



## INSTALLATION INSTRUCTIONS

**6540**  
**FLIP KIT**  
**Toyota Tundra 2007**

**Congratulations! You were selective enough to choose a BELLTECH PRODUCT. We have spent many hours developing our line of products so that you will receive maximum performance with minimum difficulty during installation.**

- Note:** Confirm that all of the hardware listed in the parts list is in the kit. **Do not** begin installation if any part is missing. Read the instructions thoroughly before beginning this installation.
- Warning:** **DO NOT** work under a vehicle supported by only a jack. Place support stands securely under the vehicle in the manufacturer's specified locations unless otherwise instructed.
- Warning:** **DO NOT** drive vehicle until all work has been completed and checked. Torque all hardware to values specified.
- Reminder:** Proper use of safety equipment and eye/face/hand protection is absolutely necessary when using these tools to perform procedures!

**NOTE:** This is a relatively complex installation and as such we recommend that a qualified mechanic perform it. We also recommend that to retain the stability of the leaf spring pack and axle assembly.

**NOTE:** As it may be necessary to temporarily loosen fuel tank mounting straps to install driver side hanger, we recommend that the fuel level be as close to empty as possible to reduce fuel tank weight.

### **RECOMMENDED TOOLS:**

- Properly rated floor jack, support stands, and wheel chocks
- Combination wrench set
- Torque wrench: *50-250 lb ft. range*
- Ratcheting socket wrench and socket sets
- Air Chisel / Die grinder W/ cut off wheel
- Heavy Duty Drill
- C-Clamps
- Safety Glasses

### **KIT INSTALLATION**

1. Open the hardware kit and remove all of the contents. Refer to the part list (Page 5 & 6) to verify that all parts are present.
2. Park the vehicle on a smooth level asphalt or concrete surface. Place a block in front of and behind the front wheels. Jack up the rear of the vehicle and place jack stands securely under the frame in the manufacturer's specified locations. Remove the rear wheels.
3. Block the front wheels of the vehicle and raise the rear wheels of the vehicle off the ground with a floor jack rated for this load. Position the jack stands under the rear axle and the differential to hold up the drive shaft. (photo 1)

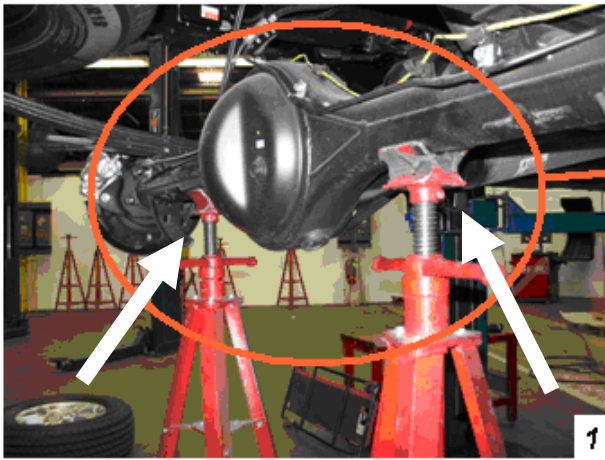
4. Remove the ABS bracket from the axle. (photo 2)
5. Remove the shocks. (photo 3, 4)
6. Remove U-bolts, upper bump stop bracket and U-bolt plate.
7. Lower the spare tire approx 6" to allow access to rear shackle. (photo 5)
8. Remove the rear shackle assembly. (photo 6)
9. Remove the front leaf spring bolt. (photo 7)
10. Remove leaf spring, placing it on the ground, reverse the center bolt so that the head of the bolt is now on the top of the leaf. (photo 8)
11. Reassemble the new shackle assembly using the factory bolts. (photo 9, 10)  
**Note: Bolt hole locations for '07-08 and '09-10 MY vehicles are different. Used the indicated bolt holes specified for your vehicle.** (photo 10a)
12. Install the new shackle assembly to the vehicle, when doing this procedure, do not tighten the bolts at this time. Leave them snug but loose. After the shackle is installed, the spare tire can be raised back into its original position.
13. First install the front leaf spring bolt, torque to factory specifications, then the shackle.
14. Install the new axle saddle with the high side towards the rear and the hole should be closer to the front of the vehicle. (photo 11, 12)
15. Assemble the bump stop onto the upper u-bolt plate. (photo 13)
16. Place the u-bolts over the upper u-bolt plate and into the lower plate, attach nuts but do not tighten at this time. When you repeat this procedure on the other side, you may have to move the axle and the saddle such that the differential is parallel to the vehicle. Once the differential is parallel, the u-bolt nuts can be tightened. Tighten each side evenly to factory torque specifications. Due to the angle of the differential, the front u-bolts will appear to be longer than the rear. (photo 14)
17. Install your new shocks and torque the original nut and bolt to 105-110 Ft.-lb.
18. Re-assemble the ABS bracket.
19. At this time, the shackle bolts are still loose. In order to insure the correct angle for the shackle, the vehicle must be lowered to the ground. Re-install the wheels and tires and torque the lug nuts to 80-85 ft.-lb., lower the vehicle to the ground. Once on the ground, tighten the shackle bolts.

