

# INSTALLATION GUIDE



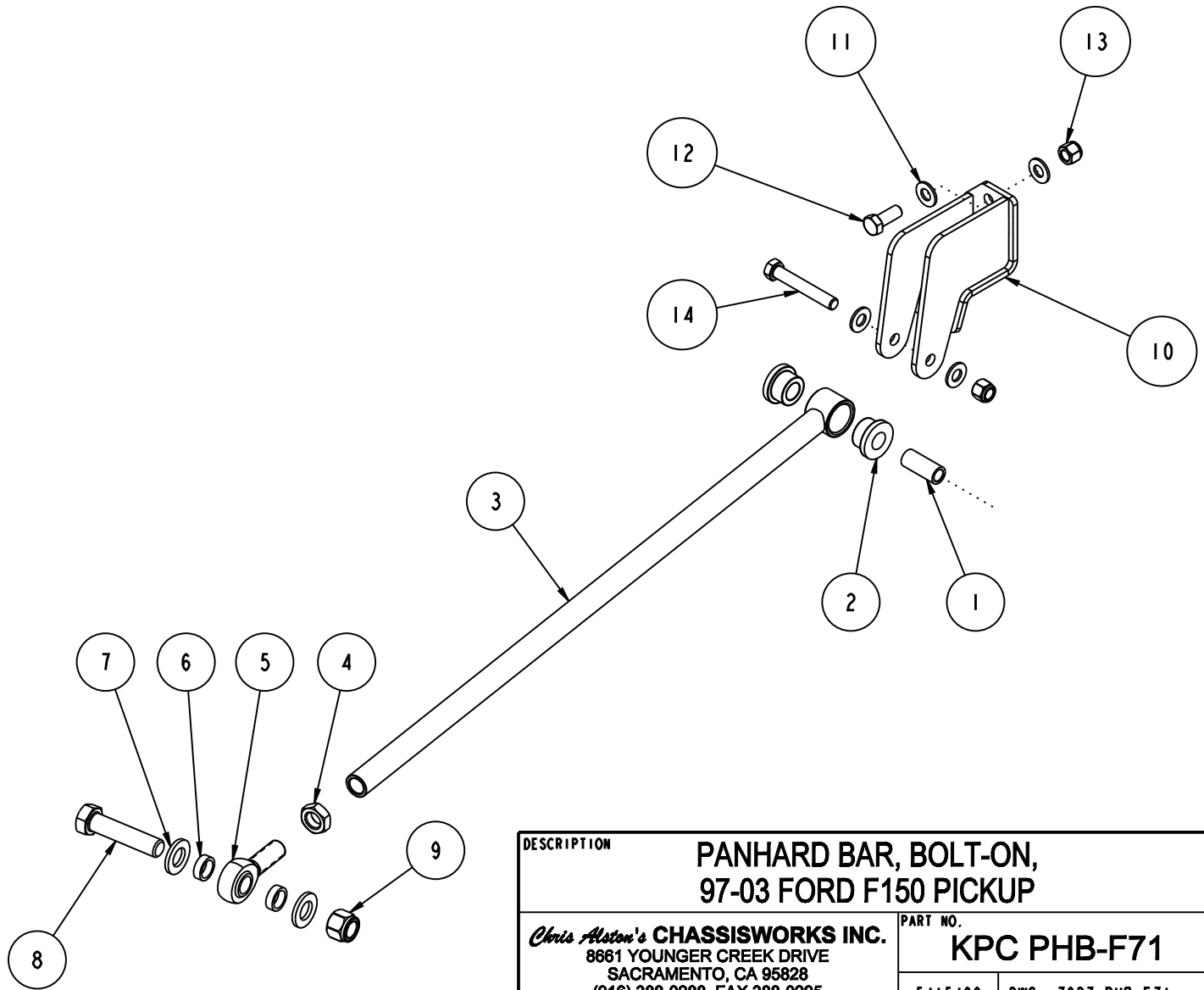
## KPC PHB-F71

**Bolt-On Panhard Bar  
1997-2003 Ford F150 Pickup**



**Description:** Bolt-on, urethane-bushed panhard bar for 1997-2003 Ford F150 pickup. Includes bolt-on frame bracket, adjustable-length link, urethane end bushings, and mounting hardware. Axle mount tab is part of KP 4-link bracket weldment.

