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559-734-7451 800-367-5480 FAX 559-734-7460

INSTALLATION INSTRUCTIONS

Rear Stabilizer Bar

00-04 2500 SUBURBAN & AVALANCHE

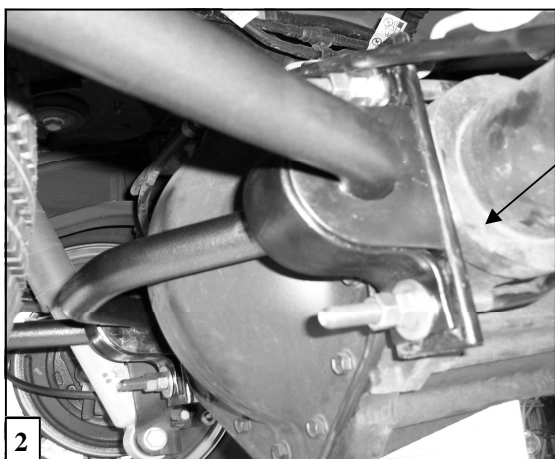
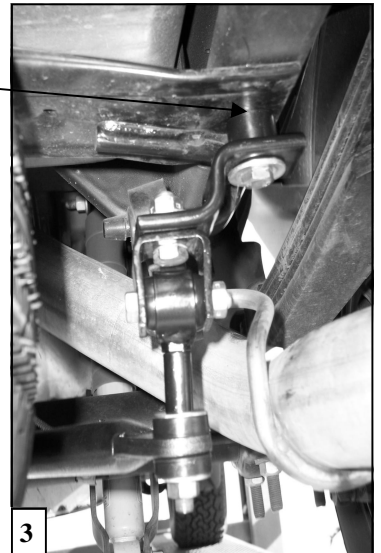
8.1 2&4 WHL

Thank you for purchasing a quality Hellwig Product.

PLEASE READ THIS INSTRUCTION SHEET COMPLETELY BEFORE STARTING YOUR INSTALLATION



SPACER PLATE &
50MM X 1.5 X M12
CAPSCREW



REAR AXLE
CASTING



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TORQUE TABLE

BOLT SIZE: 3/8" = 20-30 ft. lbs. – 7/16" = 35-45 ft. lbs. – 1/2" = 50-70 ft. lbs. – 9/16" = 70-90 ft. lbs.— 12mm = 45-55 ft. lbs

SAFETY: BEFORE STARTING YOUR INSTALLATION, BE SURE TO SET PARKING BRAKE AND CHOCK TIRES.

NOTE: TO EASE INSTALLATION AND TO PROPERLY ADJUST BAR, THE WEIGHT OF THE VEHICLE MUST BE ON THE SUSPENSION AS IF DRIVING DOWN THE ROAD. DO NOT RAISE VEHICLE BY FRAME.

NOTE: THIS KIT IS DESIGNED TO FIT THE 8.1 LITER 3/4 TON SUBURBAN AND AVALANCHE WITH A HEAVY DUTY REAR AXLE ONLY.

NOTE: THIS KIT INCLUDES LOCK NUTS WHICH REQUIRE TIGHTENING WITH A WRENCH AFTER BEING STARTED BY HAND.

