



SDHQ Motorsports
190 S McQueen Rd
Ste 109 Gilbert, AZ 85233
Phone: 480-633-2929

Product Packing List

Product: SDHQ-13-1310

Description: 2009-2014 Ford Raptor Lower A-Arm Doubler Plates

____ (4) Front Doubler Plate

SDHQ-13-1310-F

____ (4) Rear Doubler Plate

SDHQ-13-1310-R

Inspected, Packaged and Shipped By: _____ Date: _____

**For questions or help with the installation, please call SDHQ Offroad @ 480-633-2929
Mon.–Fri. 8:00am–5:30pm and Sat. 8:00am–3:30pm Arizona Time. www.sdhqoffroad.com**



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INSTALLATION INSTRUCTIONS

Product: SDHQ-13-1310

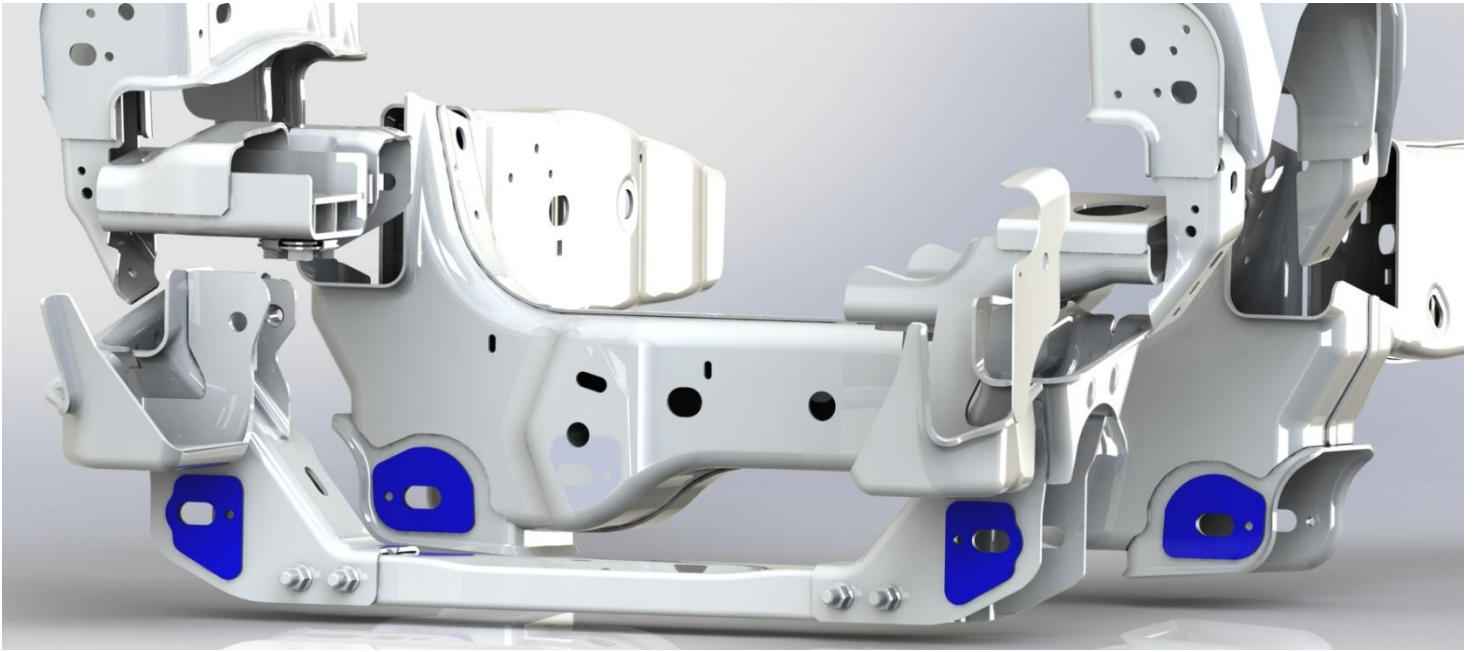
Description: 2009-2014 Ford Raptor Lower A-Arm Doubler Plates

(Finished product picture here)

<u>Parts List</u>	<u>Hardware List</u>	<u>Required Tools</u>
(4) - Front Doubler Plate SDHQ-13-1310-F (4) - Rear Doubler Plate SDHQ-13-1310-R	N/A	Jack and Jack Stands Impact Drill MIG/TIG Welder

Tech Notes

Medium Strength Loctite is recommended on all bolts.
An alignment from a reputable shop will be required after installation of the Doubler Plates.
Raptor Alignment Cam Kit (SP-86252) is recommended with the install of the Doubler Plates.
Difficulty of Installation: Hard



