

INSTALL INSTRUCTIONS

2020+ GM 2500-3500 PICKUP - 4" LIFT REAR



KIT # 10031845

kelderman**KELDERMAN MANUFACTURING****2686 HIGHWAY 92 EAST OSKALOUSA, 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
10031845	2020+ GM 2500-3500 Pickup - 4.00" Lift Rear



2026 CHEVROLET SILVERADO 3500 HD SHOWN

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	8 <i>FT-LB</i>	12 <i>FT-LB</i>
3/8"-16	19 <i>FT-LB</i>	26 <i>FT-LB</i>
3/8"-24	21 <i>FT-LB</i>	30 <i>FT-LB</i>
1/2"-13	45 <i>FT-LB</i>	64 <i>FT-LB</i>
1/2"-20	50 <i>FT-LB</i>	70 <i>FT-LB</i>
9/16"-18	70 <i>FT-LB</i>	100 <i>FT-LB</i>
5/8"-11	90 <i>FT-LB</i>	125 <i>FT-LB</i>
5/8"-18	100 <i>FT-LB</i>	150 <i>FT-LB</i>
3/4"-16	175 <i>FT-LB</i>	250 <i>FT-LB</i>
7/8"-14	275 <i>FT-LB</i>	400 <i>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.

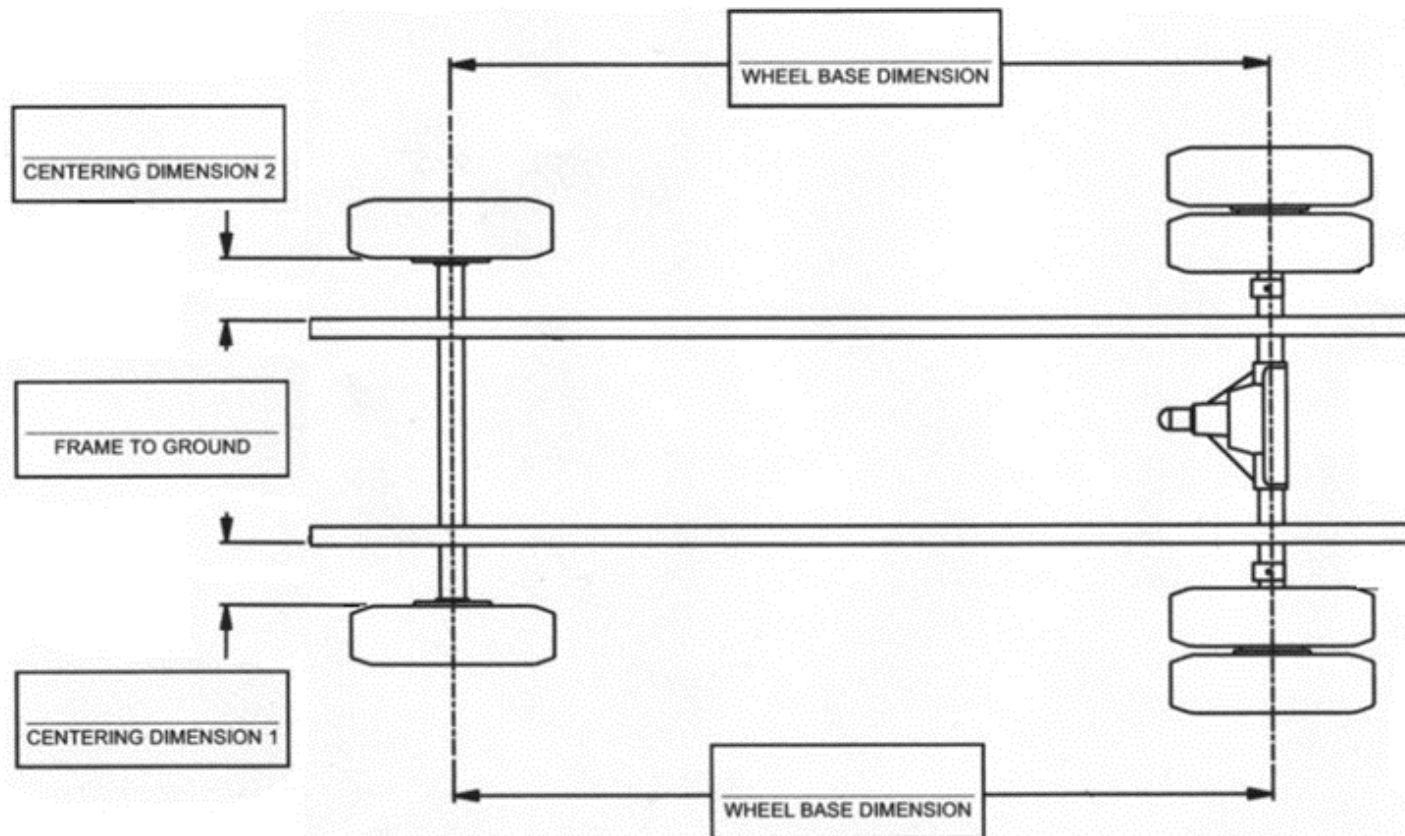
DISASSEMBLY

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 _____



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



1. THE BED MUST BE REMOVED FROM THE TRUCK.
2. JACK UP THE REAR OF THE FRAME SO THAT MOST OF THE TENSION IS OFF OF THE LEAF SPRINGS. PLACE A SET OF JACK STANDS UNDER THE FRAME AND BLOCK THE TIRES SO THE AXLE WON'T MOVE.
3. SUPPORT THE FRONT OF THE PINION WITH A JACK STAND.
4. REMOVE THE LEAF SPRINGS, SHOCKS AND SWAY BAR, IF EQUIPPED. KEEP THE MOUNTING HARDWARE FOR LATER USE.
5. REMOVE UPPER OVERLOAD PADS, IF EQUIPPED.
6. CUT BUMP STOP PADS OFF OF THE TOP SIDE OF THE AXLE AND GRIND THE AXLE SMOOTH.



