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# INSTALL INSTRUCTIONS FOR 101026

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## BEFORE YOU START

**VEHICLE FITMENT:** 2017-2025 Ford, F250/F350/F450

Please check to make sure you have all parts before proceeding. If you are missing any of the components or have any questions about the install, please call our customer support at (909)947-0015 or send us an email at [customerservice@sbfilters.com](mailto:customerservice@sbfilters.com). Installation requires loosening and removing U-Bolt nuts and under axle plates, use extreme care when doing so to ensure the axle remains in place. The vehicle should be parked on a level surface with front and rear wheels chocked. U-Bolts must be retorqued properly and should be rechecked periodically after installation to ensure they are still correctly torqued.

## REQUIRED TOOLS

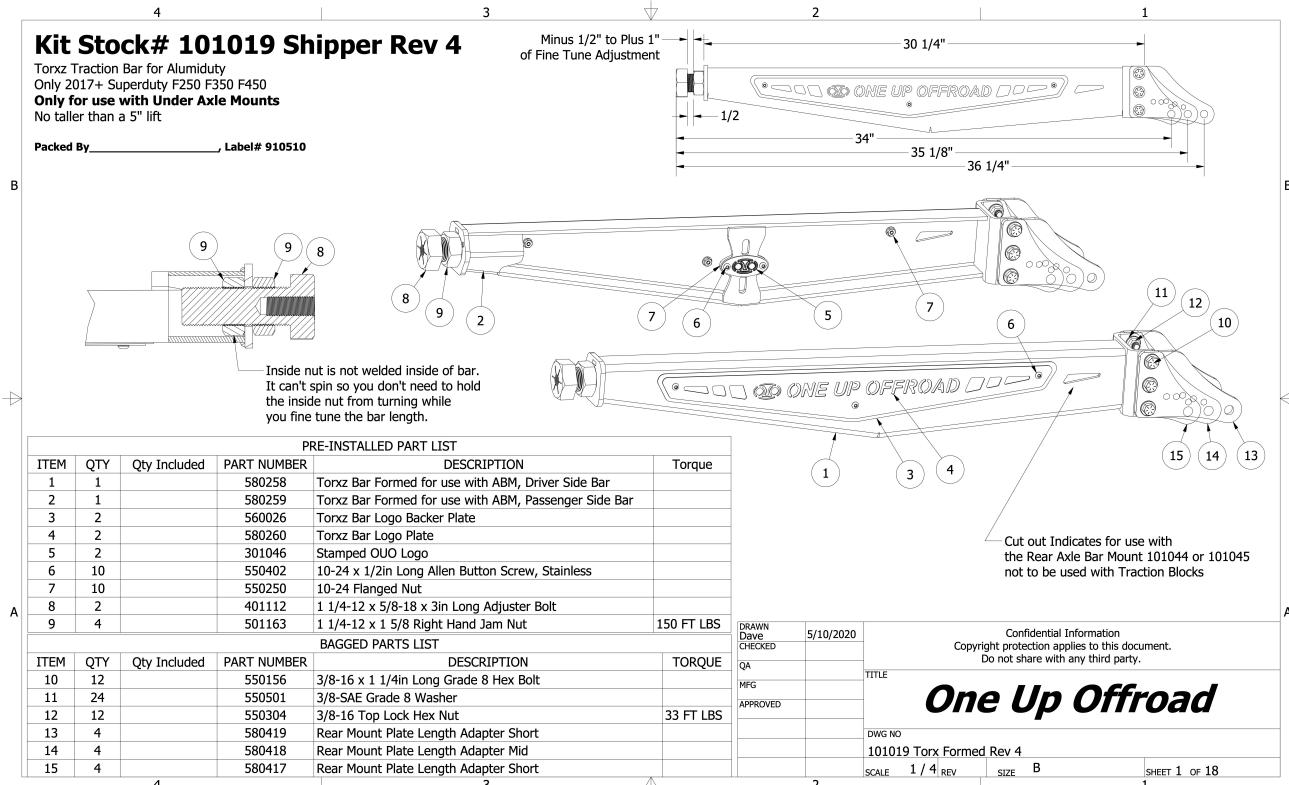
- 9/16", 3/4" & 15/16" Sockets
- 9/16" & 3/4" Wrenches
- Torque Wrench Capable of 295 ft-lb
- 1/8" Allen Wrench
- Sharp Drill Bits up to 1/2"
- Large Crescent Wrench or Standard Wrenches up to 2"
- Spray Paint

