



EVO Manufacturing

Jeep Wrangler JT Gladiator

JT Axle Swap Kit Instruction Manual

EVO- 3084



This instruction is to be used as a general guide of assembly on various axles. Use original axle measurements for placement of bracketry, adjust for personal application. Radius openings on bracketry are 3.5" diameter, grinding can be done to adapt to others.



Before starting installation procedure please read <http://evomfg.com>Returns-Warranties-Shipping>

CAREFULLY READ AND FOLLOW ALL INSTRUCTIONS IN THIS MANUAL AND KEEP FOR FUTURE REFERENCE. IF YOU HAVE ANY QUESTIONS ABOUT THE PRODUCT CALL EVO MANUFACTURING. FAILURE TO FOLLOW GUIDELINES COULD RESULT IN MALFUNCTION OF PARTS OR INJURY. PLEASE HAVE A TRAINED PROFESSIONAL ASSIST WITH OR INSTALL ALL PRODUCTS. INSTALLING EVO MFG PRODUCTS OR KITS DEMANDS SPECIFIC KNOWLEDGE, TOOLS AND EXPERIENCE. GENERAL KNOWLEDGE OF HOW TO USE LATER SPECIFIED TOOLS AND/OR LIMITED EXPERIENCE WITH EVO MFG PRODUCTS MAY NOT BE ENOUGH TO PROPERLY COMPLETE THESE TASKS. SOME OF EVO MFG PRODUCTS MAY REQUIRE TWO OR MORE PEOPLE TO INSTALL SAFELY AND CORRECTLY. DO NOT ATTEMPT ALONE, ALWAYS ENLIST THE HELP OF TRAINED PROFESSIONAL WHEN NEEDED.

Notes: Set Up Before installation

This is a bracket kit for builders. This kit includes builder brackets and spring perches for axle conversions. This does not include parking brake cable provisions and/or other brake provisions as these vary per various axle manufacturers/original equipment. It's the owner's responsibility to adapt brake as needed and verify proper operation.

Cutting and grinding will be necessary for this installation.

Welding of brackets will be necessary

Make sure to clean axle.

May need to use a second person to ease install.

Keep all mounting bolts loose (installed but not torqued) we will torque later at the end of complete installation

READ BEFORE INSTALL:

It is the installers responsibility to adapt brake as needed and verify/confirm their proper operation. If you are not capable of this or any other procedure involved in this builders kit, do not proceed.

It is generally a good idea to apply Loctite to all threaded bolts.

ALWAYS wear safety glasses and other approved safety gear when working on a vehicle.

All supplied bolts torqued according to chart at end of instruction.

It is recommended all installation be performed by a trained professional. Some modification may have to be done.

