



FORD F250 4WD 4" SUSPENSION LIFT INSTALLATION INSTRUCTIONS 1977^{1/2}-79 **KIT # F2504**

⚠ WARNING

Installation of a Performance Automotive Group body lift kit will change the vehicle's center of gravity and handling characteristics both on- and off-road. You must drive the vehicle safely! Extreme care must be taken to prevent vehicle rollover or loss of control, which could result in serious injury or death. Avoid sudden sharp turns or abrupt maneuvers and always make sure all vehicle occupants have their seat belts fastened.

⚠ NOTE

After installing this kit, it may be necessary to replace the driveshaft "U"-joints more frequently. Also, the driveshaft(s) may vibrate, but several procedures specified at the end of this document can be performed to lessen the vibration.

⚠ WARNING

Always wear eye protection when operating power tools.

⚠ WARNING

Proper installation of this kit requires knowledge of the factory recommended procedures for removal and installation of original equipment components. Performance Automotive Group recommends that the factory shop manual and any special tools needed to service the vehicle be on hand during installation. Installation of this kit without proper knowledge of the factory recommended procedures may affect the performance of these components and the safety of the vehicle. Performance Automotive Group strongly recommends that a certified mechanic familiar with the installation of offroad products install this kit.

⚠ WARNING

Performance Automotive Group recommends applying the kit Loctite® to the threads of all nuts and bolts involved in this procedure unless specified otherwise.

⚠ WARNING

Installation of a Performance Automotive Group lift kit will raise the vehicle center of gravity which will change the vehicle handling characteristics and reduce the inertia required to cause the vehicle to roll over. Drive the vehicle with extreme care! Drive at reduced speed and avoid sharp turns. Always ensure all vehicle occupants have their seat belts fastened.

⚠ WARNING

Performance Automotive Group strongly recommends using the TrailMaster shock absorbers that were engineered to be used with this kit. If using other shocks, they **MUST EXACTLY MATCH** the fully extended and fully collapsed lengths of the TrailMaster shocks. The use of longer or shorter shocks may damage the suspension parts and result in loss of vehicle control. To determine the exact length of the shocks that must be used with this kit, contact Performance Automotive Group.

⚠ WARNING

State laws: Many state and local laws specify a maximum allowable bumper height and contain other restrictions related to the installation of lift kits. Before installing this kit, verify that the resulting changes to the vehicle will maintain its compliance with the law.

⚠ NOTE

This kit may not fit on vehicles equipped with another lift kit, an extra heavy duty suspension package, a special towing package, or any other aftermarket suspension components (springs, bushings, etc.).

⚠ WARNING

This kit should only be installed on a vehicle that is in good mechanical condition. Before installing the kit, replace worn or corroded parts. If the vehicle is suspected to have been in a collision or abused, **DO NOT** install the kit. The components in this kit do not eliminate weaknesses that may exist in the original equipment components.

⚠ WARNING

This kit contains a warning label that is intended for the vehicle occupants. Apply the label to the dashboard in plain sight of all occupants.

Before Starting Installation

⚠ WARNING

Before installing this kit, read and understand all procedures, warnings, cautions, and notes in this instruction sheet. Also, read the appropriate sections of the factory service manual and the vehicle owner's manual. If any of the information in these documents is unclear, DO NOT install this kit.

⚠ NOTE

Kit parts are prefaced by the word **kit** and appear in **bold** print.

1. Carefully read all warnings and instructions completely before beginning.
2. Verify all parts have been received in this kit by checking the parts list in this document. Contact the place of purchase or your nearest dealer if parts differ from those specified.
3. **Only install this kit on the vehicle for which it is specified.** If anytime during the installation you encounter something different from what is outlined in the instructions, call technical support at (928) 636-3175.
4. Park the vehicle on a clean, dry, flat, level surface and block the tires so the vehicle cannot roll in either direction.

