

VEHICLE Nissan Patrol GQ / GU
PRODUCT Front Axle / Diff Housing Lamination Kit
PART NUMBER SB072

NOTE
This job should only be undertaken by qualified and experienced welders.
Control of heat in the weld area is critical to minimise distortion.

1. Jack up front of vehicle; support with jack stands.

2. Remove wheels.

3. Drain oil.

4. Disassemble the axle assembly by removing brakes, hubs, CV & axles, steering, knuckles and differential.

5. Remove the housing from the vehicle.

6. Remove oil, and grease from housing.

7. Mount housing on a support structure. This structure and the method of mounting need to be rigid enough to resist any distortion in the housing due to welding.

8. Reinstall differential centre to maintain shape of differential mounting ring and surroundings.

9. Wrap the diff pinion and plug the tube ends and breather hole with a non-flammable material.

10. To identify areas where paint needs to be removed, place the relevant gussets in their respective positions.

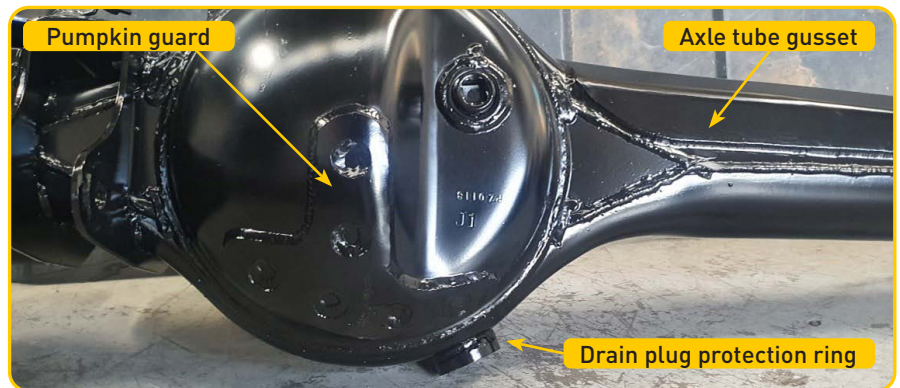
- Axle tube gusset on top of long axle tube.
- Pumpkin guard centralized on the lower leading surface of the pumpkin.
- Drain plug protection ring around the drain plug.
- Bump-stop striker pad on top of the housing bump-stop striker.
- Lower knuckle gusset on the underside of the knuckle ball tube.
- Upper knuckle gusset on the topside of the knuckle ball tube.
- Radius arm bolt washers on the exterior of the radius arm mount.
- Radius arm mount gusset in the corner on the rear side of the axle tube and radius arm mount.

Note: Trimming of gussets may be required for correct fitment and weld clearance.

11. Working from the centre out and from side to side, tack all gussets in place.

12. Intermittently stitch weld, working from the centre out and side to side, ensuring heat is managed throughout the housing.

13. Once welding has been completed, wrap with a heat/fire blanket to control the cool rate.



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14. Once cool remove differential.

15. Remove the material used for blanking off the breather and tube ends.

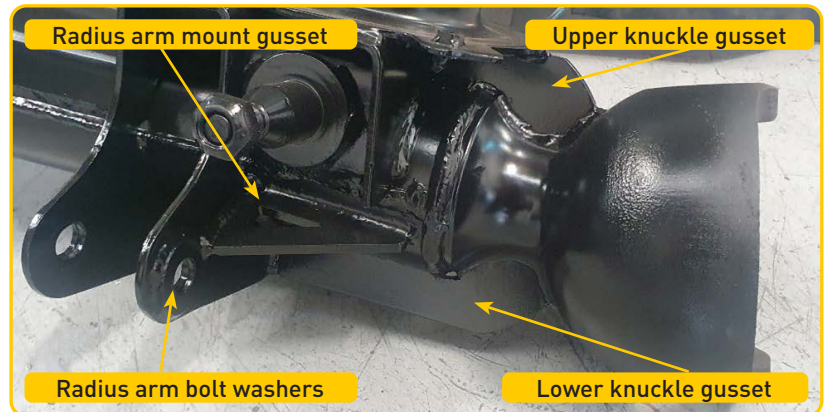
16. Clean thoroughly and paint.

17. Assembly is the reverse of the disassembly process.
a. Install bare housing in radius arms, reattaching Panhard, coils, and shock absorbers.
Do NOT tighten these bolts until vehicle is on the ground at normal ride height!
b. Install differential, knuckles, steering, CV & axles, hubs and brakes, torquing all bolts to factory specifications.
c. Fill oil to specified amount.
d. Fit wheels, torquing wheel nut to factory specifications

18. Lower vehicle onto ground.

19. Tighten radius arm bolts, panhard rod bolts, and shock absorber nuts.

20. Complete a final check to ensure all nuts and bolts are tightened to manufacturers' specification.



IT IS STRONGLY RECOMMENDED THAT THIS JOB IS UNDERTAKEN BY AN EXPERIENCED 4WD WORKSHOP.