



SYNERGY MFG. 870 INDUSTRIAL WAY, SAN LUIS OBISPO, CA (805) 242-0397

8529 DODGE DDB TRACK BAR RETROFIT KIT 03-13

V1.0

GENERAL NOTES:

- These instructions are also available on our website; www.synergymfg.com. Check the website before you begin for any updated instructions and additional photos for your reference.
- This kit is designed to retrofit first generation Synergy 8550-01 adjustable Dodge track bars for (06-08) 1500 4x4 Megacab, (03-12) 2500/3500 4x4 from the older bushing half style 4306-01 bushing to the improved, greaseless 4323-01 DDB track bar bushing
- This kit is also designed to fix ovaled out track bar brackets and can be used on either frame side or axle side track bar brackets.
- The machined washers in this kit are made from 303 stainless steel and can be welded to the vehicle if desired.

PARTS LIST:

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- (2) 852901-01 Dodge Track bar step down washer
- (1) 9/16-18 UNF x 3.25" long F911 hex head bolt
- (1) 9/16-18 UNF Stover nut
- (2) 9/16" ASTM F436 hard washer extra thick
- (1) 4323-01 9/16" bolt track bar bushing (1-7/8" x .188 Bushing shell)

Parts / Tools Needed to complete installation:

- Basic simple hand tools.
- Drill with 3/4" drill bit or step bit that goes up to 3/4" hole
- Press or balljoint install tool (to press in new DDB bushing into track bar)
- Welder (Optional if desired to weld washers into place)

APPROXIMATE INSTALL TIME: 1-2 HOURS

INSTALLATION:

- 1) Installation of this kit can be done with the vehicle sitting on the ground under its own weight.
- 2) Start by removing the track bar from the vehicle.
- 3) Remove zerk fitting, sleeve and bushing halves from frame side of track bar, and wipe off any grease from the ID of the bushing shell.
 - Note- the zerk fitting will not be re-used since 4323-01 does not require grease.

