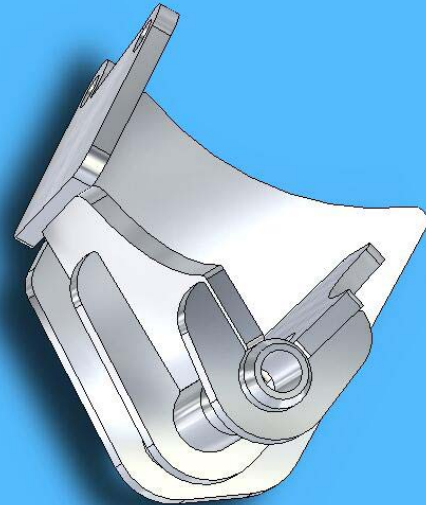
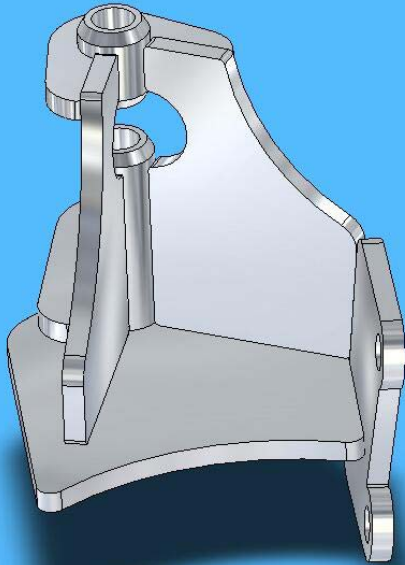
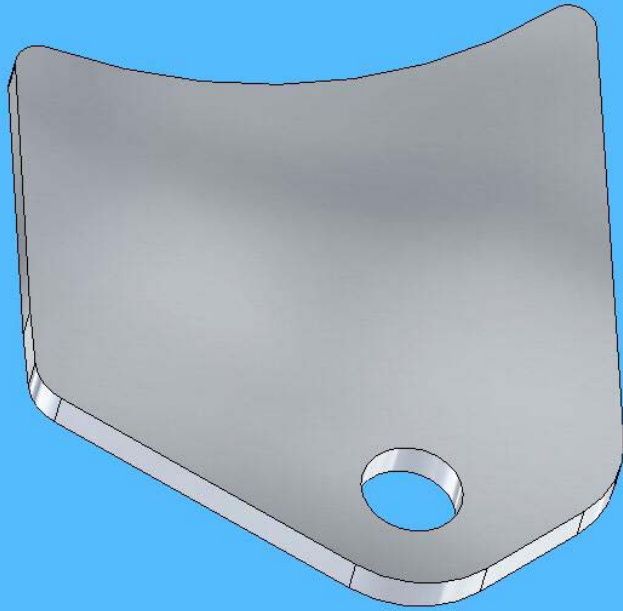
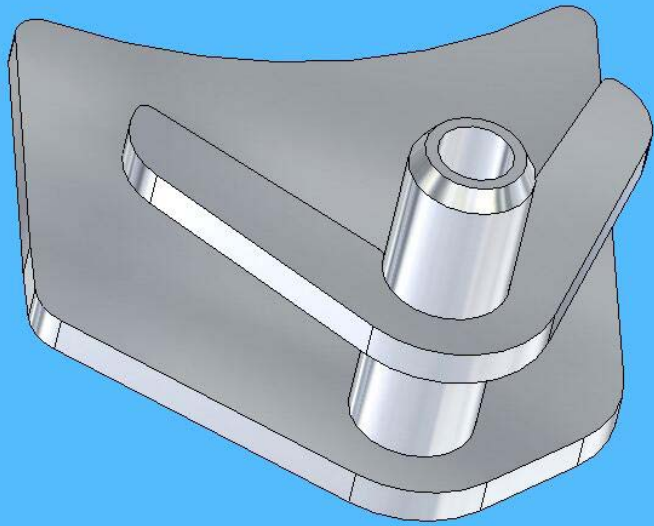


This is the final product. You are trying to make it look like this.