7. CUT FACTORY BUMP STOP BRACKETS OFF OF THE FRAME RAILS AND GRIND THE FRAME SMOOTH.



8. PAINT OR APPLY UNDERCOATING TO AREAS THAT HAVE BEEN CUT AND GROUND ON TO PROTECT FROM RUST.

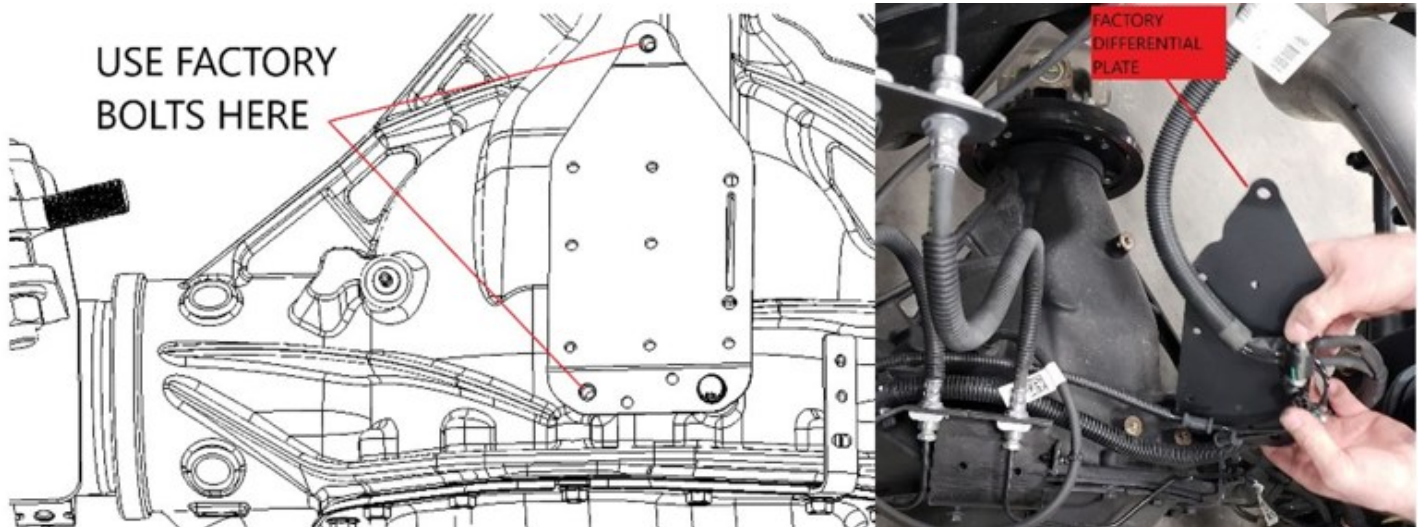
ASSEMBLY

***OPEN EVERY BOX AND LOCATE ALL PARTS. THERE ARE SEVERAL SMALLER BUSHING PIECES AND BOLTS THAT ARE PACKAGED SEPARATELY INSIDE THE MAIN BOX**

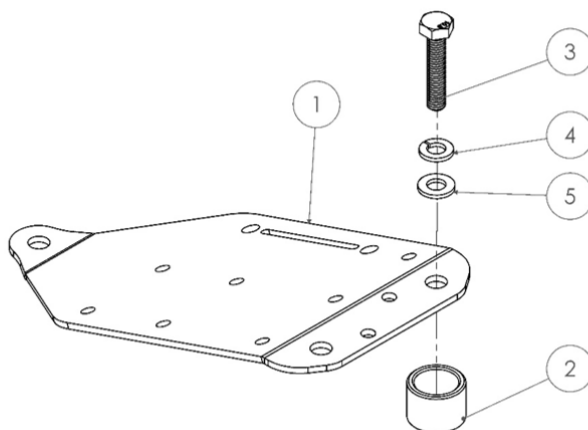
NOTE: ALL OF THE BOLTS IN THIS KIT USE A FLAT WASHER ON EACH SIDE OF THE BOLT

NOTE: SNUG ALL BOLTS BUT DO NOT TIGHTEN UNTIL THE ENTIRE KIT IS INSTALLED

1. REMOVE THE PLATE ON TOP OF THE DIFFERENTIAL AND DISCONNECT THE LINES FROM THE PLATE. REPLACE IT WITH (#10006521). USE TWO FACTORY BOLTS AND A M8-1.25 X 40MM BOLT, WASHER, LOCK WASHER AND SPACER.

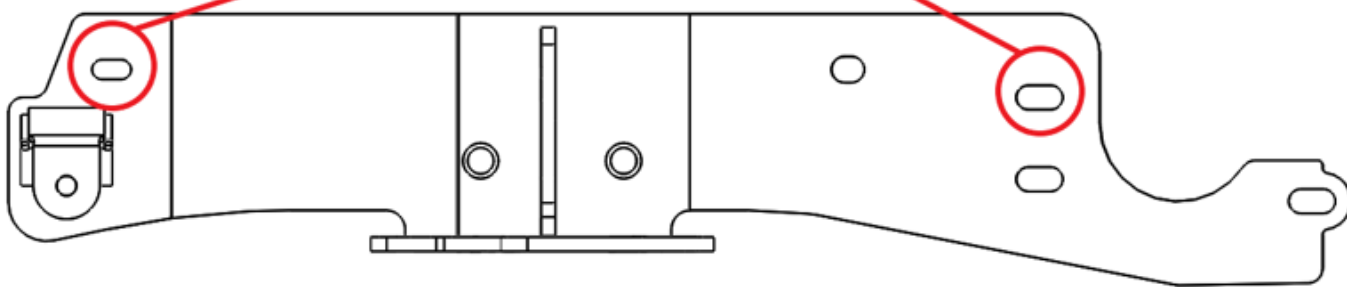


ITEM NO.	PART #	DESCRIPTION	QTY.
1	10006521	Plate - 11ga - Axle Line Relocation Bracket	1
2	10006656	CRR - 1" OD x .76" ID x .75" Long - PHB Spacer	1
3	13991	Bolt - M8 - 1.25 x 40mm Class 10.9	1
4	13993	M8 Splitlock 10.9 YZ	1
5	13997	Washer - M8 Flat Washer	1



2. LOCATE THE UPPER BAG MOUNTS DRIVER SIDE (DS #10006396) AND PASSENGER SIDE (PS #10006474). TEMPORARILY BOLT EACH UPPER BAG MOUNT TO THE FRAME SO THAT YOU CAN LOCATE THE TWO HOLES TO DRILL INTO THE FRAME DIRECTLY ABOVE EACH AIR BAG. THE HOLES NEED TO BE DRILLED TO 15/16" THROUGH THE OUTER WALL OF THE FRAME **ONLY**. IT MAY BE NECESSARY TO REMOVE THE BAG MOUNT AND DIE GRIND THE HOLES TO GET EVERYTHING TO ALIGN PROPERLY. AFTER THE HOLES ARE DRILLED, REMOVE THE BAG MOUNTS.

