

INSTALLATION INSTRUCTIONS
For
1999-2002 FORD 250 4X4, F-350 4X4,
F-250 4X2, F-450 4X2, F-550 4X2, & Excursion
(Round Axle with Leafsprings)

PARTS NEEDED:

RGS 08-09-02

41-140	SAFE-T-PLUS unit (Red)
F-127K2	Mounting Hardware Kit consists of:
	55-127-11 Anchor Bracket
	55-206 Tie Rod Bracket
	12-38-1500K 3/8 X 1-1/2" U-Bolt Kit

TOOLS NEEDED:

9/16" Socket or wrench to tighten U-bolt nuts.
13/16" Socket to remove and tighten leafspring U-bolt nuts.
1-1/8" Sockets and/or wrenches to tighten 3/4 bolts on the ends of the unit.

Thoroughly clean the section to tie rod before attaching bracket. Remove the factory damper and its tie rod bracket. The anchor bracket at the other end can remain in place.

- 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. Suspension must be at ride height to keep unit from being preloaded and causing further adjustment.
- Step 2. Remove the four nuts from the passenger side leafspring U-bolts (See Figure). If the manufacturer's steering dampner is installed, it must be removed to get the Safe-T-Plus Anchor Bracket in place.
- Step 3. Install the Anchor Bracket and tighten the U-Bolt nuts to 115-150 foot pounds of torque. (See Figure)
- Step 4. Install the Tie Rod Bracket (55-206) to the Tie Rod as shown and snug up the nuts to the U-bolts. **Do not fully tighten the U-Bolts at this time.** (See Figure)
- Step 5. Install the small end of the unit to the topside of the Anchor Bracket using the 3/4" bolt set supplied with the unit and tighten to 80-90 foot pounds of torque. Install the large end of the SAFE-T-PLUS unit using the other bolt set supplied with the unit and tighten to 80-90 foot pounds of torque. (See Figure)
- Step 6. Rotate Tie Rod Bracket around tie rod so that the small end of the SAFE-T-PLUS unit is approximately 1/2" lower than the large end of unit. When positioned, tighten the four (4) U-Bolt nuts to 20-25 foot pounds of torque while maintaining an even amount of threads extending past each nut.

Step 8. Check to be sure all hardware is tight. Also check to be sure the installed unit clears all other parts of vehicle by turning steering wheel to both extremes right and left positions. If unit scrapes or binds at any point, review these instructions and make necessary corrections by rotating unit on the tie rod to obtain necessary clearance.

Step 9. ROAD TEST & ADJUSTMENT PROCEDURES: To ensure proper alignment and installation of the SAFE-T-PLUS unit, the vehicle should be road tested. Take along a socket wrench to fit the U-Bolts on the Tie Rod. While driving on a straight stretch of road, vehicle should easily follow a straight course, if not, adjustment is necessary. To adjust, hold steering wheel in a straightforward position, stop vehicle, and set brakes. Loosen nuts on Tie Rod U-Bolts and allow unit to self-center. (frequently this movement is not noticeable). Retighten nuts and test drive again. Repeat this step if necessary until vehicle will hold a straight line. Note: Continue to hold the steering wheel in a straightforward position until the adjustment has been completed. Otherwise the wheels will return to the pulling position instead of the straight-ahead position desired. If you need additional assistance, please call us toll-free at (800) 872-7233.