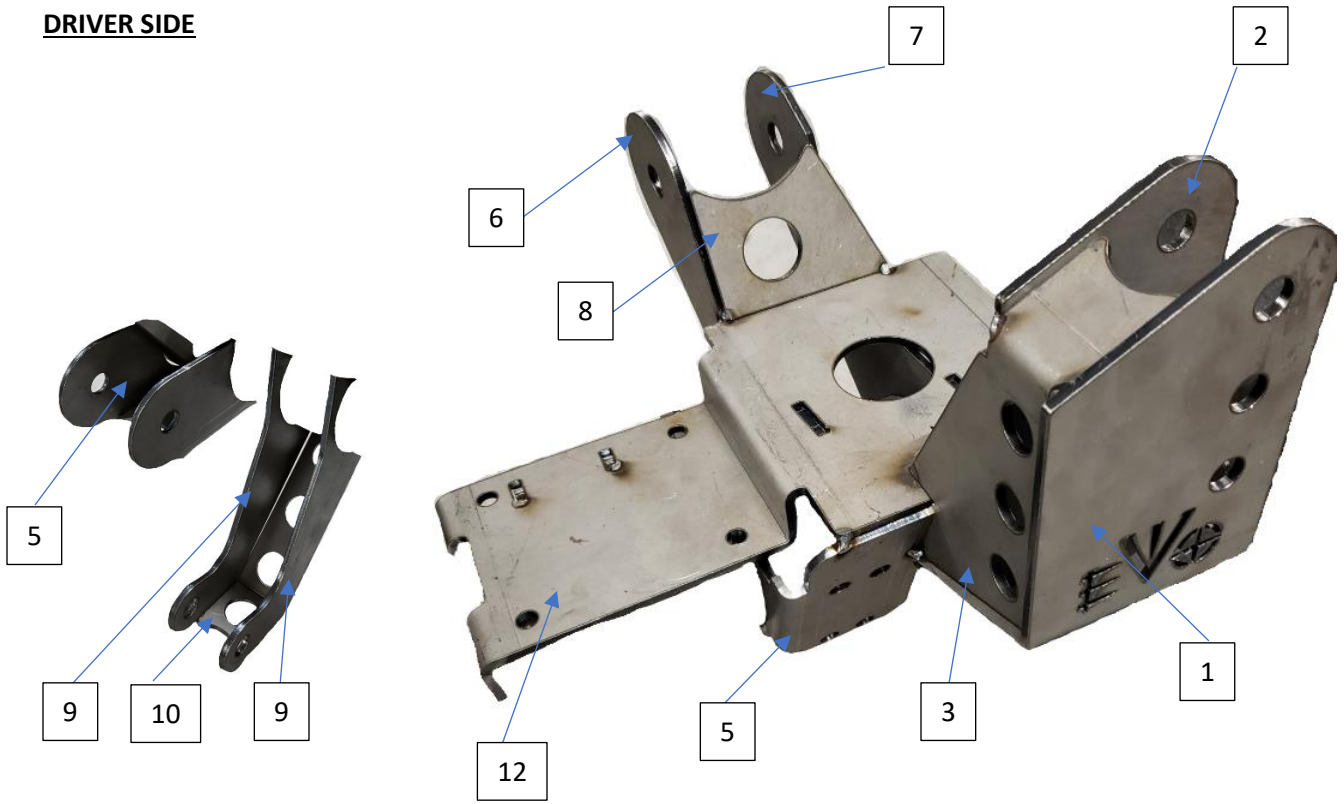
Paint all unfinished surfaces after install is complete.



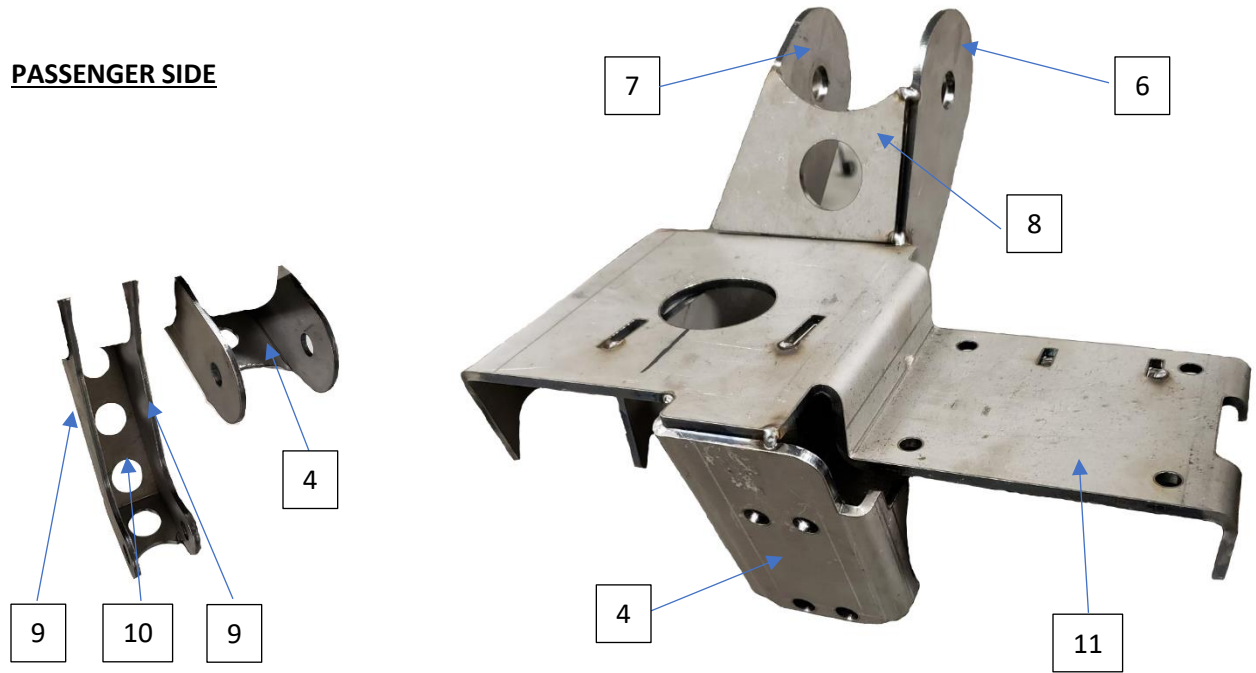
Parts included: Table below shows Rear JT Gladiator Axle Swap Kit.

