

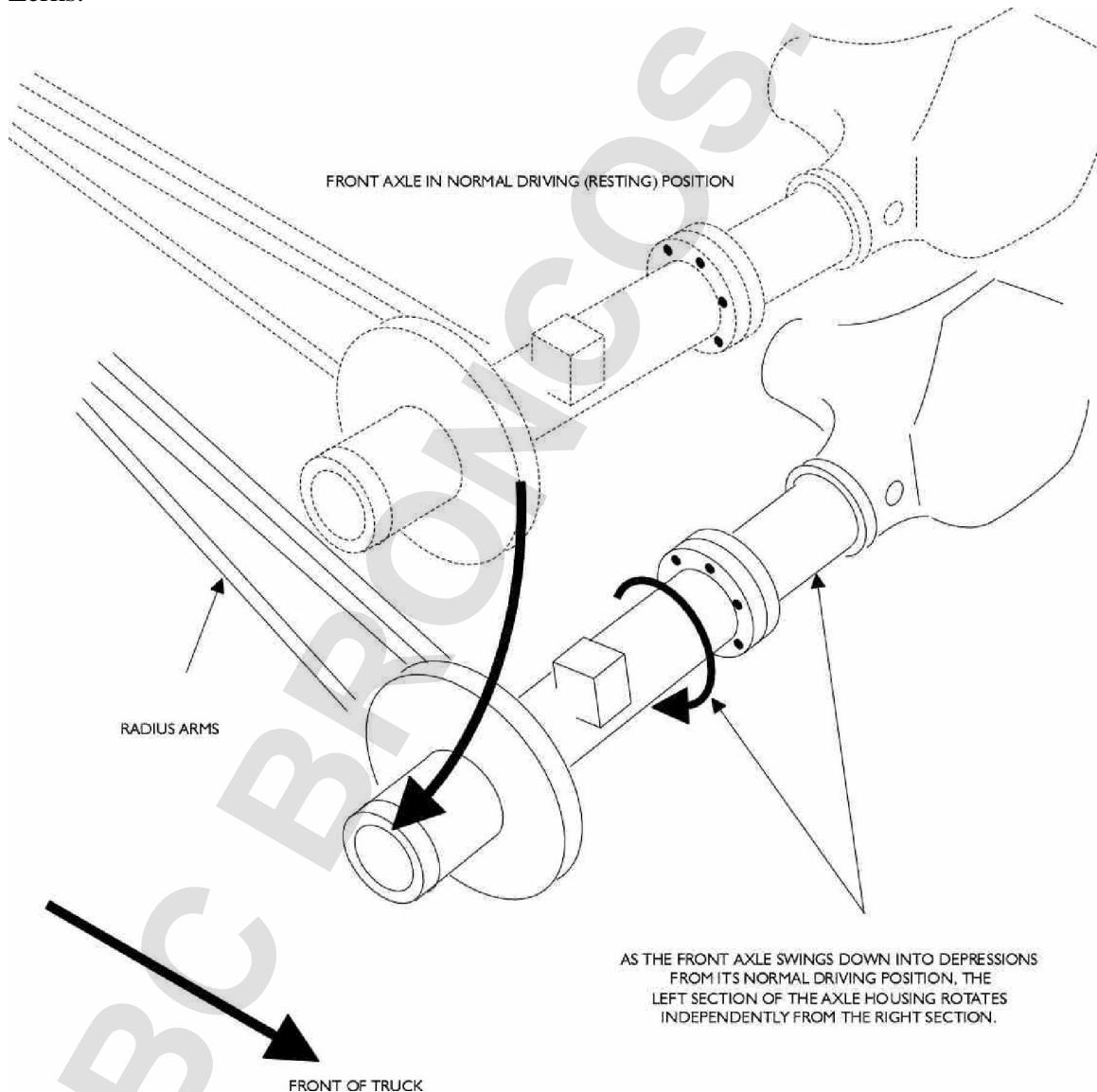
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Wristed Axle Housing Instructions

1. Remove passenger side axle and brake line.
2. Measure 4.5" from passenger side center casting and mark.
3. Using a pipe cutter, make a mark around axle tube.
4. Saw axle housing in two, following the mark made by the pipe cutter.
5. Clean ends of tube and file a chamfer on the inside of the inboard tube and a chamfer the inside and outside of the outer axel housing tube.
6. Drill two 1/2" holes 90 degrees from each other completely through axel tube about 2.5" from center casting on inboard side for bung welds.
7. Using a #3 drill, drill one hole in top of outboard axle tube for grease Zerk about 2.5" from cut and thread 1/4-28.
8. Hone inside both tubes and test fit sleeve. It should be tight, but not bind on the outboard tube.
9. The last 1" to 1.5" of the sleeve may need to be tapped into the inboard tube.
10. Put "O" rings on sleeve. Using a soft hammer, install sleeve 4" into inboard tube.
11. Make the four bung welds on inboard tube and let cool.
12. Put hub on inboard tube inside of hub center should be flush with end of tube.
13. Scribe mark on inboard tube to mark depth of hub on tube.
14. Put "O" ring in cap and put cap and bronze washer on outboard tube as far as possible. Do not install inboard bronze washer at this time.
15. Put rotor on outboard tube.
16. Put outboard tube on sleeve all the way.
17. With 1/4-28 hole in hub facing up spot weld hub in place.
18. Push rotor all the way in (be sure it is bottomed out without bronze washer installed).
19. Spot weld rotor to outboard tube.
20. Remove outboard tube from sleeve.
21. Cover exposed sleeve to protect from weld splatter.
22. Using small weld, weld rotor to tube all the way around on both sides of rotor.
23. Weld only the outside of the hub all the way round to the outside of the inboard tube.

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24. Test fit bronze washers and remove any weld interfering with good fit.
25. Lube sleeve and inside of outboard tube.
26. Lube inside of hub, rotor and bronze washer.
27. Put bronze washer in hub.
28. Slide outboard tube onto sleeve.
29. Put a small amount of silicone sealer on face of hub.
30. Bolt cap to hub using the six 1/4-28 bolts and lock washers provided.
31. Install grease Zerk fitting in outboard tube and hub.
32. Lube using Zerks.



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AS THE FRONT AXLE SWINGS UP OVER AN OBSTACLE FROM ITS NORMAL DRIVING POSITION, THE LEFT SECTION OF THE AXLE HOUSING ROTATES INDEPENDENTLY FROM THE RIGHT SECTION.

