

# ***Baja Customs***

## **Install Instructions BC-5063 Trac-inator 2017+ Ford, F250, F350 4x4**

**Warning:** Baja Customs recommends professional automotive knowledge when installing this kit to avoid possibility of injury or damage.

Notice: After installation of this kit a wheel alignment may be required. Check and maintain proper tire air pressure. Steering stabilizers are recommended for trucks running larger than stock tires. A trac-bar drop bracket is required for any lift over 4 inches.

### **Tools Required**

- Ball-joint pickle fork, large
- 30mm, 1-1/8in, 1-5/8in, socket and wrench sizes

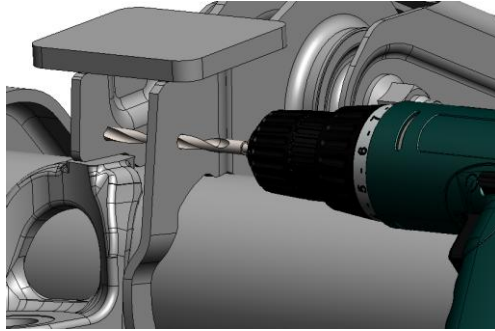
### **Instructions:**

1. Before removing the stock trac-bar, record a measurement from the center of the ball joint mount to the center of the bushing frame mount, or any horizontal location on the axle to the frame. (This measurement will help you in step 10, adjust the Trac-inator close to your stock trac-bar length and keep the axle centered under the frame).
2. Begin by removing the stock trac-bar at the axle balljoint mount first. Remove the ball-joint nut and use a large pickle fork to release the balljoint from the axle.
3. Remove the stock bolt and nut from the trac-bar frame mount. Remove the stock trac-bar.

**Note:** Tie-downs attached to the axle and frame may be necessary to prevent the axle from shifting after removing the bar, this will aid when installing the new bar.



4. Locate the 1/4" hole below the bump stop plate. Using this hole as a guide, with a 1/4" drill bit, drill a hole opposite of this hole through the other side plate. Next drill both holes out to a size of a 1/2".



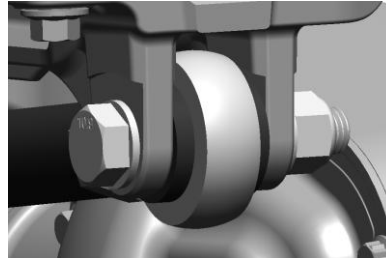
5. Thread the 1.25" Jam nuts onto the 1.25" Heim Joint shafts, if not already done so. Thread the 1.25" heim joints into the end of the bar, leaving approximately 1/4" of thread exposed between the jam nut and heim joint. **Note: The bar has both left and right hand threads, the end closest to the bend is the left hand thread side.**



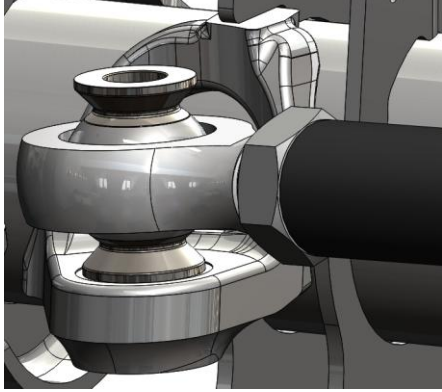
6. The right handed Heim joint goes on the frame side of the bar. Insert the Heim spacers into the Heim joint. Place the rubber isolators over the Heim spacers with the angled side towards the ball.



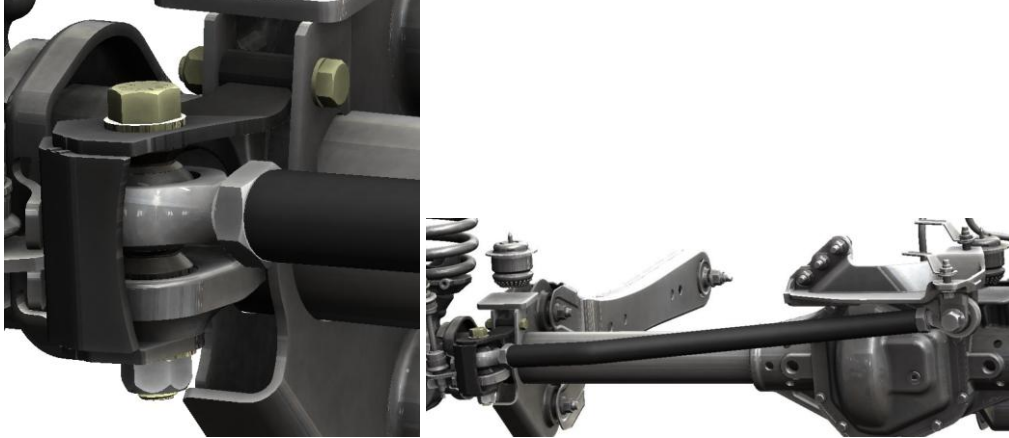
7. Install the right handed Heim joint and spacers into the trac-bar frame mount and insert the provided M20 bolt with washers on either end. Tighten but do not torque the bolt yet. **Note: If you have a Fabtech frame mount you may need to clearance the mount to fit the Heim joint correctly.**



8. Insert the high-miss spacers into the left handed Hiem joint. Place the tapered spacer end into the axle mount hole.



9. Place the support bracket over the Hiem assembly and into the bump stop plates. Insert the 1/2" bolt through the bump stop plate and bracket. Insert the 3/4" bolt thru all, with washers on either end. Tighten but don't torque the bolts yet.



10. Using the same measurement locations as you did in step 1, measure the points again. Adjust the length of the bar by turning the bar right to shorten or left to lengthen, try to match your measurement in step one.
11. Once the bar is adjusted correctly tighten all the nuts and bolts including the jam nut on the heim joint. Torque the trac-bar frame mount bolt to 350ft.lbs. and the trac-bar axle mount bolt to 300ft.lbs.
12. Take the truck to a good alignment shop, and re-torque the bolts after 1k miles.

***Hiem Replacement Part Numbers:***

Right hand threaded Hiem joint: P8DMR16T-F1

Left hand threaded Hiem joint: P8DML16T-F1

For technical assistance call: 949-229-0696 or email: [info@bajacustoms.com](mailto:info@bajacustoms.com)