



INSTALLATION INSTRUCTIONS

One-Piece Axle Kit

Kit # RT23007 for 1976-83 Jeep@ CJ-5 or 1976-81 Jeep@ CJ-7

Kit # RT23008 for 1982-86 Jeep@ CJ-7/CJ-8

(replaces factory two-piece Model 20 left and Right Axles & Hubs)

Kit Contains:	(1 pc.) LEFT AXLE SHAFT	(1 pc.) RIGHT AXLE SHAFT
	(10 Pcs.) THREADED WHEEL STUDS	(2 pcs.) HOUSING INNER OIL SEAL
	(2 pcs.) OUTER SEAL/RETAINER	(2 pcs.) BEARING & CUP
	(2 pcs.) SMALL SPACER	(2 pcs.) LARGE SPACER

Please read the entire set of instructions prior to beginning installation of these new axles.

REMOVAL OF ORIGINAL AXLE SHAFTS

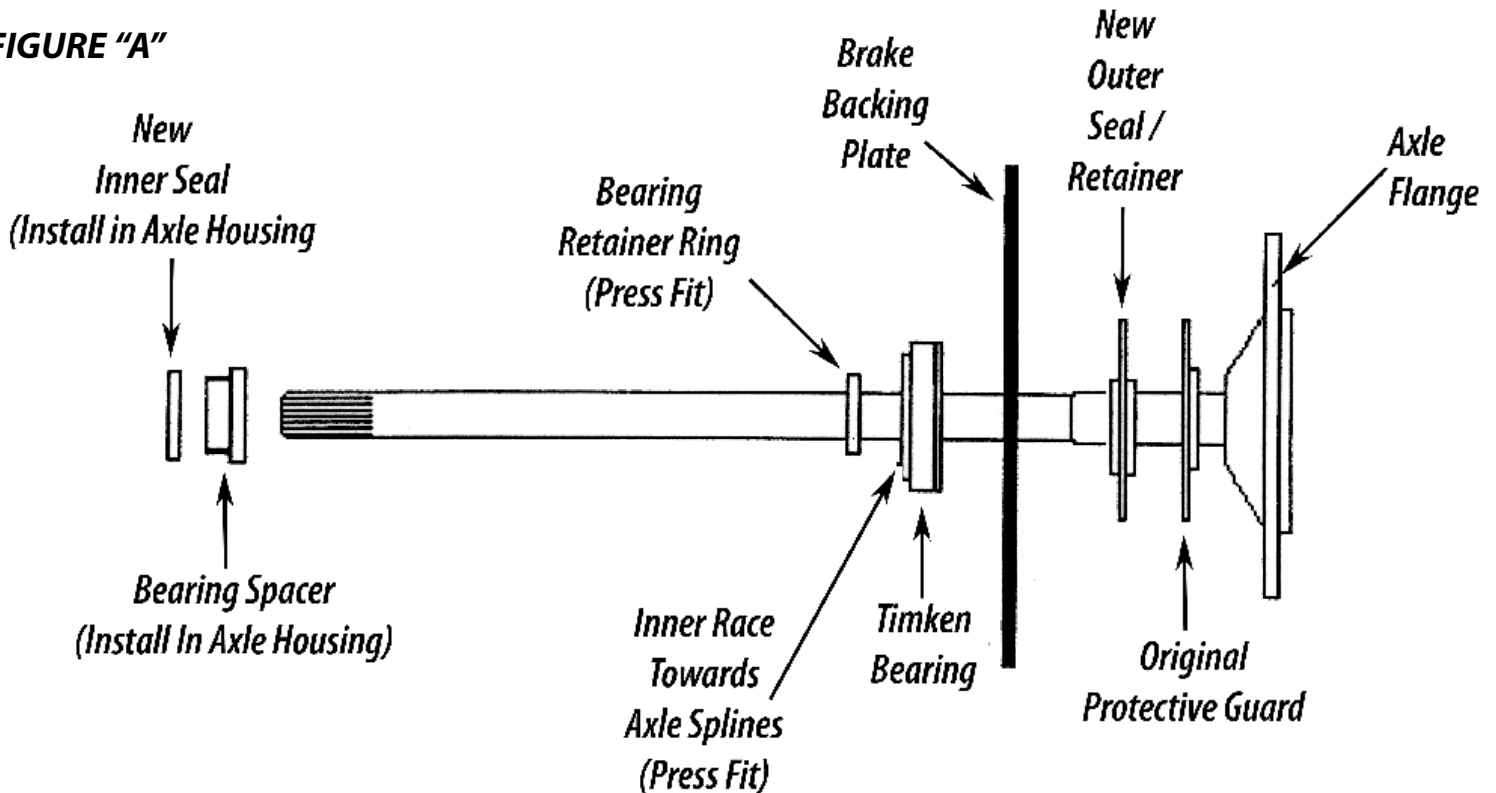
- STEP #1: Drain the axle differential fluid by removing the rear differential cover.
- STEP #2: Verify that you **DO NOT** have a PowerLock differential. **This one-piece axle Kit WILL NOT fit your vehicle if you have a PowerLock differential.** If your differential has 4 spider gears, 2 side gears, and the differential case is bolted together, then you have a PowerLock unit. If you do not have a PowerLock unit, then you may continue.
- STEP #3: Loosen all of your rear wheel lug nuts. Raise and support your vehicle with a jack and jack stand supports. Remove both wheels from the vehicle.
- STEP #4: Disconnect your emergency brake cables from the brake assemblies and backing plates.
- STEP #5: Loosen the large center axle-to-hub nut until almost completely off, but do not remove it completely. The nut will act as a STOP when the hub later pops off of the axle shaft.
- STEP #6: With the appropriate sized hub-puller tool, pull the hub free from the axle shaft until it bumps the axle nut. Remove the axle nut and the hub from the axle shaft. Repeat these steps for the opposite wheel.
- STEP #7: Disconnect the brake lines at the backing plates. Cap off the brake lines to avoid leaking brake fluid.
- STEP #8: Remove the 4 bolts from the backing plate. Remove your original protective guard. Remove the outer seal/retainer. Remove the backing plate. Be sure to mark each backing plate as driver's side or passenger's side for later reassembly. Remove the original axle shims and save them for later use. Remove brake shoes. Repeat these steps for opposite wheel assembly.
- STEP #9: Tap on one axle shaft with a mallet to remove the opposite axle shaft. Repeat for opposite side and remove both axles.
- STEP #10: Remove the original inner axle housing oil seals and discard them. Clean each of the axle housing ends, original protective guards, and backing plates.

