



2686 Highway 92 - Oskaloosa, IA 52577
phone: 641.673.0468 - fax: 641.673.4168
www.kelderman.com

03+ Gm 4500/5500 2x4 front Installation Instructions



1. Jack up the truck from the frame right behind the rear shackles and place a jack stand under the frame on each side of the truck in front of the axle. Remove the plastic fender liners.
2. Measure the leaf spring from the center pin back 9 1/2". Cut the leaf springs there. Remove the back half of the leaf spring.



Cut 9 1/2" back from center pin

**Optional aftermarket track bar
will be removed**



Passengers side

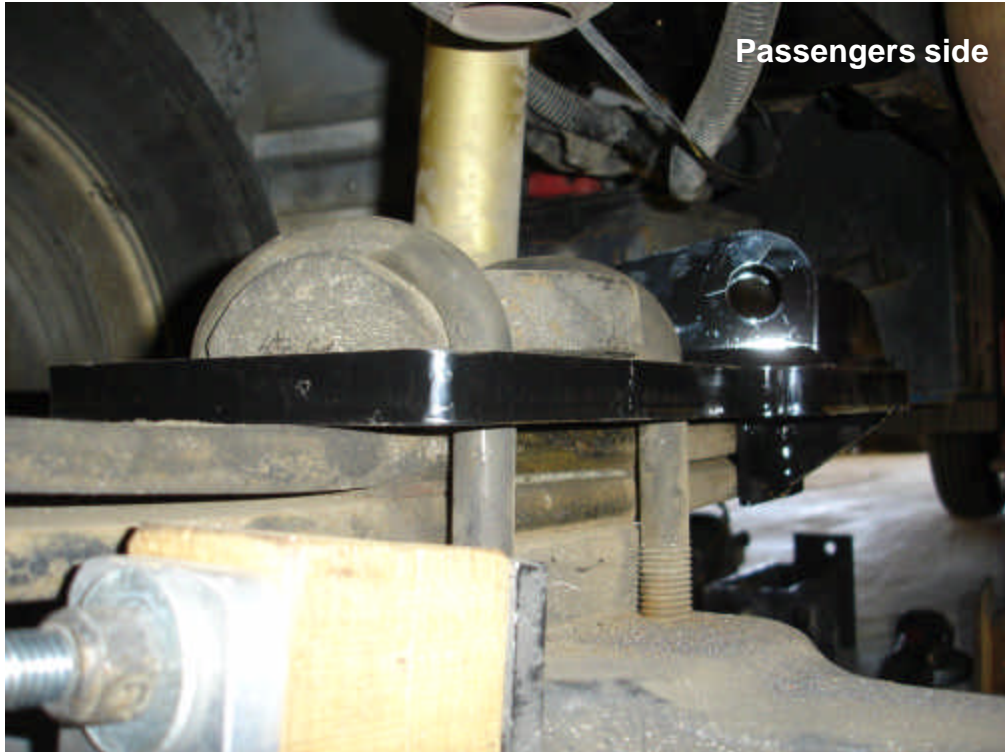
3. Remove the leaf spring U bolts and top casting. Locate the lower bag mounts and slide them over the top of the leaf springs. Put the top casting back in place and drop the u bolts back down. Torque the u bolts to 150 ft/lbs. The passengers side lower bag mount is the one with the pan hard bar mounting ears.



