JK/ JKU Steering Box Stretch Install Instructions

Thank you for purchasing the RPM Steering Box Relocation Kit. Please take your time during the installation and be sure to do it correctly. Please read the directions before starting your installation so you know what to expect. Remember, your safety and the safety of others depend on it. Feel free to call with any questions you may have, 480-476-2073.

Kit Includes:

(1) Outer Frame Relocation Bracket with Pre-welded Sleeves

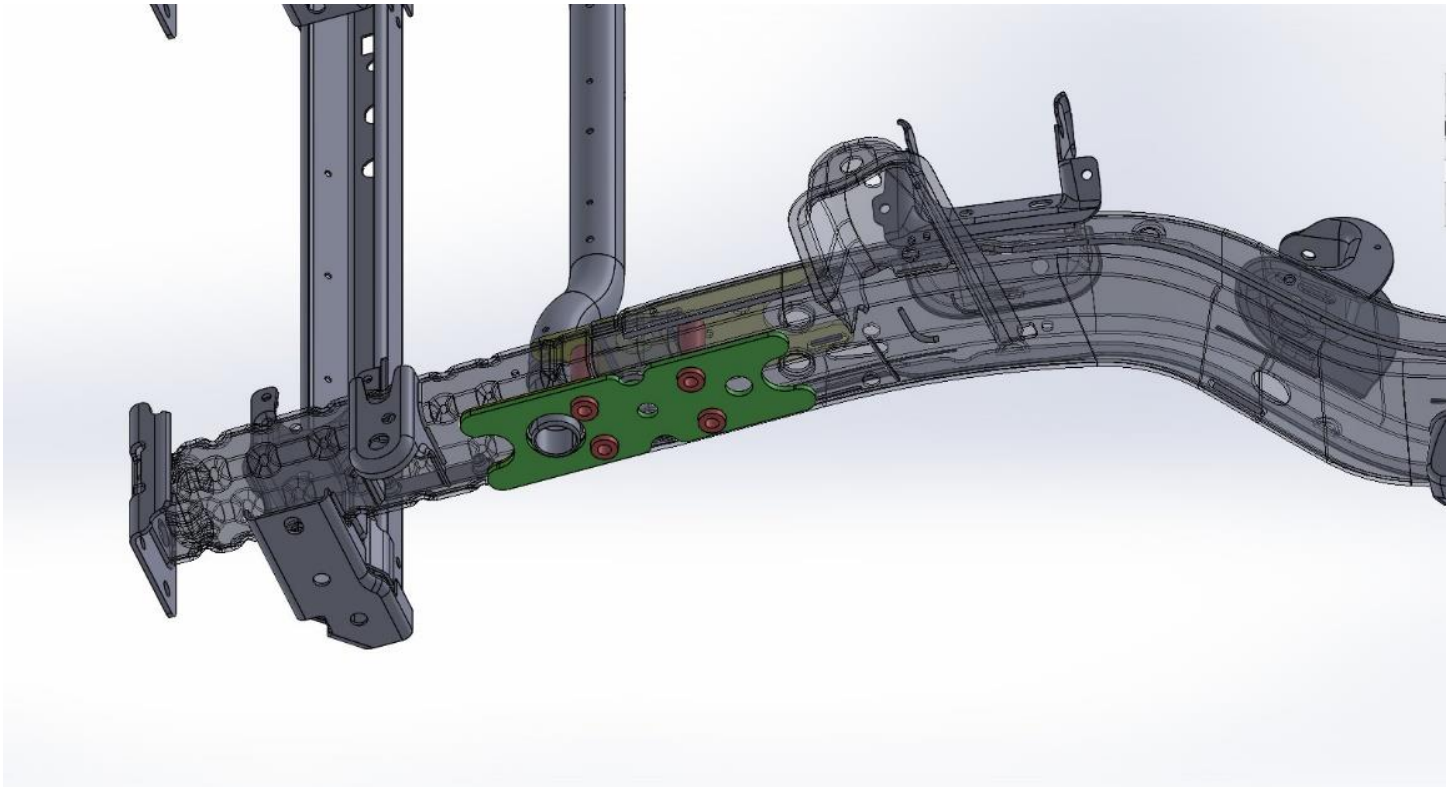
(1) Inner Frame Relocation Bracket

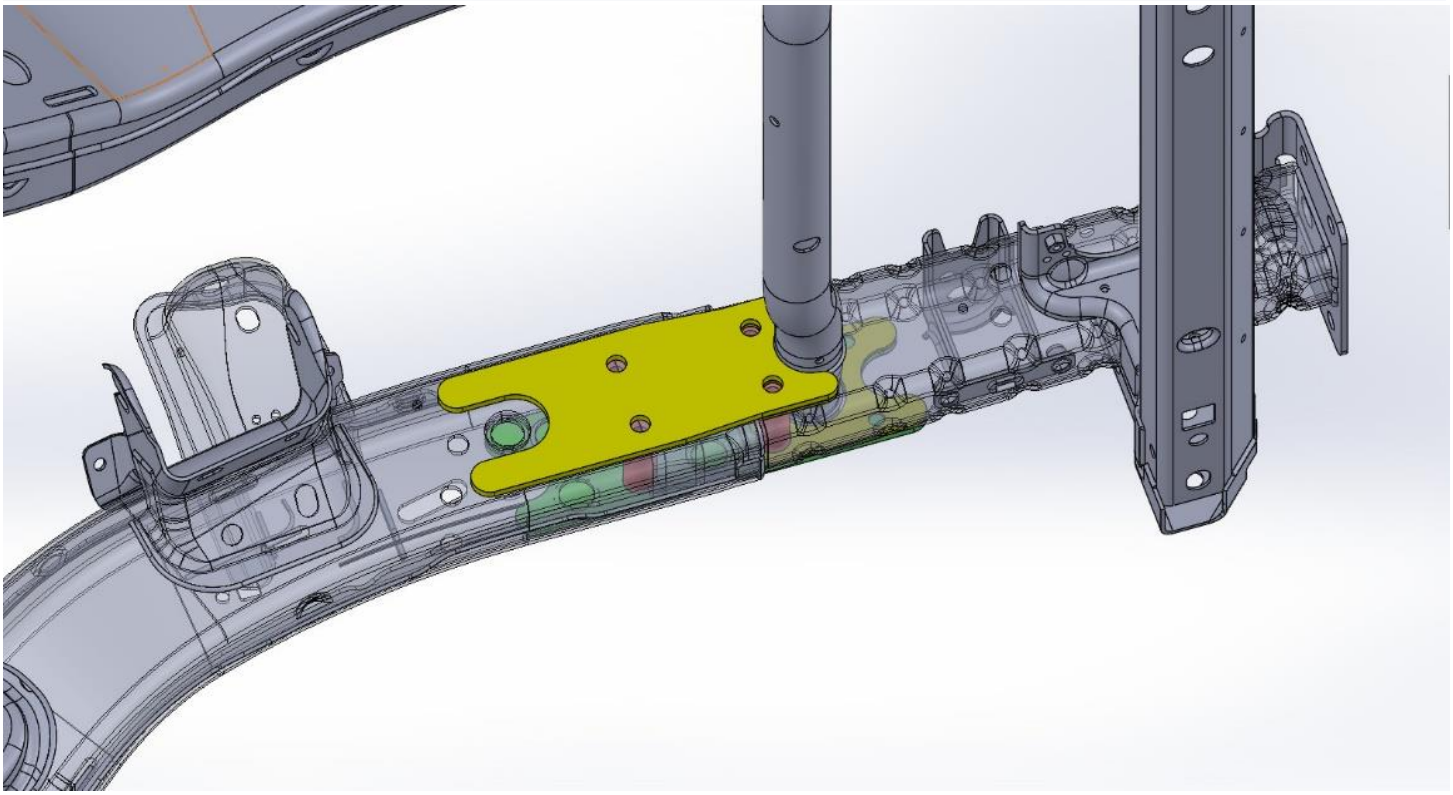
(4) ½'' Alignment Bolts and Hex nuts

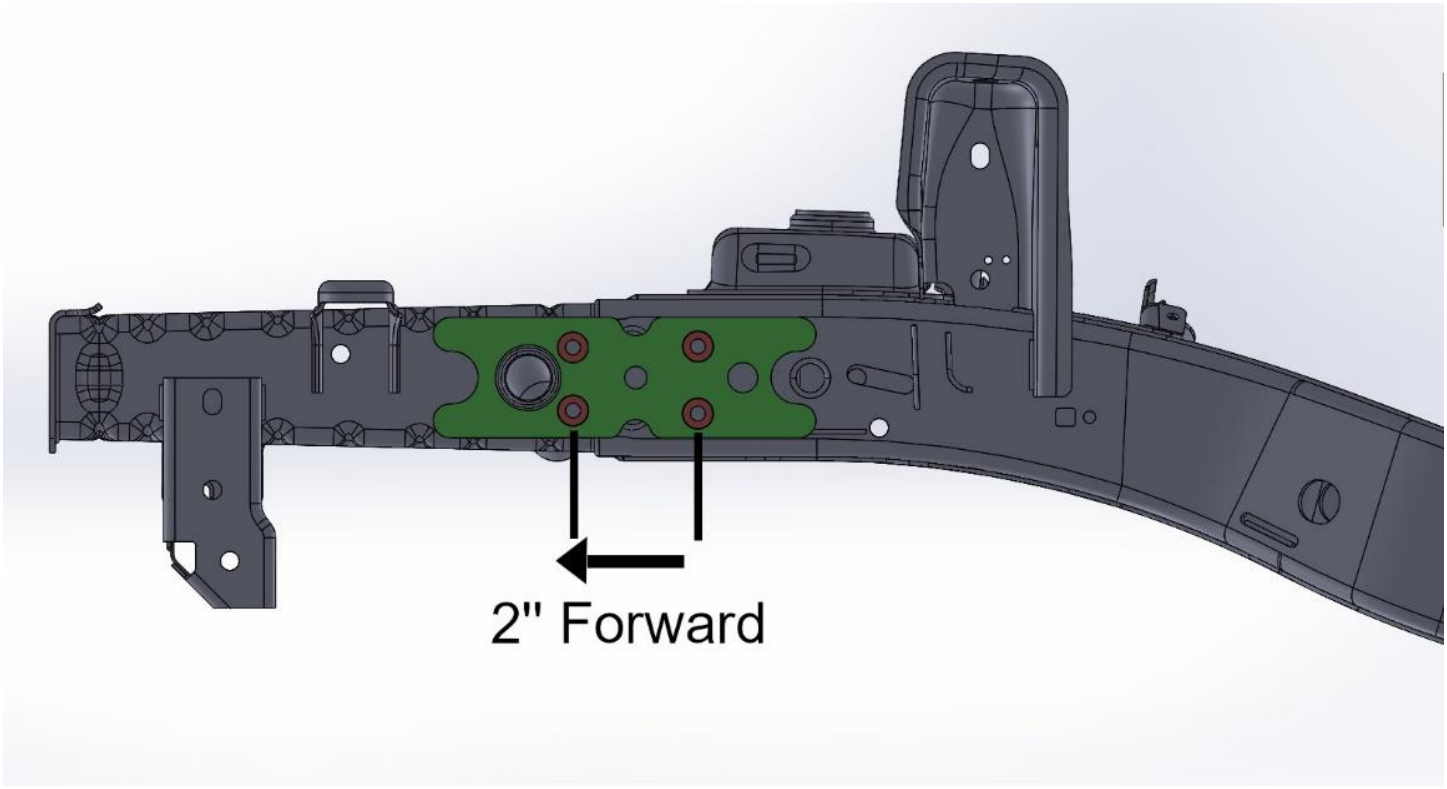
Disclaimer:

