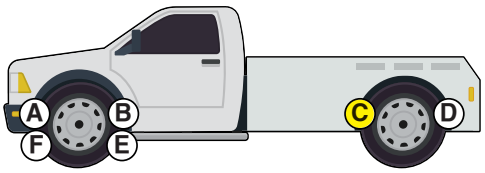


Installation Instructions

Ford F250/350 Rear Anti-Sway Bar Kit

part #1139-210
1-1/2" diameter

INTRODUCTION

Thank you for purchasing this rear anti-sway bar kit. This kit is designed to improve the handling characteristics of your Ford F250/F350 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:

- General hand tools

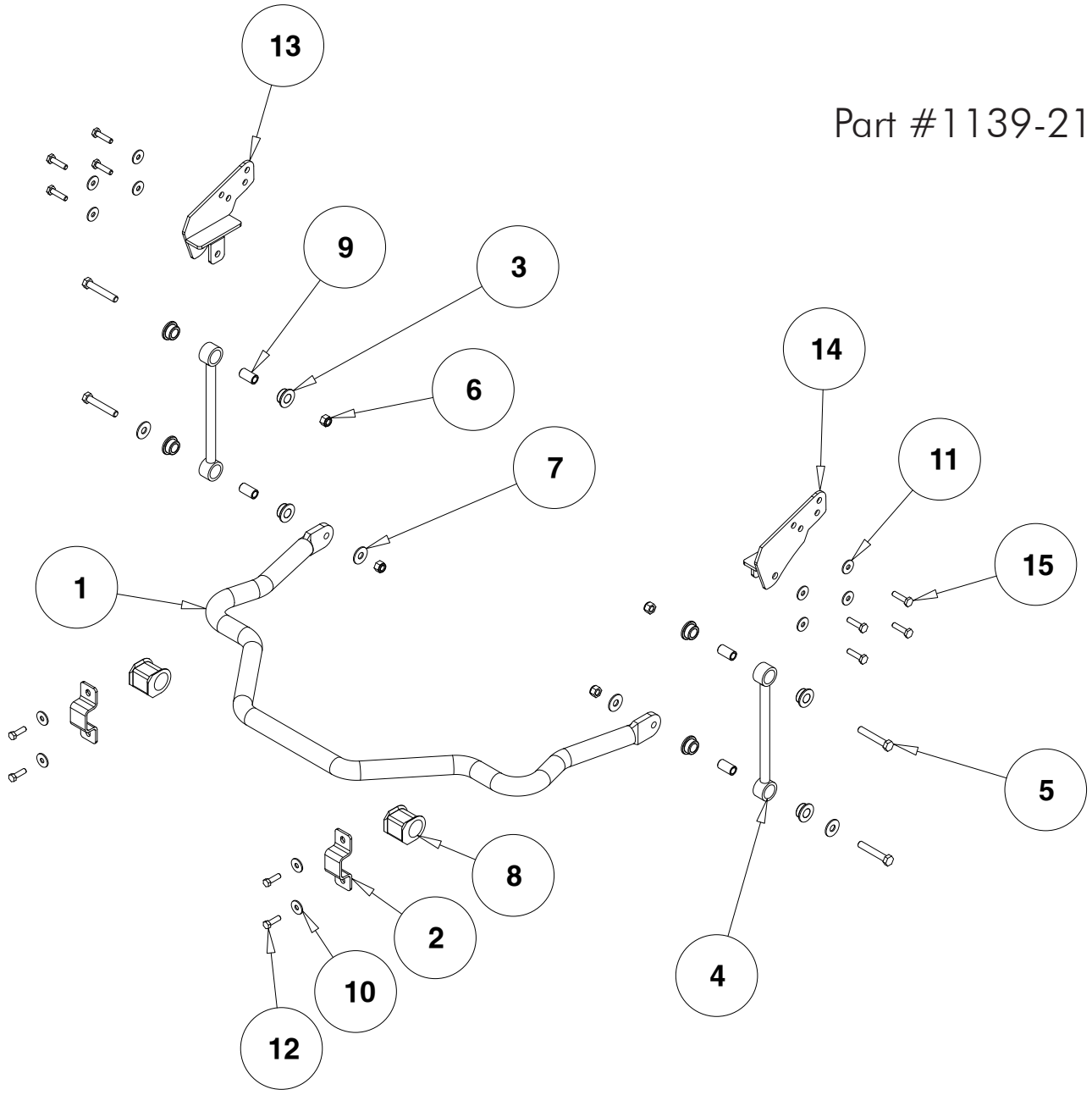
⚠ WARNING

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 #1139-210



ITEM	QTY	MATERIAL	NAME
1	1	SWAY BAR	580560-00
2	2	BUSHING CLAMP	B1032
3	8	BUSHING	205223-50
4	2	END LINK	B315
5	4	1/2-13 x 3” BOLT - GRADE 8 - YELLOW ZINC	350706-00
6	4	1/2-13 NYLON INSERT LOCKNUT	350259-00
7	4	1/2” FLAT WASHER	350308-00
8	2	BUSHING	205253-10
9	4	BUSHING SLEEVE	205522-00
10	4	3/8” FLAT WASHER	350304-00
11	8	3/8” FLAT WASHER - HARDENED	350304-80
12	4	3/8-16 x 1 1/4” BOLT - GRADE 8	350056-20
13	1	FRAME BRACKET - DRIVER SIDE	B1017
14	1	FRAME BRACKET - PASSENGER SIDE	B1018
15	8	M10-1.5 x 40mm BOLT - CLASS 10.9 - CLEAR ZINC	356103-10
16	1	AQUALUBE	400011-30
17	1	THREADLOCKER	200544-00

INSTALLATION

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

Note: If the vehicle is equipped with a factory anti-sway bar, remove the bar and endlinks before beginning this installation.

