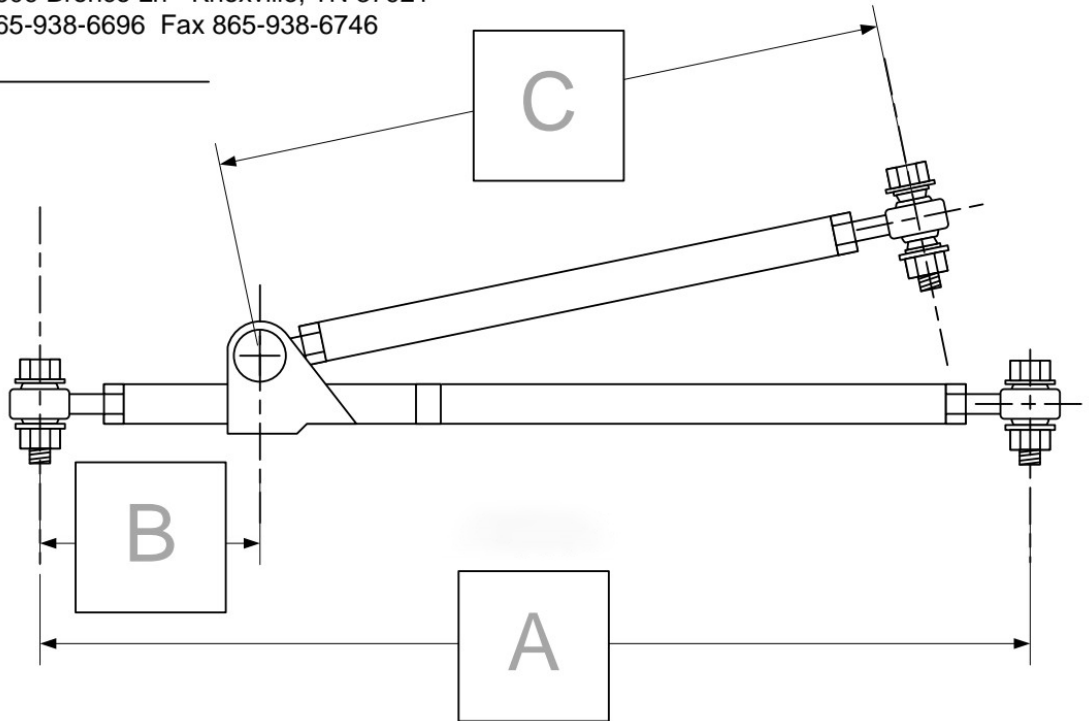




James Duff Inc.

6609 Bronco Ln - Knoxville, TN 37921
865-938-6696 Fax 865-938-6746



INSTRUCTIONS FOR STANDARD HEIM STEER SYSTEM Item Numbers 5640-A, 5640-B, and 5645 Only:

- A- Measure the length of the **Tie Rod**: (With toe-in at app. $\frac{1}{4}$ ".) Measure from center of driver steering knuckle to center of passenger steering knuckle. Record this number in **BOX "A"**.
- B- Find the **Saddle Mount Reference Point**: (Please remember that the center point will be 1.5" above tie rod.) The Saddle Mount is the mount on the passenger side of the tie rod where the drag link attaches (in parallel with the track bar) coming from the pitman arm. Measure from the center of the passenger side steering knuckle to center of the saddle mount point on the tie rod. Record this number in **BOX "B"**.
- C- Measure the length of the **Drag Link**: (Make sure pitman arm is parallel to frame.) Measure from center of pitman arm to center of Saddle Mount. The angle of your drag link should be parallel to the angle of your track bar with the vehicle at ride height. Record this number in **BOX "C"**.

INSTRUCTIONS FOR DETERMINING CUSTOM HEIM STEER SYSTEM MEASUREMENTS Item Number 5640-C Only:

NOTE: Final measurements should be taken with vehicle at ride height with the track bar in place after you have accounted for any clearance or interference issues!

- A- Determine the **Tie Rod** length: (Set toe-in at app. $\frac{1}{4}$ ".) Measure from center of driver steering knuckle to center of passenger steering knuckle. Record this number in **BOX "A"**.
- B- Determine the **Saddle Mount Reference Point**: (Please remember that the center point will be 1.5" above tie rod.) The Saddle Mount is the mount on the passenger side of the tie rod where the drag link attaches coming from the pitman arm. Measurement "B" is called the "Saddle Mount Reference Point". It is very important that the drag link and track bar are parallel to each other. Determine the saddle mount point with this in mind. You must also be aware of potential interference points before deciding where to locate the saddle mount. To find potential interference points, you can raise the front of the vehicle and have someone move your steering from lock-to-lock and look for interference along the tie rod and drag link (such as from your C-caps, aftermarket diff covers, etc.). Once you have determined the best location for your saddle mount, measure from center of passenger steering knuckle to center of saddle mount point on tie rod. Record this number in **BOX "B"**.
- C- Determine the length of the **Drag Link**: (Make sure pitman arm is parallel to frame.) Measure from center of pitman arm to center of Saddle Mount. The angle of your drag link should be parallel to the angle of your track bar with the vehicle at ride height. Record this number in **BOX "C"**.