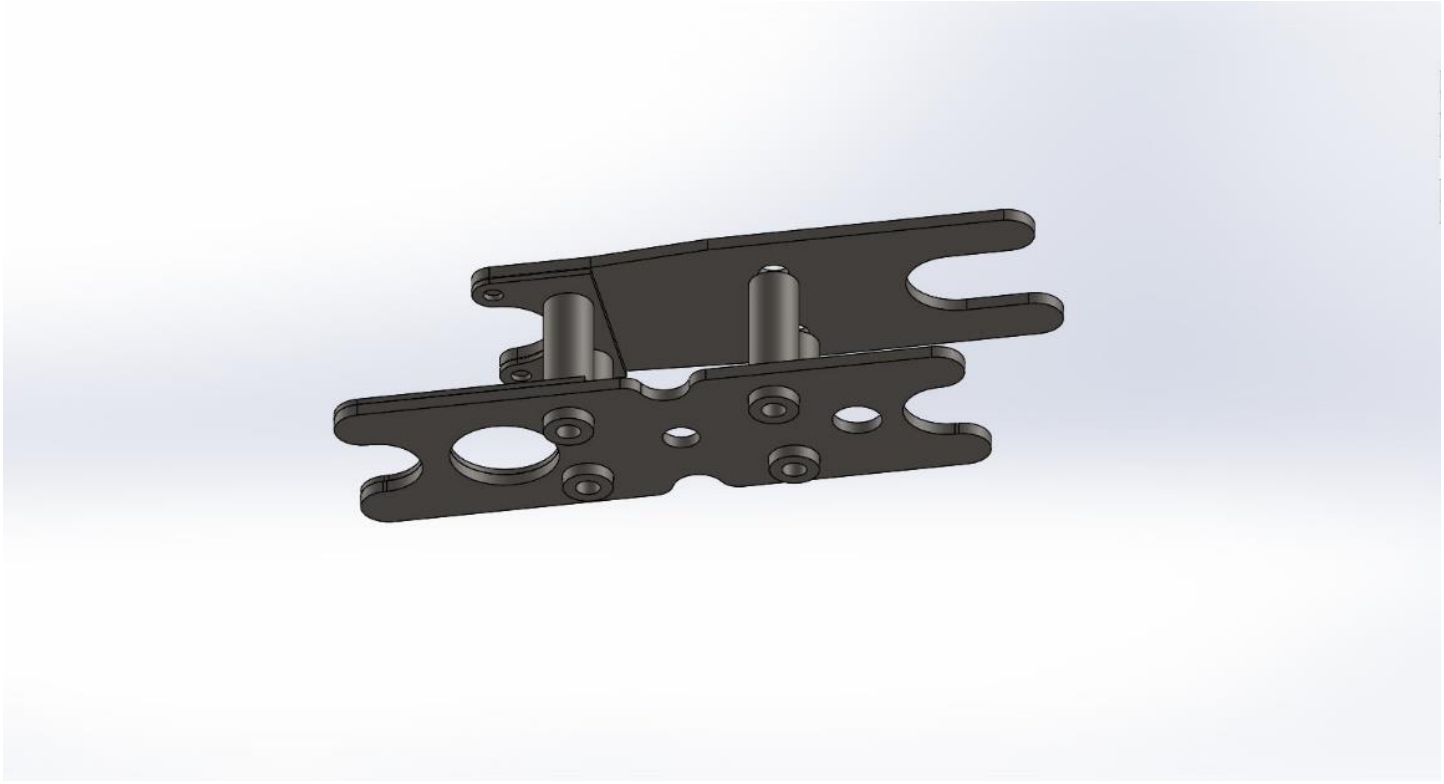
*****This is an advanced level install. Additional fab work may need to be done to work in conjunction with your vehicle's aftermarket parts. If you are not comfortable with these steps please take the vehicle to a professional for install.