



1999-2004 Ford F250 & F350 4WD  
 1980-1998 Ford F250 & F350 4WD IFS  
 1977.5-1979 Ford F250 4WD  
 2000-2005 Ford Excursion 4WD

# F35G, # F46D & # F9320

## Front Add-A-Leaf Installation Instructions



### Required Tools List:

- SAE Sockets \ Wrenches
- Metric Sockets \ Wrenches
- Cut-Off Tool or Hacksaw
- Adjustable Locking Pliers
- Alignment Bar or Screwdriver
- C-Clamps
- Wheel Chock
- Jack Stands
- Torque Wrench
- Safety Glasses
- Floor Jack
- Measuring Tape

Before beginning installation, read these instructions & enclosed driver's WARNING NOTICE thoroughly & completely. Also affix WARNING decal in passenger compartment in clear view of all occupants. Please refer to Parts List to insure that all parts & hardware are received prior to disassembly of vehicle. If any parts are found to be missing, contact SKYJACKER® Customer Service at 318-388-0816 to obtain needed items. If you have any questions or reservations about installing this product, contact SKYJACKER® Technical Assistance at 318-388-0816.

**Please Record the Important Measurement Information Below for Reference.**

**It is very helpful on determining an Accurate Achieved Lift Height Measurement.**

Make sure you park vehicle on a level concrete or asphalt surface. Many times a vehicle is not level (side-to-side) from factory, but is usually not noticed until a lift kit has been installed which makes difference more visible. Using a measuring tape, measure front & rear (both sides) from ground up to center of fender opening above axle.

Driver Side Front: _____ / _____ BEFORE / AFTER	Passenger Side Front: _____ / _____ BEFORE / AFTER
Driver Side Rear: _____ / _____ BEFORE / AFTER	Passenger Side Rear: _____ / _____ BEFORE / AFTER

### Important Notes:

- PRIOR to Disassembly, Check U-Bolt Length on Your Vehicle. Longer U-Bolts May Be Required.

**Installation: Note: Save all factory components & hardware for reuse, unless noted.**

1. Chock rear tires \ wheels.  
Raise vehicle & support frame rails using jack stands at indicated lift points in OEM service manual. (Jack stands generally are placed just behind front springs rear mounts.)
2. Remove front tires \ wheels.
3. Place a floor jack underneath front axle for support. Put a slight load on axle \ jack to prevent axle from moving. Allow ample room to lower axle.
4. Remove OEM shocks.

5. Remove OEM u-bolts. Retain u-bolts \ hardware & u-bolt plate.
6. While checking for appropriate slack in brake lines, sway bar, differential breather hose, & etc, lower axle several inches away from leaf springs.

Note: **Perform Steps 7-11 on One Side at a Time.**

7. Loosen OEM leaf spring mounts. Loosen front spring eye bolt. Loosen rear spring eye bolt. Loosen rear shackle eye bolt.

**Note:** Installation of Skyjacker Add-A-Leafs properly, you must use two (2) large C-clamps to contain elastic potential energy of OEM rear leaf springs when OEM tie bolts are being removed. **Tech Note:** Spray a good penetrating oil onto each tie bolt to help loosen nut.

Attach C-clamp on each side of OEM leaf spring center tie bolt to hold leaf spring assembly securely together. Tighten C-clamp equally on each side. (See Photo # 1)

**Tech Note:** If bend clips \ straps that hold OEM leaf spring pack together must be disturbed, do these first, then remove the spring center bolt.

Use locking pliers to hold head of OEM tie bolt. Use a wrench to loosen & remove nut. Remove tie bolt.