1. On each side, remove the forward leaf spring bumpstop or pad by removing four M10 bolts attaching it to the frame (Fig.1).

2. On the passenger side, install the B1018 frame bracket between the frame and the factory bumpstop bracket and use the supplied M10 x 1.5 x 40mm hardware to secure it. Then, install the endlink to the frame bracket using a ½" x 3" bolt and ½" nut.

3. For the driver's side, repeat step 2 but bolt the endlink to the frame bracket first using ½" x 3" bolt and ½" nut. *Note:* Ensure that the end of the bolt faces the tire, to allow clearance. Then, place it over the holes just exposed and bolt through the bumpstop and the frame bracket using M10 x 1.5 x 40mm hardware (Fig.2). On each side of the vehicle, use Loctite and tighten the M10 hardware to 70 ft-lbs.

4. On the passenger side, reverse the shock bolt so the bolt head faces the tire to allow clearance (Fig.3 — normal shock bolt. Fig.4 — reversed shock bolt).

continued on next page

Figure 1

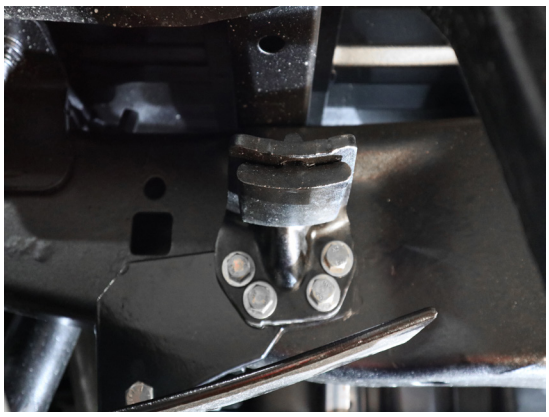


Figure 2

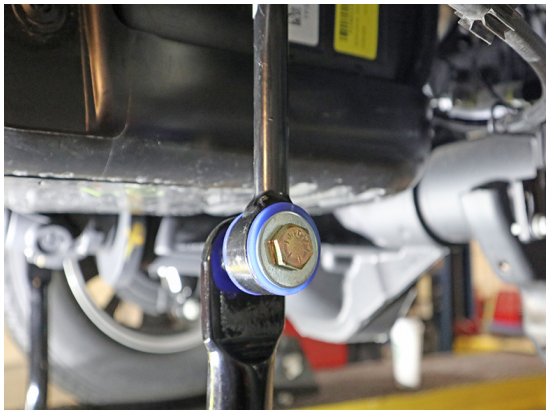
Figure 3

Figure 4

INSTALLATION

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

Figure 5



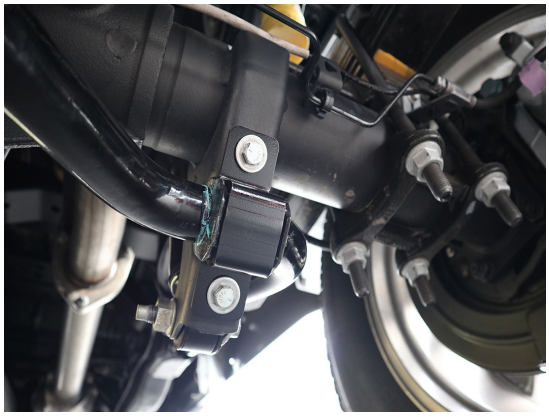
5. Hang the sway bar from the endlinks using ½" x 3" bolts, ½" flat washers and ½" lock nuts (Fig.5). Torque all ½" hardware to 80 ft-lbs.

6. Lubricate and install the bushings and place the bushing clamps over the bushings.

7. Rotate the sway bar up to the backside of the shock mount to bolt through the bushing clamps and into the weld nuts using the included 3/8" x 1¼" bolts and 3/8" flat washers (Fig.6). Use Loctite on the bolts and torque them to 60 ft-lbs.

8. Road test. Listen for noises. Reinspect fasteners.

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-bearin

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.

BOLT TORQUE REQUIREMENTS

Note: The torque values represented below are intended as general guidelines. Torque requirements for specific applications may vary. 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.

STANDARD BOLTS

Thread Size	*Grade*	*Torque*
5/16-18	5	13 ft./lb.
3/8-16	5	23 ft./lb.
7/16-14	5	37 ft./lb.
1/2-13	5	57 ft./lb.
5/8-11	5	112 ft./lb.

METRIC BOLTS

Thread Size	*Grade*	*Torque*
6mm-1.0	8.8	6 ft./lb.
8mm-1.0	8.8	18 ft./lb.
8mm-1.25	8.8	16 ft./lb.
10mm-1.25	8.8	36 ft./lb.
10mm-1.5	8.8	31 ft./lb.

METRIC BOLTS

Thread Size	*Grade*	*Torque*
12mm-1.25	8.8	64 ft./lb.
12mm-1.5	8.8	60 ft./lb.
12mm-1.75	8.8	55 ft./lb.
14mm-2.0	8.8	88 ft./lb.