



Installation Instructions Model 20 One-Piece Axle Kit

Please read completely prior to installation

1. Make sure you have the correct kit before removing original axles. Check the measurements below and compare.
2. Measurements are from outside of tube to centerline of the differential.

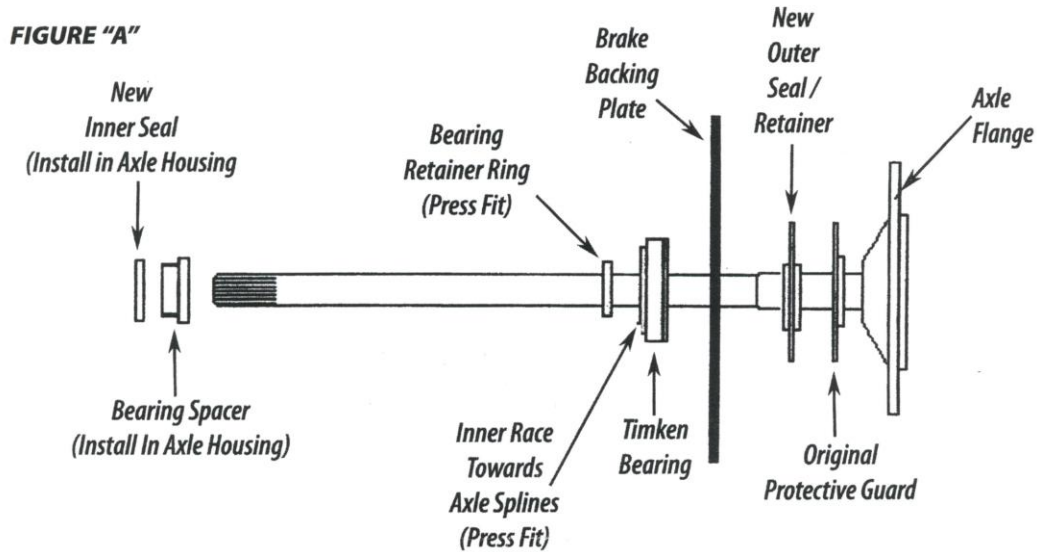
Part #	Application	Drivers (LH) side	Passengers (RH) side
SA CJL	76-83 CJ5/76-81 CJ7 Widetrack	23 15/16"	27 1/16"
SA CJS	82-86 CJ7 Narrowtrack	21 3/4"	24 3/4"
SA CJQ	76-79 Quadratrack	29"	17 1/2"

3. The following measurements are actual axle shaft lengths from outside face of the axle flange to the end of the splined end of the axle.

Part #	Application	Drivers (LH) side	Passengers (RH) side
SA CJS	82-86 CJ7 Narrowtrack	23 1/16"	26"
SA CJL	76-83 CJ5/76-81 CJ7 Widetrack	25 3/8"	28 5/16"
SA CJQ	76-79 Quadratrack	30 1/2"	19 1/4"

4. Remove differential cover and drain fluid.
5. Check for a **PowerLok** differential. A **PowerLok** is a 4-spider enclosed clutch-type unit that has two case halves bolted together with 8 bolts. This design has two sets of splines (one clutch hub and one side gear on each side) the axle needs to engage. **If you have a PowerLok, STOP!** The axles are not long enough to engage the side gear and will strip the end of the axle. If not, proceed.
6. Unbolt and remove wheels.
7. Remove emergency cables from brake assembly and backing plate.
8. Loosen hub nut on axle but do not remove. The nut will act as a "stop" when pulling the hub.
9. Pull hub from axle using appropriate hub puller. Remove nut and hub from axle.
10. Disconnect brake line from backing plate and cap to avoid leaks.
11. Remove all 4 backing plate bolts and original protective guard.
12. Remove outer seal and backing plate. Mark backing plates left and right for reassembly.
13. Remove original shims and save. You may need these later.
14. Remove brake shoes for easier assembly and repeat steps 4-11 on other side.
15. Tap end of axle shaft with a mallet to remove opposite axle. Repeat on other side and remove axles.
16. Remove inner seals.
17. Clean original protective guards, backing plates and housing ends. You are now ready for installation.

**PASSENGER'S SIDE AXLE SHAFT
EXAMPLE DIAGRAM**



18. Install axle studs and original protective guards. Torque studs to 70 ft/lbs.
19. Install inner seal into housing end using a seal driver, then grease.
20. Install bearing spacer into housing end, making sure to seat fully.
21. Before installing bearing on axle shaft, check fit into housing end. Install bearing with bearing race toward differential and seat against bearing spacer. The bearing should protrude between .020"-.060" from the housing end. If bearing protrudes more than .060", either pull and grind on the bearing spacer to achieve this measurement, or add your original shims to the housing end to achieve the same measurement. Failure to achieve these measurements can cause improper bearing load, and can result in premature bearing failure.
22. Grease outer seal and slide onto axle shaft.
23. Match backing plates and slide onto axle shaft.
24. Make sure bearing is packed with grease. Then, using a proper press, press bearing on axle with bearing race towards axle splines. (Ex - if you remove race from bearing, the race would be installed into the housing first.)
25. Apply silicone to housing end and outer seal.
26. Slide axle through housing end and align splines. Axle should slide smoothly, do not force.
27. Align backing plate and seal with housing, install bolts and tighten.
28. Rotate axle and check for binding. If rotates smoothly, reinstall brakes, parking cable, and brake line.
29. Repeat for other side.
30. After installing other axle, rotate and check for binding. If binding is present, check center differential for original axle spacer. Axles should not interfere with spacer. If they do, remove axle spacer from differential.
31. Check brake fluid and bleed as necessary.
32. Place cork gasket, cover, and fill with appropriate fluid.
33. Test drive, check for leaks & you're done!