**

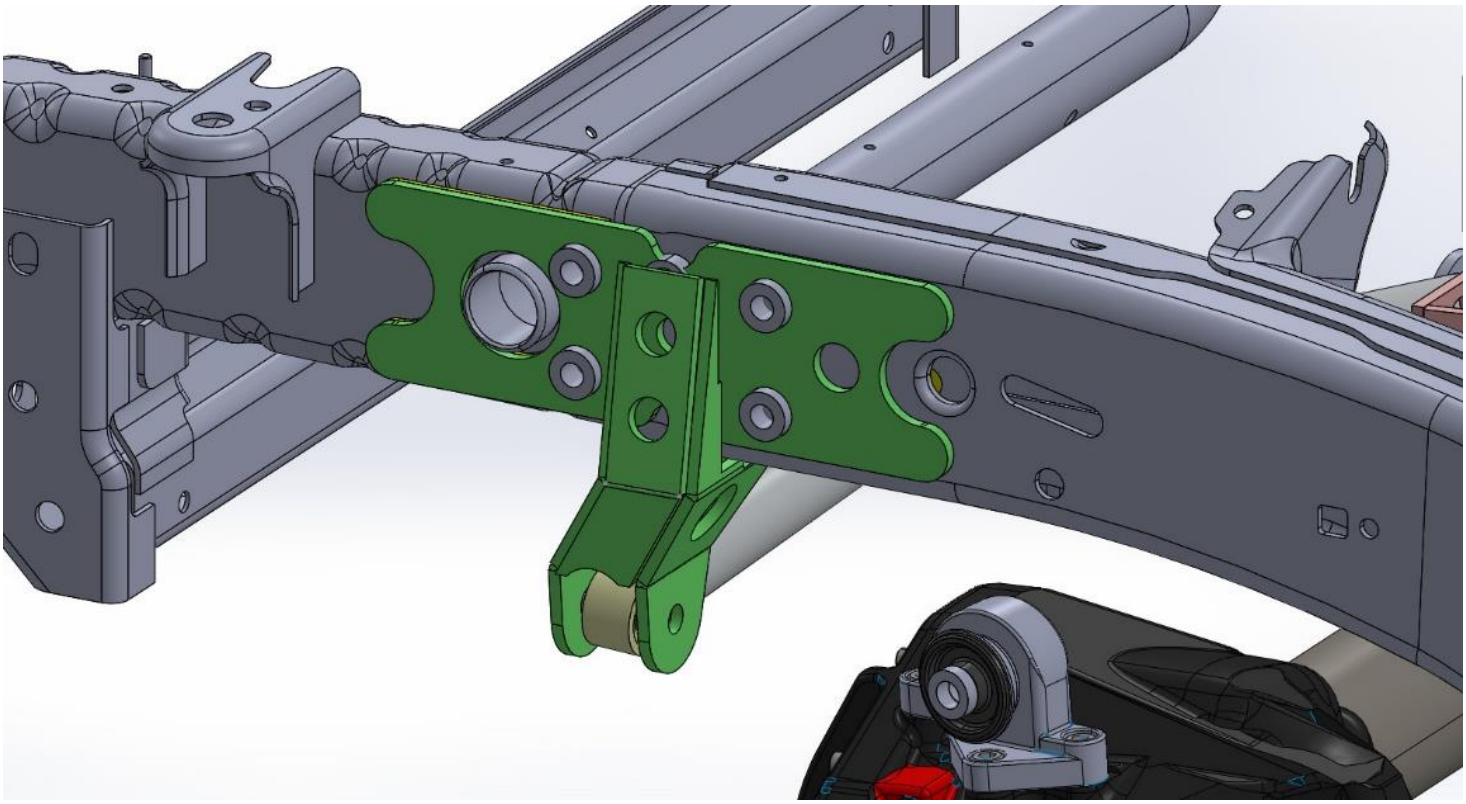
Customer assumes full responsibility for use, installation, and routine maintenance. RPM Steering is not responsible for damage as a result of improper installation, use or maintenance.






