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**PART# WFO DMAX-SBB-1118-KIT**

**Duramax Steering Box Brace**

**For 2011-2018 DMAX/HD**

## **BILL OF MATERIALS**

| <b>PART #</b>     | <b>DESCRIPTION</b>                     | <b>QTY.</b> |
|-------------------|--|-------------|
| WFO DMAX SBB-1118 | Duramax Steering Box Brace for '11-'18 | 1           |
| SAFL205-16        | 2 Bolt Flange                          | 1           |
| 855702            | Pitman Arm Stud                        | 1           |
| 7/16" Bolt        | Bolt, 7/16-14 x 1.5 Grade 5            | 2           |
| 7/16" Flat Washer | Washer, 7/16" Grade 5                  | 4           |
| 344807            | Crush Lock Nut, 7/16-14                | 2           |

### **Tools Needed:**

- Basic simple hand tools
- 1 13/16" open end wrench or socket to fit stock pitman arm bearing stud
- 1 3/4" Open end wrench or socket to fit new pitman arm bearing stud
- 10mm socket & wrench
- Hammer & Punch
- Red Loctite
- Grease

*Approximate Install Time: 1 hour*

### **Note:**

- This steering Box Brace is only designed to be used with Solid Axle Conversions where the original crossmember under the steering box has been removed.
- This Steering Box Brace can be used with or without a sway bar on the vehicle.

# 2011-18 Duramax Steering Box Brace Installation Instructions

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- 1.) Unbolt the stock sway bar clamps from the frame and let the sway bar swing down. The Sway Bar will stay attached to the axle. **Save the stock bolts, you will reuse them.**



- 2.) Remove the pitman arm nut on the steering box (1 13/16" wrench or socket). Then, install the new pitman arm stud we provided in the kit and reuse your lock washer. We suggest using red Loctite. Torque to 273 ft. lbs.



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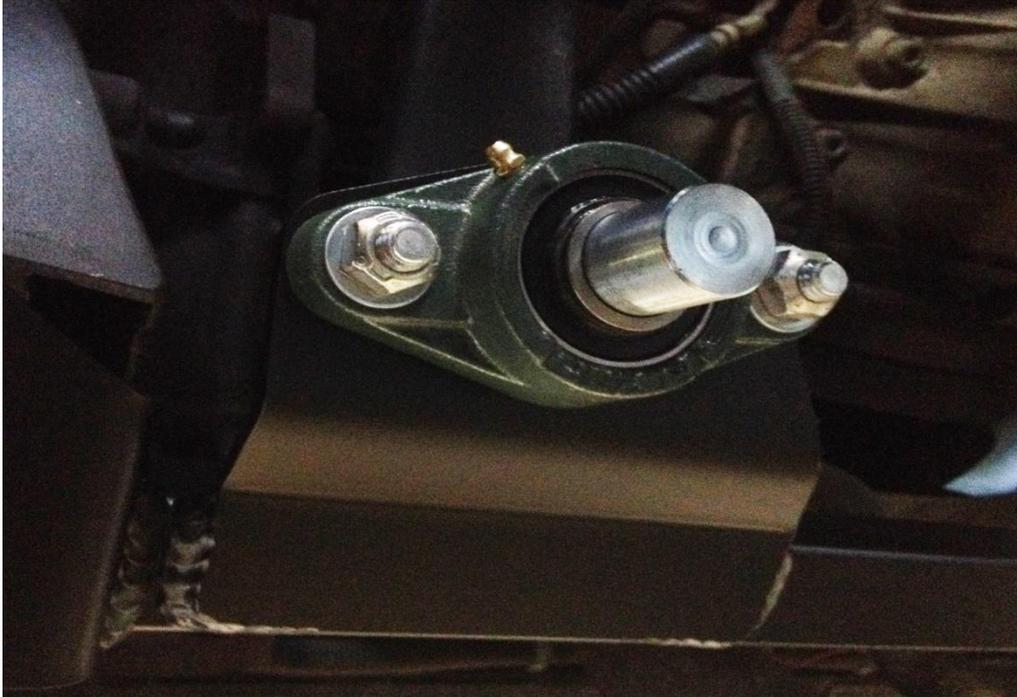
- 3.) If using a Sway Bar, position the steering box brace onto the sway bar as shown below and swing them up into place on the frame. Loosely install the four, stock M10-1.50 bolts into the threaded holes in the frame so the brace can be moved if necessary to align the bearing on the steering box brace.



- 4.) Center the pitman arm stud in the hole of the steering box brace and install the bearing using the 7/16"-14 x 1.5" long bolts provided in the kit. It is recommended to lightly coat the pitman arm stud with grease prior to assembly. (This picture shows the brace installed without the swaybar)



## 2011-18 Duramax Steering Box Brace Installation Instructions



5.) Torque the two 7/16-14 bolts to 55 ft. lbs. Torque the four M10-1.50 frame bolts to 40 ft. lbs.

6.) Next, install the bearing lock ring. With the set-screw loose, install and rotate onto bearing just like you would a nut.

- The lock ring is eccentric and will engage onto the bearing at a certain point.
- Once the lock ring can no longer be rotated by hand, use a small punch and hammer to tap it into place. **DO NOT USE PUNCH ON THE SET SCREW HOLE!** Put the tap in one of the non-threaded holes in the lock ring. Once it is seated, tighten the set screw.



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- 7.) Lastly, if you choose, you can install the OEM Duramax IFS Actuator onto our Steering Box Brace. This will allow you to keep the actuator plugged in to your harness so the lights on your dash will not always be on. First, unscrew the actuator from your IFS axle and screw it into the round bracket in the middle of the brace.



- 8.) We recommend Re-torquing the bolts after 100 miles of driving. Grease the bearing at normal chassis service intervals. Enjoy!
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