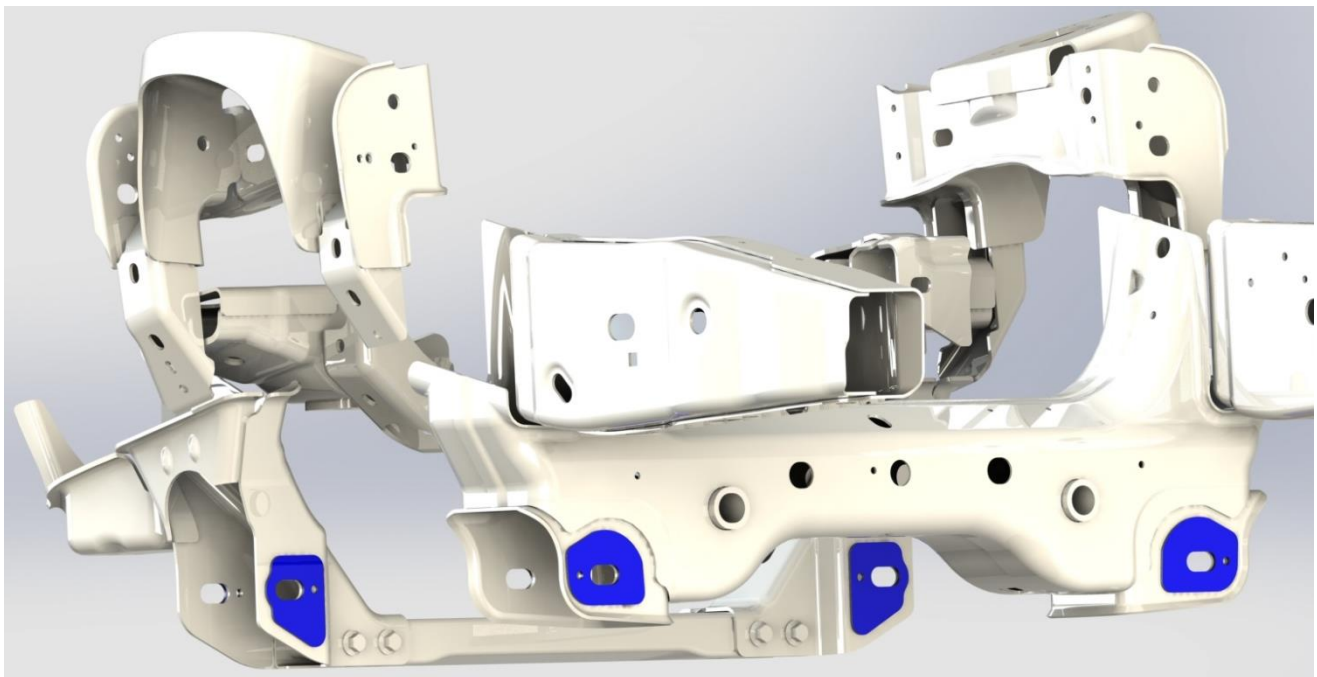
*****READ ALL INSTRUCTIONS THOROUGHLY FROM START TO FINISH BEFORE BEGINNING INSTALLATION! *****

Installation Instructions:

- 1.** Park the truck on a flat, level surface. Chock the rear wheels and set the parking brake. Use a jack to raise the front of the truck off the ground. Set jack stands under the frame and lower the truck onto them. Remove the front tires on the truck.
- 2.** Starting on the driver side, remove the bolt securing the shock to the lower control arm. Remove the nut connecting the sway bar to the lower control arm.
- 3.** Take note of the approximate position the lower control arm bolts. This will help to get the alignment close once the lower control arms are installed again. Remove the front and rear lower control arm bolts from the frame. This will allow the lower control arm to swing down out of the way while welding.
- 4.** Starting with the front lower control arm mount, clean the mounts on the frame to bare metal. Using (1) of the front doubler plates, align the slot and hole on the plate to the slot and hole on the front side of the front lower control arm mount. TAC weld the front doubler plate to the lower control arm mount. Verify alignment before fully welding into place.
- 5.** Using a second front doubler plate, align the slot and hole on the plate to the slot and hole on the back side of the front lower control arm mount. TAC weld the front doubler plate. Verify alignment before fully welding into place.
- 6.** Moving onto the rear lower control arm mount, clean the mounts on the frame to bare metal. Using (1) of the rear doubler plates, align the slot and hole on the plate to the slot and hole on

the front side of the rear lower control arm mount. TAC weld the rear doubler plate to the lower control arm mount. Verify alignment before fully welding into place.

7. Using a second rear doubler plate, align the slot and hole on the plate to the slot and hole on the back side of the rear lower control arm mount. TAC weld the rear doubler plate. Verify alignment before fully welding into place.
8. Repeat steps 2-8 for the passenger side doubler plates. Paint over the bare metal once complete to protect the metal.
9. Begin assembling the front of your truck back together. Install the lower control arm and torque to 258 ft*lbs. Connect the lower shock mount to the lower control arm and torque to 406 ft*lbs. Connect the sway bar to the lower control arm and torque to 59 ft*lbs. Install the wheels and drop your truck to the ground. The truck will need a new alignment once complete.



*****Double check all hardware is installed correctly and tight*****

*****Re-torque ALL bolts after 100 miles*****



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