1. This sway bar is **NOT** symmetrical and is designed to install with the wide angled arm to the passenger side. The arms of the sway bar will point towards the rear of the vehicle. **See photo one (1).**
2. Locate the large round cast lugs on the rear of the differential housing at each side near the axle tubes. The flat plates and sway bar mounting hardware will be located over these lugs. **See photos two (2) & three (4) .**
3. Install the D-shaped polyurethane bushings between the center hump and the arms of the sway bar. Install the U-plates over the D-bushings on the sway bar. (To avoid any possible bushing noise, you can apply a thin layer of automotive grease on the inside of the D-bushings).
4. Install the large flat 3-hole plates on the rear of the differential lugs so that the offset in the plates center hole is upward thus placing the U-plates low on the differential.
5. Install the U-bolts over the axle tubes in line with the flat 3-hole plates, so the threads are through the flat plates. **Be sure to place the U-bolts under any brake lines, hoses or wires on the differential to avoid crushing when the U-bolts are tightened later.**
6. Install the sway bar with the bushings and U-plates on the backside of the differential housing. Adjust the bushing and U-plates so they align with the U-bolts that are installed on the axle tubes. Install the U-plates onto the U-bolts and tighten with the flat washers and double nuts that are provided. **Leave loose at this time to allow for adjustment later.**
7. Locate the single bolt on each side of the spare tire cross member/carrier rearward of the axle assy. Remove bolts (**one side at a time**). Use a C-clamp to hold the cross member/carrier or block up the spare tire so it cannot drop down. **Spare tire can be removed to ease installation.**
8. Install the Z-bracket to the frame pointing inward the Z-bracket can be rotated as needed to allow for adjustment. **Leave loose at this time to allow for adjustment later.** Install the clevis brackets to the Z-brackets, on the passenger side the spacer plate and the 50mm x 1.5 x 12mm cap screw will be used to mount the Z-bracket to the vehicles frame. **See photo three (3).**
9. Assemble the end links by installing the hour shaped poly bushing through the sleeved end of the end link. Insert the steel sleeve through the poly bushing. It may be necessary to slightly grease the steel sleeve and the poly bushing to ease installation (taking care as not to damaged the poly bushings). Install the assembled end link on the mounted Z-brackets. **Leave loose at this time to allow for adjustment later. (See photo three (3).**
10. Raise the sway bar arms up to the installed end links. Using the remaining (4) round poly bushing install the sway bar arms to the end links. Tighten just slightly that the poly bushings start to bulge. **Do not over tighten or damage can occur to the poly bushings.**
11. Rotate the U-bolts on the axle so that the sway bar is as level to the frame, and the end links are straight up and down as possible. **Be sure the axle u-bolts are under any brake lines, wires or hoses to avoid any possible damage.** With the bar properly aligned and you have enough clearance on the differential and nothing will be crushed or pinched during tightening. Torque all mounting hardware to the specified rates and double nut the axle U-bolts.
12. Bounce the vehicle check for clearance on all undercarriage components; exhaust, shocks, brake and fuel lines. Test drive the vehicle and recheck your installation readjust if needed. Recheck your installation on a monthly regular basis thereafter.

ATTENTION INSTALLER: BE SURE THAT THE CUSTOMER RECEIVES THIS INSTRUCTION SHEET, ALL IMPORTANT NOTE CARDS AND THE WARRANTY FORM

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PARTS LIST

RSB KIT # 7649 "00-04" 8.1 SUBURBAN (2&4WHL)

PART #	QTY	DESCRIPTION
20217649	1	1-1/4" SWAY BAR
20907649	1	COMPLETETION KIT # 7649
118020638	2	1/2" X 5" X 7" ROUND U-BOLT
20800149	2	PLATE BRACKET
20800148	2	U-PLATE
111000649	2	1-1/4" POLY BUSHING
20800059	2	1-3/8" CLEVIS BRACKET
20800044	1	SPACER PLATE
20800061	2	END LINK
125000116	1	SMALL PARTS BAG # BG-116
101500307	2	1/2" X 1-1/4" CAP SCREW
107521044	2	1/2" LOCK NUT
101500185	4	7/16" X 2-1/4" CAP SCREW
107401042	4	7/16" LOCK NUT
111000050	2	5/8" HOUR GLASS POLY BUSHING
20800046	2	7/16" X 1-3/8" STEEL SLEEVE
105521044	8	1/2" HEX NUT
102520043	8	1/2" FLAT WASHER
102420041	4	7/16" FLAT WASHER
111000389	4	END LINK POLY BUSHING
101500047	1	M12 X 1.5M X 50 MM CAP SCREW
20800428	2	Z- BRACKET
20800723	2	END LINK SPACER (1/2"X 1-1/4")
135000382	1	INSTRUCTION SHEET R-7649 (R-382)