

10397 AIR SPRING RETROFIT KIT

2017-2021 Ford F-250/F-350/F-450 Super Duty (2WD/4WD) Applications

Refer to Figure A for vehicles that require retrofit.

AFFECTED APPLICATIONS:

The 10397 air spring kit **WILL NOT FIT** on the majority of 2017 to 2021 Ford Super Duty models – air spring brackets requiring installation will interfere with vehicle components (strike plate).

If your vehicle **IS** equipped with the strike plate (shown in Figure B), the **Retrofit Kit is required** to complete your install.

If your vehicle **IS NOT** equipped with the strike plate shown, the 10397 air spring kit **will fit your vehicle** and the Retrofit Kit is NOT required.

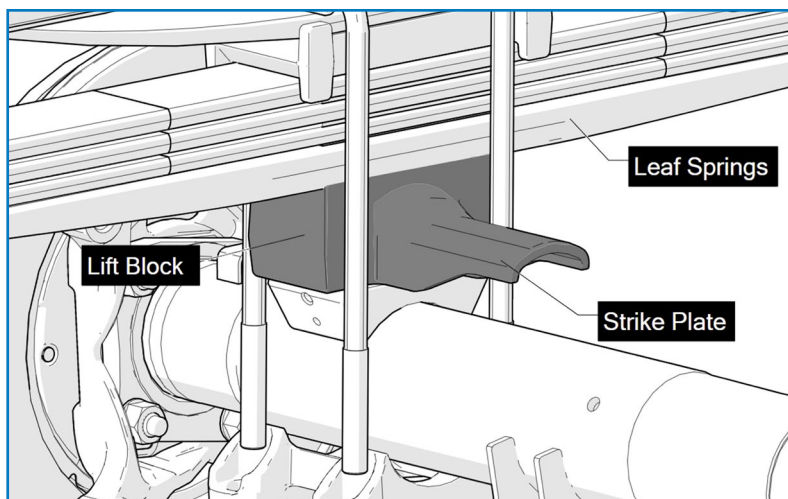
ADDENDUM TO ORIGINAL MANUAL:

Steps 4 and 6 in the 10397 installation manual (L6533) have been modified – this document has the information needed to complete these steps properly.

Lastly, there are steps to resolve brake line interference.

VEHICLE	DRIVE TYPE	REAR WHEELS	STATUS
F-250	4WD	SRW	Retrofit Required
	2WD		Kit fits
F-350	4WD	SRW	Retrofit Required
		DRW	Kit fits
	2WD	SRW/DRW	Kit fits
F-450	2WD/4WD	DRW	Kit fits

A



B

KIT CONTENTS:

The original assembly contains 32 flat washers (size 3/8"). In the Retrofit Modification Kit (see list below), the bolt head lock plates replace 4 of the flat washers on each side. There should be 26 flat washers used and 8 remaining at the end of the installation.

RETROFIT KIT CONTENTS	QTY	PART #	PURPOSE
Bolt Head Lock Plate	4	X5162	Eases lower bracket assembly. New component
Lower Axle Bracket	2	X5163	Resolves fitment issue. Replaces bracket HP1733
Spacer	4	X5164	Resolves fitment issue (gaps). New component
Plastic Sleeve	1	M8014	Protect brake line from abrasion
Tie Straps	4	C11618	Secures Plastic Sleeve

Complete the procedure on the following pages in addition to Steps 4 and 6 in the original L6533 installation manual.

1 ASSEMBLE LOWER BRACKET WITH LOCK PLATES

(Addendum to Step 4 in L6533 manual)

Use the replacement lower axle bracket provided with the Retrofit Kit in place of the bracket from the original kit (See Figure 1A).

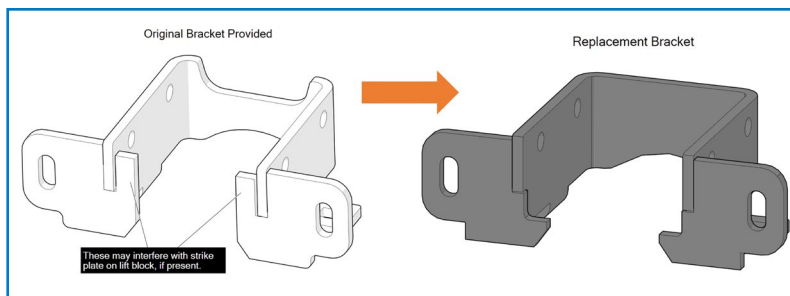
(Using Figure 1B as reference) Place two bolt head lock plates in position with flat sides against the inside of the lower bracket.

