



Thank you for purchasing this axle mounting kit. Please read through these instructions before installation.

Installation Instructions

Axle Mounting Kit for Chevy 2500/3500 Cutaway chassis

part #590061-00

Note: This kit should only be used in conjunction with the 1109-150 rear anti-sway bar kit.

INTRODUCTION

Thank you for purchasing this axle mounting kit. This kit is designed to improve the handling characteristics of your Chevrolet by reducing the body roll and balancing the weight transfer during cornering. This kit is engineered for long life and trouble-free performance.

All the hardware needed for installation is included in this kit. Refer to the PARTS LIST in these instructions to identify the parts.

SUGGESTED TOOLS

The following tools are suggested to complete the installation procedures:

- General hand tools

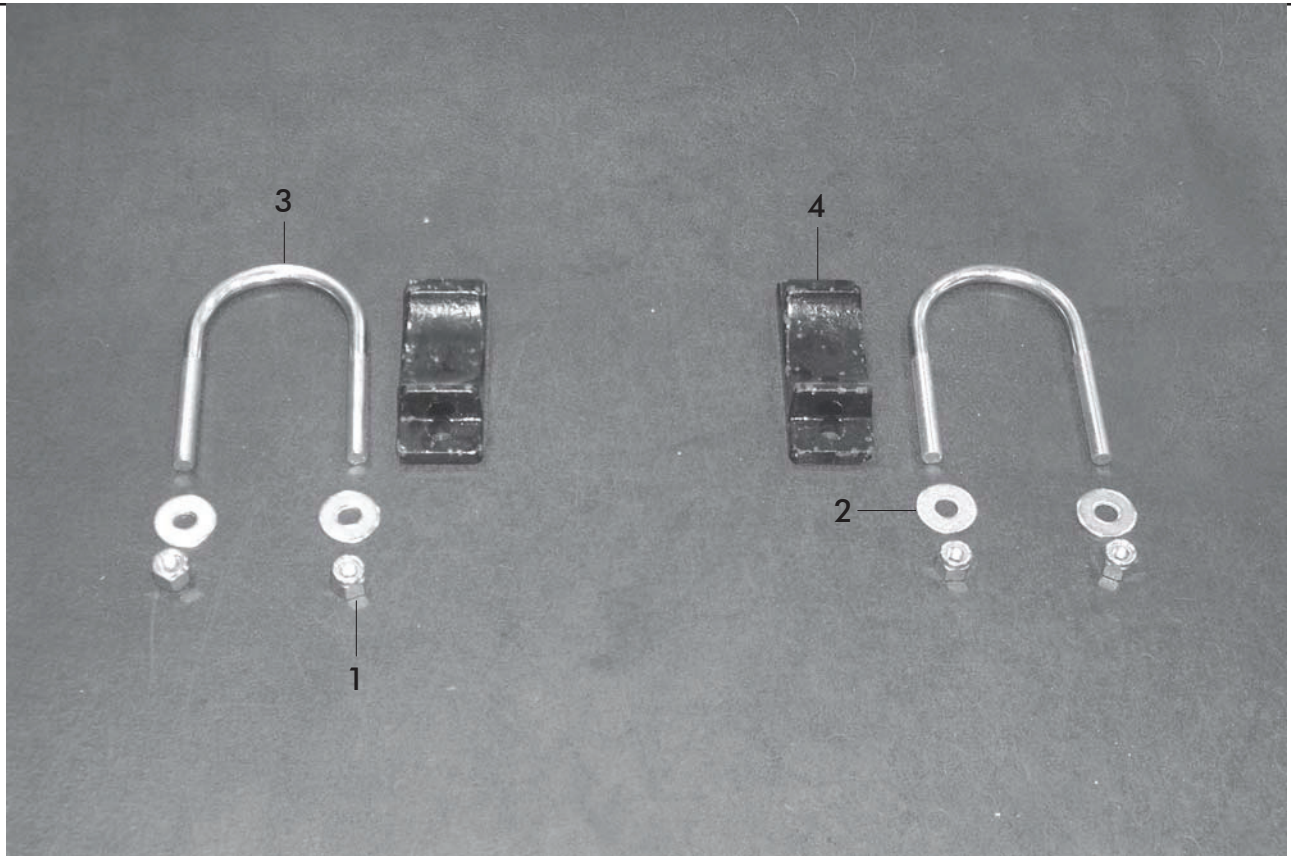
WARNING

- If raising the vehicle to install the anti-sway bar, always support the vehicle with jack stands at both frame rails or at the rear axle before working underneath. Ensure that the jack stands are securely positioned, and are rated at or above the weight of the vehicle.
- The installer must read the instructions and use all bolts and parts supplied. Use only the parts supplied by ROADMASTER to install this kit.
- Minor modifications are sometimes necessary due to slight vehicle variations, even for the same year, make and model.
- If running changes were made by the manufacturer after this kit was designed, there may be weldments, braces, gussets, or other structural items which interfere with the installation. It is the installer's responsibility to allow for these running changes without sacrificing the structural integrity of the anti-sway bar. Failure to securely fasten the anti-sway bar could result in property damage, personal injury or even death.
- ROADMASTER will not be responsible for any damage or injury resulting from any modification or alteration.
- Check ALL the fasteners for tightness before and after road testing the vehicle.
- Do not use this document for custom fabrication, as it may not show all parts or structural components.
- Do not use an air impact wrench when re-installing bolts, as stripped threads may result.
- This anti-sway bar is only warranted for the original installation. Installing a used anti-sway bar on another vehicle is not recommended and will void the warranty.

WARNING

Failure to follow these instructions can result in property damage, personal injury or even death.

