

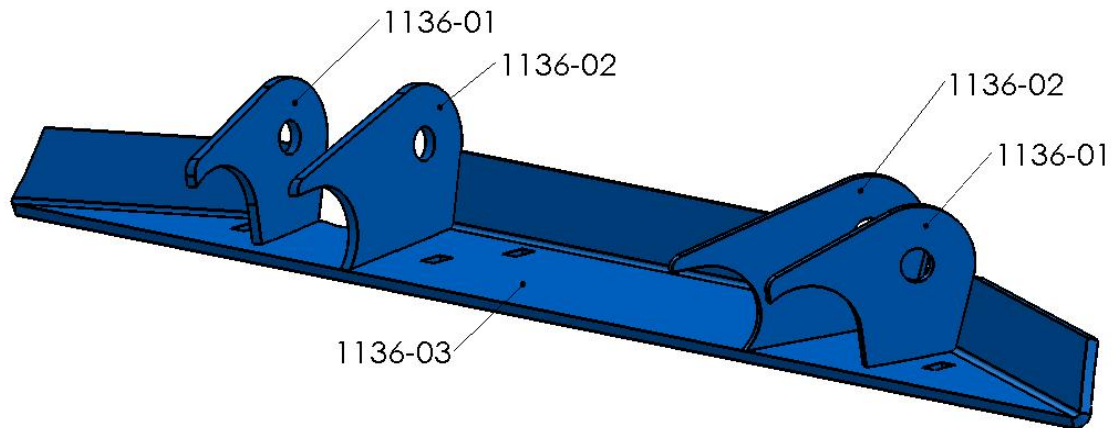


GOAT BUILT IBEX FRONT CHASSIS LOWER CONTROL ARM BRACKET

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 1136 Ibex link mount bracket:

- For optimum suspension geometry, these bracket are made to use with Ibex 1137 chassis upper control arm brackets, 1139 front upper control arm truss and 1138 front 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/

1. LCA Bracket Assembly.

- 1.1) Bolt the 1136-01 and 1136-02 tabs and position on the 1136-03 base plate using the included 9/16 bolts, washers, plain nuts and the 2.655" weld spacers. The -01 & -02 tabs should locate into the slots of -03.
- 1.2) Tack weld the components together
- 1.3) Position the 1136 bracket assembly on the front of the front belly cross bar and tack weld. Make sure the 1136 bracket is centered, the bottom is level and even with the bottom chassis tubes.
- 1.4) Weld the open edges on the front of -01 & -02 and weld down the back of that same seam.
- 1.5) Weld the base of -01 & -02 to top of -03 on the opposite side of the joint.
- 1.6) Weld the split ends of -03 and weld the vertical edges to the chassis tubes
- 1.7) Weld the 1136 bracket to the chassis as shown in the following images. Weld every 3" along the bottom edge and skip every 3" starting at the outside edges.
- 1.8) Weld the tab slots on the bottom of -03