8. Carefully & slowly loosen C-clamps equally on each side until leaf spring expands completely. Remove C-clamps.

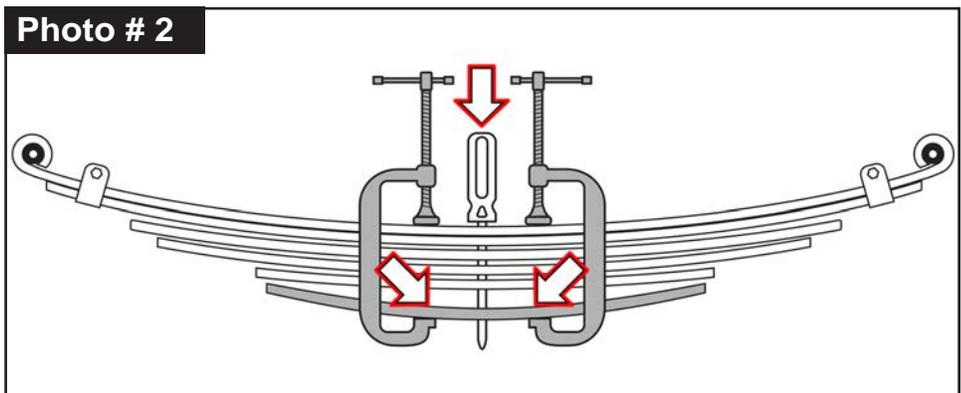
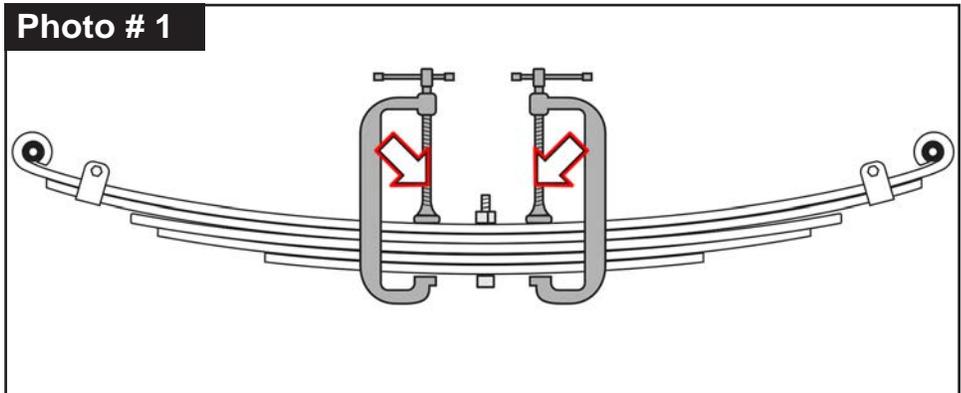
Install Skyjacker Add-A-Leaf onto “bottom” of OEM leaf spring. (See Photo # 2)

**Tech Note:** If installing more than one leaf per side, install longest first, then shortest.

Center pin is offset, match long \ short end of add-a-leaf to OEM leaf spring offset.

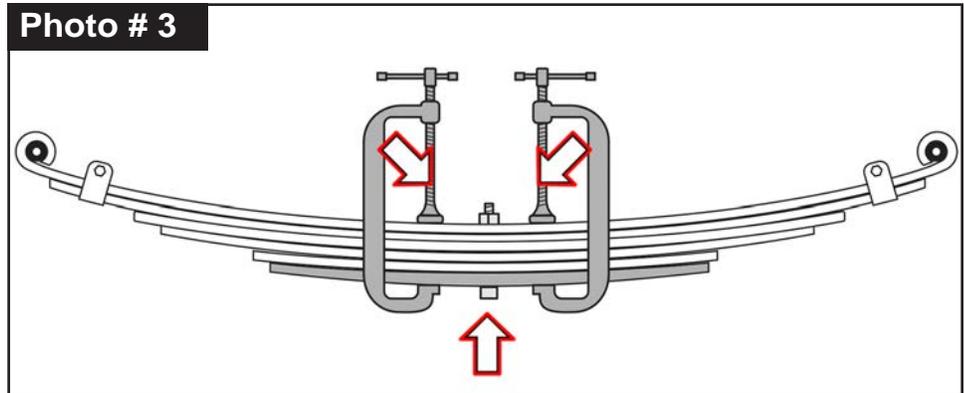
**Tech Note:** Lower rear axle as needed to allow add-a-leaf to be installed.

9. Attach C-clamp on each side of tie bolt hole to hold leaf spring assembly. (See Photo # 2)  
Use an alignment bar \ screwdriver to line up tie bolt hole in leaf spring pack. It is recommended to leave the alignment bar \ screwdriver in to help keep the leaves aligned as you tighten the C-clamps.



