

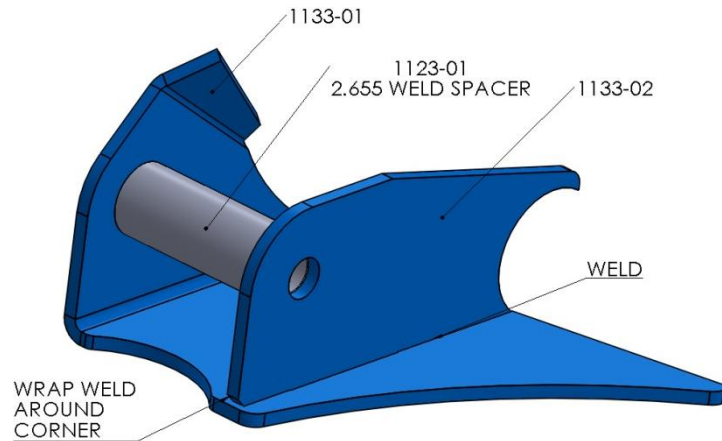


## GOAT BUILT IBEX REAR CHASSIS LOWER CONTROL ARM BRACKET

Thank you for purchasing Ibex chassis kit components, before starting your build, we recommend that you read through these instructions to familiarize yourself with the steps and parts so you can plan and prepare for your built accordingly.

A few notes about the 1133 Ibex link mount bracket:

- For optimum suspension geometry, these bracket are made to use with Ibex 1134 chassis upper control arm brackets, 1132 rear upper control arm truss and 1131 rear axle lower control arm brackets.
- These brackets are designed for use with common suspension joints that are 2-5/8 wide with a 9/16" bolt. The bolt holes can be drilled for larger bolt sizes.
- Take your time to make sure all the parts fit correctly before tack welding. Use a level, digital protractor and tape measure to double check according to the instructions.
- Bolts and lock nuts for the lower control arms are included, plain nuts are included for mock up, wait to install the lock nuts until final assembly. Torque the 9/16 bolts/nuts to 150 ft-lbs during final assembly. Proper bolt torque will insure maximum bolt/bracket strength. Many link bolt and bracket failures can be attributed to improperly torqed bolts..
- We recommend that brackets be welded by MIG or TIG. The person welding must me a competent welder capable sufficient weld penetration and weld quality
- For MIG welding, we recommend 75/25 AR/CO2 shielding gas; we have found that .035 Lincoln Super-Arc L-56 wire works best.
- For TIG welding, use 100% Argon with ER70S-2 filler rod, we like to use 1/16 diameter filler rod with this thickness of material.
- Additional assembly pictures are posted on the website, [www.goatbuilt.com/](http://www.goatbuilt.com/)

**1. LCA Bracket Assembly.**

- 1.1) Bolt the two parts of the bracket together with the included 9/16 bolt, washers and plain nut and the 2.655" weld spacer. The -02 tab should go into the slot of -01. There is a different left and right of the -01 bracket
- 1.2) Weld the two parts together. Wrap the weld around the back edge at least 1/2". Also weld the tab & slot.
- 1.3) There is a different left and right LCA bracket, they should angle outward towards the rear like the image below
- 1.4) Position and tack weld the LCA brackets to the chassis tubes. The bottom of the LCA bracket should be level to the ground and even with the bottom of the chassis tubes. I suggest that you tack weld all the brackets and assemble the rest of the suspension in the chassis just to be sure everything works with your particular set up.
- 1.5) If the LCA brackets are satisfactorily positioned, weld the LCA brackets to the chassis tubes as shown below. If you are welding only one side of a bracket, always wrap the weld around the end of the bracket onto the other side at least 1/2"

