



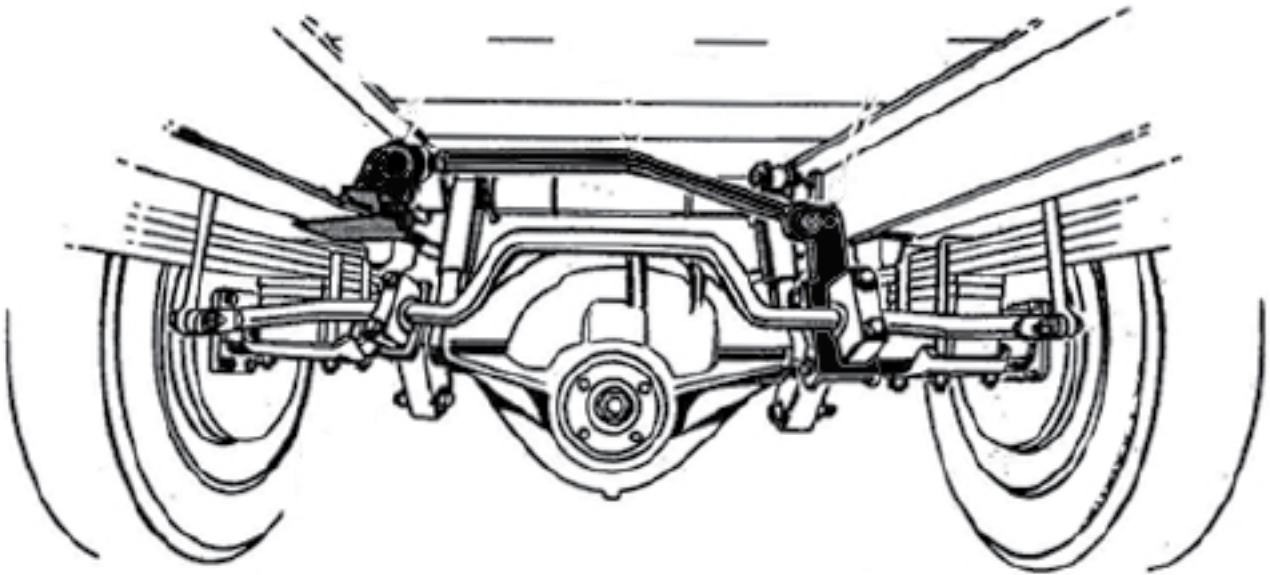
## **TT2400**

### **Ford F-53 14K, 16K & 18K GVW**

### **Motor Home Chassis Rear Bar**

### **Installation Instructions**

Each installation may vary due to chassis manufacturing options and variations in design. The rod assembly may be installed in several different combinations, such as either front or rear of the supplied brackets as well as using different bracket holes. The important thing is to maintain clearance between your trac bar and any chassis component (moving and stationary) such as exhaust, vehicle frame, differential, or any other item which might interfere with the operation of this product. Pictures and diagrams may not represent the best installation for every application.



### ***NOTICE***

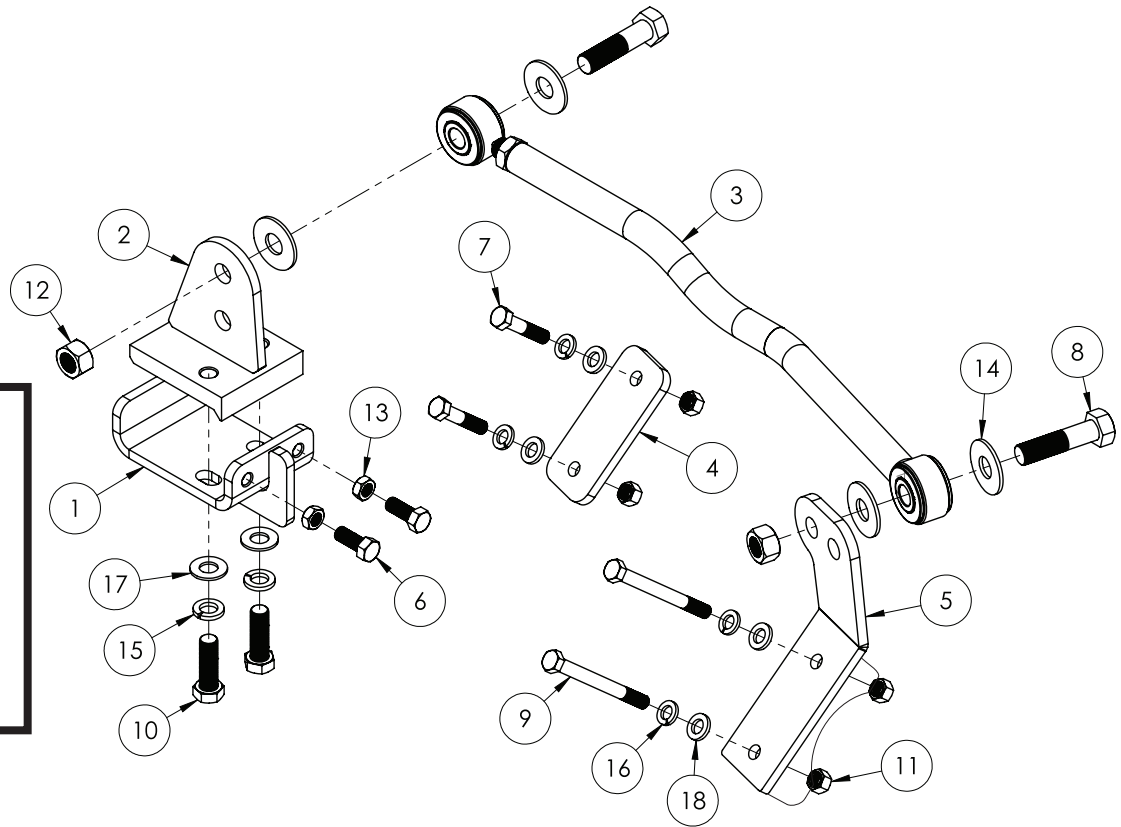
- Only a qualified mechanic using normal automotive tools and following all safety standards should perform the installation of this product.
- If the vehicle is equipped with air bags be sure that nothing interferes with the deployment of them.
- Be sure to use a sufficient amount of Loctite® Red on all bolts before tightening. Tighten all bolts according to the torque charts provided or to the manufacturer's torque specifications on OEM parts.

