

# INSTALLATION INSTRUCTIONS P-30K, P-32K, P-37K, P-CUTAWAY AND WORKHORSE P-32 THROUGH 2002

PARTS NEEDED:

4-9-03  
BKB/RK

<b>31-140</b>	<b>SAFE-T-PLUS</b> Unit (Silver)
<b>P-30KB13</b>	<b>Mounting Hardware Kit</b> consists of:
	25-301 Anchor Bracket
	25-311B Angle Bracket
	25-421 Tie Rod Bracket
	14-325 7/16-14 Top Lock Nut
	15-250 7/16 SAE Flat Washer
	16-100 1/2" X 1-1/2" X 1/4" Spacer
	10-3-350 7/16-14 X 3-1/2" Bolt
	12-516-1125K U-bolt Kit (5/16" X 1-1/8")

Thoroughly clean the section of tie rod before attaching 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 nut from frame brace bar on passenger's side of frame. Discard washer.
- Step 3. Position 25-301 Anchor Bracket on frame brace bar bolt. Reinstall nut but **do not tighten at this time.**
- Step 4. The 25-311B is mounted to the sway bar bracket in order to capture / sandwich against the anchor bracket using the 7/16 X 3 1/2 bolt and space as shown. Hook 25-311B Angle Bracket on the inside rear of sway bar bracket, placing 1/4" spacer washer between anchor bracket and outside rear of sway bar bracket. Insert bolt through diameter hole in Anchor Bracket and install flat washer and nut onto bolt. Tighten all nuts at this time.
- Step 5. Place steel retainer cap and rubber grommet on threaded rod end of the Small end of the SAFE-T-PLUS unit and insert through mounting hole in Tie Rod Bracket. (Shoulder of grommet towards bracket.) Install other grommet shoulder of grommet toward bracket), steel cap and nut and tighten, (see NOTE on page 2 of these instructions). Install locking PAL nut (flat side against nut) and tighten. (Tie Rod Bracket will be fastened to tie rod later.)

**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 6. Insert **large diameter end** SAFE-T-PLUS unit through mounting hole in Anchor Bracket. Follow same procedures as described in Step 5 for grommet installation.

- Step 7. Using the U-Bolts and nuts provided, attach Tie Rod Bracket to Tie Rod.  
**Thoroughly clean the section of Tie Rod where bracket is to be attached.**  
 Rotate Tie Rod Bracket around Tie Rod so the small diameter end of unit is approximately 1/2" lower than large end. Note: Unit can be inverted to accomplish proper positioning when necessary. When positioned, tighten the four 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 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 the instructions and make necessary corrections by rotating unit on the tie rod to obtain the necessary clearance.
- Step 9. ROAD TEST AND ADJUSTMENT PROCEDURES (two people required) To Ensure proper alignment and installation of the SAFE-T-PLUS unit, the 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 may return to the pulling position instead of the desired straight-ahead position. If additional assistance is needed, please call SAFE-T- PLUS toll free at 800-872-7233.

