



# 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 2500/3500/4500 Van and Cutaway

part #1109-175  
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 Chevrolet 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:

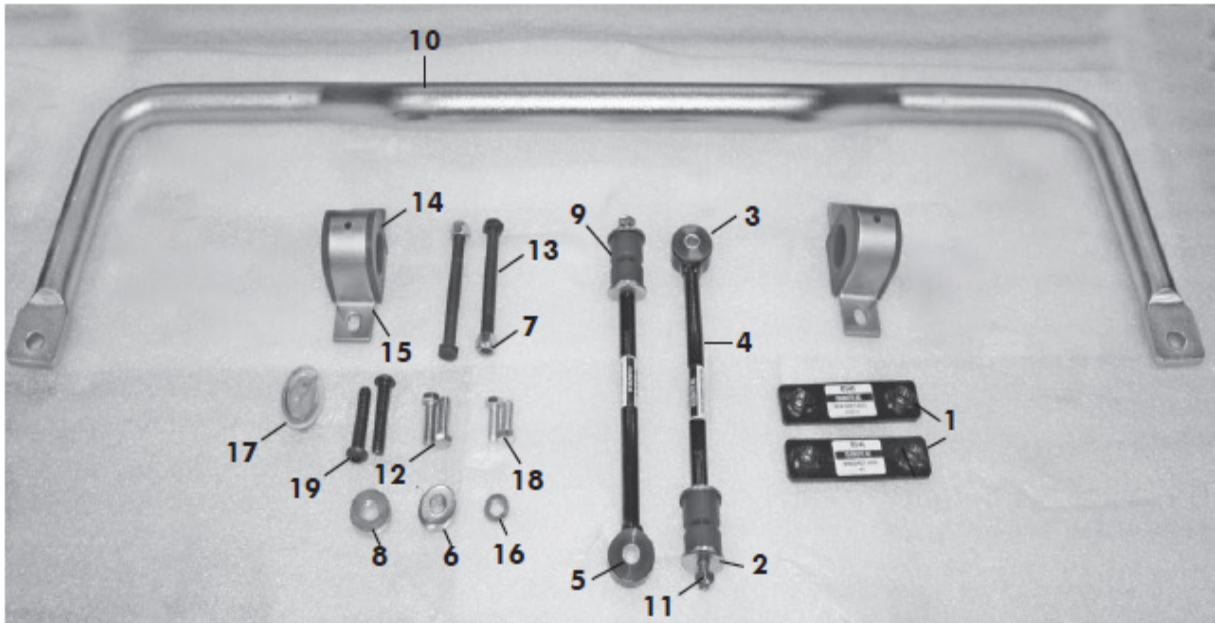
- Electric drill
- Sockets: 9/16" and 3/4"
- Socket wrench
- Floor jack (5 ton)
- Drill bits: 1/8" and 1/2"
- Lug Wrench
- Wrenches: 5/8" and 3/4"
- Jack stands (2)
- General hand tools

### 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 warranted for the original installation. Installing a used anti-sway bar on another vehicle is not recommended and will void the warranty.

# PARTS LIST



Part #1109-175

Part #	Description	Qty	Part #	Description	Qty
1. B546	Bracket	2	11. 350256-02	Locknut 7/16" NC	2
2. 357434-00	Washer, cup	4	12. 350074-00	Capscrew 7/16" x 1 1/2" NC	2
3. 205224-00	Bushing, link	2	13. 350107-80	Capscrew 1/2" x 5" NC	2
4. B321	Link	2	14. 205217-10	Bushing, saddle 1-1/2"	2
5. 205507-00	Sleeve, bushing 1/2" x 1"	2	15. B141	Bracket, saddle	2
6. 350347-00	Washer, flat 9/16"	2	16. 350345-00	7/16" flat washer	4
7. 350259-00	Locknut 1/2" NC	2	17. 400011-30	AQUALUBE grease	1
8. 350308-00	Washer 1/2"	4	18. 350073-00	Cap Screw 7/16" x 1 1/4" NC	2
9. 205381-00	Grommet	4	19. 350099-88	1/2" x 2-1/2" NC PLN	2
10. 580287-00	Sway bar 1-1/2"	1			

# INSTALLATION

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

Steps 1 and 2 are optional.