Description	#	Part #	Quantity
JT Rear Axle Rear Trackbar Bracket	1	EVO-12427	1
JT Rear Axle Forward Trackbar Bracket	2	EVO-12428	1
JT Rear Axle Trackbar Left Gusset	3	EVO-12429	1
JT Rear Axle Lower Arm/Sway Mount Passenger	4	EVO-12430	1
JT Rear Axle Lower Arm/Sway Mount Driver	5	EVO-12431	1
JT Rear Axle Outer Upper Arm Mount	6	EVO-12432	2
JT Rear Axle Inner Upper Arm Mount	7	EVO-12433	2
JT Rear Axle Upper Arm Gusset	8	EVO-12434	2
JT Rear Axle Swap Shock Mount	9	EVO-12435	4
JT Rear Axle Shock Mount Bracket Plate	10	EVO-12436	2
JT Rear Axle Main Spring Bump Mount Passenger	11	EVO-12437	1
JT Rear Axle Main Spring Bump Mount Driver	12	EVO-12438	1
JT Rear Axle Conversion Spring Tube	13	EVO-12439	2

DRIVER SIDE



PASSENGER SIDE



Recommended Tools:

- C clamps
 - Welder/ materials
 - Grinder
 - Torch/Plasma Cutter
 - Measuring tools
 - Angle Finder
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Safety Steps for installation

- For installing EVO MFG products always use wheel chokes to block rear tires from rolling.
 - Always make sure you have everything necessary ready before install.
 - If you have to, carefully lift front of vehicle by front frame rails extending suspension until tires leave the ground, place frame on approved jack stands for vehicle. Verify all lines/wires are not over extended.
 - Remove tires if needed for easier install.
 - Make sure to wear safety equipment (eye protection, hand protection, foot protection etc.) at all times during installation.
 - Make sure all safety precautions have been taken.
 - Always check and replace any part of vehicle that is worn or broken before starting install.
 - Do not mix anything EVO with weaker alternatives.
 - It is generally a good idea to apply liquid threadlock to all bolts.
 - Tighten included hardware to torque specifications in bottom table unless it is otherwise specified, factory bolts should be torqued to factory Jeep specifications.
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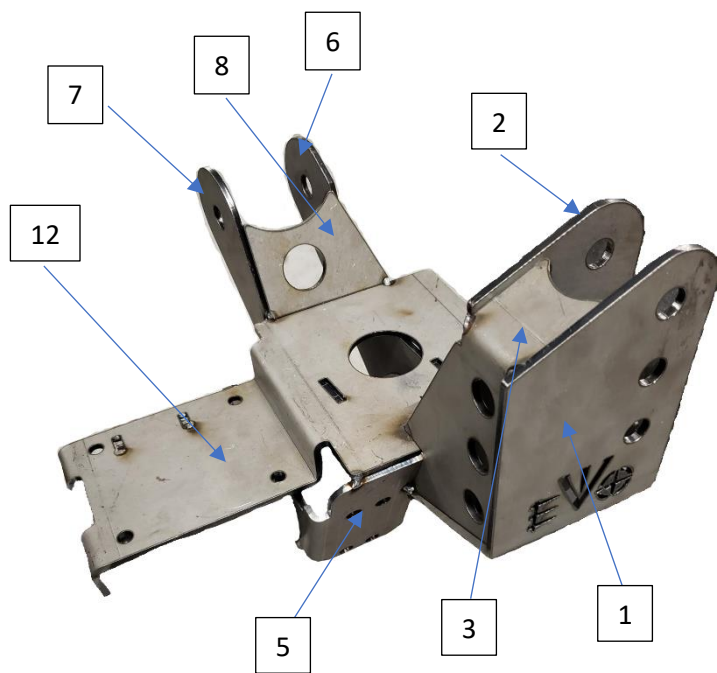