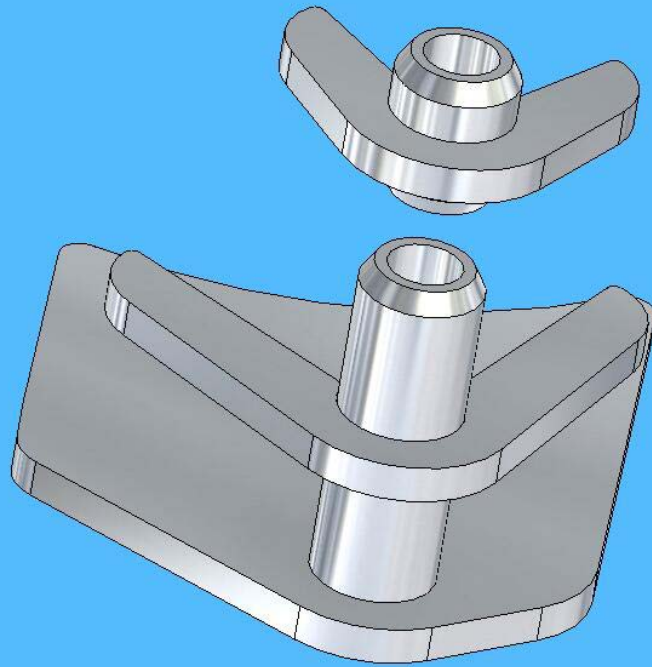




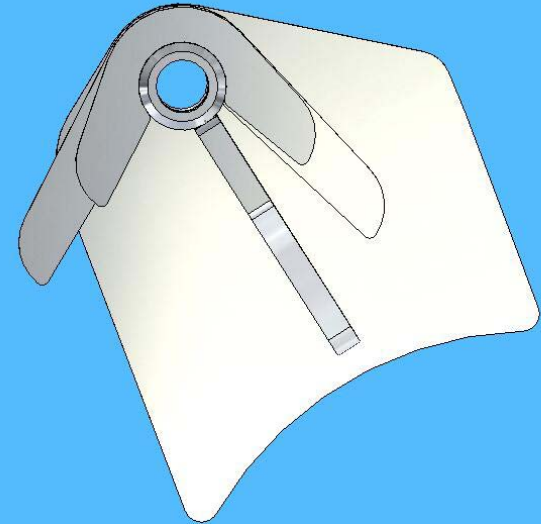
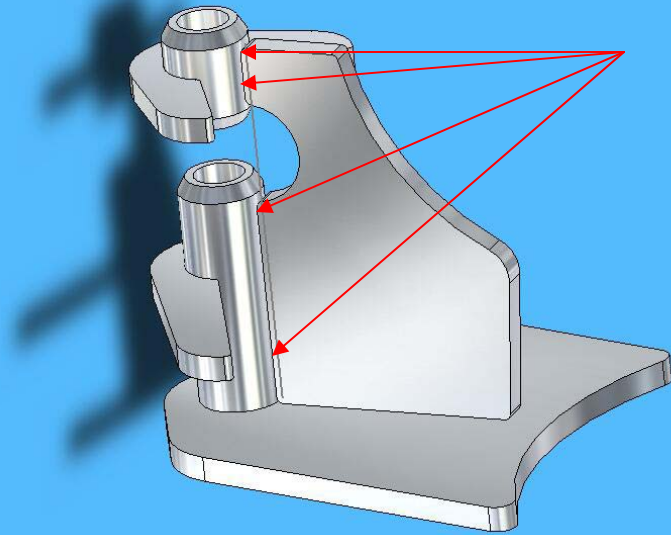
On a front axle, these instructions are for a passenger side arm. Start with a base plate and position it in front of you like in the picture. Take your LONG  $\frac{3}{4}$ " bolt and insert it from the bottom up through the hole. It will be real sloppy. The hole is 1", the bolt  $\frac{3}{4}$ . Don't worry, it is supposed to be like that. Do not tack or weld anything until the instructions say to.



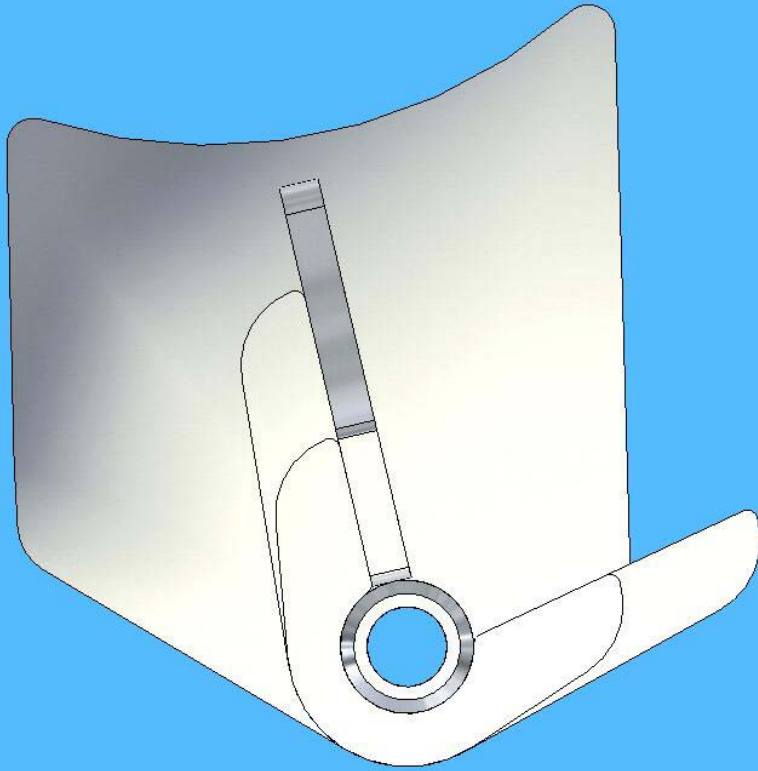
Take the lower tube, slide it over the bolt and put the end into the base plate. Slip the large triangle over the top of the tube.



