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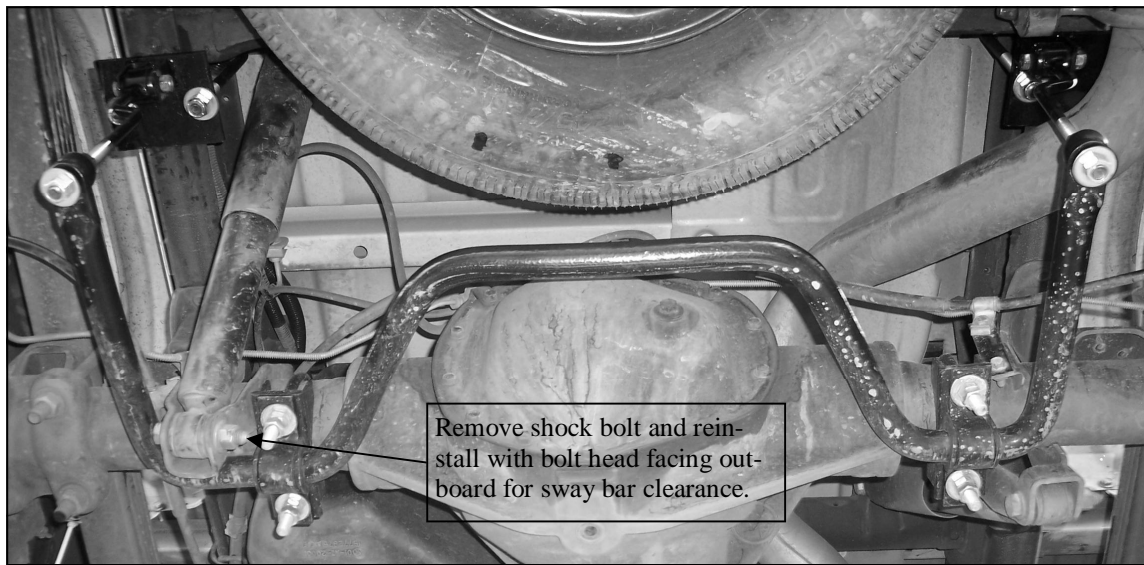
559-734-7451 800-367-5480 FAX 559-734-7460

INSTALLATION INSTRUCTIONS

Rear Stabilizer Bar 7652

GM 2500HD-3500HD 2WD-4WD

Thank you for purchasing a quality Hellwig Product.



TORQUE TABLE

Bolt Size 3/8" — 25 ft lbs * Bolt Size 7/16" — 35 ft lbs* Bolt Size 1/2" — 60 ft lbs *

SAFETY: BEFORE BEGINNING INSTALLATION BE SURE TO SET THE PARKING BRAKE AND CHOCK THE WHEELS.

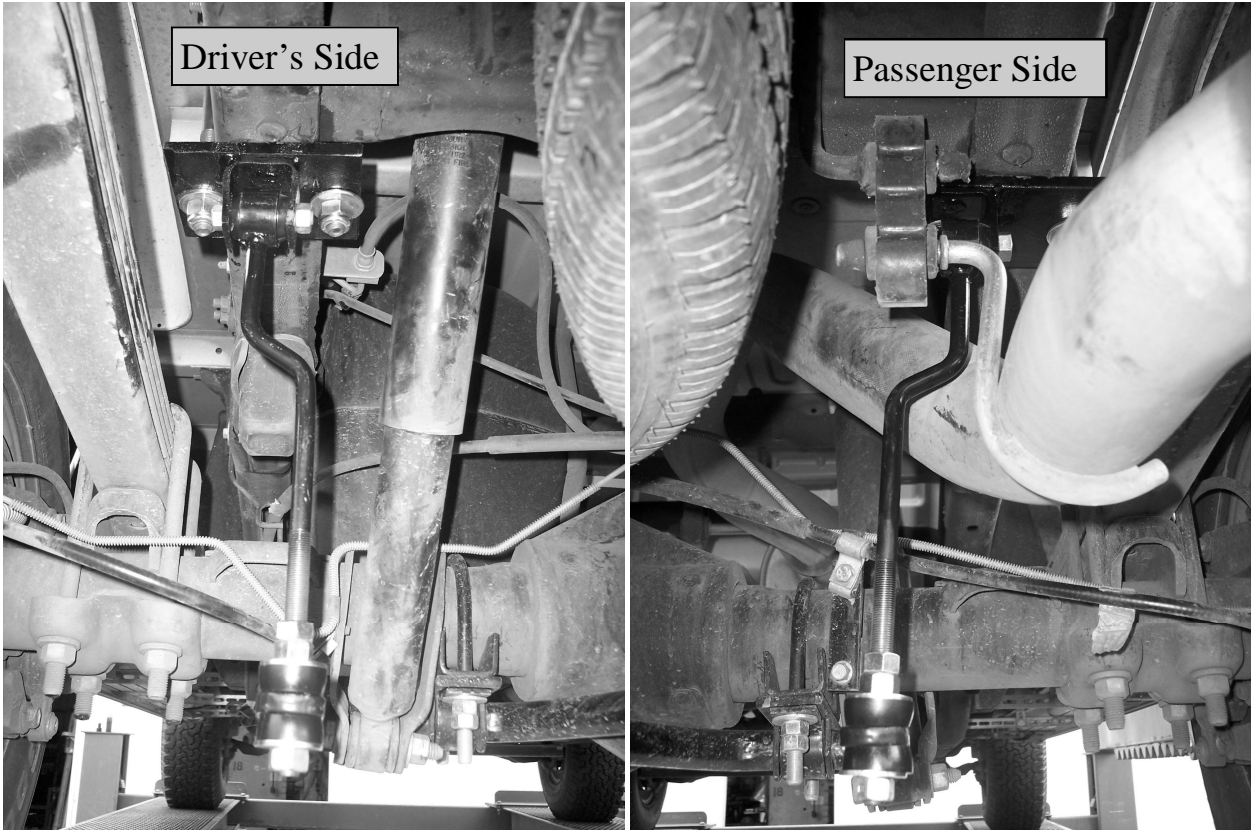
NOTE: TO EASE INSTALLATION AND PROPERLY ADJUST THE BAR, THE WEIGHT OF THE VEHICLE MUST BE ON THE SUSPENSION AS IF DRIVING DOWN THE ROAD. DO NOT RAISE THE VEHICLE BY THE FRAME.