***WARNING: IF YOU TIGHTEN THE SHACKLE ASSEMBLY WHILE AT FULL DROOP, THE CORRECT SHACKLE POSITION AND DROP WILL NOT BE CORRECT.***

## VEHICLES WITH 2-PIECE DRIVE LINES:

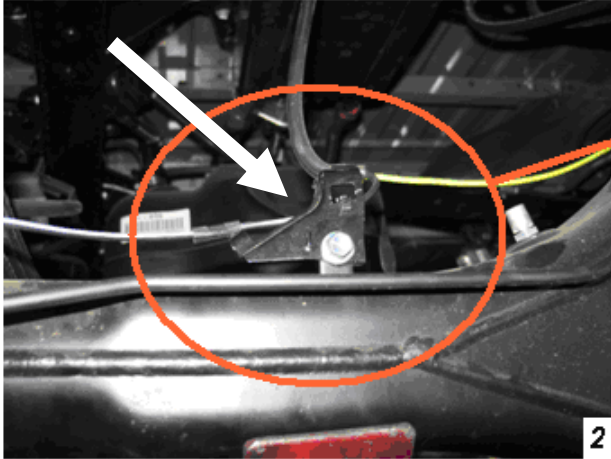
20. Vehicles with split drive lines will require four (4) transmission bracket spacers. (photo 15, 16)
21. Remove the four (4) factory bolts.
22. Jack up the transmission, place spacer between factory brackets using new bolts.
23. Tighten bolts to factory specifications.
24. The installation is complete.
25. **NOTE:** Re-check the torque on U-bolts after 10 miles, and then after 100 and 1,000 miles.

PART NUMBER	DESCRIPTION	QUANTITY
6540-001	SADDLE, RIGHT HAND	1
6540-002	SADDLE, LEFT HAND	1
6540-005	LOWER U-BOLT PLATE	2
6540-003	UPPER U-BOLT SPRING MOUNT	2
6540-007	U-BOLT	4
110670	WASHER	8
110455	NYLOCK NUT	8
68320069	8MM LENS HEX BOLT	2
4923-001	BUMP STOP	2
6540-014	SHACKLE ASSEMBLY	4
112018	10MM X 1,25 X 30MM HEX BOLT	4
110625	3/8 WASHER	4
2005-007	TRANSMISSION SPACER	4



