



4331 EUCALYPTUS AVE ~~ CHINO, CA 91710  
909-597-7800 Fax 909-597-7185  
1999-2000 FORD F-250/350 SUPER DUTY 2 WHEEL DRIVE  
FTS410 I BEAM DROP BRACKETS

**PARTS LIST:**

1 EA. I BEAM BRACKET PASSENGER SIDE FT410-104  
1 EA. I BEAM BRACKET DRIVERS SIDE FT410-103  
9 EA. 1/2" X 1 1/2" BOLTS  
12 EA. 1/2" NYLOCK NUTS  
3 EA. 1/2" X 3 1/2" BOLTS  
1 EA. COTTER PIN  
24 EA. 1/2" SAE FLAT WASHERS  
1 EA. DROP PITMAN ARM FT309

**TOOL LIST:**

FLOOR JACK  
JACK STANDS  
AIR HAMMER WITH CHISEL AND PUNCH BITS  
DRILL WITH 1/8" AND 1/2" BITS  
ASSORTED METRIC AND S. A. E. WRENCHES AND SOCKETS  
C-CLAMPS OR VISE CLAMPS  
WHITE LITHIUM GREASE

CHECK ALL PARTS INCLUDED IN THIS KIT TO THE PARTS LIST ABOVE BEFORE BEGINNING INSTALLATION OF THE KIT. IF ANY PIECES ARE MISSING, CONTACT FABTECH AT 909-597-7800

CHECK THE FACTORY PITMAN ARM SPLINE ORIENTATION WITH THE SUPPLIED PITMAN ARM BEFORE BEGIN INSTALLATION. SEE STEP 6 FOR MORE INFORMATION.

READ ALL INSTRUCTIONS THOROUGHLY FROM START TO FINISH BEFORE BEGINNING INSTALLATION.

**WARNING:** FABTECH RECOMMENDS THAT YOU EXERCISE EXTREME CAUTION WHEN WORKING WITH COIL SPRINGS TO AVOID ANY POSSIBILITY OF INJURY.

THIS KIT MUST BE INSTALLED WITH THE FTS409 RADIUS ARM KIT AND FTS131 OR FTS136 COIL SPRINGS.

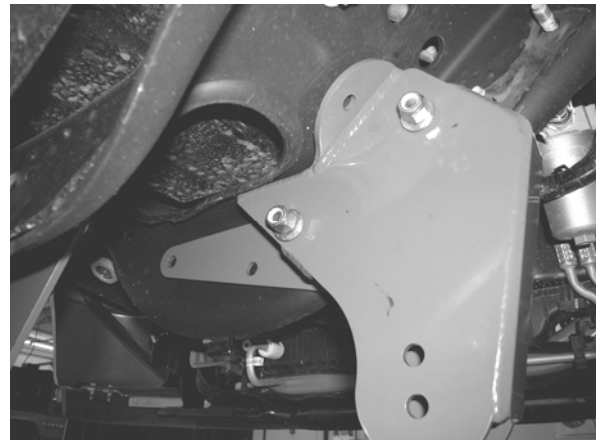
SWAY BAR DROP BRACKETS ARE INCLUDED WITH THE FTS131 AND FTS136 COIL SPRING KITS.

