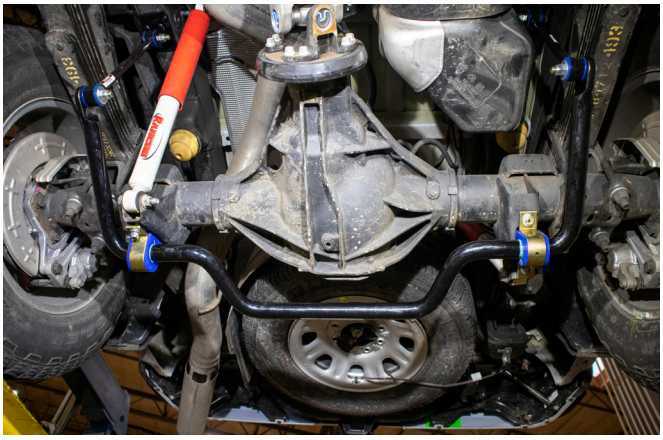
85- 6106 rev. 05 08-23

Installation Instructions

Thank you for purchasing this anti-sway bar kit. Please read through these instructions before installation.

Rear Anti-Sway Bar Kit for Chevy/GMC 2500/3500

part #1109-101
1-1/2" diameter



INTRODUCTION

Thank you for purchasing this anti-sway bar kit. This kit is designed to improve the handling characteristics of your vehicle by reducing the body roll and balancing the weight transfer during cornering. The anti-sway bar 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:

- Standard and metric hand tools
- Jack stands (2)