You are now ready to install your New One-Piece Axle Kit!

INSTALLING NEW AXLES:

PASSENGER'S SIDE AXLE SHAFT EXAMPLE DIAGRAM

FIGURE "A"



- STEP #11: Install the supplied threaded wheel studs in each of your new axle shaft flanges. (It is recommended that you use a liquid thread locker on each of the wheel studs.) Torque each of the wheel studs to approximately 70 ft./lbs.
- STEP #12: Using an oil seal installation tool, install each of your new INNER OIL SEALS in each axle housing end. Seat each of the oil seals against the housing shoulders. Apply a sparing amount of oil or grease to each of the seal surfaces.
- STEP #13: Install the large bearing spacers into each axle housing end. Be sure that each spacer is fully seated into the axle housings. Test fit each bearing into the axle housing ends, without the axle Shafts installed. Be sure the inner bearing race is facing towards the center of the differential. Be sure the bearing is resting against the bearing spacer. Each bearing should protrude 0.020" to 0.060" beyond the housing ends. (If the bearing protrudes MORE than 0.060" from the housing, then remove the bearing spacer and evenly grind the spacer just enough to achieve the required measurement.) Remove the bearings from the housing to continue axle installation.
- STEP #14: Reinstall the original protective guards onto the two new axle shafts. Apply a small amount of oil onto the outer axle seals/retainers and slide the seals onto the two new axle shafts.
- STEP #15: Slide each of the corresponding backing plates onto your new axle shafts. Be sure the brake shoe sides of the backing plates face the axle flanges.

- STEP #16: Pack each of your new bearings with high-quality EP wheel bearing grease. **Insufficiently packed bearings may cause premature bearing failure.**
- STEP #17: Press each of the bearings onto the axle shafts with the inner race facing the axle splines. **CAUTION: Only use a press suitable for axle bearings! DO NOT use a hammer to install the bearings! Most repair shops or automotive machine shops can properly install the bearings for you if you do not have a bearing press.**
- STEP #18: Press bearing retainer rings onto axle shafts. Press the rings tightly against the bearings. Again, use only a suitable bearing press.
- STEP #19: Apply a sparing amount of RTV silicone on the housing ends and outer seal/retainers. Slide each axle assembly into the housing, aligning the axle shaft splines with the center differential gears. Gently tap the axle shafts into place.
- STEP #20: Align each backing plate with the axle housings and reinstall bolts.
- STEP #21: Spin each of the axle shafts and be sure they spin freely without any binding.
- STEP #22: Reassemble each of the brake assemblies, emergency brake cables, and brake lines.
- STEP #23: Check brake fluid level and top off at master cylinder. Thoroughly bleed the brake system.
- STEP #24: Reinstall your rear differential cover with a new gasket or RTV silicone sealant and fill differential with a high quality gear oil.

YOU'RE DONE!

YOU CAN NOW FEEL CONFIDENT, BOTH ON AND OFF THE ROAD, KNOWING THAT YOU'VE GOT A PAIR OF THE MOST DURABLE AXLES AVAILABLE INSTALLED IN YOUR JEEP®!



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