

THUREN FABRICATION REAR TRACK BAR

These instructions are applicable to the following Trucks:

- 2014 - 2023 Ram 2500
- 2014 - 2023 Power Wagon

Applicable Part Numbers:

- (TF-RLR2500-TBK)

NOTE

From 2014 to present, there are many variations of the OEM rear 2500/Power Wagon rear axle trackbar bracket. Yours may not look identical to the one pictured, but our bracket has been tested on all versions and found to work perfectly.

1) OEM TRACK BAR REMOVAL

- Park on level ground
- Jack truck up by rear axle and place rear axle on jackstands
- Remove the driver side rear wheel.
- Remove rear OEM trackbar



Image 1



Image 2

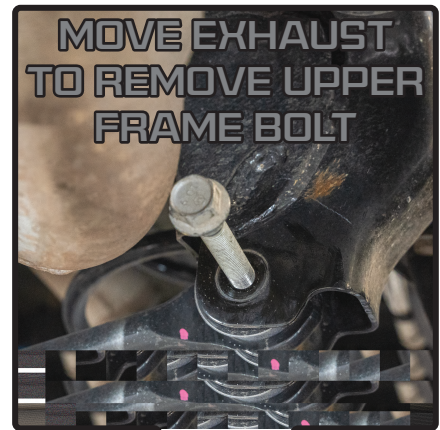


Image 3

2) Mounting The Axle Bracket

- Remove plastic brake line/abs wire retention clip from bottom side of factory trackbar bracket. Save for reinstallation later. (see image 1 & 2)
- Position Thuren trackbar bracket with large flat panel going underneath the OEM trackbar bracket. Thuren badge will be facing the rear. (see image 6)
- Slide the supplied 14mm bolt and washer through the assembly (TF Track Bar bracket > OEM trackbar mounting hole > powder coated slug/spacer > supplied dogbone support) and thread on the OEM flag nut.
- Slide the supplied 9/16" bolt through the other end of the dogbone and TF bracket, to locate the dogbone on forward side of the TF track bar bracket. (see image 4 for dogbone orientation)

IMPORTANT

Tighten the 14mm bolt and flag nut, then loosen one turn so that with a little persuasion, the bracket assembly can still shift around a bit.

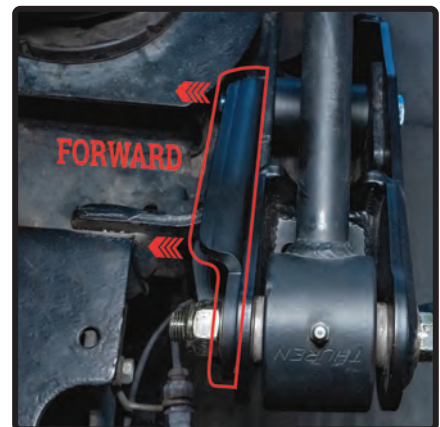


Image 4

If you don't have a Power Wagon, skip this step

- If installing on a Power Wagon, the main bolt hole is higher on the factory bracket and a new 9/16" hole will need to be drilled through both sides of the OEM axle mount.
- To locate the new hole center to drill, the Thuren track bar bracket has to be clamped/pushed into position in 3 directions.
- Pushed/clamped up tight against the bottom, against the driver side, and forward to the back face of the OEM mount.
- In this position mark the hole to drill center, and step up in bit sizes to final with a 9/16" drill bit.
- Once the OEM-rear face is drilled through, you can use the supplied black thick steel slug/spacer as a drill guide, to find center to drill through the OEM-front bracket face.

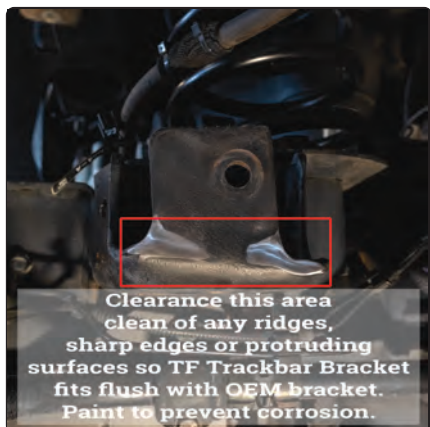


Image 5



Image 6



Image 7

- On the underside of the track bar axle mount bracket, there are 2 existing holes in the OEM bracket.
 - The holes should roughly line up with holes in the Thuren bracket. Drill through these OEM axle mount holes with 1/2" drill bit. (see image 7)
 - Sometimes the holes do not line up perfectly and if this is the case, it is fine to egg-out the holes in both brackets with the 1/2" drill bit for proper fitment. As long as the bolts slide through, you are good.
- Install the 2, 1/2" x 1.5" flange head bolts and flange nuts (*bolt heads down*), and tighten them, but then loosen them a turn so the Thuren bracket can shift side to side a bit. (see image 8)
- Now is the time to drill the final mounting bolt hole on the driver side of the bracket facing the side and rear a bit, at an angle (see image 9)
 - Using the Thuren trackbar bracket as a guide, use a center punch and mark the hole.
 - Drill hole with small drill bit as a pilot, ending with 1/2" size drill bit.

IMPORTANT

We want the Thuren bracket to be sandwiched tight to the OEM bracket in this location where this side hole is drilled. This is why the other bolts still need to be a bit loose, so that the Thuren bracket can pull together freely here. That said, if the other previously installed bolts are TOO loose, you will not drill this hole in the proper location.

