

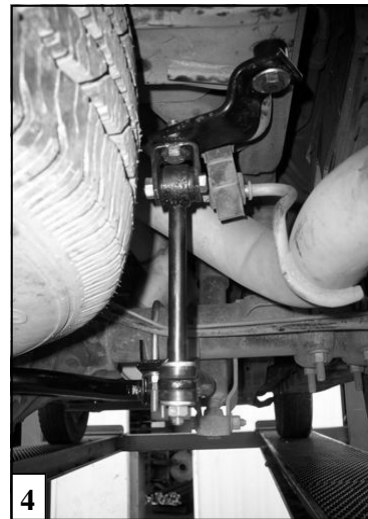
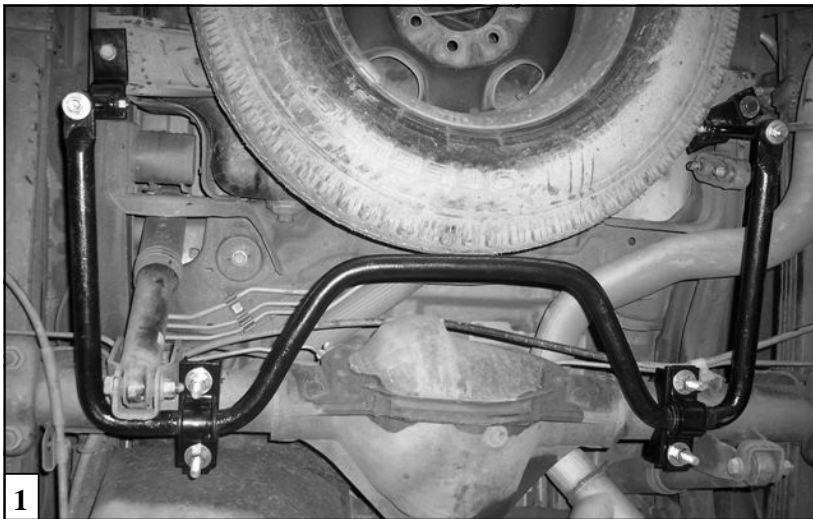
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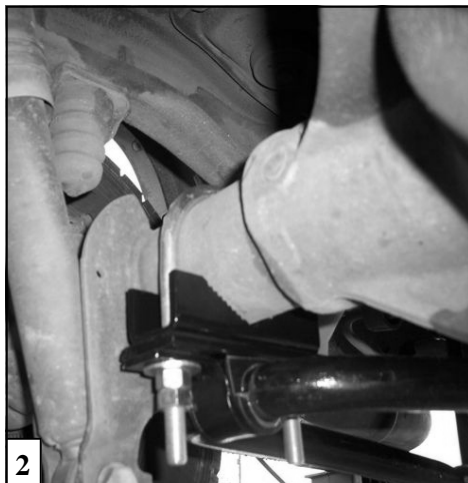
INSTALLATION INSTRUCTIONS REAR STABILIZER BAR 2500 SUBURBAN & AVALANCHE (6.1 LITER)

Thank you for purchasing a quality Hellwig Product.

PLEASE READ THIS INSTRUCTION SHEET COMPLETELY BEFORE STARTING YOUR INSTALLATION



PASSENGER SIDE



DRIVERS SIDE

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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.

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

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

NOTE: THIS SWAY BAR IS DESIGNED TO MOUNT BELOW THE AXLE TUBES WITH THE ARMS OF THE SWAY BAR FACING TOWARDS THE REAR OF THE VEHICLE.

