



SYNERGY MFG. 870 INDUSTRIAL WAY, SAN LUIS OBISPO, CA (805) 242-0397

8012-02 JK FRONT DANA 30/44 INNER C-GUSSET KIT

Version 2

GENERAL NOTES:

- These instructions are also available on our website; www.synergymfg.com. Check the website before you begin for any updated instructions and additional photos for your reference.
- The C-gussets in this kit help to prevent the factory JK Inner-C's from bending.
- These gussets can be installed with the axle still in the vehicle and with knuckles still attached.
- While not necessary, we do suggest removing the knuckles and ball-joints when installing C-gussets as to prevent any heat damage to ball-joints.

INSTALLATION:

1. Fit the C-Gussets on the axle to see what areas need to be cleaned up in preparation for welding.



2. Clean the areas to be welded as shown. Take reference of weld photos below to determine exactly which areas will need to be prepared for welding.



Once weld surfaces are prepared, place upper C-gussets in position. There will likely be a slight gap around the ball-joint area; use a C-clamp to tighten the gusset in the proper welding position.



3. Once satisfied with gusset placement, tack in several locations and fully weld all areas as shown below.



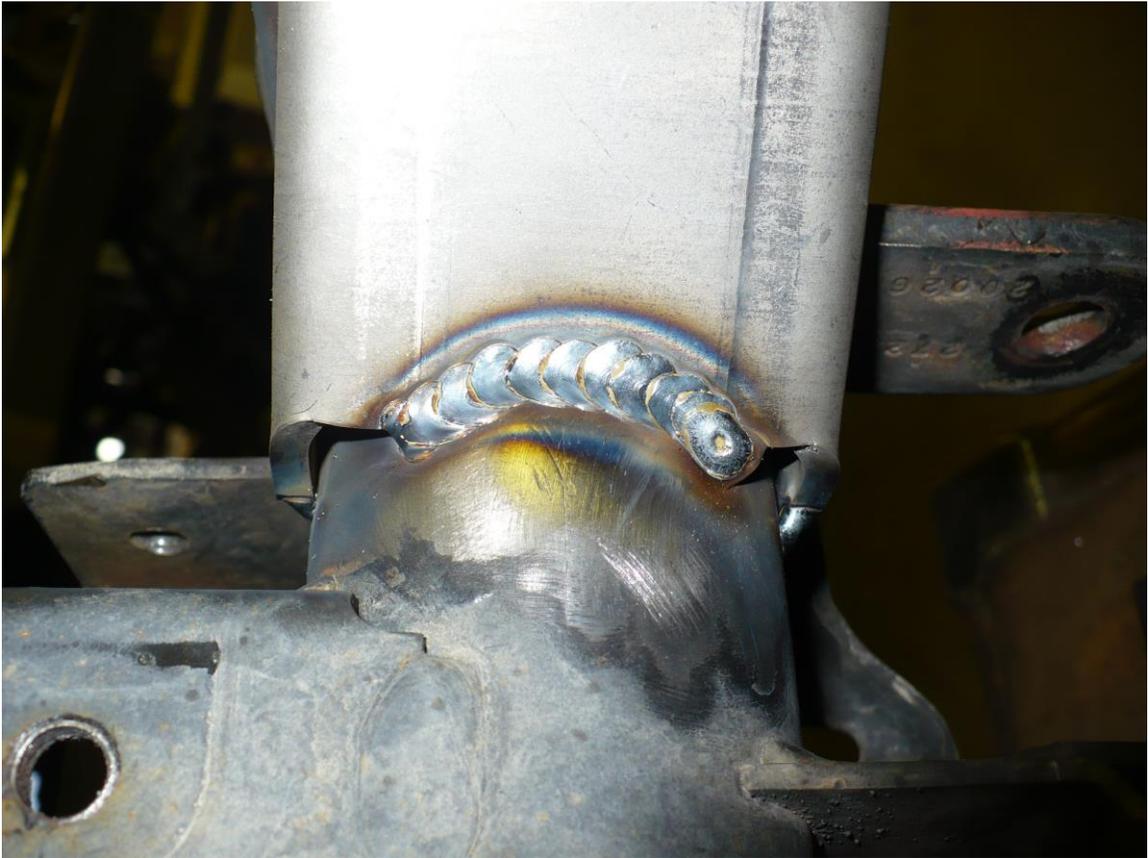
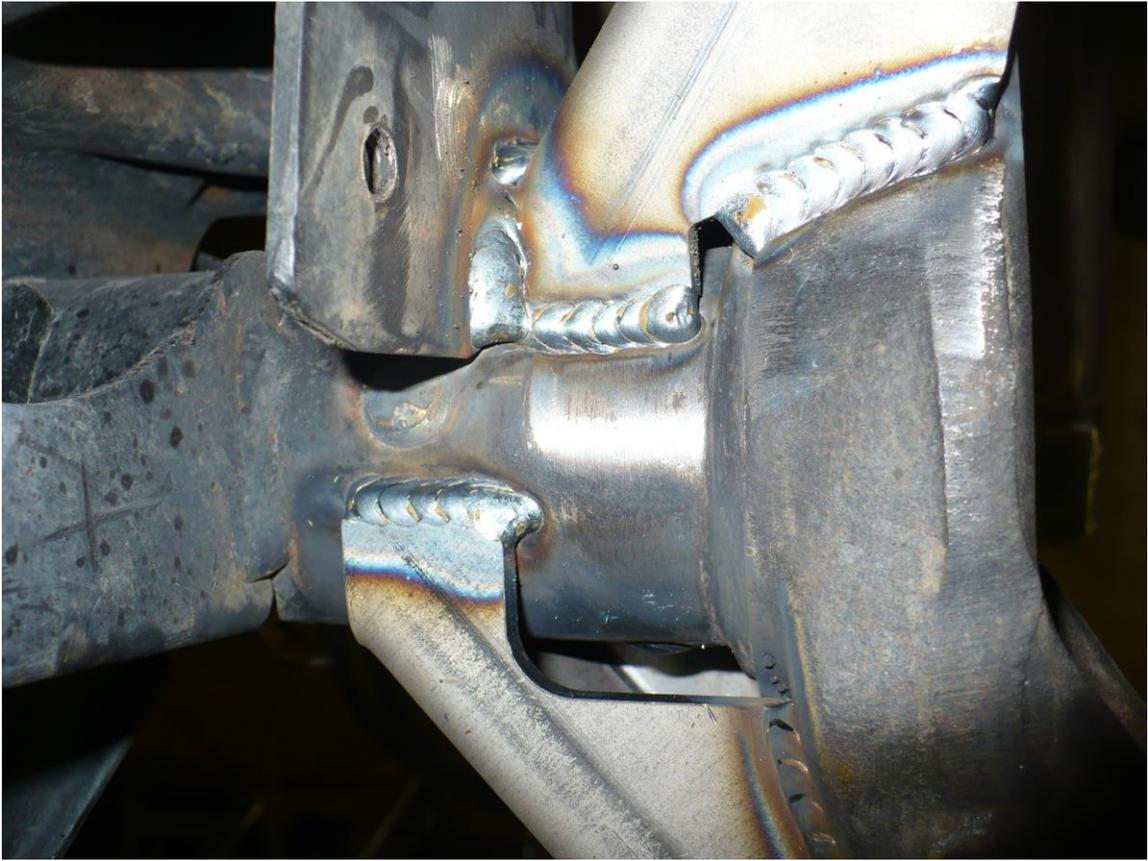


4. With upper C-gussets fully welded on, go ahead and move onto the lowers.
5. Again, begin by placing them on the axle to see what areas need to be cleaned up for welding. See fully welded pictures below for a reference as to what areas get welded.
6. Clean the two ridges on the base of the C along with the bottom half of the tube up to the shock mount as pictured below.



7. Tack the lower C-gusset on in several locations. We recommend tacking at the end of the weld for a clean weld. Once tacked, fully weld as shown in the pictures below.





8. After welding, clean off any weld burrs and paint the desired color to prevent corrosion.