



## TT2402 E350 & E450 C-Chassis Rear Bar Installation Instructions

Each installation may vary due to chassis manufacturing options and variations in design. The rod assembly may be installed in several different combinations, such as either front or rear of the supplied brackets as well as using different bracket holes. The important thing is to maintain clearance between your trac bar and any chassis component (moving and stationary) such as exhaust, vehicle frame, differential, or any other item which might interfere with the operation of this product. Pictures and diagrams may not represent the best installation for every application.

### Bolt Torque Specifications

Torque in Foot-Pounds for Inch Bolts

Bolt Size	Grade 5	Grade 8
1/4"	10	14
5/16"	19	29
3/8"	33	47
7/16"	54	78
1/2"	78	119
5/8"	154	230
3/4"	257	380



### Bolt Torque Specifications

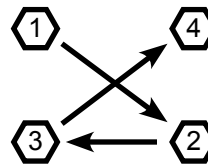
Torque in Foot-Pounds for Metric Bolts

Bolt Size	Grade 8.8	Grade 10.9
6MM	6	8
8MM	16	22
10MM	31	40
12MM	54	70
14MM	89	117
16MM	161	230
18MM	222	318

### Bolt Torque Specifications

Torque in Foot-Pounds for Grade 5 U-Bolts

Bolt Size	Fine	Course
3/8"	21	18
7/16"	33	29
1/2"	52	45
5/8"	107	91
3/4"	190	165
7/8"	304	270



\*Always tighten and torque u-bolts in a cross pattern sequence.

## NOTICE

- Only a qualified mechanic using normal automotive tools and following all safety standards should perform the installation of this product.
- If the vehicle is equipped with air bags be sure that nothing interferes with the deployment of them.
- Be sure to use a sufficient amount of Loctite® Red on all bolts before tightening. Tighten all bolts according to the torque charts provided or to the manufacturer's torque specifications on OEM parts. If no manufacturer specifications can be found then use the torque charts provided.
- Dealer or installer be certain the user receives these instruction sheets.

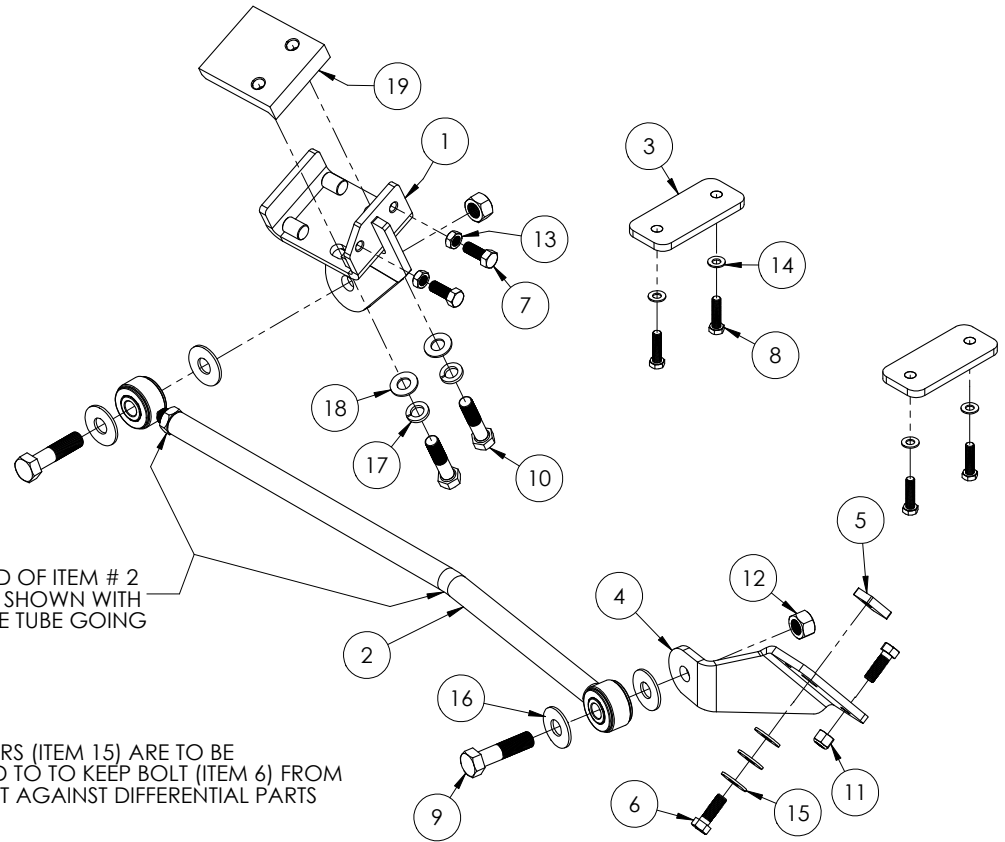
# TT2402

## E350 & E450 C-Chassis thru 2004 Rear Bar

### Installation Instructions

#### Tools Required

Torque Wrench  
 Loctite® RED  
 3/4" Socket  
 3/4" Wrench  
 15/16" Socket  
 1-1/16" Socket  
 1-1/8" Wrench  
 13MM Socket  
 17MM Socket



