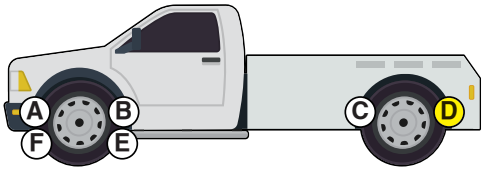
85-6413 rev. 03 12-24

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



Installation Instructions

Rear Anti-Sway Bar Kit for the Ford F550 Truck and Super C

part #1139-211

1¾" diameter – Heat-treated

Designed for heavy-duty applications

INTRODUCTION

Thank you for purchasing this anti-sway bar kit. This kit is designed to improve the handling characteristics of your Ford F550 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. For maximum suspension control, use this kit along with our front anti-sway bar kit.

SUGGESTED TOOLS

The following tools are suggested to complete the installation procedures:

- Assorted wrenches and sockets
- General hand tools

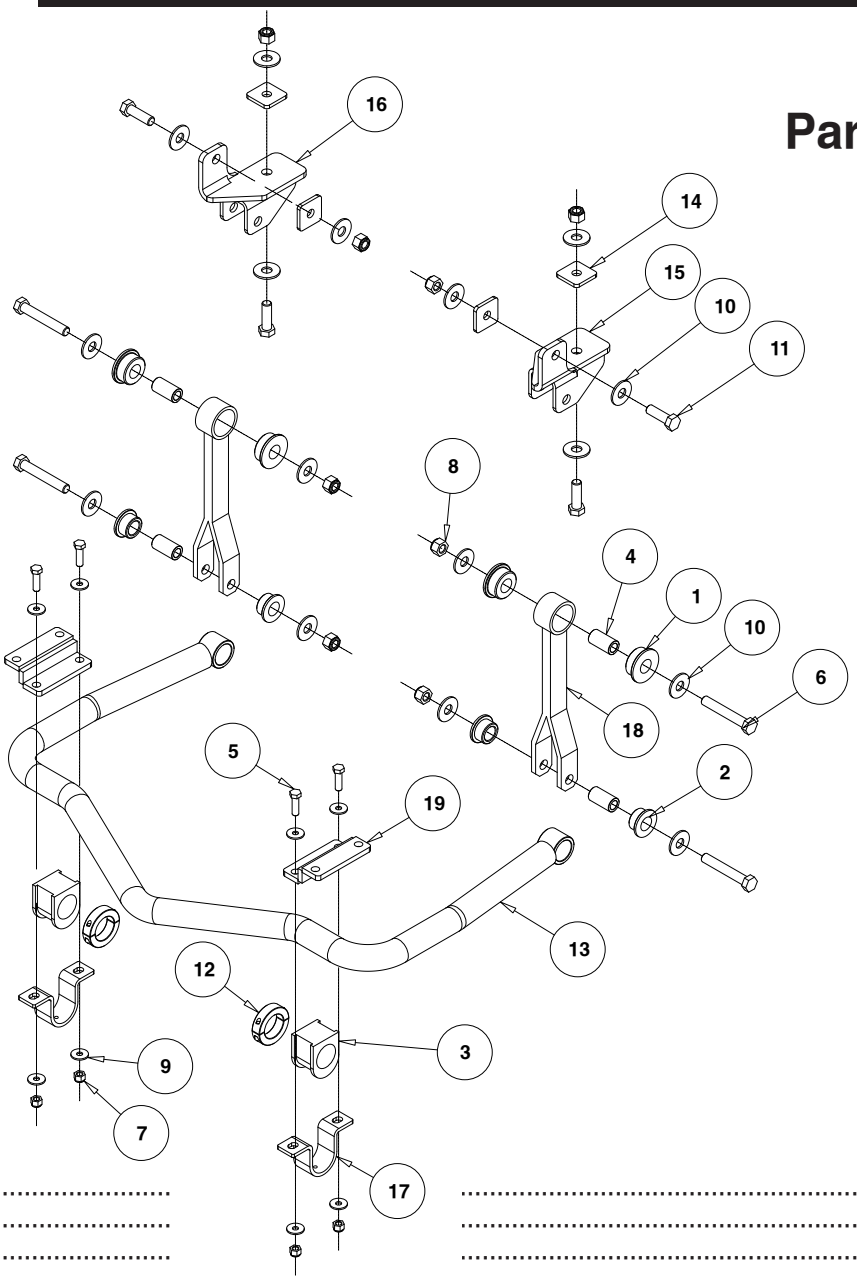
⚠ WARNING

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 #1139-211



ITEM	QTY	MATERIAL	PART
1	4	BUSHING	205202-10
2	4	BUSHING	205209-00
3	2	BUSHING	205220-20
4	4	BUSHING SLEEVE	205503-00
5	4	7/16-14 x 1 1/2” BOLT - GRADE 8	350074-50
6	4	5/8-11 x 4” BOLT - GRADE 8	350158-50
7	4	7/16-14 NYLON INSERT LOCK NUT - GRADE 8	350257-50
8	8	5/8-11 NYLON INSERT - GRADE 8	350263-20
9	8	3/8” HARDENED WASHER	350304-80
10	16	5/8” FLAT WASHER	350731-00
11	4	5/8-11 x 2” BOLT - GRADE 8	350453-00
12	2	SPLIT COLLAR	350530-75
13	1	ANTI-SWAY BAR	580506-00
14	4	2” X 2” BACKING PLATE	A-000188
15	1	FRAME BRACKET	B1053
16	1	FRAME BRACKET	B1054
17	2	BUSHING CLAMP	B141
18	2	END LINK	B404
19	2	AXLE BRACKET	B992
20	1	AQUALUBE	400011-30
21	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. **Remove the factory endlinks.**
   On each side, disconnect the endlink from the frame rail.

2. **Remove the factory anti-sway bar from the axle.**
   Remove two 10mm x 1.5 bolts attaching the bushing clamps to the anti-sway bar and axle.

⚠WARNING

