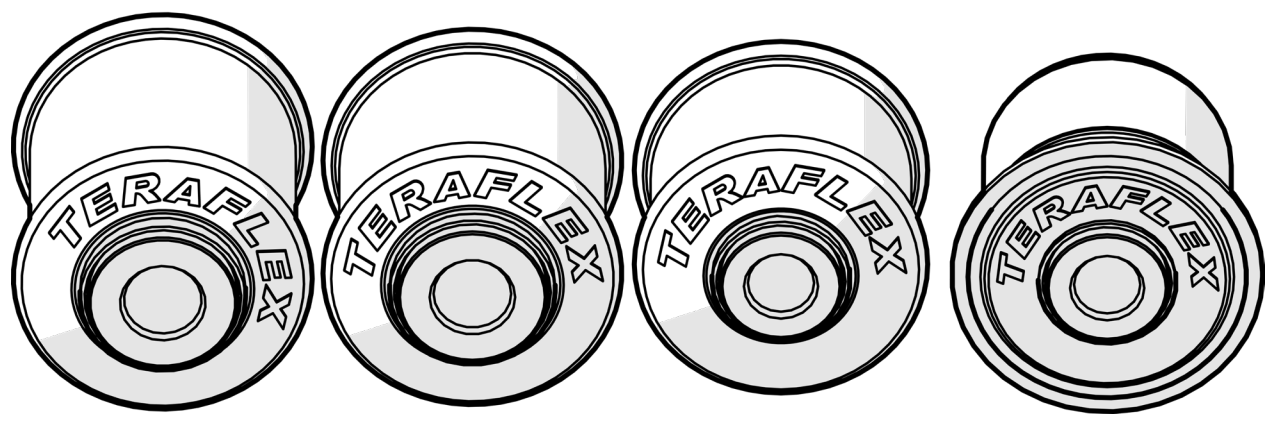
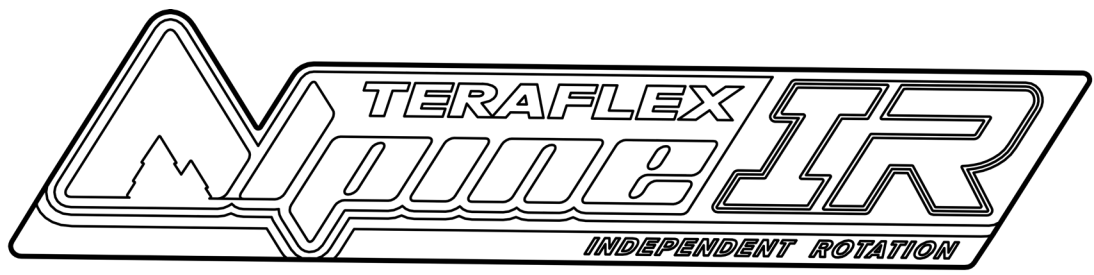




IR Bushing Replacement

www.TERAFLEX.com

- # 1952700
- # 1952701
- # 1952800
- # 1952801



Important Notes:

Prior to beginning this install, or any installation, read the instructions thoroughly to familiarize yourself with the required steps. Evaluate if you are experienced and capable to personally perform these modifications. A factory service manual should be used in conjunction with these installation instructions.

This product will change the highway handling characteristics of your vehicle, exercise caution. After altering the suspension it is always advisable to have an alignment done by a competent 4 wheel drive shop or by an alignment shop that is experienced with lifted 4 wheel drive vehicles.

Refer to the parts list to ensure that all necessary components and hardware has been included. If any parts are missing please contact your local TeraFlex dealer for assistance.

