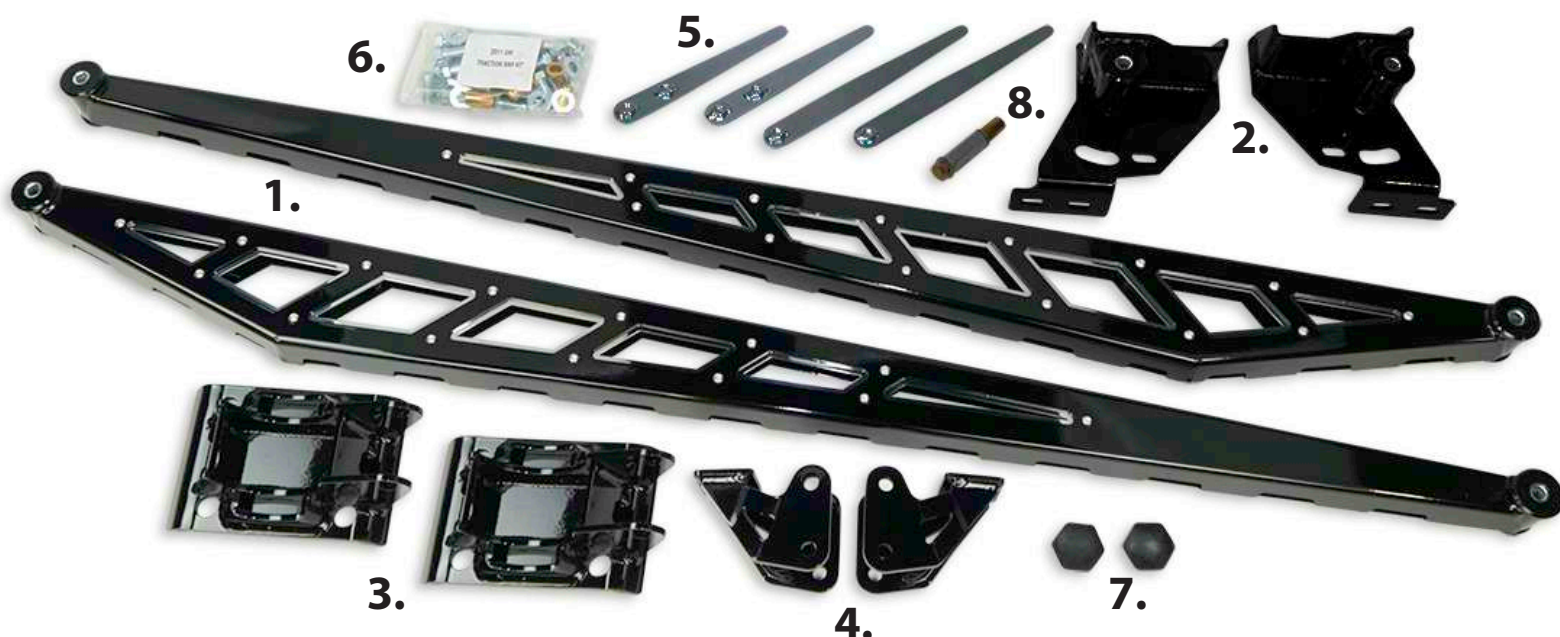


**READ THESE ENTIRE INSTRUCTIONS BEFORE STARTING ANYTHING**

## **2020+ GM 2500/3500 TRUCK**

### **TRACTION BAR INSTRUCTIONS (PART #52418)**

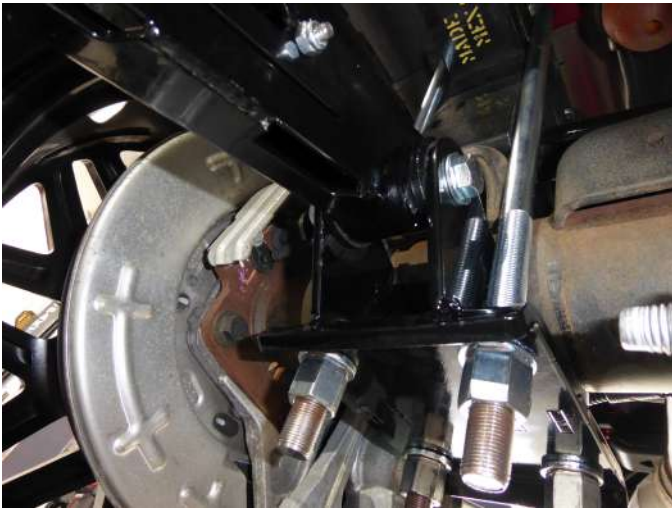
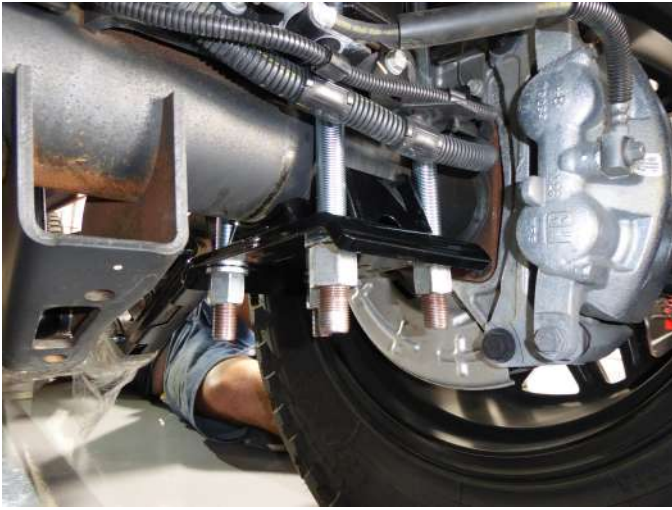
**\*\*\* NOTE\*\*\* Before powder-coating, painting, or installing kit. Be sure that all parts are in the boxes.**



#### **Kit Includes:**

- 1. Traction Bars (2)**
- 2. Front Frame Shackle Mounts (2)**
- 3. Rear Axle Mounts (2)**
- 4. Front Shackles (2)**
- 5. Frame Insert Nuts (4)**
- 6. Hardware Pack**
- 7. Bump Stops (2)**
- 8. Insert Nut Tool**
- \*9. Bushings (12)**
- \*10. Bushing Inserts (6)**
- \*11. S/S Inserts & Hardware (2)**

1. Using wheel chocks, secure front wheels. Raise rear of vehicle and support frame with jack stands. Support the rear axle with hydraulic jack.
2. With the axle supported, remove the passenger side u-bolts and lower u-bolt plate.
4. Install new provided u-bolts and lower u-bolt plate. Torque u-bolt nuts to factory specs.
5. Repeat this process on the driver side.
6. You can now drop the vehicle back on the ground. With the weight of the vehicle on the suspension, back the vehicle up and pull it forward again. This is to make sure the suspension is settled.



7. Now install provided bushings and sleeves in the traction bars.
8. Install backend of traction bar into the u-bolt mount using the provided hardware. DO NOT TIGHTEN YET.

9. Assemble shackles and frame mount brackets with provided bump stops, bushings, and sleeves.