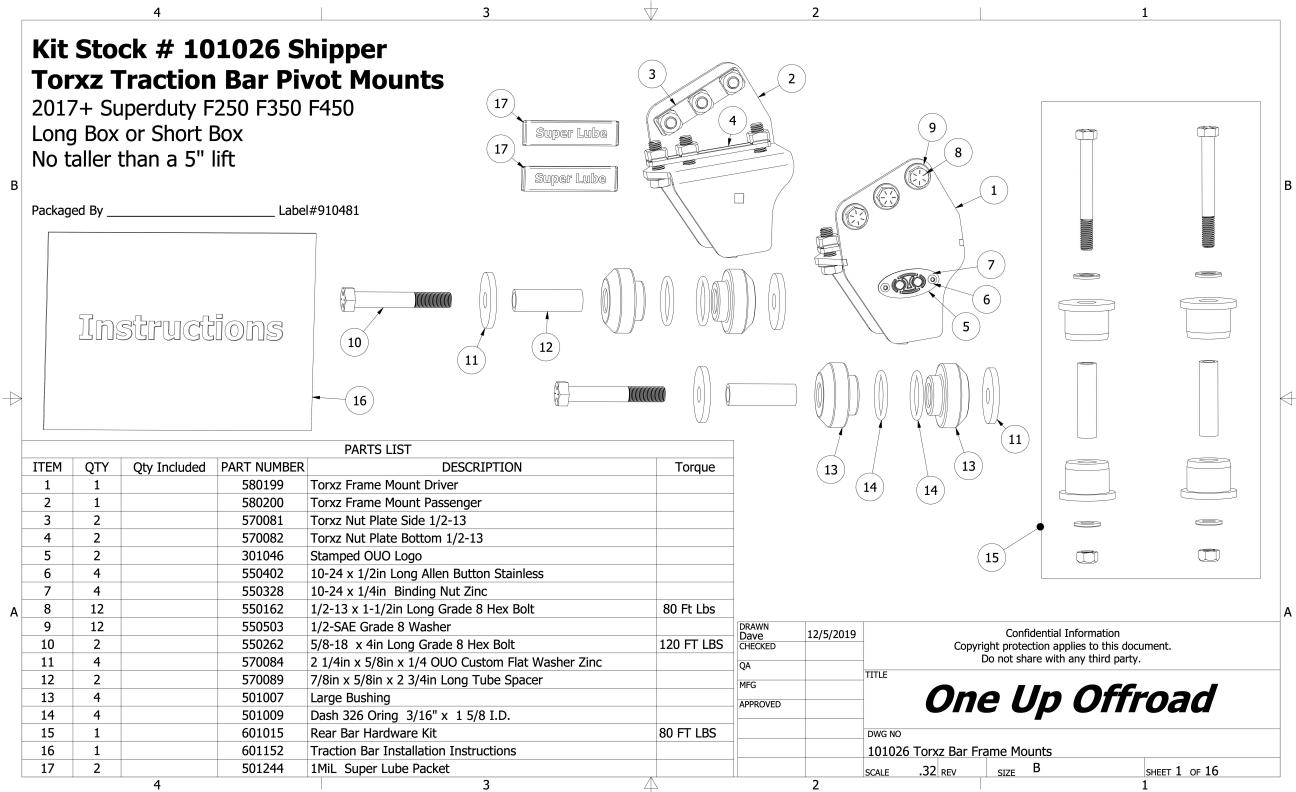
**Note:** Approximate Install Time: 3 Hr 00 Mins for Kit Installation.



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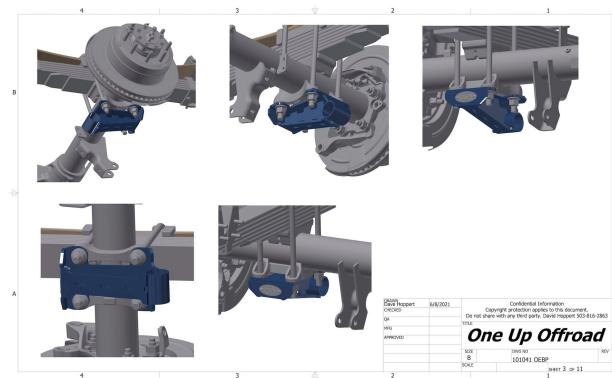
## STEP 1

Remove your existing U-Bolt Nuts. Leave your OEM Under Axle/Bottom Plate Installed and hanging on the U-Bolts as it will be re-used in the next step.



## STEP 2A

Place the 101041 Under Bottom Plate Axle Mount (Single Rear Wheel Trucks) or 101042 (Dual Rear Wheel Trucks) against the OE bottom plate and reinstall the nuts. The large hole extending off the bracket needs to be facing the front of the truck. Torque the nuts in a crossing pattern and 4 stages as follows. SRW Trucks: Stage 1 - 48lb-ft, Stage 2 - 96lb-ft, Stage 3 - 148 lb-ft, Stage 4 - 195 lb-ft. DRW Trucks: Stage 1 - 74lb-ft, Stage 2 - 148lb-ft, Stage 3 - 221 lb-ft, Stage 4 - 295 lb-ft. Recheck U-Bolt torque after 500 miles or immediately if you hear any popping.



