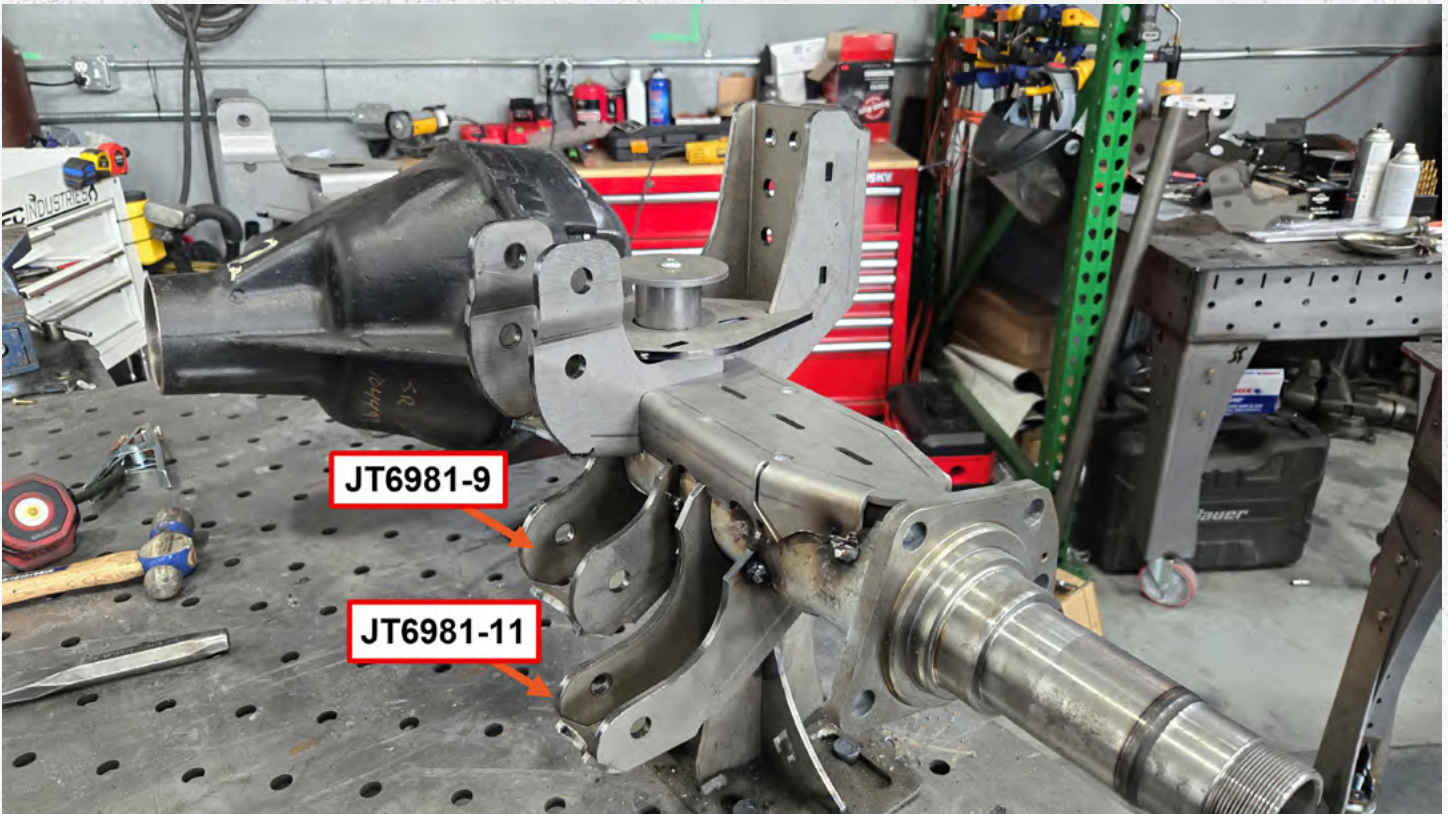
Step 11:

Place the **TU2002** coil-spring tube concentric with the hole in the **JT6981-3** bracket. Cap it with **JT6981-15** and weld it into place.