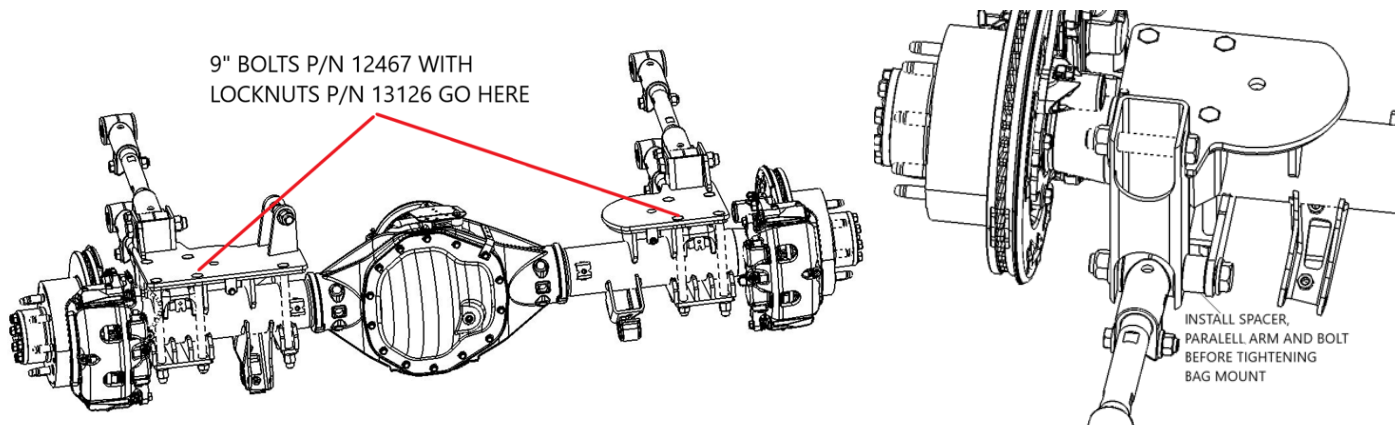
USE THESE HOLES TO BOLT UP
THE BAG MOUNT WHILE YOU
DRILL THE HOLES IN THE FRAME



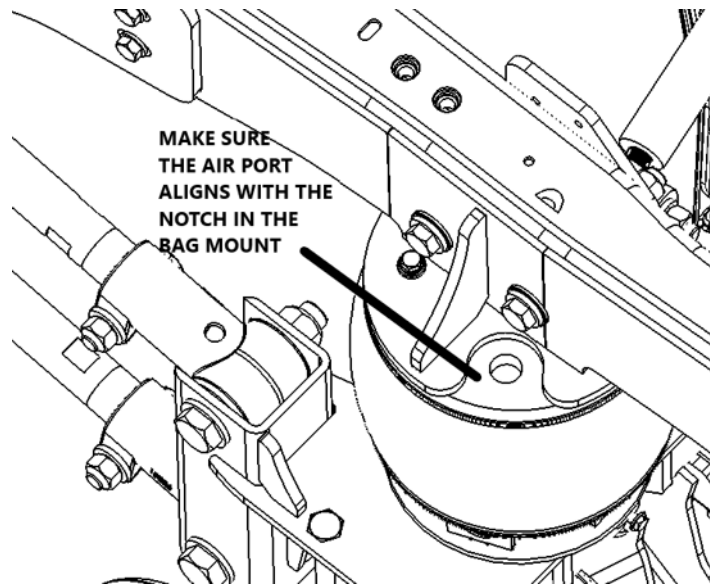
3. DRILL 11/16" HOLES IN THE INSIDE FRAME RAIL TO CORRESPOND WITH THE HOLES IN THE OUTSIDE OF THE FRAME.



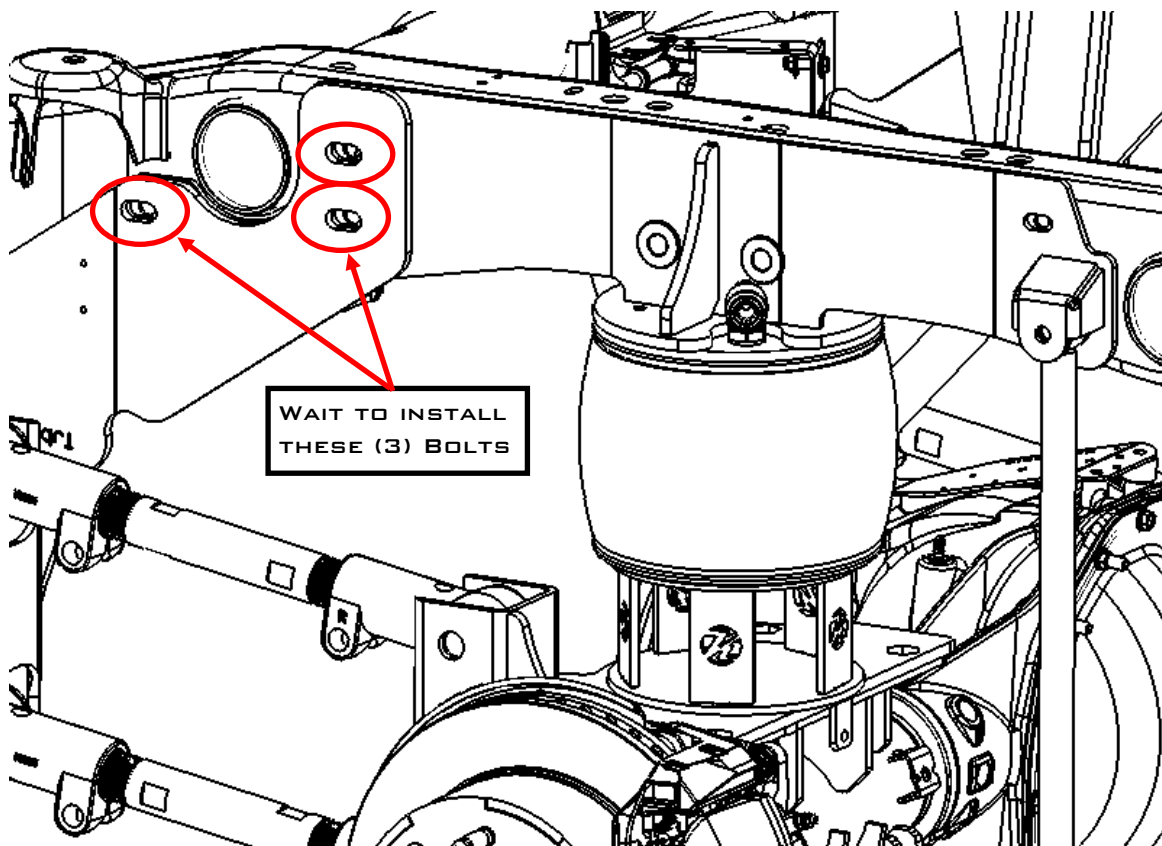
4. LOCATE THE LOWER BAG MOUNTS AIR BAGS, AXLE CLAMPS AND AXLE CLAMP HARDWARE. DS LOWER BAG MOUNT (#10006347), DS AXLE CLAMPS (#10006365) AND (#10006422). PS LOWER BAG MOUNT (#10006369) AND PS AXLE CLAMP (#10006366). LOCATE THE AXLE BOLTS IN THE BOLT KIT, LOCATE THE (2) 9" AXLE BOLTS AND PLACE THEM IN THE BAG MOUNTS TO THE REAR INSIDE HOLE ON THE PS BAG MOUNT, REAR MIDDLE ON THE DS BAG MOUNT, TO CLEAR THE SWAY BAR WHEN THE SUSPENSION IS FULLY EXTENDED. THESE SHORTER BOLTS WILL ALSO USE TOP LOCK NUTS (#13126), INSTEAD OF THE HIGH NUTS (#13179). MOUNT THE BAG MOUNTS USING THE FACTORY LEAF SPRING PAD TO POSITION THE BAG MOUNTS. INSERT A PARALLEL ARM INTO THE LOWER MOUNT AND USE THE MOUNTING BOLT AND SPACER TO ALIGN THE AXLE CLAMP AND PARALLEL ARM MOUNT ON EACH SIDE BEFORE TIGHTENING ANYTHING.

