



## RZR RADIUS ROD WELD BUNG INSTALLATION INSTRUCTIONS

Step 1: Clean the 4 bungs with a solvent to remove the machining oil.

Step 2: Remove the 4 radius rod bolts, radius rods, and radius rod plate at the frame. If your radius rod bolt threads are damaged you should clean with a die or purchase new bolts. You should not try to reinstall damaged bolts.

Step 3: Use a drill and a  $\frac{3}{4}$ " drill bit to enlarge the 4 radius rod bolt holes. You should also use a larger drill bit or a file to put a small chamfer on the edge of the hole. This helps the weld-in bungs sit flush against the frame.

Step 4: Use a flap disc or wire wheel to remove the powder coating from the frame around the radius rod bolt holes.

Step 5: Insert the 4 weld-in bungs into the radius rod bolt holes. Insert the radius rod bolts through your radius rod plate and your radius rod misalignment spacers or the radius rods themselves. Thread the bolts into the weld in bungs then use some clamps to hold them in place. This helps ensure you have the weld-in bungs aligned/concentric with your radius rod plate.

Step 6: Tack weld each bung in at least 2 places. Remove the clamps, radius rod bolts, radius rods or spacers, and the radius rod plate. Weld the bungs to the frame. We recommend MIG or TIG welding them.

Step 7: Clean the raw metal and apply several coats of primer or paint to prevent rusting. It will be difficult to get the back side but do as much as you can.

Step 8: Apply some red loctite to the radius rod bolts. Reinstall the radius rod plate, radius rods, and radius rod bolts. Torque the bolts according to the factory spec. Torque specs as of 2018: M10 – 42 ft.lbs. M12 – 100 ft.lbs.