## INSTRUCTIONS:

1. Disconnect the negative terminal on the battery. Jack up the front end of the truck and support the frame, at the front frame rails, with jack stands. **NEVER WORK UNDER AN UNSUPPORTED VEHICLE.** Remove the front tires.
2. Remove the brake calipers and tie them up out of the way. **DO NOT ALLOW THE CALIPERS TO HANG FROM THE BRAKE LINES!** Remove the front shocks and the sway bar end links. Loosen the I Beam pivot bolts, **DO NOT REMOVE THESE BOLTS FROM THE I BEAM BRACKETS.**
3. Support the I beams with floor jacks and remove the J clips at the top of the coil spring. Lower the floor jacks supporting the I beams to release the coil springs from the coil buckets and remove the nut at the bottom of the coil springs. Set the coil spring, retaining washer, insulator and lower washer aside. Separate the drag link from the pitman arm. Remove the bolts securing the radius arms to the radius arm mounts and the I beam pivot bolts. Set the radius arm/I Beam assemblies aside.
4. The rivets and bolts securing the factory I beam brackets to the frame must be removed. The rivets can be removed by drilling out the heads and pushing the rivet out of the frame with a hammer and punch.
5. Attach the new drop brackets to the frame using the included hardware. You will reuse most of the factory holes and have to drill some new ones. Locate the existing holes with the supplied bolts and mark the new holes that must be drilled with a center punch. Drill the holes with a pilot drill (1/8") and follow through with a 1/2" drill. **BE SURE THERE IS NOTHING BEHIND THE FRAME SECTIONS YOU ARE DRILLING THROUGH, PLACE A PIECE OF PLATE STEEL ABOVE THE FRAME BELOW THE OIL PAN TO PREVENT DRILLING INTO THE PAN.** Tighten all the fasteners securing the brackets to the frame. SEE PHOTOS BELOW AND IN NEXT COLUMN.



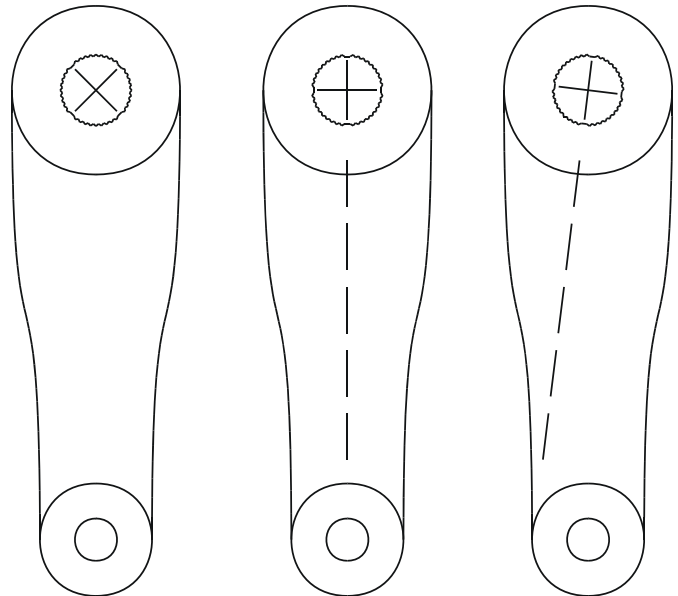
**Driver Side I-beam Bracket  
Ft410-104  
Viewed from the front**



**Passenger Side I-beam Bracket  
Ft410-103**

**Viewed from the rear**

6. Remove the nut securing the original pitman arm to the steering box shaft. A pitman arm puller must be used to remove the pitman arm from the steering shaft. Using the diagram shown above, confirm that the master spline orientation on your factory pitman arm matches the one on the FT309 pitman arm supplied with this kit. If they do not match, you will need to purchase a FTS310 or FTS311 replacement pitman arm. Align the master splines on the steering shaft, replace the original washer and nut and torque the new unit in place at 200-225 ft.-lbs. SEE DIAGRAM IN NEXT COLUMN.



**FTS309**

**FTS310**

**FTS311**

7. Install the extended radius arms at this time using the instructions supplied with that kit.
8. Slide the I beams into the new drop brackets reusing the factory bolts, do not tighten them yet. Reattach the drag link onto the new pitman arm and torque the castle nut, be sure to install a new cotter pin. Reinstall the coil springs the same way they were removed. Replace the

tires and fully torque the lug nuts. Set the truck back on the ground. Reattach the sway bar end links to the I beams, using the factory hardware. Fully torque the I beam pivot bolts and check all other fasteners. Set the toe-in to approximate factory specs. We recommend driving the truck for approximately fifty miles and then have the truck aligned to factory specs.

