

# Hellwig PRODUCTS

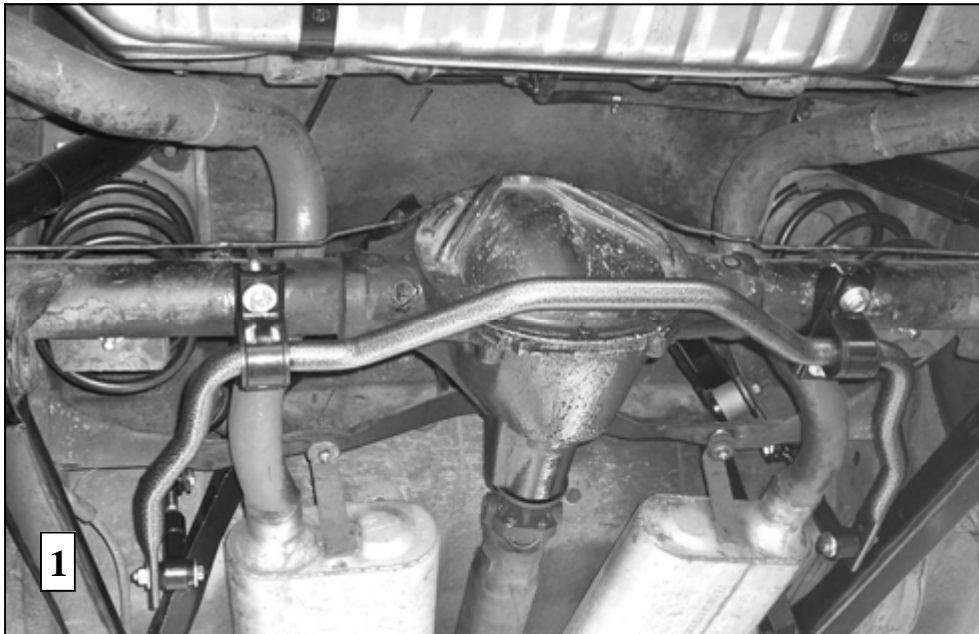
## INSTALLATION INSTRUCTIONS

**55864,55868**

### **GM A-Body Adjustable Rear Sway Bar With Integral End link/Tailpipe Mount (Patent Pending)**

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"—65 ft lbs \*Bolt Size 9/16"— 90 ft lbs

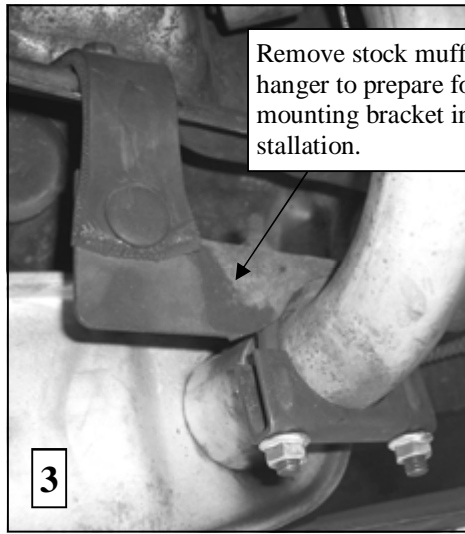
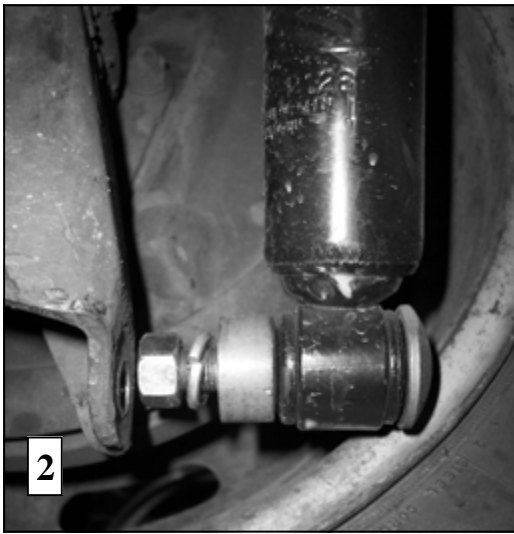
**SAFETY: BEFORE BEGINNING INSTALLATION BE SURE TO SET THE PARKING BRAKE AND CHOCK THE FRONT WHEELS.**

