

# KPC 4LBO-F71 97-03 FORD F-150 BOLT ON 4-LINK

## INSTALLATION INSTRUCTIONS

1. Jack the vehicle and support it with stands under the frame on all four corners. The suspension must be left handing.
2. Remove the bed and rear bumper.
3. Remove the rear sway bar (if applicable) and the rear shocks.
4. Support the rear axle to facilitate removal of the leaf springs. (cargo straps work well for this) Figure 1.
5. Remove and discard the factory U-bolts and the bolts securing the leaf springs to the hangers.
6. Remove and discard the rear leaf springs leaving the axle hanging in the cargo straps.
7. Remove and discard the forward and rear factory leaf spring brackets.
8. Install the forward 4-link brackets where the forward leaf spring brackets were (using the existing rivet holes left empty in step 7) with the supplied hardware, eight  $\frac{1}{2}$ " x  $1\frac{1}{4}$ " bolts, eight  $\frac{1}{2}$ " flat washers (place between the frame and the nuts) and eight  $\frac{1}{2}$ " locking nuts. Figure 2.
9. Install the rear 4-link brackets on the axle as shown in Figure 3 with the supplied U-bolts, black  $\frac{9}{16}$ " washers and black  $\frac{9}{16}$ " nuts. Torque U-bolt nuts to 120 lbs.  
Note: The axle bracket with the panhard bar attachment installs on the passenger's side.
10. Assemble the 4-link bars and ends by installing the urethane bushings, steel sleeves, and jam nuts. Then screw the adjustable ends into the bars. The heim end is for the panhard bar. Figure 4 A and B. Caution: All 4-link steel sleeves have an inner diameter of  $\frac{1}{2}$ ". All cantilever steel sleeves have an inner diameter of  $\frac{9}{16}$ ".
11. Install the nonadjustable ends of the 4-link bars into the rear 4-link brackets using four  $\frac{1}{2}$ " x 3" bolts and four  $\frac{1}{2}$ " locking nuts.  
Note: These four bolts must be installed from the center of the truck out to avoid hitting the frame.
12. Install the adjustable ends of the 4-link bars into the forward brackets using four  $\frac{1}{2}$ " x 3" bolts and four  $\frac{1}{2}$ " locking nuts.  
Note: Route your emergency brake cable between the upper and lower 4-link bars on your driver's side.
13. Attach the adjustable (heim) end of the pre-assembled panhard bar to the passenger side axle bracket as shown in Figure 5. Using one  $\frac{3}{4}$ " x  $2\frac{1}{2}$ " bolt, one  $\frac{3}{4}$ " flat washer, and one  $\frac{3}{4}$ " locking nut.
14. Attach the "panhard to frame" bracket to the nonadjustable end of the panhard bar using one  $\frac{1}{2}$ " x 3" bolt and one  $\frac{1}{2}$ " locking nut. Figure 6.
15. Temporarily place the pan hard bar frame mount inside the frame rail. You'll want the angle of the pan hard bar to keep the bar appx. 1 inch away from the differential. (If you're running a step notch, this might require you trimming the notch to make room for the pan hard bar frame bracket). Mark or punch the mounting holes prior to drilling.
16. Drill two  $\frac{1}{2}$ " holes and the install the frame mount using two  $\frac{1}{2}$ " x  $1\frac{1}{2}$ " bolts, flat washer, and  $\frac{1}{2}$ " locking nuts. Figure 7.  
Note: If you're installing a KP Components cantilever system, the pan hard bar frame mount will utilize the two forward mounting holes on the cantilever bracket.
17. Now install your bed and rear bumper and your installation is complete.

