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INSTALLATION INSTRUCTIONS

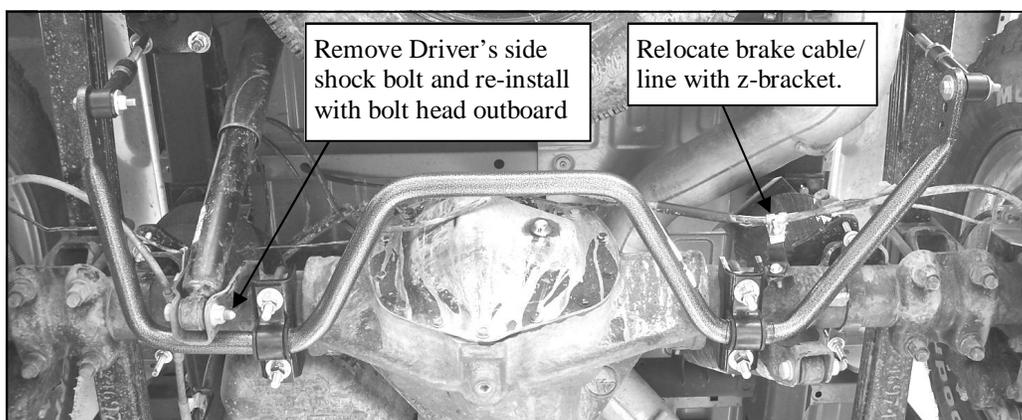
Rear Stabilizer Bar 7664

2007.5+ GM 2500HD-3500HD 2WD-4WD

Duramax Diesel Only

Thank you for purchasing a quality Hellwig Product.

PLEASE READ THIS INSTRUCTION SHEET COMPLETELY BEFORE STARTING YOUR INSTALLATION



TORQUE TABLE

Bolt Size 3/8"— 35 ft lbs * Bolt Size 7/16"— 45 ft lbs* Bolt Size 1/2"—75 ft lbs *Bolt Size 9/16"— 90 ft lbs

SAFETY: BEFORE BEGINNING INSTALLATION BE SURE TO SET THE PARKING BRAKE AND CHOCK THE WHEELS.

