

INSTALL INSTRUCTIONS

**STOCK HEIGHT 4-LINK REAR
2019+ CHEVROLET 4500-6500**



KIT # 10006311 - 10008314

kelderman



KELDERMAN MANUFACTURING

2686 HIGHWAY 92 EASTOSKALOOSA, IOWA 52577

INFO@KELDERMAN.COM 1-800-334-6150

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KIT NUMBERS

- THIS INSTALLATION MANUAL COVERS THE FOLLOWING AIR RIDE KITS.

KIT NUMBER	DESCRIPTION
10006311	2019+ CHEVROLET 4500/5500/6500 - 4-LINK REAR - STOCK HEIGHT - 4-1/4" X 4-5/8" AXLE
10008314	2019+ CHEVROLET 4500/5500/6500 (J27) - 4-LINK REAR - STOCK HEIGHT - 4-7/8" X 5-1/2" AXLE



INTRODUCTION

IMPORTANT

- ◆ IT IS IMPORTANT THAT THE ENTIRE INSTALLATION INSTRUCTIONS BE READ THOROUGHLY BEFORE PROCEEDING WITH INSTALLATION.
- ◆ IF YOUR KIT WAS ORDERED RAW, OPEN EVERY BOX AND LOCATE ALL PARTS. THERE ARE SEVERAL SMALLER BUSHING PIECES AND BOLTS THAT ARE PACKAGED SEPARATELY INSIDE THE MAIN BOX.

PRODUCT INSTALLER RESPONSIBILITIES

- ◆ INSTALLER IS RESPONSIBLE FOR INSTALLING THIS PRODUCT IN ACCORDANCE WITH KELDERMAN MFG. INC. SPECIFICATIONS AND INSTALLATION INSTRUCTIONS.
- ◆ INSTALLER IS RESPONSIBLE FOR PROVIDING PROPER INSTALLATION OF VEHICLE COMPONENTS AND ATTACHMENTS AS WELL AS REQUIRED OR NECESSARY CLEARANCE FOR SUSPENSION COMPONENTS, AXLES, WHEELS, TIRES, AND OTHER VEHICLE COMPONENTS TO ENSURE A SAFE AND SOUND INSTALLATION AND OPERATION OF THIS PRODUCT.

DEFINITION OF TERMS

- ◆ **WARNING:** INDICATES A POTENTIALLY HAZARDOUS SITUATION WHICH, IF NOT AVOIDED, COULD RESULT IN DEATH OR SERIOUS INJURY.
- ◆ **CAUTION:** A POTENTIAL HAZARDOUS SITUATION MAY RESULT IN PROPERTY DAMAGE.
- ◆ **NOTE:** PROVIDE INFORMATION OR SUGGESTIONS THAT HELP CORRECTLY PERFORM A TASK.
- ◆ **TORQUE:** WHEN ITALICIZED “TORQUE” ALERTS THE INSTALLER TO TIGHTEN FASTENERS TO A SPECIFIED VALUE.

BOLT TORQUE CHART

BOLT SIZE	GRADE 5 TORQUE	GRADE 8 TORQUE
1/4"-20	<i>8 FT-LB</i>	<i>12 FT-LB</i>
3/8"-16	<i>31 FT-LB</i>	<i>44 FT-LB</i>
3/8"-24	<i>35 FT-LB</i>	<i>49 FT-LB</i>
1/2"-13	<i>75 FT-LB</i>	<i>106 FT-LB</i>
1/2"-20	<i>85 FT-LB</i>	<i>120 FT-LB</i>
9/16"-18	<i>121 FT-LB</i>	<i>171 FT-LB</i>
5/8"-11	<i>150 FT-LB</i>	<i>212 FT-LB</i>
5/8"-18	<i>170 FT-LB</i>	<i>240 FT-LB</i>
3/4"-16	<i>297 FT-LB</i>	<i>420 FT-LB</i>
7/8"-14	<i>474 FT-LB</i>	<i>669 FT-LB</i>

SAFETY

YOUR SAFETY AND THE SAFETY OF OTHERS IS VERY IMPORTANT.

- ◆ READ AND UNDERSTAND ALL SAFETY PRECAUTIONS AND INSTRUCTIONS BEFORE INSTALLING THIS PRODUCT.

CAUTION: TRUCKS EQUIPPED WITH PARKING SENSORS OR OTHER LIKE DEVICES.

- ◆ RELOCATION OF THESE DEVICES WILL ALTER THE FIELD OF VIEW. IT IS THE RESPONSIBILITY OF THE OWNER TO UNDERSTAND HOW THESE CHANGES AFFECT THE OPERATION OF THESE SYSTEMS.

WARNING: COMPONENTS UNDER PRESSURE.

- ◆ BLEED ALL PRESSURE FROM THE AIR SYSTEM BEFORE PERFORMING ANY MAINTENANCE OR SERVICE. SERIOUS INJURY COULD OCCUR IF COMPONENTS ARE REMOVED WHILE SYSTEM IS PRESSURIZED.

WARNING: CARELESS INSTALLATION CAN RESULT IN SERIOUS INJURY OR PROPERTY DAMAGE

- ◆ WEAR EYE PROTECTION.
- ◆ DISCONNECT THE BATTERY BEFORE DOING ANY WORK ON THE VEHICLE.
- ◆ WORK ON FLAT LEVEL GROUND.
- ◆ ENSURE TRUCK IS PROPERLY SUPPORTED BY JACK STANDS. NEVER WORK UNDER A VEHICLE SUPPORTED ONLY BY HYDRAULIC JACKS.
- ◆ TAKE PRECAUTIONS WHEN LIFTING PRODUCT. DUE TO THE SIZE AND WEIGHT OF THIS PRODUCT TWO PEOPLE ARE RECOMMENDED FOR INSTALLATION.
- ◆ NEVER WORK DIRECTLY UNDER THE PRODUCT UNTIL IT HAS BEEN SECURELY FASTENED TO THE VEHICLE.
- ◆ AVOID SHARP, HOT, AND MOVING COMPONENTS WHEN ROUTING ELECTRICAL CABLES AND AIR LINES.
- ◆ IF DRILLING, INSPECT BOTH SIDES OF THE SURFACE AND REMOVE/RELOCATE ANY OBJECTS LOCATED IN THE WAY.
- ◆ ENSURE ALL BOLTS ARE PROPERLY TIGHTENED BEFORE DRIVING.

PRODUCT OWNER RESPONSIBILITIES

- ◆ PRODUCT OWNER IS SOLELY RESPONSIBLE FOR PRE-OPERATION INSPECTION, PERIODIC INSPECTIONS, MAINTENANCE, AND USE OF THE PRODUCT AS SPECIFIED BY KELDERMAN MFG. INC. OF PARTICULAR IMPORTANCE IS THE RE-TORQUE OF FASTENERS.
- ◆ THIS RE-TORQUE MUST BE PERFORMED WITHIN 2500 MILES OF THIS PRODUCT BEING PUT INTO SERVICE.
- ◆ THE KELDERMAN AIR SUSPENSION IS FULLY AUTOMATIC IN CONTROLLING THE HEIGHT OF THE CHASSIS WHEN PROPERLY INSTALLED.
- ◆ NO MANUAL INTERVENTION TO CONTROL AIR PRESSURE OR RIDE HEIGHT IS NEEDED DURING THE COURSE OF NORMAL OPERATION.
- ◆ PRODUCT OWNER IS RESPONSIBLE FOR “*DOWN TIME*” EXPENSES, CARGO DAMAGE, AND ALL BUSINESS COSTS AND LOSSES RESULTING FROM A WARRANTABLE FAILURE.

SERVICE INTERVALS

FIRST 2,500 MILES

- ◆ CHECK RIDE HEIGHT $\pm 1/4$ ”
- ◆ CHECK FOR AIR LEAKS AROUND FITTINGS.
- ◆ CHECK FOR ANY LOOSE OR RUBBING HOSES AND WIRES.
- ◆ RE-TORQUE ALL HARDWARE.

EVERY 30,000 MILES

- ◆ CHECK RIDE HEIGHT $\pm 1/4$ ”
- ◆ CHECK FOR AIR LEAKS AROUND FITTINGS.

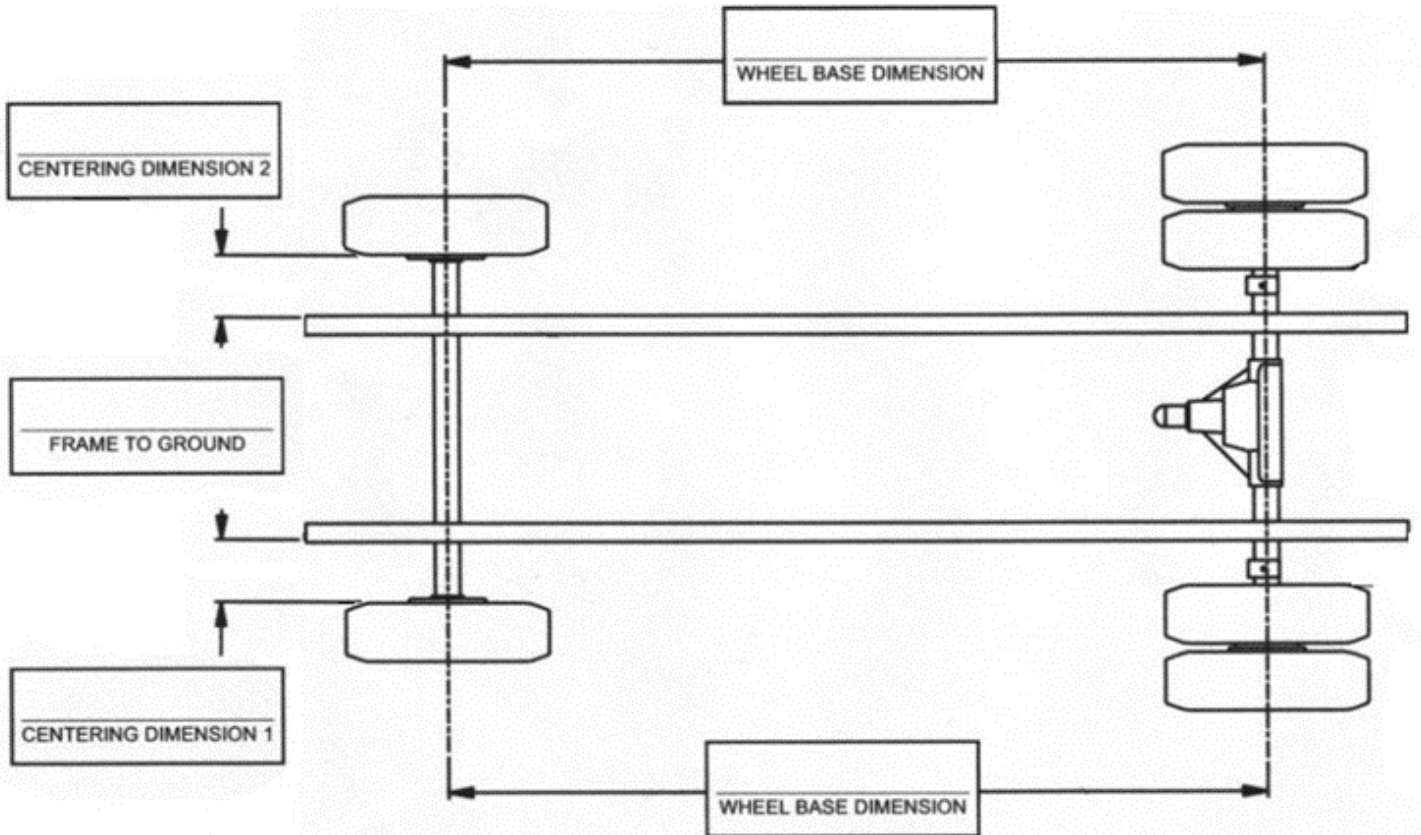
DISASSEMBLY

1. BEFORE DOING ANYTHING, MEASURE THE PINION ANGLE AND RECORD IT. THIS IS IMPORTANT BECAUSE YOU WILL NEED TO PUT THE AXLE BACK TO THIS MEASUREMENT AFTER INSTALLATION. SEE FIGURE 1.