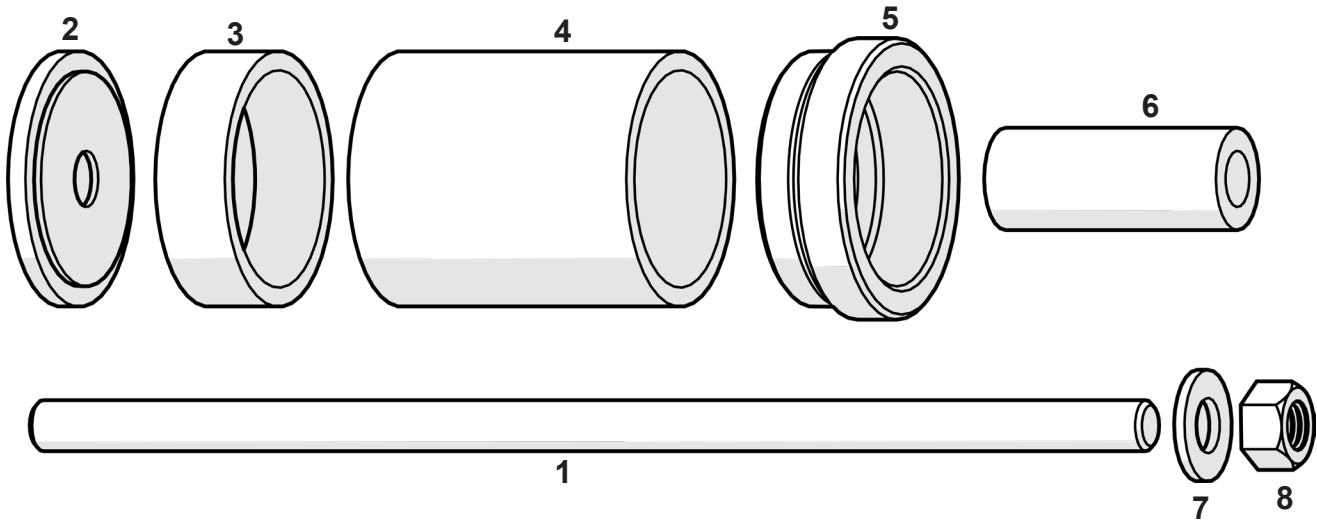
When reinstalling OEM hardware, refer to the torque specs given in the Factory Service Manual.

Tools Needed:

- Metric Sockets and Open End Wrenches
- Torque Wrench
- Mineral or PAG oil
- Factory Service Manual
- General Mechanics Tools

Maintenance Note:

After the first 300 miles and every 3,000 miles after that, re-torque all the suspension components and bolts.

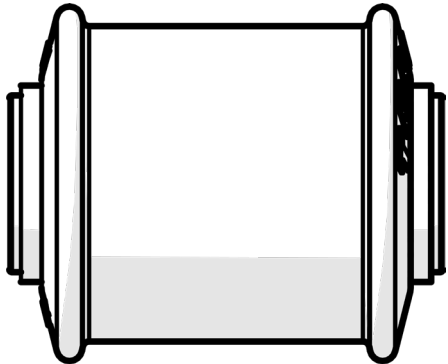


Item #	Part No.	Description	QTY
1	98-13-02-005	IR Bushing Replacement, 10" 1/2-13 UNC-2A All Thread	1
2	98-13-02-007	IR Bushing Replacement, Release Tube / Backing Plate Assembly	1
3	98-13-02-003	IR Bushing Replacement, Bushing Release Tube	1
4	98-13-02-003-1	IR Bushing Replacement, 3" Bushing Release Tube, Removal	1
5	98-13-01-001	Control Arm Bushing Tapered Cup	1
6	98-13-02-004	IR Bushing Replacement, 2.5" Press Spacer	1
7	37	Washer 1/2" Flat Zinc Plated	2
8	32	Nut 1/2"-13 UNC Zinc Plated	2

REPLACEMENT OF THE CONTROL ARM BUSHINGS IS BEST DONE WITH ALL 4 TIRES OF THE JEEP ON THE GROUND. IF YOU PREFER TO RAISE THE JEEP FOR INSTALLATION REFER TO YOUR FACTORY SERVICE MANUAL FOR SAFE LIFTING LOCATIONS AND PROCEDURES.

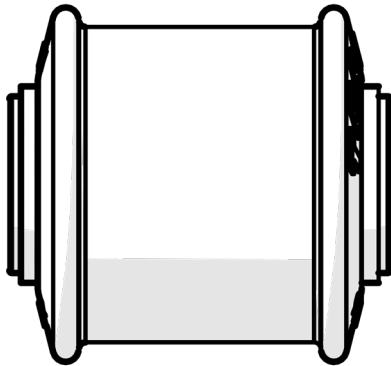
NOTE: DO NOT REMOVE MORE THAN ONE CONTROL ARM AT A TIME