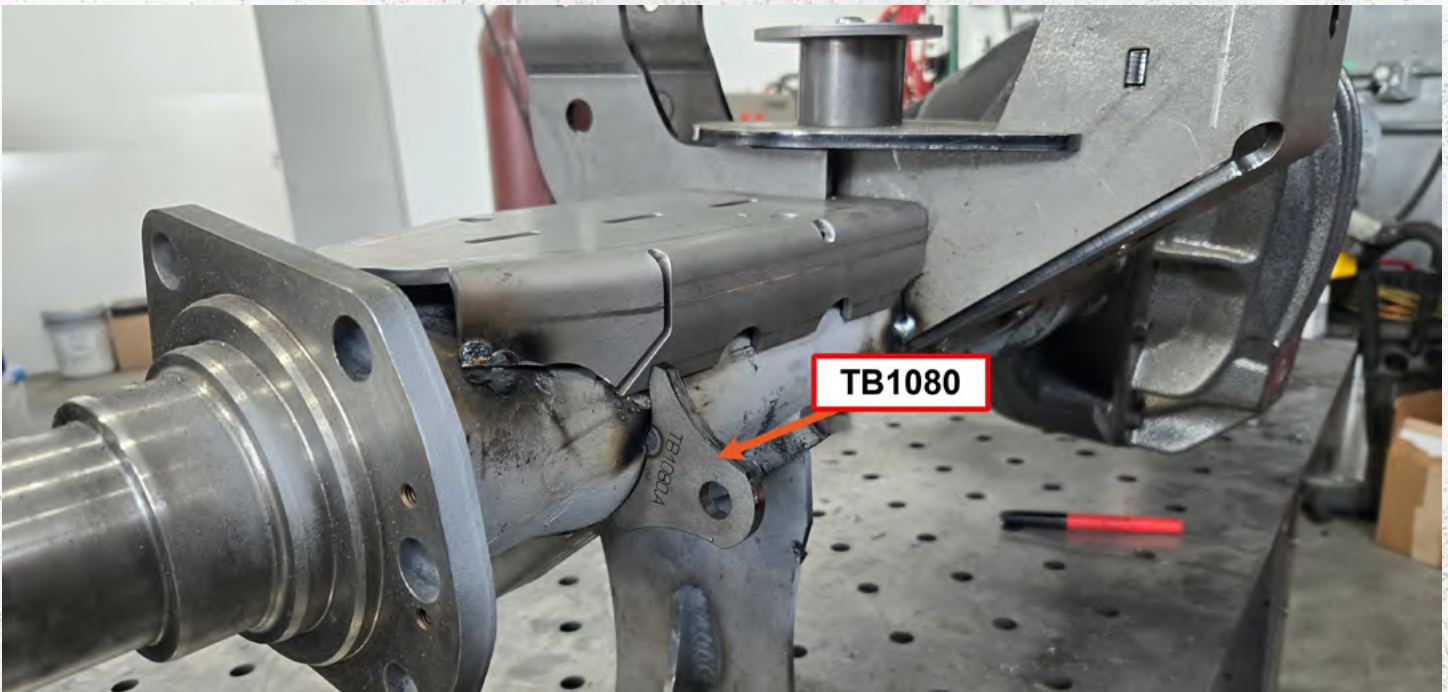
Step 12:

The above image shows the spring retainer and button head bolt installed. This should be installed after the coil spring is in place.



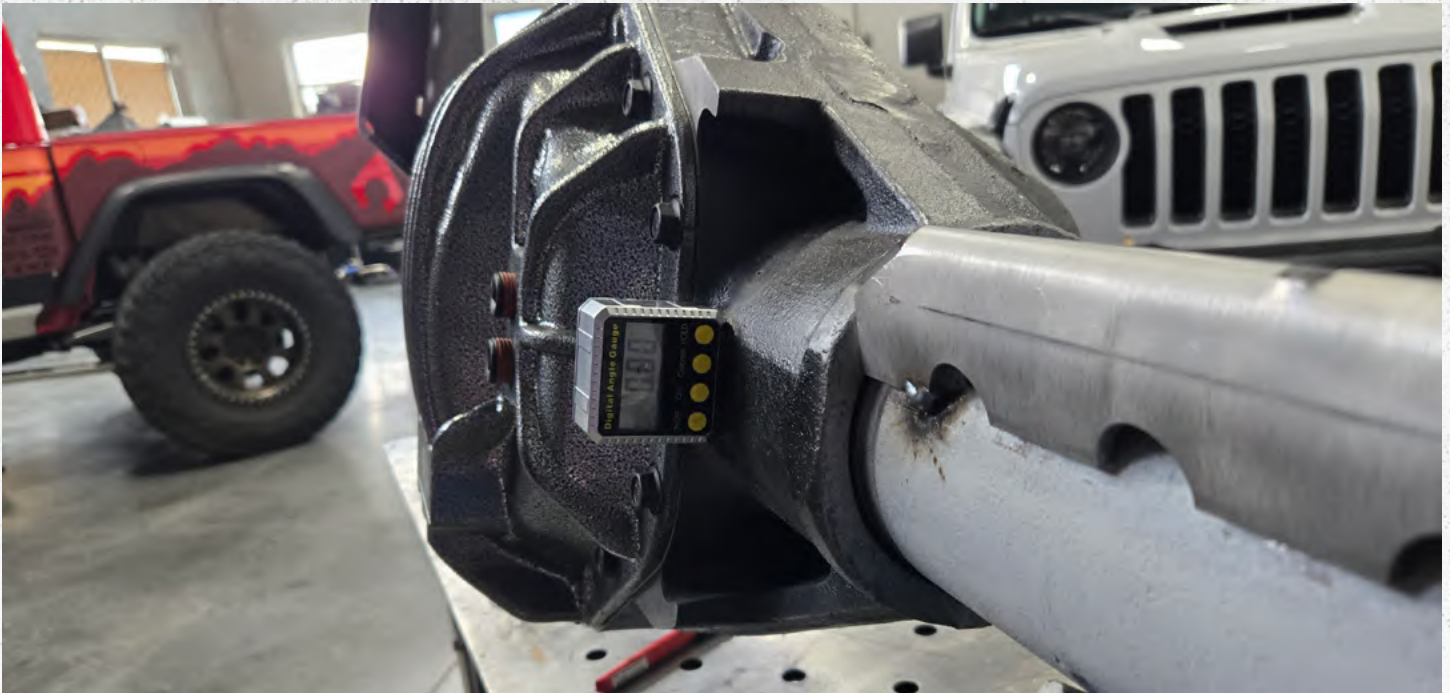
Step 12: (inside view)

