



# 7104 Installation Instructions

## 2016-2020 GM 2500HD/3500HD without OE Mount

### Steering Stabilizer

### Read and understand all instructions and warnings prior to installation of product and operation of vehicle.

Zone Offroad Products recommends this system be installed by a professional technician. In addition to these instructions, professional knowledge of disassembly/ reassembly procedures and post installation checks must be known. Minimum tool requirements include the following: Assorted metric and standard wrenches, hammer, hydraulic floor jack and a set of jack stands. See the "Special Tools Required" section for additional tools needed to complete this installation properly and safely.

#### »» PRODUCT SAFETY WARNING

Certain Zone Suspension Products are intended to improve off-road performance. Modifying your vehicle for off-road use may result in the vehicle handling differently than a factory equipped vehicle. Extreme care must be used to prevent loss of control or vehicle rollover. Failure to drive your modified vehicle safely may result in serious injury or death. Zone Offroad Products does not recommend the combined use of suspension lifts, body lifts, or other lifting devices.

You should never operate your modified vehicle under the influence of alcohol or drugs. Always drive your modified vehicle at reduced speeds to ensure your ability to control your vehicle under all driving conditions. Always wear your seat belt.

#### »» TECHNICAL SUPPORT

[www.zoneoffroad.com](http://www.zoneoffroad.com) may have additional information about this product including the latest instructions, videos, photos, etc.

Send an e-mail to [tech-zone@sporttruckusainc.com](mailto:tech-zone@sporttruckusainc.com) detailing your issue for a quick response.

888.998.ZONE Call to speak directly with Zone tech support.

#### Difficulty Level

easy 1 2 **3** 4 5 difficult

Estimated installation: hours

#### Special Tools Required

Torsion Bar Unloading Tool

#### Tire/Wheel Fitment

N/A

#### »» PRE-INSTALLATION NOTES

1. Special literature required: OE Service Manual for model/year of vehicle. Refer to manual for proper disassembly/reassembly procedures of OE and related components.
2. Adhere to recommendations when replacement fasteners, retainers and keepers are called out in the OE manual.
3. Larger rim and tire combinations may increase leverage on suspension, steering, and related components. When selecting combinations larger than OE, consider the additional stress you could be inducing on the OE and related components.
4. Post suspension system vehicles may experience drive line vibrations. Angles may require tuning, slider on shaft may require replacement, shafts may need to be lengthened or trued, and U-joints may need to be replaced.
5. Secure and properly block vehicle prior to installation of Zone Offroad Products. Always wear safety glasses when using power tools.
6. If installation is to be performed without a hoist, Zone Offroad Products recommends rear alterations first.
7. Due to payload options and initial ride height variances, the amount of lift is a base figure. Final ride height dimensions may vary in accordance to original vehicle attitude. Always measure the attitude prior to beginning installation.

rev02172021

**\*Important\* Verify you have all of the kit components before beginning installation.**

## ZON7104 Kit Contents

### Qty Part

1	Stabilizer cylinder	1	1/2"-13 x 1-1/4" bolt
1	Stabilizer Bracket	1	1/2" SAE flat washer
1	Tapered Stud Pack	1	Hourglass bushing 1-1/4" wide
2	1/2" Rivet Nut	1	Hourglass bushing 1-7/16" wide
1	3/4" washer	1	Sleeve - 5/8" x 1/2" ID
1	Bolt Pack 340	1	Bolt Pack 799
1	1/2"-20 nut - center lock	1	1/2"-13 x 2" Bolt
2	1/2" SAE washer	1	1/2" Washer
1	12mm-1.75 x 70mm bolt	1	1/2" Star Washer External tooth
1	12mm-1.75 lock nut	1	9/16" Hex high Nut

1. **IMPORTANT: Before beginning installation, please make sure that the hole on the OE drag link is tapered**

## INSTALLATION INSTRUCTIONS

2. Park vehicle on clean flat and level surface. Block the rear wheels for safety.
3. Remove factory front skid plate, if equipped.
4. The front control arm bolt on the Driver's side must be removed. Trucks with aftermarket lift kits that include drop brackets will still need to follow the remaining steps, but the bolt will support the front crossmember. To safely remove the bolt, follow all steps listed below:
5. Raise front of vehicle and support frame rails with jack stands.
6. Unload the Driver's side torsion bar using appropriate tool. Remove the torsion bar key bridge to remove all load from the torsion bar. This is an important safety step.
7. Install the rivet nut into the factory hole in the frame. There is one extra rivet nut incase the installation is messed up. Follow directions at the end of the instruction sheet for how to install the rivet nut properly. If installation fails on first attempt, it is possible to tack weld the rivet nut in place to keep it from spinning (disconnect battery(s) if welding is performed). (See Page 3)
8. Remove the front lower control arm bolt.
9. Place the bracket with washer between the bracket and frame mounting point. Reattach with factory hardware. Wait until the vehicle is on the ground for final torque.
10. Attach bracket to frame with 1/2" hardware. Tighten to 55 ft-lbs.
11. Install the narrow bushing into the body end of the stabilizer with sleeve. Install the wider bushing into the rod end of the stabilizer, no sleeve is required.
12. Attach body end of stabilizer to factory mount with 12mm x 70mm hardware.
13. Attach stud pack to centerlink with the centerlock nut from bolt pack #340 (included in the stabilizer box kit). Do not use the castellated nut that comes in the stud pack. (See pass side stabilizer mount picture)
14. Install the washer from the stud pack onto the stud, followed by the bushing, another washer, and locking nut.
15. Tighten 12mm hardware and 1/2" stud nut to 55 ft-lbs, 7/16" stud nut to 45 ft-lbs.
16. Reload torsion bars, and set to previous height.

