

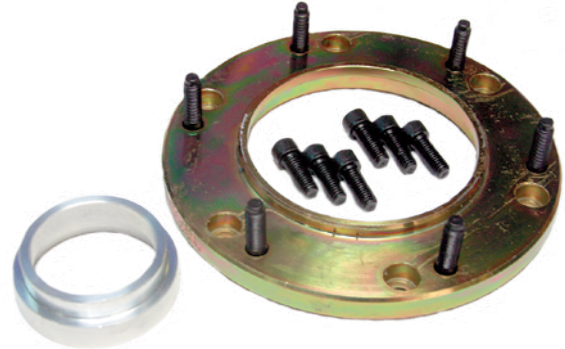


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1994-2013 Dodge 4WD Index Ring Installation Instructions Part # IXR10, IXR20, & IXR20K

REQUIRED TOOL LIST:

- Safety Glasses
- Metric / Standard Wrenches & Sockets
- Hex Key Wrenches
- Bristle Disc
- Stud Remover
- Torque Wrench
- Transmission Jack



Before beginning the installation, thoroughly & completely read these instructions & the enclosed driver's WARNING NOTICE. Affix the WARNING decal in the passenger compartment in clear view of all occupants. Please refer to the Parts List to insure that all parts & hardware are received prior to the disassembly of the vehicle. If any parts are found to be missing, contact SKYJACKER® Customer Service at 318-388-0816 to obtain the needed items. If you have any questions or reservations about installing this product, contact SKYJACKER® Technical Assistance at 318-388-0816.

Component Box Breakdown:

Part #: IXR10 / IXR20 / IXR20K

| Item # | Description | Qty | Item # | Description | Qty |
|---------|--|-----|----------|--|-----|
| IXR10-S | INDEX RING / DODGE (Included With IXR10) | 1 | TCS2675 | T-CASE SEAL (Included With IXR20K) | 1 |
| IXR20-S | INDEX RING / DODGE (Included With IXR20 & IXR20K) | 1 | 10X25SHB | 10MM X 25 SOCKET HEAD BOLT (Included With IXR20K) | 6 |
| DTSA269 | 2.69"OD TRANS SEAL ADAPTER (Included With IXR20K) | 1 | HB-IXR10 | HDWR BG:INDEX RNG IXR10/20 | 1 |
| | | | I-IXR10 | INST SHEET: IXR10 / IXR20 | 1 |

Hardware Bag Breakdown:

Part # HB-IXR10

| Item # | Description | Qty | Item # | Description | Qty |
|-----------|------------------------------|-----|--------|------------------------------|-----|
| 38X158IRS | 3/8 X 1 5/8 STUD, INDEX RING | 6 | LT100 | NUTS N' BOLTS 427 1 ML TUBE | 1 |
| 38IRFN | 3/8" FLANGED NUT, INDEX RING | 6 | S343-3 | SILICONE, ULTRA BLACK, 3 OZ. | 1 |
| 38X1SHB | 3/8 X 1 SOCKET HEAD BOLT | 6 | | | |

Installation:

1. Drain the fluid from the transfer case & disconnect the drive shafts. Remove the speedometer wire from the rear of the transfer case & remove any vacuum lines, vent hoses, & etc from the top of the transfer case. If equipped, remove the transfer case shift linkage from the transfer case bracket. Remove the six retaining nuts that hold the transmission to the transfer case & remove the transfer case using a transmission jack.
2. With the transfer case out of the vehicle, remove the six retaining studs on the front of the transfer case using a stud remover or similar tool. **Note:** Now would be a good time to check the condition or replace your transfer case input seal & extension housing seal.
3. Clean the outside edge of the transfer case with a bristle disc or similar tool, being sure to remove all silicone. **Note:** This surface should be clean & free of any residue. (See Photo # 1)
4. Install the new Skyjacker 3/8" x 1 5/8" studs into the new Skyjacker index ring. The new studs will install into the counter sunk holes of the new index ring & the new studs should be pointing in the same direction of the inside lip of the new index ring. (See Photo # 2) **Note:** The teeth on the head of the new studs will prevent spinning. To ensure that the new studs are pulled down flush, thread on the new Skyjacker nuts & tighten. Then remove the new nuts for future installation.
5. Line the new index ring up on the transfer case. **Note:** The new index ring will only install one way. Once the holes are lined up, mark the position with a marker so it can easily be lined up once the new Skyjacker silicone is applied. (See Photo # 3)
6. Apply a bead of the new silicone to the outside of the transfer case mounting surface. (See Photo # 4) Install the new index ring using the new Skyjacker 3/8" x 1" or 10mm x 25mm socket head bolts & thread locking compound. **Note:** Check for the correct thread pitch of the OEM transfer case to determine whether to use the 3/8" x 1" or 10mm x 25mm socket head bolts.
7. Tighten each bolt across from each other so the new index ring pulls up tight. Torque to 35 ft. lbs. (See Photo # 5)