JACK STANDS UNDER AXLE

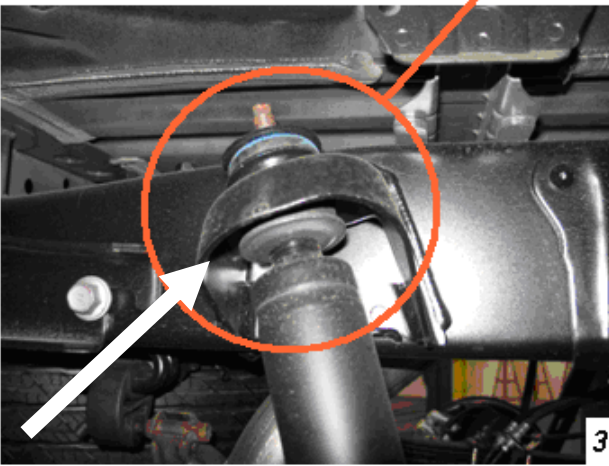
1



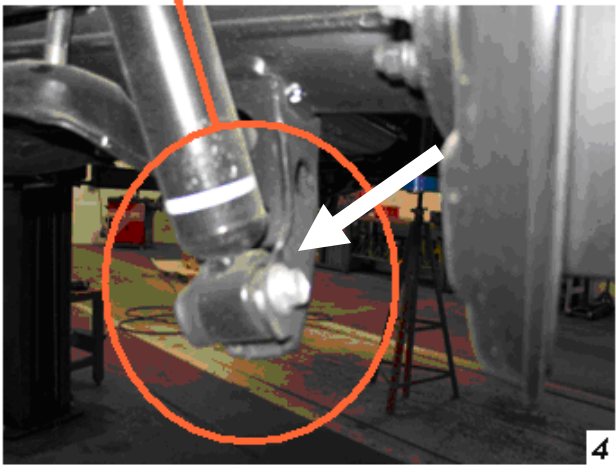
ABS BRACKET

SHOCK MOUNTS

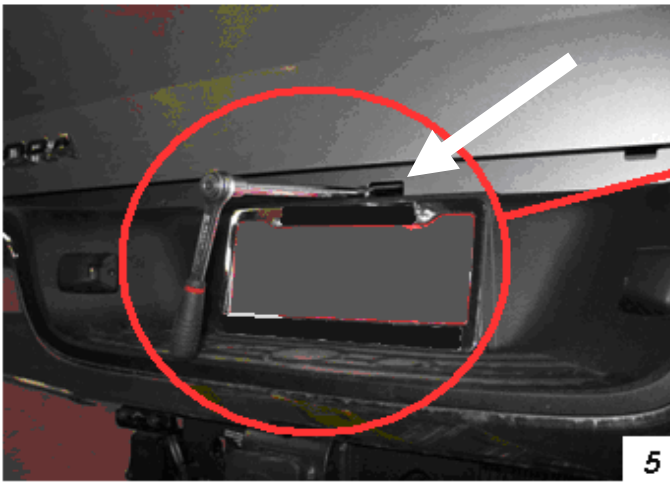