# TT2400

## Ford F-53 14K, 16K & 18K GVW Motor Home Chassis Rear Bar Installation Instructions

**Tools Required**

Torque Wrench  
 Loctite® RED  
 1/2" Wrench  
 3/4" Socket  
 3/4" Wrench  
 15/16" Socket  
 1-1/16" Socket  
 1-1/8" Wrench  
 6" Drive Extension



Item No.	Part Number	Description	Qty.
1.....	61-6745.....	Frame Bracket Weldment .....	1
2.....	61-6746.....	Nut Plate Frame Bracket .....	1
3.....	62-3636.....	TT2400 Rod Assembly .....	1
4.....	101-7117.....	Spacer Plate .....	1
5.....	101-7121.....	Mounting Bracket.....	1
6.....	201-0308.....	1/2"-20 x 1-1/4" Hex Head Bolt, Grade 5, ZP .....	2
7.....	201-0467.....	12MM-1.75MM x 50MM Hex Head Bolt, Grade 10.9.....	2
8.....	201-0632.....	3/4"-16 x 3" Hex Head Bolt, Grade 5, ZP.....	2
9.....	201-0817.....	12MM-1.75MM x 120MM Hex Head Bolt, Grade 10.9.....	2
10.....	201-0912.....	5/8"-18 x 2" Hex Head Bolt, Grade 5, ZP.....	2
11.....	202-0117.....	12MM-1.75MM Hex Nut, ZP .....	4
12.....	202-0168.....	3/4"-16 Stover Lock Nut, ZP .....	2
13.....	202-0184.....	1/2"-20 Jam Hex Nut, Grade 5, ZP .....	2
14.....	203-0007.....	3/4" Flat Washer, ZP .....	4
15.....	203-0013.....	5/8" Lock Washer, ZP .....	2
16.....	203-0105.....	12MM Lock Washer, ZP.....	4
17.....	203-0106.....	5/8" SAE Flat Washer, ZP.....	2
18.....	203-0112.....	12MM Flat Washer, ZP .....	4
19.....	190-0155(not shown).....	10-1/2" Loom Flex, Grade .413 ID .....	1
20.....	290-0275(not shown).....	8" Nylon Cable Tie .....	2

### Important:

Use only genuine factory replacement parts on your trac bar. Do **NOT** substitute homemade or non-typical parts. If a bolt is lost or in need of replacement, for your safety and the preservation of your trac bar, be sure to use a replacement bolt of the same grade (In most cases it will be Grade 5, please reference the parts list above).

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Before beginning work, position the vehicle on a level surface with the front wheels straight ahead and the coach sitting at normal ride height. Set the park brake and chock the wheels for added safety.

### **Axle Bracket Installation**

1. On some chassis the sway bar brackets are held on with 10mm bolts. We suggest that you remove the bolts and the nuts that are tack welded on the differential and replace them with the 12mm bolts (#7 & #9) that are included in the kit. On other models, they already have 12mm bolts, but you will still want to replace with the longer 12mm bolts supplied in the kit.
2. Remove the bolts from the sway bar on both the driver and passenger side (2 each). On the driver's side, install the axle bracket (#5) underneath the sway bar bracket with the supplied hardware. Torque bolts (#9) to 50 ft. lbs.
3. There are 4 holes drilled and tapped in the side of the axle bracket to accept the four square head set-screws. Put a drop of Loctite on each set-screw and thread into the tapped holes. The axle bracket has slotted holes in it to accomodate shifting the bracket to clearance the factory bump stop on some coaches. Tighten the set-screws down until they contact the bracket that is welded to the differential. If you have to shift the axle bracket over you may not need to use the set screws on the outside of the bracket.
4. On the passenger side insert the spacer plate (#4) between the sway bar bracket and differential and use the supplied bolts (#7) and torque to 50 ft. lbs.