Install brackets **JT6981-9** and **JT6981-11** on the driver side of the vehicle, note that the brackets key into **JT6981-1** and are concentric to the axle tubing.



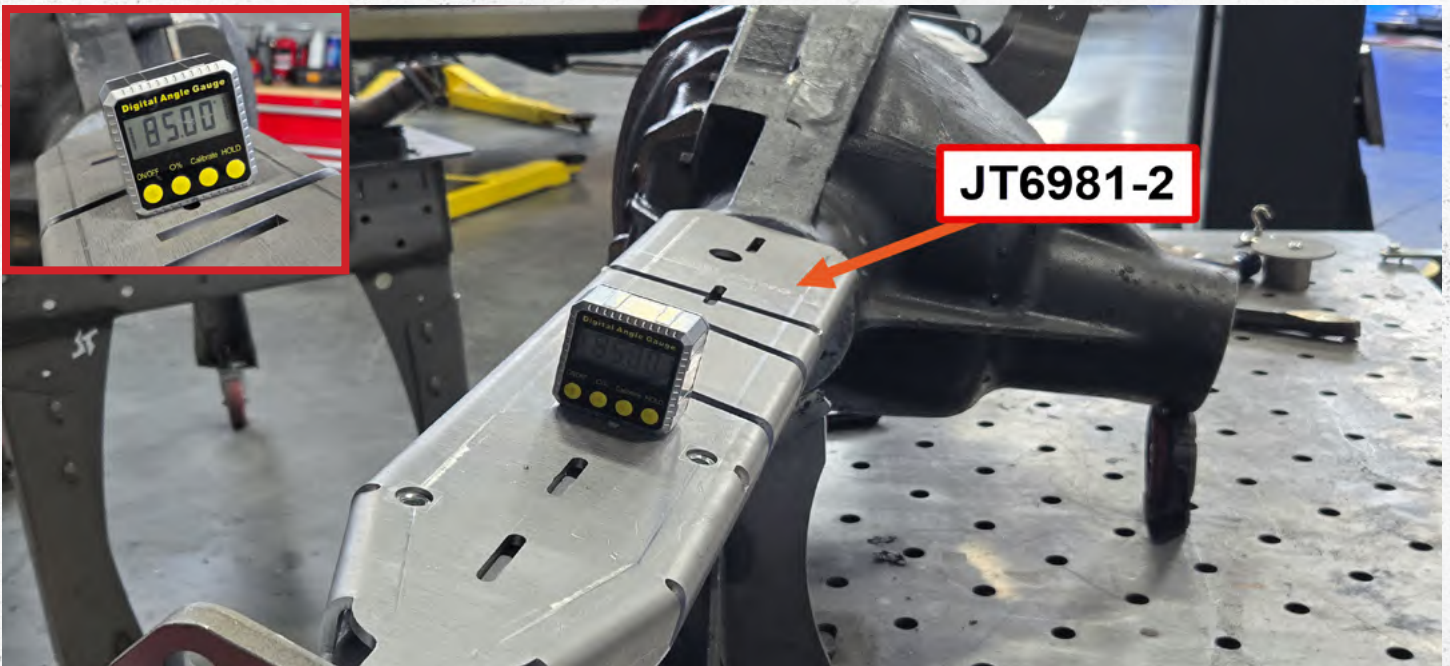
Step 13:

Install the **TB1080** sway bar tab on the back side of the axle.