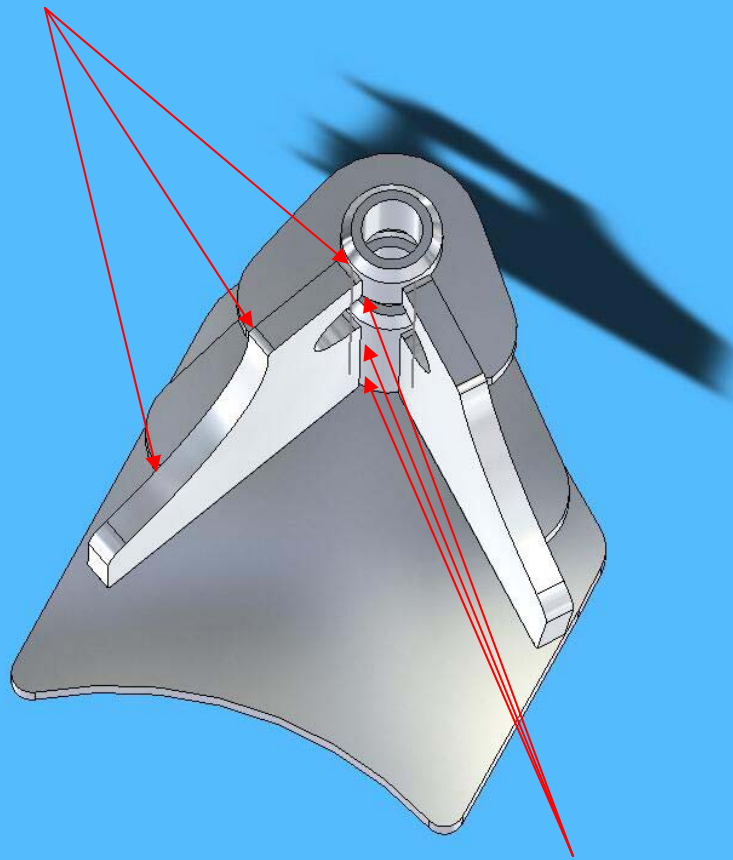
Slide an old heim onto the bolt. The heat from welding will ruin this heim, so either use an old one, make a spacer, or just waste the 30 bucks and use the same one for all the arms. Once you have the heim on, put the small tube over the bolt and the small triangle over top of the small tube. Put your nut on the threaded end of the bolt and snug it up tight enough to not let anything move. You don't need 100 ftlbs, but don't leave it loose.



You have 2 vertical pieces. If you set them side by side you will see one of them tapers to a smaller height on one side than the other. You want to start with the taller of the 2. Make sure it is perpendicular to the tube, and flush with the base plate. Tack it in a few places to both of the tubes, **BUT NOT TO THE BASE PLATE OR TRIANGLES**. It should look just like the picture on the right. Tack spots are in red.