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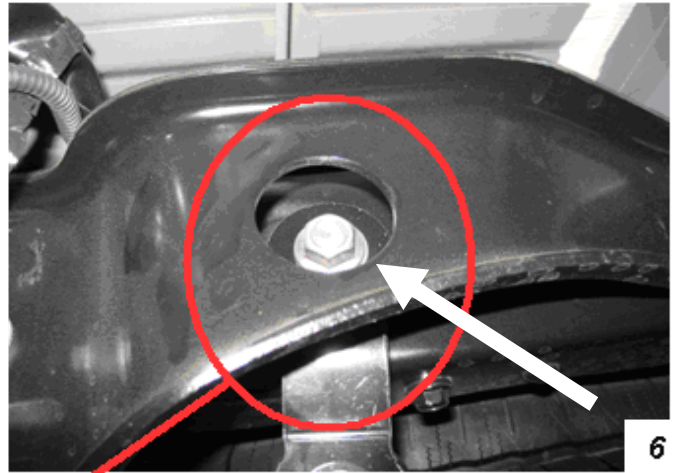
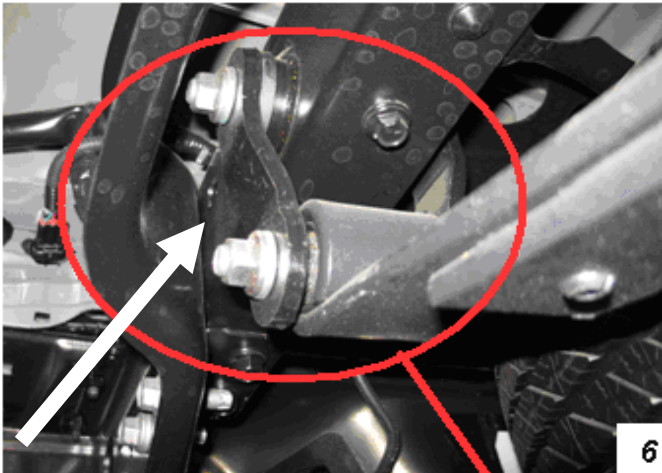
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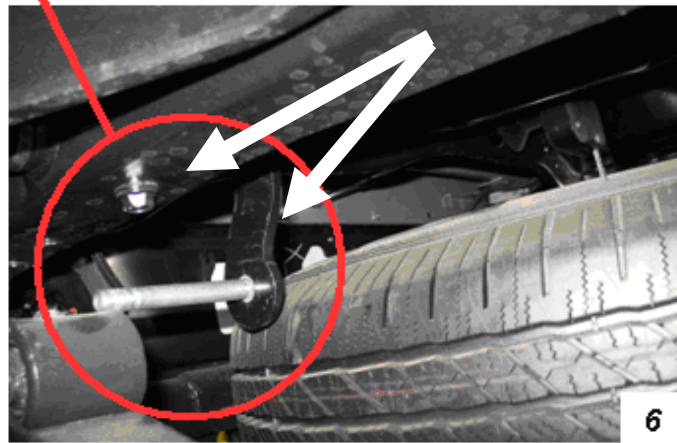