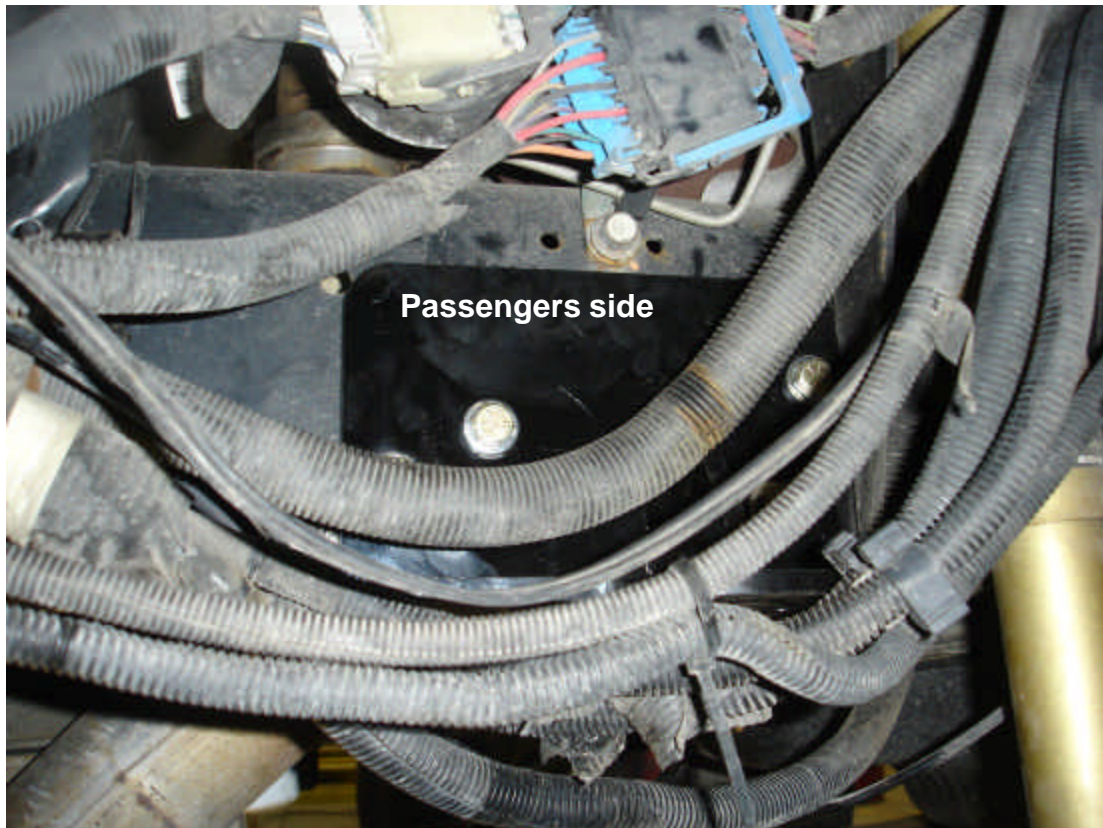
4. Locate the drivers side upper bag mount. This is the mount with the pan hard bar ears. Remove the four nuts that hold the transmission mount in place. Place the upper bag/pan hard bar mount against the frame and fasten it to the frame with the factory nuts and the four 1/2x2 1/2" bolts. Torque the bolts to 125 ft/lbs.

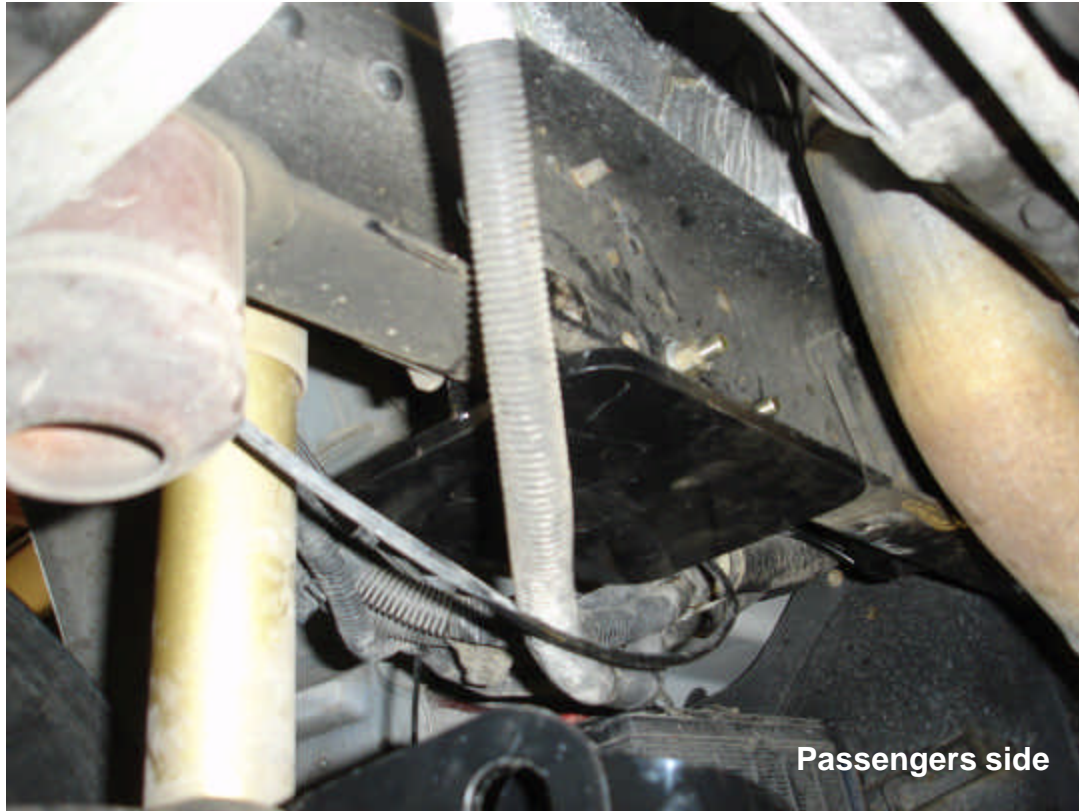


All these pictures drivers side



5. Locate the passengers side upper bag mount. Fasten in place with the 1/2x2" bolts. Torque to 85 ft/lbs. It hides behind all the truck wiring.