Removing the bushing clamps will release the anti-sway bar. The anti-sway bar is heavy, and may cause property damage or personal injury if it falls on equipment, engine components or any part of your body. Ensure that the anti-sway bar is supported and that you are out of the way when removing the brackets.

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

3. **Lubricate the new bushings with the supplied grease.**
   Put a thorough coating of grease on the inside of each saddle bushing (Figure 1).

4. **Place B992 Brackets on rear end.**

5. **Place the bushings and clamps on the anti-sway bar and lift it into place.**
   Lift the anti-sway bar into place, centering the B141 bushing clamps over the bushings and align them with the included axle brackets. On each clamp, place the supplied 7/16” lock nuts over the included 7/16” x 1½” bolts. Finish with 3/8” washers and 7/16” Nyloc nuts. Use Loctite Red® on these bolts. Ensure the bar is centered side-to-side and then tighten the bolts to 50 ft.-lbs.

6. **Connect the endlinks to the bar.**
   Then, attach the endlinks to the outside of the bar using the supplied (Figure 3). Leave the bolts finger-tight for now.

7. **Install the frame bracket on each side.**
   Use the 5/8” x 2” bolts and 5/8” washers to bolt the frame bracket to the frame rail on each side. Then, finish each bolt with a 2” x 2” backing plate, 5/8” washer and 5/8” Nyloc nut.

8. **Install the endlink to the frame bracket on each side.**
   Using the remaining 5/8” x 4” bolts and 5/8” washers, attach the end link to the frame bracket on each side. Finish each bolt with a 5/8” washer and 5/8” nuts (Figure 4).

9. **After road testing, re-check all fasteners for proper tightness**.

Figure 1

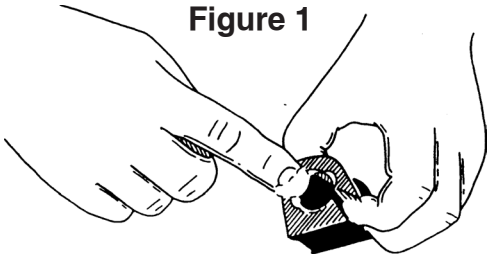


Figure 2

Figure 3

Figure 4

⚠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 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

⚠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.