**NOTE: TO PROPERLY ADJUST THE BAR, THE WEIGHT OF THE VEHICLE MUST BE ON THE SUSPENSION AS IF DRIVING DOWN THE ROAD.**

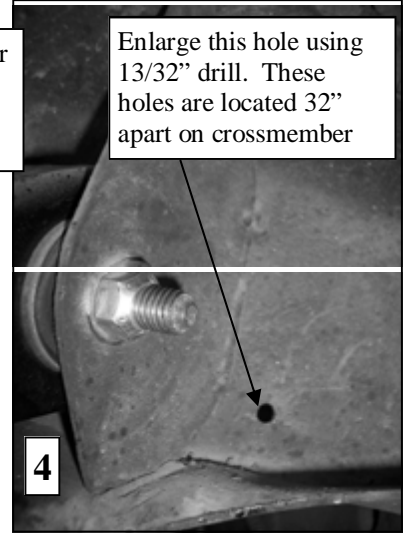
**NOTE: THIS KIT REQUIRES DRILLING THE FRAME RAIL AND POSSIBLE RELOCATION OF FUEL AND BRAKE LINES. INSTALLER MUST ENSURE THAT THE SWAY BAR KIT WILL NOT INTERFERE WITH ANY FUEL OR BRAKE LINES OR HOSES.**

**IMPORTANT NOTE: SWAY BAR END LINKS MUST BE ATTACHED ON OUTER HOLE PRIOR TO INITIAL USE.**

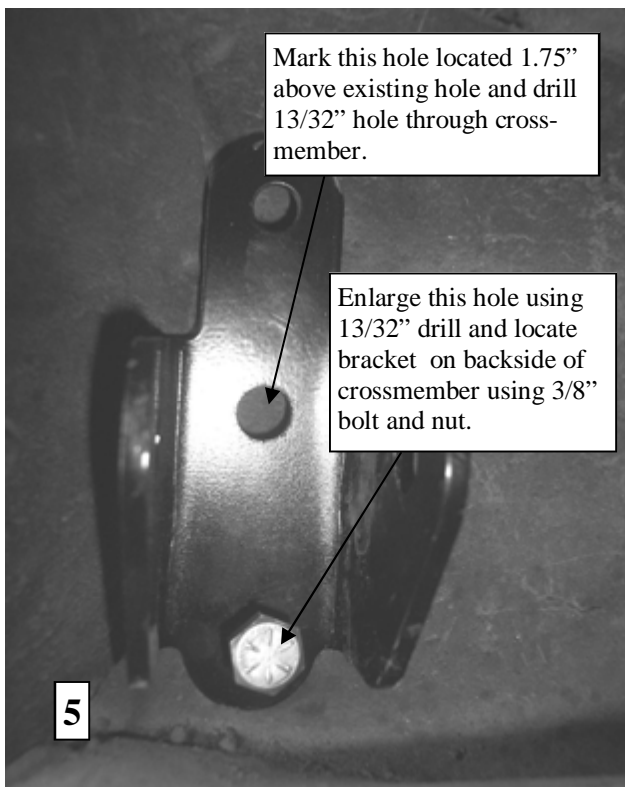
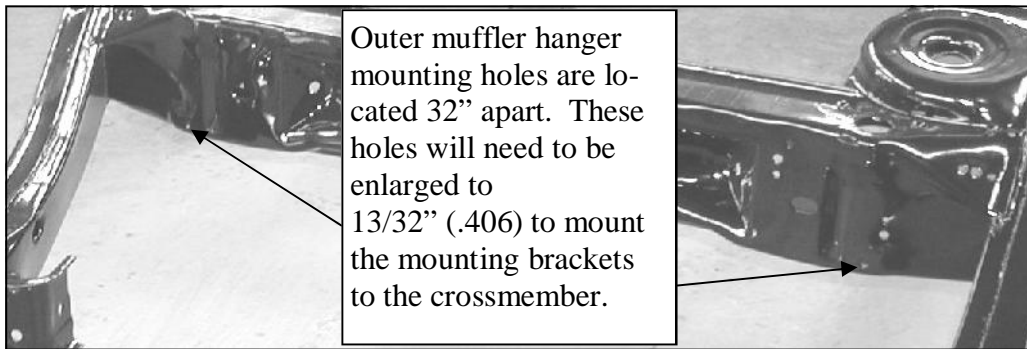
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Remove stock muffler hanger to prepare for mounting bracket installation.