Align holes and insert four 3/8" – 16 x 1.5" hex bolts through the lock plates and the lower brackets.

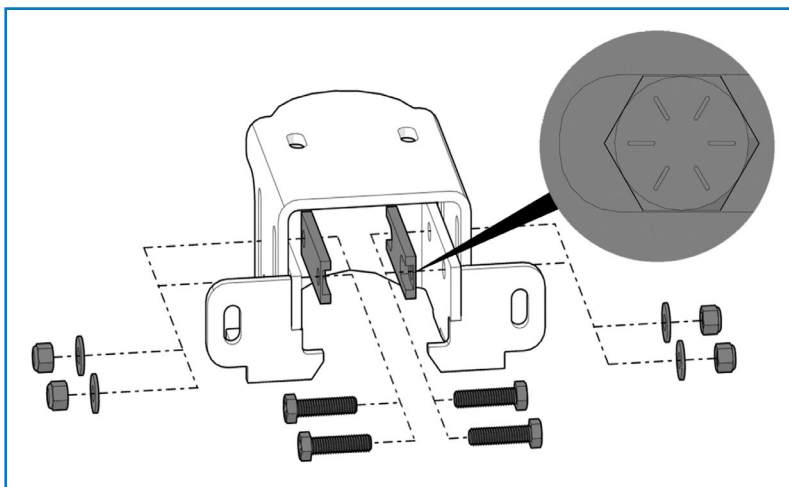
Attach four 3/8" flat washers and four 3/8" nylon lock nuts onto the ends of the bolts.

Align hex heads of the bolts as per the callouts in Figure 1B.

Hand-tighten nuts so that the bolt heads fall within the machined grooves of the lock plate, preventing rotation.



1A



1B

2 CHECK LOWER AXLE BRACKET FLANGES FOR CONTACT

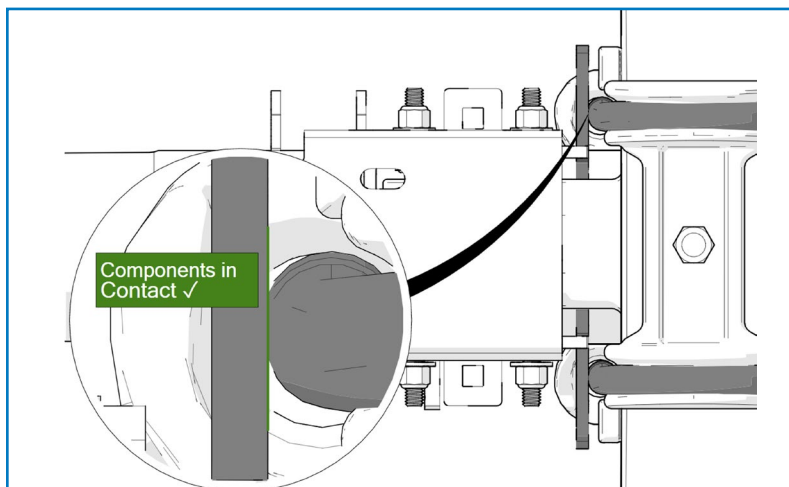
(Addendum to Step 6 in manual)

Ensure lower axle bracket is fully resting on the vehicle axle and push the air spring assembly towards the leaf pack.

At its furthest position, observe bracket flanges for contact with the leaf spring U-bolts as shown in the comparison images (Figure 2A shown here & 2B shown on following page).

FIGURE 2A:

If the lower axle bracket is in contact with the leaf spring U-bolts, and there is no gap, the spacers are not required. **Complete Step 6 as per the provided manual, then proceed to Step 3 in this document.**

