



## PART #FK3204-6

Rev. # 1-04

### 2004-2007 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!!!**

This kit is designed to be used with DJM hanger #EH3204 or shackle #SH3200. If used separately a frame notch kit is recommended.

#### NEW REAR SHOCKS ARE REQUIRED.

(DJM PART #2200 when are used with DJM hanger #EH3204 or shackle #SH3200)

#### Hardware Parts List:

- |                                |                         |
|--------------------------------|-------------------------|
| 2) Lower Axle Brackets (3204A) | 1) 18mmx140mm Bolt.     |
| 2) Upper Axle Brackets (3204P) | 1) 18mm Nylock Nuts.    |
| 4) 5/8" U-Bolts (1025)         | 1) 18mm Washers.        |
| 4) 5/8"x 11 x 3-1/2" Bolts.    | 2) Spring Plates (3204) |
| 8) 5/8 Flat Washers            | 2) Bump Stops (10R)     |
| 4) 5/8" x 11 Nylock Nuts       | 2) Zip Ties             |

#### RELOCATING (FLIPPING) REAR AXLE

Remove rear leaf springs (suggest doing one side at a time). The forward leaf spring bolt on the driver side can not be removed without moving the gas tank. The pros will cut the bolt instead of moving the tank, a new 18mm x 140mm bolt is included to replace the original. The factory spring bolt is reused on the passenger side.

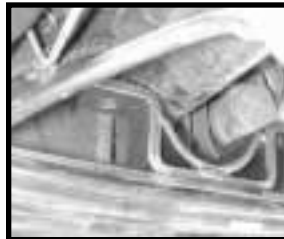
If using new shackles, remove stock shackle and loosely bolt the new shackle to the spring. If using new hangers refer to hanger installation instructions.

There are two axle locator pins in the factory leaf spring. Reverse the rearward one so the nut is on the bottom. Unbolt and discard the forward one.

There is a brake line on the back side of the axle. Remove the bolt holding the brake line clip to the axle, just below the leaf spring mount and move the brake line out of the way.

Reinstall the leaf spring under the axle. Place the new axle locator bracket on top of the spring, line up the hole in the bracket with the pin in the spring. Lower the rear axle into the new axle supports.

Install new U-bolts and spring plates (5 hole) on the bottom of the springs. Tighten u-bolts to hold axle in place, you may need to loosen them again to adjust drive line angle.



Temporarily bolt on wheels and set vehicle down. Tighten shackle bolts and spring bolts.



Check the drive line angle. You want the drive shaft to be straight from the transmission back to the rear end. This can only be checked with the tires on the ground (at ride height). Adjust pinion angle as necessary.



Place the new upper axle plates, with the pin down in the rearward hole, on top of the axle. Install and tighten the 5/8" bolts provided with one flat washers on top of the upper plate and one on the bottom of the axle locator. Tighten U-Bolts. Check all bolts.



Use the zip ties to secure the brake line clip to the 5/8" bolt.

Remove factory bump stop. The new bump stop will thread into the factory hole in the frame.



Install rear wheels and torque lug nuts. Test drive and adjust pinion angle as necessary. Measure and record the height of the rear on the installation helper.