

# Dual Steering Stabilizer

F250/F350 Super Duty and Excursion | 1999-2004

Part # 55373

Rev. 102617



## SAFETY WARNING

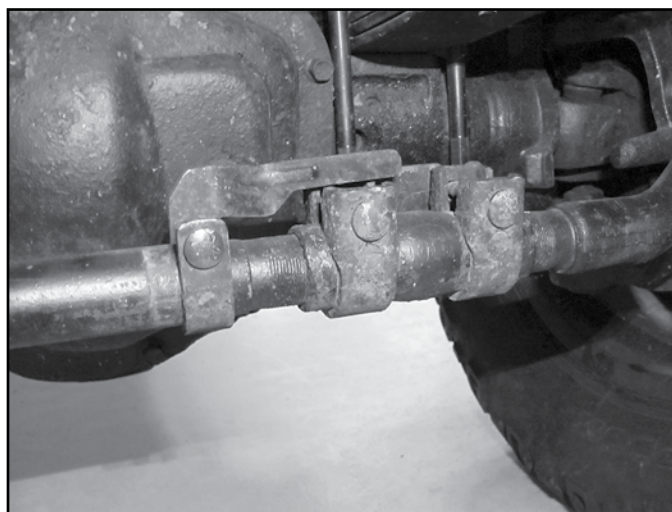
BDS Suspension Co. recommends this system be installed by a professional technician. In addition to these instructions, professional knowledge of disassembly/ reassembly procedures and post installation checks must be known.

## INSTALLATION INSTRUCTIONS

1. Raise vehicle and support the frame with jack stands. Turn the wheels so they are straight ahead.
2. Remove the OE steering stabilizer from the OE mounting brackets. Remove the mounting bracket from the tie rod.
3. Loosen and rotate the tie rod adjusting sleeve clamps on both sides so the clamps are facing up. This will provide clearance under the tie rod for the stabilizer cylinders. Do not tighten hardware at this time. The clamps may need to be adjusted further to provide adequate clearance (Fig. 1).

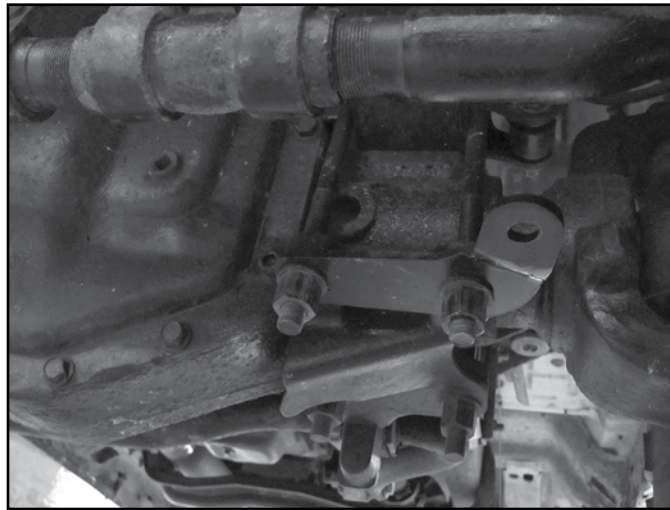
Box Kit		
Part #	Qty	Description
A240	1	Center Bracket w/ Nameplate
01581	1	U-bolt Mount Plate
561120214RB	3	5/16" x 1-1/2" x 2-1/4" U-bolts
322	2	Bolt Pack
	2	1/2"-13 x 2-1/2" bolt
	2	1/2"-13 Prevailing torque nut
	4	1/2" SAE Washer
309	1	Bolt Pack
	8	1/4" USS washer
	8	5/16"-18 prevailing torque nut