Assemble:

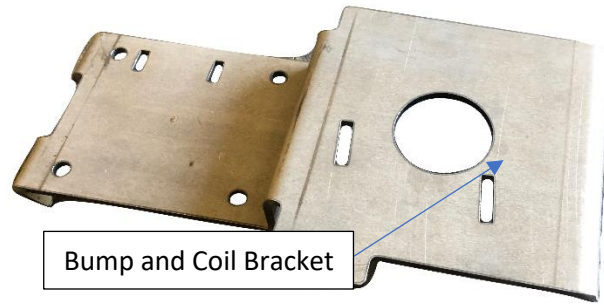
Putting left (driver) side together:

Place all brackets according to instruction steps onto prepped axle using factory geometry as a general guideline for placement.

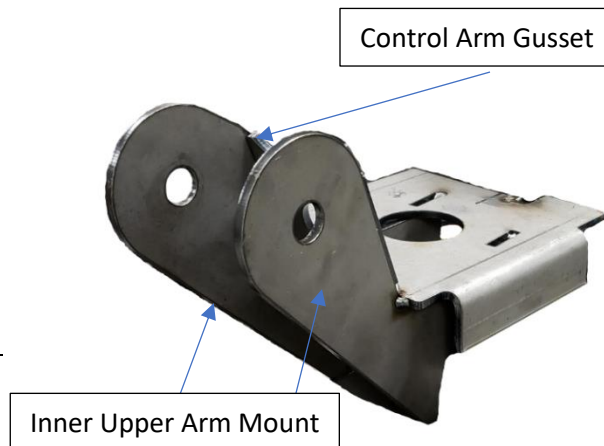
Assemble brackets together.
Reference picture/table above to make sure correct parts are fitted to the driver side bracket group. Use the following steps to assemble.