PINION ANGLE _____



2. TAKE THE FOLLOWING MEASUREMENTS FOR FUTURE REFERENCE. THESE MEASUREMENTS WILL BE USED TO ADJUST THE SUSPENSION AFTER INSTALLATION.



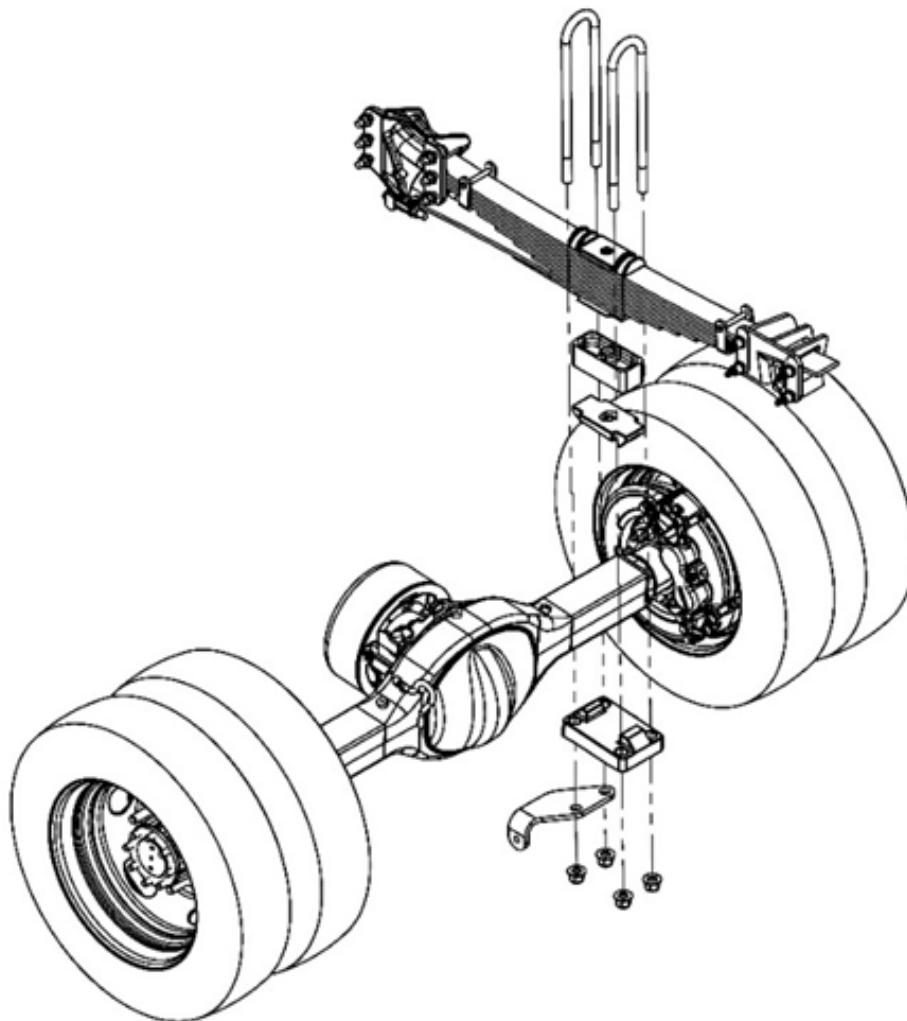
3. CHOCK THE FRONT WHEELS. LIFT THE REAR OF THE VEHICLE JUST ENOUGH TO TAKE THE WEIGHT OFF THE LEAF SPRINGS. PLACE JACK STANDS UNDER THE FRAME AND CHOCK THE REAR TIRES SO THE AXLE WON'T ROLL. SUPPORT THE FRONT OF THE PINION WITH A JACK STAND.

4. IF EQUIPPED, UN-BOLT AND REMOVE THE SHOCK ABSORBERS.

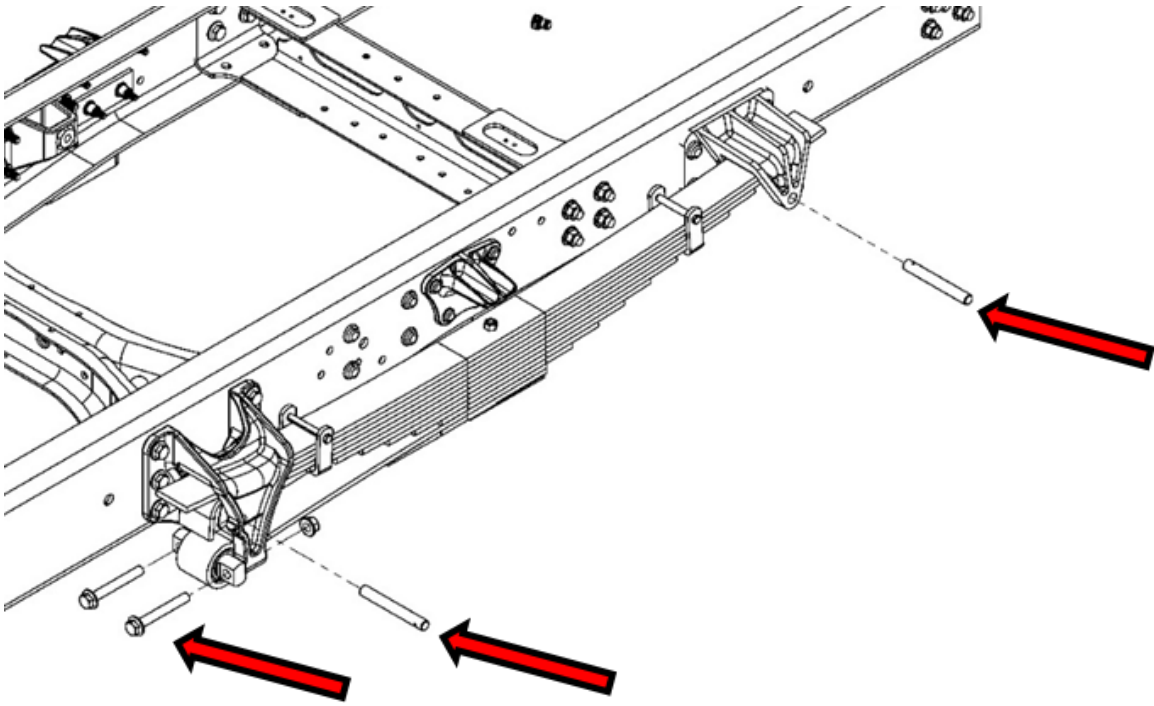
5. UNBOLT THE PARKING BRAKE CABLE BRACKET FROM THE TOP OF THE DIFFERENTIAL HOUSING.

6. REMOVE ANY EXHAUST THAT EXTENDS OVER AND PAST THE REAR AXLE. **NOTE:** ON TRUCKS EQUIPPED WITH THIS STYLE EXHAUST IT WILL NEED TO BE MODIFIED TO EXIT IN FRONT OF THE AXLE.

7. UNBOLT THE LEAF SPRINGS FROM THE AXLE. KEEP THE CAST LOWER AXLE CLAMPS, THEY WILL BE REUSED DURING INSTALL. **NOTE:** THE TIRES DO NOT NEED TO BE REMOVED.

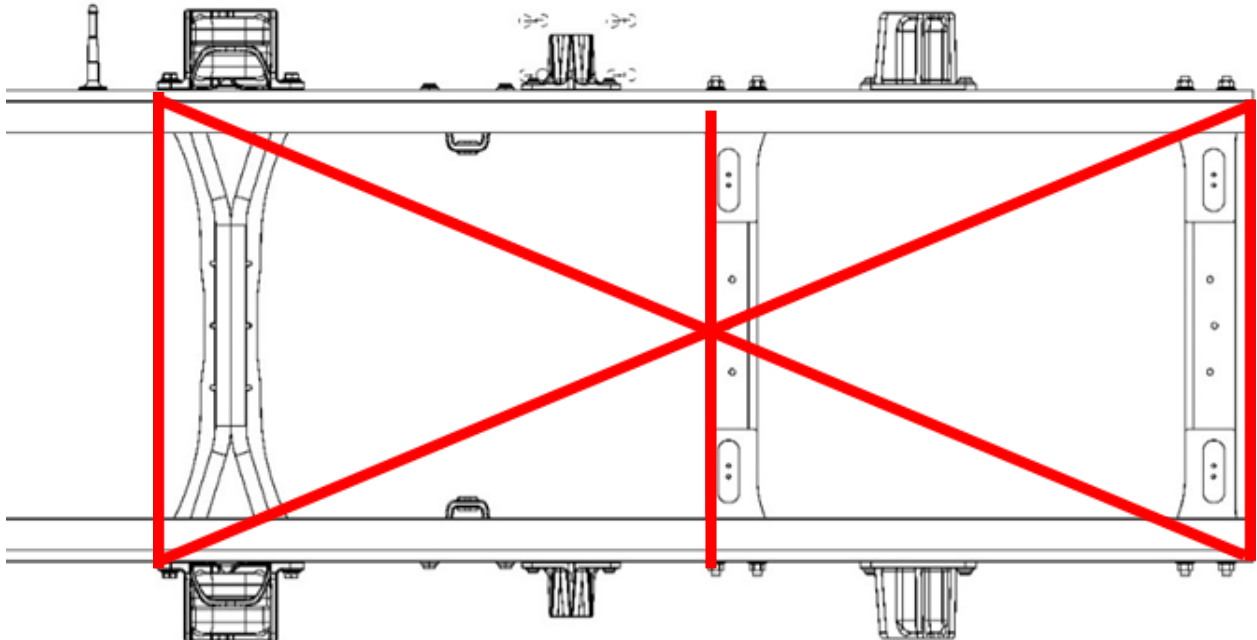


8. REMOVE THE PINS FROM EACH SPRING HANGER AND UN-BOLT THE LEAF SPRING FROM THE FRONT HANGER. THE LEAF SPRING IS NOW FREE TO BE REMOVED.



9. MARK, MEASURE, AND NOTE THE FRAME WIDTH AT EACH CROSSMEMBER. USING THOSE SAME MARKS, MEASURE THE FRAME DIAGONALLY TO CHECK FOR SQUARE. THESE MEASUREMENTS WILL BE COMPARED AGAINST WHEN INSTALLING THE SIDE PLATES.

