



Solid Steel Industrial Manufacturing Ltd.

Installation Instructions For Dodge Ram Track Bar Conversion Bracket **(Refer to diagram on back of this page)**

Some 1994 and 1995 models have a small brace bolted to the edge of the frame tab and cross-member. Remove this brace and use two 1/2" flat washers as a spacer between the cross-member and TBK track bar mount. Later models have a reinforcing gusset welded to the tab and cross-member and may require one or two of the 1/2" flat washers as a spacer.

Retain mounting bolt from lower track bar bushing for re-use.

Remove rearmost steering box mounting bolt and retain for re-use. (Except with Borgeson box, which will require alternate bolt P/N: TBK BOLT)

Be sure to insert tapered bushing into frame tab. (1994 models have smaller diameter tapered hole and will require drilling the hole out to accept the 5/8" bolt provided without the tapered bushing)

Insert 1/2" X 5" bolt through cross-member from above - hole is right beside steering shaft. ** NOTE: Due to the difference in cross-member size on some trucks, it may be required to use the 1/2" X 4 1/2" bolt (torqued to 40 ft/lbs) in the center mounting location. Both the 5" and 4 1/2" bolts are supplied in the hardware kit. This bolt may be at an angle when installed. This is due to the offset holes in the cross-member. This is normal, however you may want to ream out the holes in the cross-member to align them. DO NOT MODIFY THE MOUNTING HOLES IN THE TBK BRACKET.**

Loosely install the steering box bolt, rotate the TBK assembly upward and fit any required 1/2" spacers, then assemble nylock nut to the 1/2" bolt.

Inspect the mating surface between the TBK and truck where the 5/8" bolt goes through the TBK. In some cases, the factory weld protrudes far enough to prevent a snug fit. If the gap is more than 1/8", insert the 5/8" USS (large diameter) flat washer between TBK bracket and tapered bushing, insert 5/8" bolt, 5/8" SAE washer and lock nut and loosely tighten the bolt

Install the track bar to ensure proper orientation alignment of the TBK and track bar.

Tighten all bolts gradually to values given in diagram below, and torque the track bar bolts to 155 ft/lb.

On trucks with steering dampener located on the axle rather than the frame, it may be necessary to install the dampener on the outside (forward) of the original mounting tabs. Use the spacer and 12mm X 110mm bolt provided to do this.

Your steering wheel may require re-centering after installation. Adjust the adjustment sleeve on the tie rod adjacent to the pitman arm to accomplish this. If the steering wheel is off to the left, you will need to shorten the tie rod. If the steering wheel is off to the right, you will need to lengthen the tie rod. DO NOT ATTEMPT TO RECENTER THE STEERING WHEEL BY ANY OTHER METHOD.

Recheck all bolts after 500 miles and then periodically for proper torque.

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