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## **INSTALLATION INSTRUCTIONS**

### **G.M. RETRO FIT IDLER ARM & PITMAN ARM KIT**

**2001-2006 Chevy 2500HD & 2500 Suburban**  
**FTS71003R Retro Fit Idler Arm & Pitman Arm Kit**

#### **PARTS LIST:**

<b>Qu a</b>	<b>Part #</b>	<b>Description</b>
1	FT20258	Stock GM 2500HD Idler Arm
1	FT20259	Stock GM 2500HD Pitman Arm
2	FT71003Ri	Retro Instructions
1	FT71003Ri-1	Part Process Info / Shipping Label
1	FTBOX3	Return Box

#### **READ THE FOLLOWING BEFORE BEGINNING INSTALLATION**

DO NOT ALTER THE FINISH OF THESE COMPONENTS, EXAMPLE- CHROMING, ZINC PLATING OR PAINTING. CHANGING THE FINISH CAN CAUSE STRUCTURAL FATIGUE OF COMPONENTS.

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.

READ ALL INSTRUCTIONS THOROUGHLY FROM START TO FINISH BEFORE BEGINNING INSTALLATION! IF THESE INSTRUCTIONS ARE NOT PROPERLY FOLLOWED, SEVERE FRAME, SUSPENSION AND TIRE DAMAGE MAY RESULT TO THE VEHICLE.

VEHICLES THAT WILL RECEIVE OVERSIZED TIRES SHOULD CHECK BALL JOINTS, TIE RODS ENDS AND IDLER ARM EVERY 2500-5000 MILES FOR WEAR AND REPLACE AS NEEDED.

#### **Tool List: (NOT INCLUDED)**

- Floor Jack & Jack Stands
- Assorted Metric & S.A.E Sockets & Allen Wrench's
- Torque Wrench
- Pitman Arm Puller
- Grease Gun with Grease

## **INSTALLATION INSTRUCTIONS**

1. Disconnect the negative terminal on the battery. Jack up the front end of the truck and support the frame rails with jack stands. Remove the front tires.  
**NEVER WORK UNDER AN UNSUPPORTED VEHICLE!**
2. Locate the Fabtech steering stabilizer and remove from the Fabtech brackets. Save the stabilizer and all of the hardware.
3. Disconnect both driver and passenger tie rod ends from the steering knuckles and save the hardware.
4. Locate the Idler Arm on the passenger side of the frame where it is connected to the center link. Remove the nut attaching the Idler Arm to the center link. Discard the hardware. Using a Tie Rod End Separating tool, remove the Idler Arm from the center link.
5. Locate the two bolts attaching the Idler Arm assembly to the frame. Remove the bolts and save. Remove the Idler Arm assembly from the truck. Remove the nut attaching the Idler Arm frame mount to the Idler Arm. Using a Tie Rod End Separating tool, remove the Idler Arm from the assembly. Save the frame mount for reinstallation and Idler Arm to send back to Fabtech.
6. Locate the pitman arm on the driver side of the truck, remove the nut attaching it to the center link and discard it. Using a Tie Rod End Separating tool, separate the center link from the pitman arm. Remove the center link from the truck and save.
7. Loosen the nut attaching the pitman arm to the steering box. Locate the three bolts attaching the steering box to the frame, remove the two lower bolts and **LOOSEN** the top bolt only. This will allow the steering box to rotate upward toward the rear of the truck allowing access to the pitman arm itself. **USE CARE TO NOT DAMAGE THE JOINT ON THE STEERING BOX STEERING LINKAGE WHEN ROTATING THE STEERING BOX.**
8. Remove the nut attaching the pitman arm to the steering box and save along with the original washer. Using a Heavy Duty pitman arm puller, remove the Fabtech pitman arm from the truck. Save the Pitman arm to send back to Fabtech.
9. Locate the new FT20258 Idler arm. Attach the new Idler Arm to the previously removed Idler Arm frame mount using the original hardware. Torque to 70 ft lbs. Using a grease gun, grease the two grease fittings in the idler arm and the frame mount. SEE PHOTO IN NEXT COLUMN.
10. Attach the Idler Arm assembly to the original frame mount using the original hardware. Leave Loose at this time.
11. Locate the new FT20259 Pitman Arm. Attach the Pitman Arm to the factory steering box using the original hardware and torque to 184 ft. lbs. **WHEN INSTALLING THE NEW PITMAN ARM TO THE STEERING BOX, MAKE SURE THE NEW PITMAN ARM IS POSITIONED IN THE SAME WAY THE ORIGINAL PITMAN ARM WAS.** Using a grease gun, grease the grease fitting on the pitman arm.
12. Re-attach the factory steering box to the frame using the original hardware. Torque to 95 ft. lbs.
13. Locate the factory center link and connect it to the new Idler Arm and Pitman Arm using the new supplied nuts. Torque both Idler Arm and Pitman Arm bolts to 46 ft lbs. Insert the supplied cotter pin.
14. Torque the Idler Arm frame mount bolts to 70 ft. lbs.
15. Locate Fabtech steering stabilizer and re-install back into the Fabtech brackets as it was removed. SEE DIAGRAM ON LAST PAGE FOR REFERENCE.
16. Reconnect the tie rod ends to the steering knuckles and torque to 50 ft. lbs.
17. Using a grease gun, grease all the grease fittings on the Idler Arm and Pitman Arm if you have not done so already.
18. With both sides of the truck completely finished and the truck still off the ground, cycle the steering left to right from stop to stop. Make sure there is plenty of clearance between the ABS line and all other components.
19. Reinstall the tires onto the truck and torque the lugs to factory specifications, which can be found in the owner's manual. Set the truck back on the ground and cycle the steering left to right from stop to stop. Make sure there is plenty of clearance between the ABS line and all other components.
20. **Complete a full front-end alignment on the truck!**