## Post-Installation Warnings

1. Check all fasteners for proper torque. Check to ensure for adequate clearance between all rotating, mobile, fixed, and heated members. Verify clearance between exhaust and brake lines, fuel lines, fuel tank, floor boards and wiring harness. Check steering gear for clearance. Test and inspect brake system.
2. Re-torque all fasteners after 500 miles. Always inspect fasteners and components during routine serving.

17. Lower the front of the vehicle to the ground. Tighten lower control arm bolt to 180 ft-lbs.
18. Reinstall skid plate(s) if equipped.
19. Recheck after 500 miles.

### **PASS SIDE STABILIZER MOUNT**

(DO NOT USE CASTELLATED NUT, USE CENTER LOCK NUT)



Figure 1

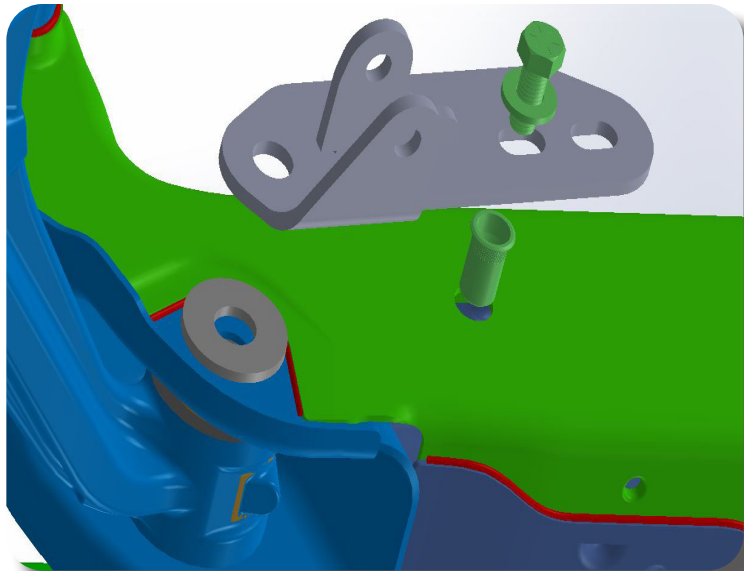


Figure 2 - 2016-2019 trucks use farthest slot, 2020+ trucks use nearest slot

## Rivet Nut Installation Instructions

### » RIVET NUT INSTALLATION TOOL ASSEMBLY

1. For a 1/2" rivet nut, place the provided 1/2" SAE washer on a 1/2" x 2" bolt followed by a 9/16" high nut and 1/2" serrated edge lock washer. Thread this tool assembly into the rivet nut as shown. **Figure 3.**

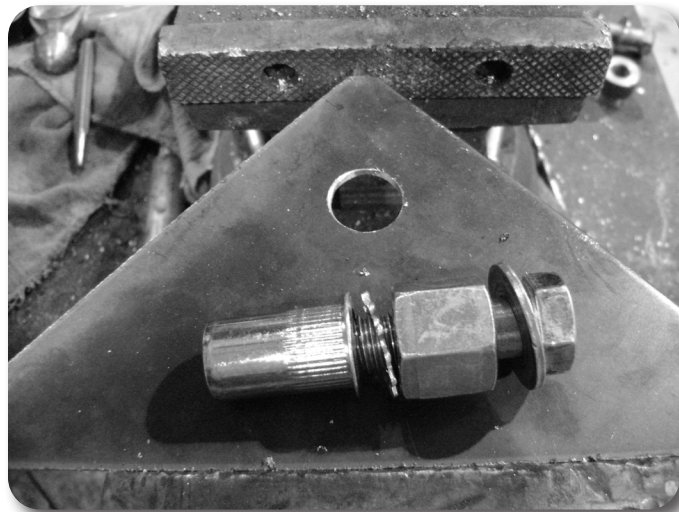


Figure 3 - 1/2" Rivet Nut Shown

### » RIVET NUT INSTALLATION

2. Place the installation tool with the rivet nut threaded on the end into the appropriately sized hole.
3. For a 1/2" rivet nut, hold the nut closest to the rivet nut still with an 7/8" wrench and tighten the 1/2" bolt with a 3/4" wrench to set the rivet nut. Be sure to hold the rivet nut flush to the surface and square to the hole as it is tightened. **Figure 4**

### Step 6 & 7 Note

If available, an impact gun is recommended for tightening the bolt to ensure the rivet nut remains square to the hole and to ease holding the nut from spinning.



Figure 4 - 1/2" Rivet Nut shown

### **Step 8 & 9 Note**

If using the recommended impact gun, use caution to not exceed the recommended torque specifications.

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### **» TORQUE SPECIFICATIONS**

4. 1/2" rivet nuts will approach 90 ft lbs for maximum grip strength. Do not exceed 100 ft-lbs when setting the rivet nut.

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### **» RIVET NUT TOOL REMOVAL**

5. Once the center bolt is tightened, remain holding the nut from spinning with the wrench and loosen the center bolt to remove the installation tool.
6. Verify proper installation by checking for consistent rivet nut deformation to see the threads are square and centered to the rivet nut. Figure 5.



Figure 5

### **Step 10 \*IMPORTANT\***

It is very important to hold the nut as the bolt is loosened because the grip of the star washer will try to spin the rivet nut and ruin the installation.