JK MODELS



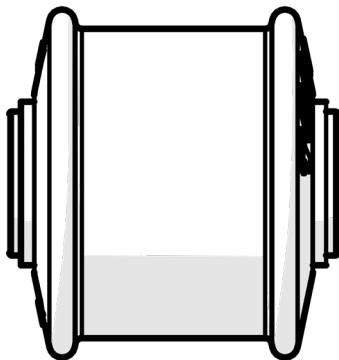
611015 x 8

- Large Revolver Rubber Bushing, Lower Control Arms, Complete Assembly
- REPLACES ALL LOWER CONTROL ARM BUSHINGS



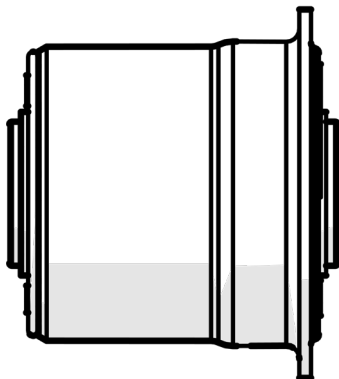
611016 x 4

- Medium Revolver Rubber Bushing, Rear Upper Arms, Complete Assembly
- REPLACES ALL REAR UPPER CONTROL ARM BUSHINGS



611017 x 2 (LONG ARM- 611019 x 2)

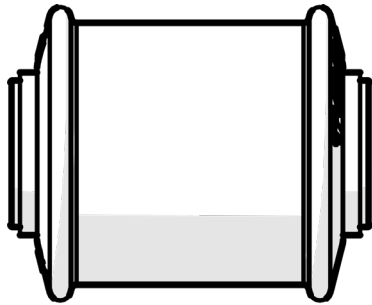
- Small Revolver Rubber Bushing, Front Upper Arms Frame Side, Complete Assembly
- REPLACES FRONT UPPER CONTROL ARM BUSHINGS AT THE FRAME



611018 x 2

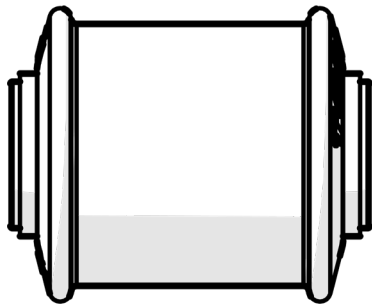
- Small Revolver Rubber Bushing, Front Upper Arms Axle Side, Complete Assembly
- REPLACES FRONT UPPER CONTROL ARM BUSHINGS AT THE AXLE

JL MODELS



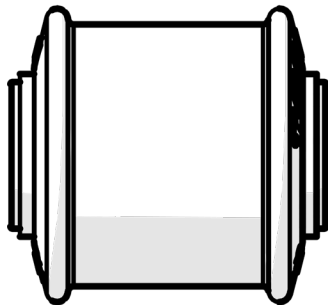
611020 x 4

- Large Revolver Rubber Bushing, Lower Control Arms, Complete Assembly, 16mm ID
- **REPLACES ALL FRONT LOWER CONTROL ARM BUSHINGS**



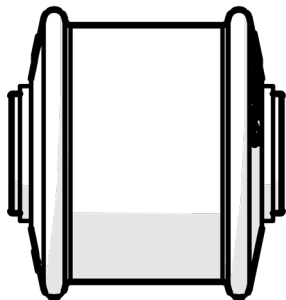
611015 x 4

- Large Revolver Rubber Bushing, Lower Control Arms, Complete Assembly
- **REPLACES ALL REAR LOWER CONTROL ARM BUSHINGS**



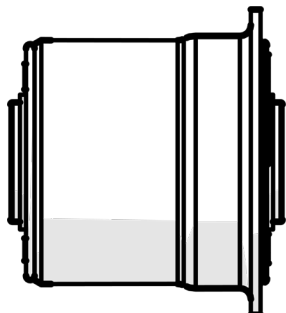
611016 x 4

- Medium Revolver Rubber Bushing, Rear Upper Arms, Complete Assembly
- **REPLACES ALL REAR UPPER CONTROL ARM BUSHINGS**



