



Tie-Rod Flip Kit Installation Instructions

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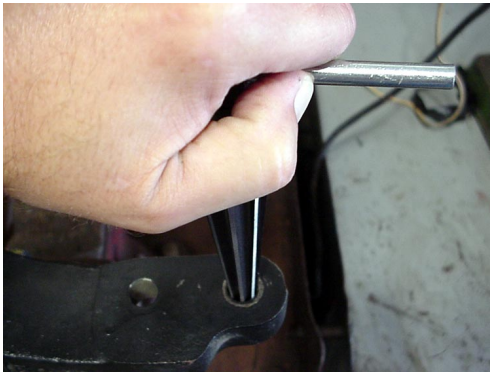
1. The 2044R Tie-Rod Flip Kit includes a Reamer and a Knuckle Tapered sleeve Insert. The insert is shown on right and the reamer to be used is on the left.



2. First, Remove the Tie-Rod or the Drag-link from the knuckle. Insert the reamer from the bottom of the knuckle and mark the depth with a piece of tape as shown.



3. Remove the reamer from the knuckle and slightly move the tape up toward the smaller tapered end of the reamer and wrap the tape around the reamer. This will be used as a crude depth guide while using the reamer. **WARNING:** Should you remove too much material from the knuckle, the knuckle will be unusable as the steering components will not be able to be set tight to factory specifications.



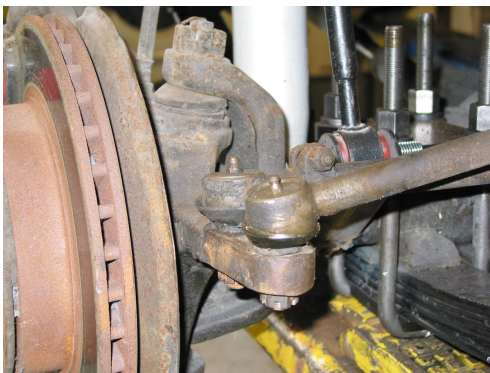
4. Gently turn the reamer clockwise to remove material from the topside of the knuckle as shown above.



5. As you get close to the tape mark in depth, remove the reamer and try inserting the insert on the top-side of the knuckle to determine proper depth as a guide. The insert should protrude approximately 1/64" for proper depth.



6. Remove the insert and install the insert into the bottom side of the knuckle. The insert should sit flush with the knuckle surface. Reinstall the steering components into the topside of the knuckle. **Note:** If the cotter pin cannot be inserted through the component castle nut, remove additional material, using the reamer. Material must be removed in incremental amounts.



7. When finished, your kit should look like this.

Replacement Tie Rod Ends
#R048136600 Right Hand
#R048136674 Left Hand

Replacement Heavy Duty Cross
Tie Rods (2pcs.)
82-86 CJ's #XTRCJ40W
72-81 CJ's #XTRCJ40N