



**Directions #647 Kit - 1997 Chevrolet/GMC 3500HD**

**Step #1.** Install the furnished u-bolts (open side up) on the axle approximately half way between the wheel and the vehicle spring assembly. *Make certain that brake lines are outside of U-bolts!* Place axle locking bracket assembly on to the u-bolts (forks down). Slide one (1) sleeve on to each of the four (4) threaded u-bolt ends.

**Step #2.** Place the anti-sway bar on a flat surface with the forged end bend up. Install one mid-section bushing/frame bracket assembly on the bar center section at each bend as follows:

1. Apply lithium grease liberally to urethane bushings.
2. Open bushings and snap onto bar.
3. Press slotted bushing bracket on to bushing.
4. Attach frame brackets to bushing brackets by installing the four (4) 3/8" bolts, washers and nuts in the following order (bottom to top): Bolt, flat washer, frame bracket (flange toward bar center), bushing bracket, flat washer and lock nut. Tighten nuts till frame bracket to bushing bracket gap is approximately 1/16".

**Step #3.** Slide one 7/16" cup washer (cup up) and one urethane bushing (nipple up) on to one of the long 7/16" bolts. Insert this assembly into the center hole of one of the channel brackets (forks down; bolt up). In order add the following parts to the bolt:

1. Urethane bushing (nipple down).
2. Cup washer (cup down)
3. Long sleeve
4. Cup washer (cup up)
5. Urethane bushing (nipple up).

**Step #4.** Insert the above end-link assembly into an eye hole (forged end bend up) at one end of the anti-sway bar. Add the following parts to the end-link bolt assembly:

1. Urethane bushing (nipple down).
2. Cup washer (cup down)
3. Lock nut

**Tighten end link assembly to seat urethane bushing nipples in the channel bracket and anti-sway bar. Do not over tighten! Proper assembly will allow the bushings and/or the sleeve to be rotated by hand.**

**Continued**

- Step #5.** Repeat step #3 for second end-link assembly.
- Step #6.** Place anti-sway bar across vehicle frame with assembled mid-section bushings outside of frame and end-links hanging down. Slide the two channel brackets (outer holes) on to threaded upright ends of the previously installed u-bolts. Add one 7/16" flat washer, one 7/16" lock washer and one 7/16" nut to each of the four (4) threaded u-bolt ends. Move u-bolt/end-link/bar assembly until end-links are perpendicular to the ground. Torque u-bolt nuts to 45 ft. lbs.
- Step #7.** Using two cup washers as shims between the vehicle frame and the anti-sway bar (both ends), position the frame brackets against the frame and level with the frame rail top. Using the frame bracket as a drill guide, drill a 3/8" hole in the *right* frame rail (near the shock mount) for the back bolt. Install the following hardware (inside frame rail to out): Bolt, flat washer, frame, frame bracket, flat washer and lock nut and torque to 30 ft. lbs. Check position of bar and drill remaining three (3) frame bracket holes installing bolts as above.
- Step #8.** Torque remaining four (4) bushing bracket to frame bracket bolts to 30 ft.lbs.
- Step #9.** Bounce the truck to check all clearances throughout the suspension travel distance. Road test the vehicle to accustom yourself to its handling. Visually inspect the installation for anomalies and correct if needed. As we cannot supervise your installation or driving, we cannot be responsible for more than the cost of the kit.

**Hardware:**

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|----------------------------|-------------------------------|
| 1- 647RPB 1-1/4" Bar       | 4- RH 107 Cup Washers         |
| 2- RH 410B U-Bolts         | 2- RH 007U End-Link           |
| 2- RH 52B 4" Axle Locks    | 1- RH 29C Right Frame Bracket |
| 2- RH 29B Channel Brackets | 1- RH 29B Left Frame Bracket  |
| 4- RH 066C Sleeves         | 2- UB 615W Bushings           |
| 4- RH 102 Washers          | 2- RH 072W Brackets           |
| 4- RH 101 Washers          | 8- RH 214 Bolts               |
| 4- RH 310 Nuts             | 16- RH 104 Washers            |
| 1- RH 901 Grease           | 8- RH 304 Nuts                |