611017 x 2

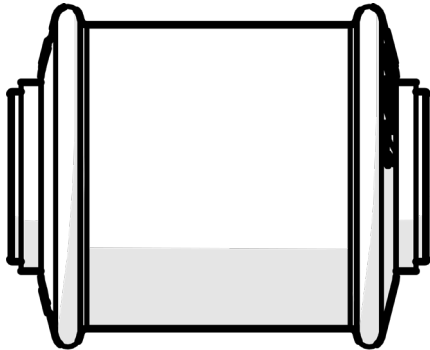
- Small Revolver Rubber Bushing, Front Upper Arms Frame Side, Complete Assembly
- **REPLACES FRONT UPPER CONTROL ARM BUSHINGS AT THE FRAME**



611018 x 2

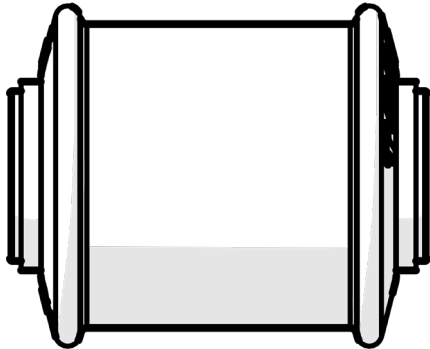
- Small Revolver Rubber Bushing, Front Upper Arms Axle Side, Complete Assembly
- **REPLACES FRONT UPPER CONTROL ARM BUSHINGS AT THE AXLE**

JL MODELS (LONG ARM)



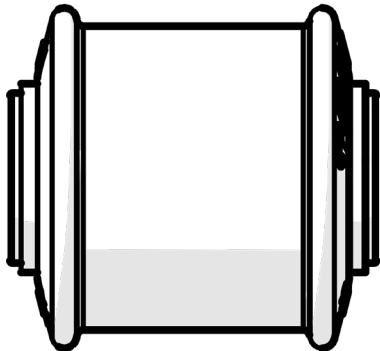
611020 x 4

- Large Revolver Rubber Bushing, Lower Control Arms, Complete Assembly, 16mm ID
- **REPLACES ALL FRONT LOWER CONTROL ARM BUSHINGS**



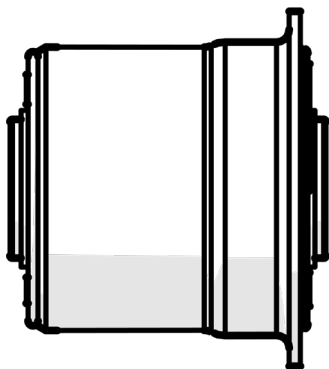
611015 x 6

- Large Revolver Rubber Bushing, Lower Control Arms, Complete Assembly
- **REPLACES ALL REAR LOWER CONTROL ARM BUSHINGS AND REAR UPPER CONTROL ARM BUSHINGS AT THE FRAME**



611016 x 4

- Medium Revolver Rubber Bushing, Rear Upper Arms, Complete Assembly
- **REPLACES REAR UPPER CONTROL ARM BUSHINGS AT THE AXLE AND FRONT UPPER CONTROL ARM BUSHINGS AT THE FRAME**

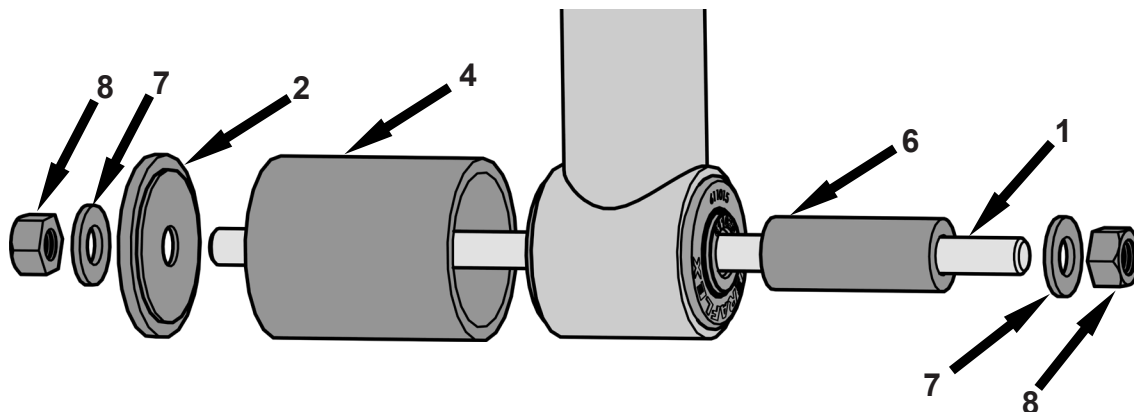


611018 x 2

- Small Revolver Rubber Bushing, Front Upper Arms Axle Side, Complete Assembly
- **REPLACES FRONT UPPER CONTROL ARM BUSHINGS AT THE AXLE**