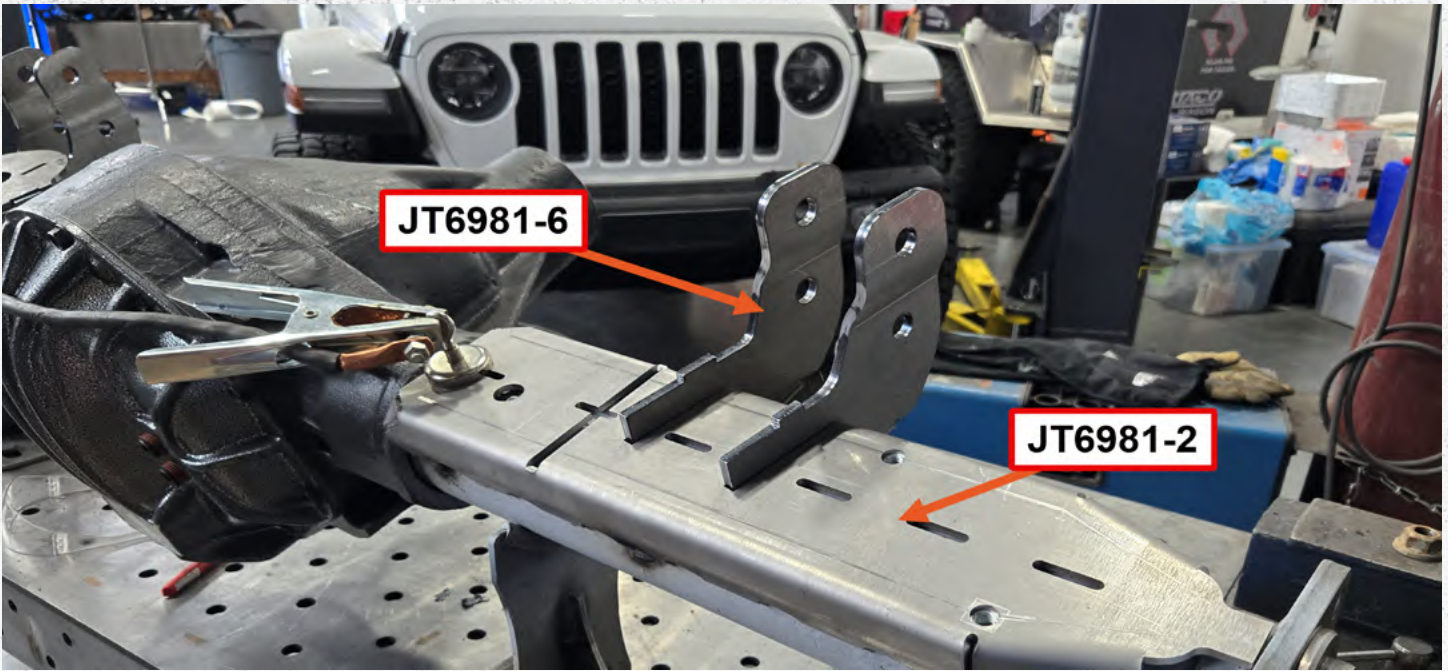
Step 14:

On the passenger side, set the angle finder to zero similar to **step 1**.