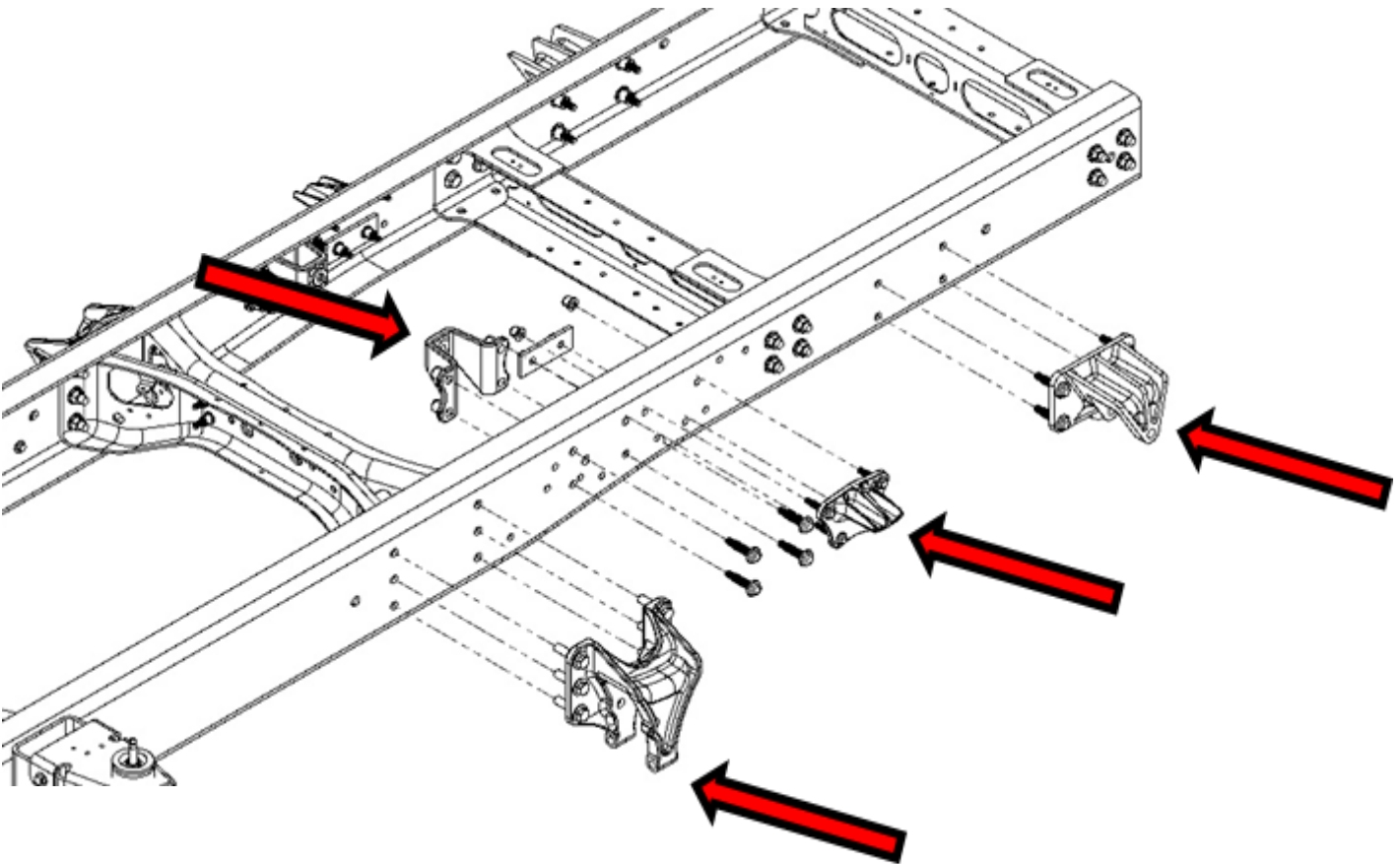
FRAME WIDTH: FORWARD _____ DIAGONAL MEASUREMENT #1 _____
FRAME WIDTH: MIDDLE _____ DIAGONAL MEASUREMENT #2 _____
FRAME WIDTH: REAR _____



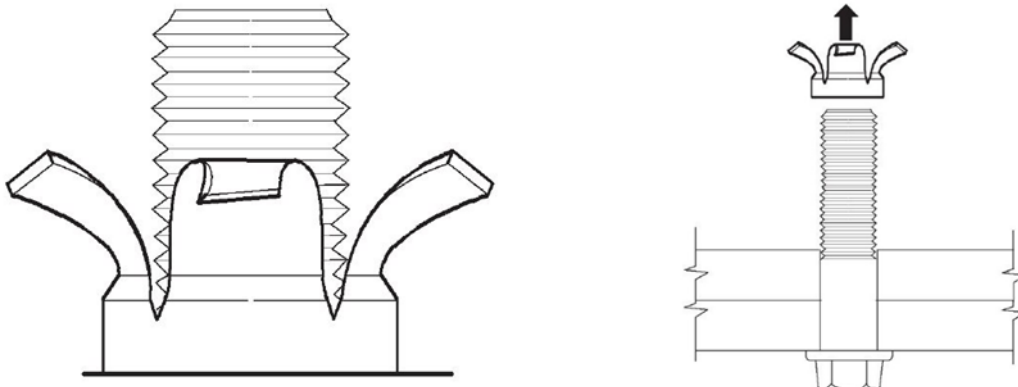
10. MARK THE LOCATION OF THE FORWARD AND MIDDLE CROSSMEMBERS ON THE FRAME RAILS.

11. ON TRUCKS EQUIPPED WITH A MID-MOUNT FUEL TANK REMOVE THE TANK STRAPS AND SLIDE THE TANK AWAY FROM THE FRAME TO GAIN ACCESS TO THE SPRING HANGER HARDWARE. **CAUTION:** TAKE CAUTION NOT TO DAMAGE OR KINK ANY LINES RUNNING TO THE TANK.

12. REMOVE THE SPRING HANGERS, BUMP STOP PADS, AND SHOCK BRACKETS (IF EQUIPPED) FROM ONLY ONE FRAME RAIL. **NOTE:** AT THIS POINT IT IS RECOMMENDED TO ONLY REMOVE PARTS FROM ONE FRAME RAIL THEN INSTALL NEW COMPONENTS BEFORE MOVING TO THE OPPOSITE SIDE.

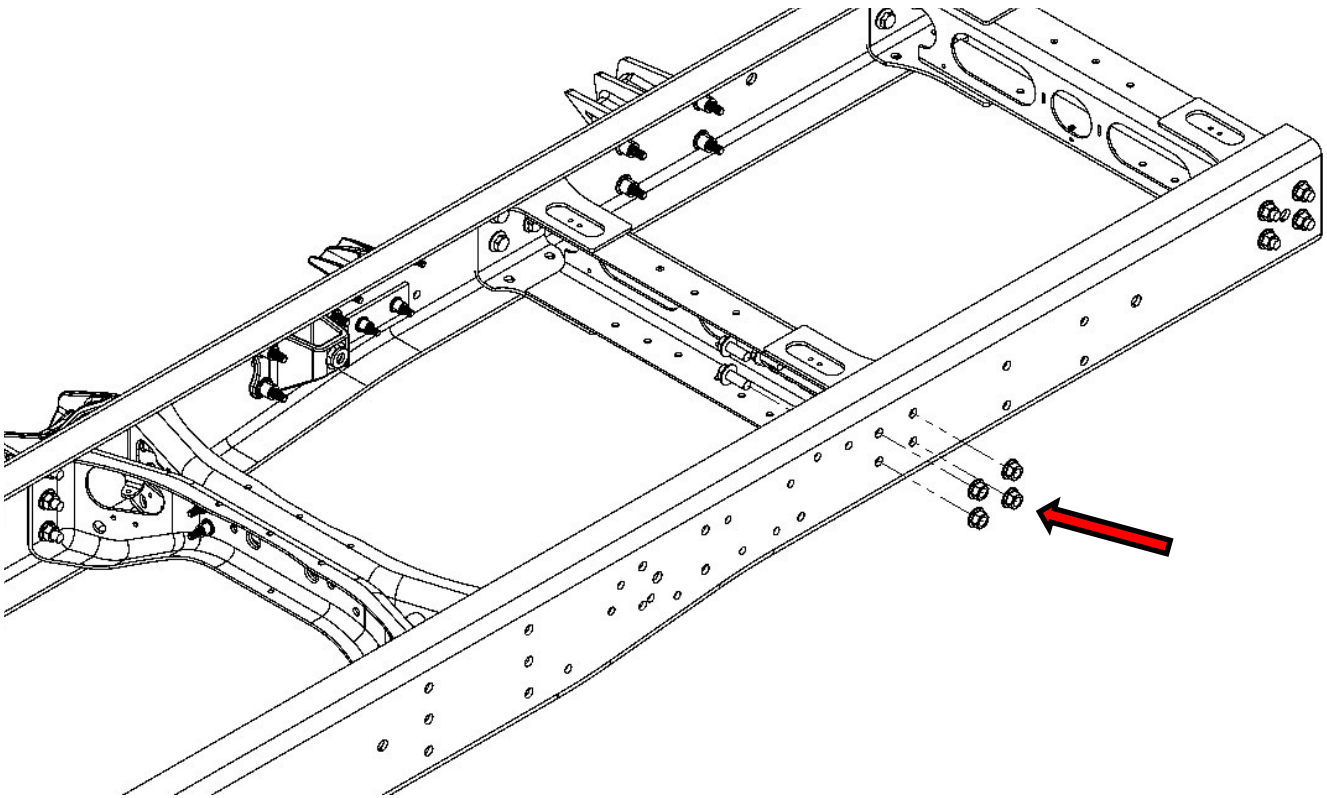


13. REMOVE THE HUCK BOLTS SPLIT THE NUT USING A CUTOFF WHEEL OR AN AIR CHISEL.



14. BETWEEN THE FORWARD AND MIDDLE CROSSMEMBER UN-BOLT ALL ELECTRICAL, FUEL, BRAKE LINES, AND CABLES FROM EACH FRAME RAIL.

15. UN-BOLT THE MIDDLE CROSSMEMBER. **NOTE:** SUPPORT THE REAR FUEL TANK ON TRUCKS EQUIPPED WITH ONE.



16. PROCEED TO *STEP 1* OF THE *KIT INSTALLATION* SECTION OF THESE INSTRUCTIONS AND INSTALL THE KELDERMAN SIDE PLATE ONTO THE NOW BARE FRAME RAIL.

ASSEMBLY

1. RE-ALIGN THE FORWARD AND MIDDLE CROSSMEMBERS WITH THE MARKS MADE DURING DISASSEMBLY AND INSTALL SIDE PLATES (#10006393-DS & 10006316-PS) TO FRAME RAIL WITH HARDWARE SHOWN BELOW. DRILL HOLES AS SHOWN.

DRILL THESE LOCATIONS IN THE FRAME WITH AN 1 1/16" DRILL BIT USING THE SIDE PLATE AS A DRILL JIG.

5/8"-18 x 2" BOLTS



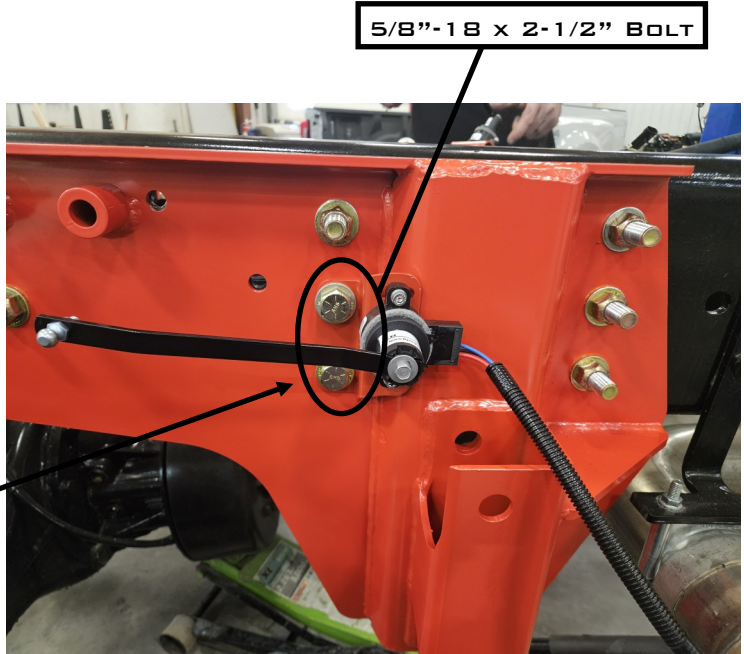
5/8"-18 x 2" BOLTS



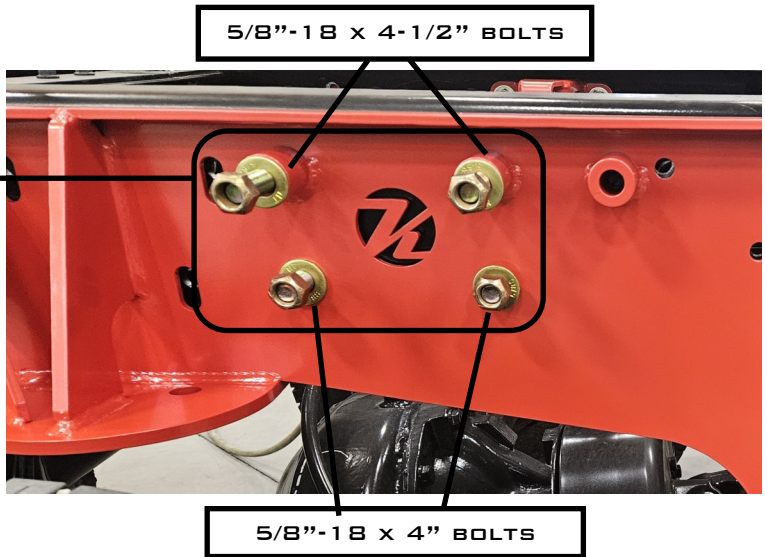
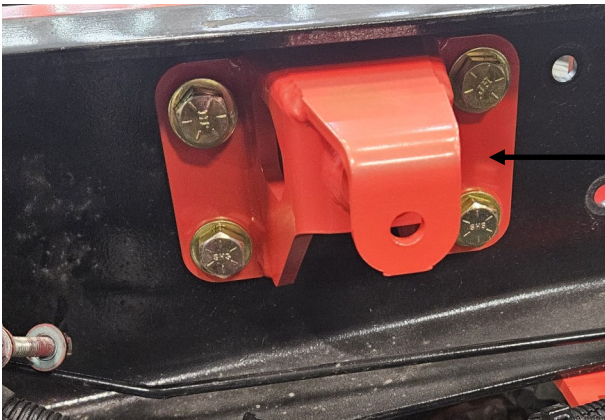
2. INSTALL SENSOR BRACKETS (#10006467) TO THE SENSOR AND THEN INSTALL THE ASSEMBLY TO THE SIDE PLATES WITH 5/8"-18 X 2-1/2" BOLTS.