CONTROL ARM BUSHING REMOVAL / INSTALL

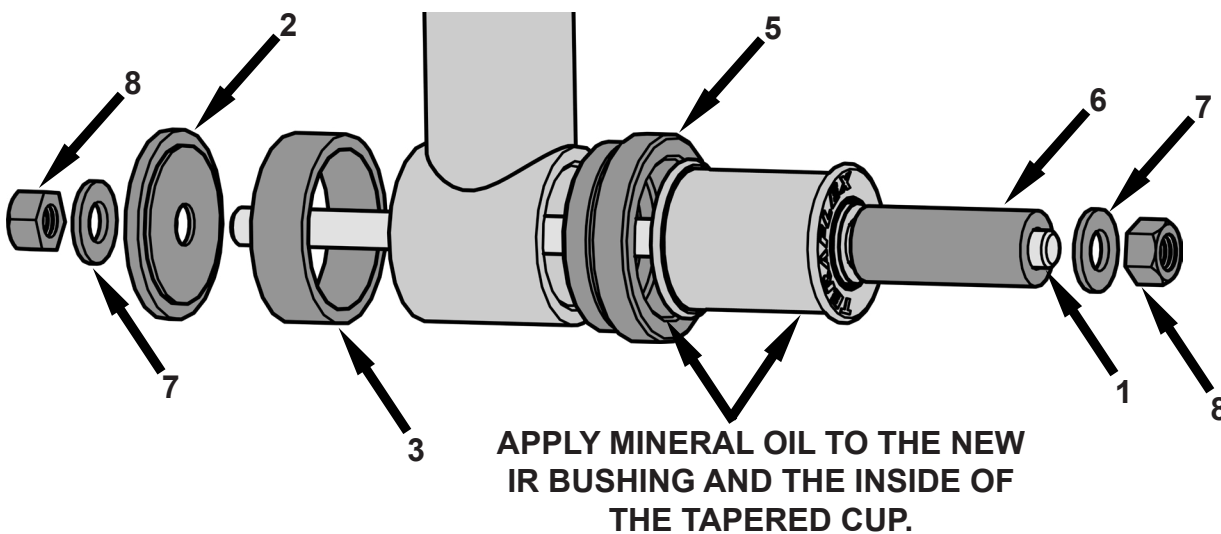
REMOVE ONE OF THE CONTROL ARMS FROM THE JEEP
 REFER TO PAGE 8 FOR NUT AND BOLT SIZES
 INSTALL THE BUSHING REPLACEMENT TOOL ONTO THE CONTROL ARM AS
 SHOWN BELOW



1 USING A 19mm SOCKET AND WRENCH TIGHTEN THE ASSEMBLY
 UNTIL THE BUSHING IS REMOVED FROM THE CONTROL ARM

APPLY MINERAL OIL TO THE NEW IR BUSHING AND INSTALL INTO THE CONTROL ARM
 USING THE BUSHING REPLACEMENT TOOL AS SHOWN BELOW

**WARNING: DO NOT USE ANY PETROLEUM BASED LUBRICANTS TO
 INSTALL THE NEW IR BUSHING**



APPLY MINERAL OIL TO THE NEW
 IR BUSHING AND THE INSIDE OF
 THE TAPERED CUP.