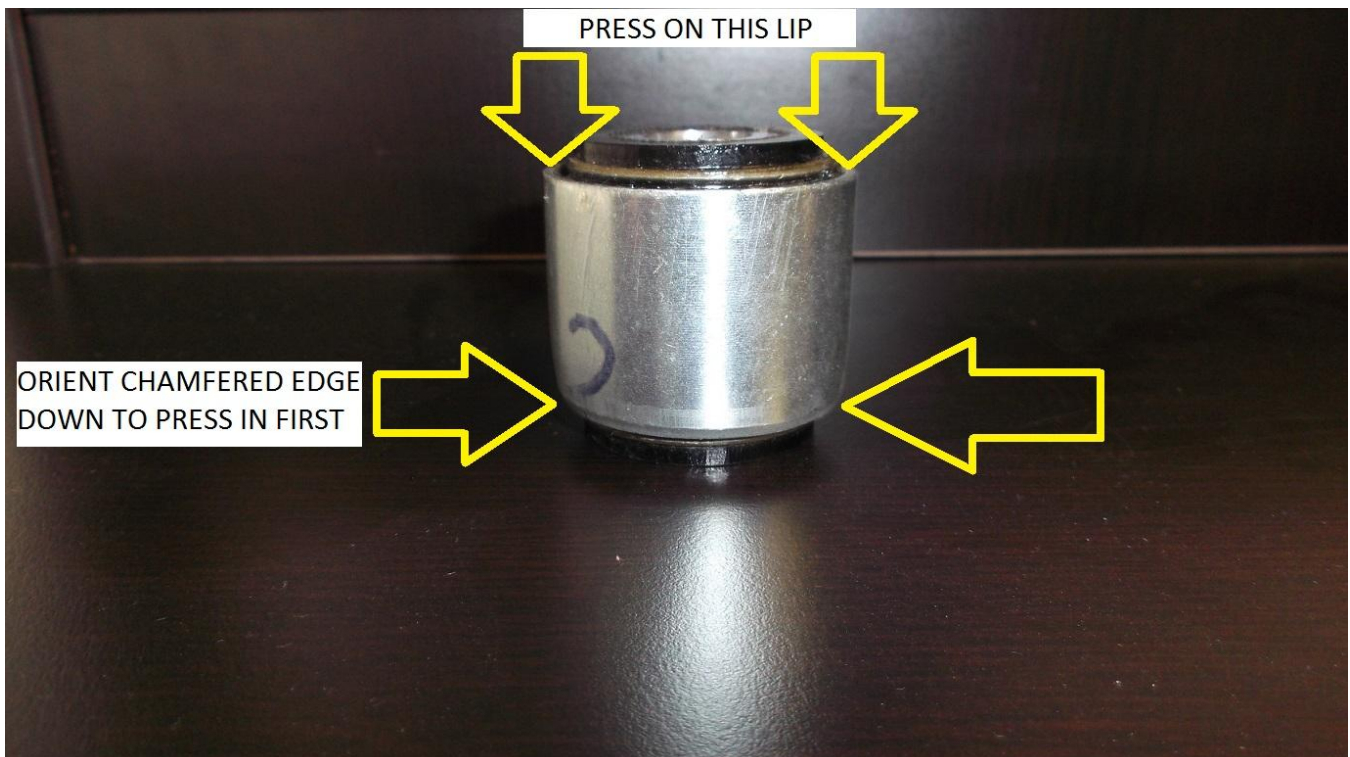


- 4) Next, use a small die grinder or dremel tool to put a small chamfer into one side of the track bar bushing shell as shown. About 1/16" x 45 degree chamfer is all that is needed. This is just to allow the new bushing to press in easier and not catch on the lip of the bushing shell.
- Paint exposed areas of metal to prevent corrosion. Part number 4016, Synergy Semi-Gloss Steel Metallic Touch-Up Paint is an exact match to the grey powder coat color used on the track bar.





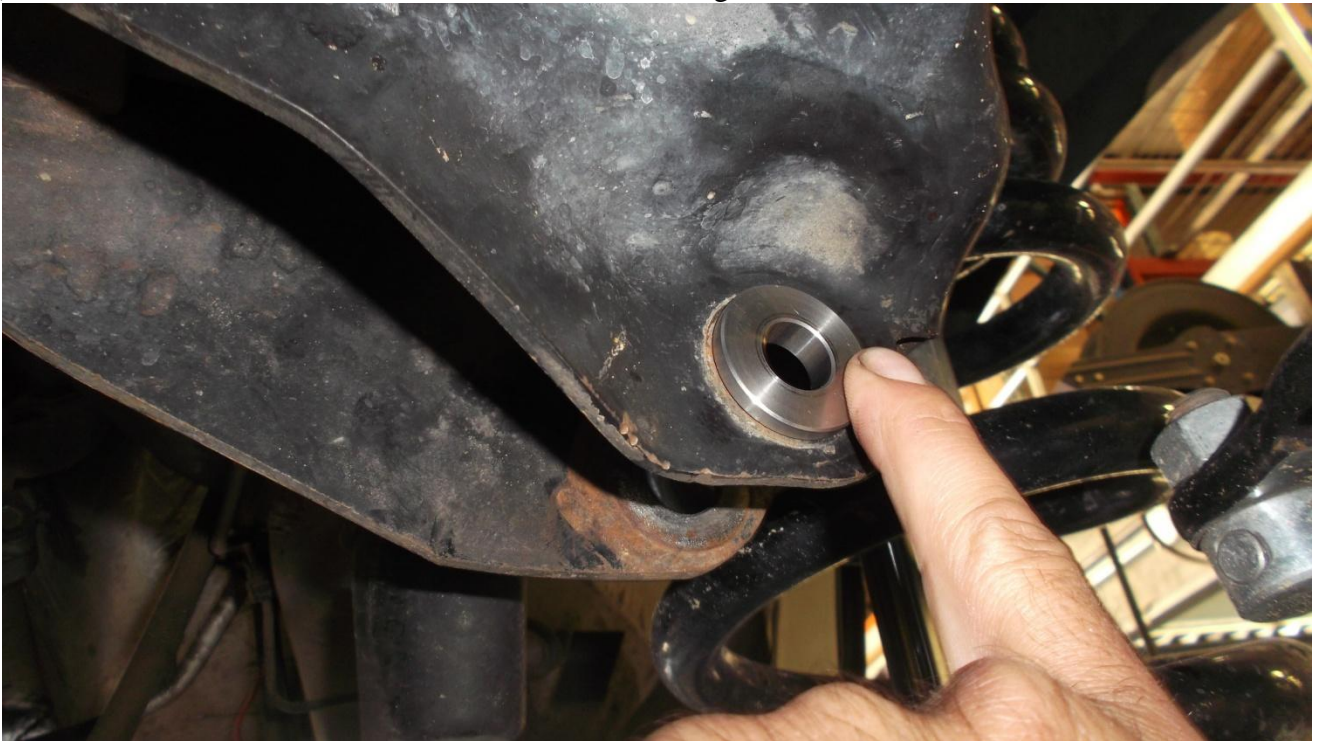
- 5) Next, use either a hydraulic press or a balljoint install tool to press the bushing into the trackbar. Orient the bushing as below. Be sure to use the chamfered edge of the bushing as the leading edge when pressing into the track bar.
- Note – a piece of 1.50 x .120 material works well to press the bushing into the track bar.



