



Part# F406-200K

Fabricated Radius Arms

2023-2026 Ford F250 / F350 4wd



Installation Notes

Please Read These Installation Instructions Completely Before Beginning The Installation. Carefully Reviewing The Instructions In Advance Will Help Ensure You Have The Proper Tools, Equipment, And Mechanical Experience Required To Complete The Installation Safely And Correctly. We Recommend Reading Through The Instructions At Least Twice Before Starting The Installation Process.

For All Fasteners That Do Not Use A Locking Nut (Such As A Prevailing Torque Or Nylon-Insert Lock Nut), Or When Reinstalling A Previously Used Locking Nut, Pro One Design Recommends Applying A Medium-Strength Thread Locker During Assembly. We Recommend Using Loctite® 243 Or An Equivalent Medium-Strength Thread-Locking Compound To Help Maintain Proper Fastener Retention. After All Hardware Has Been Tightened To The Specified Torque Values, Apply A Torque Stripe Or Paint Mark To Each Fastener To Provide A Quick Visual Reference During Future Inspections.

Important Headlight Sensor Notice

If Your Vehicle Is Equipped With The Factory Automatic Headlight Leveling Sensor, You Will Need To Purchase The Pro One Design Headlight Sensor Lockout Kit ([Part # F406-256](#)). Please Read And Follow The Separate Headlight Sensor Lockout Installation Instructions Before Beginning Installation Of Your Pro One Design Suspension System.

Before You Begin

Before Beginning Installation, Verify That You Have Received All Components Required To Complete Your Pro One Design Suspension System. Carefully Compare The Contents Of Your Kit To The Included Parts List Before Disassembling The Vehicle. Identifying Any Missing Or Damaged Components Prior To Installation Will Help Prevent Unnecessary Delays.

If You Discover Any Missing, Damaged, Or Incorrect Parts, Please Contact Pro One Design Customer Support @ 559-271-8629 Before Proceeding With The Installation. Do Not Begin Installation Until All Required Components Have Been Received.



F406-200K	22-26 Ford F250 / F350 / F450 Radius Arms	Qty
F-20023	Driver Radius Arm	1
F-20025	Installed Hardware	Qty
3-381	Polyurethane Pivot Bushing	2
3-379	Stainless Pivot Ball	1
3-378	Stainless Washer	2
HO-250	HO-250 Retaining Ring	1
H-8011	Grease Zerk 1/4"-28	1
F-20020	Bagged Hardware	
	18-2.5mm x 140mm HCS	2
	18-2.5mm Nyloc Nut	2
	18mm Washer	4
3-405	Cam 1 Notch	4
3-412	Cam 2 Notch	4
F-20024	Passenger Radius Arm	1
F-20025	Installed Hardware	
3-381	Polyurethane Pivot Bushing	2
3-379	Stainless Pivot Ball	1
3-378	Stainless Washer	2
HO-250	HO-250 Retaining Ring	1
H-8011	Grease Zerk 1/4"-28	1
Choose Between 12" Or 15" Limiting Strap For Your Application Only 1 Size Included With Kit		
H-8030-12	Limiting Strap 12" For 3.5" Kit	2
H-8030-15	Limiting Strap 15" For 5.5" Kit	2
	1/2"-13 x 1 1/2" Hex Bolt	4
	1/2" Nyloc Nut	2
	1/2" Washers	6
W-2501	1/4" Thick Washer	2
NT-4574	Nut Tab 1/2"-13	2
H-8030-15-JIG	15" Limiting Strap Drill Jig	1

1 – Remove Factory Radius Arm

1. If your Vehicle Is Equipped With **Factory Automatic Headlight Leveling Sensor** Read The Important Notice Above.
2. Raise The Front Of The Vehicle And Support It Securely With Jack Stands. Remove Both Front Wheels And Support The Front Axle With A Floor Jack Or Suitable Support.
3. Perform The Following Steps On One Side At A Time To Maintain Proper Axle Alignment During Installation.
4. Remove The Front Shock From The Side You Are Working On.
5. Using A Trim Clip Removal Tool, Remove Any Vacuum Hose Retainers Or Clips Attached To The Radius Arm.
6. Remove The Factory Radius Arm Mounting Bolts At Both The Frame And Axle Ends. Carefully Remove The Factory Radius Arm From The Vehicle. Retain The Factory Hardware For Reinstallation Unless Otherwise Specified.