**NOTE:**  
 ADJUSTABLE END OF ITEM # 2  
 NEEDS TO BE AS SHOWN WITH  
 THE BEND OF THE TUBE GOING  
 UP AS SHOWN

**NOTE:**  
 THE FLAT WASHERS (ITEM 15) ARE TO BE  
 USED AS NEEDED TO TO KEEP BOLT (ITEM 6) FROM  
 BOTTOMING OUT AGAINST DIFFERENTIAL PARTS

Item No.	Part No.	Description	Qty.
1.....	61-6439 .....	Frame Bracket .....	1
2.....	62-3634 .....	TT2402 Rod Assembly .....	1
3.....	101-7117 .....	Sway Bar Spacer Plate .....	2
4.....	101-7145 .....	TT2402 Axle Bracket .....	1
5.....	102-7113 .....	1/2"-13 Nut Plate .....	1
6.....	201-0051 .....	1/2"-13 x 1-1/2" Hex Head Bolt, Grade 5, ZP .....	2
7.....	201-0308 .....	1/2"-20 x 1-1/4" Hex Head Bolt, Grade 5, ZP .....	2
8.....	201-0518 .....	10MM-1.5 x 40MM Hex Head Bolt, Grade 10.9, ZP .....	4
9.....	201-0632 .....	3/4"-16 x 3" Hex Head Bolt, Grade 5, ZP .....	2
10.....	201-0913 .....	5/8"-18 x 2-3/4" Hex Head Bolt, Grade 5, ZP .....	2
11.....	202-0094 .....	1/2"-13 Hex Nylon Lock Nut, ZP .....	1
12.....	202-0168 .....	3/4"-16 Stover Lock Nut, ZP .....	2
13.....	202-0184 .....	1/2"-20 Jam Hex Nut, ZP .....	2
14.....	203-0003 .....	3/8" Flat Washer, ZP .....	4
15.....	203-0005 .....	1/2" Flat Washer, ZP .....	3
16.....	203-0007 .....	3/4" Flat Washer, ZP .....	4
17.....	203-0013 .....	5/8" Lock Washer, ZP .....	2
18.....	203-0106 .....	5/8" SAE Flat Washer, ZP .....	2
19.....	229-0734 .....	Frame Bracket Nut Plate .....	1
20.....	190-0155 (not shown).....	10-1/2" Loom .....	1
21.....	290-0275 (not shown).....	8" Cable Tie .....	2

#### Important:

Use only genuine factory replacement parts on your trac bar. Do **NOT** substitute homemade or non-typical parts. If a bolt is lost or in need of replacement, for your safety and the preservation of your trac bar, be sure to use a replacement bolt of the same grade (In most cases it will be Grade 5, please reference the parts list above). Replacement parts may be ordered through your nearest Blue Ox® Dealer or Distributor.

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**Installation Instructions**

1. Position the vehicle on a level surface with the front wheels straight ahead and sitting at normal ride height. Set the brake and chock all the wheels.



2. If the vehicle has a sway bar equipped, install the sway bar spacers shown in the right photo prior to installing the axle bracket.

On the passenger side, remove the shock from the lower mount. Install the axle bracket onto the shock mount with the supplied 1/2" hardware and fully tighten.

Reinstall the shock to the mount with the factory hardware.

Note: The upper bolt/nut plate may need to be reversed for shock absorber clearance



3. Position the frame bracket onto the driver side frame rail and loosely secure it with the nut plate frame bracket and the 5/8" hardware. Loosely install the 1/2"-20 bolts and jam nuts into the frame bracket.

The bracket needs to be loose enough on the frame rail to move back & fourth to line up with the axle bracket.

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4. Install the rod assembly onto the axle bracket with one (1) 3/4"-16 x 3" bolt, two (2) 3/4" flat washers and a 3/4" lock nut. Be sure the flat washers are on either side of the urethane bushing. Position the frame bracket so it is straight with the axle bracket and rod assembly. Adjust the length of the rod assembly until you are able to pass a bolt thru both the rod assembly and frame bracket. Install a 3/4" bolt, two (2) flat washers and a 3/4" lock nut into the rod assembly and frame bracket. Leave all bolts finger tight for now



5. Once the frame bracket is straight with the rod assembly and axle bracket, alternately tighten down the 5/8" bolts on the frame bracket and torque to specifications. Then torque the 1/2"-20 x 1-1/4" bolts to the frame and tighten the jam nuts
6. Torque the 3/4" bolts in the rod assembly to specifications. Inspect for any wiring or hoses that may rub against the brackets and secure in a safe position with the loom and/or cable ties provided.

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