

41 IRS Assembly

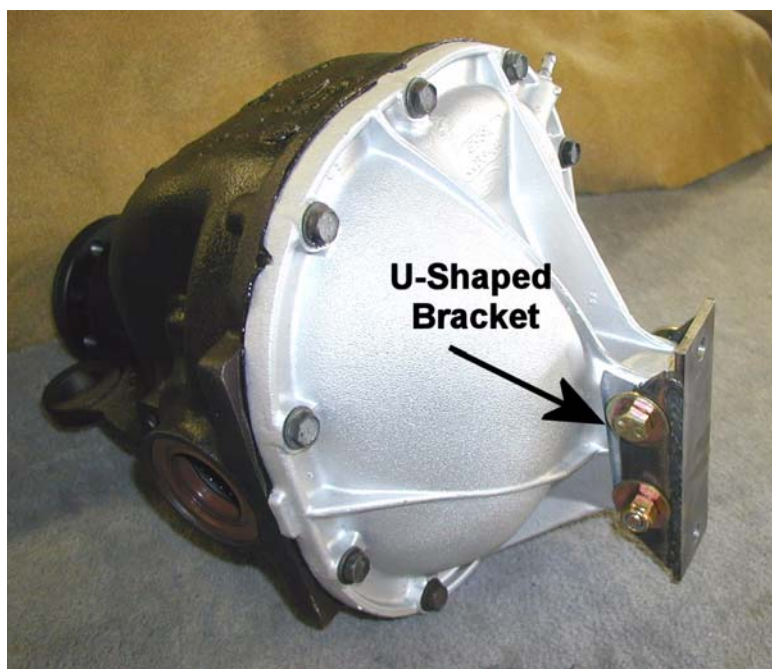
Tools	Parts	Fasteners



41.1 IRS Assembly

Steps:

1. First step is to set main IRS cradle on a flat stable surface so it can be easily moved around.
2. Locate the "U" shaped bracket which is used for the rear mount of the pumpkin.



3. Then locate the 2 two piece mounting bushings for the mounts at the front of the pumpkin and install them into the 2 holes located at the front of the casting. The pumpkin will need to come up thru the bottom of the cradle and locate above the lower cradle support. (There is a cutout in the cradle to clear the pinion flange).



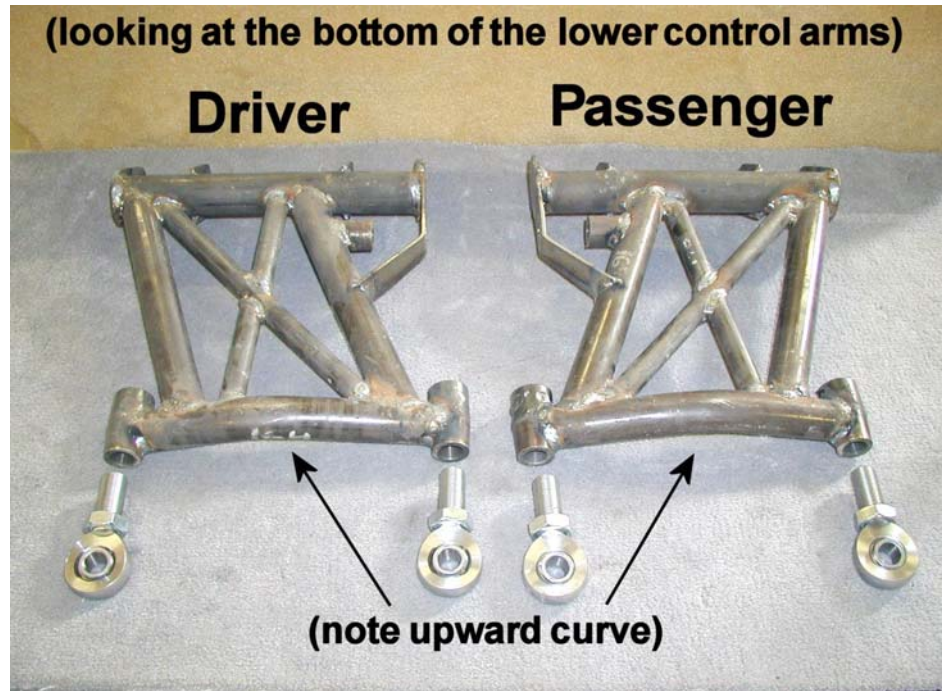
4. Install the 2 long 3/8" X 6" mounting bolts, washers, and nuts into front mounts as shown.



