



INSTALLATION INSTRUCTIONS

For F-119K2.5

Parts Needed:

41-180	SAFE T PLUS Unit (Tan)
F-119K2.5	Mounting Hardware Kit consists of:
	55-119-6 Anchor Bracket
	55-206 Tie Rod Bracket
	12-38-1625K 3/8 X 1-5/8" U-Bolt Kit
	14-400 (2) 1/2-13 Hex Nut
	10-4-300-13 (2) 1/2-13 X 3 Bolt

Tools Needed:

Standard 9/16 sockets and/or wrench for the U-bolt nuts.
Standard 1 1/8 sockets and/or wrench for unit attachment bolts and Anchor bracket bolts.

NOTE: **If there is more than six inches of travel in either direction you must replace the original equipment stops on the steering arms with the 1/2 inch bolts and nuts provided. Adjust the tie rod travel to a maximum of six inches in each direction.**

1. Set front wheels of vehicle to a straight-ahead position. **This is important.** Later adjustment of the Tie Rod Bracket may be avoided if front wheels are set perfectly straight.
2. Remove nuts from axle spring rear U-Bolt on Passenger side, install Anchor Bracket 55-119-6, replace and tighten nuts securely. SAFE T PLUS unit is to be attached to topside of Anchor Bracket with 3/4" bolt, nut and washer provided.
3. Install Tie Rod Bracket on Tie Rod with U-Bolts provided.
4. a) Install small end of SAFE T PLUS Unit to Anchor Bracket on topside with 3/4" bolt, nut and washer provided. (See sketch)
b) Install large end of SAFE T PLUS unit to Tie Rod Bracket with bolt, nut & washer provided. (See sketch)
5. a) Tighten the unit bolt on Anchor Bracket to **80-90 foot pounds** of torque.
b) Tighten the U-Bolts on the Tie Rod Bracket to **25-35 foot pounds** of torque.

c) Finally, tighten the unit bolt on the Tie Rod Bracket to **80-90 foot pounds** of torque.

NOTE: It is important that the anchor bracket is mounted on the passenger's side of the vehicle and that step # be followed in the order as listed in these instructions for proper installation to be achieved.

6. Check to be sure installed unit clears all other parts of vehicle by turning steering wheel to both extreme right and left positions. If unit scrapes or binds at any point, review these instructions and make necessary corrections by rotating unit on Tie Rod to obtain necessary clearance.