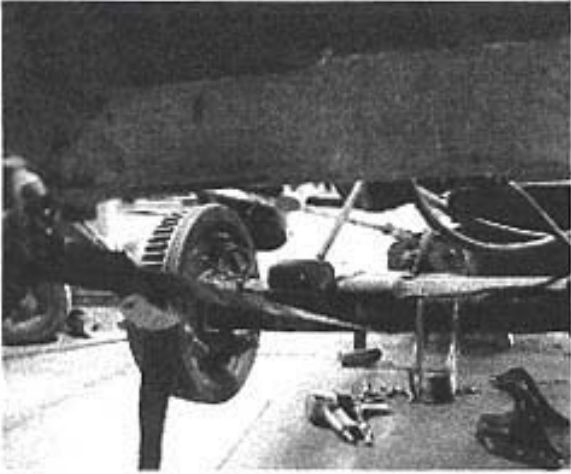


Figure 1

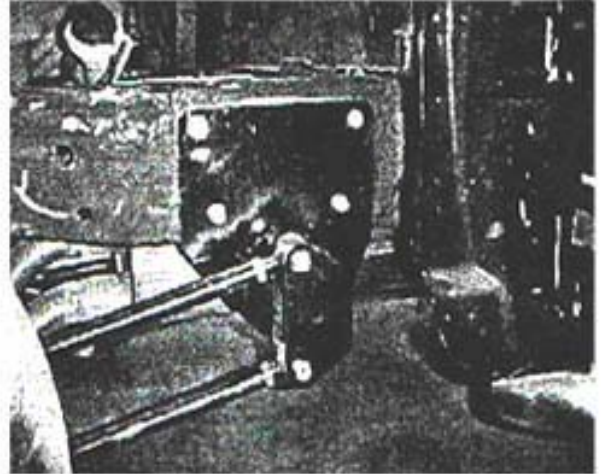


Figure 2

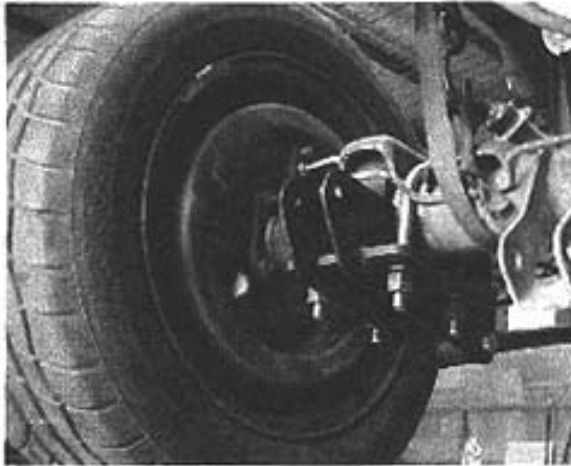


Figure 3

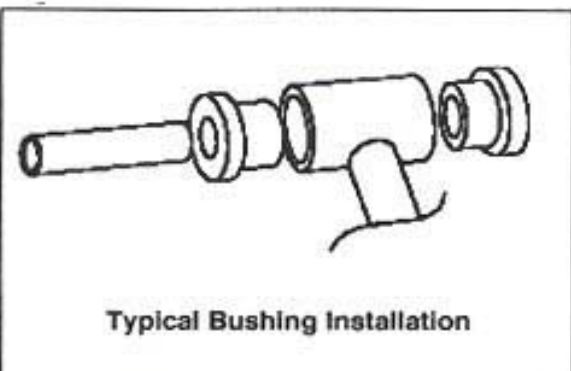


