

Hellwig PRODUCTS.com

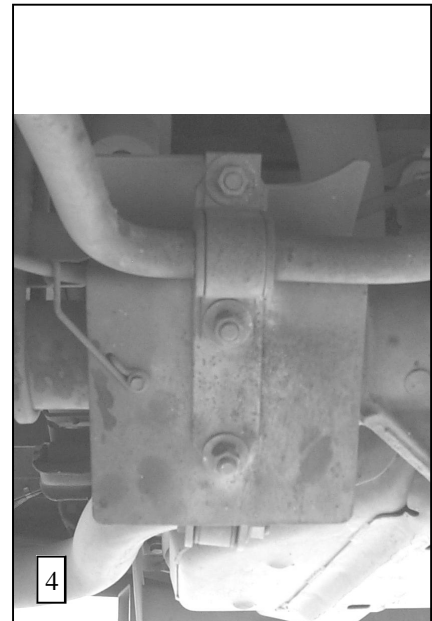
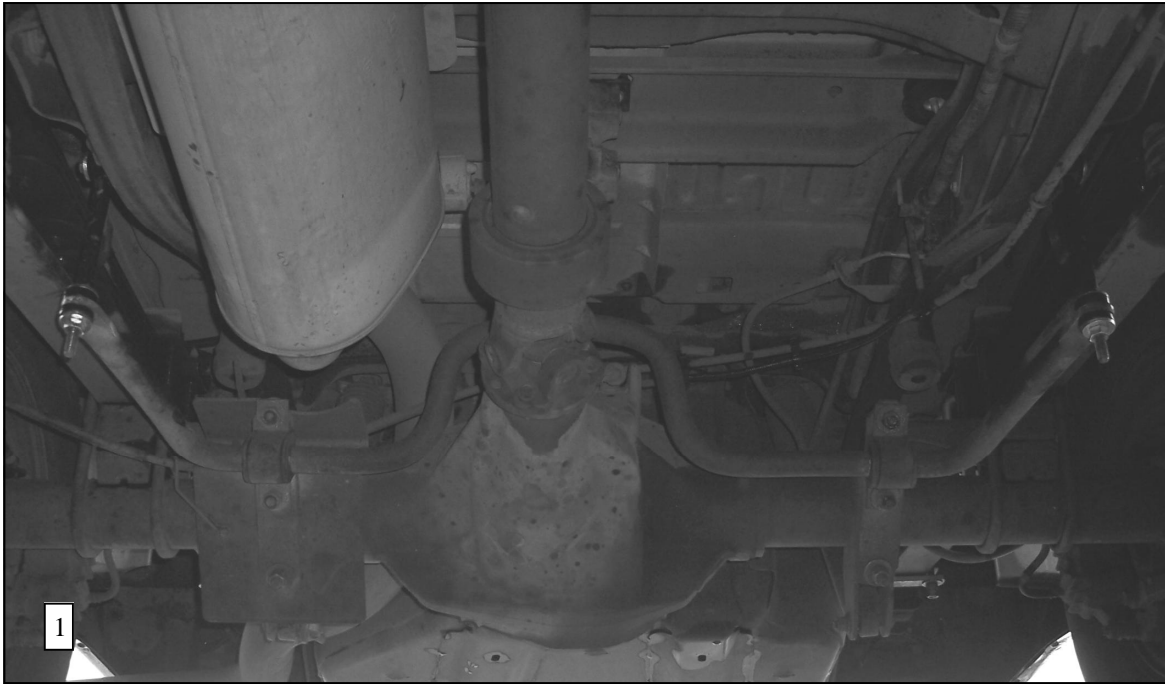
559-734-7451 800-367-5480 FAX 559-734-7460

INSTALLATION INSTRUCTIONS

Rear Stabilizer Bar

EXCURSION 2 & 4 WHL DR

Thank you for purchasing a quality Hellwig Product.



Hellwig PRODUCTS.com

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

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.

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

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 THE VEHICLE BY FRAME.

NOTE: THIS UNIT IS DESIGNED TO MOUNT OVER THE TOP OF THE DIFFERENTIAL WITH THE ARMS POINTING FORWARD AND ATTACHES TO THE SHOCK MOUNTS USING THE ADAPTER PLATES AND U-BOLTS PROVIDED.

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

1. Install the D-shaped polyurethane bushings on the straight areas of the bar close to the shoulders or corners of the sway bar. To avoid any possible bushing noise, apply a thin layer of grease to the inside of the D-bushing.
2. Remove the factory U-bolts that hold the lower shock mounts to the axle. These will be replaced with the new U-bolts which are provided. Position the 3-hole adapter plates onto the U-bolts so that they are flat against the lower shock mount brackets. The third hole will be above the rear axle. SEE PHOTO (4).
3. Position the U-plates over the D-shaped bushing that are installed on the sway bar. Position the U-plates and bushings so they line up with the U-bolts that are installed on the shock mount brackets. The U-plates will mount on the top hole of the 3-hole plate and the upper leg of the U-bolt. **Leave loose at this time to allow for adjustment later.** SEE PHOTO (4).
4. Install the hourglass bushing first and then the sleeve into the loops of the end links (to ease installation to lightly grease the poly-bushings and steel sleeves before installing).
5. Attach end links to frame rail as shown in photos with thin washer next to rail and heavy washers against bolt head and nut on inside of rail. SEE PHOTOS 2 & 3.
6. On the drivers side, remove the emergency brake cable bracket. Reattach it by threading the bracket through our end link mounting hardware. Add an extra nut to this end link to mount the bracket. SEE PHOTO (3).
7. Install spacer tubes on end links followed by a heavy washer and bushing.
8. Insert end of end link through holes in sway bar and complete installation using another bushing, washer and lock-nut as shown in photos 2& 3.
9. Torque all mounting hardware to the specified rate. Bounce the vehicle check for clearance on all undercarriage components ie: exhaust, shocks, differential, wires, brake and fuel lines.
10. Test drive the vehicle and recheck your installation readjust as needed. Recheck your installation after one week of driving and on a monthly regular basis thereafter.

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

Hellwig PRODUCTS.com

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

PARTS LIST

RSB KIT # 7643

"99-04" EXCURSION 2 & 4 WHL DR.

PART #	QTY	DESCRIPTION
20217643	1	1-1/4" SWAY BAR
20907643	1	COMPLETION KIT # 7643
118000156	2	1/2" X 3-5/8" X 6-1/2" ROUND U-BOLT
20800207	2	3-HOLE FLAT PLATE
20800065	2	7/16" X 9" END LINK
111000867	2	1-1/4" POLY BUSHING
20800775	2	U-PLATE BRACKET
20800222	2	5/8" X 5-7/8" END LINK SPACER
125000068	1	SMALL PARTS BAG # BG-68
101500225	2	7/16" X 3" CAP SCREW
111000050	2	5/8" HOURGLASS POLY BUSHING
20800046	2	7/16" X 1.38" SLEEVE
101500307	2	1/2" X 1-1/4" CAP SCREW
102400027	8	17/32" X .16 X 1-1/4" THICK FLAT WASHER
107521044	2	1/2" LOCK NUT
102420041	2	7/16" FLAT WASHER
107401042	4	7/16" LOCK NUT
111000389	4	END LINK BUSHING
105521044	8	1/2" HEX NUT
102520043	6	1/2" FLAT WASHER

7643 (R-7643)

01/18/05