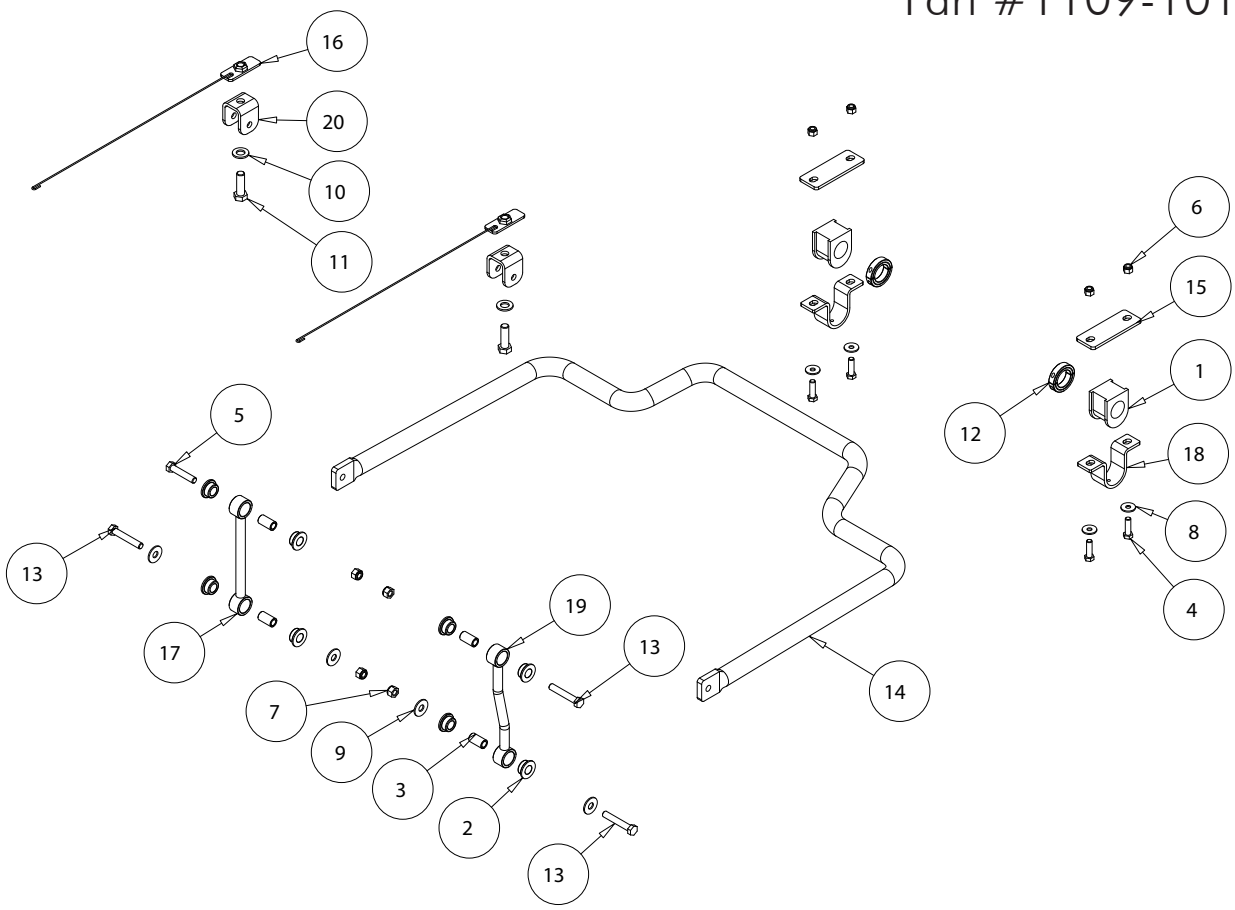
⚠ WARNING

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

- 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.
- Regardless of year, make and model, a wide range of options for specific applications may or may not interfere with the installation. It is the installer's responsibility to make certain that equipment is not damaged once the suspension solution travels through the full range of motion. Failure to ensure adequate clearance could result in non-warranty property damage, personal injury or even death.
- 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 warranteed for the original installation. Installing a used anti-sway bar on another vehicle is not recommended and will void the warranty.

PARTS LIST

Part #1109-101



ITEM	QTY	MATERIAL	NAME
1	2	BUSHING	205217-10
2	8	BUSHING	205223-50
3	4	BUSHING SLEEVE	205522-00
4	4	7/16-14 x 1 1/2” BOLT - GRADE 8	350074-50
5	1	1/2-13 x 2 1/2” BOLT - GRADE 8	350099-80
6	4	7/16-14 NYLON INSERT LOCK NUT	350257-00
7	4	1/2-13 NYLON INSERT LOCK NUT	350259-00
8	4	3/8” HARDENED WASHER	350304-80
9	4	1/2” FLAT WASHER	350308-00
10	2	5/8” SAE WASHER	350348-80
11	2	5/8-11 x 2” BOLT - GRADE 8	350453-00
12	2	SPLIT COLLAR	350530-10
13	3	1/2-13 x 3” BOLT - GRADE 8	350706-00
14	1	ANTI-SWAY BAR	580551-00
15	2	PLATE	B1081
16	2	BACKING PLATE	B1083
17	1	END LINK	B1128
18	2	BUSHING CLAMP	B141
19	1	END LINK	B589
20	2	FRAME BRACKET	B765
21	1	AQUALUBE	400011-30
22	1	LOCTITE	200544-00

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 passenger side brackets.**
   On the passenger side only, locate the large frame hole and insert the supplied backing plate with wire rod (B1083) from the outside of the frame rail. Fish the B1083 up the frame rail (toward the front of the vehicle) to the oblong hole located on the bottom of the frame rail (Figure 1). *Note: The large frame hole is located forward of the rear axle but rearward of the shocks.*

2. **Install the frame brackets.**
   Using the supplied 5/8" bolt, 5/8" washer and B765 frame bracket, loosely secure it to the B1083 you installed in the previous step (Figure 2).

3. **Install the driver's side brackets.**
   On the driver's side only, you will need to unbolt the rearward tank strap on the frame rail side. Allow the tank to hang down for now and support it, as needed. Now, loosen the brake line support bracket off from the frame rail, to allow more clearance to gain access to the large hole in the frame rail. Now, repeat steps 1 and 2 for the driver's side.