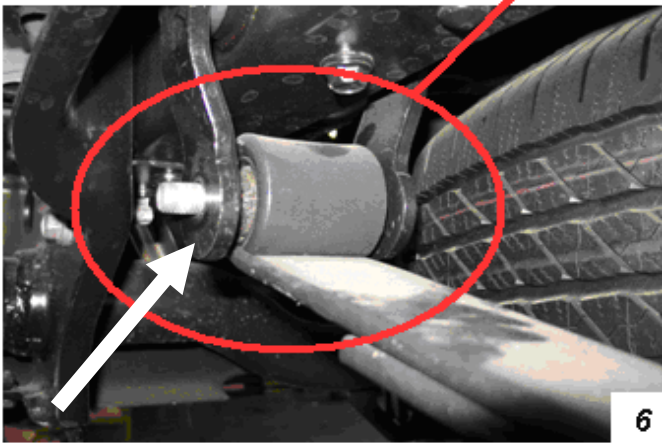
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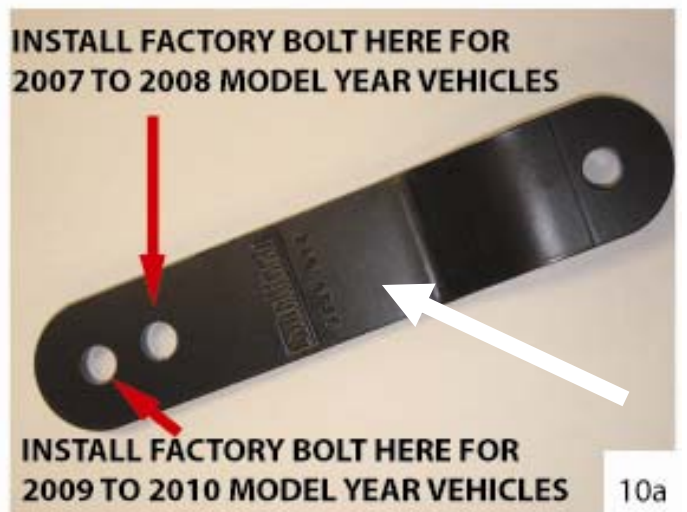
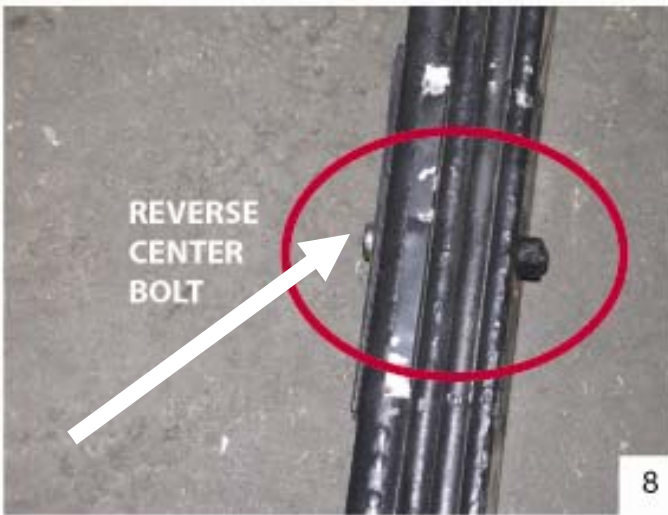
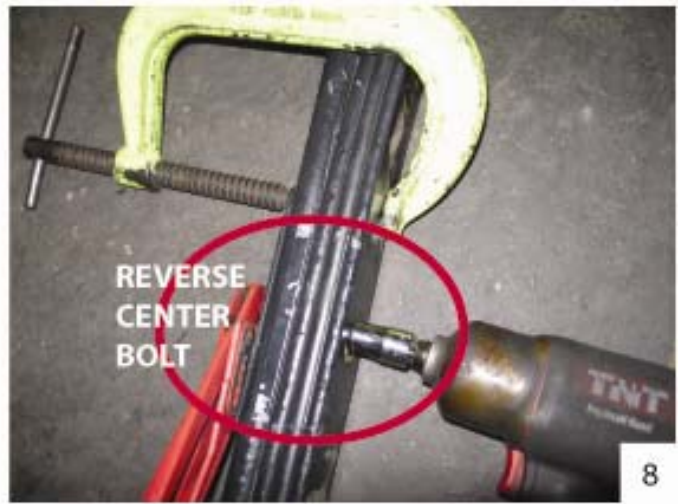