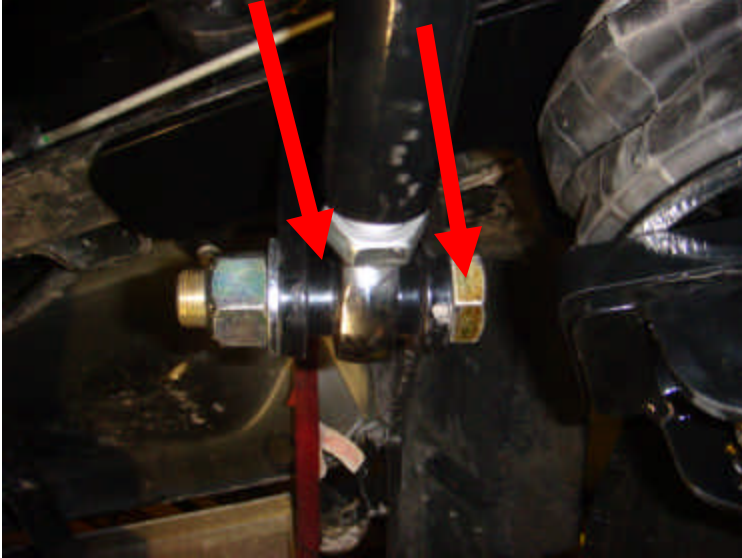




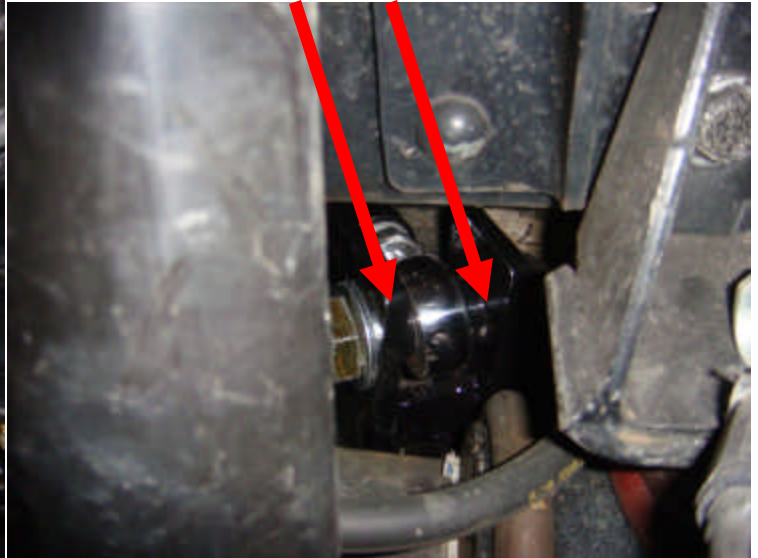
6. Locate the 5323 air bags. Slide the bag over the air bag mount and fasten in place with the 1/2x4" bolt. Use the supplies flat washer and lock nut.



Spacers on drivers side



Spacers on passengers side



Drivers side

Passengers side

7. Locate the pan hard bar. Use the 7/8x4" bolt, flat washers and lock nut to connect the heim ends into the pan hard bar ears. Make sure to use the supplied spacers to center the heim end in place. Once in place torque the bolts to 200 ft/lbs.

8. Locate the sway bar upper end link mounts. These fasten to the engine cross member. Use the 1/2x4 1/2" bolts to fasten through the holes in the cross member. Next, locate the lower sway bar mounts. Take off the front U bolt nuts and slide the mounts over the u bolts. Make sure the tabs with the two holes go towards the center of the vehicle. Tighten with the factory u bolt nuts. Torque to 150 ft/lbs.



Drivers side

Passengers side



Passengers side

Drivers side

1/2 x 2" bolts

9.

Locate the sway bar, blue bushings and "D" clamps. Put the blue bushings on the sway bar and slide the "D" clamps over it. Use the 1/2x2" bolts to fasten the sway bar to the lower sway bar mounts.

10. Next locate the end links. The end links fasten to the upper mounts with the 1/2x3" bolts. Make sure to run the drivers side bolt outside in, so the nut and treads are towards the center of the truck. Failure to do this may cause the leaf spring to rub on the bolts. Torque to 100 ft/lbs.

11. Attach the bottom of the end links to the sway bar. Torque the 1/2" bolts to 75 ft/lbs.



Sway bar mount



Drivers side

16. Inflate the bags to 8". Next adjust the pan hard bar so that the axle is centered. Make sure the wheels are straight and measure from the frame to the inside of the tires. Check the steering wheel. It should be close to straight. You may have to adjust the pan hard bar to get the wheel straight. It will not matter if the axle is off a 1/4" or so to make the steering wheel straight.
17. Now go back and retorque all the bolts.
18. Trim the fender liners so that they do not rub on the air bags.

