

Typical Weld-On 4-Link Installation Instructions

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1. FIGURE 1-1 SHOW YOU A COMPLETELY ASSEMBLED 4 LINK ASSEMBLY. IT IS SHOWN WITH RECOMMENDED AIR BAGS, YOU MAY USE AIR SHOCKS OR COIL OVER SHOCKS. BUT THIS HARDWARE IS NOT INCLUDED AND MUST BE PURCHASED SEPARATELY.

2. MAKE SURE THAT THE VEHICLE IS ON LEVEL GROUND AND THE FRAME IS PLACED ON JACK STANDS. NEVER WORK ON A VEHICLE THAT IS SITTING ON JACKS.

3. ONCE THE VEHICLE IS SECURE REMOVE YOUR REAR TIRE, STOCK SHOCKS, UNBOLT YOUR LEAF SPRINGS, HANGERS AND REMOVE.

4. SEE FIGURE 1-2 THIS FIGURE SHOWS YOUR AIR BAG ASSEMBLY TO YOUR LOWER AND UPPER BAG MOUNTS. NOTE: YOUR LOWER BAG MOUNT WELDS TO THE BOTTOM OF YOUR AXLE OR IT MAY BE FLIPPED OVER AND WELDED TO THE TOP OF YOUR AXLE DEPENDING ON YOUR HEIGHT NEEDS. YOUR UPPER BAG MOUNT MUST BE CUT FROM EACH END TO FIT YOUR FRAME. ONCE THIS IS DONE ALIGN YOUR UPPER BAG MOUNT WITH YOUR LOWER BAG MOUNT AND WELD IN PLACE. BE SURE THAT YOUR AIR BAG IS REMOVED AND THAT YOUR AXLE IS CENTERED BEFORE WELDING ANYTHING.

5. SEE FIGURE 1-3 THIS FIGURE SHOWS YOUR 4 LINKS BAR INSTALLATION TO YOUR FRONT AND AXLE MOUNTS. FRONT BRACKETS CAN BE PLACED INSIDE OR ON THE OUTSIDE OF YOUR FRAME. DEPENDING ON YOUR OWN CLEARANCE ISSUES. THEY MUST BE WELDED FLUSH WITH THE BOTTOM OF YOUR FRAME RAIL. SEE FIGURE 1-1 AND 1-3, THESE BOTH SHOW THEM INSTALLED ON THE SIDE OF YOUR FRAME

