

## INSTALLATION INSTRUCTIONS:

### #5322, 5326, 5327 Torque Tamer Long Travel Traction Bar, 1966-77 Bronco



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#### CONTENTS:

1	Traction Bar Arm	1	1/2"-13 X 4 GR 8 Pltd Bolt
1	Cross Member, Main	2	1/2"-13 X 3 1/2" GR 8 Bolts
1	Cross Member, End	6	Urethane Bushings
2	Shackles	7	1/2" NC Nyloc Nuts
1	Axle Mount, Large	1	3/4" Nyloc Nut
1	Axle Mount, Small	1	3/4" X 2" GR 5 Bolt
6	1/2" SAE Washers	1	3/4" SAE Washer
1	3/4" Jam Nut	4	3/8" Self Tapping Screws
1	3/4" Rod End	3	Steel Sleeves
4	1/2"-13 X 4" GR 5 Pltd Bolts	12	USS 1/2" Washers

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If you purchased our DIY kit (#5322), please read the instructions in their entirety then install the DIY Torque Tamer. The main crossmember is bare and the shackle mounts are only tack welded in their correct position so you can move them if needed.

**NOTE: IF YOU CHOOSE TO MODIFY THE (#5322) DIY KIT, IT CANNOT BE RETURNED OR EXCHANGED.** The changes required are custom in nature and James Duff is not responsible for the final placement of parts your build requires. Make sure you use a qualified welder to finish welding the shackle mount on the main crossmember, the weld on axle mounts and any other modifications you make that require welding. Please contact tech@duffuff.com if you have any tech questions. Please read all instructions before beginning.

**NOTE: The 5326 & 5327 kit requires welding for installation unless the bolt on torque tamer bracket is purchased (#5329).** Some exhaust modifications may be needed, torque tamer will fit with Duff Exhaust System Part #3090, 3095, 3065, 3141 & 3142. If you're not using our exhaust system, then you must be mindful of how you route the exhaust. The Torque Tamer shares the same space where most custom built exhaust is ran.

**IMPORTANT: Do not install torque tamer #5322, #5326, or #5327 until your Bronco is complete & ready to drive. If you purchased the bolt on torque tamer bracket #5329 it can be installed at anytime.**

1. Measure from the forward edge of the under cab body mount below the seat platform 10 1/2" and make a mark, repeat this step for the other side. DO NOT measure from the rivet that holds the body mount on.

2. Orient the cross member so that shackle attachment point is facing rearward and to the driver side as shown in FIG 1.

3. Remove the tape & insert the Cross Member End into the Main Cross Member until the bare metal end is not exposed. center the main tube of the cross member on the mark you made on the frame, clamp the cross member in place.

4. Mock up the traction bar before drilling any holes. be sure the shackle is at the 12 o'clock position or no more than 20 degrees camped forward or rear of 12 o'clock.

5. once you're sure the mock up of the traction bar looks good, using the frame bracket as a guide mark the 4 side holes and drill 1/2" holes sideways through the frame and secure with the 1/2" X 4" GR 5 Bolts, 8 USS washers and Nyloc nuts.

6. Drill four 21/64" holes in the bottom of the frame using the holes in the cross member frame mounts as a guide. Secure the bottom four holes using the 3/8" Self Tapping screws and washers.

7. Install the urethane bushings in each eye end of the traction bar and cross member. Insert the steel sleeves into each of the bushing sets.

8. Thread the jam nut onto the rod end all the way, and then thread the rod-end into the threaded hole leaving about 1/8" of the threads exposed in the back of the traction bar.

9. Attach the shackles to cross-member so that the end with two holes is facing up using the 1/2" X 3 1/2" GR 8 Bolt and Nyloc nut.

10. Using the 3/4" X 2" GR 5 Bolt attach the Large Axle Housing Mount to the rod end on the outside of the arm. Secure with the Washer and 3/4" Nyloc Nut.

11. Attach the Small Axle Housing Bracket to the inside top of traction bar using the 1/2" X 4" GR 8 Bolt, Washer and Nyloc Nut. (See Fig. 1)

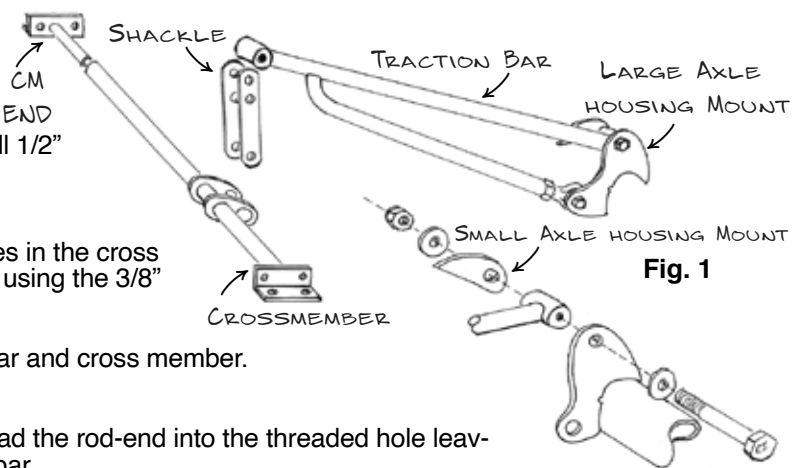
12. Loosely attach the traction bar to the Cross Member using the 1/2" X 3 1/2" Bolt and Nyloc nut. Make sure the bar is above the crossmember and nuts are facing outward towards the driver side frame.

13. Position the rear mounts over the axle housing and check for alignment, adjust angle to a good fit.

14. The shackles should be close to the 12 o'clock position. Fine adjustment can be made by adjusting the rod-end, if more adjustment is needed the traction bar can be moved to the other hole in the shackle.

15. After proper alignment is complete, clean the area around the axle mounts and tack weld the brackets to the axle housing.

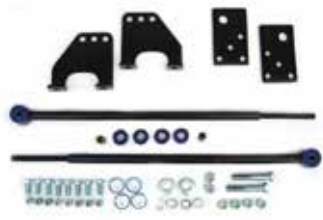
16. Remove the traction bar from the axle mounts and fully weld the brackets to the housing. When the mounts have cooled paint the welds to prevent rusting.



17. Re-attach the traction bar to the axle mounts and tighten the bolts and nuts securely.
18. Make any final adjustments and tighten the shackle bolts and rod end jam nut securely.
19. Re-check all fasteners to ensure they are tight.



**Torque Tamer Bolt-on Bracket #5329**



**Classic Traction Bars #5300**



**Torque Tamer Bolt-On Bracket Sway Bar Spacer #5324**



**Lube Locker Differential Gasket #5767**



**Hellwig Sway Bar #5311/5312/5313**



**Torque Tamer Hardware Refresh Kit #H5326**



**Torque Tamer Replacement Busings #5326BSH-KIT**



**1/8" Rocker Guards with Slider Ski Step #7012**

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