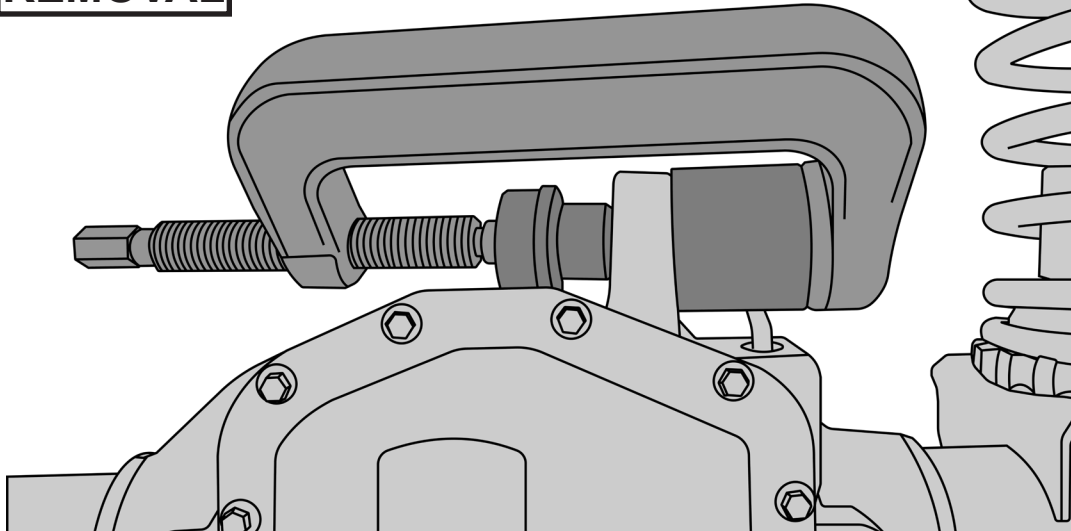
2 USING A 19mm SOCKET AND WRENCH TIGHTEN THE ASSEMBLY
 UNTIL THE BUSHING IS INSTALLED INTO THE CONTROL ARM