Figure 4A



Figure 4B

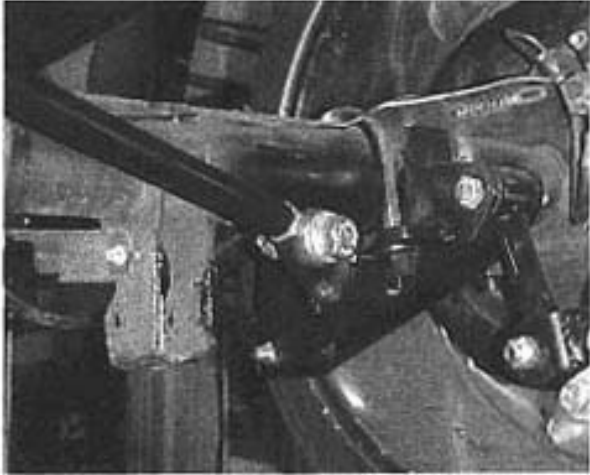


Figure 5

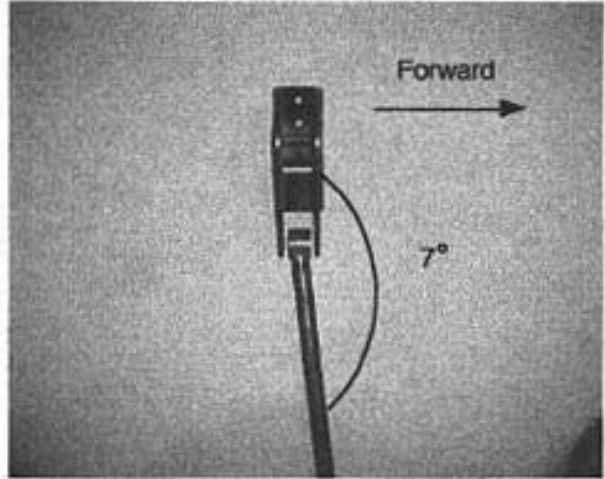


Figure 6

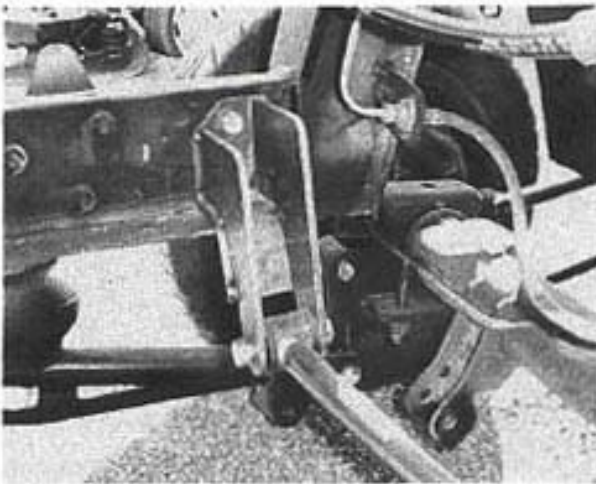
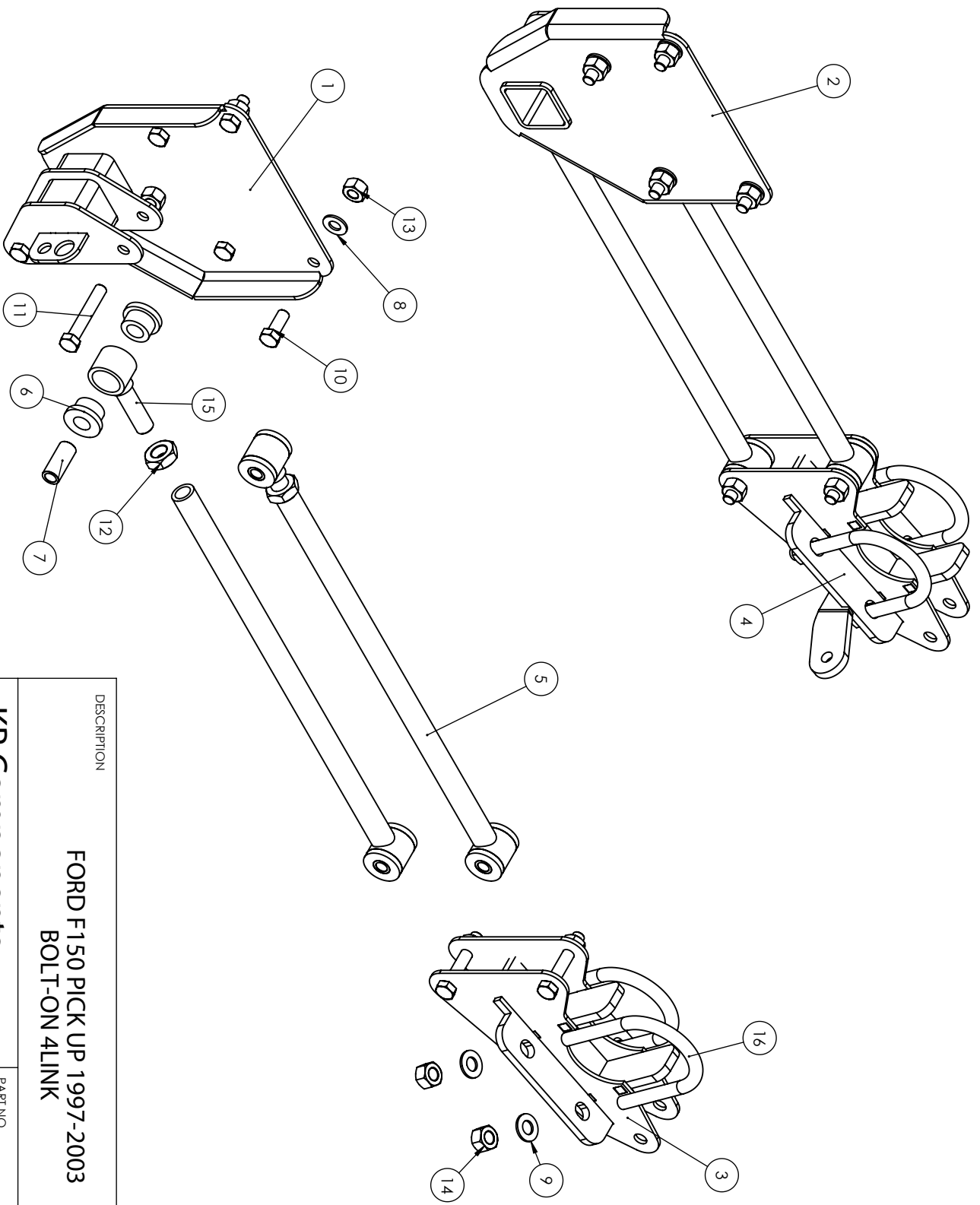