- 6) Press bushing in until the metal shell of the bushing is flush with the track bar bushing shell.
- 7) Installation of new bushing into track bar is complete.
- 8) Next, using a $\frac{3}{4}$ " drill bit or a step drill that goes up to $\frac{3}{4}$ ", drill out the factory track bar mount to $\frac{3}{4}$ ". A quality step drill works well.



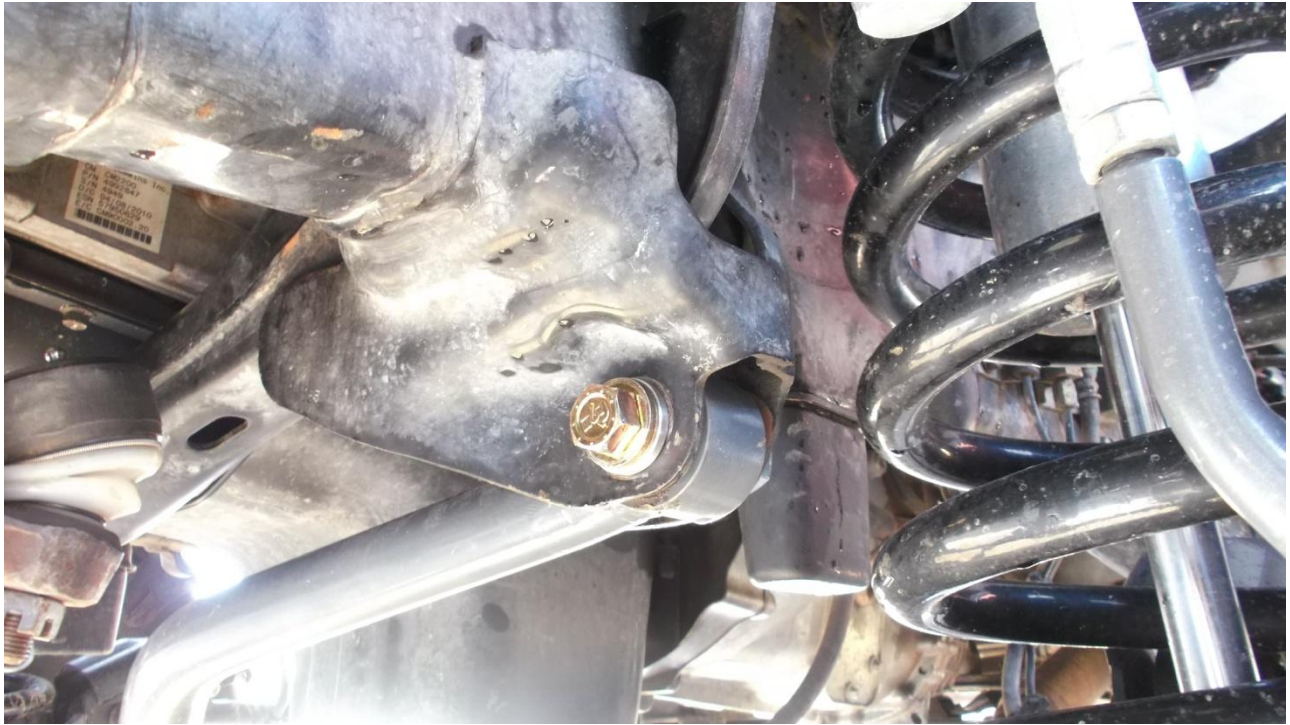
9) Next, test fit the machined trackbar washer. It is designed to fit into the bracket as shown.



10) When satisfied with fitment, remove any burrs or material from the inner face of the track bar bracket as to not damage the bushing on installation.

- If welding of washers to the bracket is desired, now is the time to do it. Remove paint on bracket where welding will occur. Install trackbar with bolt and simply snug the bolt to hold washers in line. Tack washers in place. Remove track bar and fully weld. Once welds have cooled, deburr welds and paint any exposed areas of metal to prevent corrosion.

11) Bolt in the track bar. Use a washer under both the head of the bolt and the nut. Torque bolt to 150 ft-lbs.



Installation is Complete