AXLE BUSHING REMOVAL / INSTALL

USE A BALL JOINT PRESS TOOL TO REMOVE OLD BUSHING AND INSTALL THE NEW IR BUSHING

DISCONNECT THE AXLE BREATHER HOSE AND ANY ELECTRICAL WIRES IN THAT ARE IN THE WAY

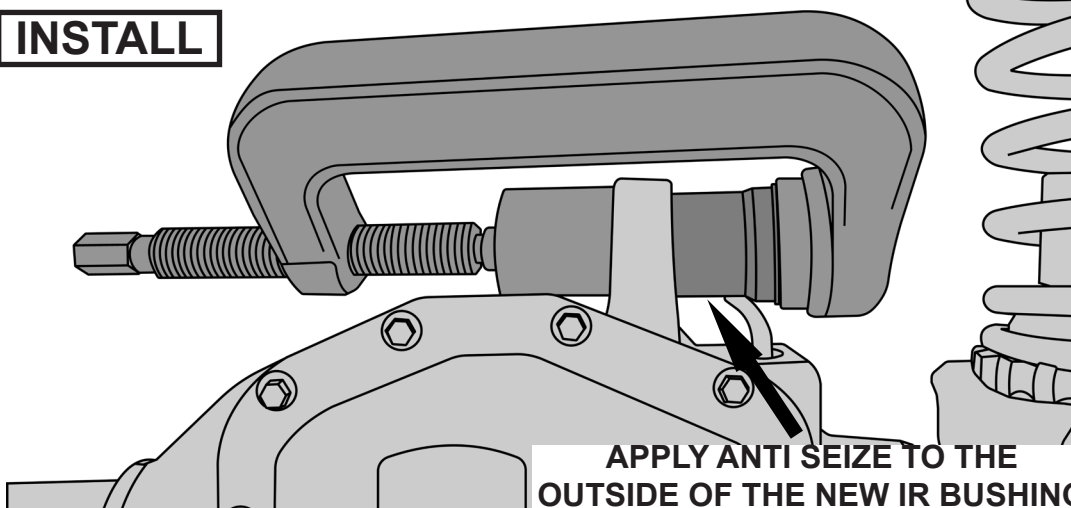
REMOVAL



1

PRESS THE BUSHING INTO THE AXLE UNTIL FULLY SEATED

INSTALL

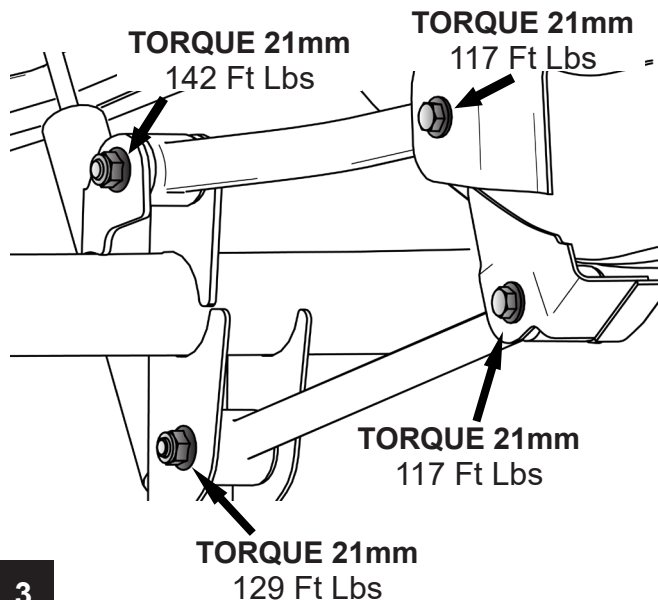


APPLY ANTI SEIZE TO THE
OUTSIDE OF THE NEW IR BUSHING

2

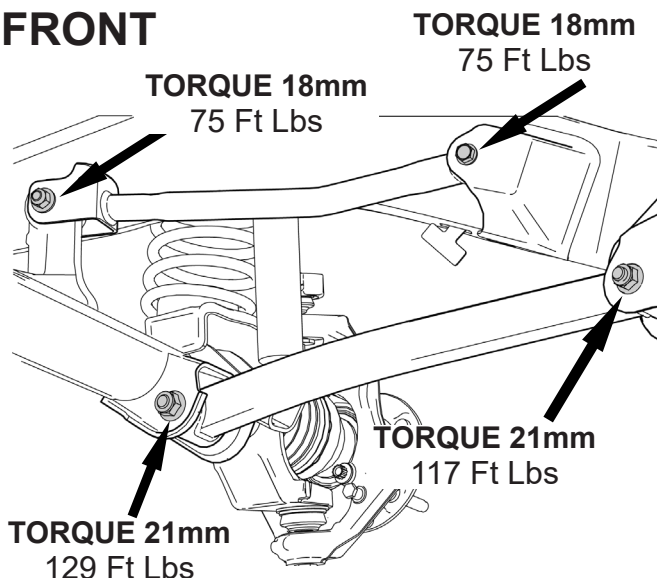
JK MODELS CONTROL ARM TORQUE SPECS

REAR



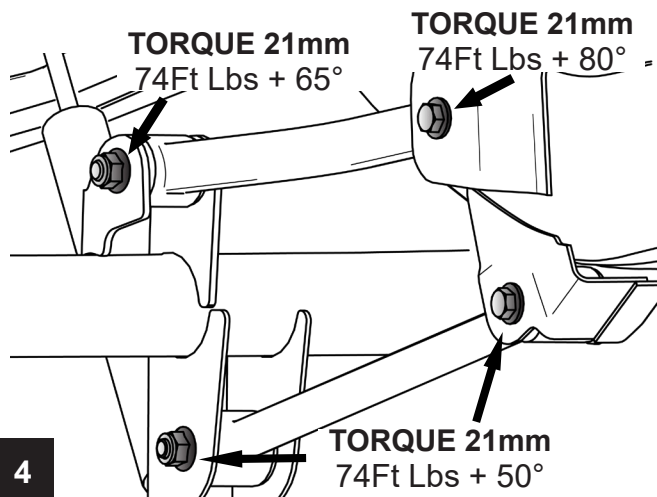
3

FRONT



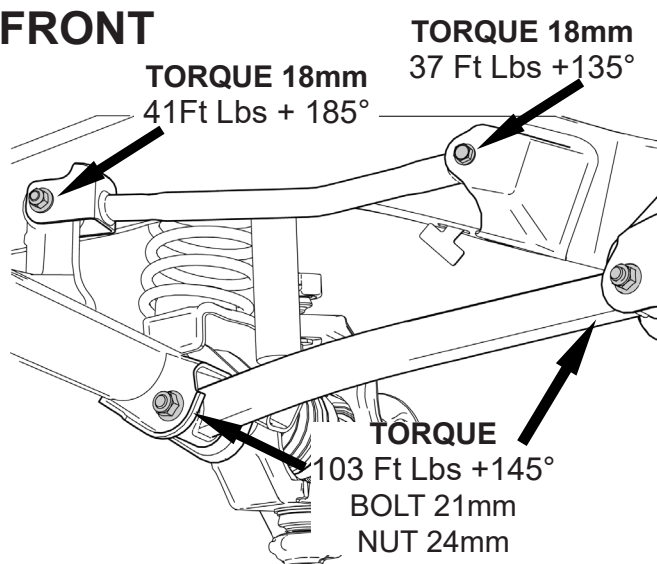
JL MODELS CONTROL ARM TORQUE SPECS

REAR



4

FRONT



TERAFLEX

PRODUCT INFORMATION

MAINTENANCE INFORMATION:

It is the buyer's responsibility to have all suspension, drivetrain, steering, and other components checked for proper tightness and torque after the first 100 miles and every 3000 miles after that.

