



EVO-1006 C2 Axle Gusset Kit, JK



	QTY	PART#	DESCRIPTION
□	2	EVO-10020	Upper Knuckle Gusset
□	2	EVO-10021	Lower Knuckle Gusset

Caution: This kit requires welding. Welding creates a very bright arc that should not be looked at without an approved protective shield/clothing. Welded surfaces and areas in their vicinity will be very hot for a long period of time after welding. Please use caution. All welding should be performed by a professional.

1. Elevate front of vehicle securely by frame, fully extend suspension.
2. Remove front wheels.
3. It is highly recommended that the ball joints on the both top and bottom of the Axle C's on both sides of the axle be removed with the recommended Jeep ball joint puller. See service manual for instructions.
4. Place C2 Axle Gussets on top and bottom of driver side axle by hand. Mark axle with paint pen/marker where all surfaces are to be welded.
5. Remove C2's and repeat step 3 on Passenger side.
6. Clean all surfaces of paint/coating around the marks made in step's 3 and 4 with a wire wheel or sanding disk.
7. Place Upper Gussets in place on both driver and passenger side. Make sure that C2's seat fully against spring perch. Tap with rubber mallet if required.
8. Verify that all coating/paint is cleaned from all areas to be welded.
9. Tack both driver and passenger C2's in place.
10. Weld gussets in no more than 1 inch increments alternating from driver to passenger sides after every increment. After welding each increment before alternating to the opposite side, cool welded surface.
11. Place lower Axle C2's in place on driver side.
12. Tack weld into place.
13. Verify that all coating/paint is cleaned from all areas to be welded.
14. Repeat steps 11-13 on passenger side.
15. Weld gussets in no more than 1 inch increments alternating from driver to passenger sides after every increment. After welding each increment before alternating to the opposite side, cool welded surface.
16. Clean all area of slag and burn off with cleaner.
17. Paint all uncoated surfaces.