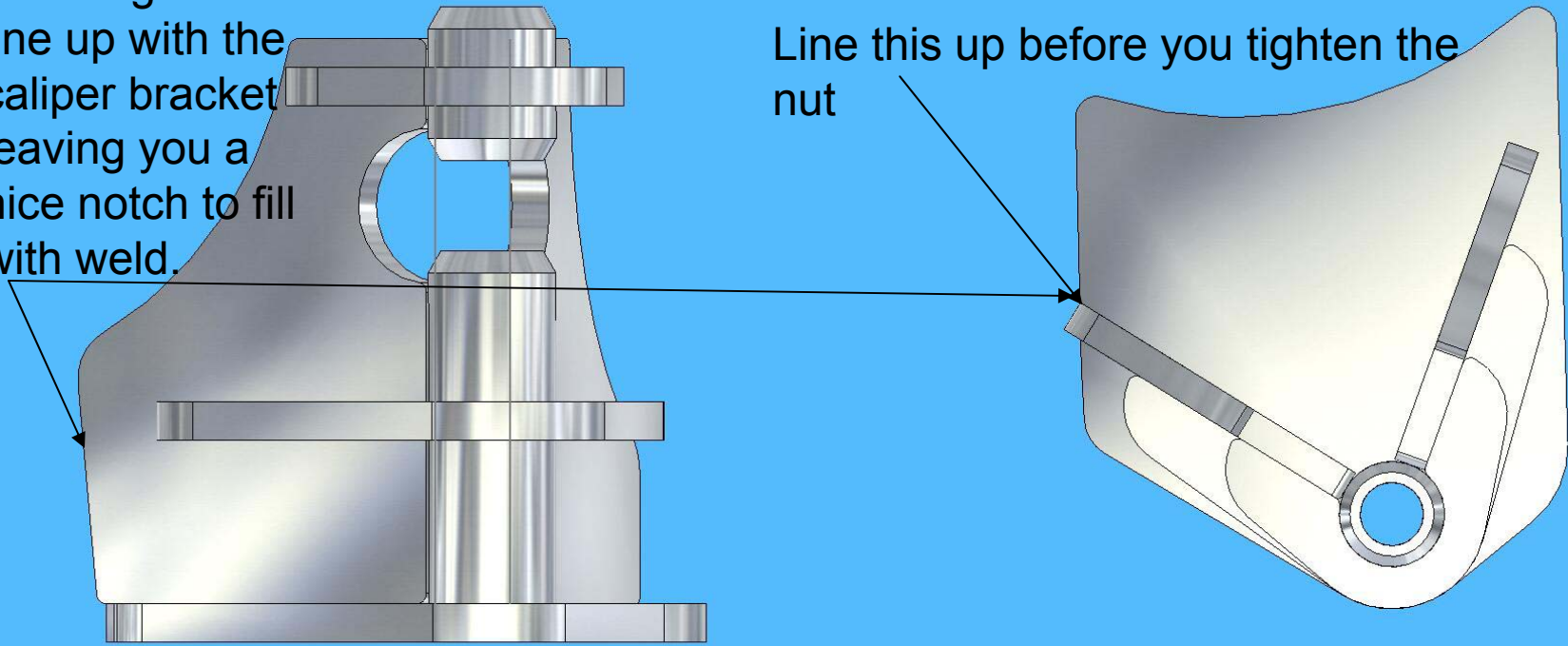
Start with the lower triangle. Twist it over until its face is flush with the face on the vertical piece. Center it up height wise so it is in the middle of the flat section of tube or at least close. Try to keep it horizontal to the base. Tack it to the vertical piece as well as to the tube. Do the same thing with the upper triangle.



Loosen the bolt a half turn or so. Just enough to twist the pieces you have tacked together. Turn it so the triangles are completely over top of the base plate. Don't worry about getting them lined up anywhere special yet. As long as they are over the base plate like the picture you are good. Tighten the nut back up. Get your other vertical piece and get it in like the picture. Tangent and flush to the tubes, flush to the base plate, and you now use the triangles to set where it goes... Tack it to the tubes and triangles. NOT THE BASE YET.

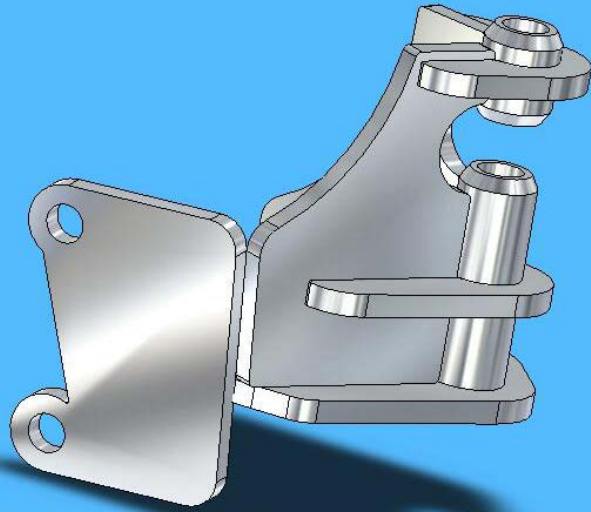
This edge should line up with the caliper bracket leaving you a nice notch to fill with weld.

Line this up before you tighten the nut



Bolt the caliper bracket onto the portal. Loosen the nut a half turn again. Twist the tube/triangle assembly until you get the edge of the vertical perfectly lined up with the edge of the base plate. Tighten the nut again. Before you tack anything, go over to the axle, and set the base plate on top of the steering arm. Everyone's steering arms will be heated and bent differently, so this part might not be perfect. You might need to grind a little or tweak it to make it fit right. You will take that same edge of the vertical piece you lined up with the edge of the base plate, and angle it so it lines up with the inside edge of the caliper bracket. If it looks like it will line up right, go back and tack everything to the base plate, set it back on the arm and tack it to the caliper bracket, and to the arm. Check for clearance everywhere, turn the portal, if everything looks good, weld it up.





Should look like this, if not, you did something wrong. Like I said, my arms were heated and bent some, so this fit it perfectly, If your are different, a little grinding should be all it takes...