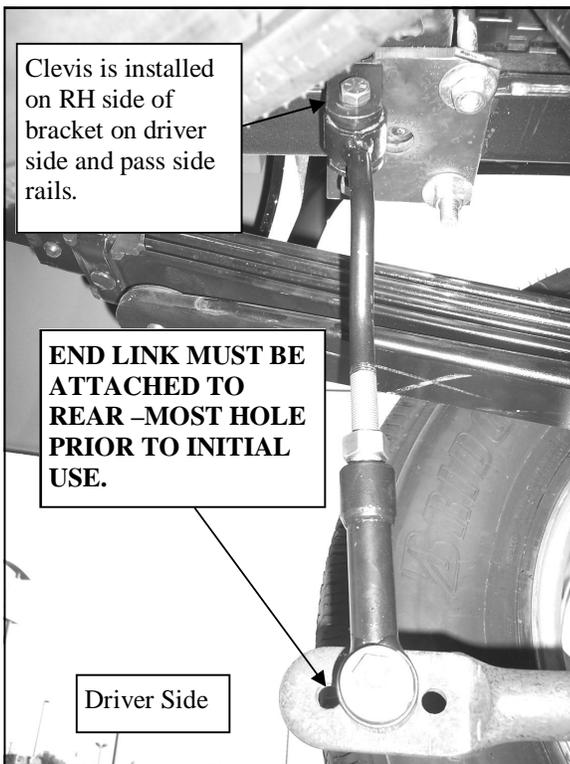
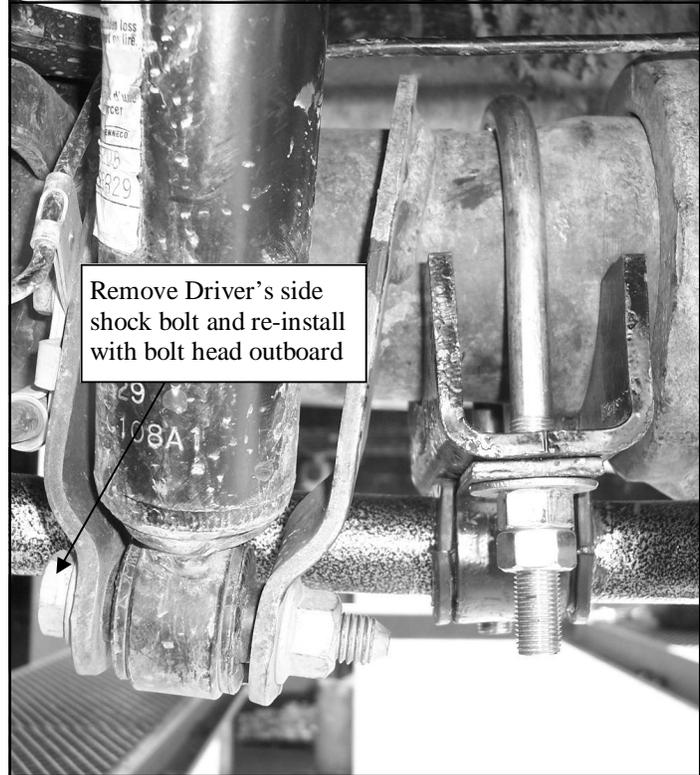
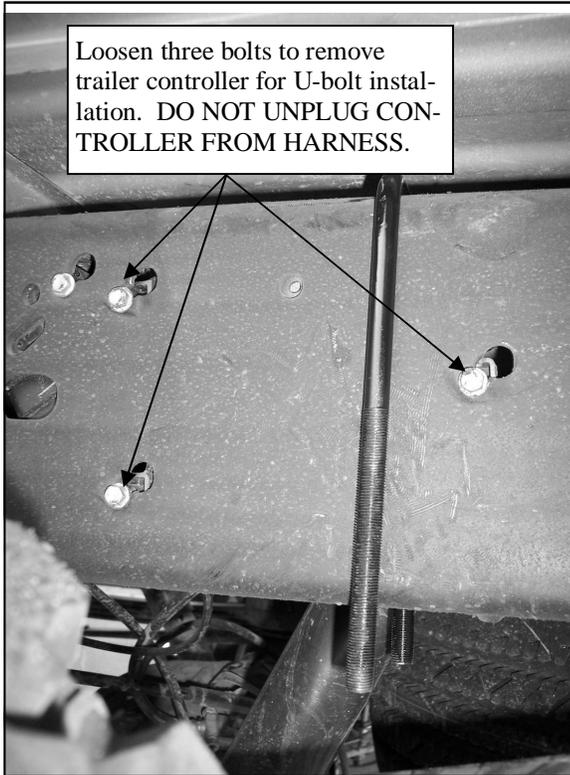
NOTE: TO EASE INSTALLATION AND PROPERLY ADJUST THE BAR, THE WEIGHT OF THE VEHICLE MUST BE ON THE SUSPENSION AS IF DRIVING DOWN THE ROAD. DO NOT RAISE THE VEHICLE BY THE FRAME.

NOTE: THIS UNIT IS DESIGNED TO MOUNT TO THE BOTTOM OF THE AXLE TUBES WITH THE ARMS OF THE BAR TOWARD THE REAR OF THE VEHICLE.

1. Lubricate the D shaped bushings and place them on the straight areas of the bar on each side of the center hump.
2. Hold bar up to the axle and locate the position on the axle tubes to mount the u-bolts. **Be sure to put the U-Bolts Under Any Brake Lines, Wires or Hoses on the Axle to Avoid Any Possible Damage.** The threads of the U-Bolts will point down.
3. The saddle brackets have different radiuses to match the taper of the axle. Install saddles on axle so that they sit squarely on the axle. Place the U-Plates over the D shaped bushings on the bar and attach the bar to the U-Bolts and saddle brackets with the flat washers and nuts provided. **LEAVE LOOSE AT THIS TIME** to allow for adjustment later.
4. Remove brake cable/line bracket from axle and use z-bracket and 5/16 bolt and nut to relocate as shown in photos. **Remove the driver side lower shock bolt, turn it around and reinstall from the outboard side of the lower shock bracket.**