Pro One Design Fabricated Radius Arms Caster Adjustment

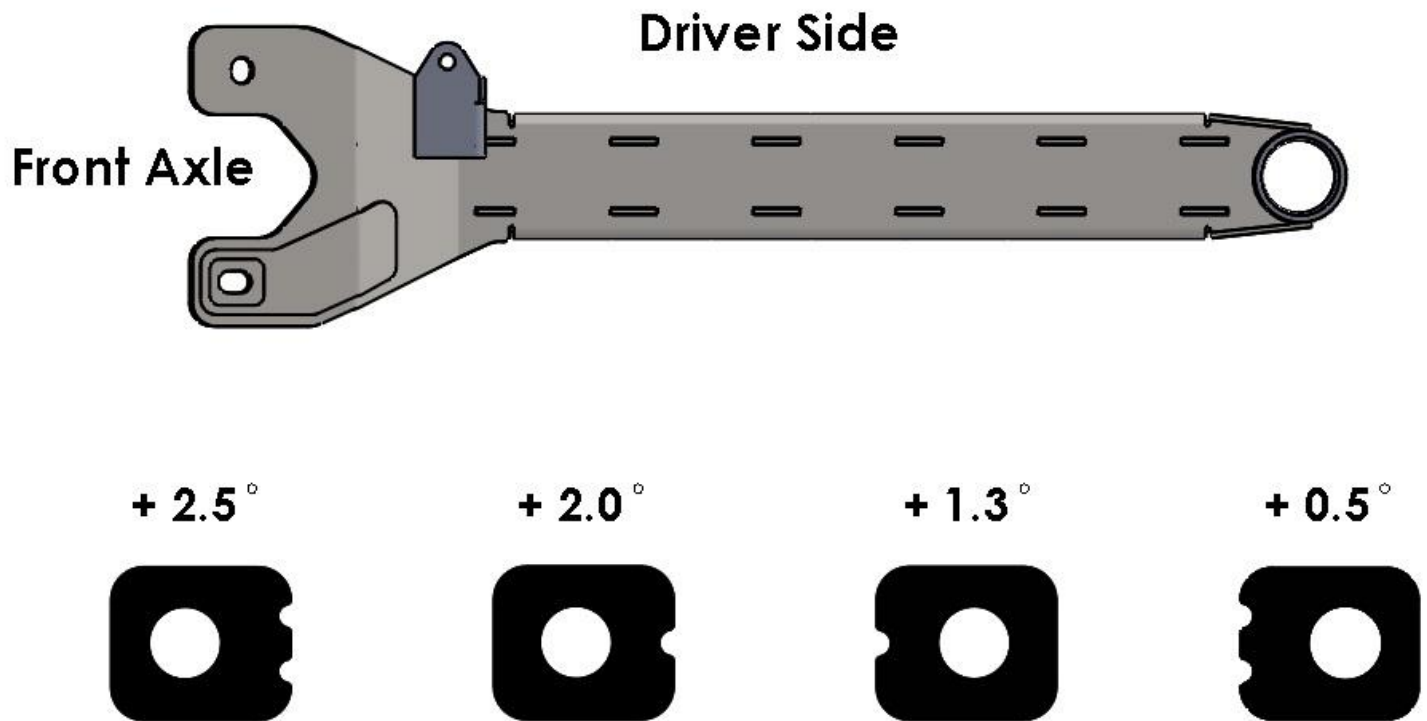
Pro One Design Fabricated Radius Arms Feature Four Selectable Caster Settings, Allowing You To Fine-Tune Front-End Alignment For Your Specific Suspension Height And Driving Preferences.

Two Different Offset Caster Cams Are Included With Each Kit:

- One Cam Features An Identification Notch.
- One Cam Is Supplied Without A Notch.

Each Cam Can Be Installed In Two Different Orientations, Providing A Total Of Four Caster Adjustment Positions.

Depending On The Selected Cam And Its Orientation, Caster Correction Can Be Adjusted From $+0.5^{\circ}$ To $+2.5^{\circ}$, Allowing Proper Alignment Across A Wide Range Of Lift Heights While Optimizing Steering Feel, Straight-Line Stability, And Return-To-Center.



