



Rev. # 10-02

## PART #FK3097-6

### 1997-2002 FORD F150 REAR FLIP KIT

# INSTALLATION INSTRUCTIONS

Please take the time to read these **INSTALLATION INSTRUCTIONS** and check the **Hardware Parts List** to be sure you have all the listed parts.

These installation instructions are prepared for the professional installer with the proper equipment, tools and experience in suspension systems and safety. This vehicle and its components are extremely heavy and can be dangerous without the proper equipment and experience.

Please read the warranty information (blue page enclosed). Complete your Product Warranty Card and mail it to DJM Suspension.

Please take a few minutes to fill out your installation helper (back side of warranty). Accurate measurements **BEFORE BEGINNING INSTALLATION** will show any irregularities in your vehicle.

**NEVER WORK UNDER TRUCK SUPPORTED BY A JACK ONLY !!!**  
**USE QUALITY JACK STANDS WHICH HAVE A RATING ADEQUATE FOR YOUR TRUCKS WEIGHT!!!**

New shocks are required. Use DJM #1910.

#### **Hardware Parts List:**

##### Axle Flip Kit

- 2- Axle Locators (1010-A)
- 2- Upper Axle Plates (1010-P)
- 4- 5/8" U-Bolts (1025)
- 4) 5/8" x 18 Nuts
- 8) 5/8" Flat Washers
- 2- 5/8" x 3-1/2" Bolts
- 2- 5/8" x 4" Bolts
- 8- 5/8" Flat Washers
- 8- 5/8" Nylock Nuts
- 2- Leaf Spring Plates (1025)

##### Frame Support Kit

- 1- Left Frame Support (1025)
- 1- Right Frame Support (1025)
- 16- 1/2"x 13 x 1.75" Bolts
- 16- 1/2" Flat Washers
- 16- 1/2" Nuts
- 2- Urethane Bump Stops (10S)

Install new U-bolts and spring plates (5 hole) on the bottom of the springs. Cross-torque u-bolts.

Place the new upper axle plates with the pin down on top of the axle. Install the 5/8" bolts, with one flat washers on top of the upper plate and one on the bottom of the axle locator.



#### **Installing Frame Supports**

Frame supports are installed after axle is relocated. Raise the axle, and mark the center on the frame. Use this mark to center the frame support. Frame supports mount to frame with long side forward. Make a template or use one of the brackets and mark the frame. Use a sawzall, cutting wheel or plasma cutter to notch frame. **Do not use a torch!!** Move any wires or brake lines out of the way before cutting. Drill and bolt frame support to frame. Install bump stop to frame support.



#### **RELOCATING (FLIPPING) REAR AXLE**

Remove front and rear spring eye bolts and remove spring from truck. Keep bolts they will be reused to reassemble springs. Reinstall the leaf spring under the axle. Place the new axle locator bracket on top of the spring, with the off center hole toward front of vehicle. This will center the rear axle and pull the drive shaft back from the transmission slightly. Lower the rear axle into the new axle supports. Rotate axle to desired pinion angle.

Install new shocks.

Check all hardware has been tightened. Take for test drive.

Adjust pinion angle if necessary.

Measure and record completed height on installation helper.