ATTACH THE SENSOR TO THE SENSOR BRACKET BEFORE INSTALLING TO THE SIDE PLATE.

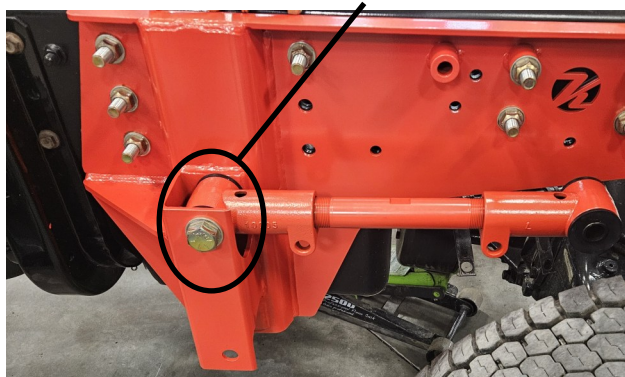
USE 1/4"-20 X 1-1/4" SOCKET HEAD CAP SCREW, SPLIT LOCK WASHER AND HEX NUT



3. INSTALL SHOCK MOUNTS (#10006533) USING THE 5/8"-18 X 4" & 4-1/2" BOLTS IN THE CENTER OF THE SIDE PLATE AROUND THE "K". THE BOLT SHOULD BE ORIENTED WITH THE BOLT HEAD INSIDE THE FRAME



NOTE: ON THE DS, IT HELPS TO INSTALL THE TOP TRAILING ARM BAR BEFORE BOLTING ON THE DS SIDE PLATE. THE TOP TRAILING ARM BAR INSTALLS WITH 7/8"-14 X 5-1/2" BOLT.



4. INSTALL 1/2"-20 X 1-3/4" BOLTS IN THE PS SIDE PLATE.

1/2"-20 X 1-3/4" BOLTS



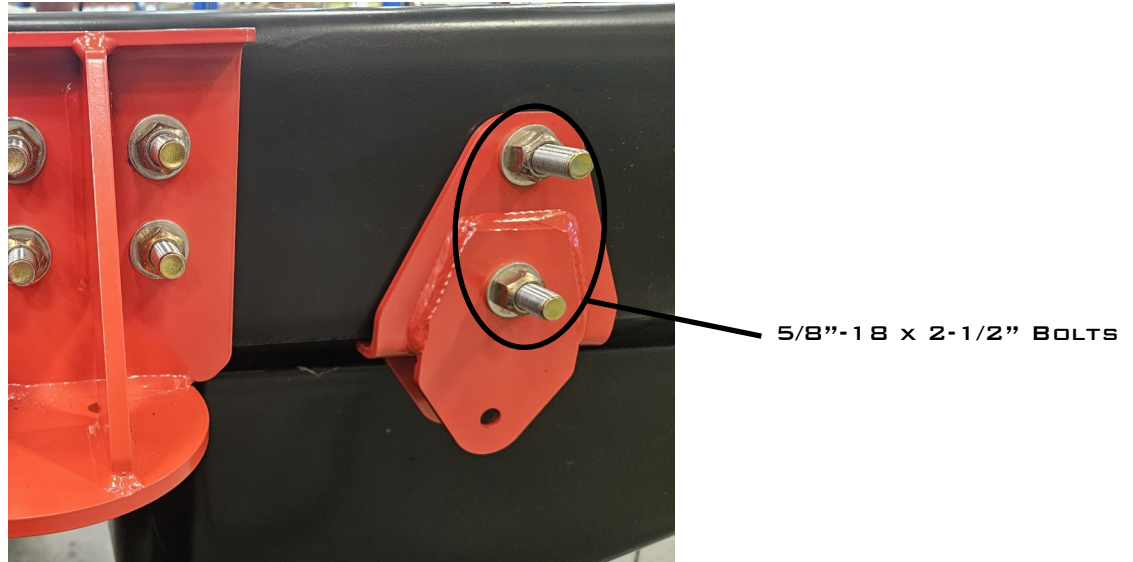
5. INSTALL 1/2"-20 X 1-3/4" BOLTS IN THE DS SIDE PLATE.



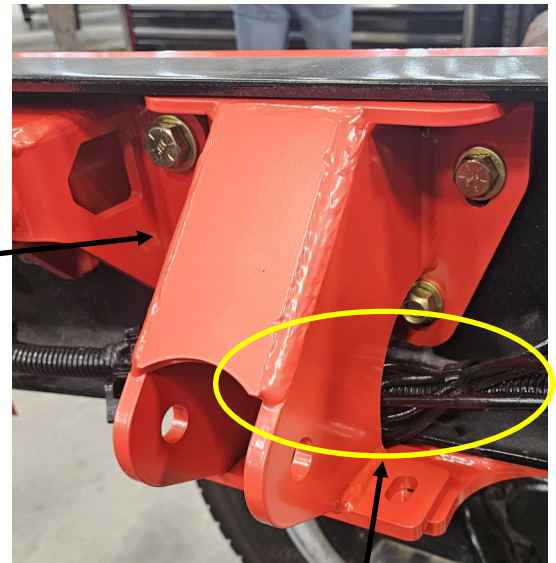
NOTE: THE STANDOFF BUSHINGS ALLOW FOR ACCESSORY BRACKETS TO BE MOUNTED WITHOUT CUTTING THE SIDE PLATE TOP FLANGE.

ATTACH THE HARNESS STRAP HERE WITH 1/2"-20 X 1-3/4" BOLT.

6. INSTALL END LINK FRAME BRACKET (#10006442) USING 5/8"-18 x 2-1/2" BOLTS. THE END LINK FRAME BRACKET WILL BOLT UP AT THE LOCATION OF THE REMOVED REAR SPRING HANGER.

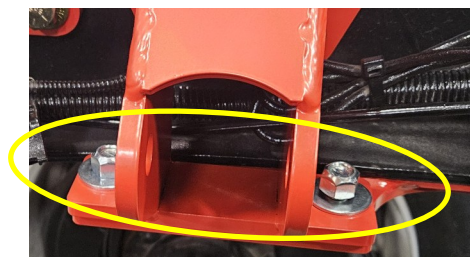


7. INSTALL THE UPPER PANHARD BAR BRACKET (#10006381) ONTO THE PASSENGER SIDE FRAME RAIL. USE 1/2"-20 x 2" BOLTS TO FASTEN THRU THE FRAME RAIL. USE *HARDWARE* TO FASTEN THE BOTTOM FLANGE OF THE PANHARD BAR BRACKET TO THE SIDE PLATE. ON THE PASSENGER SIDE CUT OFF THE FACTORY BRAKE LINE BRACKET AFTER THE FIRST HOLE AND FASTEN IT TO THE FORWARD CARRIAGE BOLT, AND CAUSE DAMAGE.

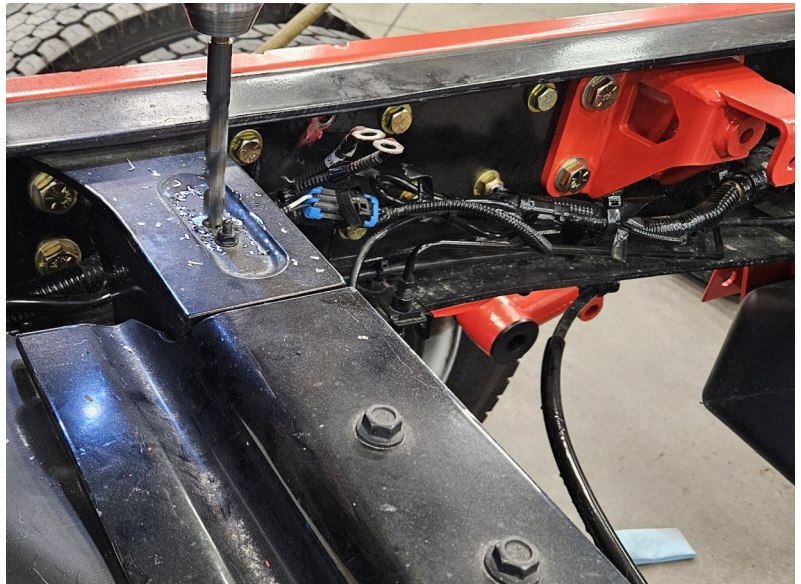


NOTE: ROUTE THE WIRING HARNESS THRU THE OPENING AT THE BOTTOM OF THE PANHARD BAR BRACKET BEFORE FASTENING.

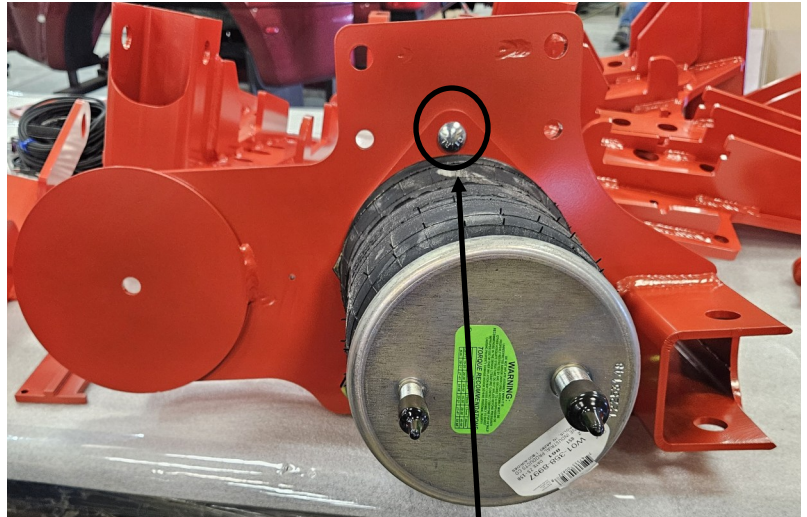
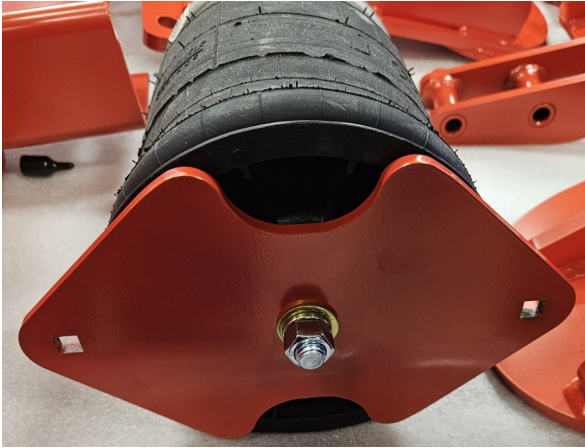
CAUTION: POSITION THE SMOOTH HEAD OF THE 1/2"-13 x 1-1/2" CARRIAGE BOLT DOWN OR IT WILL RUB ON THE BAG



8. DRILL OUT HOLE SHOWN AND ATTACH THE GROUND STRAP AND BOLT. DRILL OUT HOLE TO 3/8”.



9. INSTALL THE FRONT AIR BAG (#8997) ONTO THE LOWER BAG MOUNT (#10006329-DS & 10006410-PS) USING THE SPACER PLATE (#10006339). THEN, USE 7/8"-14 X 9" BOLTS TO BOLT THRU THE LOWER BAG PLATES, THE CAST AXLE CLAMPS, AND LOWER SHOCK EAR PLATES (#10006798-DS & 10006803-PS). DO NOT TIGHTEN HARDWARE YET. **NOTE:** FOLLOW THE DIRECTIONAL MARKINGS ON THE CAST AXLE CLAMPS. LEAVE HARDWARE LOOSE.