10. Install the shackle onto the frame mount bracket using the provided hardware.
11. Now install traction bar onto shackle using the provided hardware.
12. With the brackets fully assembled, lift the frame mount up and place against the bottom of the frame. Making sure there is no gap between the bump stop and the frame mount.
13. Insert provided bottom (DUAL) nut bracket inside the frame and tighten using provided bolts.
14. Now insert provided side (SINGLE) nut bracket inside the frame and tighten.



15. With the frame bracket in place, use a scribe to mark the upper two holes.
16. With holes marked, remove the frame mount.



17. Use a center punch to correct mark the center of each hole. It is extremely important the the holes are drill correct. Drill each hole to 11/16".



18. With both holes drilled out, insert the two provided 1/2" bolts into the frame bracket with the provided rivet nuts installed.

19. Line up bracket with rivet nuts going into the hole drilled onto the frame.



20. Be sure to use an impact wrench on the two upper frame bolts. This will ensure that the rivet nuts are secure.
21. Reinstall the lower three bolts using the nut brackets inside the frame.
22. Now fully assemble shackle and traction bar back onto the frame mount.



23. Be sure to check the entire vehicle to make sure nothing is rubbing. Check all tires, brake lines, hoses, sensors, wires, etc, for clearance.

**AFTER 500 MILES, BE SURE TO GO OVER ALL PARTS AND RETORQUE ALL HARDWARE**