FIGURE 1



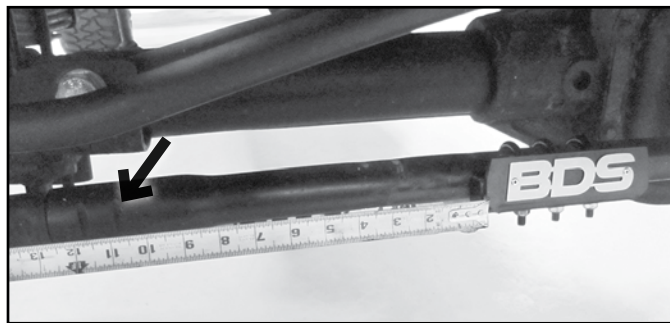
4. Remove the nuts from the driver's side front U-bolt. Install the supplied mounting bracket on the U-bolt so the tab is pointing toward the front of the vehicle and secure with original nuts and washers (Fig. 2). Torque nuts to 70 ft-lbs.

**FIGURE 2**



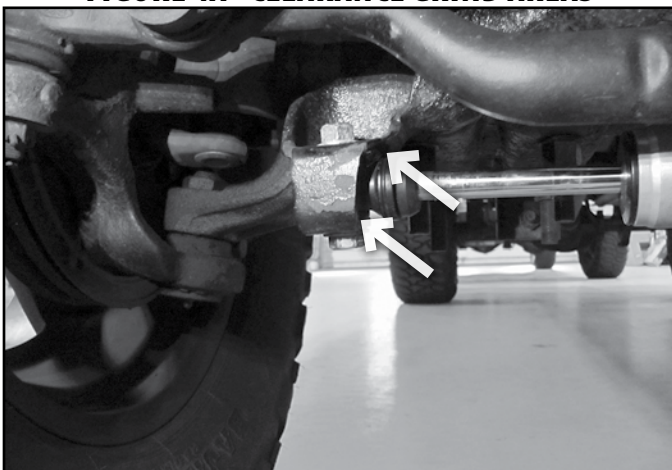
5. Mount the new tie rod bracket to the underside of the tie rod with the 5/16" x 1-1/2" x 2-1/4" u-bolts. Mount it so the bracket is level and edge of the front face of the bracket is approximately 10-3/4" from the edge of the first groove in the tie rod (Fig. 3). Tighten the bracket enough to hold the position, the position of the bracket can be fine tuned once the cylinders are installed.

**FIGURE 3**



6. Install the hourglass bushings and 1/2" ID sleeves into the cylinder eyes. Start by installing rod end of the passenger side cylinder into the factory axle mount. First check that the provided 1/2" bolt will fit through the lower hole, in some cases this may need to be enlarged with a drill. Also the top and bottom of the mount may need to be slightly clearanced with a grinder to clear the stabilizer end. *Note: Another option is to cut off the bottom of the mount at the top of the front face only leaving the top mounting hole.* Install the bolt with washer from the bottom up and torque the bolts to 40 ft-lbs. (Fig. 4A & 4B)

**FIGURE 4A - CLEARANCE GRIND AREAS**



**FIGURE 4B - OPTIONAL CUT LINE**



7. Attach the body of the passenger side cylinder to the bottom side of the new tie rod bracket and secure using the 1/2"-2-1/2" bolt, nut, and washers with the bolts going from the bottom up. Torque bolt to 40 ft-lbs.

8. Install the rod end of the driver side cylinder into the bottom of the outside bracket attached to the u-bolts using the 1/2" hardware from the bottom up. Lastly, compress the cylinder and attach it to the center bracket with the 1/2" hardware. Torque bolts to 40 ft-lbs.
9. With the wheels facing forward, measure the exposed rod on the cylinders and if necessary move the tie rod bracket until the cylinders are equally extended. Torque the tie rod bracket U-bolts to 20 ft-lbs. (Fig. 5)

**FIGURE 5**



10. Perform a steering sweep to make sure there is no interference and the cylinders have full stroke to the steering stops. Tighten the tie rod adjusting sleeve clamps to 41 ft-lbs.