ATTACH AIR BAG ASSEMBLY TO LOWER BAG WELDMENT WITH 3/8"-16 X 1-1/4" CARRIAGE BOLTS.

NOTE: IF YOU HAVE THE LARGE AXLE VERSION, YOU WILL USE 7/8"-14 X 10" BOLTS INSTEAD OF THE 9" LONG ONES.



10. INSTALL THE PANHARD BAR CROSSMEMBER (#10006384) TO THE LOWER BAG PLATES USING 1/2"-13 X 1-3/4" CARRIAGE BOLTS AND 5/8"-18 X 9" BOLTS TO FASTEN LOWER AXLE CLAMPS (#10006427-DS & 10006431-PS) TO THE AXLE. ALIGN THE HOLES ON THE LOWER SHOCK EAR PLATES WITH THE OTHER COMPONENTS, YOU WILL NEED TO INSTALL THE LOWER TRAILING ARM TO BOLT THE SHOCK EAR TO THE LOWER BAG MOUNT. USE 7/8"-14 X 5-1/2" BOLTS. DO NOT TIGHTEN HARDWARE YET.



1/2"-20 X 3-1/2"



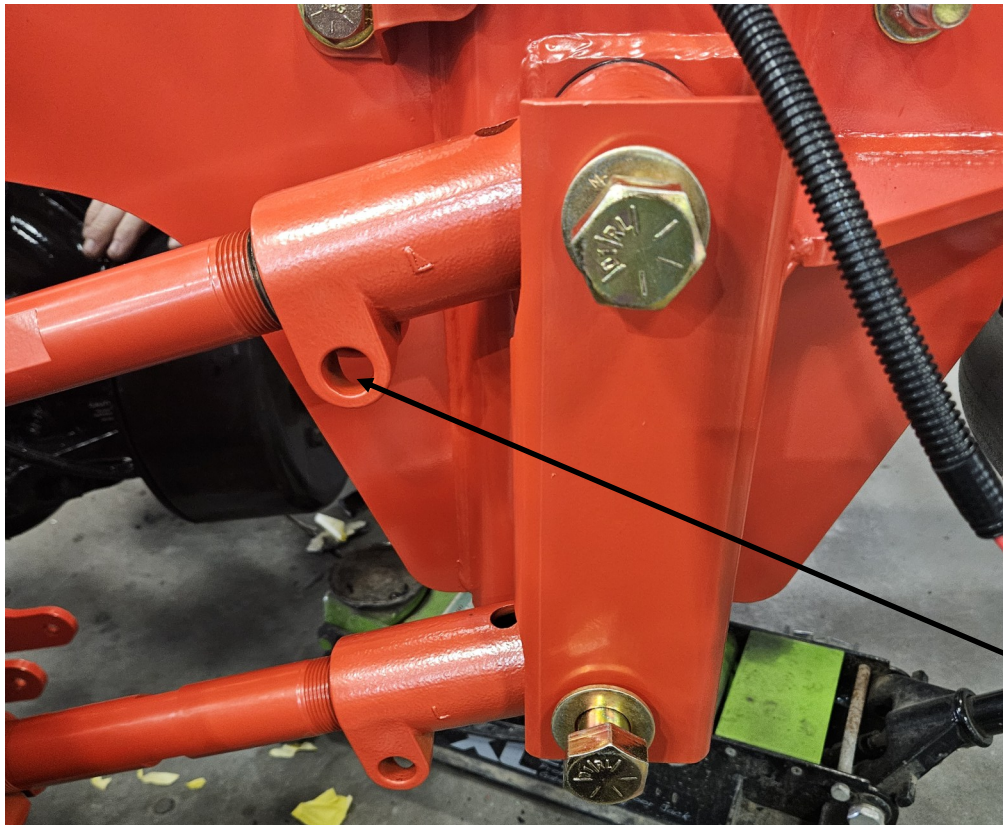
TRAILING ARM NEEDS TO BE INSTALLED TO ATTACH THE SHOCK EAR. THREAD THE LEFT HAND KNUCKLE (10006) ONTO THE TRAILING ARM BAR. USE THE 7/8"-14 X 5-1/2" BOLTS ON THE PS & DS.

11. ASSEMBLE THE REMAINING TRAILING ARM BARS (#52114.5). THREAD CAST KNUCKLES (#10005 & 10006) ONTO THE TRAILING ARM BAR. ADJUST THE KNUCKLES EQUALLY UNTIL THE GAP BETWEEN THE KNUCKLES EQUALS 8-1/8" ON BOTH BARS. INSERT 5/8"-18 X 3" PINCH BOLT INTO THE CAST KNUCKLES BUT DO NOT TIGHTEN.

#10005



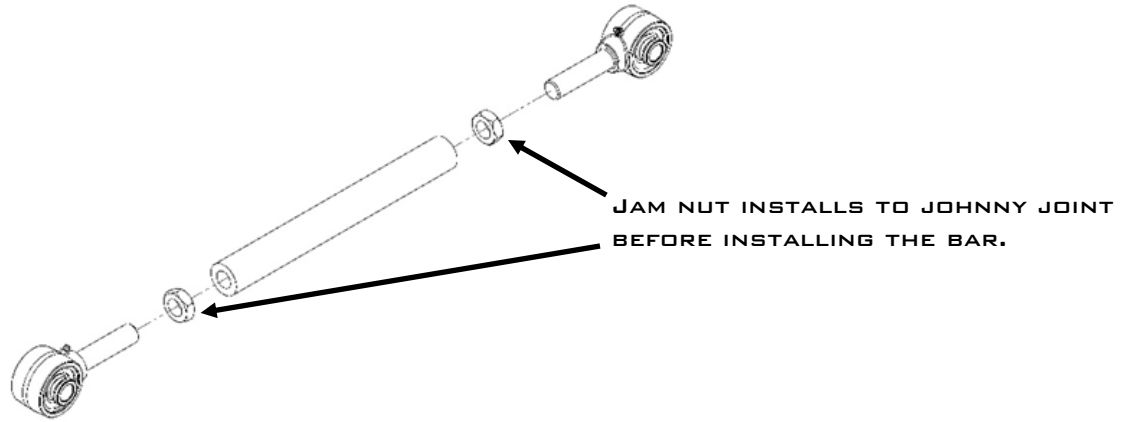
#10006



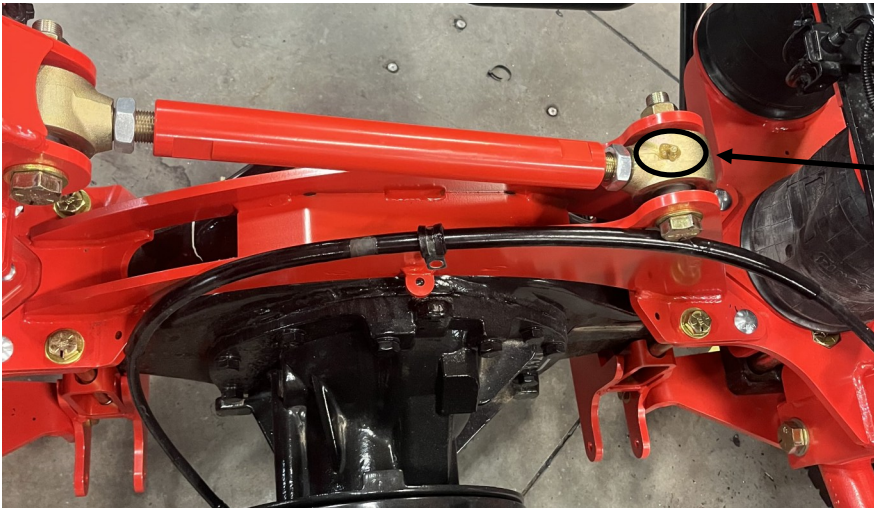
INSTALL AND TIGHTEN PINCH BOLTS AFTER CONFIRMING BARS ARE SET.

****ONCE ALIGNED, TIGHTEN DOWN ALL HARDWARE INSTALLED UP TO THIS POINT****

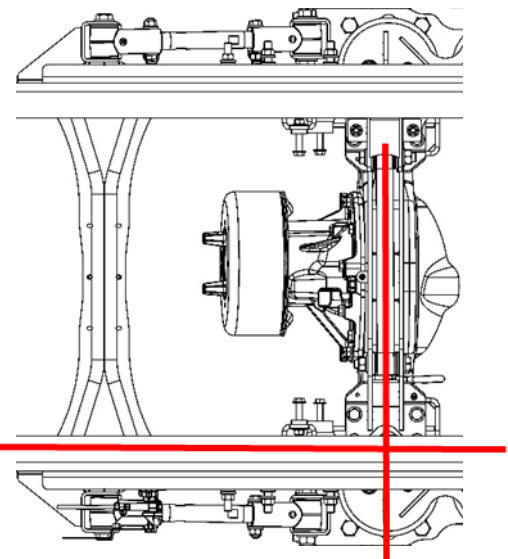
12. LOCATE PANHARD BAR (#10011537), 7/8" JAM NUTS (#13210-RHT & 13211-LHT) AND JOHNNY JOINTS (#80281-RHT & 80282-LHT). THREAD JAM NUTS ONTO JOHNNY JOINT BEFORE THREADING INTO PANHARD BAR. **NOTE:** SET THE LENGTH OF THE ASSEMBLED BAR TO 18-1/8" MEASURED CENTER TO CENTER. THIS LENGTH MAY NEED TO BE ADJUSTED IN NEXT STEP



13. INSTALL THE 3/4"-16 x 4-1/2" BOLTS TO THE ASSEMBLED PANHARD BAR INTO THE UPPER PANHARD BAR BRACKET AND PANHARD BAR CROSSMEMBER. **NOTE:** ADJUST ALL FOUR TRAILING ARMS EQUALLY TO MOVE AXLE FORWARD AND BACKWARD. ADJUST THE PANHARD BAR LENGTH TO CENTER THE AXLE UNDER THE FRAME. **TORQUE:** 3/4"-16 PANHARD BAR BOLTS SHOULD BE TORQUED TO 150FT-LB.