You can install your axle mount logo plates at this step as well with the provided #10-24 Stainless Button screws and serrated flange nuts. The logos should face the rear of the truck.

## STEP 2B

Remove the rubber bushings and aluminum sleeve from the Rear Bar Mount Hardware kit, Part KP2010-00, and press them into the openings on the under axle mount. Make sure the aluminum tube is slid into the urethane bushings to act as a compression limiter.

## STEP 3

Starting on the driver side of the truck, find the fuel tank impact shield that is installed in front of the forward most leaf spring bolt. Remove the

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Its that hold it to  
the frame. You can discard

the shield as we will not be reusing it. The S&B Frame Bracket will act as an impact shield itself and is much stronger than this factory sheet metal piece.

## STEP 4

Use a flathead screwdriver or pry bar to pry the cage nuts out of the frame. We will not be reusing the cage nuts.

## STEP 5

Find the driver side frame mount (KI2048-00). Open hardware pack KP2031-00 as well and locate 2 of the 1/2" bolts as well as 1 of each size frame nut plate. Push the driver side mount against the frame tab and install 1 bolt from the bottom through the middle hole and into the frame. Install 1 bolt from the

Cookie Preferences  any of the existing holes. Install the nut

plates from the inside of the frame pocket and tighten the bolts hand tight. Push the mount as far forward as the bolts will let you. This is the position we will permanently mount the bracket in. Clamp the frame mount to the frame and remove the nut plate from the bottom. You can drill through the holes in the bracket to be sure the holes line up correctly. Another option is to use a 1/2" transfer punch and then remove the bracket before drilling. Do not drill into the nut plates, it will destroy the threads. You need to drill two 1/2" holes in the forward and rear hole locations on the bottom side of the frame mount. We highly recommend sharp drill bits and stepping up in sizes progressively. Astro Tools Turbo Step TS29 bits work great.

## STEP 6

After the holes are drilled, you can remove the bracket and clean the area of chips, paint the raw metal, and let dry.

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## STEP 7

Reinstall the bracket along with 6 of the 1/2" bolts, 1/2" washers and 2 frame nut plates. Torque all 1/2" hardware to 80lb-ft

## STEP 8

Repeat the frame bracket mounting process on the passenger side. Match the location of the passenger side bracket to the driver side bracket by measuring from a cab mount to the bracket.

Clamp the bracket to the frame once aligned. Drill through the bracket to ensure proper alignment.

Alternatively, you can use a transfer punch to mark your holes and remove bracket before drilling. You will need to drill 6 1/2" holes in the

the passenger side.

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## STEP 9

After the holes are drilled, remove the bracket and clean the area of chips, paint the raw metal, and let dry.

## STEP 10

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Reinstall the bracket using 6 of the 1/2" bolts, 1/2" washers, and 2 frame nut plates. Torque all of the 1/2" hardware to 80lb-ft.

## STEP 11

Locate the 4 O-rings included in KP2031-00. Press each O-ring into the O-ring groove on both sides of the frame mount. This protects the urethane bushings and keeps water from accumulating inside the bushing group.

## STEP 12

Press the urethane bushings into the frame mounts. The O-rings should help to keep them in place. Next, press the aluminum sleeve through the inside of the bushings. This is

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bolt without crushing the bushings. Install one of the large washers on each side of the bushings and then pass the long 5/8" bolt through the washers, bushings, and aluminum sleeve. Thread the 5/8" bolt into the threaded hole on the front of the Torxz bar and torque the 5/8" bolt to 120 lb-ft. Loosen the jam nut and turn the head of the 1-1/4" bolt until you have roughly 3/4" between the bolt head and jam nut.

## STEP 13

Move to the back of the bar. We include short, medium and long end plates. Determine which end plates are closest to lining up with the center of the hole in the under axle plate. Mount those end plates to the outside of the traction bar itself with 6 of the 3/8" bolts, 12 washers and 6 of the 3/8" nuts. Torque 3/8" hardware to 33lb-ft. Then, loosen the jam nut and adjust the bolt at the front of the traction bar to align the hole in the end plates with the center of the bushings in the under axle plate. Install the bolt through the axle

plate once centered. Torque 1/2" hardware to 80lb-ft.

## STEP 14

After the rear 1/2" bolt is installed, make small adjustments to the large black bolt at the front of the traction bar to make the bushing gap the same on both sides of the frame mount with the truck at ride height. When the bar position is correct, tighten the jam nut to 150lb-ft.

## STEP 15

Your installation is complete. If you have any questions during the install process, please give us a call at 909.947.0015 or email us at [customerservice@sbfilters.com](mailto:customerservice@sbfilters.com)

Thank you for your business!

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