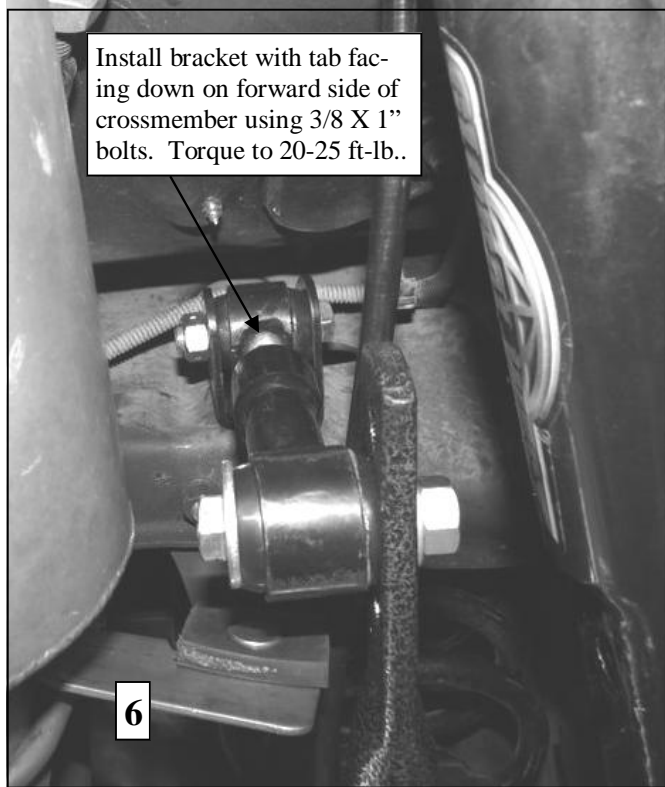


Enlarge this hole using 13/32" drill. These holes are located 32" apart on crossmember



Mark this hole located 1.75" above existing hole and drill 13/32" hole through crossmember.

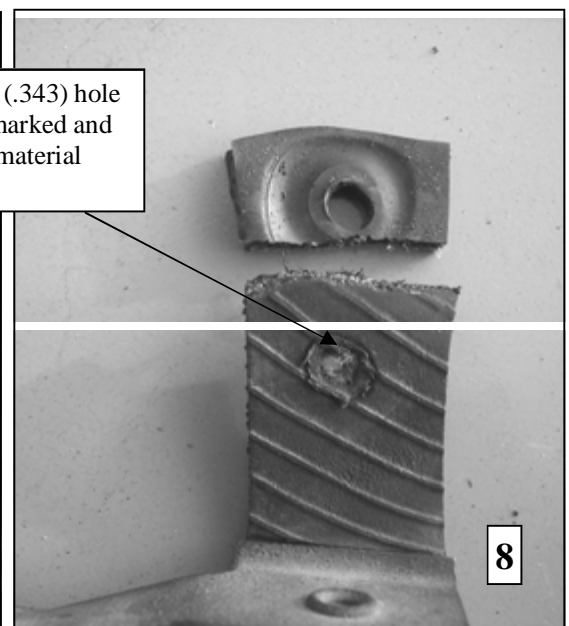
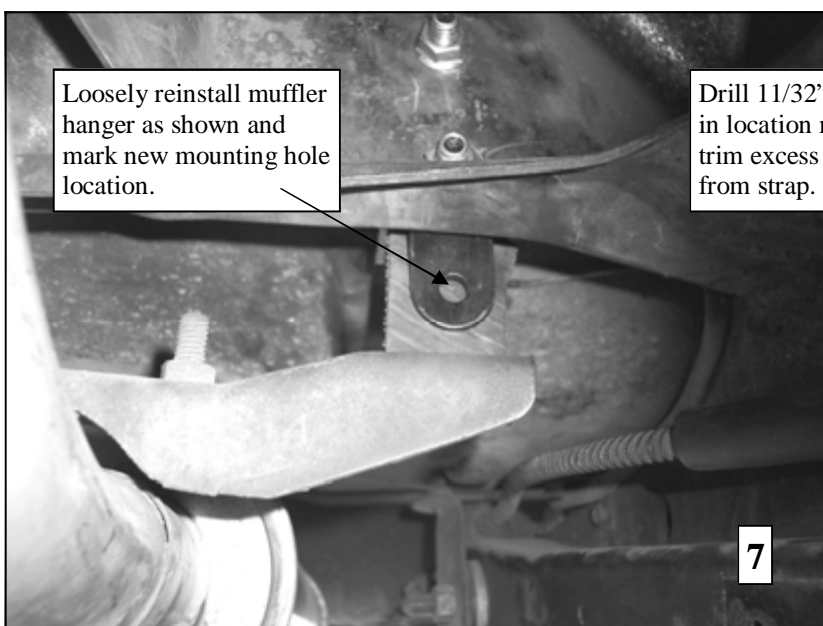
Enlarge this hole using 13/32" drill and locate bracket on backside of crossmember using 3/8" bolt and nut.