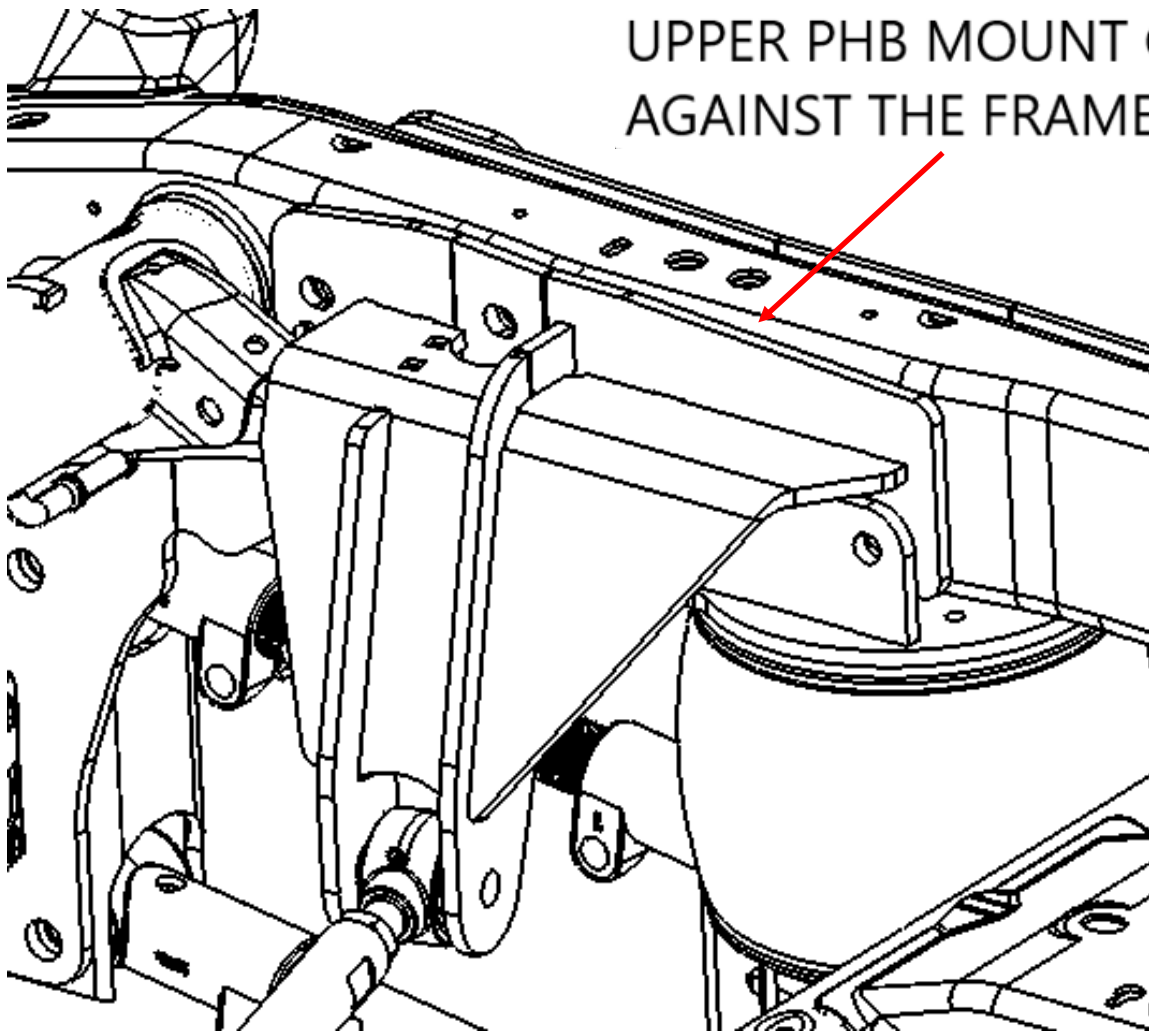


5. MOUNT THE AIR BAGS TO THE UPPER BAG MOUNTS WITH 3/8" X 1-1/4" - 16 BOLTS, LOCK WASHERS AND FLAT WASHERS. BE SURE TO ALIGN THE AIR PORT WITH THE NOTCH IN THE BAG MOUNT. INSTALL THE 3/4" X 3/4" 90° AIR FITTING INTO THE AIR PORT ON THE AIR BAG.

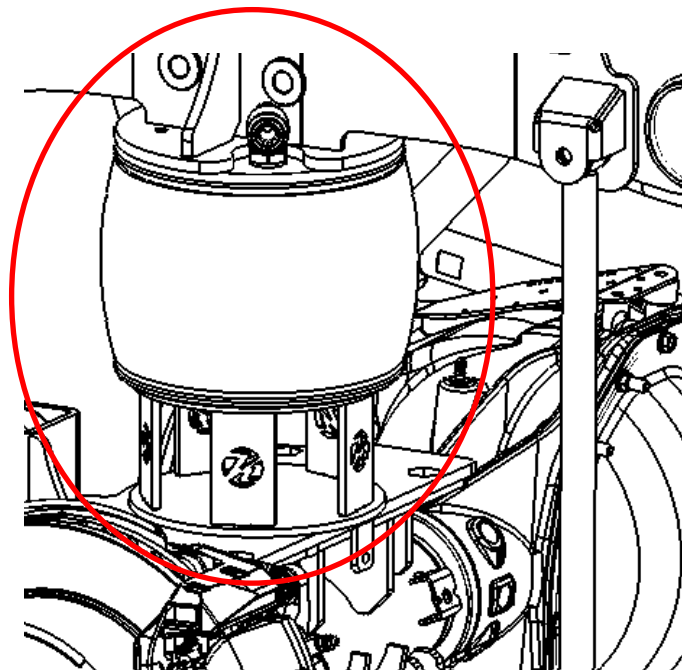


6. MOUNT THE UPPER BAG MOUNT TO THE FRAME ON THE DRIVER'S SIDE. USE THE 5/8"-18 X 5" (#12435), AND THE 5/8"-18 X 6" BOLTS (#12443), ALONG WITH THE CRUSH BUSHINGS (#10006399). ALSO INSTALL THE 1/2"-20 X 1-1/2" BOLT (#12007). THE UPPER PANHARD BAR MOUNT (#10031823.) MUST BE INSTALLED AT THE SAME TIME. IT GOES AGAINST THE FRAME. DO NOT INSTALL THE (3) FORWARD BOLTS YET, AS THEY GO THROUGH THE FRONT TRAILING ARM MOUNTS AS WELL. INSTALL THE CRUSH BUSHINGS THROUGH THE UPPER BAG MOUNT AND THE HOLES THAT YOU DRILLED INTO THE FRAME.