Figure 7



DESCRIPTION

**FORD F150 PICK UP 1997-2003**

**BOLT-ON 4LINK**

**KP Components**

8661 Younger Creek Drive  
 Sacramento, CA 95828  
 KPtech@cachassisworks.com

PART NO  
**KPC 4LBO-F71**

SHEET 1 OF 2

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	BO4L-04-07	97-02 FORD F150 PICK UP FRONT 4LINK DRIVER SIDE BRACKET ASSEMBLY	1
2	BO4L-04-09	97-02 FORD F150 PICK UP FRONT 4LINK PASSENGER SIDE BRACKET ASSEMBLY	1
3	BO4L-04-12	97-02 FORD F150 PICK UP 4LINK DRIVER SIDE AXLE BRACKET ASSEMBLY	1
4	BO4L-04-13	97-02 FORD F150 PICK UP 4LINK PASSENGER SIDE AXLE BRACKET ASSEMBLY	1
5	BO4L-04-16	97-02 FORD F150 PICK UP 4LINK PARALLEL BAR ASSEMBLY	4
6	BP-1	SHORT POLY BUSHING	16
7	BS-1	.5000 ID X .7500 OD X 1.7500 LONG SLEEVE	8
8	FW 0.5	1/2" FLAT WASHER	8
9	FW 0.5625	9/16" FLAT WASHER	8
10	HF BOLT 0.5-20X1.25X1.25-N	1/2"-20 X 1 1/4" FINE THREAD G8 BOLT	8
11	HF BOLT 0.5-20X3X1.25-N	1/2"-20 X 3" FINE THREAD G8 BOLT	8
12	HHJNUT 0.7500-16-D-N	3/4"-16 RIGHT HAND JAM NUT	4
13	HHNUT 0.5000-20-D-N	1/2"-20 FINE THREAD SELF LOCKING NUT	16
14	HHNUT 0.5625-18-D-N	9/16" U-BOLT NUT	8
15	RE 01	THREADED ROD END	4
16	UB 325	3.25" U-BOLT	4

DESCRIPTION  
**97-03 FORD F150 PICK UP BOLT-ON 4LINK  
BILL OF MATERIALS**

**KP Components**

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Sacramento, CA 95828  
KPrech@cachassisworks.com

PART NO  
**KPC 4LBO-F71**

SHEET 2 OF 2

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