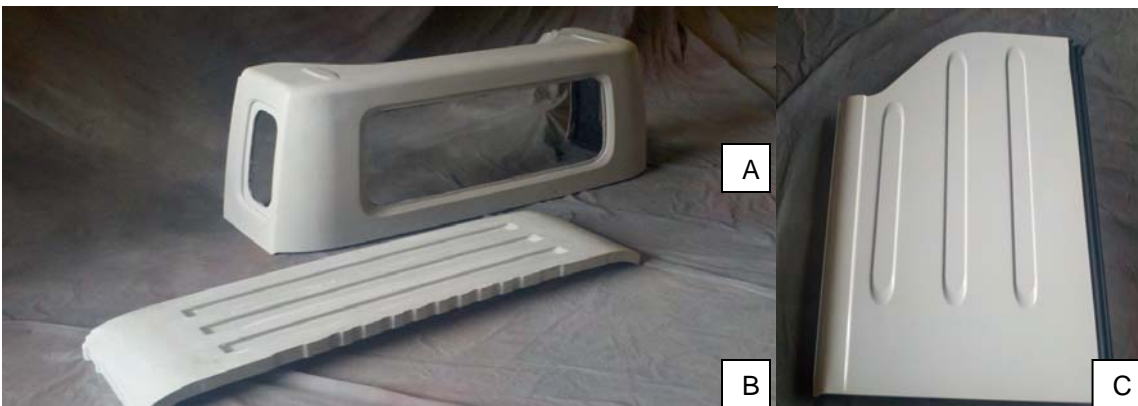




JK8 Body Kit



KIT CONTENTS









CALL OUT	PART NUMBER	DESCRIPTION	QUANTITY
A	P5156021	HARDTOP	1
B	P5155997	BULKHEAD	1
C	1PH98/9TZZAE	RH/LH FREEDOM PANELS	2
D	P5156009/10	OUTER RH/LH QUARTER TRIM PANELS	2
E	68001172/3AD	INNER RH/LH QUARTER TRIM PANELS	2
F	P5156007/8	RH/LH 2 DOOR SPORTS BAR RHLH	2
G	P5156004	FLOOR PAN	1
H	P5156006	REAR STORAGE COVER	1
I	P5156012	BULKHEAD BAR	1
J	68026036/7AB	FRONT RH/LH BELT RAIL	2
K	55395640/1AG	REAR RH/LH BELT RAIL	2
L	P5156005	CROSSMEMBER	1
M	P5156011	CROSSMEMBER BRACKETS	2
N	55395270/1AB	RH/LH MUCKETS	2
O	68001202/3AB	B PILLAR RH/LH LOWER TRIM PANEL	1
P	68088042AA	HARDTOP SEAL	1
Q	5KP66/7DX9AD	UPPER B PILLAR TRIM RHLH PANELS	2
R	1CD06/7DX9AD	UPPER B PILLAR TRIM COVER	2
S	5KP70/1DX9AD	LOWER B PILLAR TRIM RHLH PANELS	2
T	P5155994/5	HARDTOP RHLH WINDOWS	2
U	P5155996	HARDTOP REAR SLIDING WINDOW	1
V	P5156002	HARDTOP TO BULKHEAD SEAL	1
W	82213093	BADGE	1
X	P5156021	HARDTOP AND WINDOW HARDWARE KIT	1
Y	P5155993	ASSORTED HARDWARE KIT	1