5. Now install the rear "U" shaped mounting bracket onto the differential cover and fasten with 3/8"x2 1/2" bolts.
6. Then fasten bracket to cradle with 3/8"x2 1/2" bolts. Loctite and torque all fasteners to 50 ft/lbs.



7. Locate left and right lower control arms and lay them out accordingly. **Note:** each lower control arm is curved on the side closest to the differential. The arc needs to go towards the bottom to allow for the travel of the C.V. shaft.
8. Install a jamb nut on all 4 of the large heim joints and install them into the control arms. (Don't forget the anti seize).



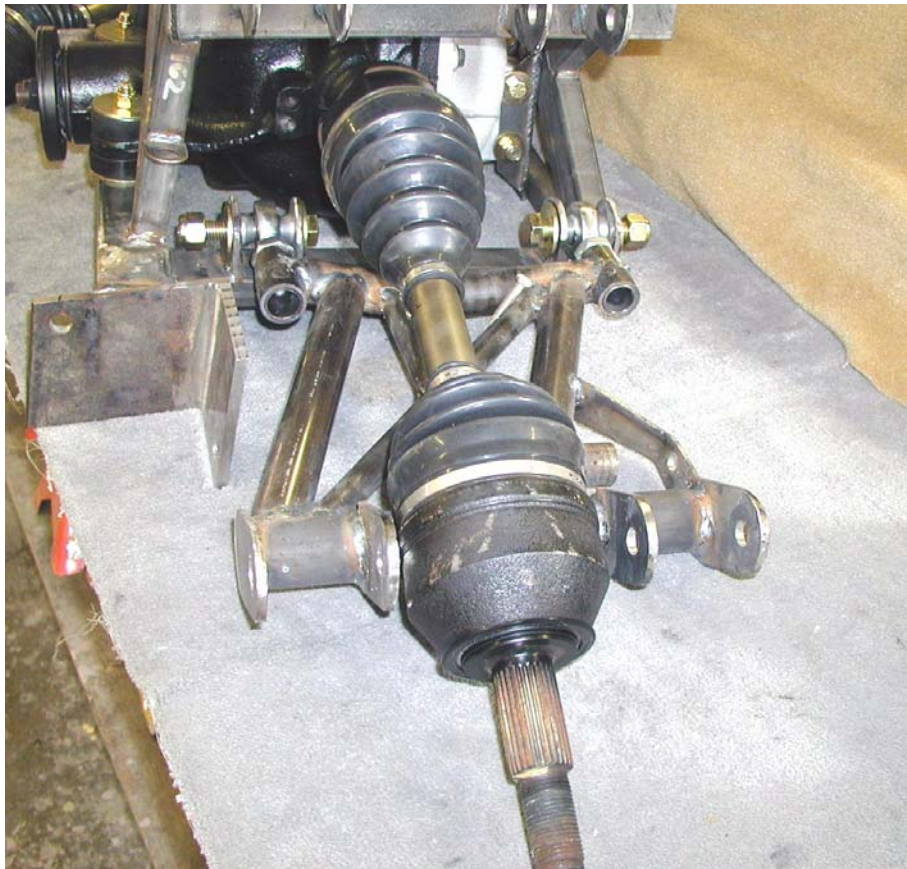
9. Bottom out the heim joints and then loosen them exactly 5 turns. This will give you preliminary alignment.
10. Lock the jamb nuts.



11. Install the control arms onto the lower mounts of the cradle using two of the cone shaped spacers on each of the four 5/8" X 3 1/2" mounting bolts. Loctite and torque.



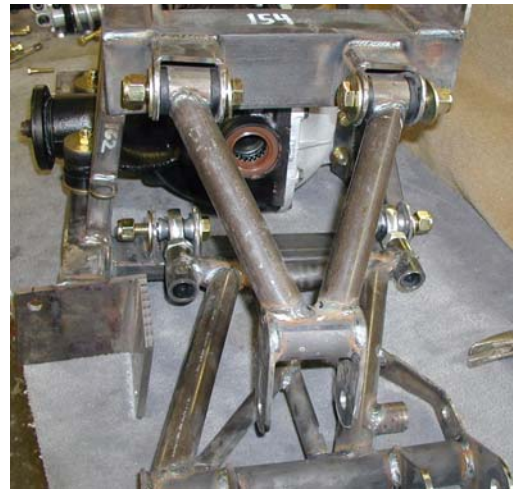
12. Install the C.V. shafts into the pumpkin until they click into place. They are identical left and right.