ITEM	QTY	PART NO.	DESCRIPTION
1	1	3140-1624-056	SLEEVE, POLY BUSHING, $\varnothing 3/4 \times .50 \times 1.750$
2	2	3141-2440-0.88	POLYURETHANE BUSHING 1.63 x .750 x .750
3	1	7935-002	PANHARD BAR WELD, 9° x 1 5/8 32.987 LONG x 3/4-16 THREAD
4	1	3102-075-16RC	JAM NUT, 3/4-16 RIGHT, CLEAR ZINC
5	1	3111-075X075-RT	ROD END, 3/4-16 RIGHT x 3/4 BORE, TEFLON, MTM-12
6	2	D16.120-000.313	CUT TUBE, $\varnothing 1 \times .120$ WALL DOM x .313
7	2	3157-075S-C	WASHER, 3/4 SAE, ZINC PLATED, 13/16 ID x 1 15/32 OD x 5/32 THICK
8	1	3100-075F3.25Y	HEX BOLT, 3/4-16 x 3 1/4, GRADE 8, YELLOW ZINC
9	1	3101-075-16C	LOCKNUT 3/4-16, GRADE 5, NYLON INSERT, CLEAR ZINC
10	1	7935-011	PANHARD FRAME BRACKET ASSY, 97-03 FORD F150
11	6	3157-050S-C	WASHER, 1/2 SAE, ZINC PLATED, 1/2 ID x 1 1/16 OD x 3/32 THICK
12	2	3100-050C1.25Y	HEX BOLT, 1/2-13 x 1 1/4, GRADE 8, YELLOW ZINC
13	3	3101-050-13C	LOCKNUT 1/2-13, GRADE 5, NYLON INSERT, CLEAR ZINC
14	1	3100-050C3.25Y	HEX BOLT, 1/2-13 x 3 1/4, GRADE 8, YELLOW ZINC



DESCRIPTION		PANHARD BAR, BOLT-ON, 97-03 FORD F150 PICKUP	
Chris Alston's CHASSISWORKS INC. 8661 YOUNGER CREEK DRIVE SACRAMENTO, CA 95828 (916) 388-0288 FAX 388-0295		PART NO. <b>KPC PHB-F71</b>	
		5/15/09	DWG: 7927-PHB-F71

# PARTS LIST

## KPC PHB-F71 - Bolt-on Panhard Bar, '97-03 F150

Qty	Part Number	Description
1	7935-005	Panhard bar frame bracket
1	7935-007	Panhard bar weldment 36-1/4" OAL

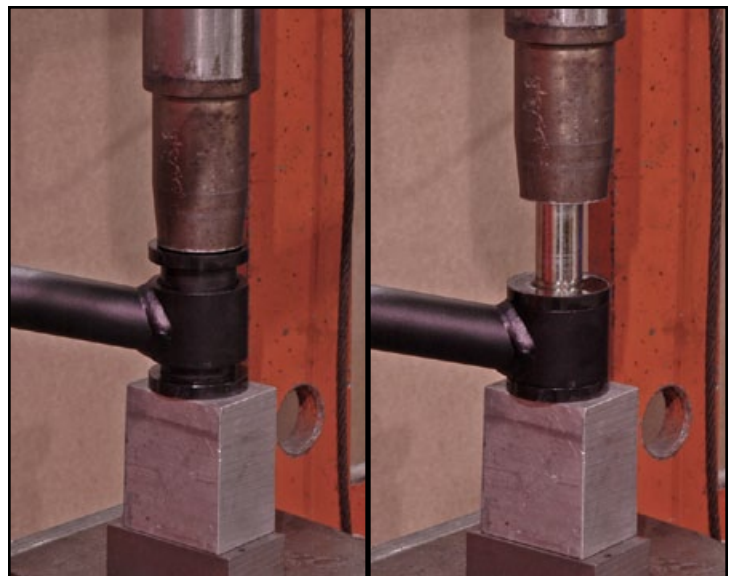
## 7926-PHBF71 - Hardware Bag

Qty	Part Number	Description
2	3100-050C1.25Y	Bolt 1/2-13 x 1-1/4" hex cap screw Grade 8
1	3100-050C3.25Y	Bolt 1/2-13 x 3-1/4" hex cap screw Grade 8
1	3100-075F3.25Y	Bolt 3/4-16 x 3-1/4" hex cap screw Grade 8
3	3101-050-13C	Locknut 1/2-13 nylon insert
1	3101-075-16C	Locknut 3/4-16 nylon insert
1	3102-075-16RC	Jam nut 3/4-16 clear zinc
1	3111-075x075-RT	Rod end 3/4 x 3/4-16 RH, Teflon
1	3140-1624-056	Sleeve 1/2 ID x 3/4 OD x 1-3/4" long for poly bushing
2	3141-2440-0.88	Poly bushing .75 bore x .875" OAL
1	3151-1/2OZ	Poly lube 1/2 oz. cup
6	3157-050S-C	Washer 1/2" SAE flat
2	3157-075S-C	Washer 3/4" SAE flat
2	D16.120-000.313	Spacer 1" OD x 3/4" ID x .313" inches long