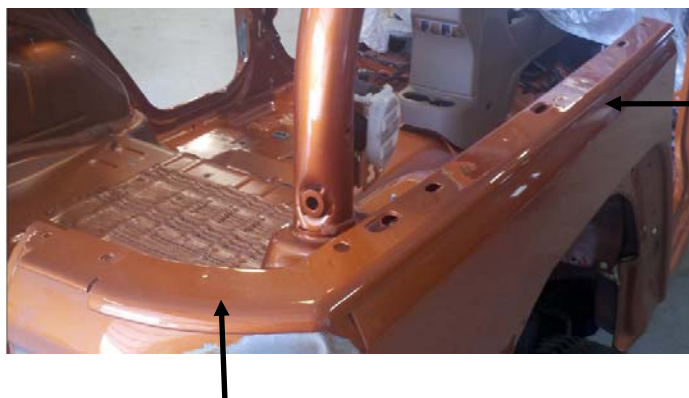
KIT INSTALLATION

1. Disconnect Battery
2. Remove in the following order prior to installation of the kit:
 - Freedom Top Panel
 - Soft Top
 - Dome Light and Speaker Bar Including Wiring
 - B Pillar Trim
 - Seats Front and Rear
 - Carpet
 - Fuel Door
 - License Plate Bracket
 - Tailgate and Wiring
 - Rear Bumper
 - Rear Wheel Flares
 - Hard Top Including Wiring
 - Front and Rear Doors
 - Sport Bar Padding
 - Sill Trim
 - Seat Belts and Mounting Hardware
 - Rear Subwoofer
 - Rear Storage Enclosure
 - Tail Lamps
 - Spare Tire
 - Tailgate Hinges
 - Rear Wheel Liners
 - Running Boards

*Use Chrysler Service Manual or Chrysler Tech Connect for proper removal and installation procedures.

*** Recommended to be installed by a certified body shop facility. This is a one way conversion kit.**

3. Apply protective covering to Instrument Panel and Center Console.
4. Belt Rail Removal – Remove spot welds in 11 places per side and remove from quarter trim panels.



5. Outer Quarter Trim Panel Removal – Remove spot welds in 75 places per side and remove from inner quarter trim panels and vehicle body.



6. Rear Corner Trim Panel Removal – Remove spot welds in 22 places per side and remove from vehicle body.
CAUTION: When removing gas trim ring ease clips from trim panel.



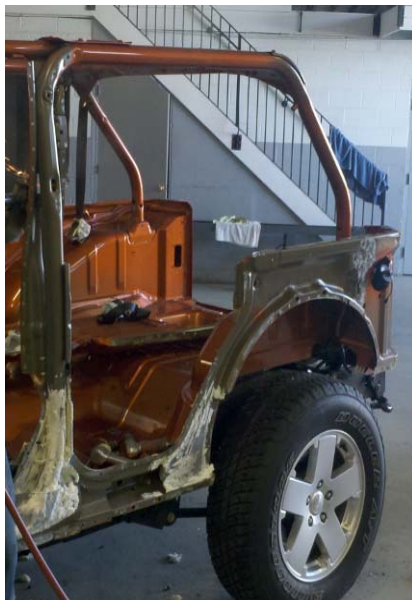
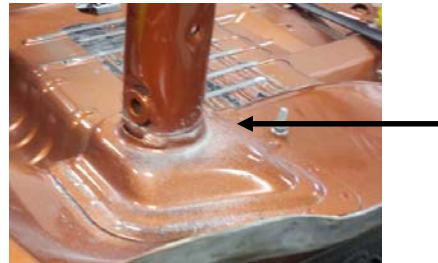
7. Outer B Pillar Panel Removal – Remove spot welds in 67 places per side and remove from vehicle body.



8. Inner Lower B Pillar Panel Removal – Remove B pillar bolts in 2 places. Remove spot welds in 18 places per side and remove from vehicle body. Cut B pillar bar 24” up from vehicle floor pan. Remove any excess foam material in B pillar and lower rocker.



9. Remove Sport Bar – Stabilize B pillar portion of the sport bar when cutting rear portion of the sport bar remove spot welds 16 places per side. Save sport bar to remove upper crossmember.