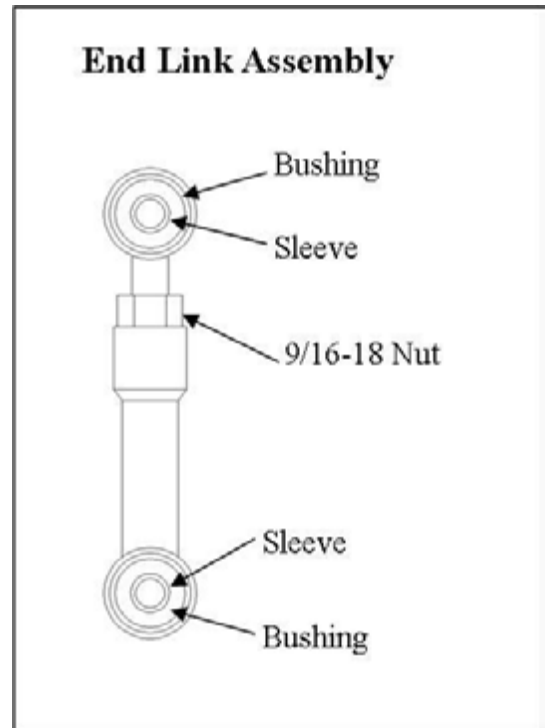
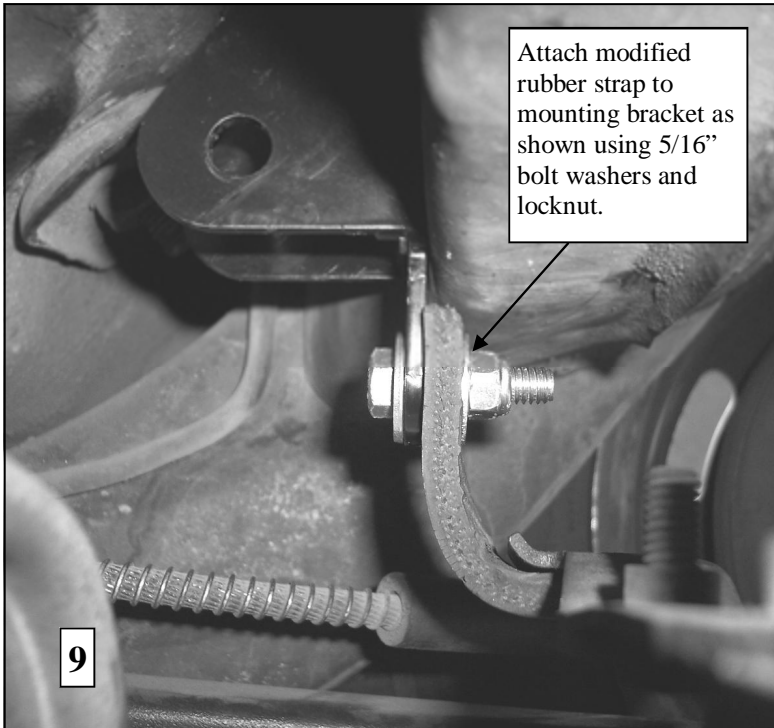
Install bracket with tab facing down on forward side of crossmember using 3/8 X 1" bolts. Torque to 20-25 ft-lb..