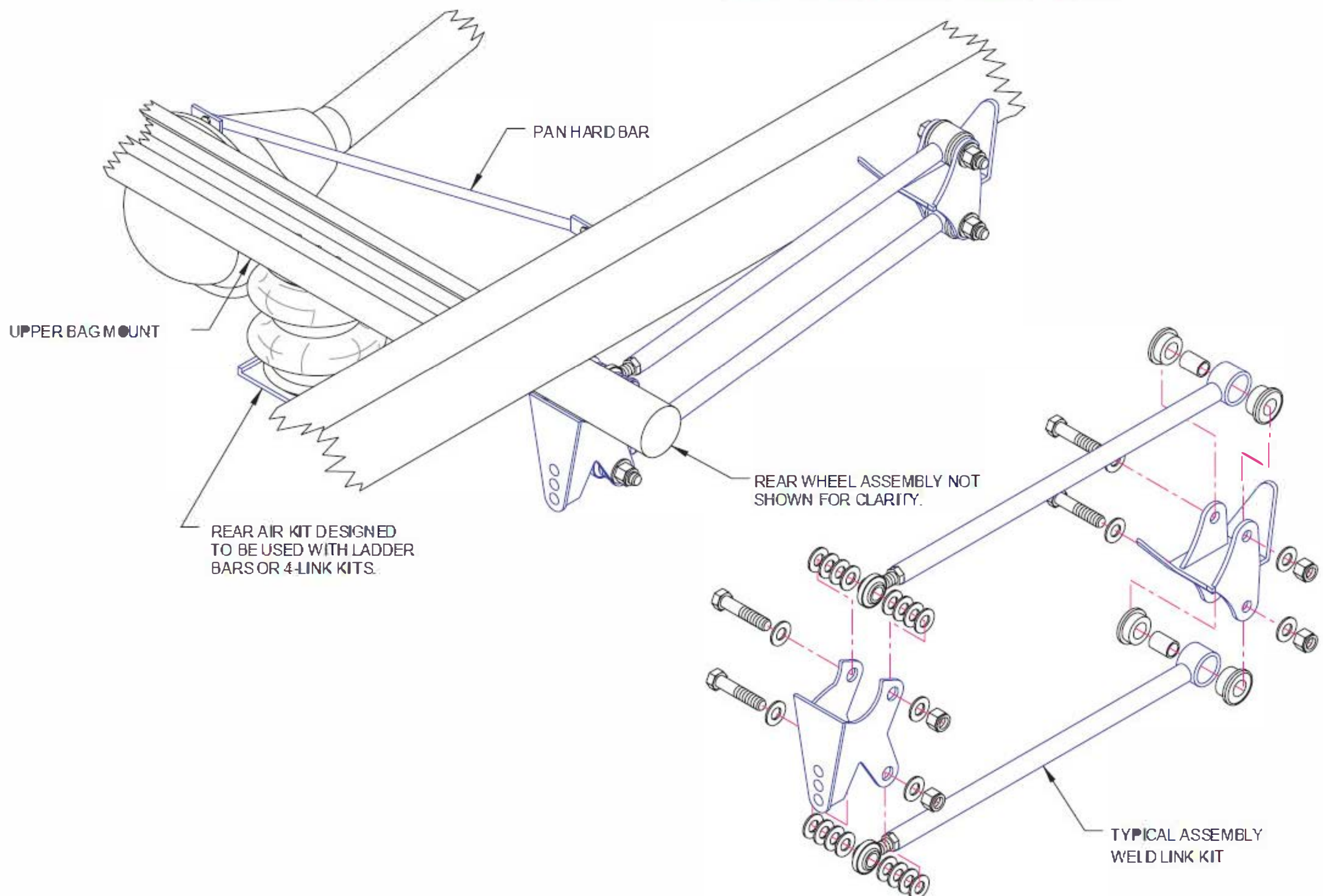


6. AXLE BRACKETS ARE TO BE PLACED PARALLEL AND EQUAL DISTANCES FROM THE AXLE ENDS. BE SURE THAT YOUR AXLE IS CENTERED AND THAT YOUR 4 LINK BARS ARE PARALLEL BEFORE WELDING INTO PLACE.

7. INSTALL BOTH YOUR UPPER AND LOWER 4 LINK BARS. THE LINKS ARE ADJUSTABLE, INSTALL THE ADJUSTABLE END TOWARDS THE REAR OF THE TRUCK. YOUR 5/8 WASHERS ARE USED AS SHIMS ON THE ADJUSTABLE ENDS. SEE FIGURE 1-3 FOR ASSEMBLY.

8. BOLT TOGETHER AND SET TRUCK AT DRIVE HEIGHT. NOW YOU SHOULD BE READY TO WELD YOUR NEW PANHARD BAR FROM THE SIDE OF THE OF THE FRAME TO YOUR DIFFERENTIAL. THE BAR SHOULD RUN PARALLEL TO YOUR AXLE AND INSTALLED SO IT DOES NOT COME IN CONTACT WITH ANYTHING. THE PURPOSE OF THIS BAR IS TO PROVIDE LATERAL SUPPORT TO YOUR VEHICLE. MEANING KEEPING THE AXLE FROM SHIFTING FROM SIDE TO SIDE. BE SURE THAT YOUR AXLE IS CENTERED BEFORE WELDING YOUR BAR. FIGURE 1-4 SHOWS YOUR PAN HARD BAR WELDED IN PLACE.

9. IF USING AIR BAGS BE SURE THAT THEY ARE REMOVED BEFORE WELDING ANYTHING AND THAT THEY HAVE THE APPROPRIATE CLEARANCES. AIR BAGS MUST NOT COME IN CONTACT WITH ANYTHING!!!! (YOU AS THE CONSUMER ARE RESPONSIBLE FOR YOUR AIR BAGS. WE DO NOT WARRANTY BAGS.)



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