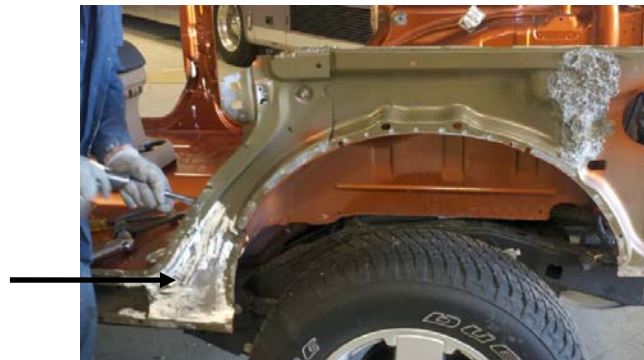
10. Upper Crossmember removal – Remove spot welds in 6 places per side. Keep Crossmember for later install.



SAVE and REUSE Crossmember



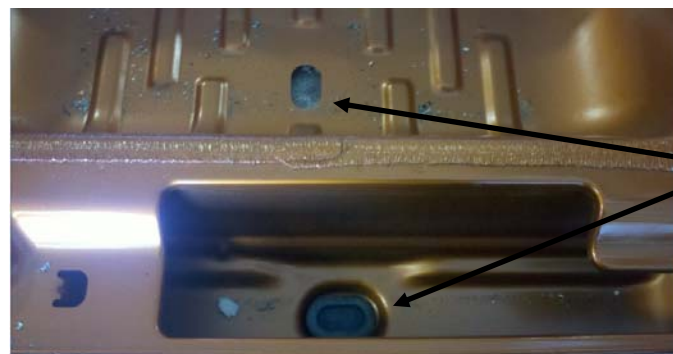
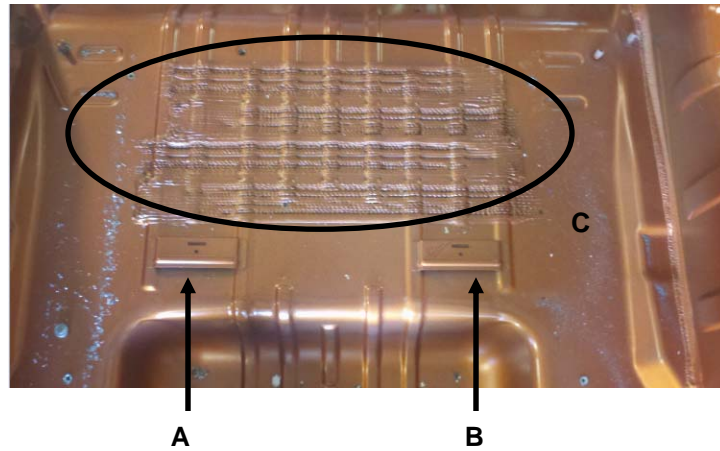
11. Remove Lock Pillar Support.



12. Outer Wheel House Removal – Remove spot welds in 29 places per side remove from vehicle body.



13. Remove spot welds in 4 places on the 2 brackets referenced as A and B. Then, remove any adhesive from the ribs reference C that may affect installation of the floor pan. Also remove any drain plugs in the storage enclosure bumper opening and rear seat area.



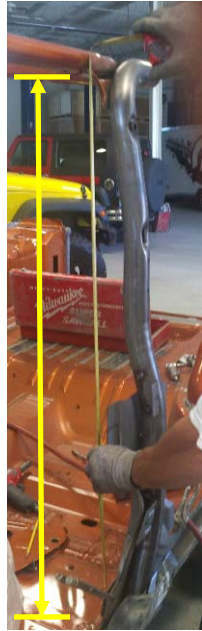
14. Remove any caulk, clean and straighten all edges of metal, sand and prep surfaces for welding.

15. Install Lower B Pillar Panel. Align lower edge with rocker and weld into location. Install b pillar bolts after creating a slot.