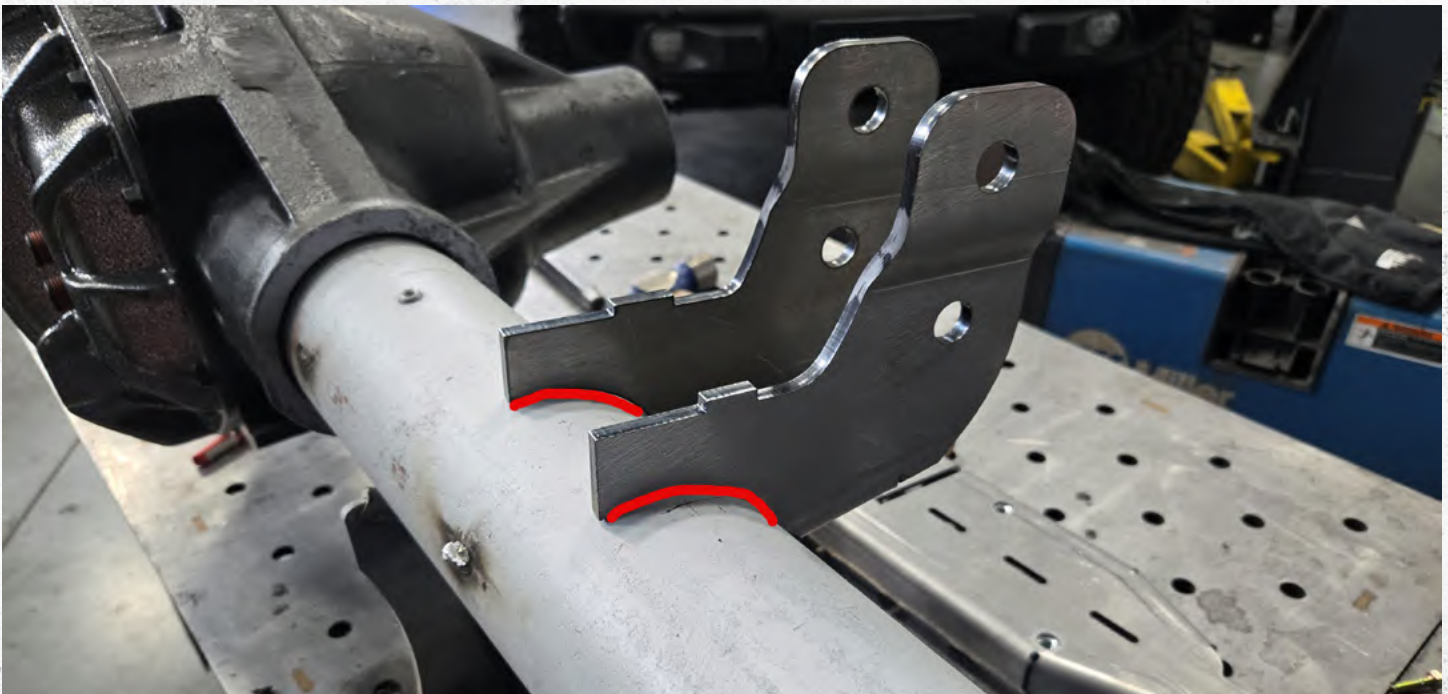


Step 14: (additional view)

Set the passenger side **JT6981-2** bracket at 85 degrees (5 degrees forward towards the pinion).



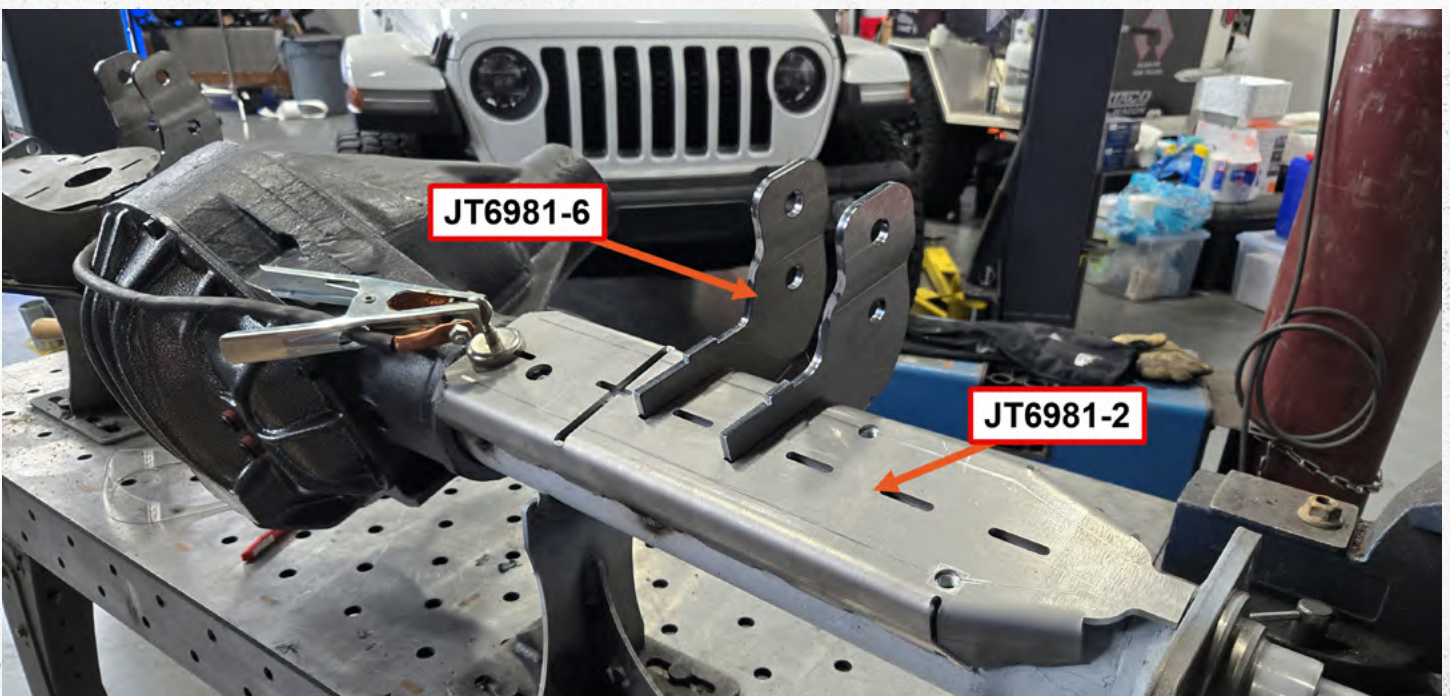
Step 15:
Install bracket **JT681-6** which keys into **JT6981-2**.