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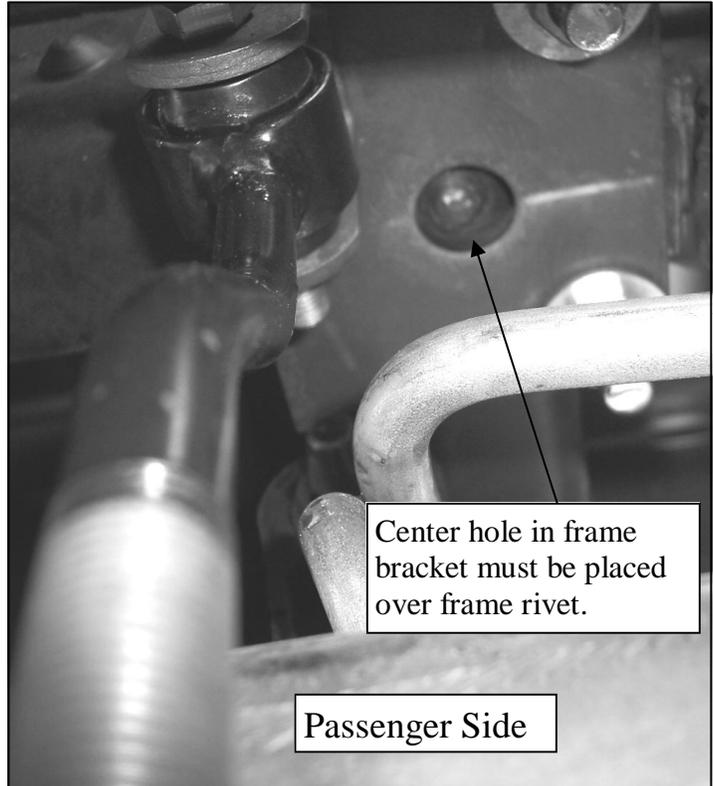
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5. Locate existing spare tire crossmember on vehicle frame. Place square U-bolt over the frame rail in front of the crossmember with the legs of the U-bolt pointing downward. If equipped with trailer brake controller, loosen the 3 bolts attaching controller to frame rail and slide controller off slots in rail (see photo) - **DO NOT DISCONNECT CONTROLLER FROM HARNESS.** This will allow the drivers side U-bolt to be installed on frame rail.
6. Reattach trailer brake controller to frame rail if required.
7. Insert the legs of the U-bolts into the slotted holes of the frame brackets. Using 1/2" locknuts and washers, install the frame bracket with the clevis on the RH side of the bracket as shown in photos. The large hole in the bracket must be centered over the frame rivet. **LEAVE LOOSE** for adjustment later.
8. Insert hourglass bushing first and then the sleeve into the loops of the end links. Lubricate the bushing and sleeve before assembly. Attach 9/16 nut to threaded half of end link before assembling end link halves.
9. Attach end links to clevis on frame brackets using 7/16 X 2-1/4 bolts and locknuts. **LEAVE LOOSE** for adjustment later.

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10. Adjust end links so that the arms of the sway bar are parallel with the ground. When satisfied with fit, attach end links to the rearmost hole of sway bar with 7/16 x 2-3/4 bolts, washers, and locknuts. A washer can be placed between the sway bar and end link bushing to aid alignment of the end links.
11. Tighten end link bolts on sway bar and frame brackets to 40 ft-lb. Tighten 9/16" nut on end links to lock threads in place.
12. Center sway bar on axle and tighten axle U-bolts to 60 ft-lb. Double nut axle u-bolts after torquing to spec.
13. **Bounce the vehicle checking for clearance on all under carriage components: fuel tank, shocks, exhaust, differential, brake and fuel lines, etc.** Test drive the vehicle and recheck all clearances and the installation alignment. Adjust as needed. Re-check your installation after one week of driving and periodically on a regular basis.
14. **The sway bar has three end link mounting holes. The end link MUST be mounted on the outer hole for initial use. For a firmer setting, use the inner holes. You must use the outer mounting hole until you are accustomed to the vehicles new handling characteristics. After driving vehicle, a firmer setting may be selected if desired. It is recommended that the outer hole be used for street driving.**

ATTENTION INSTALLER: PLEASE MAKE SURE CUSTOMER RECEIVES THIS INSTRUCTION SHEET, ALL IMPORTANT NOTE CARDS, WARNING CARDS AND THE WARRANTY FORM