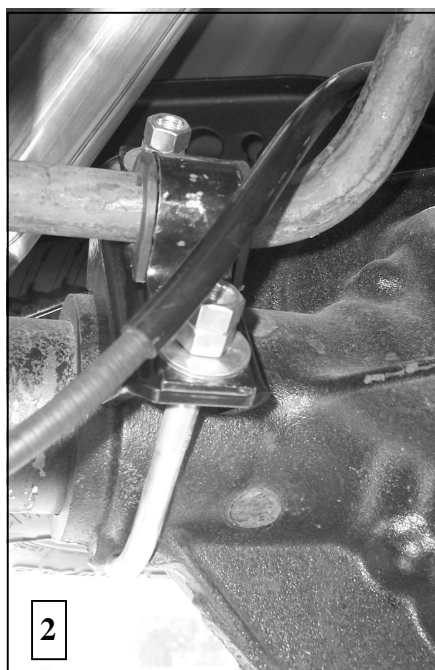# INSTALLATION INSTRUCTIONS
## Rear Stabilizer Bar
## 2WD & 4WD F-250/F-350 Super Duty Except Dual Wheels
**Thank you for purchasing a quality Hellwig Product.**
**PLEASE READ THIS INSTRUCTION SHEET COMPLETELY BEFORE STARTING YOUR INSTALLATION**



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**TORQUE TABLE**
**BOLT SIZE:** 3/8" = 20-30 ft. lbs. – 7/16" = 35-45 ft. lbs. – ½" = 50-70 ft. lbs. – 9/16" = 70-90 ft. lbs.

**SAFETY: BEFORE STARTING YOUR INSTALLATION, BE SURE TO SET PARKING BRAKE AND CHOCK THE WHEELS.**

**NOTE: TO EASE INSTALLATION AND TO PROPERLY ADJUST BAR, THE WEIGHT OF THE VEHICLE MUST BE ON THE SUSPEN-SION, AS IF DRIVING DOWN THE ROAD. DO NOT RAISE THE VEHICLE BY FRAME.**

**NOTE: THIS UNIT IS DESIGNED TO REPLACE THE FACTORY INSTALLED REAR ANTI-SWAY BAR OR AS AN ADDITION IF THE REAR ANTI-SWAY IS NOT FACTORY SUPPLIED.**

**NOTE: THIS KIT INCLUDES LOCK NUTS WHICH REQUIRE TIGHTENING WITH A WRENCH AFTER BEING STARTED BY HAND.**

1. Remove the factory installed rear anti-sway bar (if equipped) and all factory supplied hardware.
2. Locate the half round cast lugs on the differential housing at each side near the axle tubes. Install the U-bolts on the axle between these lugs and install the saddles over the legs of the U-bolts.  Orient the saddle brackets as shown in photos two (2) and three (3).
3. Place the D-shaped poly-bushings onto the straight areas of the bar on each side of the center clearance hump. Place the U-plates over the bushings on the bar, position the U-plates and ploy-bushings as close as possible to the center of the hump. To avoid any possible bushing noise, apply a thin layer grease to the inside of the bushings ( automotive grease can be used ).
4. Disconnect the emergency cable bracket located on the passenger side shock mount.  Save bolt to reattach the bracket later.  Move emergency brake cable out of the way to ease sway bar installation.
5. Place the bar with the bushings and U-plates up over the top of the differential housing. Align the bushings and U-plates so that they align with the U-bolts on the differential. Place the bar bushings and U-plates onto the U-bolts and saddles , attach them with the flat washers and nuts provided. **Leave loose at this time to allow for adjustment later.**
6. Locate the end links and assemble with the poly bushings as in photo (**4**). Insert the hour glass poly bushings through the welded ends of the end links. Insert the steel sleeves through the hour glass poly bushings. ( To ease installation lightly grease the steel sleeve and the hour glass bushing before assembling ).
7. Attach the end links to the frame rail as shown in photo four (4).  Install jam nut and hex nut on end link in position shown in photo four (4).
8. Raise the arms of the sway bar and install the end link bushings on the arms of the sway bar as shown in the photos with the locknut on the bottom of the end link.   Tighten the nuts until the poly bushings start to bulge. Do not over tighten or damage can occur to the poly bushings.
9. Align the bar to be as centered on the differential as possible , and so that the arms are as level as possible. Move the bar axle, axle mounting hardware and the frame brackets so the bar is aligned properly. The bar should have clearance on all undercarriage components. Tighten all of the mounting hardware to the specified rates. Be sure to move any lines, wires or hoses on the axle or the inside of the frame to avoid any damage. **Double nut the axle U-bolts.**
10. Bounce the vehicle checking for clearance on all undercarriage components shocks, exhaust etc… test drive the vehicle and recheck your installation. **Recheck periodically on a regular basis thereafter.**

**ATTENTION INSTALLER: BE SURE THE CUSTOMER RECEIVES THIS INSTRUCTION SHEET, ALL WARNING AND NOTE CARDS AND THE WARRANTY FORM.**

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