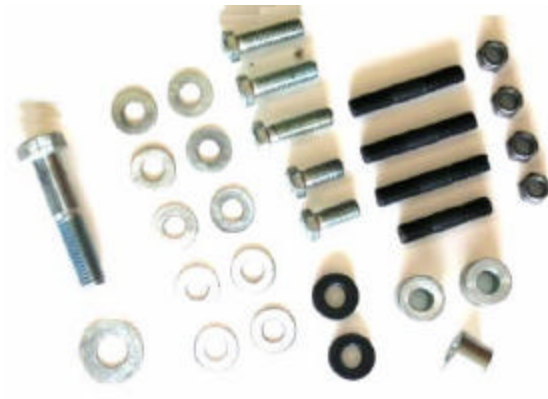




1976 – 1986 CJ H/D Steering Box Bracket Instructions
P/N: 18003.10



- Parts List:**
- | | |
|------------------------------|------------------------------|
| (1) H/D Steering Box Bracket | (4) 7/16" Lock nut |
| (1) 5/8" x 2 1/2" Bolt | (10) Flat washer |
| (1) 5/8" Flat washer | (2) 7/16" x 1" Hex head bolt |
| (3) Tall spacer .700" | (3) 7/16" x 2" Hex head bolt |
| (2) Short spacer .275" | (1) Outer frame clamp |
| (3) 7/16" x 2 1/2" Stud | |
| (1) 7/16" x 2" Stud | |

NOTE:

The Rugged Ridge CJ Heavy Duty steering box bracket has been manufactured using 3/8" welded plate steel for superior strength and durability. With proper installation this unit will greatly improve the weak steering mount offered by the OE three piece bracket system. Please take the time to read over this instruction prior to installing this product. It will be necessary to remove your steering box from the frame and it is recommended that the proper step be followed. A service manual is highly recommended.

Installation can be done with box still attached to the lower steering shaft and power steering hose, but great care should be taken to avoid any damage to these components.

If your vehicle is equipped with a winch it may be necessary to remove the winch and mounting plate to install the H/D steering box bracket.



Step (1): Remove old upper and lower bracket from power steering box and frame.
Please refer to the service manual for the proper steps.
To help with the installation it will be necessary to lower the front sway bar from its mounts if the vehicle is equipped. (see fig. 1 and 2)

Fig. 1



Fig. 2



Step (2): Install supplied 7/16" studs into the power steering box. You will need to place the longer 2 1/2" studs in the front and lower rear mounting holes in the steering box. The smaller 2" stud should be installed in the upper rear mounting hole. Note that a good quality thread lock should be used when installing the studs. Also take care when installing studs not to damage the outer fine threads. (see fig.3 and 4)

Fig. 3



fig.4



Step (3): Add spacers to the studs as shown in fig. 5 and fig.6 making note of the location of the thin spacers and thick spacers. The thin spacer is to be placed on the upper rear 2" stud. Place steering box bracket onto steering box and install the 7/16" flat washer and lock nut (torque to 65 ft. lbs.)





Note: Please take the time to test fit the steering box brace to your steering box before installing. Over the years there have been a number of variations in the steering box design and the H/D steering box might require some filling of holes. Every effort has been made to assure a proper fit but not all variances can be accounted for.

Fig.5



Fig.6



Step (4): Bolt up the new mount with steering box to frame starting with the rear frame mount first using one $7/16'' \times 2''$ bolt and the last $.275''$ short spacer. Do not tighten. At this time reinstall the high and low pressure power steering hoses following the steps described by the service manual.

Step (5): Raise the steering box into place and install the remaining bolts. Note that the (2) small 1'' bolts are to be used on the top cross member and the longer 2'' bolts are to be used along the bottom of the frame rail. Do Not Tighten any bolts. It is important that all bolts are started by hand to insure alignment of all holes and to ease installation.

Note: For some applications where a shackle reversal has been performed additional spacers will be needed on the lower frame rails to insure proper hole alignment and fitment. (See fig. 7) All other installations should look like (Fig.8).

Fig. 7



Fig.8





Step (6): When all bolts have been aligned and started tighten all but the lower rear frame bolt with a torque wrench to torque 55ft. lbs.

Step (7): Remove rear frame bolt and install the Outer frame clamp. (See fig.9). Reinstall the lower rear bolt loosely. Thread the 5/8" x 2 1/2" Hex head bolt 5/8" flat washer through the Outer Frame Clamp and vehicle frame hole (See fig.10). The 5/8" x 2 1/2" bolt will secure to the H/D steering box bracket. Torque the lower frame rail bolt to 55 ft. lbs, and the 5/8" x 2 1/2" bolt to 65 ft. lbs.



Fig. 9



Fig. 10

Step (8): Follow the service manual for any further installation requirements that may be needed.

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