PARTS LIST



Part #590061-00

| Part # | Description | Qty |
|--------------|-------------------|-----|
| 1. 350259-01 | Locknut 1/2" N200 | 4 |
| 2. 350308-00 | Washer 1/2" | 4 |
| 3. 357359-00 | U-bolt | 2 |
| 4. 480013 | Bracket, flat | 2 |

INSTALLATION

The following instructions must be followed in the order listed to ensure a proper installation and to preserve the ROADMASTER warranty.

1. Install the U-bolts for the anti-sway bar mounts.

Install each U-bolt about 6" inboard of the springs on the axle housing. Use a screwdriver to carefully bend the brake lines away from the axle so that the U-bolts will fit between the brake lines and the axle housing (Figure 1). Insert the U-bolts from the front.

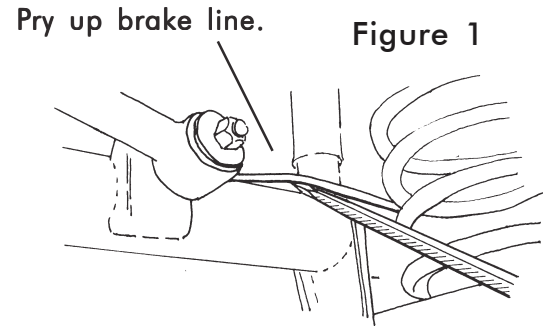


Figure 1

2. Install the assembly on the axle housing.

Lubricate the inside of the split bushing with the provided lubricant (Figure 2). Install the split bushings on the anti-sway bar and slide the saddle brackets over the split bushings. Install the U-bolt flat bracket on the U-bolt. Position the anti-sway bar so that the arms are toward the rear and the bend in the center is down. Lift the anti-sway bar/bushing assembly to the axle housing and install the washers and nuts on the U-bolts (Figure 3.) Do not tighten at this time.

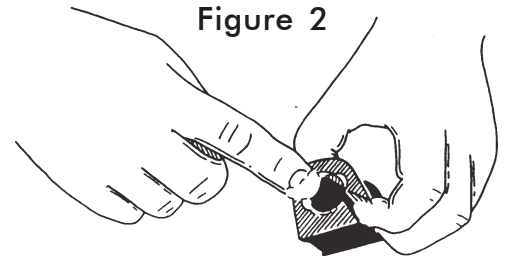


Figure 2

3. Drill holes in the frame for link bolts.

Install link assemblies on the anti-sway bar ends. Install the cup washers, grommets, and links to the anti-sway bar (Fig 4). Install and finger tighten the nut. Tighten the U-bolts to 65 ft./lbs.

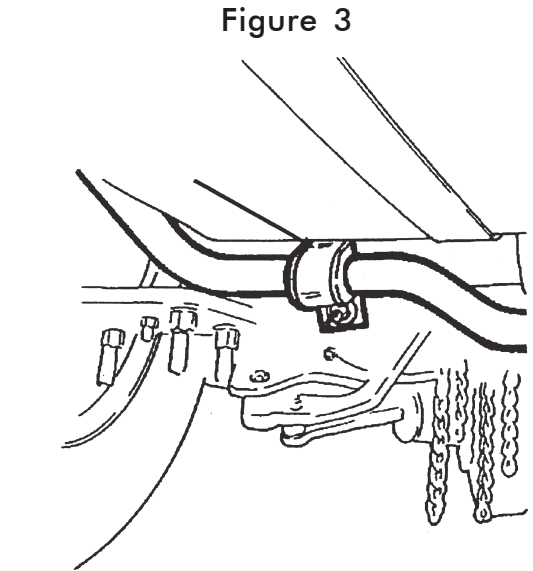


Figure 3

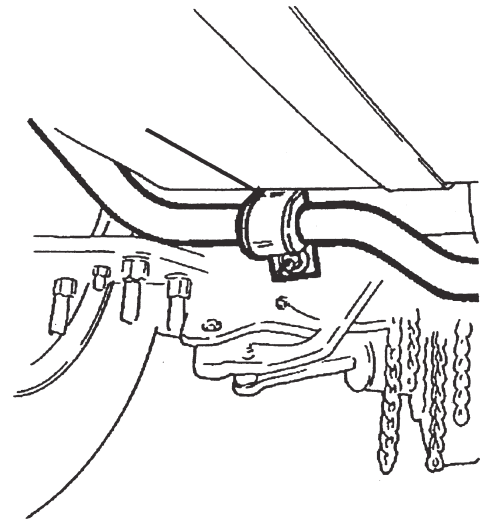


Figure 4

! WARNING

Make sure that the U-bolts are between the brake lines and the housing. If the U-bolts are over the brake lines, friction will cause the lines to rupture, causing a loss of brake fluid. The brakes will no longer function. Failure to follow these instructions may result in property damage, personal injury or even death.

**BOLT TORQUE REQUIREMENTS
STANDARD BOLTS**

| Standard Bolt | | | U-bolts | |
|---------------|-------|--------------|---------|--------------|
| Thread | Grade | Torque | Thread | Torque |
| 3/8 | 5 | 30 ft./lbs. | 3/8-24 | 35 ft./lbs. |
| 7/16 | 5 | 50 ft./lbs. | 1/2-20 | 70 ft./lbs. |
| 1/2 | 5 | 75 ft./lbs. | 5/8-18 | 140 ft./lbs. |
| 5/8 | 5 | 140 ft./lbs. | 3/4-16 | 250 ft./lbs. |
| | | | 7/8-14 | 400 ft./lbs. |

Note: Endlink bolts use grommets and should NOT be torqued. Tighten these bolts by hand until the grommet starts to deform. Also, these torque values are intended as general guidelines. Roadmaster does not warrant this information to be accurate for all applications and disclaims all liability for any claims or damages which may result from its use.