1. Start with placing the bump stop and coil spring bracket on the axle. We will connect the necessary brackets to the bump stop and coil bracket in the following steps.
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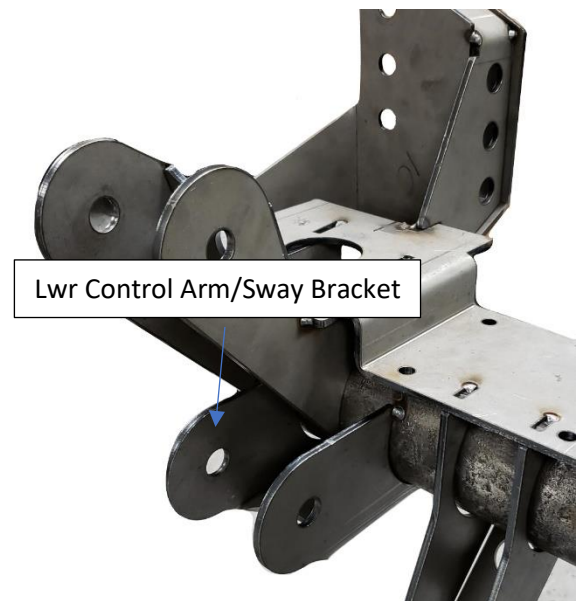
2. Now assemble the inner and outer upper arm mount onto the spring/bump stop bracket. The longer upper arm mount bracket should go on the inside and insert into the slot, the shorter bracket fit into the slot on the outside. Attach the upper arm mount gusset.
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3. Place the inner and outer shock mount plate tabs into the slots complimenting the tab. Insert the two plates into the small slots on the main spring/bump stop bracket. Then on the bottom of the two shock mount brackets attach the shock mount gusset.
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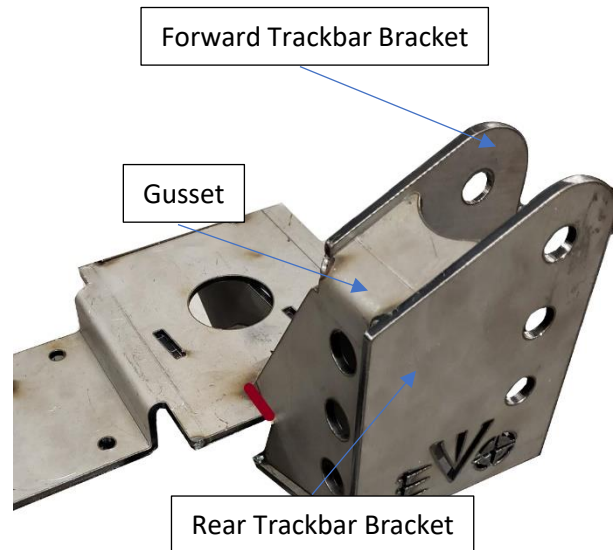


4. Take the lower control arm/sway bracket and install onto axle tube from bottom to top. You may have to pull open in order to fit around axle tube. Do not grind material. Then press back to tube diameter.
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5. Assemble the rear trackbar bracket, forward trackbar bracket and axle trackbar gusset as pictured. The forward bracket should be placed first. Then locate the gusset onto spring/bump bracket. Finally, lay rear bracket flush on the back side of the gusset.

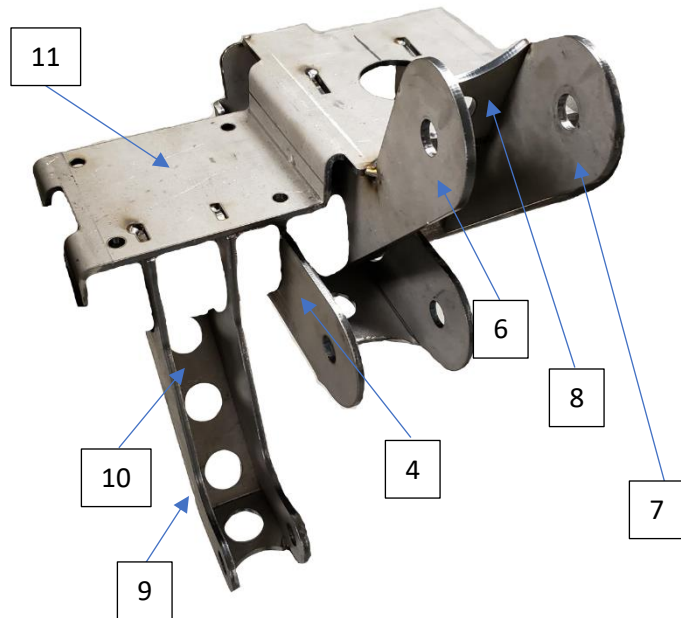
Make sure the trackbar gusset seats in a similar position to the one in the picture. Use red line in picture for reference.



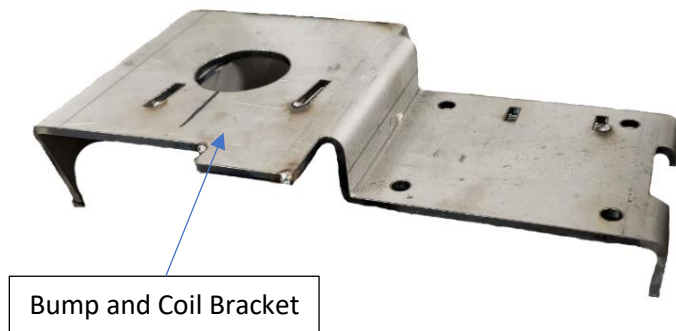
Putting left (passenger) side together:

Place all brackets according to instruction steps onto prepped axle using factory geometry as a general guideline for placement.