## **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.

Coil over 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.

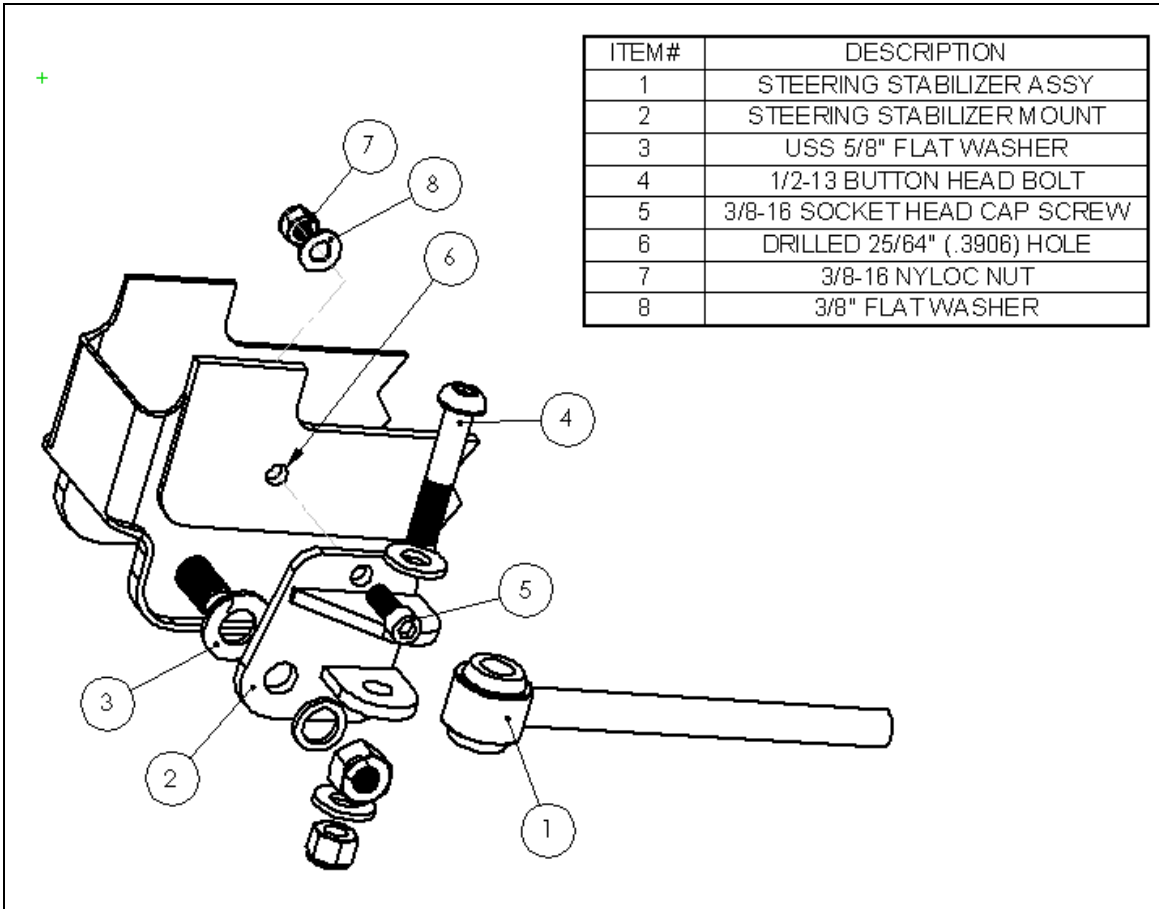
Fabtech's obligation under this warranty is limited to the repair or replacement, at Fabtech option, of the defective product only. All costs of removal, installation or re-installation, freight charges, incidental or consequential damages are expressly excluded from this warranty. Fabtech is not responsible 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.



**Frame Bracket Assembly**