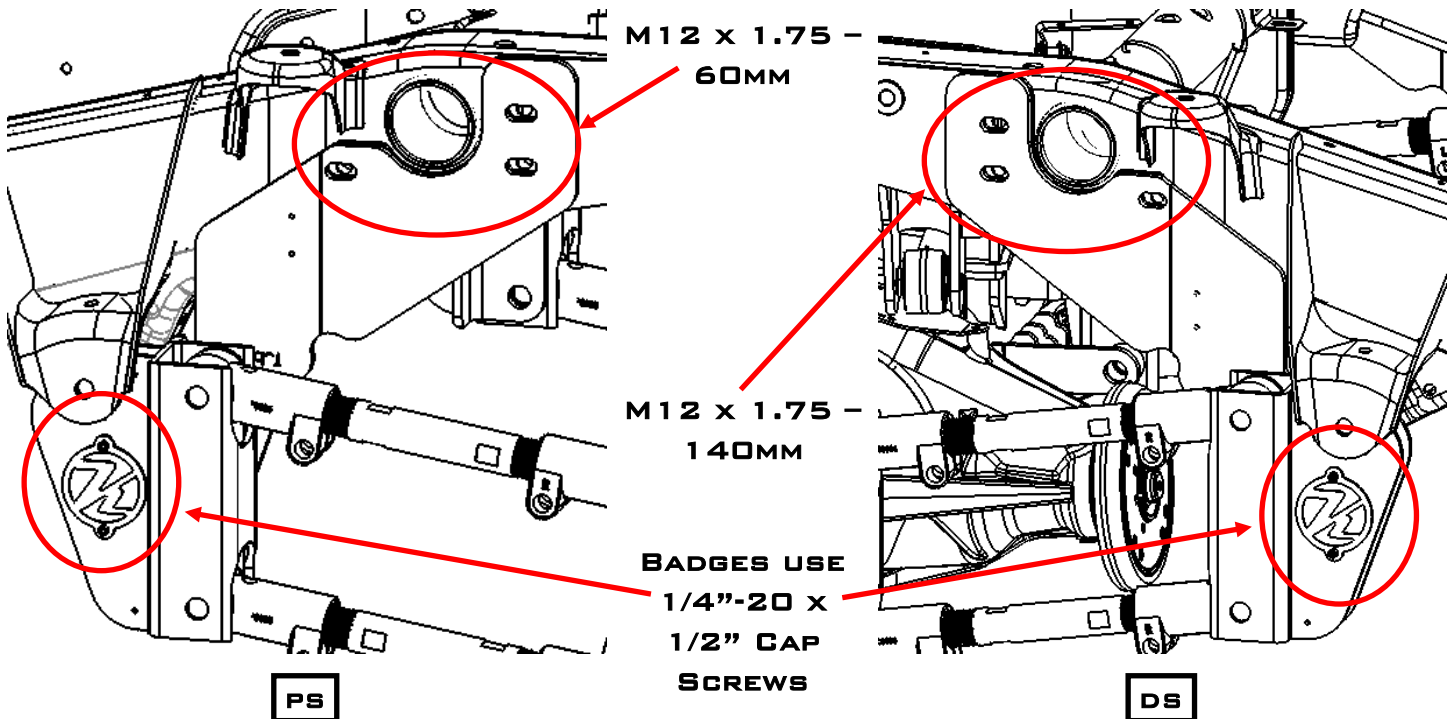


7. MOUNT THE AIR BAGS TO THE AIR BAG SPACERS (#10031821) AND THEN MOUNT THAT ASSEMBLY TO THE LOWER BAG MOUNT. THE BAG ITSELF TAKES A $\frac{3}{4}$ " COARSE THREAD JAM NUT, LOCK WASHER AND FLAT WASHER. THE SPACER MOUNTS WITH A $\frac{3}{4}$ " FINE THREAD JAM NUT, LOCK WASHER AND FLAT WASHER.

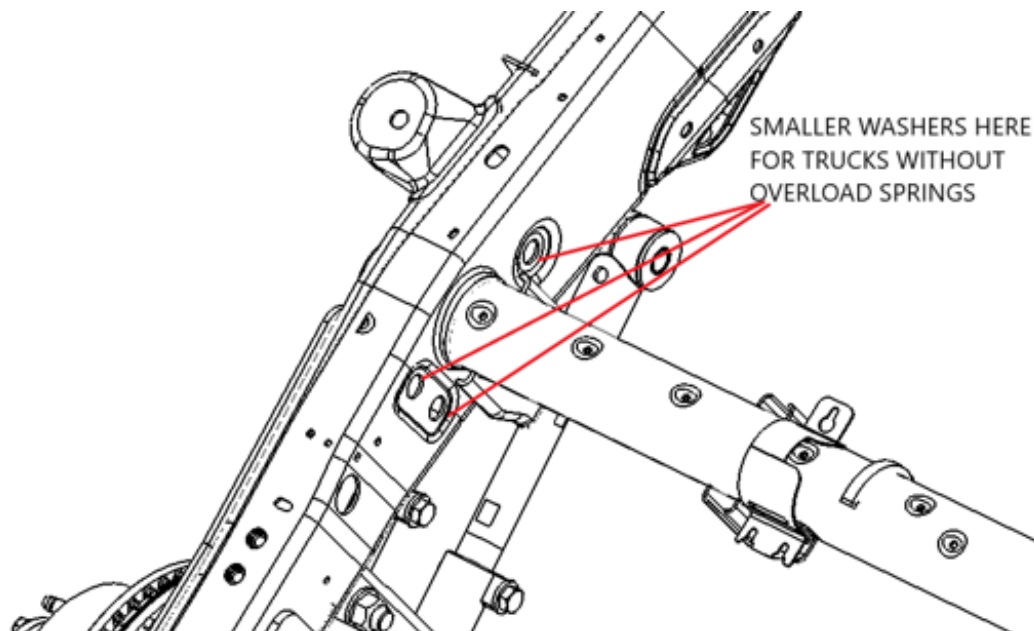


8. THE FUEL TANK WILL NEED TO BE TAKEN LOOSE AND SLID TOWARD THE CENTER OF THE TRUCK TO ALLOW ACCESS TO THE BOLT HOLES TO MOUNT THE TRAILING ARM MOUNTS.

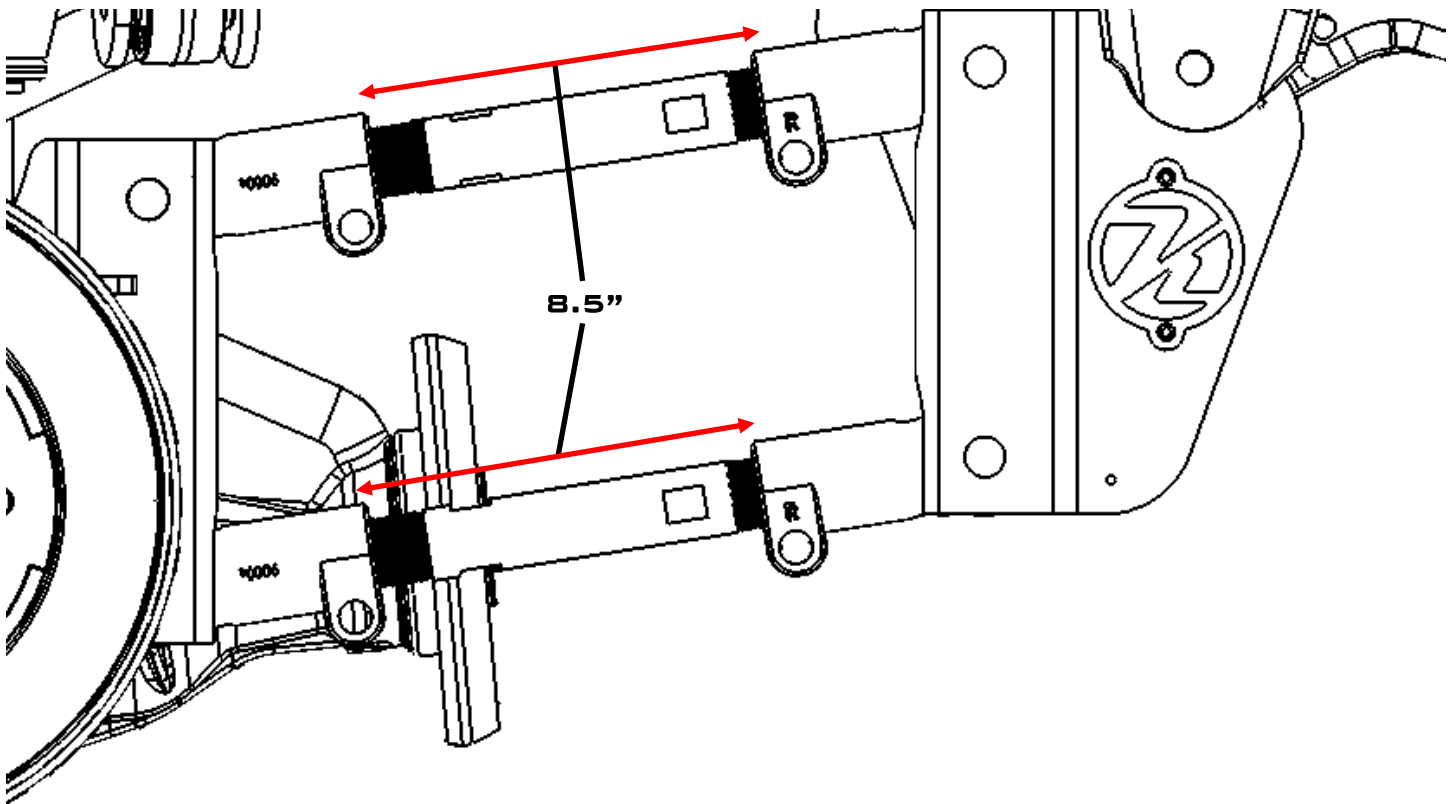
9. LOCATE THE FRONT TRAILING ARM MOUNTS. DS PERCH MOUNT (#10031814), PS PERCH MOUNT (#1003187). PLACE THEM AGAINST OF THE UPPER BAG MOUNT SIDE PLATE. THE FRONT OF THE MOUNT GOES INTO THE FRONT LEAF SPRING MOUNT AND USES THE FACTORY LEAF SPRING BOLT. IF YOUR TRUCK CAME WITH OVERLOAD SPRINGS, YOU WILL USE THE M12 X 1.75 - 60MM BOLTS ON THE DRIVER'S SIDE AND M12 X 1.75 - 140MM ON THE PASSENGERS SIDE. IF YOUR TRUCK DID NOT COME WITH FACTORY OVERLOAD SPRINGS SEE THE FOLLOWING STEP.