Step 16:
Remove the **JT6981-2** bracket so that **JT6981-6** can be welded (shown by the red line).



Step 17:
Weld along the red lines shown above.

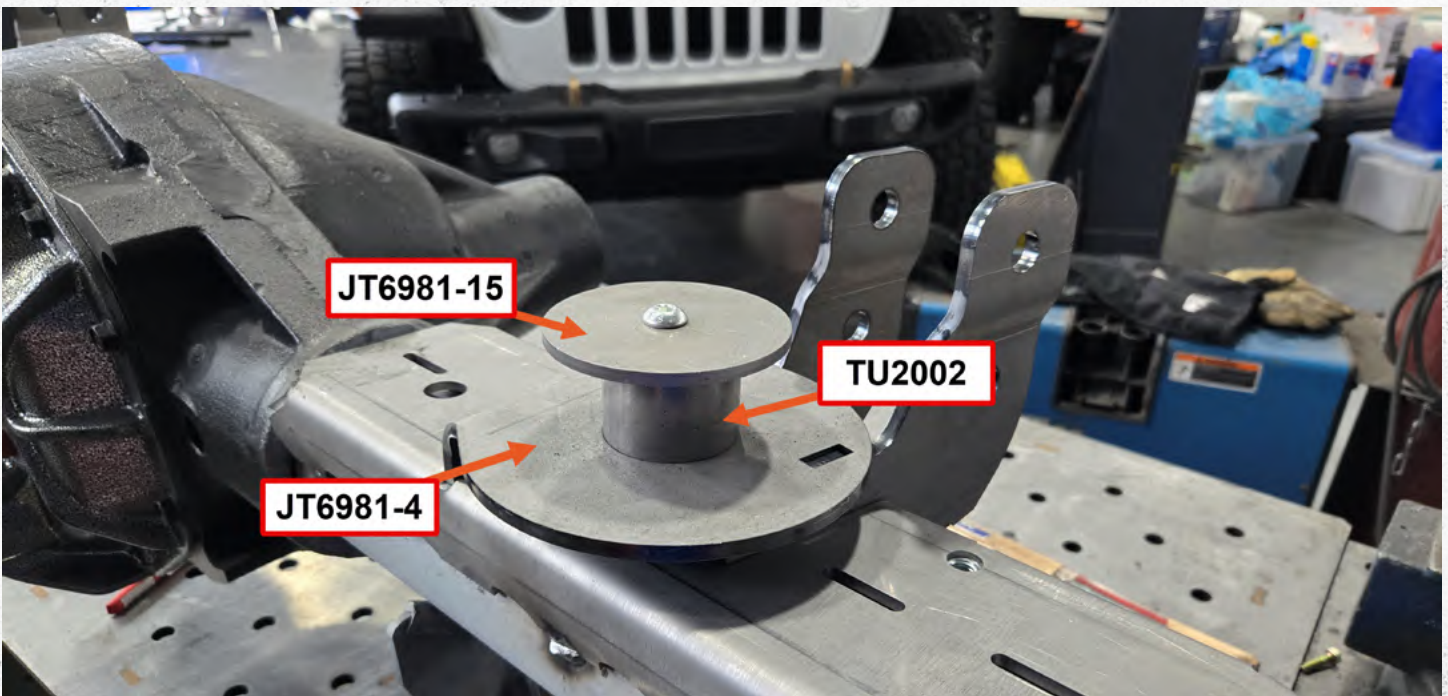


Step 18:
Reinstall **JT6981-2**. Fully weld this bracket.