13. Locate the upper control arms. They are the same left to right. The arms must be installed so they form a "V" shape when upright.

14. Install the 8 urethane upper pivot bushing halves and four 1 7/8 length bushing inserts into the arms.

15. Install the arms onto the upper mounts of the cradle using 9/16" X bolts. Loctite and torque.



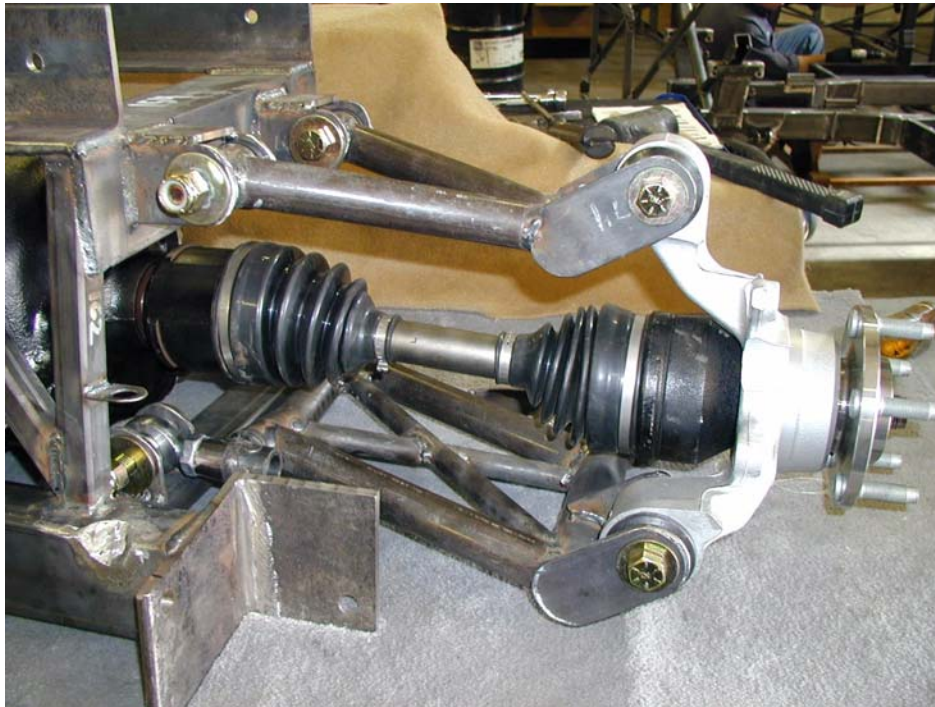
16. Locate the spindle assemblies at their respective sides. **The caliper mounting tabs will be towards the front of the vehicle. This will be opposite of what the casting on the spindles say.**

17. Slide a spindle onto C.V shaft and install mounting bolts thru all 3 control arm bushing holes. Loctite nuts and torque.

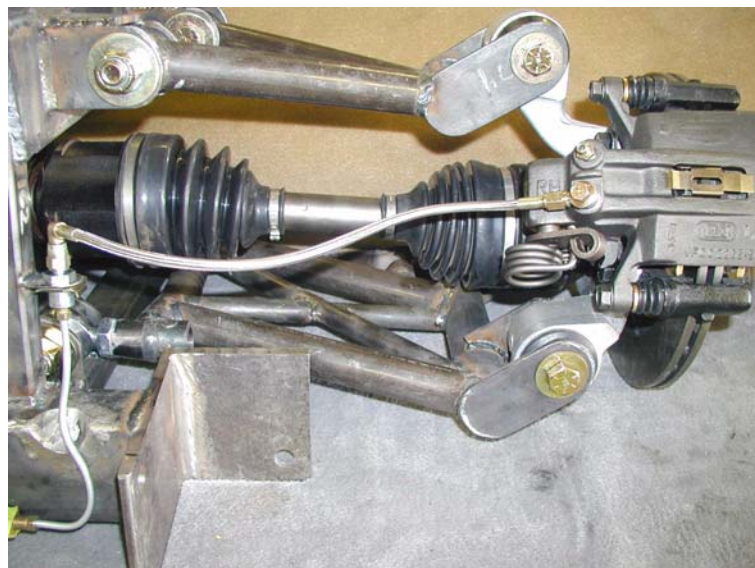
18. Repeat on opposite side.

