

# HELL BENT STEEL, INC - INSTALLATION INSTRUCTIONS

## FRONT ANTI-SWAY BAR DROP BRACKETS, END LINKS, AND BUSHINGS FOR 1994-2011 DODGE RAM SOLID AXLE 4X4

YOU CAN ALSO VIEW THE INSTRUCTIONS ON LINE AT [www.hellbentsteel.com](http://www.hellbentsteel.com)

### **IMPORTANT NOTES:**

Please read before beginning installation. OEM Manual should be used as a reference.

**It is highly recommended that a certified mechanic perform this installation.**

Read and understand all the instructions before beginning installation. Use Loctite® on all bolts associated with this installation.

### **Torque Settings:**

- Anti-sway bar bushing to frame bolts: 10mm, 45 ft-lbs
- Drop bracket to frame bolts: 10mm, 45 ft-lbs
- End link frame nut:
  - HBS-SMX-1224, 1225, 1227, 1311: 60 ft-lbs
  - HBS-SMX-1226: 40 ft-lbs

---

### **Drop Bracket Installation:**

**The goal of the drop brackets is to keep the sway bar end-links in their stock (vertical) position.**

Doing so will avoid any excessive wear on the end-link bushings and extend the life of the end-links. After your leveling kit is installed, check the angle position of the end-links. If the end-links are leaning either forward or backward then use the drop brackets to adjust the end-links to the vertical position. If the end-links are vertical without the drop brackets, then you do not need to install the drop brackets. Installing drop brackets when they are not needed can cause excessive wear on the end-link bushings and reduce the life of the end-links.

1. To begin installation, block the rear tires of the vehicle so that the vehicle is stable and can not roll.
2. With a 15mm socket or end wrench, remove the four (4) 10mm bolts that mount the anti-sway bar to the frame.

**NOTE:** The anti-sway bar will swing free when the bolts are removed. Be sure to support the bar to avoid injury and excessive load on the end-links.

**\*\*\*If only installing the anti-sway bar drop brackets skip to step 5 \*\*\***

---

### **Anti-Sway Bar Bushing Installation:**

3. Remove the stock bushing and bracket from the anti-sway bar. Remove any dirt, rust, or scale.
4. Grease the inner diameter of the bushing and the contact area of the anti-sway bar before installation. Install new bushings and brackets on to the anti-sway bar. Rotate the anti-sway bar up and down while holding the brackets to disperse the grease.

**NOTE:** For periodic maintenance, each bushing requires three full pumps of a grease gun to insure proper lubrication.



5. Bolt the anti-sway bar drop brackets to the bushing bracket on the anti-sway bar using the 10mm bolts, nuts, and washers provided and a 17mm end wrench and socket. Do not torque the bolts at this time.

6. Bolt the anti-sway bar drop bracket to the frame. Leave the bolts loose enough to allow position adjustment of the anti-sway bar.



\*\*\* If only installing drop bracket skip to step 9 \*\*\*

### **Anti-Sway Bar End-link Installation:**

7. Remove the stock end-links from the truck with a 15mm socket by removing the pin and nut where the end-link mounts to the frame of the truck and the nut on the top that secures the anti-sway bar with an 18mm socket. Repeat on opposite side.



**NOTE:** The end-link may be in the opposite position than as shown in the picture depending on the model year of the truck.

8. Install the new end links to the anti-sway bar using a  $\frac{3}{4}$ " socket. Tighten nut so that there is  $\frac{1}{2}$ " -  $\frac{3}{4}$ " of threads exposed, lightly compressing the bushing. Bolt the end-link to the frame of the truck with a  $\frac{9}{16}$ " end wrench and socket and torque to the proper specs.



9. Adjust anti-sway bar using the slots in the drop bracket so that the end links are **vertical**. Also check the horizontal position of the anti-sway bar for alignment with the axle.



**NOTE:** If you find that your drop brackets push the end links out of vertical and toward the front of the truck, reverse the direction of the bracket. In that case they will be opposite of the position shown in the picture. Reversing the brackets pushes the anti-sway bar in the opposite direction and puts the end links in the correct (vertical) position. In some applications the end-links will be in the vertical position without the drop brackets.

10. Tighten all bolts and nuts on the anti-sway bar and drop bracket and torque to the proper specs.

You may view these instructions in full color on our website at [www.hellbentsteel.com](http://www.hellbentsteel.com)

Join us on **facebook** at [www.facebook.com/hellbentsteel](http://www.facebook.com/hellbentsteel)