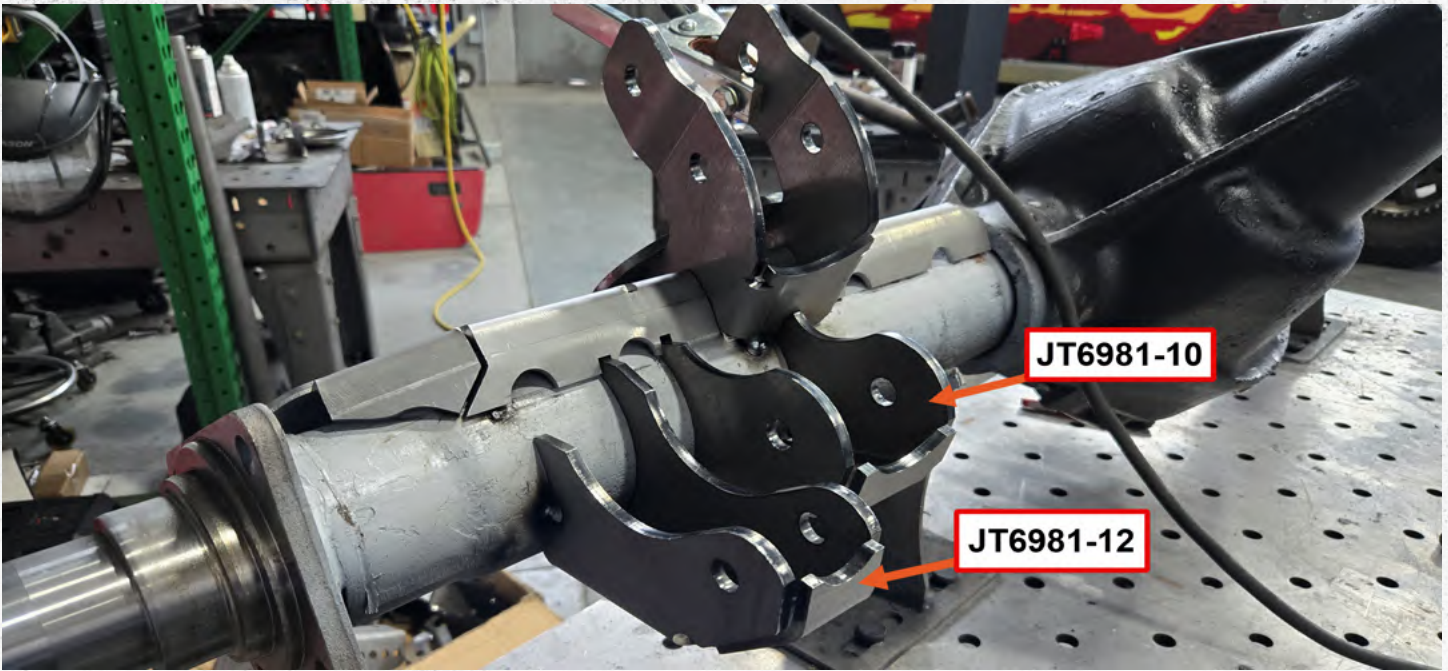
Step 19:

Install **JT6981-4**, this bracket fits in a slot on **JT6981-2** and the UCA bracket.



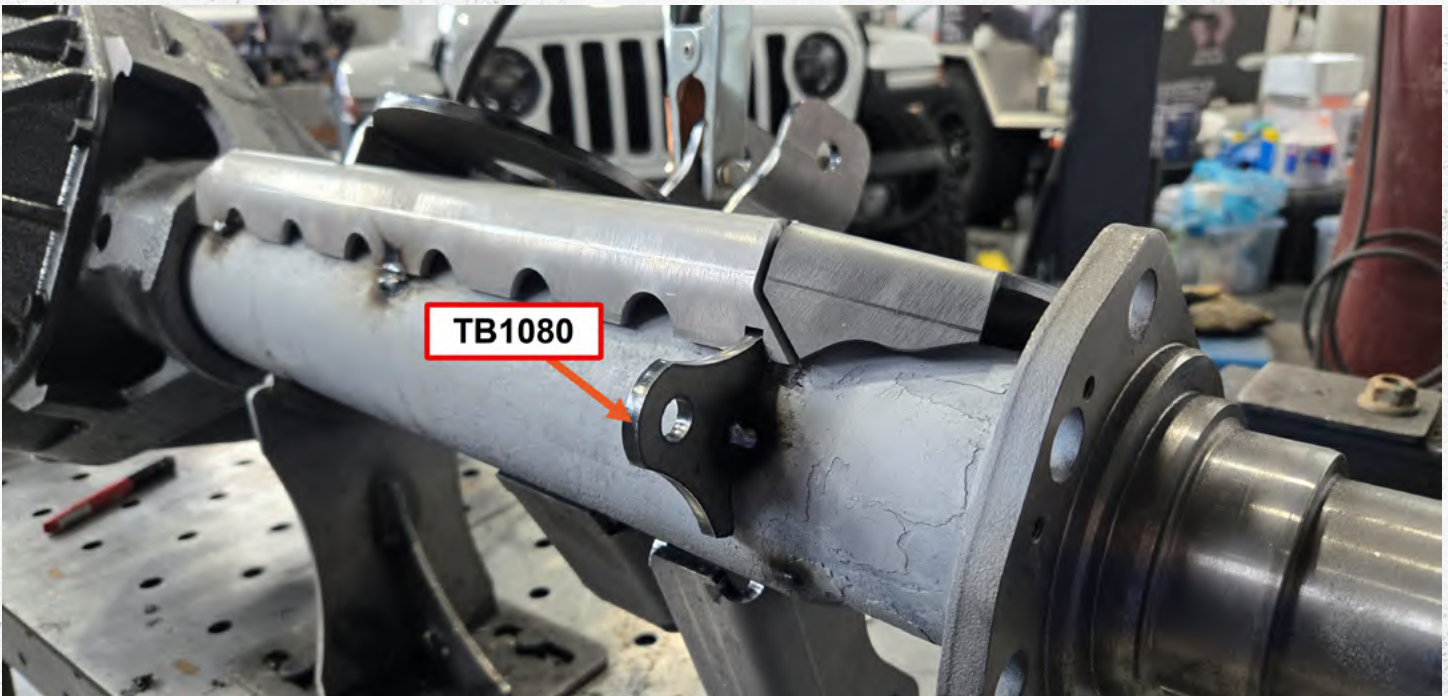
Step 20:

Assemble the coil-spring post on the passenger side using the same materials from step 11 & 12.



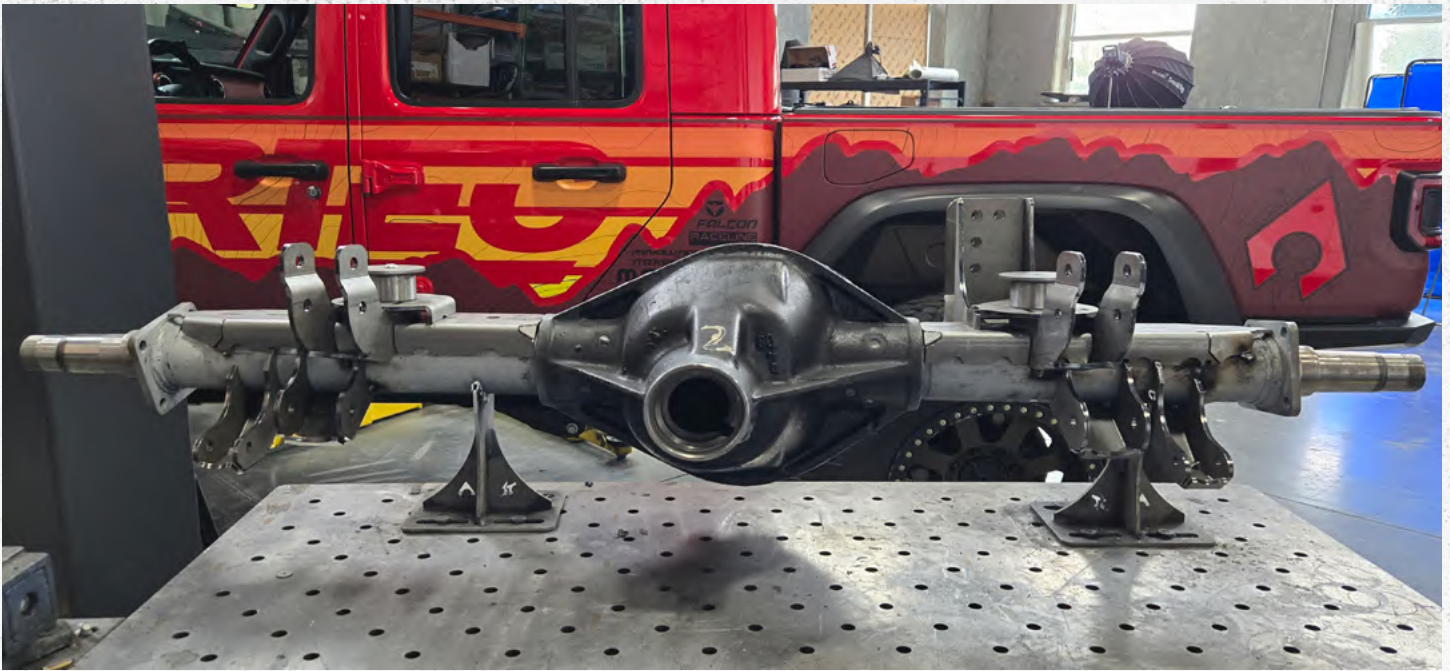
Step 21:

Install brackets **JT6981-10** and **JT6981-12** on the passenger side of the vehicle, note that the brackets key into **JT6981-2** and are concentric to the axle tubing.



Step 22:

Weld the **TB1080** way bar tab onto the back of the axle truss.



Step 23:

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 too 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 JT 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.