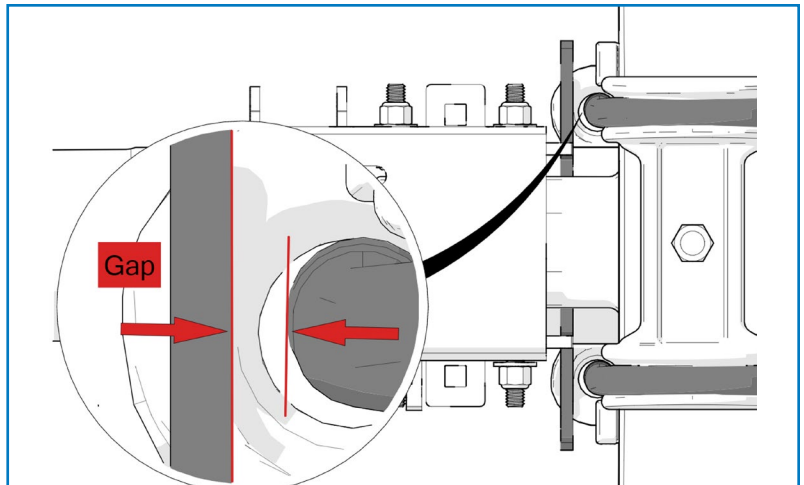


2A

FIGURE 2B:

If there is any gap between the lower axle bracket and the leaf spring U-bolts, the spacers included in this kit must be installed as per the instructions below (using Figure 2C):

- Place the two spacers provided in between the lower bracket flanges and leaf pack U-bolts. Align spacers with flanges, ensuring edges and slot holes align.
- Hold spacers in position while inserting the square U-bolt around the leaf pack and through the slot holes on the spacers and lower axle bracket flanges.
- Secure the U-bolt using two 3/8" flat washers and two 3/8" nylon lock nuts. Do not fully tighten yet.



2B

3 CHECK BRAKE LINES FOR INTERFERENCE

There may be interference between the lower bracket of the kit and the brake line (as shown in Figure 3).

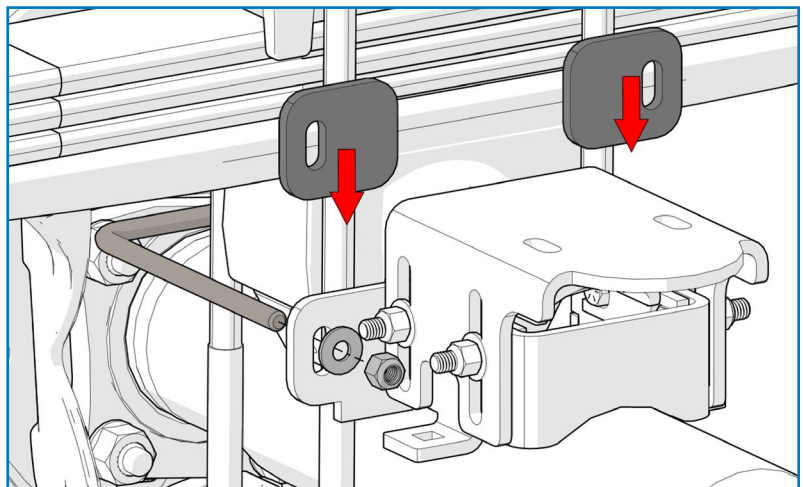
Carefully bend the brake line bracket away from the air spring brackets.

Use caution not to pull or strain the brake lines.

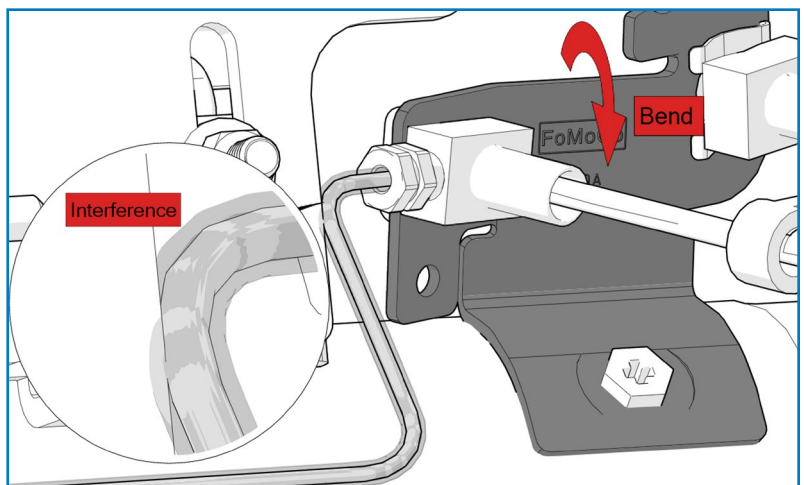
It may be necessary to unbolt the retaining bracket securing the brake line under the leaf pack to adequately bend the bracket without stressing the hard lines.

It is recommended to further protect the brake lines by wrapping the line in the plastic sleeve provided to further reduce the risk of wear by friction or rubbing.

Proceed with remaining installation as per the provided manual.



2C



3