

1. Start by trimming off the bend wings (marked with the black "X" in the diagram) at the end of the trailing arm main plates by cutting along the etched lines.



2. Weld the 1.25"-12 thread adapter in to the shorter leg of the 2" x .25" DOM tube. Fully weld the tube adapter and plug weld both holes. Be careful not to overheat the threads of the bung- too much heat directly to the threads could cause warpage. Try to direct the majority of the heat towards the tubing to help avoid this. Let bung cool to the touch before checking thread fitment.

NOTE: DO NOT WELD WITH HEIM INSTALLED.



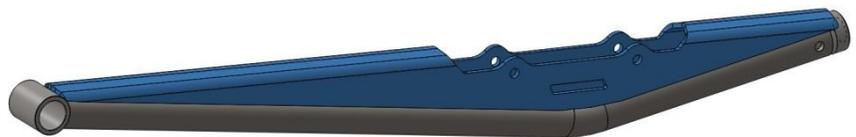
3. Notch the long leg of the 2" x .25" DOM tubes for the Bushed DOM. This is where you can set the angle of your bushing in the trailing arm. You can also set the bushings at 0* and build the angle in to your chassis mounting brackets. Once angle is set, fully weld the Bushed DOM in place. Do not weld with poly bushings installed. If the Bushed DOM needs to be assembled for your welding, check out our Bushed DOM Mock Up Pucks (P/N: R2019)

NOTE: If debating whether to angle your Bushed DOM or angle your chassis mounting brackets, keep in mind:

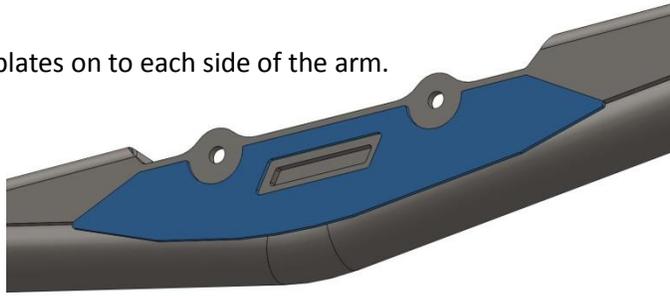
-If you only angle your Bushed DOM, the offset from the chassis to shock mounting points will stay mostly constant through suspension travel

-If you only angle your brackets, the shock mounting points will usually get closer to the chassis when the suspension droops and further away when it compresses.

4. Set the Main Plate on the tube. Some minor grinding may be required for perfect fitment between the tubes and Main Plates. Tack the Main Plate to the tube every 3-4" then weld the entire seam one section at a time, jumping around to different sections of the arm to spread the heat out as evenly as possible.

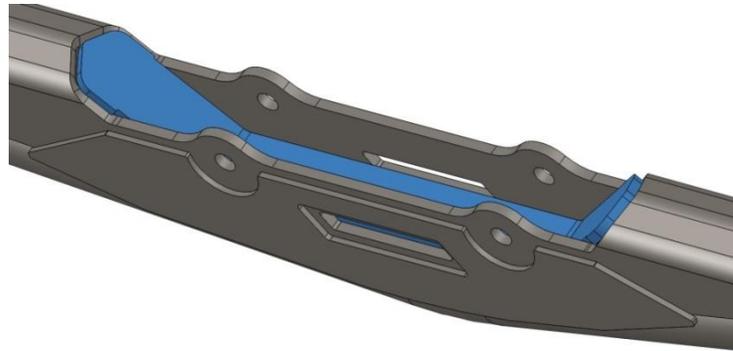


5. Fully weld the overlay plates on to each side of the arm.



6. Drop the Shock Valley in to the Main Plates and line up the weld gaps at the top as well as across the drain slot. Tack in place and fully weld.

NOTE: Some grinding of may be required for the Shock Valley to drop in.



7. Install the heim and bushings and the arms are ready to rock!