19. Install new spindle nuts loosely onto C.V. shaft ends. These need to be torqued to 250 ft lbs! This will be difficult until cradle is installed in vehicle. **NOTE: IF YOU DECIDE TO DO THIS STEP LATER, IT IS IMPERATIVE IT IS NOT FORGOTTEN.**

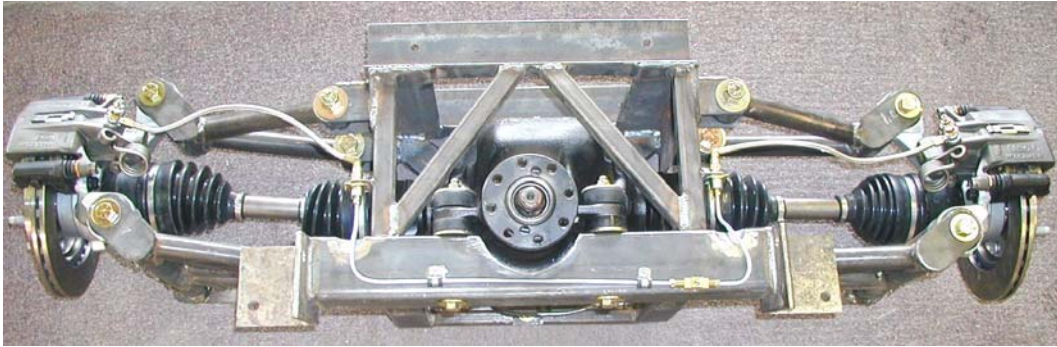




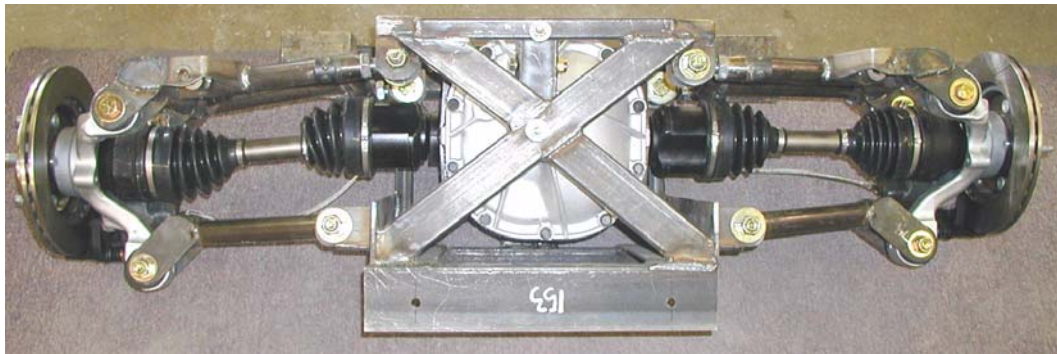
20. Install brake rotors and caliper mounting brackets.
21. Install brake shoes and calipers into brackets.
22. Don't forget the spindles have been switched, so install the calipers accordingly. Just remember the bleeder screws go UP.
23. Install Brake lines and fittings as shown.
24. Re-check that all fasteners are tight.



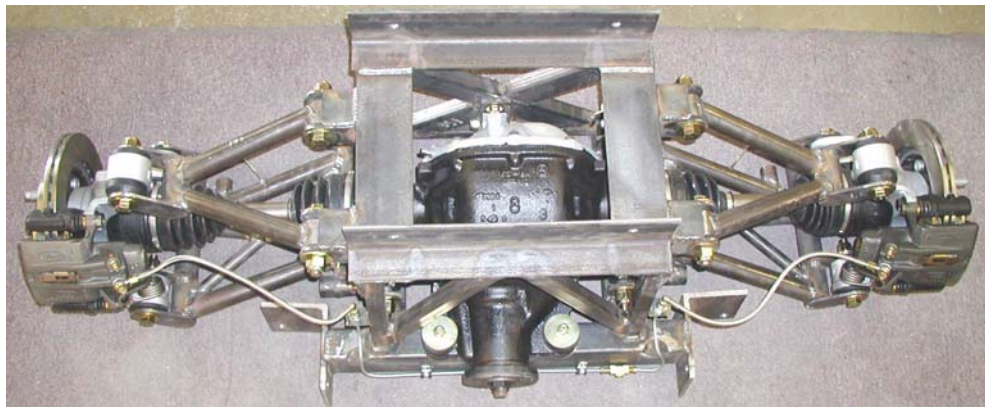
25. IRS Front View Assembled



26. IRS Rear View Assembled



27. IRS Top View Assembled



28. IRS Bottom View Assembled