Slot Location

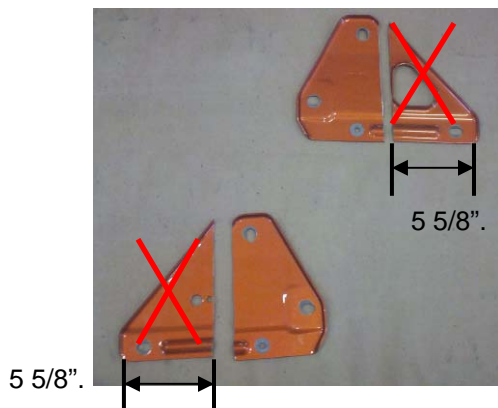
16. Install B Pillar Sport Bar. Measure 44 3/4" from vehicle floor to lower weld on B pillar re-use B pillar bolts and tighten to 48Nm.



17. Weld Upper Crossmember into B Pillar Sports Bar.



18. Cut back hard top brackets 5 5/8". Fasten into place with 3 bolts per side at 20-27Nm.



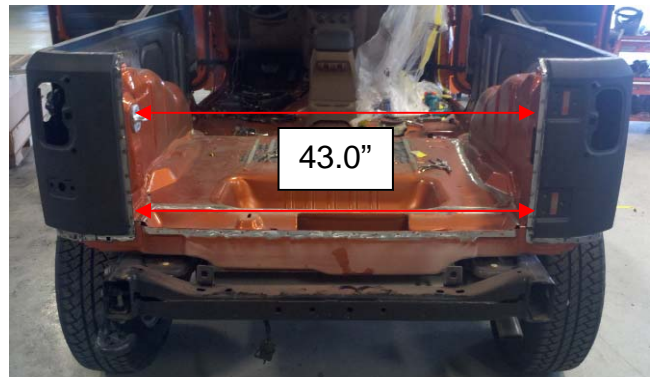
19. To align inner quarter panel align both panels to the bottom clamp outer corner and inner quarter panel together and insert a couple set screws on the inner panels for welding location. Remove outer panel after alignment.



20. Remove outer panel and weld both Inner Quarter Panels to vehicle body remove any set screws and weld holes. Surface Primer grinded areas.



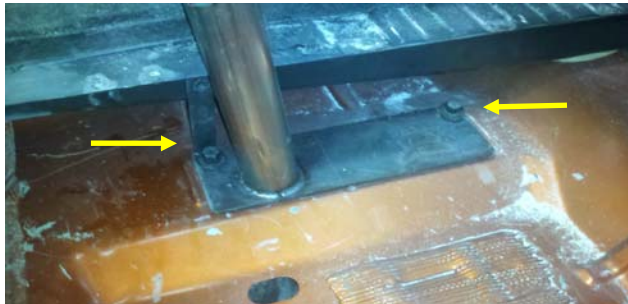
21. Install Outer Quarter Panels. Align holes for tail lamps. Measure width in between Rear Corners to 43.0”.



22. Weld RH/LH Front and Rear Belt Rails.
Align with front and rear locating holes.



23. Install Bulkhead Support Bar. Fasten bracket using rear seat bolts 75Nm and insert bulkhead bar into the B pillar. Fasten center sport bar with M12 bolts to 81Nm.



Install M12 bolts.

24. Install Lower Cross Member – Install the lower bracket hole to the bulkhead bar mounting plate using the same M8 bolt to 75Nm. Dry fit cross member and mark drill locations for the upper bracket hole and center drain hole. Drill 3/8" hole in left and right side lower cross member. Drill 1" drain hole in vehicle floor pan to line up with the center drain hole in the cross member. Align floor pan (G) to lower cross member prior to welding. Apply body adhesive around center drain hole and lip portion of cross member. Place cross member center and use 3/8" bolt at 48Nm to fasten bracket to cross member.