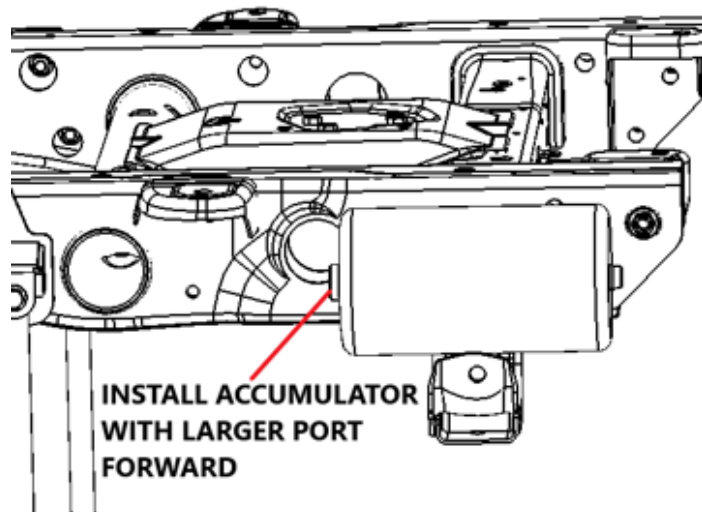
10. IF YOUR TRUCK DID NOT COME WITH OVERLOAD SPRINGS, YOU WILL USE 7/16" HARDWARE IN THOSE HOLES. IF USING THE 7/16" HARDWARE, THE LARGER WASHER GOES ON THE OUTSIDE OF THE KIT, THE SMALLER WASHER GOES INTO THE FRAME.



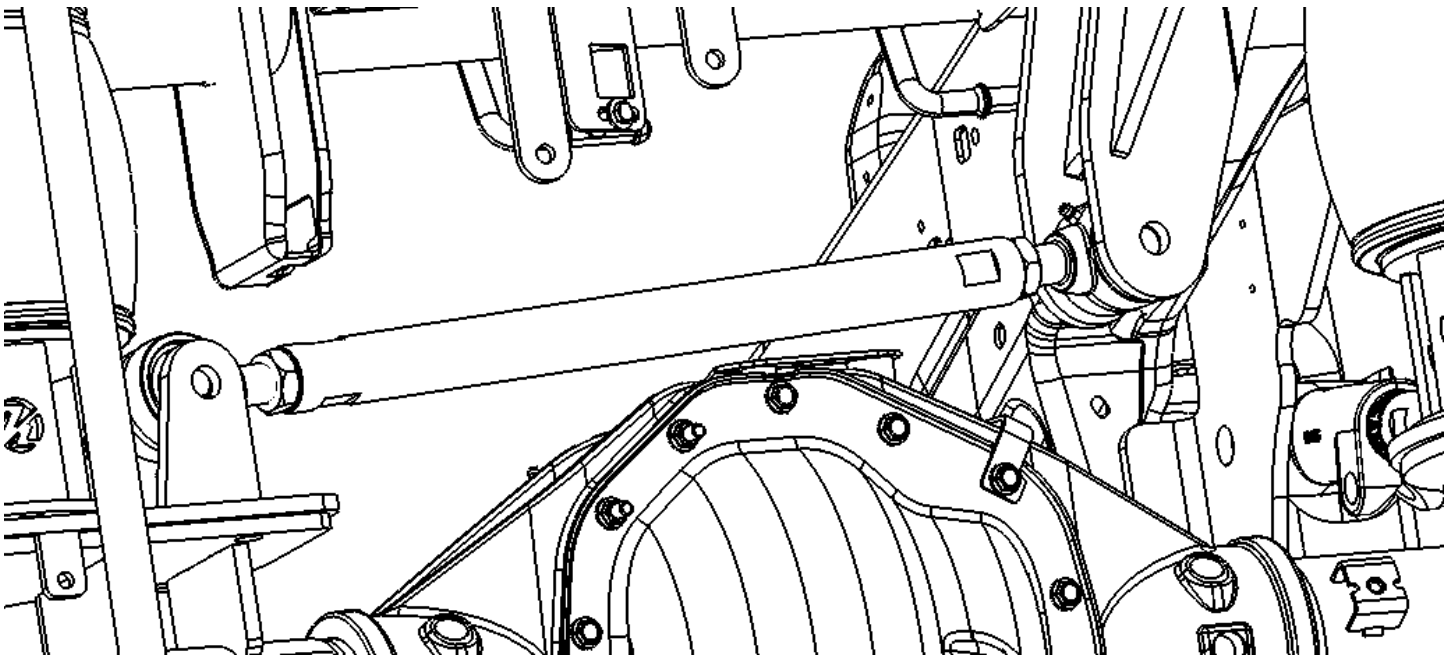
11. LOCATE THE TRAILING ARMS (#10006949). PRESET THE TRAILING ARM LENGTH TO 8-1/2" BETWEEN THE CAST KNUCKLES. THE FRONT BARS ATTACH TO THE FORWARD TRAILING ARM PLATE WITH THE 7/8"-14 X 5-1/2" BOLTS. THE TOP REAR ATTACH WITH 7/8"-14 X 5" BOLTS AND THE BOTTOM REAR ATTACH WITH 7/8"-14 X 6-1/2" BOLTS. **DO NOT TORQUE THESE BOLTS UNTIL THE INSTALL IS COMPLETE.**