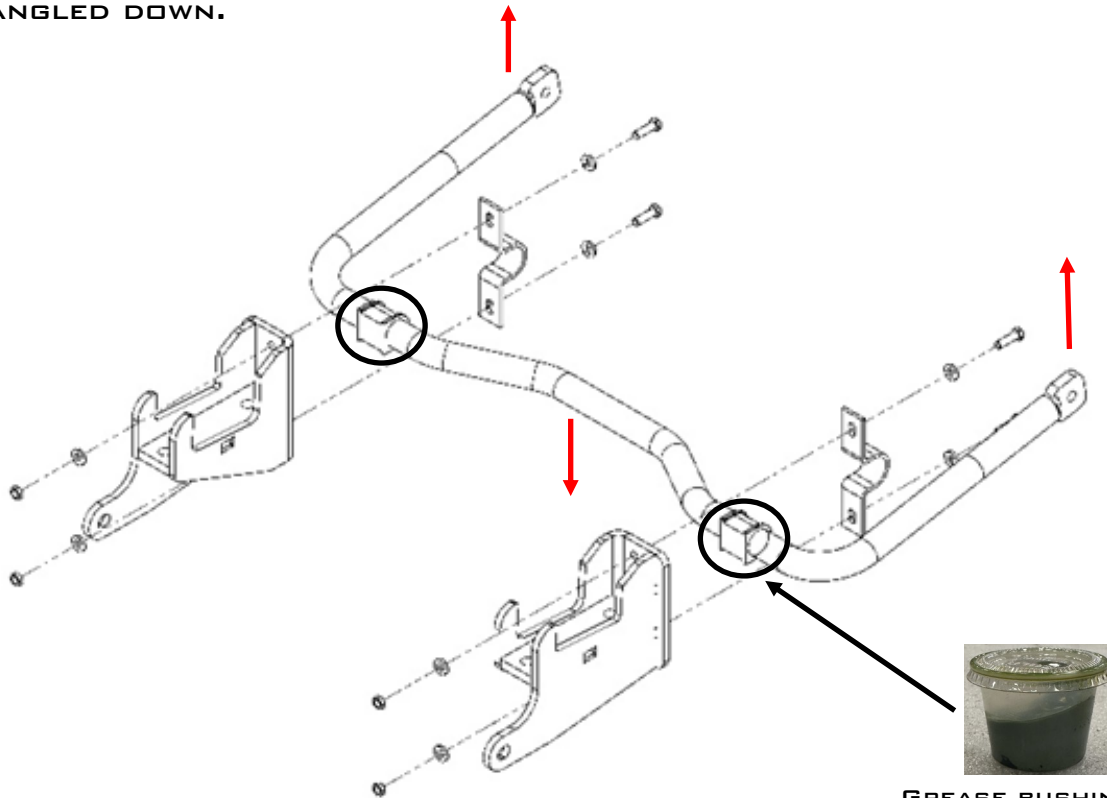


GREASE ZERK ON DRIVERS SIDE WILL FACE UP AND PASSENGER SIDE WILL FACE DOWN.



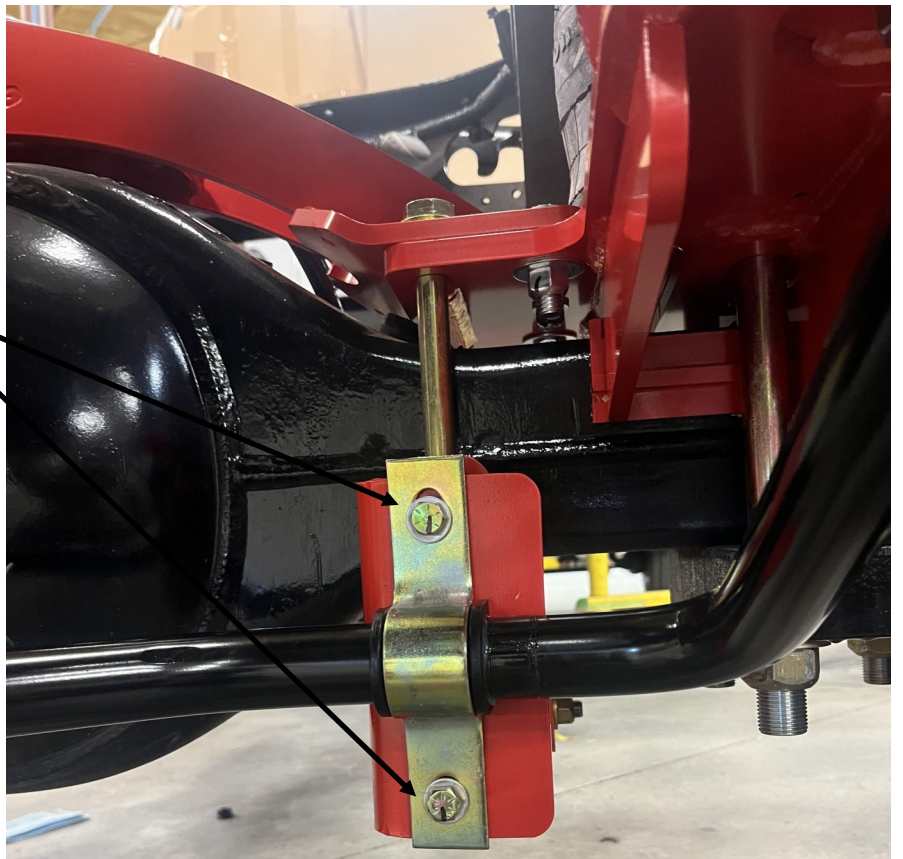
AT RIDE HEIGHT THE PANHARD BAR SHOULD RUN PERPENDICULAR TO THE FRAME RAILS.

14. GREASE SWAY BAR BUSHINGS AND INSTALL ONTO SWAY BAR (#80270). INSTALL THE D-RINGS OVER THE BUSHINGS AND FASTEN TO THE LOWER AXLE CLAMPS USING 3/8" HARDWARE. **NOTE:** INSTALL SWAY BAR WITH THE ARMS ANGLED UP AND THE CENTER ANGLED DOWN.



GREASE BUSHINGS PRIOR TO INSTALL

3/8"-24 x 1-1/4"



15. INSTALL THE END LINK ASSEMBLY (#10006436) TO THE END LINK MOUNTS USING 1/2"-20 X 3" BOLTS.

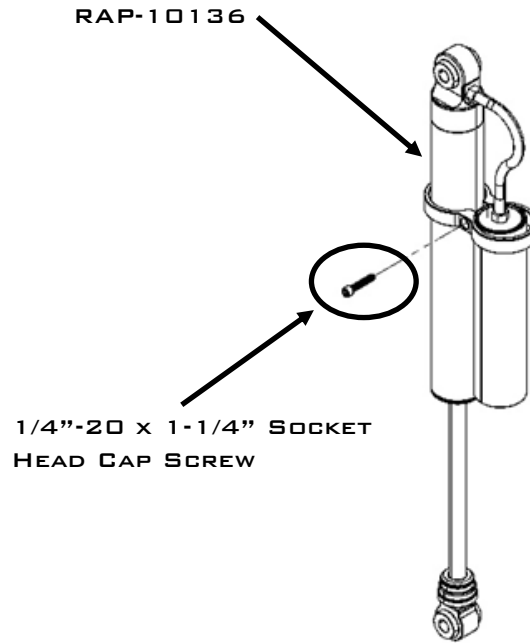
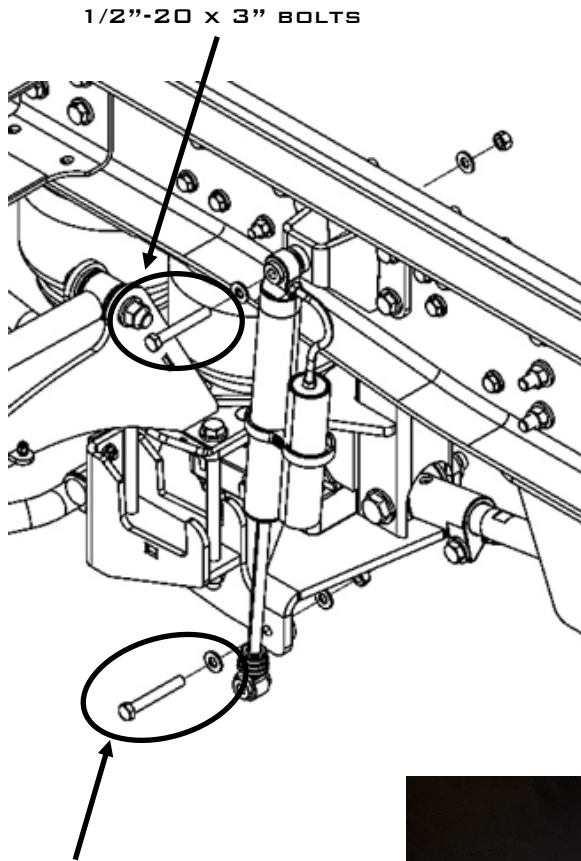


NOTE: INSTALL THE END LINK WASHER ON THE SIDE OPPOSITE THE SWAY BAR.

1/2"-20 X 3" BOLTS

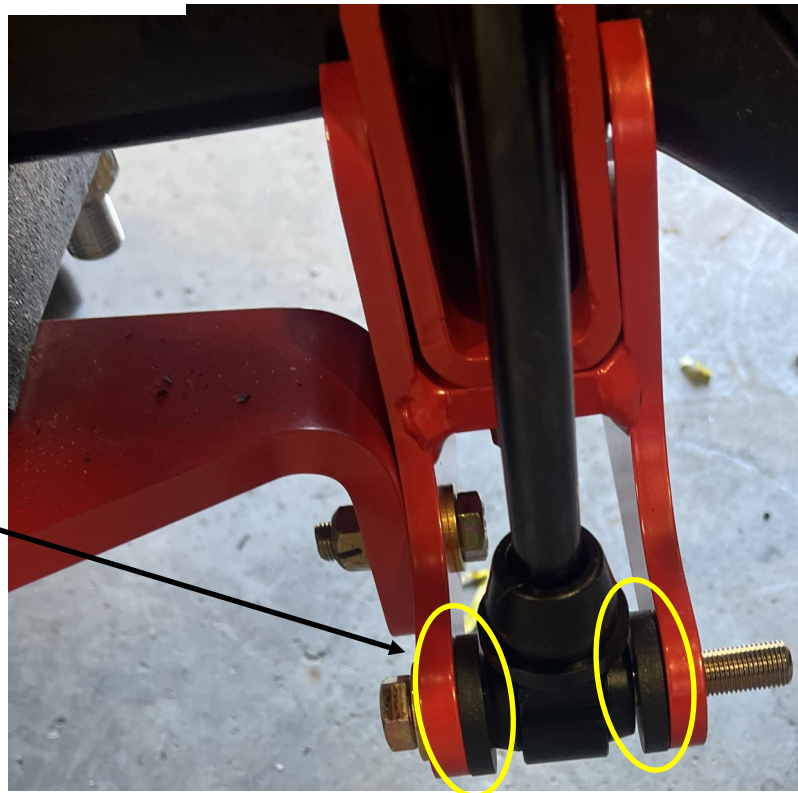


16. LOCATE SHOCKS (#10007132/RAP-10136), PIGGYBACK CLAMPS (#80253), WASHER (#11551), 1/2"-20 x 3" & 4" BOLTS AND 1/4"-20 x 1-1/4" SOCKET HEAD CAP SCREW. ATTACH CLAMP TO SHOCK BODY AND THEN SLIDE OVER RESERVOIR AND BOLT WITH 1/4"-20 x 1-1/4" SCREW. ATTACH SHOCK TO UPPER SHOCK MOUNT AND LOWER SHOCK EAR WITH 1/2"-20 x 3" BOLTS.



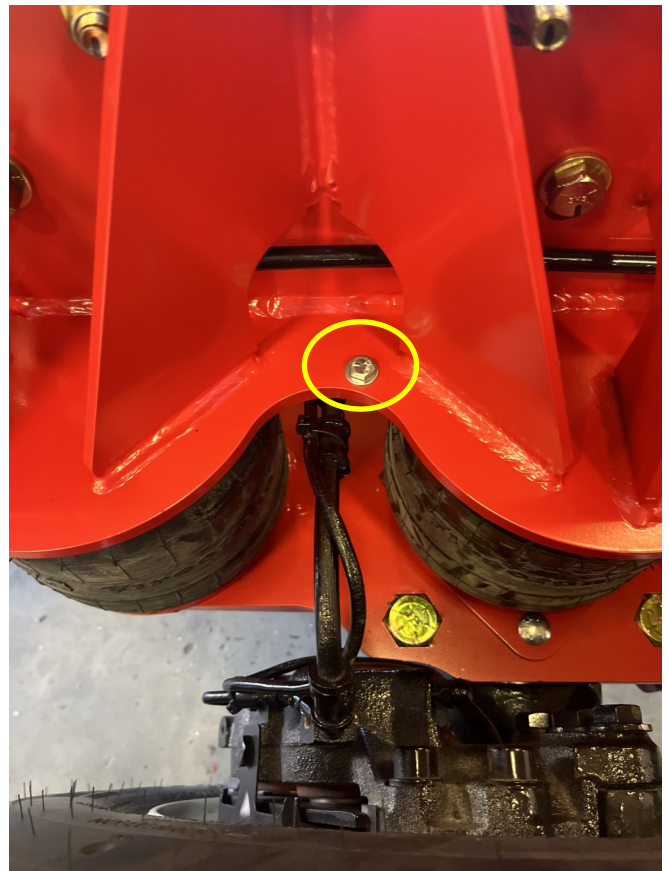
1/2"-20 x 4" BOLTS

WASHER (#11551) NEED TO BE ON EACH SIDE OF THE SHOCK WHEN BOLTING TO THE LOWER SHOCK EAR.

