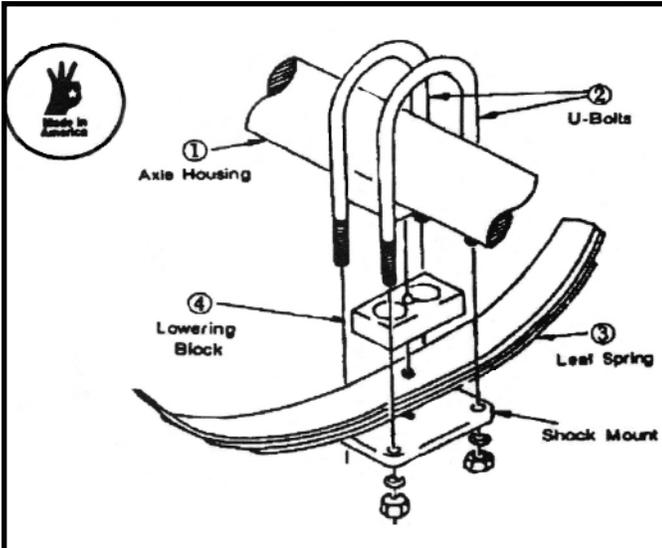




# INSTALLATION INSTRUCTIONS REAR STEEL BLOCKS

Rev. # 10-03



## Hardware Parts List:

### SB-1LK,SB2397-1

- 2- Steel Blocks.
- 2- 3/8" Spring Bolts w/nuts.
- 4- 1/2"x3"x10" U-Bolts.
- 8- 1/2" Nuts and Washers.

### SB2LK,SB-3LK,SB4LK,

### SB2397-2,SB2397-3, SB2397-4

- 2- Steel Blocks.
- 2- Ring Shims
- 4- 1/2"x3"x10" U-Bolts.
- 8- 1/2" Nuts and Washers.

### SB2397-1RT

- 2- Steel Blocks.
- 2- 3/8" Spring Bolts.
- 4- 5/8"x3-5/8"x10" U-Bolts.
- 8- 5/8" Nuts and Washers.

### SB2397-2RT,SB2397-3RT, SB2397-4RT

- 2- Steel Blocks.
- 2- Ring Shims
- 4- 5/8"x3-5/8"x10" U-Bolts.
- 8- 5/8" Nuts and Washers.

## INSTALLING 1" BLOCKS

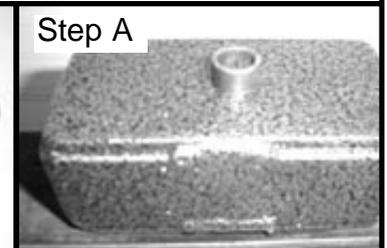
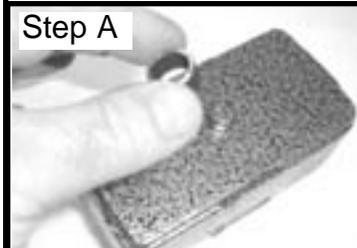
Clamp leaf springs together on each side of the spring center bolt. Remove factory spring bolt. Place block on top of the leaf spring and using the bolt supplied attach to the spring pack. Attach nut and tighten. Cut any excess bolt if necessary. Lower axle on to the block and line up bolt with axle locating hole. Install u-bolts, spring plates and tighten. Check u-bolts for torque.



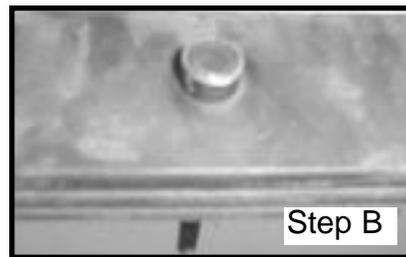
## INSTALLING 2",3" & 4" BLOCKS

Check the diameter of the leaf spring pin. If the pin is larger than the one in the top of the block, use step A; if the pin is the same size use step B:

**A:** Place the ring shim on top of the block. Place block flat on spring. Lower axle down on the block. Be sure pin is aligned. Install u-bolts and tighten.



**B:** Place the ring shim on top of the leaf spring. Place block flat on spring. Lower axle down on the block. Be sure pin is aligned. Install u-bolts and tighten. Dakota RT require the holes in the factory spring plates must be enlarged to 5/8". Trim excess ubolt as needed.



4" blocks are tapered to correct pinion angle. Install on top of the leaf spring with the thin end forward.  
Check u-bolts for torque every few months.