1. Unload the suspension.

Before beginning this installation, unload the suspension to allow safe access to the underside of the vehicle. You can use a hoist or jack stands to accomplish this.

## 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.

2. Put jack stands under the axle (optional).

Place the jack stands under the rear axle housing to correctly locate the mounting points for the links. Lower the axle housing onto the jack stands. Push the side of the body to make sure that the vehicle is stable.

3. Enlarge the existing hole in the shock bracket.

Using a 1/2" drill bit, enlarge the top existing hole in the shock bracket, located on the rear of the axle.

4. Install the anti-sway bar assembly to the shock brackets using items 14 and 15.

Place the (B546) bracket on the inside of the shock bracket. Use two washers on each side of the bottom to shim the 1/4" gap. *Note:* Use the 1 1/4" long bolt for the top hole and the 1 1/2" long bolt for the bottom hole.

5. Assemble the end links.

Install the link assemblies on the anti-sway bar ends. Install the cup washers, grommets, and links to the anti-sway bar (Figure 1). Install and finger tighten the nut.

Figure 1



# INSTALLATION

6. Move the anti-sway bar assembly until the link is vertical.

Swing the anti-sway bar arms upward until the arm is about parallel to the ground, or frame rail. Pivot the bar on the axle until each link is vertical and touching the outboard surface of the frame rail. Tighten the bushing clamp nuts enough to maintain this position. Use a punch to mark the frame rail at the center of the link hole. Some vehicles may have an existing hole that just needs to be enlarged. Check inside the frame rail for possible interference before enlarging the existing hole.

7. Drill the holes for mounting the links to the frame.

Use a 1/8" drill bit to start the hole for the link bolt. Finish the hole with a 1/2" drill bit.

8. Mount the upper links to the frame.

Install the bushings in the upper links. Install the bushings in the hole in the links. Install the sleeves in the bushings (Figure 1, on the previous page).

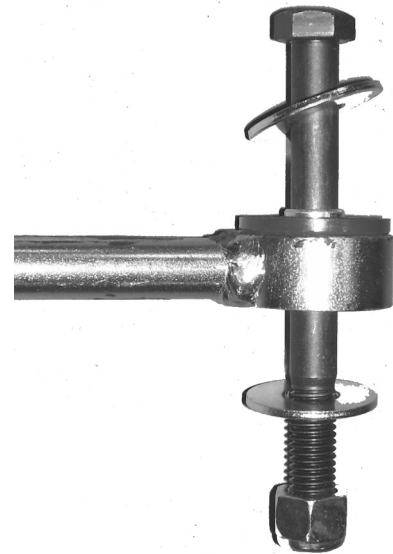
9. Fasten the link to the frame rail.

Install a 9/16" flat washer on the capscrew (350107-00). Insert the bolt through the upper link bushing and frame rail. Install the 1/2" flat washer and lock nut from the inboard side of the frame rail. Repeat for the other side (Figure 2). Tighten the upper link nut to 30 ft.-lbs.

10. Remove the emergency brake bracket.

Remove the emergency brake bracket from the driver's side. Now, secure the emergency brake cable to the anti-sway bar endlink with a zip tie.

**Figure 2**



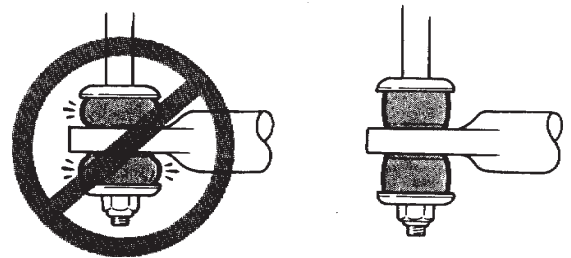
## **WARNING**

### **Overtightening the link nut may damage the bushing.**

If the upper link nut is overtightened, the bushings will fail. 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.

11. Remove the jacks and re-torque lug nuts.

If you raised the vehicle and removed the wheels, re-install the wheels and remove floor jacks. Tighten lug nuts to the specified torque.



11. Test drive and check fasteners.

## **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.