Photo # 1



Photo # 2



Photo # 3



Photo # 4

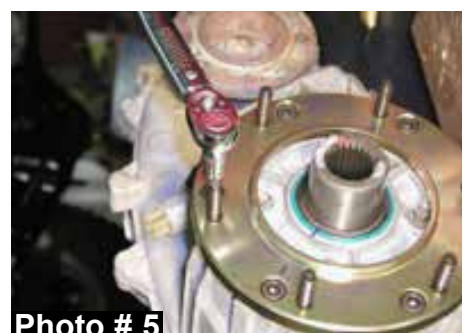


Photo # 5

Note: Some manual transmission models & models with a G56 manual transmission will not require the use of the new Skyjacker transmission seal adapter. (See Photo # 6) If the new transmission seal adapter is not required, do not remove the rear transmission seal.

Transmission Seal Adapter



Photo # 6

If not installing a new transmission seal adapter, skip to Step # 9.

Note: If the OEM inner transmission output seal is 2.57" OD, order separately the transmission seal adapter Part # DTSA10.



Photo # 7

8. Remove the inner transmission output seal located at the rear of the transmission. Install the new transmission seal adapter into the rear of the transmission. **Note:** It is recommended to apply a thin layer of silicone on the outside of the new transmission seal adapter so it can slide in without binding. To install, tap the new transmission seal adapter in until it seats flush. It is recommended to use a 2x4 or other flat surface when tapping in the new transmission seal adapter. This will ensure the new transmission seal adapter is installed straight. Once the new transmission seal adapter is installed, install the new transmission seal (Part # TCS2675) into the new transmission seal adapter using the same process. (See Photo # 7 / Arrow # 1 shows the new transmission seal adapter & Arrow # 2 shows the new transmission seal.)



Photo # 8

9. Clean the backside of the transmission mounting surface using a bristle disc or similar tool. Apply a bead of silicone around the rear outside edge of the transmission mounting surface. (See Photo # 8)



Photo # 9

10. Using a transmission jack, install the transfer case using the new Skyjacker flange nuts & washers. (See Photo # 9)
11. Reconnect the speedometer wire, vacuum lines, vent hoses, shift linkage, & etc.
12. Refill the transfer case with fluid & reinstall the drive shafts.

TORQUE SPECIFICATIONS

| <u>INCH SYSTEM</u> | | | <u>METRIC SYSTEM</u> | | |
|--------------------|----------------|----------------|----------------------|------------------|-------------------|
| Bolt Size | Grade 5 | Grade 8 | Bolt Size | Class 8.8 | Class 10.9 |
| 5/16 | 15 FT LB | 20 FT LB | 6MM | 5 FT LB | 9 FT LB |
| 3/8 | 30 FT LB | 35 FT LB | 8MM | 18 FT LB | 23 FT LB |
| 7/16 | 45 FT LB | 60 FT LB | 10MM | 32 FT LB | 45 FT LB |
| 1/2 | 65 FT LB | 90 FT LB | 12MM | 55 FT LB | 75 FT LB |
| 9/16 | 95 FT LB | 130 FTLB | 14MM | 85 FT LB | 120 FT LB |
| 5/8 | 135 FT LB | 175 FT LB | 16MM | 130 FT LB | 165 FT LB |
| 3/4 | 185 FT LB | 280 FT LB | 18MM | 170 FT LB | 240 FT LB |

- The above specifications are not to be used when the bolt is being installed with a bushing.

Seat Belts Save Lives, Please Wear Your Seat Belt.