



#J5203 Installation Instructions Jeep XJ/TJ/ZJ Weld-On Sway Bar Mount

Read and understand all instructions and warnings prior to installation of product and operation of vehicle.

Zone Offroad Products recommends this system be installed by a professional technician. In addition to these instructions, professional knowledge of disassembly/ reassembly procedures and post installation checks must be known. Minimum tool requirements include the following: Assorted metric and standard wrenches, hammer, hydraulic floor jack and a set of jack stands. See the "Special Tools Required" section for additional tools needed to complete this installation properly and safely.

» PRODUCT SAFETY WARNING

Certain Zone Suspension Products are intended to improve off-road performance. Modifying your vehicle for off-road use may result in the vehicle handling differently than a factory equipped vehicle. Extreme care must be used to prevent loss of control or vehicle rollover. Failure to drive your modified vehicle safely may result in serious injury or death. Zone Offroad Products does not recommend the combined use of suspension lifts, body lifts, or other lifting devices.

You should never operate your modified vehicle under the influence of alcohol or drugs. Always drive your modified vehicle at reduced speeds to ensure your ability to control your vehicle under all driving conditions. Always wear your seat belt.

» TECHNICAL SUPPORT

Live Chat provides instant communication with Zone tech support. Anyone can access live chat through a link on www.zoneoffroad.com.

www.zoneoffroad.com may have additional information about this product including the latest instructions, videos, photos, etc.

Send an e-mail to tech@zoneoffroad.com detailing your issue for a quick response.

888.998.ZONE Call to speak directly with Zone tech support.

Difficulty Level

easy 1 2 **3** 4 5 difficult

Estimated installation: 1-2 hours

Special Tools Required

Welder

Cut-off Wheel, Reciprocating Saw or Hack Saw

» PRE-INSTALLATION NOTES

1. Special literature required: OE Service Manual for model/year of vehicle. Refer to manual for proper disassembly/reassembly procedures of OE and related components.
2. Adhere to recommendations when replacement fasteners, retainers and keepers are called out in the OE manual.
3. Larger rim and tire combinations may increase leverage on suspension, steering, and related components. When selecting combinations larger than OE, consider the additional stress you could be inducing on the OE and related components.
4. Post suspension system vehicles may experience drive line vibrations. Angles may require tuning, slider on shaft may require replacement, shafts may need to be lengthened or trued, and U-joints may need to be replaced.
5. Secure and properly block vehicle prior to installation of Zone Offroad Products. Always wear safety glasses when using power tools.
6. If installation is to be performed without a hoist, Zone Offroad Products recommends rear alterations first.
7. Due to payload options and initial ride height variances, the amount of lift is a base figure. Final ride height dimensions may vary in accordance to original vehicle attitude. Always measure the attitude prior to beginning installation.

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Kit Contents

Qty	Part
2	Extended Link Mount
2	Gusset

INSTALLATION INSTRUCTIONS

1. Park the vehicle on a clean, flat surface and block the rear wheels for safety.
2. Raise the front of the vehicle and support with jack stands under the frame rails. The tires do not need to be removed as long as the steering can be cycled left and right freely.
3. Disconnect the sway bar links from the axle mounts. Save hardware and swing the sway bar and links up and out of the way.
4. The factory front sway bar link axle mounts must be cut off to make room for the extended mounts provided. These new mounts will provide more steering linkage clearance once the vehicle is lifted by moving the link mounting point up 2". Starting on the driver's side, make a cut mark on the axle link mount that is flush with the top surface of the axle coil mount. This mark will be approximately 2-5/8" from the top point of the link mount **Figure 1A, 1B**.



Figure 1A



Figure 1B

5. Cut the link mount along the cut line with a reciprocating saw or cut off wheel. Take care to make the cut as straight and square as possible. The top portion that is cut from the driver's side mount will be used as a template for the passenger's side. Also, making a square cut here will help with setting up the welding process later on.
6. With the driver's side link mount removed, use the cut portion as a template by aligning the hole and the profile of the cut piece with the passenger's side mount **Figure 2**. Note: A 1/2" bolt can be inserted in the mounting holes of the ends to aid in aligning them.

Step 6 Note

A 1/2" bolt can be inserted in the mounting holes of the ends to aid in aligning them.



Figure 2

7. Cut the passenger's side link on the cut line in the same fashion as the driver's side.
8. With the link mounts cut, go through and remove any corrosion, oil, etc from the remaining portion of the factory link mounts. The surfaces must be corrosion/oil free to promote quality welds.
9. Position a provided new link mount on the cut surface of the original driver's side mount. The front edge of the new mount should be flush with the front cut edge of the old mount. The inside surface of the link mount should also be flush/parallel with the inside surface of the original mount. Tack weld the new link mount in place. **Figures 3A, B** Double check to see that the new mount is square with the original.

Step 9 Note

It is recommended to grind a bevel in the edge of the new link mount (outside where it meets the original mount) to promote good weld penetration of both pieces of material..