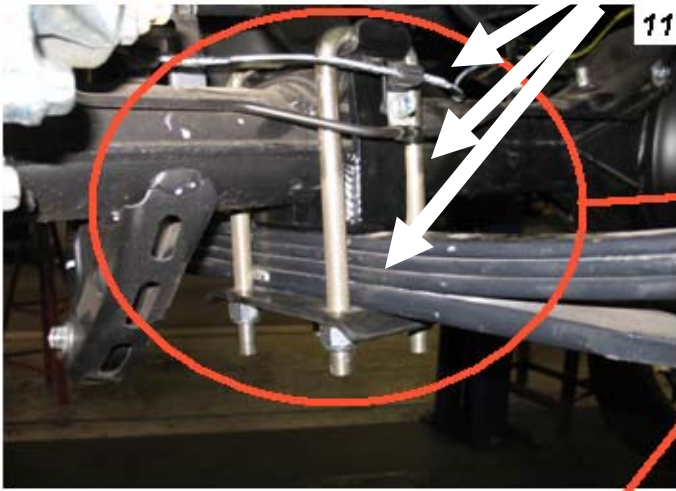
**LOWERING SPARE TIRE**



**REMOVING REAR OEM SHACKLE ASSEMBLY**



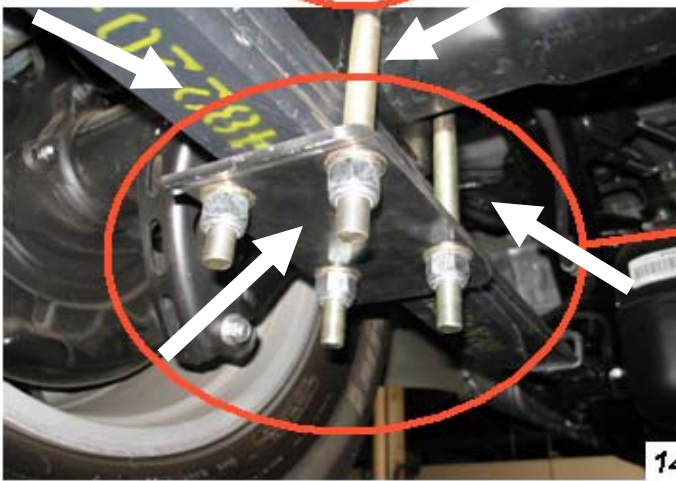
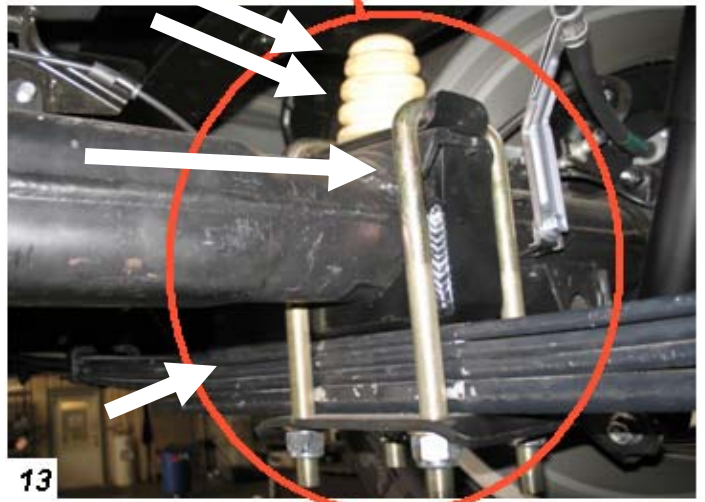
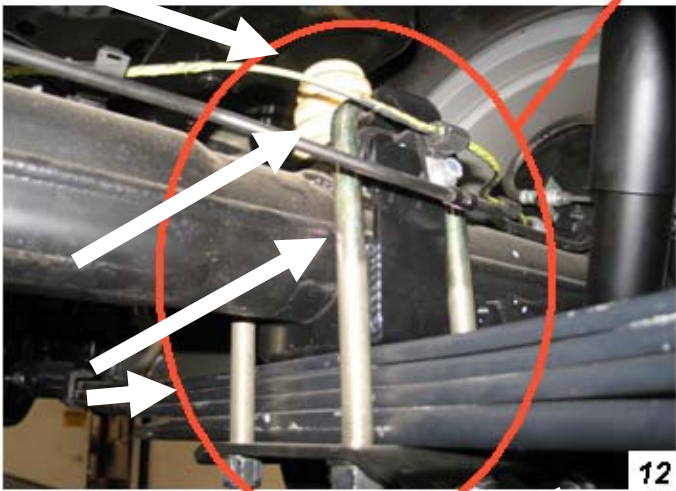




**INSTALLING SADDLES AND BUMP STOPS**

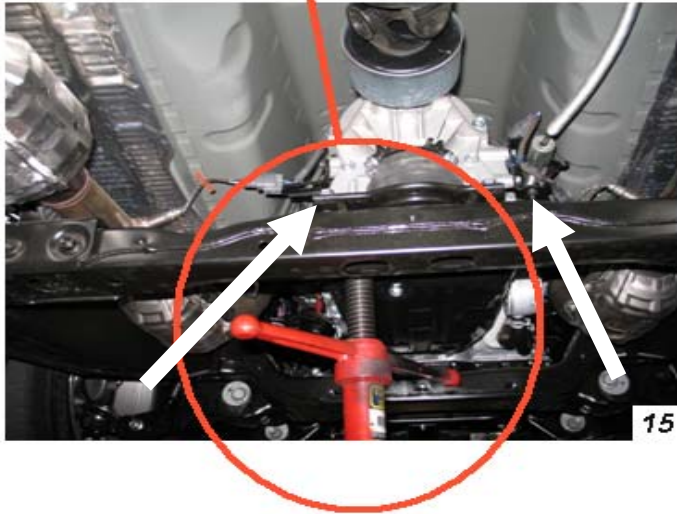
**TALL SIDE**

**SHORT SIDE**



**U-BOLT NUTS,  
TIGHTEN EVENLY**

**RAISE TRANSMISSION**



**INSTALL SPACERS**