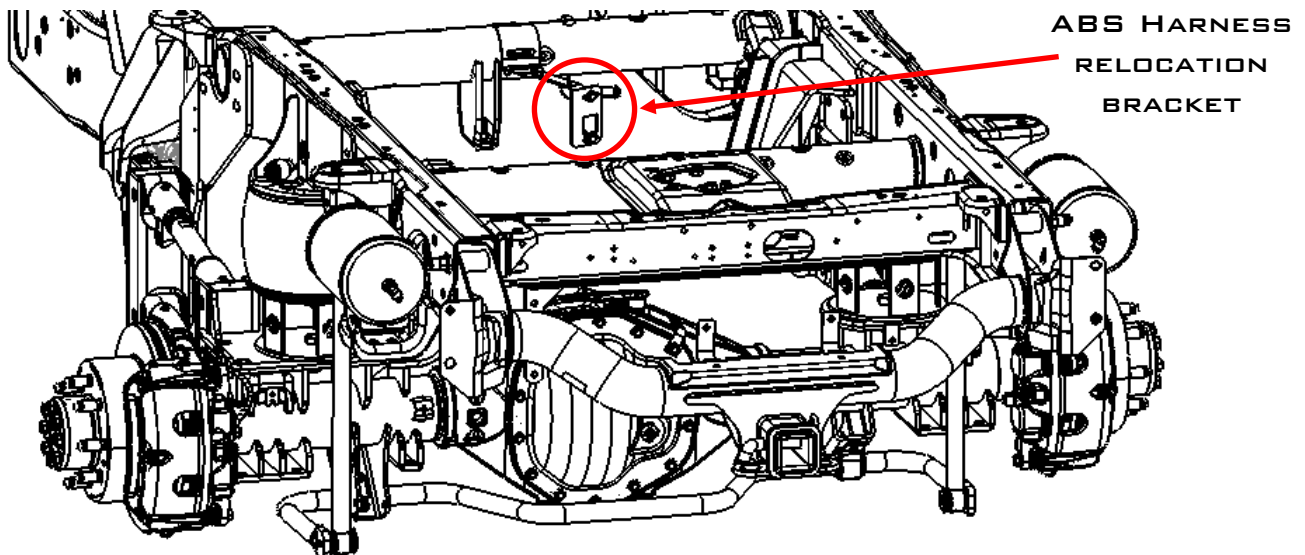
12. LOCATE THE ACCUMULATOR TANKS (#10006420 (DS) AND (#10006421 (PS). THESE TANKS FASTEN INTO THE FACTORY REAR LEAF SPRING SHACKLE MOUNTS WITH THE FACTORY BOLTS. MAKE SURE THAT THE LARGE PORT FOR THE 3/4" AIR FITTING IS POINTING FORWARD. TORQUE THE FACTORY LEAF SPRING BOLT TO 135 FT./LBS. ONCE THE TANK IS SECURED WITHIN THE MOUNT, RUN THE 3/4" AIR LINE FROM THE LARGE FITTING IN THE AIR TANK TO THE FITTING IN THE AIR BAG. TORQUE THE NUT ON THE BOTTOM OF THE BAG TO 35 FT./LBS.



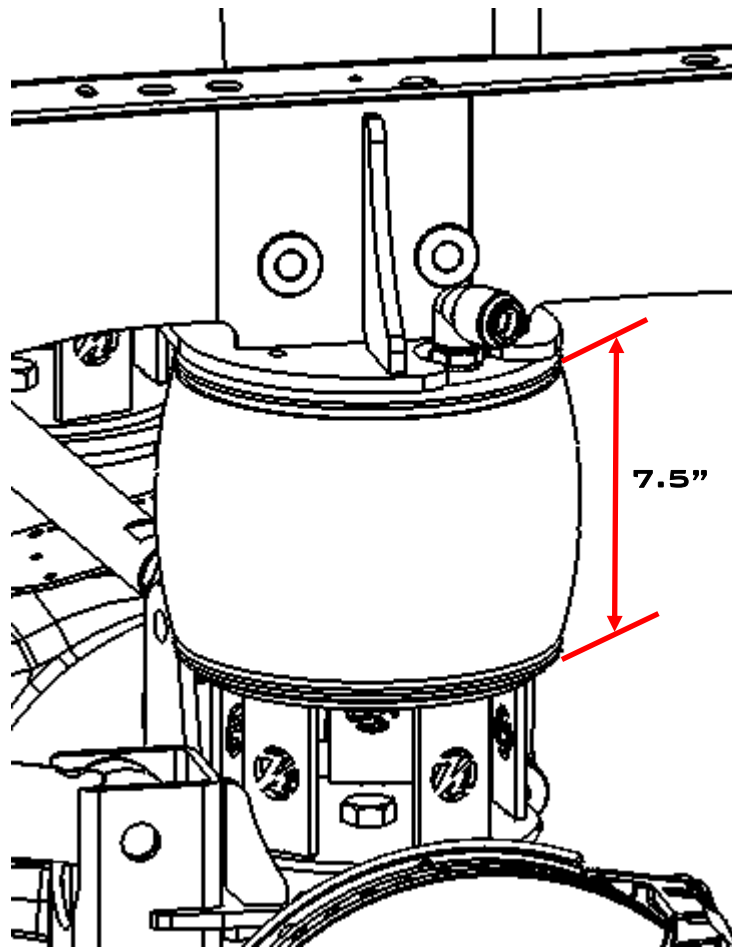
13. LOCATE THE PANHARD BAR (#10007434), JOHNNY JOINTS (#80281 & 80282) AND JAM NUTS (#13210 & 13211). ASSEMBLE JAM NUTS TO JOHNNY JOINT ENDS AND INSTALL JOHNNY JOINTS TO PANHARD BAR. IT FASTENS TO THE UPPER AND LOWER PANHARD BAR MOUNTS WITH $\frac{3}{4}$ "-16 X 4- $\frac{1}{2}$ " BOLTS. TORQUE BOLTS TO 200 FT./LBS. INSTALL ABS HARNESS RELOCATION BRACKET. SEE PICTURE BELOW.



14. LOCATE THE SWAY BAR (#80259), MOUNTING CLAMPS (#80271), SWAY BAR BUSHINGS (#80256), AND SWAY BAR END LINKS (#10012036). THE SWAY BAR FASTENS TO THE AXLE IN THE FACTORY LOCATION, IF EQUIPPED, ON THE SHOCK MOUNTS. IF YOUR TRUCK DID NOT COME WITH A FACTORY SWAY BAR, YOU WILL NEED TO TAP THE FACTORY WELD NUTS TO $\frac{3}{8}$ "-24 TO MOUNT THE MOUNTING CLAMPS TO THE AXLE. IF YOUR TRUCK CAME WITH A FACTORY SWAY BAR, USE THE FACTORY BOLTS TO MOUNT THE NEW CLAMPS. THE UPPER END OF THE END LINKS MOUNT TO THE POCKETS IN THE UPPER BAG MOUNTS WITH $\frac{1}{2}$ "-20 X 3" BOLTS. THE LOWER END OF THE END LINKS ATTACH TO THE FRAME WITH $\frac{1}{2}$ "-20 X 3" BOLTS AS WELL, BE SURE TO USE THE LARGE MACHINED WASHER ON THE BOLT HEAD, (#11551). USE THE SUPPLIED GREASE BETWEEN THE SWAY BAR AND THE SWAY BAR BUSHINGS TO PREVENT SQUEAKING.

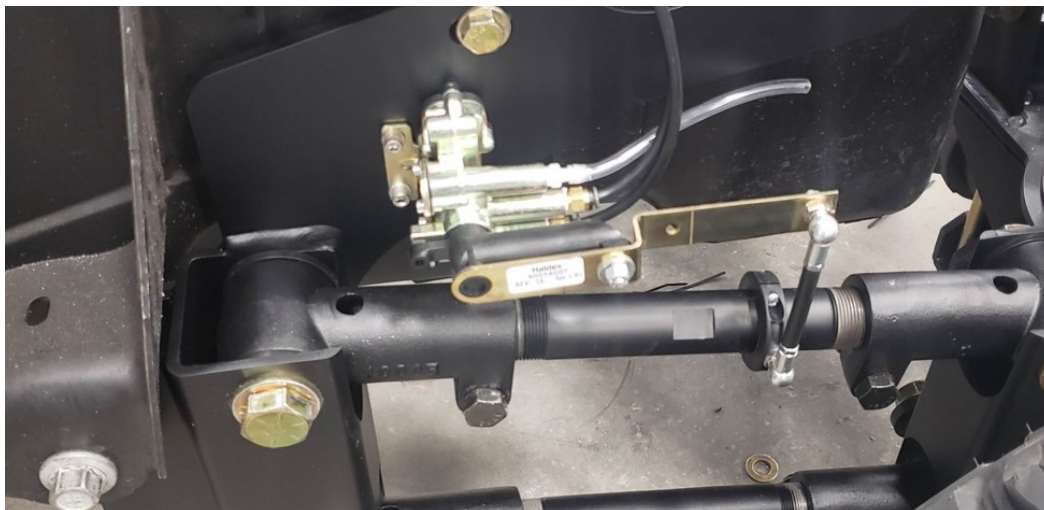


15. ONCE THE KIT IS INSTALLED, INFLATE THE AIRBAGS TO 7-1/2" THIS IS WHERE THE AIRBAG RIDES THE BEST. MEASURE OFF OF THE FRONT AXLE BALL JOINTS TO MAKE SURE THAT THE AXLE IS SQUARE WITH THE FRONT.