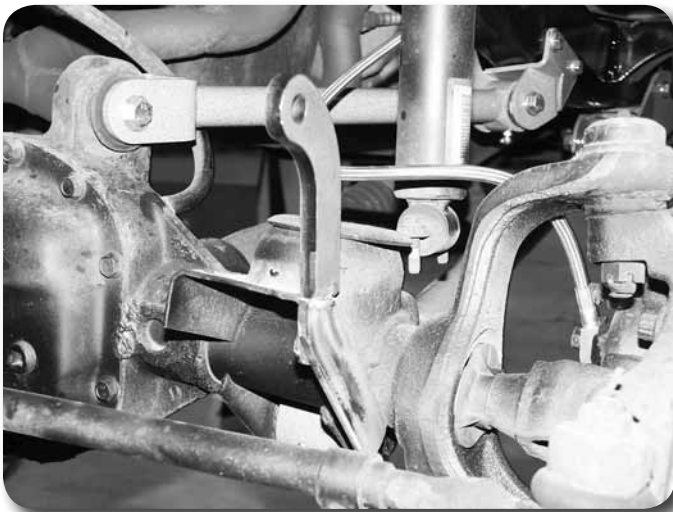


Figure 3A

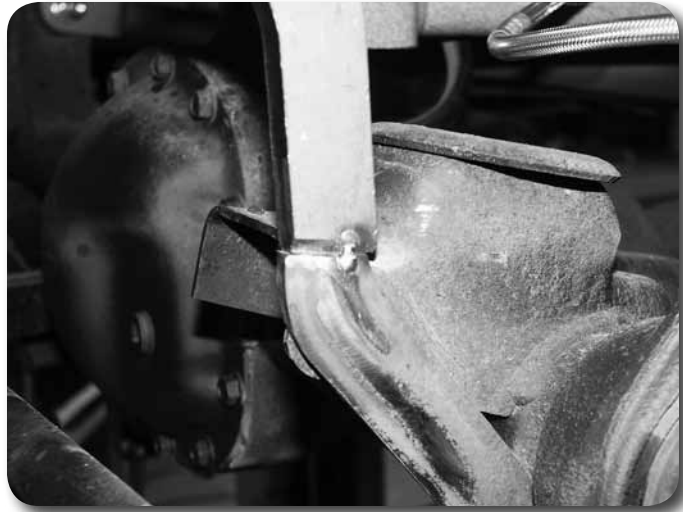


Figure 3B

10. Repeat the link setup procedure on the passenger's side of the vehicle. **Figure 4.** With both pieces tacked in place check the relationship between the two mounts to see that they are the same. Measure the inside distance between the tops of the links and the bottoms of the links to see that they are the same (approximately 38-1/2").



Figure 4

11. With the links positioned correctly, locate the provided formed side gussets. Position the gussets so that they are parallel to the front surface of the original link mount and flush to the outside surface of the new link mount **Figure 5.** Once they are in the desired position, tack weld the gussets in place.

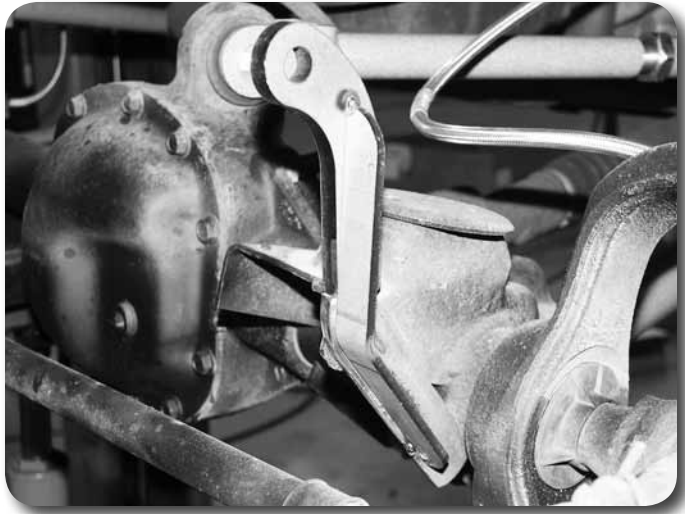


Figure 5

12. With the link mount parts correctly in place finish weld the components to the axle. Weld all around the point where the original mount meets the new mounts as well as the full length of the gusset where it meets the new and original link mounts **Figure 6**
13. When the welded areas have cooled, paint all bare metal surfaces to prevent corrosion.
14. Attach the axle end of the sway bar links to the new mounts and torque the mounting hardware to the proper specs.
15. If removed, install the wheels and lower the vehicle to the ground. Check all hardware for proper torque. Check all clearances related to the steering/sway bar/sway bar links. The new mounts have effectively added 2" of length to the sway bar links. Check to see that the links do not need to be shortened or otherwise modified to operate correctly.

Step 12 Note

Weld the back side of the gusset for best weld penetration and aesthetics.

Step 14 Note

The torque specs on the sway bar link hardware may vary depending on the style/manufacturer of the sway bar links on the vehicle. Generally, a 12mm or 1/2" hardware can be torqued to 60-65 ft-lbs.



Figure 6