



**INSTALLATION INSTRUCTIONS  
FOR  
1999-2007 DODGE 2500, 3500 4X2 SERIES  
Gas or Diesel (including Dually)**

PARTS NEEDED:

Rev. 05-2013 IB

<b>31-140</b>	<b>SAFE-T-PLUS</b> unit (Silver)
<b>D-342K14</b>	<b>Mounting Hardware Kit</b> consists of:
	25-341            Anchor Bracket
	25-405           Tie Rod Bracket
	12-516-1250K   5/16 X 1 1/4" U-Bolt Kit

TOOLS NEEDED:

15mm Socket and/or wrench for the sway bar bolts.  
9/16 socket and/or wrench for the nuts on the end of the unit and the U-bolt nuts.

**STEP BY STEP PROCEDURES**

- Step 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.
- Step 2. Thoroughly clean the section of the tie rod that the 25-405 tie rod bracket mounts to.
- Step 3. Remove driver's (left) side sway bar bracket bolts and loosen bolts on passenger right side sway mount bracket. Using pry bar pull driver's side bracket down enough to insert anchor bracket 25-341 between frame and sway bar bracket. Make sure SAFE-T-PLUS mounting hole is toward the rear and to the inside of the sway bar bracket. (see sketch). Use the 1st & 4th hole on the long leg, counting from the end of that leg.
- Step 4. Reinstall and tighten bolts on both sway bar brackets.
- Step 5. Install tie rod bracket 25-405 onto large end of Safe-T-Plus unit using grommets and washers provided. (see sketch)

**NOTE: It is very important to insert the lip of the grommet into the mounting hole on the tie rod bracket.**

- Step 6. Tighten tie rod bracket on SAFE-T-PLUS unit with nut provided until rubber grommets slightly bulge over the steel washers or until they are approximately 1/4" thick.
- Step 7. Install small end of SAFE-T-PLUS unit into anchor bracket mounting hole with remaining grommets and washers. Follow procedures of Step 6 for proper tightness.
- Step 8. Attach tie rod bracket to the tie rod using the 5/16" x 1 1/4" U-bolts provided.

**NOTE: Rotate tie rod bracket on tie rod up or down in order that the**

large end of SAFE-T-PLUS is slightly higher than small end.  
when positioned, tighten the four (4) self locking u-bolt nuts to  
20-25 foot pounds of torque while maintaining an even  
amount of threads extending past each nut.

Step. 9 Check to be sure SAFE-T-PLUS unit clears all other components of the vehicle by turning wheels to full left and full right positions. If SAFE-T-PLUS unit scrapes or binds at any point, review these instructions and make necessary corrections by rotating tie rod bracket on the tie rod to obtain necessary clearance.

Step 10. **ROAD TEST & ADJUSTMENT PROCEDURES** – Step-by-Step instructions are provided herewith separately.

If you need additional technical assistance, please call our technical support team us toll-free at (800) 872-7233 or email us at [support@safe-t-plus.com](mailto:support@safe-t-plus.com).