2" Forward





***Shown with optional offset track bar bracket available on www.rpmsteering.com

Steps:

1) Remove drivers side tire to access the steering box work area.
2) Remove the drag link at the pitman arm
3) Remove the Track Bar
4) Remove the steering box (save the 4 bolts as they will be used again)
5) Remove any other suspension at this point that will be deleted (ie. Coil Springs, Shocks etc)
6) Cut off the factory coil bucket, track bar bracket and grind the steering box welded sleeves protruding from the frame so that the whole outside of the frame is smooth. Also grind away any paint where you will need to weld.
7) Use our steeing box relocation kit bracket as template to mark your outer frame side holes 2'' forward of the factory bolt pattern. NOTE the orientation of the bracket in the pictures above as the holes are not equally spaced apart and you will need to mark the holes with it set the way it will be installed.
8) Use a center punch and mark the centers of the 4 holes to be drilled.
9) DRILL ONLY THROUGH THE OUTER WALL OF THE FRAME ON THIS STEP
10) Drill each hole to a 1'' final diameter. You may want to start with a ½'' bit and step up to the final size. ***It is recommended before the next step to use a weldable paint such as "Steel It" to paint the frame before installation of our bracket to prevent rust.

11) Insert the RPM outer frame bracket with the pre-welded sleeves into the side of the frame in the orientation pictured above. (depending how well you marked and drilled the holes in the side of the frame you may need to slightly open up the holes a bit more til the sleeves slide in.
12) Tac weld the plate to the outside of the frame as it will be the template/ guide for drilling the inner frame holes.
13) Using a ½'' drill bit you can now drill the inner frame by using the pre-welded sleeves as your bit guide drilling from the outside of the frame inward.
14) With the holes drilled you can now place the inner plate in line with the bolt pattern and use the provided 1/2'' hardware to bolt the plates together for welding. The bolts are only for alignment purposes and will be discarded after installation.
15) You are now ready to weld the brackets to the inner and outer of the frame. Take caution on welding long strings in one area. Weld a few stitches in an area and jump to the opposite side to allow some cooling between each weld. This will help from weakening the frame from overheating.
16) Remove provided alignment bolts. They are not used for any box installation.
17) Weld any other parts that come in contact with the plates such as track bar bracket or coilover tower and finish with a durable paint to avoid rusting.
18) Reinstall steering box using factory bolts set aside earlier
19) Reinstall other suspension components

****Depending on your steering box (aftermarket boxes) you may need to notch the round crossmember bar for clearance.