



1. THINK SAFETY, ALWAYS WEAR SAFETY GLASSES WHEN PERFORMING THE OPERATIONS PRESCRIBED IN THESE INSTRUCTIONS

2. READ ALL INSTRUCTIONS CAREFULLY BEFORE ATTEMPTING INSTALLATION

ASSEMBLY TOOLS NEEDED:

- Impact Sockets: 7/16" – 1-3/8"
- Wrenches: 7/16" – 1-3/8"
- Torque Wrench:
- Drill Bits: 1/4", 1/2"
- Center Punch and Hammer:
- Two (2) C-Clamps

Bolt Size	GR.2 Dry	GR.5 Dry	GR.8 Dry	Metric Size	GR.8.8 Dry
1/4"	66*	9	12	M8	17
5/16"	11	17	25	M10	35
3/8"	20	30	45	M12	60
7/16"	32	50	70	M14	95
1/2"	50	75	110	M16	155
9/16"	70	110	150		
5/8"	100	150	220		
3/4"	175	260	380		
7/8"	170	430	600		
1"	250	640	900		

NOTE: These torque values are to be used for all hardware. Unless otherwise specified, all torque values must meet this specification.
NOTE: All torque values are in Ft-Lbs unless otherwise stated
*In-Lbs

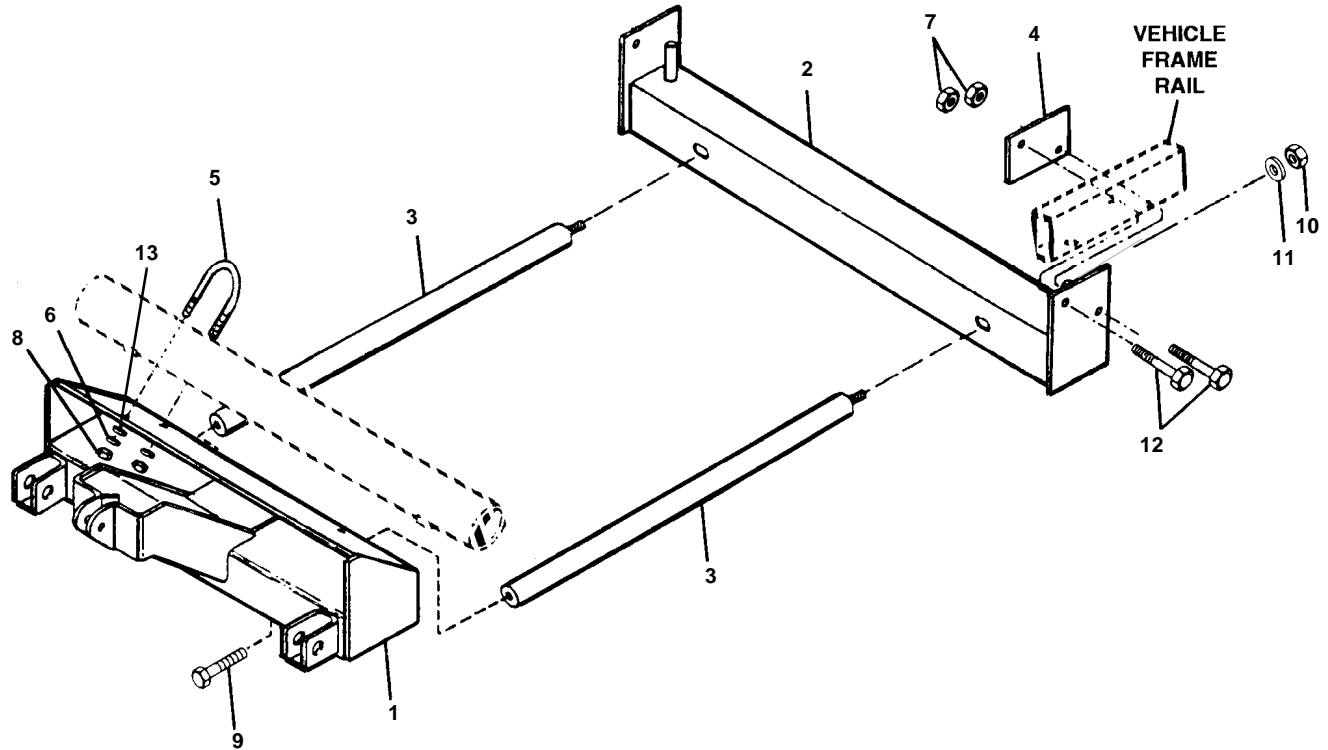
INSTALLATION NOTES

1. Vehicle front suspension must be in normal position (as with vehicle on the ground) to install sub-frame assembly.
2. Mount Sub-Frame assembly completely before tightening any bolts unless otherwise specified.

MOUNTING INSTRUCTIONS:

1. Support Sub-Frame Assembly (#96101544) under vehicle tubular front crossmember. Install using U-Bolts (#98009122), Flatwashers, Lockwashers and Nuts provided as shown on front page.
2. Locate 3/4" holes on bottom front, left and right vehicle frame rails. Install Rear Crossmember (#96001350) by locating Crossmember Guide Pins into frame rail holes and clamp Crossmember in place. Using holes in Rear Crossmember as a template, center punch and drill 1/4", then 1/2" holes through frame rails.
3. Place Support Plates (#96001352) on inside of frame rails and align with holes just drilled. Secure using 1/2" x 3-1/2" Capscrews (#98009036) and Nylock Nuts provided.
4. Install Support Pipe Assemblies (#96001422) with stud end going into Rear Crossmember and secure with Flatwashers and Nylock Nuts provided. Secure to Sub-Frame Assembly using 5/8" x 2" Capscrews (#98009041).
5. Using the Torque specification chart above, torque all bolts starting at the rear and working forward.

1988 AND LATER SUZUKI SIDEKICK 2 - DOOR / GEO TRACKER 2 - DOOR
Sub-Frame Assembly & Installation Instructions
Part No. 99004044 Sub-Frame (Complete) Includes Hardware



ITEM	PART NO.	DESCRIPTION	QTY.
1	96101544	Sub-Frame Assembly	1
2	96001350	Crossmember, Rear	1
3	96001422	Pipe, Support.....	2
4	96001352	Plate, Support.....	2
5	98009122	U-Bolt, 3/8" -16 NC x 3" x 2" x 1-1/2".....	2
6	98009008	Washer, Lock, 3/8".....	4
7	98009013	Nut, Hex, Nylock 1/2"-13 NC	4
8	98009077	Nut, Hex head, 3/8" -16 NC	4
9	98009041	Capscrew, 5/8" -11 NC x 2"	2
10	98009038	Nut, Hex, Nylock, 5/8"-11 NC	2
11	98009039	Washer, Flat, 5/8"	2
12	98009036	Capscrew, Hex Head, 5/8"-11NC x 3 1/2"	4
13	98009032	Washer, Flat, 3/8"	4



SNO-WAY INTERNATIONAL, INC.

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