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1. Ensure that the vehicle is secure and stable before working under the vehicle.
2. If vehicle is equipped with factory rear sway bar, remove factory rear sway bar.
3. Disconnect rear shock absorbers from axle as shown in photo (2).
4. Chock front wheels and raise vehicle frame until rear coil springs are unloaded. Support frame with jack stands and remove coil springs from vehicle.
5. If equipped with stock muffler hangers, remove muffler hanger and set aside. See photo (3)
6. Locate outboard mounting hole for muffler hanger on each side of the vehicle. These holes will be located on the upper control arm crossmember about 32" apart. Enlarge these holes with a 13/32" (.406) diameter drill. See photo(4).
7. Install mounting bracket on backside of crossmember as shown in photo (5) with tab pointing up using 3/8 X 1" bolt and nut. The bracket will be used as a template to mark the location of the 13/32" (.406) hole that will need to be drilled 1.75" above the existing hole that was enlarged. See photo (5).
8. Align bracket so that it is vertical and mark location of hole as shown in photo (5). Remove bracket from frame rail and prepare to drill holes in rail.
9. **BEFORE DRILLING ANY HOLES IN THE RAIL—RELOCATE AND/OR PROTECT ANY FUEL OR BRAKE LINES THAT MAY INTERFERE WITH THE DRILL BIT OR SWAY BAR INSTALLATION.**
10. Drill 13/32" (.406) hole in frame for each mounting bracket.
11. Install mounting bracket on forward side of crossmember with tab pointing down as shown in photo (6) using 3/8 X 1" bolts, washers, and locknuts. Torque bolts to 20-25 ft-lb.
12. If equipped with stock-style muffler hangers, loosely reinstall muffler hanger as shown in photo (7) with outboard strap overlapping mounting bracket as shown. Locate new hole to be drilled in rubber strap.
13. Drill 11/32" (.343) hole in rubber strap and trim excess material from strap. See photo (8).
14. Re-install muffler hanger and attach outboard rubber strap to tab on mounting bracket using 5/16" bolt, washer and locknut as shown in photo (9).



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15. Re-install coil springs and attach shock absorbers to axle bracket. Torque shock bolts to factory specification. Set axle at ride height before proceeding with installation.
16. Assemble end links as shown in diagram. Assemble end links by inserting bushings first and then inner sleeve into outer sleeve of end link. **Fully lubricate bushings before installation.** Install 9/16" nut on threaded section of end link before assembling the two halves together as shown. **IMPORTANT NOTE - The end link threads are NOT powder coated so that the end links can be threaded together. To prevent corrosion, it is advised to lightly coat the exposed threads with black spray paint after adjusting to desired length.**
17. Attach end links to frame mounting bracket using 7/16 X 2-1/4" bolts and locknuts. **Leave loose for adjustment later.**
18. Lubricate the D shaped bushings and place them onto the straight areas of the bar on each side of the center hump as close to the outside bend as possible. See photo (1).
19. Hold sway 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.
20. Place the saddle brackets onto the U-Bolts on the axle tubes. 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 Stover locknuts provided. **LEAVE LOOSE AT THIS TIME** to allow for adjustment later.
21. Position sway bar on axle so that it clears all frame mounted components including fuel tanks, brake lines, fuel lines, exhaust pipes etc. Sway bar can be rotated back and forth on axle to maximize clearance.

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22. Attach end links to the outer hole of the sway bar as shown in photo (10) using 7/16-20 X 2-1/2" bolts, locknuts and washers. Align end links for best fit as shown in photo (10). **IMPORTANT NOTE – The end link must be attached to the outer hole prior to initial use.**
23. Adjust end links for best fitment of the sway bar to the vehicle.
24. When satisfied with the fit of the sway bar, torque axle U-bolts to 35-40 ft-lb.
25. Torque end link mounting bolts to 35-40 ft-lb. Tighten jam nut on end link to lock in adjustment.
26. **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.
27. **The sway bar has three end link mounting holes. The end link MUST be mounted on the outer hole for initial use. SEE PHOTO 10. For a firmer setting, use the inner holes. You must use the outer mounting hole as shown in photo 10 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.**