**CAUTION: Do Not Use Skyjacker Tie Bolts to Draw OEM Leaf Springs Together. Failure of Any Component Can Cause an Explosive Disassembly & Possible Injury!**

10. Tighten C-clamps equally on each side until leaf spring compresses enough to install supplied Skyjacker tie bolt up through bottom of leaf spring. (See Photo # 3) With tie bolt installed, tighten nut by hand. Then continue to tighten C-clamps.



11. Once C-clamps have drawn leaves securely together, use locking pliers to hold tie bolt head & tighten tie bolt nut with a wrench. **Caution:** Do not use an air gun to tighten tie bolt. An air gun could strip or over torque \ stretch tie bolt.

**Torque Specifications:**

3/8" Tie Bolt	= 17 ft lbs.
7/16" Tie Bolt	= 27 ft lbs.
1/2" Tie Bolt	= 41 ft lbs.

**Note:** Make sure individual leaves are all in-line with each other. If applicable, re-form bend clips \ straps or install new bend clips. If heat is used on straps, allow straps to cool naturally & thoroughly before removing the C-clamps.

Remove C-clamps. Cut off any excess tie bolt length with cut-off tool or hacksaw.

**Note: Perform Steps 7-11 on Opposite Side at This Time, Then Proceed to Step 12.**

12. Clean spring pads of all debris. Raise axle to mate leaf springs axle pad.  
**Note:** Be sure that leaf spring center bolt head seats properly into top of axle pad.
13. Install OEM U-bolts \ hardware & OEM u-bolt plate. Tighten u-bolts evenly using an 'X' crisscross tightening sequence. Torque to OEM specifications.
14. Install OEM shocks. Secure, but **Do Not Completely Tighten.**
15. Install tires \ wheels. Lower vehicle to ground. Torque lugs to OEM service manual specifications.

**Final Clearance Check & Torque Steps:**

1. Jounce vehicle a couple of times. This will help suspension settle to new ride height. Cycle steering lock-to-lock & check all components for proper operation & clearances. Pay special attention to clearance between tires \ wheels, shocks, brake hoses, ABS wiring, etc.
2. **Tighten & Torque Sequence.**  
Tighten Shock Bushings until bushing starts to swell slightly.  
Tighten Leaf Springs in this sequence:  
Front spring eye bolt. Rear spring eye bolt. Shackle eye bolt.

## **Final Notes:**

- After installation is complete, double check that all nuts & bolts are tight. Refer to following chart for proper torque specifications.
- With vehicle placed on ground, cycle steering lock to lock & inspect steering, suspension, brake lines, front & rear drivelines, fuel lines & wiring harnesses for proper operation, tightness & adequate clearance.
- Have headlights readjusted to proper settings.
- Have a qualified alignment center align vehicle to OEM specifications.
- After first 100 miles, check all hardware for proper torque & periodically thereafter.

<b>TORQUE SPECIFICATIONS</b>					
<b>INCH SYSTEM</b>			<b>METRIC SYSTEM</b>		
<b>Bolt Size</b>	<b>Grade 5</b>	<b>Grade 8</b>	<b>Bolt Size</b>	<b>Class 8.8</b>	<b>Class 10.9</b>
5/16	180 in-lbs	240 in-lbs	6MM	60 in-lbs	108 in-lbs
3/8	30 ft-lbs	35 ft-lbs	8MM	216 in-lbs	23 ft-lbs
7/16	45 ft-lbs	60 ft-lbs	10MM	32 ft-lbs	45 ft-lbs
1/2	65 ft-lbs	90 ft-lbs	12MM	55 ft-lbs	75 ft-lbs
9/16	95 ft-lbs	130 ft-lbs	14MM	85 ft-lbs	120 ft-lbs
5/8	135 ft-lbs	175 ft-lbs	16MM	130 ft-lbs	165 ft-lbs
3/4	185 ft-lbs	280 ft-lbs	18MM	170 ft-lbs	240 ft-lbs

**The Above Specifications Are Not to Be Used  
When the Bolt Is Being Installed With a Bushing.**

**Seat Belts Save Lives, Please Wear Your Seat Belt.**