

**INSTALLATION INSTRUCTIONS  
FOR  
1999 - 2010 FORD F-250 thru F-350 Super Duty Lariat  
4 X 2 (GAS OR DIESEL) TWIN I-BEAM AXLE**

**PARTS NEEDED:**

5-24-02 C

<b>31-140</b>	<b>SAFE-T-PLUS</b> unit (White)
<b>F-349K14</b>	<b>Mounting Hardware Kit</b> consists of:
	25-349                      Anchor Bracket
	25-419                      Tie Rod Bracket
	12-516-1250K              5/16 X 1-1/4" U-Bolt Kit
	10-M15-35      (2)      8.8 HCS 10 mm – 1.5 X 35Z

**TOOLS NEEDED:**

Standard 1/2" sockets and/or wrench for unit attachment bolts.  
Standard 9/16" socket and/or wrench for the U-bolts.  
Metric 17-mm socket for the Anchor Bracket bolts.

Thoroughly clean the section of the Tie Rod before attaching Tie Rod bracket.

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. Remove both bolts from driver's side stabilizer bar bracket.

Step 3. Install Safe-T-Plus unit to Anchor Bracket 25-349 using rubber-bushing kit provided.

Step 4. Install Safe-T-Plus Unit to Tie Rod Bracket 25-419 using rubber bushing kit provided.

**NOTE:              All grommets are to be tightened until they bulge over the edge of the steel caps or until they are approximately 1/4" thick.**

Step 5. Install Anchor Bracket 25-349 below the stabilizer bar bracket and the frame on driver's side. (See Figure 1).

Step 6. Install and tighten new Bolts 10-M15-35, which are longer to allow for thickness of bracket.

Step 7. Mount Tie Rod Bracket 25-419 to Tie Rod with U-Bolts provided (See Figure 2). After all other bolts are tight, tighten U-Bolt nuts to 20 - 25 ft. lbs.

Step 8. Check to be sure installed unit clears all other parts of vehicle by turning steering wheel to Both extreme 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.

Figure 1

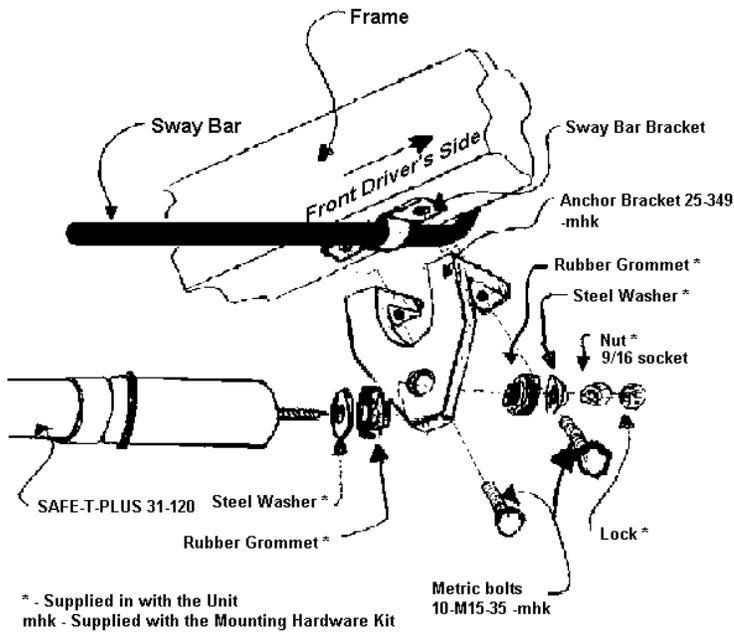


Figure 2