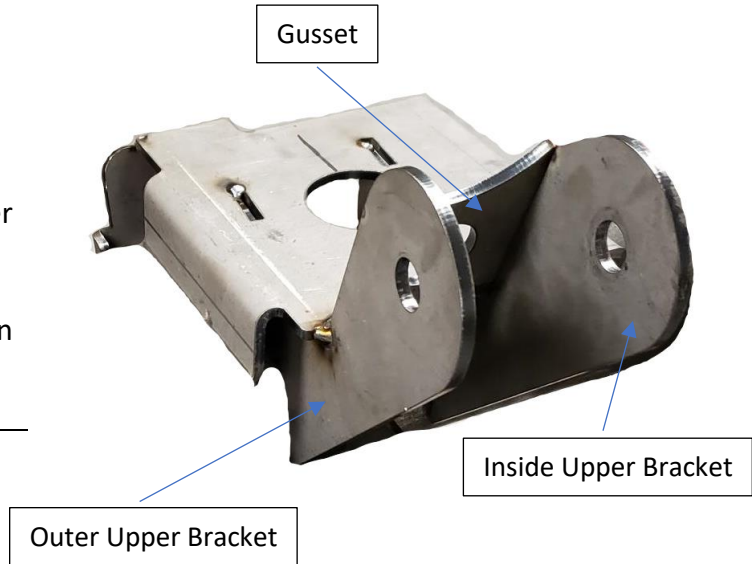
6. On a flat surface, assemble brackets together. Reference picture/table above to make sure correct parts are fitted to the passenger side bracket group.



7. Start with placing the bump stop and coil spring bracket on the axle. We will connect the necessary brackets to the bump stop and coil bracket in the following steps.



Now assemble the inner and outer upper arm mount onto the spring/bump stop bracket. The longer upper arm mount bracket should go on the inside and insert into the slot, the shorter bracket fit into the slot on the outside. Attach the upper arm mount gusset.



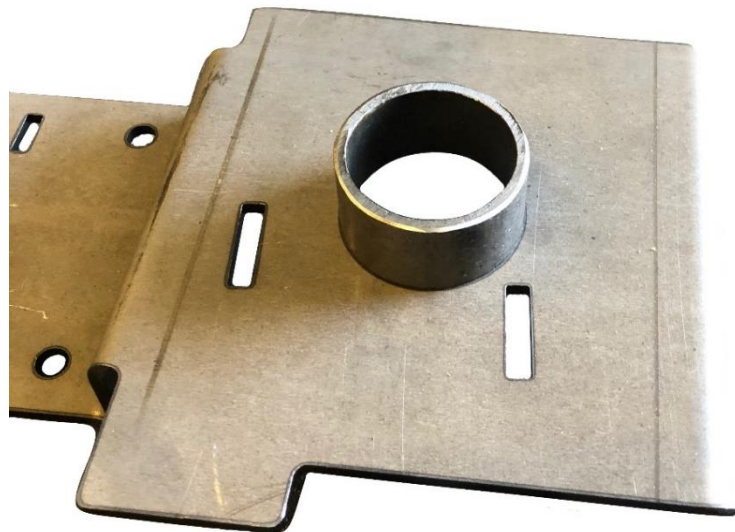
8. Place the inner and outer shock mount plate tabs into the slots complimenting the tab size. Insert the two plates into the small slots on the main spring/bump stop bracket. Then on the bottom of the two shock mount brackets attach the shock mount gusset.