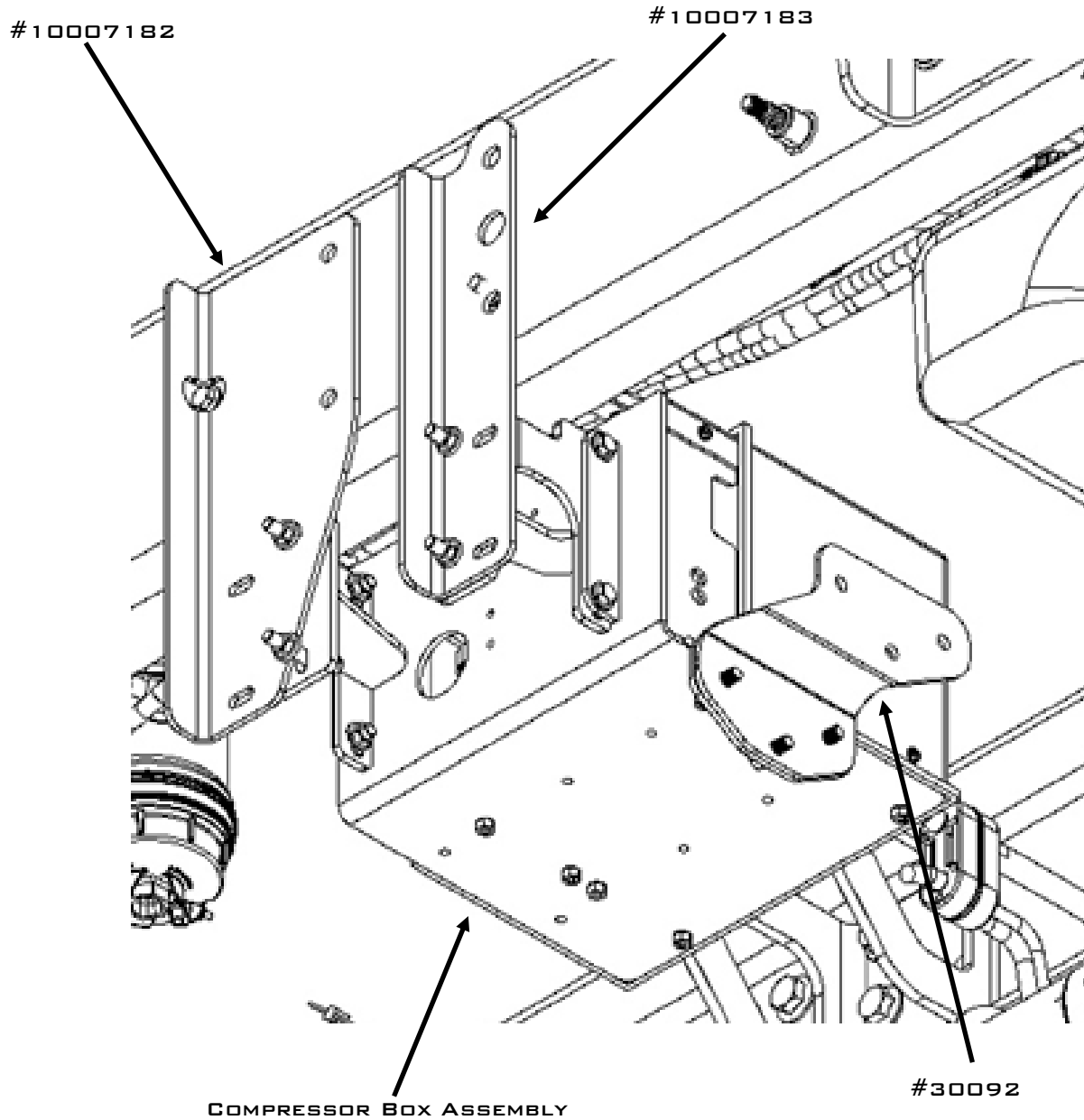


NOTE: ORIENT THE RESERVOIR TOWARD THE FRONT OF THE TRUCK. CHECK THAT THE RESERVOIR WILL NOT CONTACT ANY BRACKETS OR SNAG ANY HOSES OR LINES AS THE SUSPENSION TRAVELS THRU ITS FULL SWEEP.

17. FASTEN THE PARKING BRAKE CABLE BRACKET REMOVED IN DISASSEMBLY *STEP 5* TO THE TAB ON THE PANHARD BAR CROSSMEMBER. DEPENDING ON THE BRAKE LINE CONFIGURATION, THE BRAKE LINES WILL GO IN BETWEEN BAGS ON LOWER BAG PLATE OR BE ATTACHED TO THE UPPER BAG PLATE AS SHOWN.



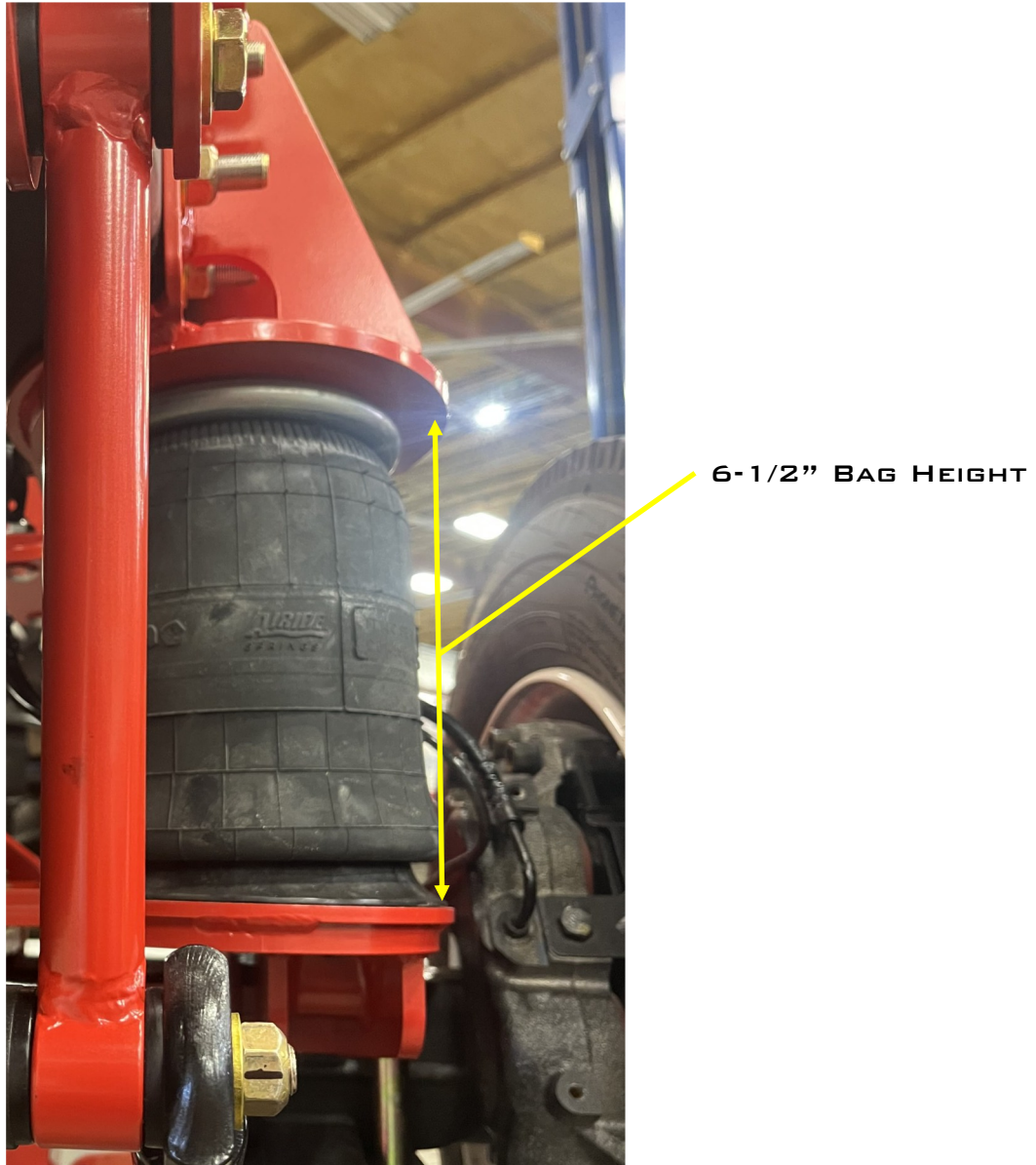
18. THIS KIT IS SUPPLIED WITH TWO BRACKETS THAT WILL MOUNT THE COMPRESSOR BOX TO THE DRIVER'S SIDE FRAME RAIL IN FRONT OF THE MID MOUNT FUEL TANK. THERE IS ALSO A BRACKET THAT WILL LIFT THE AIR DRYER IF THIS MOUNTING METHOD IS USED.



NOTE: REFER TO THE AIR CONTROLS INSTRUCTION MANUAL FOR DIRECTIONS ON PLUMBING AND INSTALLING THE COMPRESSOR.

NOTE: ALTERNATELY THE COMPRESSOR BOX CAN BE MOUNTED AT INSTALLER'S DISCRETION WHEREVER THERE IS ROOM.

19. INFLATE THE AIRBAGS TO 6-1/2" THIS IS THE DESIGNED RIDE HEIGHT FOR THIS KIT.



20. WITH THE TRUCK SITTING AT RIDE HEIGHT CHECK PINION ANGLE AND WHEELBASE MEASUREMENTS. ADJUST THE TRAILING ARM BARS AS NEEDED TO SET THE REAR AXLE BACK TO FACTORY POSITION.

21. RE-INSTALL THE EXHAUST.

22. TORQUE ALL FASTENERS TO THE SPECIFICATIONS IN THE CHART BELOW, UNLESS NOTED OTHERWISE IN THESE INSTRUCTION. **SEE PAGE 4 FOR TORQUE CHART.**