16. MOUNT THE HEIGHT CONTROL SENSORS TO THE PERCH MOUNT USING THE HARDWARE PROVIDED WITH THE SENSORS. THE MECHANICAL VALVE MUST BE VERTICAL WHEN INSTALLED AND THE ARM MUST BE HORIZONTAL AT RIDE HEIGHT. THE HEIGHT CONTROL VALVES ARE THE SAME FOR EACH SIDE OF THE TRUCK. THE HEIGHT CONTROL VALVE HAS A BUILT IN 8 SECOND DELAY.

NOTE: BEFORE INSTALLING THE MECHANICAL VALVE, ROTATE THE ARM CLOCKWISE AND COUNTERCLOCKWISE 4-5 TIMES EACH WAY. THIS WILL PREPARE THE INTERNALS FOR OPERATION AFTER SITTING IN INVENTORY.



17. THE RECOMMENDED MOUNTING LOCATION FOR THE COMPRESSOR BOX AND AIR TANK IS WHERE THE SPARE TIRE ORIGINALLY WENT. USE THE SUPPLIED MOUNTING BRACKETS AND WELD THEM TO THE CROSS MEMBER. REFER TO FIGURES 12-14 FOR PLUMBING AND WIRING OF THE AIR SYSTEM. ON THIS SYSTEM YOU WILL RUN THE AIR LINE FROM THE HEIGHT CONTROL VALVE TO THE ACCUMULATOR TANK. YOU WILL CONNECT THE AIR BAG TO THE ACCUMULATOR TANK WITH THE $\frac{3}{4}$ " TUBING AND CONNECTORS.

MAKE SURE TO USE A BATTERY PROTECTION DEVICE ON THE BATTERIES OR UNHOOK THE BATTERIES BEFORE WELDING!



18. AFTER INSTALL IS COMPLETE, AND THE REAR AXLE IS SQUARE, TORQUE ALL FASTENERS TO THE SPECIFICATIONS IN THE CHART BELOW.

BOLT SIZE	GRADE 5 TORQUE	GRADE 8 TORQUE
1/4"-20	8 FT-LB	12 FT-LB
3/8"-16	19 FT-LB	26 FT-LB
3/8"-24	21 FT-LB	30 FT-LB
1/2"-13	45 FT-LB	64 FT-LB
1/2"-20	50 FT-LB	70 FT-LB
9/16"-18	70 FT-LB	100 FT-LB
5/8"-11	90 FT-LB	125 FT-LB
5/8"-18	100 FT-LB	150 FT-LB
3/4"-16	175 FT-LB	250 FT-LB
7/8"-14	275 FT-LB	400 FT-LB

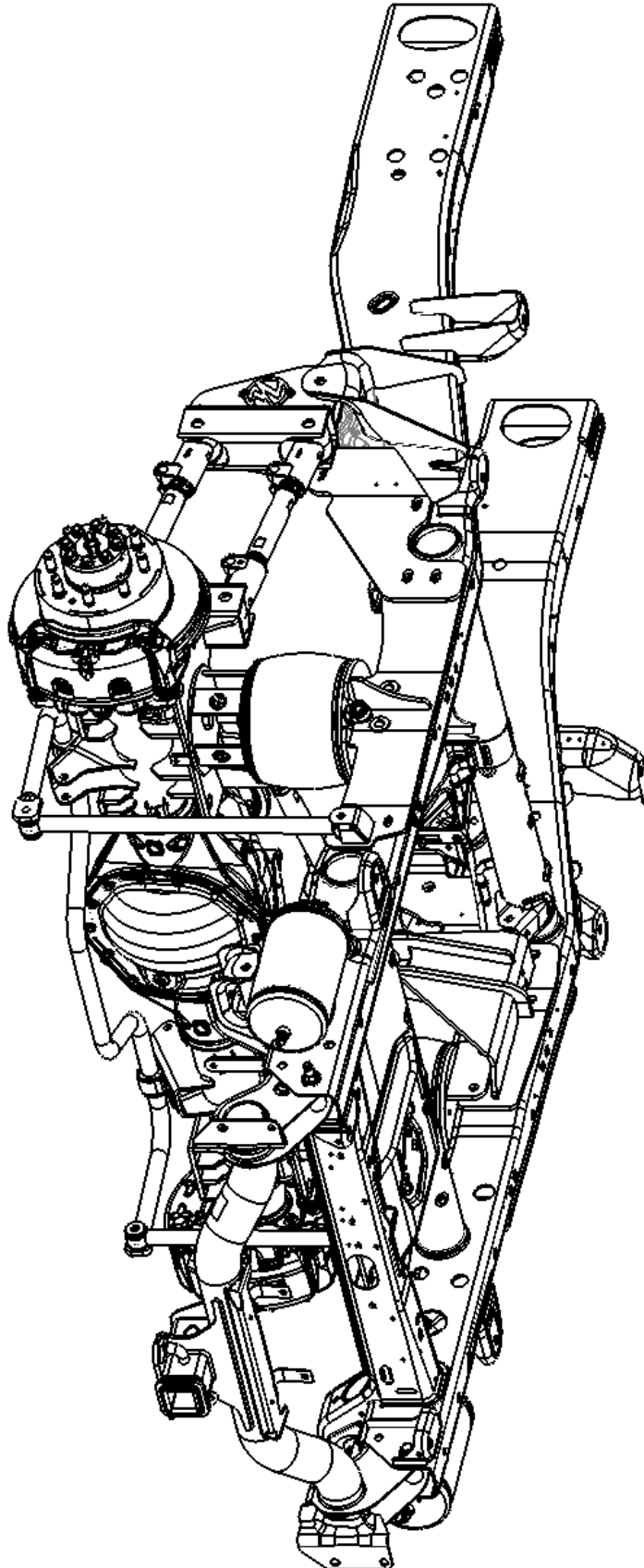
19. AFTER THE BOLTS ARE TORQUED AND THE AIR BAGS ARE INFLATED TO RIDE HEIGHT, YOU CAN NOW REPLACE THE BED.

20. SET THE PINION ANGLE TO THE MEASUREMENT THAT YOU TOOK IN SUSPENSION REMOVAL STEP 1.

21. NOW THE TRUCK IS READY FOR A TEST DRIVE. PAY CLOSE ATTENTION TO HOW THE TRUCK HANDLES AND IF THERE ARE ANY VIBRATIONS.

22. WHEN YOU TEST DRIVE THE TRUCK, IF THE TRUCK PULLS TO ONE SIDE, SHORTEN THE OPPOSITE SIDE TRAILING ARMS ONE TURN AND TEST DRIVE AGAIN. REPEAT UNTIL PULL IS NO LONGER NOTICEABLE.

KIT DRAWINGS



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:

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