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### **INSTALLATION INSTRUCTIONS**

*4-Link Hardware Kit With and Without Panhard Bar  
QA1 P/N 1682-110, 1682-120*

READ ALL INSTRUCTIONS CAREFULLY AND THOROUGHLY PRIOR TO STARTING INSTALLATION. PRODUCTS THAT HAVE BEEN INSTALLED ARE NOT ELIGIBLE FOR RETURN. USE THE PROPER JACKING LOCATIONS. DEATH OR SERIOUS INJURY CAN RESULT IF INSTRUCTIONS ARE NOT CORRECTLY FOLLOWED. A GOOD CHASSIS MANUAL, AVAILABLE AT YOUR LOCAL PARTS STORE, MAY ALSO AID IN YOUR INSTALLATION.

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This kit includes all the necessary hardware to build your 4-link suspension. Because there will be variation in the width of your mounts, whether purchased or fabricated, we did not include misalignment spacers. Part numbers are provided below for a variety of spacers that work with these pieces.

#### **Tubing Size Required:**

Trailing Arms-1.375" OD x 0.095" wall thickness  
Panhard Bar-1.25" OD x 0.095" wall thickness

#### **Tubing Material:**

The tubing adapters in this kit are made of Chromoly, which is the preferred material. Mild steel tubing can be used as long as the welding wire is Chromoly compatible.

#### **Welding:**

To protect the treads in the tubing adapters from warping, thread a bolt (not the rod end) into the adapter while welding. Drill two 3/8" holes 180° from each other, 3/8" from the end of the tube and plug weld them shut. Bevel the end of the tubing to match the bevel on the tubing adapter then weld the full circumference.

#### **Trailing Arm and Panhard Bar Length:**

When measuring for the length of the links or panhard bar, make sure to keep a minimum of 1.125" of thread engaged into the tubing adapter.

## 1682-110

Quantity	Part Number	Description
4	XMR8-12	Endura Series Rod End, Male, RH, 1/2" Bore, 3/4-16 Thread
4	XML8-12	Endura Series Rod end, Male, LH, 1/2" Bore, 3/4-16 Thread
5	JNR12S	Jam Nut, RH, 3/4-16 Thread, Steel
5	JNL12S	Jam Nut, LH, 3/4-16-Thread, Steel
4	1844-133	Tube Adapter, RH 3/4-16 Thread, 1.375" OD x 0.095" Wall Tubing
4	1845-106	Tube Adapter w/ Hex, LH, 3/4-16 Thread, 1.375" OD x 0.095" Wall Tubing
1	XMR12	Endura Series Rod End, Male, RH, 3/4" Bore, 3/4-16 Thread
1	XML12	Endura Series Rod End, Male, LH, 3/4" Bore, 3/4-16 Thread
1	1844-127	Tube Adapter, RH 3/4-16 Thread, 1.25" OD x 0.095" Wall Tubing
1	1845-104	Tube Adapter w/ Hex, LH, 3/4-16 Thread, 1.25" OD x 0.095" Wall Tubing

## 1682-120

Quantity	Part Number	Description
4	XMR8-12	Endura Series Rod End, Male, RH, 1/2" Bore, 3/4-16 Thread
4	XML8-12	Endura Series Rod end, Male, LH, 1/2" Bore, 3/4-16 Thread
4	JNR12S	Jam Nut, RH, 3/4-16 Thread, Steel
4	JNL12S	Jam Nut, LH, 3/4-16-Thread, Steel
4	1844-133	Tube Adapter, RH 3/4-16 Thread, 1.375" OD x 0.095" Wall Tubing
4	1845-106	Tube Adapter w/ Hex, LH, 3/4-16 Thread, 1.375" OD x 0.095" Wall Tubing

### Standard Spacer Options For Trailing Arms

Part Number	ID	Width	Total Installed Width
SG84	0.500	0.250	1.250
SG85	0.500	0.250	1.375
SG88	0.500	0.500	1.750
SG812	0.500	0.750	2.250

\*Measurements in inches

### High Misalignment Spacer Options for Panhard Bar

Part Number	Mating Rod End Bore	ID	Width	Total Installed Width
SG12-84	0.750	0.500	0.250	1.375
SG12-88	0.750	0.500	0.500	1.875
SG12-108	0.750	0.625	0.500	1.875
SG12-812	0.750	0.500	0.775	2.425
SG12-816-W	0.750	0.500	1.000	2.875

\*Measurements in inches

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