



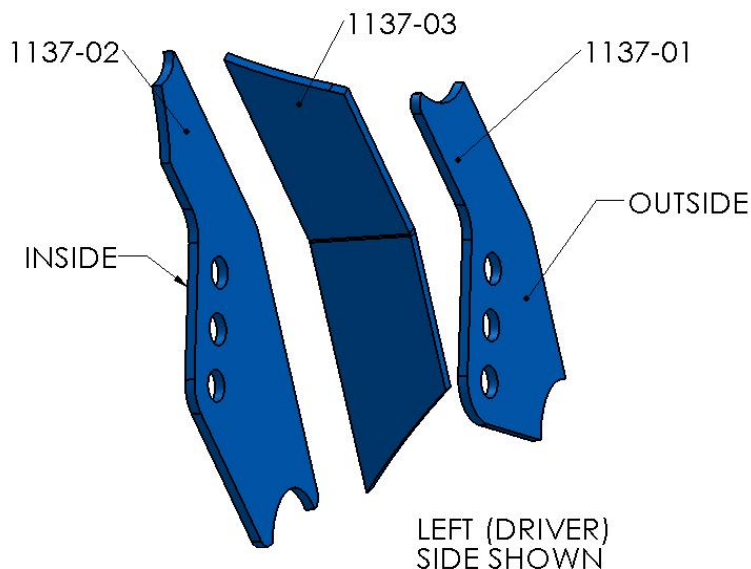
GOAT BUILT IBEX FRONT CHASSIS UPPER CONTROL ARM BRACKET

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 1137 Ibex link mount bracket:

- For optimum suspension geometry, these bracket are made to use with Ibex 1136 lower control arm brackets, 1139 upper control arm truss and 1138 front axle lower control arm brackets.
- These brackets are designed for use with suspension joints that are 2" 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. UCA Bracket Assembly.



- 1.1) Assemble and tack weld one side at a time, the 1137-01 and 1137-02 side plates are the same for both sides, however the 1137-03 center plate has a left and right version.
- 1.2) Bolt the 1137-01 and 1137-02 side plates using the 9/16 bolts, washers, plain nuts and the 2.030" weld spacers. Use 2 spacers in each bracket, one in the top hole, one in the bottom hole. Make sure you put the bolts in the from the outside so you can get them out after the bracket is tack welded in.
- 1.3) Tack weld in position on the chassis tubes as shown below. You may need to grind the top of the -02 bracket to fit the welds in the corner of the chassis floor assembly.
- 1.4) Position the -03 center bracket in-between the side plates and chassis tubes. The -03 center plate should be offset .25" from the side plates, tack weld into place.
- 1.5) Weld the outside of the side plates to the chassis tubes, wrap the weld around the ends and into the inside of the side plates
- 1.6) Weld the -03 center plate to the side plates and chassis tubes.