- Install the 1/2" x 1.5" flange bolt in this drilled location from outside in, then install the flange nut. You can now fully tighten this bolt and nut to **90ft/lbs.**



Image 8



Image 9

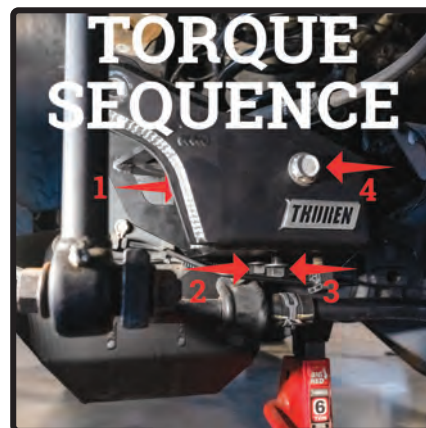
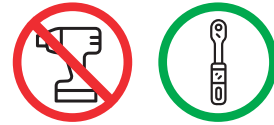


Image 10

3) Important Final Axle Bracket Tightening Sequence

- The goal here is to get all 3 important surfaces (*driver side, bottom, and rear*) tight to each other, and this specific sequence is required to get this done. (see image 10)
- Make sure the supplied 14mm bolt is still inserted loose through the bracket and the dogbone. (*OEM Track bar location*) This will locate the dogbone in position for final bracket tightening.
- Make sure the previous drilled driver side hole has the ½" BP bolt and nut installed, and final torque to 90ft/lbs
- Tighten the 2 bottom slightly loose ½" BP bolts to 90ft/lbs
- Tighten the slightly loose OEM trackbar mounting bolt to 130ft/lbs
- Reinstall Brake line and ABS line clips.
- New Thuren bracket installation is complete!

FINAL TORQUE



4) Thuren Track Bar Installation

- The Thuren Trackbar is side specific.
- The frame side will have the weld on gusset and the grease zerk *pointing down*
- The axle side grease zerk will point up, but the weld gusset *will be down*.
- Lift the trackbar into the frame pocket, and install the OEM bolt and nut through the assembly. Fully tighten to 130ft/lbs
- Install supplied 9/16" x 4" bolt with washer through Thuren track bar bracket, trackbar, and dogbone. Install washer and nylock nut with bolt. Torque bolt to 140ft/lbs.
- You may need to use a centering tool to align the trackbar with the axle bracket.
- Additionally, ratchet straps or a pry bar can be used to help pull the axle into alignment, aiding in bolt installation.

5) Final Checks

- Reinstall the driver side wheel and tire, torque lug nuts. Torque to 140-150 ft lbs
- Remove Jack Stands & lower truck back on the ground.
- Retorque mounting hardware after 500-1000 miles.
- Grease the Zerks *every oil change or so*.

Thuren Rear Trackbar installation is complete!



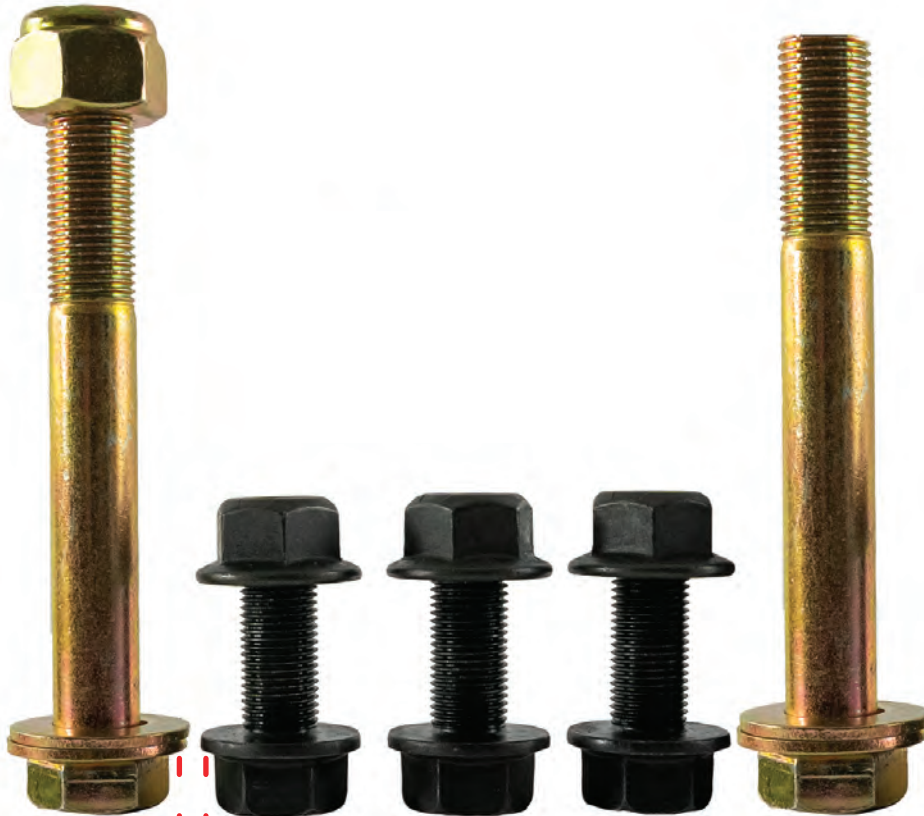
THUREN FABRICATION REAR TRACK BAR HARDWARE LIST

These instructions are applicable to the following Trucks:

- 2014 - 2023 Ram 2500
- 2014 - 2023 Power Wagon

Applicable Part Numbers:

- (TF-RLR2500-TBK)



**TRACK BAR
AXLE SIDE MOUNT**

**TF TRACK BAR
BRACKET**