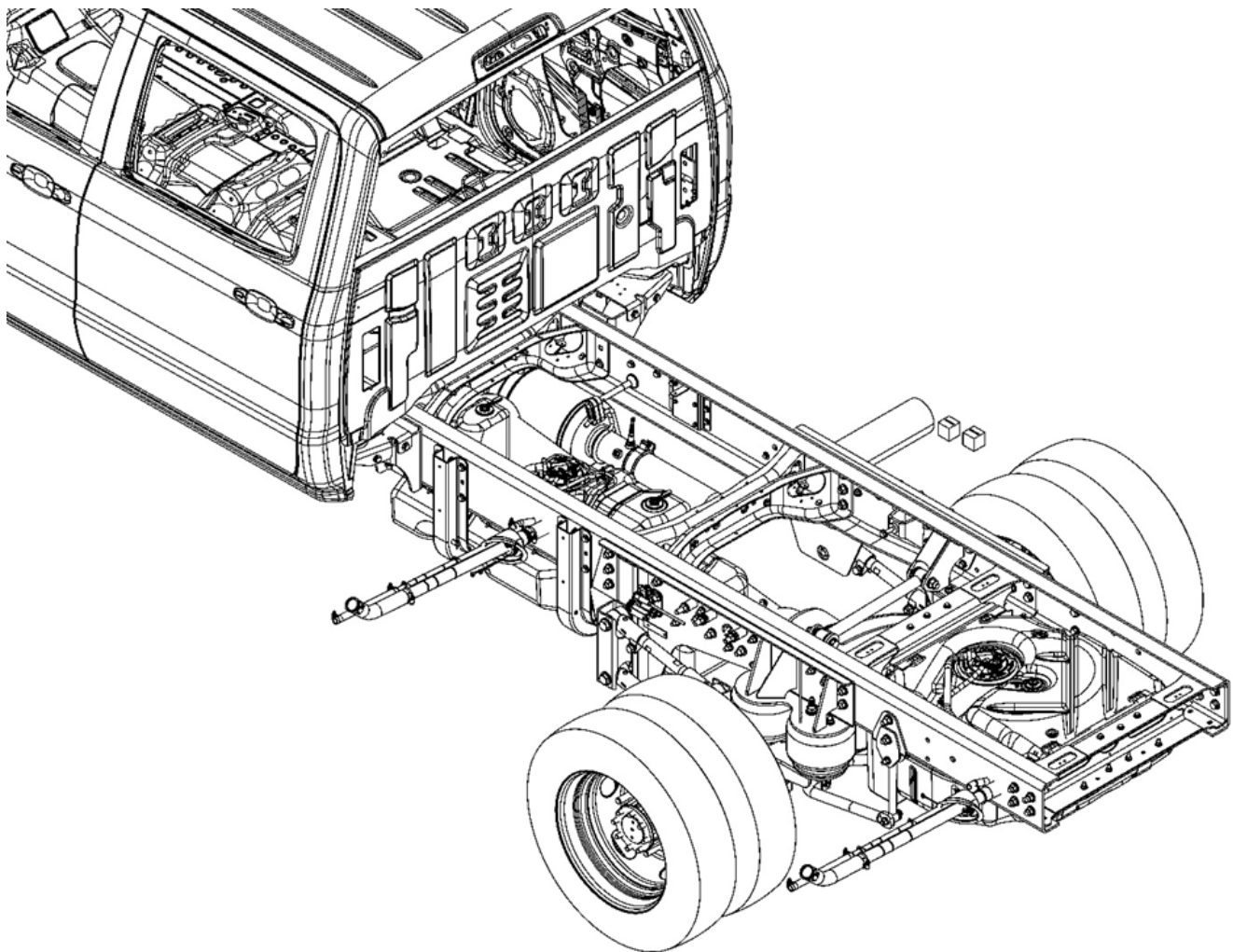
23. SWEEP THE SUSPENSION THRU THE FULL RANGE OF MOTION AND CHECK THAT NO COMPONENTS ARE BINDING, COLLIDING, OR RUBBING.

24. GREASE THE PANHARD BAR JOHNNY JOINTS.

25. THE TRUCK IS NOW READY TO TEST DRIVE. IF THE TRUCK PULLS TO ONE DIRECTION, SHORTEN THE OPPOSITE SIDE TRAILING ARMS ONE TURN AND TEST DRIVE AGAIN. REPEAT UNTIL PULL IS ELIMINATED. ALWAYS CHECK THE PINION ANGLE AND BAG HEIGHTS AFTER MAKING ANY TRAILING ARM ADJUSTMENTS.

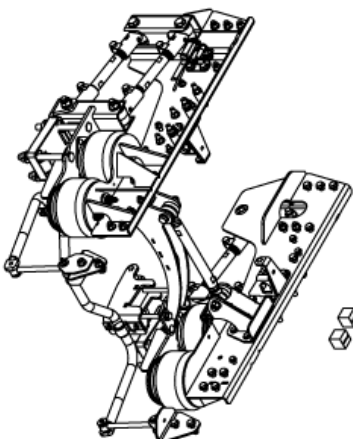
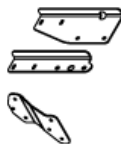
26. AFTER TEST DRIVING CHECK ALL FASTENERS TO MAKE SURE NOTHING HAS WORKED LOOSE. INSPECT SUSPENSION FOR SIGNS THAT ANY COMPONENT MAYBE BINDING, COLLIDING, OR RUBBING, REPOSITION IF REQUIRED.

27. USE SOAPY WATER TO CHECK AIR COMPONENTS AND LINES FOR ANY LEAKS.



KIT DRAWINGS - 10006311

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
Assemblies			
1	18498	Assembly - Trailing Arm Knuckle - 10006 (LHT) - 7/8" Bolt	4
2	18499	Assembly - Trailing Arm Knuckle - 10005 (RHT) - 7/8" Bolt	4
3	10006436	Assembly - 9.5" End Link	2
4	10007076	Assembly - Axle Mount (DS)	1
5	10007078	Assembly - Forward Bag Plate	2
6	10007081	Assembly - PHB Crossmember	1
7	10007083	Assembly - Axle Mount (PS)	1
8	10007084	Assembly - Sway Bar D-Ring	2
9	10007087	Assembly - End Link Bracket	2
10	10007088	Assembly - Side Plate (DS)	1
16	10007089	Assembly - Upper Shock Bracket	2
12	10007090	Assembly - Upper PHB Bracket	1
13	10007095	Assembly - Side Plate (PS)	1
14	10011536	Assembly - Panhard Bar - 13" Bar Length - 3/4" Bolt	1
Parts			
15	11551	Plate - 1/4" - 1.5"OD x .53" ID x 1/4"	2
16	30092	Plate - 7ga - Offset Dryer Relocation Plate - 5" - w/Bends	1
17	52114.5	Tube - Trailing Arm - 14.5" Long - Thread: External 1.5"-12	4
18	10007182	Plate - 7ga - Compressor Box Frame Bracket - w/Bends	1
19	10007183	Plate - 7ga - Compressor Box Frame Mount - w/Bends	1
Purchased Parts			
20	80012-8997	Air Bag - Firestone 8997	2
21	80077	Mechanical Height Control Valve	1
22	80168	KV2L11-35s - 90° Elbow, 3/8" x 1/4-18 NPT	1
23	80270	Purchased - Rear Sway Bar - 1-3/8" Dia	1
24	10007132	Purchased - Kelderman-Raptor Shock (10136LH): Remote Reservoir Twin Eyelet - 25.25" Ext.	1
25	10009011	Purchased - Kelderman-Raptor Shock (10136RH): Remote Reservoir Twin Eyelet - 25.25" Ext.	1



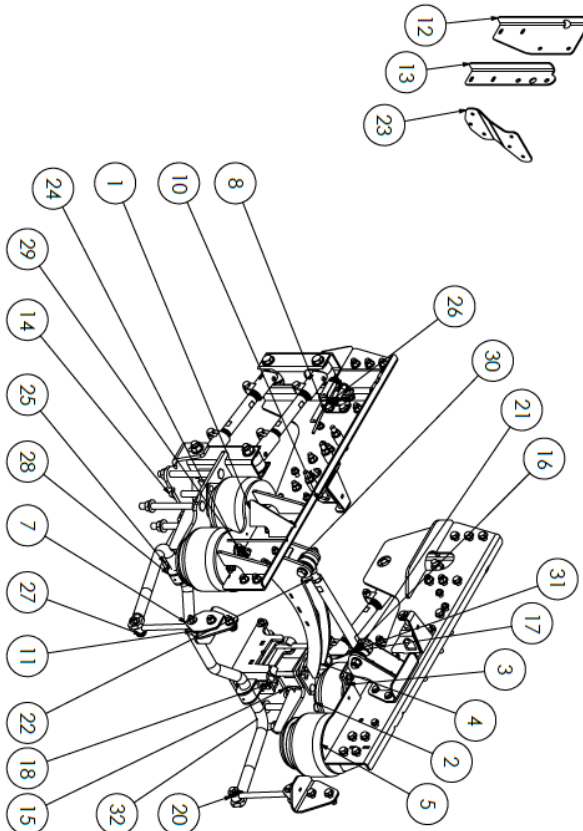
	REVISION	A	DO NOT SCALE DRAWING	1:50	Approximate Weight = lbs
	UNLESS OTHERWISE SPECIFIED, DIMENSIONS IN INCHES	DESCRIPTION:	Kit - 4-link Rear - Shock Height - 4-1/4" wide x 4-3/8" Tall Axle		
	STD. TOLERANCES	PROJECT:	2019+ GM 4500/5500/4500 - CC - 4WD		
	PART NUMBER: 10006311	DESIGN BY:	Roy Anderson		
	DATE: 12/12/2019	DATE:	12/12/2019		
	SCALE: 1/2"	DATE:	12/12/2019		
	DWG. NO. 10006311	DATE:	12/12/2019		
	TITLE: KIT DRAWING	DATE:	12/12/2019		
	DRAWN BY: Roy Anderson	DATE:	12/12/2019		
	CHECKED BY: Roy Anderson	DATE:	12/12/2019		
	APPROVED BY: Roy Anderson	DATE:	12/12/2019		



SHEET 1 OF 6

KIT DRAWINGS - 10008314

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	10006316	WELDMENT - SIDE PLATE (DS)	1
2	10006339	PLATE - 1/4" - REMOVABLE LOWER BAG PLATE	2
3	10006381	WELDMENT - UPPER PHB BRACKET	1
4	10006384	WELDMENT - PHB CROSSMEMBER	1
5	10006393	WELDMENT - SIDE PLATE (PS)	1
6	10006431	WELDMENT - LOWER AXLE CLAMP W/SHOCK & SWAYBAR (PS)	1
7	10006442	WELDMENT - END LINK FRAME BRACKET	2
8	10006459	PLATE - 11GA - SENSOR KEY (DS) - W/BENDS	1
9	10006467	PLATE - 11GA - SENSOR KEY (PS) - W/BENDS	1
10	10006553	WELDMENT - UPPER SHOCK BRACKET	2
11	10006879	WELDMENT - 9.5" END LINK	2
12	10007182	PLATE - 7GA - COMPRESSOR BOX FRAME BRACKET - W/BENDS	1
13	10007183	PLATE - 7GA - COMPRESSOR BOX FRAME MOUNT - W/BENDS	1
14	10010209	ASSEMBLY - AXLE MOUNT (DS) - J27 AXLE	1
15	10010219	ASSEMBLY - AXLE MOUNT (PS) - J27	1
16	10011537	ROUND BAR - 1.5" OD X 13" L - PANHARD BAR - 7/8"-14 THREAD	1
17	10037979	ASSEMBLY - TRAILING ARM, 18.1299	4
18	10040092	TUBE - 2 X 4 X 5/16 WALL X 7.00 - PS CLAMP ADAPTER	1
19	11550	CRR - SLEEVE BUSHING - 750"OD X .511"ID - 1.375L	4
20	11551	PLATE - 1/4" - 1.5"OD X .53" ID X 1/4"	2
21	13210	JAM NUT RHT - 7/8"-14 - GR5 - Z	1
22	13211	JAM NUT LHT - 7/8"-14 - GR5 - Z	1
23	30092	PLATE - 7GA - OFFSET DRYER RELOCATION PLATE - 5" - W/BENDS	1
24	80012-8997	AIR BAG - FIRESTONE 8997	4
25	80049	PURCHASED PART - D-RING	2
26	80077	MECHANICAL HEIGHT CONTROL VALVE	1
27	80134	PURCHASED PARTS - INSERT PRESS-IN BUSHING (END LINK) - 1.160"OD X .745"ID	8
28	80138	SWAY BAR BUSHING - 1-1/2" ID	2
29	80148	FITTING - ELBOW - 90° - 1/4"-18 MNPT X 3/8" PTC - DOT	4
30	80281	HEM END - 2.5" JOHNNY JOINT NARROW - 7/8"-14 RHT	1
31	80282	2.5" JOHNNY JOINT NARROW, 7/8"-14 LHT, BALL CENTER 3/4" HOLE HEM END	1
32	80297	PURCHASED - REAR SWAY BAR - 1-1/2" DIA	1



DATE: 12/12/2017	SCALE: 1:10	DEPENDENT WEIGHT: 50
DESIGNER: [Name]	DRAWN: [Name]	CHECKED: [Name]
PROJECT: 10008314	DATE: 11/20/2025	SCALE: 1:10

NOTES

CONTACT INFORMATION

KELDERMAN MANUFACTURING APPRECIATES YOUR BUSINESS. WE STRIVE TO MEET THE NEEDS OF OUR CUSTOMERS BY PROVIDING THE HIGHEST QUALITY PRODUCTS. IF YOU HAVE ANY QUESTIONS CONCERNING OUR PRODUCTS PLEASE CALL OR EMAIL US AT THE FOLLOWING:

2686 HIGHWAY 92
OSKALOOSA, IOWA 52577

PHONE: [1-800-334-6150](tel:1-800-334-6150)

EMAIL: INFO@KELDERMAN.COM

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