### **RETORQUE ALL NUTS, BOLTS AND LUGS AFTER 50 MILES AND PERIODICALLY THEREAFTER.**

For technical assistance call: 909-597-7800

### **Product Warranty and Warnings-**

Fabtech provides a Limited Lifetime Warranty to the original retail purchaser who owns the vehicle, on which the product was originally installed, for defects in workmanship and materials.

The Limited Lifetime Warranty excludes the following Fabtech items; bushings, bump stops, ball joints, tie rod ends, limiting straps, cross shafts, heim joints. These parts are subject to wear and are not considered defective when worn. They are warranted for 60 days from the date of purchase for defects in workmanship.

Take apart shocks are considered a serviceable shock with a one year warranty on leakage only. Service seal kits are available separately for future maintenance. All other shocks are covered under our Limited Lifetime Warranty.

Fabtech does not warrant any product for finish, alterations, modifications and/or installation contrary to Fabtech's instructions. Alterations to the finish of the parts including but not limited to painting, powdercoating, plating and/or welding will void all warranties. Some finish damage may occur to parts during shipping which is considered normal and is not covered under warranty.

Fabtech products are not designed nor intended to be installed on vehicles used in race applications or for racing purposes or for similar activities. (A "RACE" is defined as any contest between two or more vehicles, or any contest of one or more vehicle against the clock, whether or not such contest is for a prize). This warranty does not include coverage for police or taxi vehicles, race vehicles, or vehicles used for government or commercial purposes. Also excluded from this warranty are sales outside of the United States of America.

Installation of most suspension products will raise the center of gravity of the vehicle and will cause the vehicle to handle differently than stock. It may increase the vehicle's susceptibility to a rollover, on road and off road, at all speeds. Extreme care should be taken to operate the vehicle safely at all times to prevent rollover or loss of control resulting in serious injury or death. Fabtech front end Desert Guards may impair the deployment or operation of vehicles equipped with supplemental restraining systems/air bag systems and should not be installed if the vehicle is equipped as so.

Fabtech makes every effort to ensure suspension product compatibility with all vehicles listed in the catalog, but due to unknown auto manufacturers production changes and/or inconsistencies by the auto manufacturer, Fabtech cannot be responsible for 100% compatibility, including the fitment of tire and wheel sizes listed. The Tire and Wheel sizes listed in Fabtech's catalog are only a guideline for street driving with noted fender trimming. Fabtech is not responsible for damages to the vehicle's body or tires.

Fabtech's obligation under this warranty is limited to the repair or replacement, at Fabtech option, of the defective product only. All costs of removal, installation or re-installation, freight charges, incidental or consequential damages are expressly excluded from this warranty. Fabtech is not responsible for damages and/or warranty of other vehicle parts related or non related to the installed Fabtech product. This warranty is expressly in lieu of all other warranties expressed or implied. This warranty shall not apply to any product that has been subject to accident, negligence, alteration, abuse or misuse as determined by Fabtech.

Fabtech suspension components must be installed as a complete system including shocks as shown in our current catalog. All warranties will become void if Fabtech parts are combined and/or substituted with other aftermarket suspension products. Combination and/or substitution of other aftermarket suspension parts may cause premature wear and/or product failure resulting in an accident causing injury or death. Fabtech does not warrant products not manufactured by Fabtech.

Installation of Fabtech product may void the vehicles factory warranty; it is the consumer's responsibility to check with their local vehicle's dealer for warranty disposition before the installation of the product.

It is the responsibility of the distributor and/or the retailer to review all warranties and warnings of Fabtech products with the consumer prior to purchase.

Fabtech reserves the right to supercede, discontinue, change the design, finish, part number and, or application of parts when deemed necessary without written notice. Fabtech is not responsible for misprints or typographical errors within the catalog or price sheet.