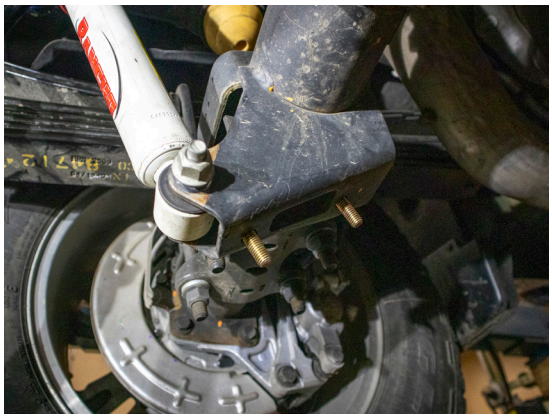
4. **Prepare the anti-sway bar for installation.**
   On each side, remove the lower shock bolt and nut and loosen the upper nut to swing the shock out of the way. *Note:* If your shock mounts are equipped with weld nuts, you will need to drill them out using a 7/16" drill bit in order to allow clearance for the new hardware. Reinstall each shock, replacing the factory bolts. On the passenger side, you will need to bolt from the outside toward the inside of the vehicle. The driver's side shock bolt reinstalls the same as it was removed. On each side, insert two 7/16" x 1½" bolts through the shock mounts, utilizing the holes you just drilled (Figure 3).

continued on next page

Figure 1

Figure 2

Figure 3



INSTALLATION

5. Attach the end links to the frame brackets.
Note: Use the drawing on page 2 as a reference to locate the end links, which are side-specific. Ensure that the correct end link is used on each side before proceeding.

On the passenger side, use the ½" x 3" supplied hardward to attach each end link to the frame bracket. On the driver's side, use a ½" x 2½" bolt and ½" nut to allow clearance for the gas tank (Figure 4).

6. Install the anti-sway bar.
Hang the anti-sway bar from the end links and loosely bolt them together on each side using the supplied ½" x 3" bolt. Finish the bolts using the supplied ½" flat washers and ½" Nylock nuts (Figure 5).

7. Install the anti-sway bar.
Lubricate the bushings and install the bushings and their clamps on the anti-sway bar. Then, rotate the anti-sway bar up so that the bracket clamps align with the shock mount bolts. Finish the bolts with 7/16" flat washers and 7/16" Nylock nuts (Figure 6).

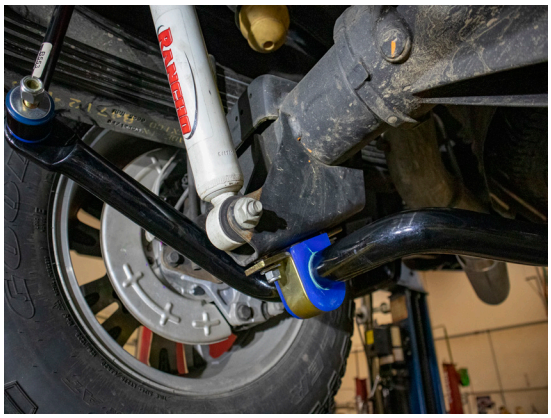
8. Center the anti-sway bar and tighten.
Make sure that the anti-sway bar is centered on the frame, then tighten the bushing clamp bolts on each side (Fig.6) and install the set collars. *Note: The set collars are not shown in these photos. Please refer to the drawing on page 2 to ensure proper placement.*

9. Test drive the vehicle.
Drive the vehicle and then carefully check all the fasteners for proper tightness.

Figure 4

Figure 5

Figure 6



⚠WARNING

After road testing, re-check all fasteners for proper tightness — if a fastener has worked loose or fallen off, re-tighten or replace it. Without all kit components properly tightened or in place, the anti-sway bar will not stabilize the vehicle at full capacity, which may cause reduced cornering ability or other reductions in vehicle handling or performance.

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

⚠WARNING

The anti-sway bar is not a load-bearing component

Do not tow or hoist the vehicle using the anti-sway bar or its mounting brackets as attachment points. The anti-sway bar is not designed to carry the weight of the vehicle and may collapse, which will damage the anti-sway bar components, the suspension, or other components. The vehicle will detach or fall, which may cause severe personal injury.

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