Parts List

<u>Qty.</u>	<u>Description</u>
2	Spring , front leaf
4	Bolt , "U" 9/16" x 3" x 7 1/4"
8	Nut , 9/16" fine high
8	Washer , 9/16" SAE
2	Spring , R2150 rear add-a-leaf
1	Block , steering
3	Bolt , 9/16" x 3 1/2"
2	Pin , 3/8" fine center
2	Nut , 3/8" fine
1	Loctite ®

Install Kit

Front Axle

1. Lift front of vehicle with hydraulic jack or equivalent.
2. Place jack stands under frame behind leaf spring hangers.
3. Remove front wheels.
4. Remove front shock absorbers.
5. Support front axle housing with hydraulic jack.
6. Remove front "U"-bolts.
7. Lower the hydraulic jack and front axle housing away from leaf springs.
8. Remove bolts holding leaf springs to spring hangers.
9. Remove leaf springs.
10. Install kit **leaf springs** on spring hangers using stock bolts. DO NOT tighten at this time.
11. Using hydraulic jack, lift front axle housing and install it on kit **leaf springs** using kit "**U**"-bolts, kit **fine high nuts** (9/16"), and kit **SAE washers** (9/16").
12. Remove three nuts and coned washers holding steering arm to front axle housing. Disconnect steering arm from front axle housing. Remove studs from front axle housing.
13. Apply Loctite to threads of kit **bolts** (9/16" x 3 1/2"). Install kit **steering block** on front axle housing using kit **bolts**, stock coned washers, and stock nuts. Tighten kit bolts to manufacturer's specification.
14. Install new (longer) front shock absorbers.
15. Install front wheels.
16. Lower the front end of vehicle to ground.
17. Tighten bolts holding leaf springs to spring hangers.

Rear Axle

1. Lift rear of vehicle with hydraulic jack or equivalent.
 2. Place jack stands under frame just forward of leaf spring hangers.
 3. Remove rear wheels.
 4. Remove rear shock absorbers.
 5. Support rear axle housing with hydraulic jack.
 6. Remove rear "U"-bolts.
 7. Lower the hydraulic jack and rear axle housing away from leaf springs.
 8. Using a "C"-clamp or similar tool, clamp spring pack together (except the overload spring). Remove center pin and overload spring.
 9. Place kit **rear add-a-leaf** on spring pack, drawing the entire stack together with a "C"-clamp.
 10. Install kit **center pins** on spring pack with kit **center pin** (3/8" fine) and kit **fine nut** (3/8"). Remove "C"-clamp from spring pack.
 11. Using hydraulic jack, lift rear axle housing and install it on leaf springs using "U"-bolts and nuts. Tighten nuts to manufacturer's specification.
 12. Install new (longer) rear shock absorbers.
 13. Install rear wheels.
 14. Lower the rear of vehicle to ground.
 15. Ensure all fasteners are tight.
- a. Perform a steering sweep test to ensure the brake hoses have sufficient slack and will not contact other parts. If necessary, replace the brake hoses with longer ones to ensure there is adequate slack in the hoses when the suspension is fully unloaded. Longer hoses may be available through your local parts supplier. Check the brake lines for damage. Test the brake system.
2. Miscellaneous
 - a. Check all fasteners for proper torque. Check to ensure there is adequate clearance between all fixed and moving parts including exhaust components, brake lines, fuel lines, fuel tank, floor board, and wiring harnesses.
3. Warning Label
 - a. Install the kit **label** (warning) in the cab so it can easily be seen by all vehicle occupants. If the label is lost or damaged, call TrailMaster at (928) 636-3175 to request a replacement.
4. Headlights
 - a. Adjust the headlights.

After Completing Installation

1. Steering/brake hoses

5. Alignment

- a. Align the vehicle to the manufacturer's specification. The size of rim and tire combination should be considered alignment.

⚠ WARNING

All warranty information, instruction sheets, and other documents regarding the installation of this product must be retained by the vehicle owner. Information contained in the instructions and on the warranty card will be required for any warranty claims. The vehicle owner needs to understand the modifications made to the vehicle and how they affect handling and performance. Failure to provide the customer with this information can result in damage to the vehicle or severe personal injury.

⚠ WARNING

It may be necessary to replace the driveshaft "U"-joints more frequently. If the driveshaft vibrates, perform one of more of the following procedures to lessen the vibration:

⚠ WARNING

DO NOT exceed the maximum vehicle payload specified by the manufacturer.

⚠ WARNING

To prevent worn, damaged, or loose parts from suddenly failing and causing loss of vehicle control, perform the following steps every six months (or 500 miles, whichever comes first) and after EACH offroad use:

- Inspect for worn or damaged kit and factory parts in the suspension, braking, and steering systems
- Retorque all nuts and bolts according to the specifications in this document or in the factory service manual as appropriate.

⚠ WARNING

Always use a spare tire of equal size to the other tires on the vehicle.