### **Frame Bracket and Rod Installation**

5. Position the frame bracket (#1) onto the passenger side frame rail and loosely secure with the nut plate frame bracket (#2) and the 5/8"-18 x 2" (#10) bolts with 5/8" lock (#15) and flat washers (#17). Loosely install the the two 1/2"-20 x 1.25" (#6) bolts with the 1/2"-20 (#13) jam nuts into the frame bracket. The bracket needs to be loose enough on the frame rail to move back and forth to line up with the axle bracket.
6. Install the rod assembly onto the axle bracket with one 3/4"-16 x 3" (#8) bolt, two 3/4" (#14) flat washers and a 3/4" (#12) lock nut. Be sure the flat washers are on either side of the urethane bushing. Position the frame bracket so it is straight with the axle bracket and rod assembly. Adjust the length of the rod assembly until you are able to pass a bolt through both the rod assembly and frame bracket. Install a 3/4" (#8) bolt, two flat washers (#14) and a 3/4" (#12) lock nut into the rod assembly and frame bracket. Leave all bolts just finger tight for now.
7. Once the frame bracket is straight with the rod assembly and axle bracket, alternately tighten down the 5/8" (#10) bolts on the frame bracket and torque bolts to 80 ft. lbs. Torque the 1/2"-20 x 1.25" (#6) bolts 40 ft. lbs. but be careful not to over-tighten as it will pull strip the threads. Torque jam nuts (#13) to 35 ft. lbs. to keep the bolts from backing out.

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8. Torque the 3/4" (#5) bolts on the rod assembly to 150 ft. lb.

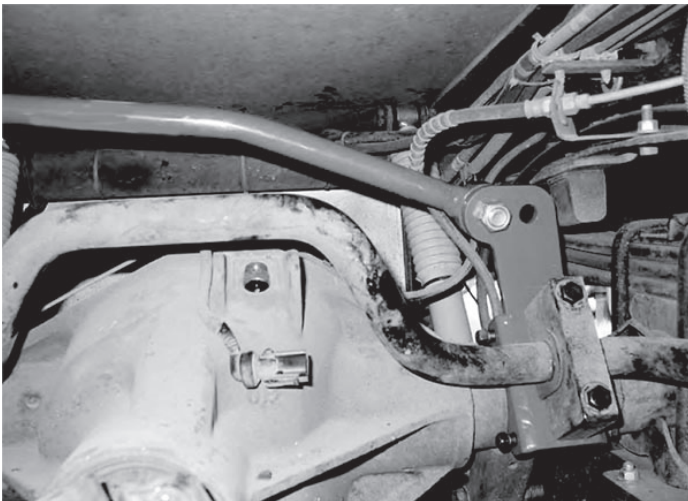
### Finishing Up

9. Double check all fasteners for proper torque value if indicated. If you have had the RV raised up while performing the installation, you will want to double check all clearances once weight is put back onto the suspension.

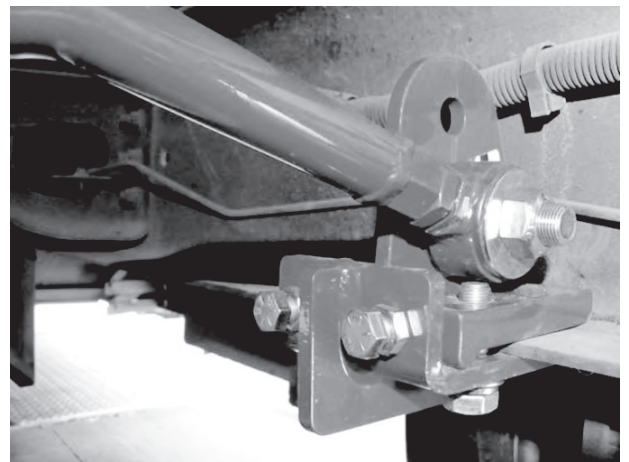
#### Bolt Torque Specifications

Item #	Torque
6: Bolt 1/2" - 20 x 1.25"	40 #
7/9: Bolt 12mm-1.75mm	50 #
8: Bolt 3/4"-16 x 3"	150 #
10: Bolt 5/8"-18 x 2"	80 #
13: Jam Nut 1/2"-20	35 #

10. Re-check torque on bolts after 500 miles of driving.



Looking back at rear axle from front



Passenger side frame rail from rear of coach looking forwards