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

1. Place the D shaped bushings onto the straight areas of the bar on each side of the center hump.
2. Hold bar up to the axle and locate the position on the axle tubes to mount the u-bolts. **Be sure to put the U-Bolts Under Any Brake Lines, Wires or Hoses on the Axle to Avoid Any Possible Damage.** The threads of the U-Bolts will point down.
3. Remove brake cable/line bracket from axle and use single flat plate to relocate higher.
4. Place saddle brackets onto the U-Bolts on the axle tubes. The saddle brackets have different radius to accommodate the taper in the axle tube. If they do not sit square, reverse their orientation. Place the U-Plates over the D shaped bushings on the bar and attach the bar to the U-Bolts and saddle brackets with the flat washers and nuts provided. **LEAVE LOOSE AT THIS TIME** to allow for adjustment later. **For additional bar clearance remove the driver side lower shock bolt, turn it around and reinstall from the opposite side of the lower shock bracket.**

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5. Locate existing spare tire crossmember on vehicle frame. Place square U-bolt over the frame rail in front of the crossmember with legs of the U-bolt pointing downward.
6. Insert the legs of the U-bolt into slotted holes of the frame brackets. Using 1/2" locknuts and washers, install the frame bracket with the centered clevis on the driver side of vehicle as shown in photos. Install the frame bracket with the offset clevis on passenger side of vehicle as shown in photos. **LEAVE LOOSE** for adjustment later. (**FINAL TIGHTENING ON FRAME U-BOLTS : Push out u-bolt leg against frame rail. Snug nuts to frame bracket then torque outboard nut first to 20 ft-lb and then inboard nut to 20 ft-lb. Final torque outboard nut first to 35 ft-lb and then inboard nut to 35 ft-lb.**)
7. Insert hourglass bushing and then sleeve into end link assembly. **Lubricate the bushing and sleeve to ease assembly.**
8. Attach end links to clevis on frame bracket as shown using the 7/16 x 2 1/4" bolts. **LEAVE LOOSE** for adjustment later.
9. Raise bar ends upward to be level with the frame and attach end links to sway bar ends as shown in photos using the hardware provided. Use the 1/2" lock nut on the end of the end link assembly.
10. Align bar from side to side through the D-bushings to be as centered as possible. Rotate bar front to rear by rotating the U-Bolts on the axle. Adjust frame brackets so that the end-links are straight up and down as possible. **Be sure the bar does not contact the differential, shocks, or leaf springs.**
11. Torque all of the mounting hardware to the specified rates. Double-nut axle u-bolts with supplied nuts and tighten to lock nuts together. Bounce vehicle, checking for clearance on all undercarriage components, ie: exhaust, shocks, fuel lines, brake lines, etc.
12. Recheck installation periodically on a regular basis.

ATTENTION INSTALLER: PLEASE MAKE SURE CUSTOMER RECEIVES THIS INSTRUCTION SHEET, ALL IMPORTANT NOTE CARDS, WARNING CARDS AND THE WARRANTY FORM