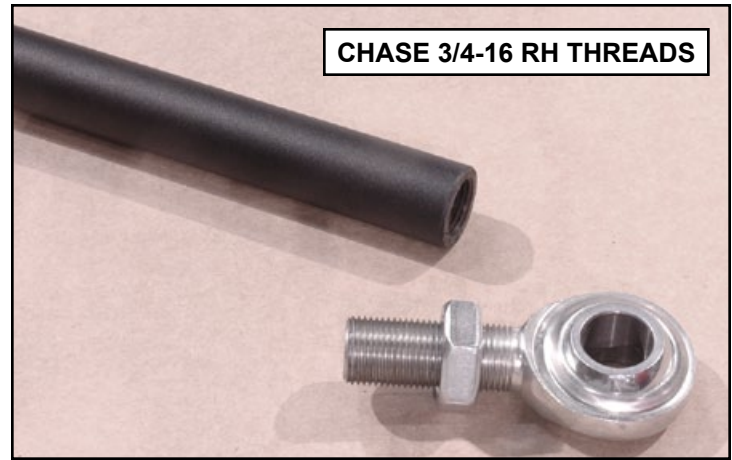
# INSTRUCTIONS

*The 4-link suspension must be installed and the axle housing positioned at ride height before beginning installation.*

1. Press the poly bushings into both sides of the pivot link until they are fully seated.
2. Apply a small amount of poly lube to the outside of the 1-3/4" sleeve and press it into the bushings until centered.



3. Use a 3/4-16 right-hand tap and die to chase the panhard bar female threads and rod end male threads.
4. Thread the jam nut onto the rod end until there are 5-7 threads between the jam nut and the rod-end bearing housing.
5. Apply a small amount of anti-seize to the rod-end threads and screw it into the panhard bar until the jam nut contacts the tube.
6. Insert the urethane-bushed end of the panhard bar into frame bracket and secure with the 1/2-13 x 3-1/4" hex bolt, flat washers, and locknut. There must be a flat washer under the bolt head and locknut. The panhard bar must angle toward the front of the truck.
7. Verify that the axle housing is at ride height before centering the housing relative to the frame.
8. Using a straight-edge along the axle flange, measure from the frame rail to the straight-edge.
9. Record and compare the measurements from each side of the vehicle.
10. Shift the axle housing so that both measurements are equal and the housing is centered between the frame rails.
11. Attach the panhard bar rod end to mounting tab on the passenger side axle bracket.
12. Secure the rod end to the tab with a 3/4-16 x 3-1/4" hex bolt, two 1/4" wide spacers, two flat washers, and a locknut. There must be one spacer on each side of the rod end and flat washers under the bolt head and locknut.
13. Move the axle through its complete range of travel to check for binding. Correct any issues before continuing.
14. Use a 1/2" bit to drill the two holes in the frame, using the panhard-bar bracket as a guide. Drill one hole at a time.
15. Install the 1/2-13 x 1-1/4" hex bolt, flat washers, and locknut in each hole as drilled.
16. Verify that the housing is still centered at ride height, then tighten the jam nut and mounting bolt on the rod end side of the panhard bar.



**WARRANTY NOTICE:**

There are NO WARRANTIES, either expressed or implied. Neither the seller nor manufacturer will be liable for any loss, damage or injury, direct or indirect, arising from the use or inability to determine the appropriate use of any products. Before any attempt at installation, all drawings and/or instruction sheets should be completely reviewed to determine the suitability of the product for its intended use. In this connection, the user assumes all responsibility and risk. We reserve the right to change specification without notice. Further, Chris Alston's Chassisworks, Inc., makes **NO GUARANTEE** in reference to any specific class legality of any component. **ALL PRODUCTS ARE INTENDED FOR RACING AND OFF-ROAD USE AND MAY NOT BE LEGALLY USED ON THE HIGHWAY.** The products offered for sale are true race-car components and, in all cases, require some fabrication skill. **NO PRODUCT OR SERVICE IS DESIGNED OR INTENDED TO PREVENT INJURY OR DEATH.**

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