

# **Installation Instructions for 64090, 64670 & 64672**

## **Ladder Bar Suspension**

555-64090(Cross Member), 555-64670(Non-Adj. Ladder Bar) & 555-64672(Adj. Ladder Bar)

**NOTE:** This kit contains Mild Steel components that require assembly using the GTAW (TIG) or GMAW (MIG) welding process.

1. First determine the location of the front ladder bar cross member. Using the diagram below (Ladder Bars and Cross Members Sold Separately)
2. Slide the ladder bar crossbar cross member brackets onto the cross member. Now tack weld the ladder bar cross member into place. Bolt two of the 3/4" rod ends between the cross member brackets. Make sure that the bolts are tight to eliminate play between the brackets. Use a level to ensure that the brackets are tacked on a level and square to the chassis.
3. Measure the distance between the front chassis brackets and use this dimension to determine the proper location of the axle bracket. Use the four solid rod ends between the axle brackets for proper alignment. Slide the axle brackets on to the axle tubes. Tack weld the brackets into place making sure that the front edge of the bracket is perpendicular to the pinion centerline. Always double check the bracket spacing before tack welding the axle bracket to the axle tubes. On some applications the I.D. of the axle bracket may need to be enlarged. We recommend using a round file or a die grinder to complete this task.
4. Remove the rod ends from the cross member and the axle brackets. Position the axle under the vehicle. Make certain the pinion is the drivetrain centerline of the vehicle and that the axle tubes are square to the center line. With the axle in the desired wheel base position.
5. Install the jam nuts onto the rod ends. Thread them all the way up. Now thread the tube ends onto the rod ends half way up the treads and snug up the jam nuts. Now insert each rod end into each end of the ladder bars.
6. Install the ladder bar assemblies onto axle bracket using the 5/8" hardware supplied.
7. Install the top ladder bar assemblies into the third hole down on the cross member bracket holes using the 3/4" hardware supplied.
8. Make sure all dimensions are checked and in place.
9. Remove the ladder bar assemblies. Check the brackets for alignment and being square. Finish welding the Cross member brackets to the cross member and the Axle brackets to the axle tubes. We recommend welding 1" at a time, switching back and forth between brackets to prevent distortion.
10. Once welding is finished and cooling is complete. Install your ladder bar assemblies; once those are installed you are ready to set up your ladder bar.

**NOTE: Always use anti-seize compound on all threads when assembling the ladder bars.**



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