Cross Member



25. Weld Floor Pan – Align with 3 bolt hole locations. After floor pan is welded in fill any holes with body adhesive.

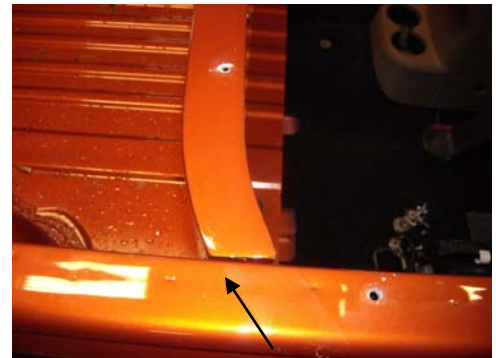


26. Weld Cover Storage – Fit rear cover storage area to floor pan and weld.

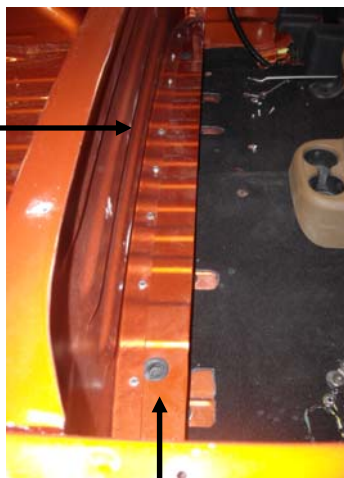


27. Prep vehicle, hardtop and bulkhead for paint at this time.

28. To determine the location of the bulkhead dry fit hard top, remove and mark location on belt rail. Pre drill 13 holes evenly across lower bulkhead surface. 1/8". Install Bulkhead to Floor Pan using 13 1/4" self-tapping bolts. Adhere to inner trim panels with Body Adhesive and then caulk.



Drill 3/4" access holes for bracket access then re-use and insert the access plugs from the rear door handle.



Pre drill 13 holes in this location.

Drain Plug



Install Bulkhead

29. Trim muckets by removing an 1/8" of inch material to the right of white line prior to pressing into place. This will seat the hardtop properly into place.



30. Install Windows into hard top using the hardware kit provided. Holes are pre-drilled. Window frame seam located on the bottom.

31. Install hard top to bulkhead by drilling 5/16" holes reusing hardtop fasteners. Equally space 4 along the back and one on each side of the hard top. Prep bottom hard top surface with alcohol wipe and apply hard top to Bulkhead Seal. Fit hard top seal to hard top. Install freedom panels.



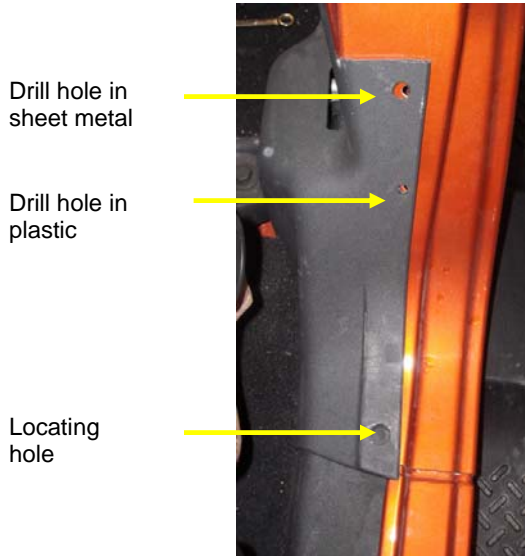
32. Install Side Airbag Sensor. Drill a 3/16" hole 4 1/2" rear ward and 13" from floor pan in the inner b pillar panel. Install 6mm self- tapping bolt in the top hole and then drill the lower 3/16" hole.



33. Trim lower b pillar trim 55mm wide top length 26mm and lower length 75mm.



34. Install lower push pin locating hole. Press trim firmly into place and mark and drill a 1/4" top hole in sheet metal. Center hole is present in sheet metal and 1/4" hole needs to be aligned and drilled in plastic. Locate trim with push pin in top hole. Use paint marker to mark tip of push pin and contact sheet metal. Drill two 1/4" holes to attach lower push pins in sheet metal.



35. Install upper trim panel and wrap upper trim cover. Trim carpet to fit.



36. Use masking tape to align end of badge a ½” from the tailgate and a ¼” up from the tailgate bracket. Prep badge location using alcohol to clean. Make sure vehicle is at room temperature and install badge.



37. Repeat step 2 on the components that are applicable per the Chrysler Manual or TECH Support.