9. Take the lower control arm/sway bar bracket and install onto axle tube from bottom to top. You may have to heat bracket and pull open in order to fit around axle tube. Do not grind material.
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10. Place the spring tube on top of both Bump/Spring brackets (one on each bracket). Locate the spring tube hole in bracket where spring will be placed, attach.
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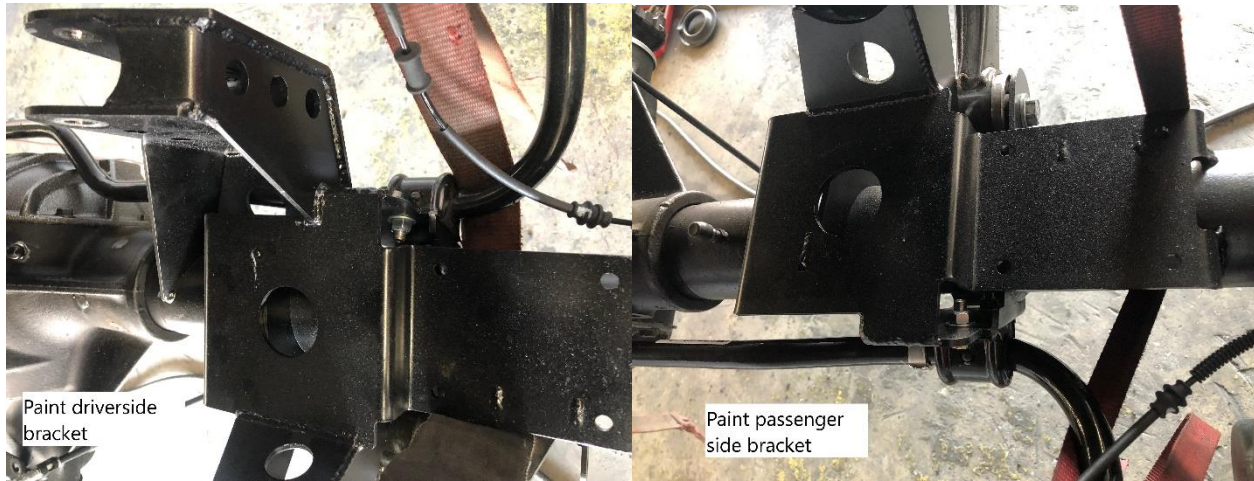


After placing EVO MFG axle brackets on new axle, use C clamps to keep in place. Tack at multiple locations.

Every axle and setup is different, use factory axle as reference for placement of EVO MFG bracketry. Use picture as reference for a general idea on where brackets should be placed on axle. Adjust for your application.



Weld to axle.





After Install:

- Tighten all bolts securing all parts to specified locations.
- After completing installation using provided instructions, go through all steps again to make sure nothing was missed, not tightened or improperly assembled.
- Some components may need to be purchased separately.
- Check BRAKES, turn signals, headlights, fog lights (if applicable), taillights, blinkers and windshield wipers.
- Adjust mirrors, speedometer and headlights if needed.
- Make sure all gauges are fully operational.
- Before driving, check and make sure brakes are working properly, then drive the vehicle slowly for a couple minutes, looking and listening for abnormal noises while driving. After modification of a vehicle there will be differences in driving experiences and capabilities, be mindful of that.
- Inspect and Retorque all Bolts after 500 miles of completed installation and regularly thereafter.
- Some modification may be required.

Recommended Torque:

Size	Grade 2		Grade 5		Grade 8		18-8 S/S	
	Coarse	Fine	Coarse	Fine	Coarse	Fine	Coarse	Fine
#4*	-	-	-	-	-	-	5.2	-
#6*	-	-	-	-	-	-	9.6	-
#8*	-	-	-	-	-	-	19.8	-
#10*	-	-	-	-	-	-	22.8	31.7
1/4	4	4.7	6.3	7.3	9	10	6.3	7.8
5/16	8	9	13	14	18	20	11	11.8
3/8	15	17	23	26	33	37	20	22
7/16	24	27	37	41	52	58	31	33
1/2	37	41	57	64	80	90	43	45
9/16	53	59	82	91	115	129	57	63
5/8	73	83	112	128	159	180	93	104
3/4	125	138	200	223	282	315	128	124
7/8	129	144	322	355	454	501	194	193
1†	188	210	483	541	682	764	287	289