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

1. Position the D-shaped poly bushings on the straight areas of the sway bar on each side of the center hump. SEE PHOTO #1.
2. Hold the sway bar up to the axle, locate the position on the axle to mount the U-bolts. The threads of the U-bolts will be pointing down and slightly to the rear. SEE PHOTOS #2 & 3. **be sure to install the U-bolts under any brake lines, wires or hoses on the axle to avoid any possible damage.**
3. Place the saddle brackets on the U-bolts previously installed on the axle. Install the U-plates over the D-shaped poly bushing on the sway bar. Fasten the sway bar to the U-bolts and saddle brackets with the flat washers and nuts that are provided. **Leave loose at this time to allow for adjustment later.**
4. Assemble the end-links by installing the sleeve type poly-bushing (it may be necessary to lightly grease the poly-bushing and steel sleeve before installing) into the tube welded to the end of the link. Place the small steel sleeve inside the bushing to complete this end of the assembly.
5. Locate the single bolt on each side of the spare tire crossmember/carrier rearward of the axle. Use a C-clamp to hold the crossmember/carrier in position or block up the spare tire so it cannot drop down (spare tire can be removed to ease installation). Remove the bolts (**one side at a time**). SEE PHOTOS 4 & 5.
6. Attach the Z-brackets to the frame with the Z pointing inward. Attach the end link clevis brackets to the Z-brackets with the mounting hardware provided. SEE PHOTO # 4 & 5. **Leave loose at this time to allow for adjustment later.**
7. Using the hardware provided attach the end link assemblies to the clevis brackets that are mounted on the Z-brackets. On the threaded ends of the end links install a thick flat washer, round end link bushing. Raise the sway bar arm to the threaded end link insert thru the eye of the sway bar arm and install round bushing and thick flat washer. Install the lock nut to the end link assy. Do the same on the opposite end link assy.(Leave loose at this time to allow for adjustment later). **Do not over tighten or damage can result to the poly bushings.**
8. Align the sway bar side to side through the bushings to be as centered as possible. By rotating the U-bolts on the axle the sway bar can be positioned front to rear. This will adjust the end link brackets to be straight up and down as possible. The Z-brackets can be rotated in any direction to allow the best alignment of the end links on your particular vehicle. (SEE PHOTOS 4 & 5). **Be sure that the sway bar does not make contact with the differential, shocks or springs.**
9. Torque all the mounting hardware to the specified rate. Bounce the vehicle check for clearance on all undercarriage components, exhaust, shocks, wires, brake and fuel lines.
10. After on week of driving recheck your installation making sure it has not moved readjust if necessary. 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 # 7653

“00-04” 6.1 LITER 2500 SUBURBAN & AVALANCHE

PART #	QTY	DESCRIPTION
20217653	1	1-1/4” SWAY BAR
20907653	1	COMPLETION KIT # 7653
111000536	2	1-1/4” POLY BUSHING
20800378	2	U-PLATE
118000156	2	1/2” X 3-5/8” X 6-1/2” ROUND U-BOLT
20800871	2	SADDLE BRACKET
20800428	2	Z-BRACKET
20800065	2	WELDED END LINK
20800432	2	FLAT PLATE
20801941	1	BRAKE LINE BRACKET
20800059	4	CLEVIS BRACKET
20800042	1	Z-BRACKET
20800222	2	5/8” X 5-7/8” END LINK SPACER
125000653	1	SMALL PARTS BAG # BG-653
107521044	4	1/2" LOCK NUT
107401042	4	7/16" LOCK NUT
111000050	2	5/8” HOURGLASS POLY BUSHING
20800046	2	7/16” X 1.38” STEEL SLEEVE
101500307	4	1/2” X 1-1/4” CAP SCREW
102520043	8	1/2” FLAT WASHER
105521044	8	1/2" HEX NUT
101500185	4	7/16” X 2-1/4” CAP SCREW
101202020	1	5/16” X 1” CAP SCREW
105321178	1	5/16" HEX NUT
102400027	4	THICK FLAT WASHER
111000762	4	END LINK BUSHING
101500047	1	12MM X 1.5 X .50MM CAP SCREW
135007653	1	INSTRUCTION SHEET R-7653 (R-653)

7653 (R-7653)

01/18/06