NOTICE TO INSTALLER:

The enclosed "Warning to Driver" sticker must be installed in the vehicle in driver's view. This sticker is to act as a constant safety reminder when operating the vehicle. It is your responsibility as the equipment installer to install the provided sticker and to forward the product instructions to the vehicle's owner for review. If a "Warning to Driver" sticker or product installation guide were not included in the kit, FREE replacement stickers and instructions are available by request. It is the installer's duty to ensure a safe and controllable vehicle after the modifications have been performed.

WARNING:

Neither the seller nor the manufacturer will be liable for any loss, damage, or injury directly or indirectly arising from the use of or inability to determine the use of these products. Before using, the user shall determine the suitability of the products for its intended use, and the user shall assume all responsibility and risk in connection therewith.

WARNING TO DRIVER:

This vehicle has been modified to enhance off road performance and has unique handling characteristics. Use in harsh environments can cause extreme stress on the components. Vehicle should be inspected after being off road to make sure that all the components are in working order and safe to travel on the highway. All fasteners should be checked so that they are at the correct torque specifications as the vibration and stresses from off roading may cause critical fasteners to work loose. Extra care should be taken to inspect the critical components, steering, and brake systems. During each oil change components such as arms, tie rod ends, etc should be greased and checked for excessive wear. Any worn components should be replaced. When returning to the pavement always set or restore tire air pressure to the factory recommendation and connect or engage any disabled sway bar mechanisms. Because of the higher center of gravity and larger tires, this vehicle handles and reacts differently than many passenger cars, both on and off road. You must drive it safely! Extreme care should be taken to prevent vehicle rollover or loss of control, which can result in serious injury or death. Avoid sudden sharp turns or abrupt maneuvers. Generally, braking performance and capabilities are decreased when significantly larger/heavier tires are used, especially when used in combination with transfer case low-range reduction kits. Take this into consideration while driving. Do not add, alter or fabricate any factory or aftermarket parts to increase vehicle height over the intended height of the TeraFlex product purchased. Mixing component brand is not recommended. TeraFlex Inc. will not be responsible for any altered product or any improper installation or use of our products. We will be happy to answer any questions concerning the design, function, and correct use of our products. It is ultimately the buyer's responsibility to have all bolts/nuts checked for tightness after the first 100 miles and then every 3000 miles. Wheel alignment, steering system, suspension and drive line systems must be inspected by a qualified professional mechanic at least every 3000 miles.

TERAFLEX PRODUCT WARRANTY:

TeraFlex Inc. warrants TeraFlex Suspension products to the original retail purchaser to be free of defects in material and workmanship for as long as the original purchaser owns the vehicle on which products were originally installed.

Failure to complete regular maintenance (grease every 3000 miles) on TeraFlex FlexArms will void this warranty. All other conditions of the standard TeraFlex product warranty apply.

All TeraLow products are covered by the TeraFlex two (2) year warranty to be free of defects in material and workmanship for two years from date purchased.

TeraFlex axles are covered by a 12-month warranty to be free of defects in materials and workmanship.

This warranty does not cover or include product finish, improperly installed or applied products, improperly maintained products, products or components used for racing or competition or damage due to abuse or neglect, products that fail due to the use of larger tire and wheel combinations.

All returns must be accompanied by an original invoice. It is the customer's responsibility to remove the product from the vehicle. Shipping charges are the responsibility of the customer. TeraFlex Inc. will pay the return freight if the product meets the terms of warranty.

This warranty is for the replacement or repair of defective TeraFlex products only and does not include freight charges, labor charges for removal of or installation of TeraFlex or related products or components, costs incurred due to down time of the vehicle, or lost profits due to vehicle down time.

A returned goods authorization number (RGA#) must accompany any returned products. For more information please contact a TeraFlex customer service representative.

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