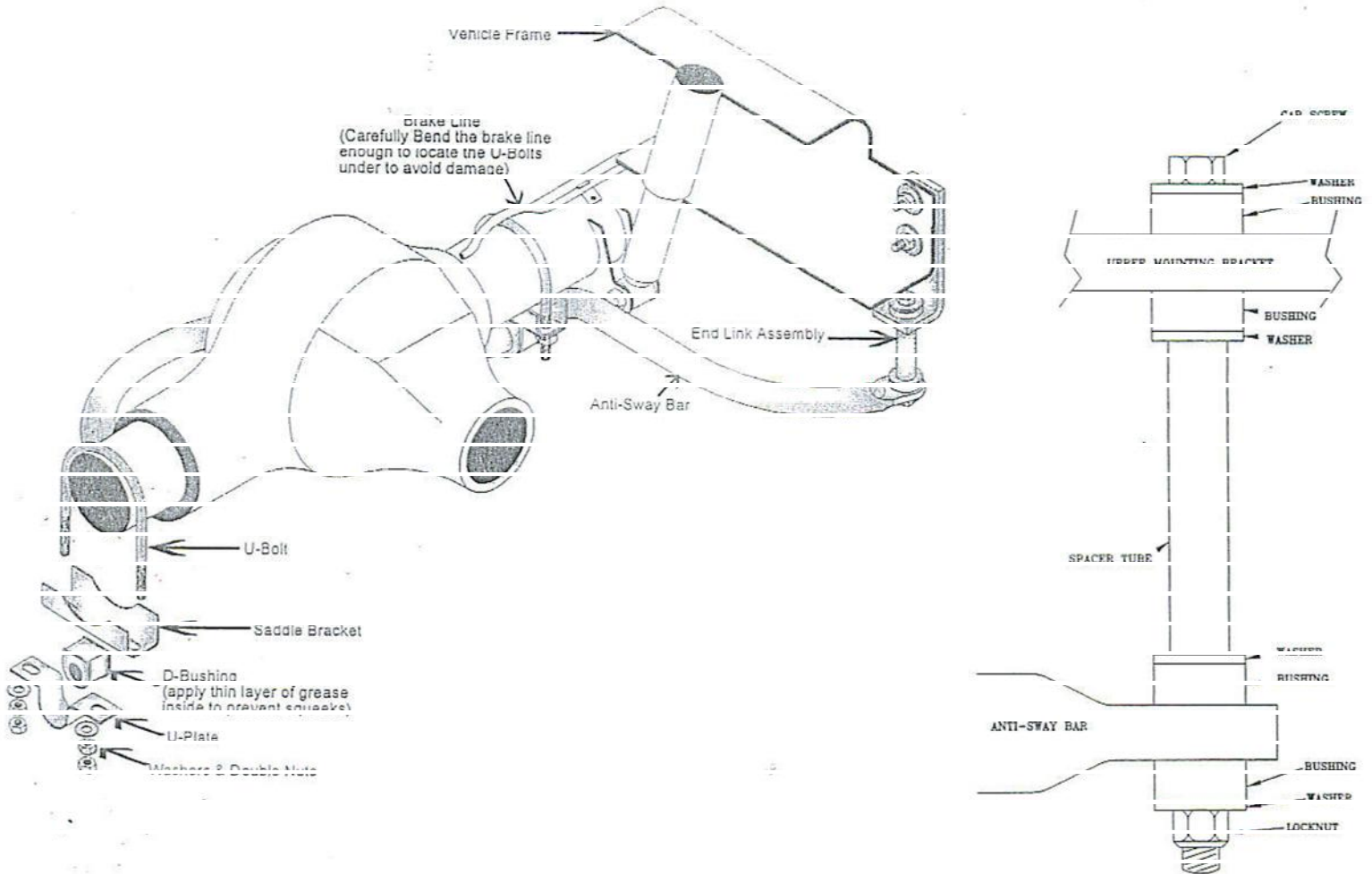


# HELLWIG INSTALLATION INSTRUCTIONS

FACTORY & GENERAL OFFICES - 16237 AVENUE 296, VISALIA, CA - (559)-734-7451

PLEASE READ THIS INSTRUCTION SHEET COMPLETELY BEFORE STARTING YOUR INSTALLATION



## Torque Rates

3/8" = 20-30 ft. lbs.	7/16" = 35-45 ft. lbs.
1/2" = 50-70 ft. lbs.	9/16" = 70-90 ft. lbs.

**IMPORTANT: IT WILL BE NECESSARY TO REVERSE THE LOWER SHOCK BOLTS SO THAT THE HEAD OF THE BOLT IS TOWARD THE DIFFERENTIAL AND SO THE THREADS ARE TOWARD THE TIRE.**

**NOTE: THIS UNIT IS DESIGNED TO MOUNT TO THE REAR AXLE WITH THE ARMS OF THE BAR TOWARD THE FRONT OF THE VEHICLE.**

1. Place the D-bushings onto flat areas of bar on each side of the center hump.
2. Place bar under axle tubes and differential with arms toward front of vehicle, center bar around differential.
3. Place U-bolts onto axle tubes to align with bushings on bar. Be sure to place U-bolts under any brake lines, wires or hoses on axle to avoid any possible damage when tightened.
4. Place U-plates onto D-bushings on bar. Place axle saddle brackets onto U-bolts on axle tubes. Raise bar up and attach bar with flat washers and double nuts provided. Leave loose at this time to allow for adjustment. See diagram.

**Diagram.**

5. Attach end-link assembly and frame angle brackets to end of bar. See diagram. Leave loose at this time for adjustment. Tighten end-links only until bushings start to bulge slightly. **DO NOT OVER TIGHTEN end-links or damage to the bushings will result.**
6. Rotate ends of bar upward so the two holes in the frame angle brackets align with the two holes in the side of the frame rails. On some vehicles it may be necessary to drill the two holes in the frame rails. Rotate axle U-bolts as needed to align end-links in as straight up positions as possible.
7. Attach angle brackets to frame with bolts, flat washers and lock nuts provided. Leave loose.
8. Align bar to be centered between shocks as well as possible. Check for clearance on shock bolt heads and differential housing. **Be sure axle U-bolts are under any brake lines, hoses or wires on axle tubes. Be sure frame bracket mounting bolts, washers and lock nuts are under any vehicle components in frame rails to avoid pinching when tightened.**
9. Torque mounting hardware to specified rates. Double nut axle U-bolts.
10. Bounce vehicle checking for clearance on all undercarriage components. Test drive vehicle and recheck your installation. Recheck your installation after two weeks driving and periodically thereafter

**ATTENTION INSTALLER: BE SURE CUSTOMER RECEIVES THIS INSTRUCTION SHEET, WARNING CARD AND WARRANTY FORM**