1 Notch – +0.5° Caster Recommended For 4.5" / 5.5" Kits

2 Notch – +1.3° Caster Recommended For 4.5" / 5.5" Kits

2 Notch – +2.0° Caster Recommended For 2.5" / 3.5" Kits

1 Notch – +2.5° Caster Recommended For 2.5" / 3.5" Kits

2 – Install Radius Arm And Caster Cams

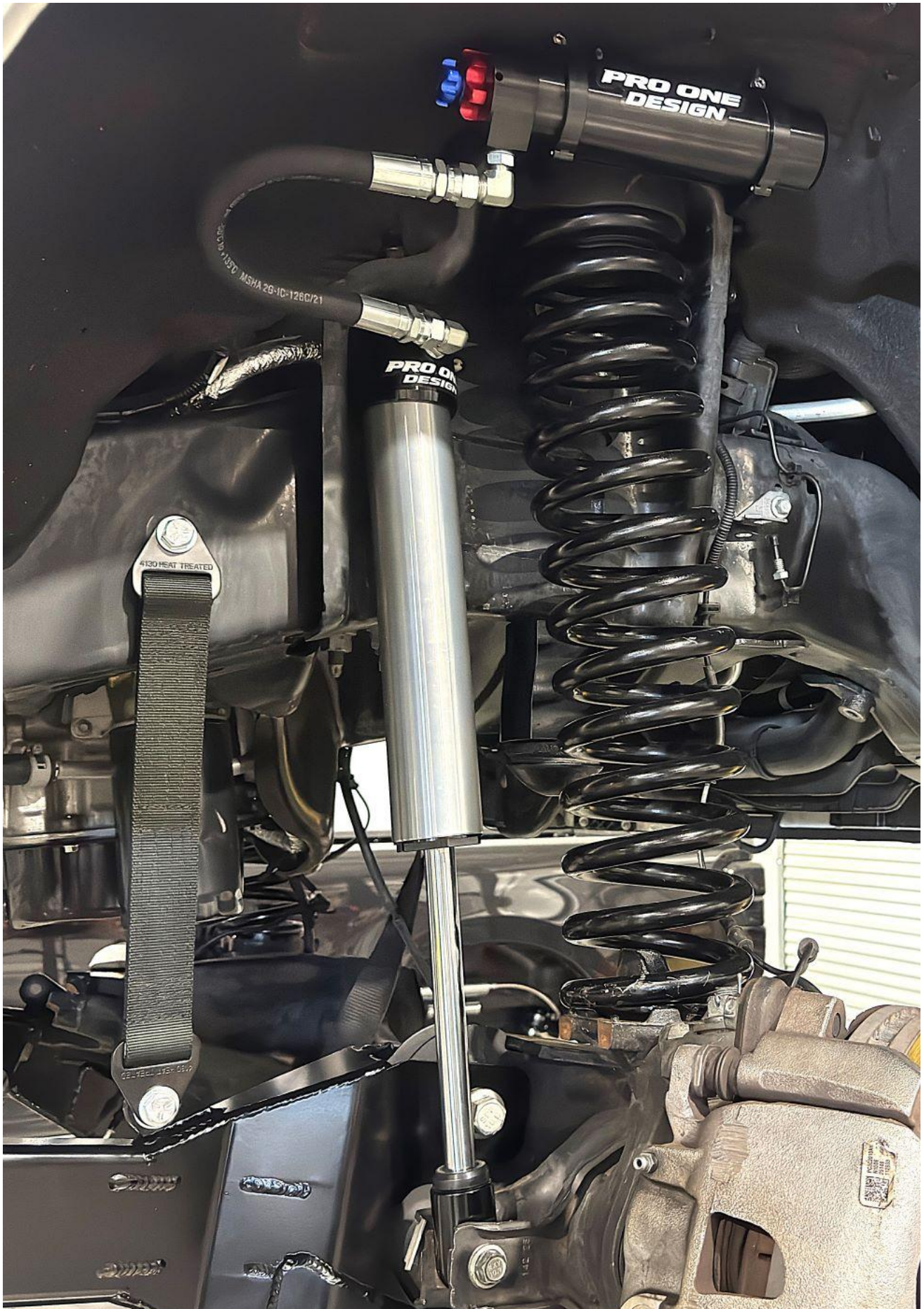
- 1. After Selecting The Correct Caster For Your Application, Install The Matching Caster Cams As A Pair. Always Use Two Identical Cams—One On Each Side Of The Vehicle.**
- 2. Position The Radius Arm In Place And Install The Supplied 18MM-2.5 x 140MM Bolt In The Front Lower Radius Arm Mounting Location As Shown Below.**
- 3. Reinstall The Factory Radius Arm Mounting Bolts In All Remaining Mounting Locations. Leave All Hardware Loose At This Time. Final Torque Will Be Performed With The Vehicle At Ride Height.**



3. Install Limiting Straps

1. Install The Pro One Design Limiting Straps Using The Supplied 1/2"-13 x 1-1/2" Grade 8 Hex Bolts At Both The Upper And Lower Mounting Locations As Shown Below. At The Upper Mounting Location, Install The Supplied Nut Tab Through The Access Hole In The Lower Portion Of The Frame And Align It With The Mounting Hole. Before Installing The Upper Bolt, Place The Supplied 1/4" Flat Washers Between The Frame And The Limiting Strap Bracket To Provide Proper Clearance.
2. Attach The Lower End Of The Limiting Strap To The Pro One Design Fabricated Radius Arm Using The Supplied Hardware.
3. Once Both Ends Of The Limiting Strap Are Installed, Verify That The Strap Is Properly Aligned And That All Hardware Is Tightened To The 80 ft-lbs.





4 – Install Wheels And Tires

1. Install The Front Wheels And Tires Using The Manufacturer's Recommended Wheel Lug Nuts. Tighten The Lug Nuts In A Crisscross Pattern To The Manufacturer's Specified Torque.

Once The Wheels And Tires Are Installed, Carefully Lower The Vehicle To The Ground And Allow The Suspension To Settle At Normal Ride Height Before Proceeding To The Final Torque Procedure.

5 – Torque Radius Arm Hardware

1. With The Vehicle Sitting On Level Ground At Normal Ride Height, Tighten All Radius Arm Mounting Hardware To The Manufacturer's Specified Torque.
2. Torquing The Radius Arm Hardware At Ride Height Prevents Bushing Preload And Ensures Proper Suspension Performance, Ride Quality, And Bushing Life. Verify That All Radius Arm Hardware Has Been Properly Tightened Before Proceeding To The Final Alignment.

6 – Final Suspension Inspection

1. After Completing All Steps Above, Carefully Inspect The Entire Front Suspension And Double-Check That All Components Have Been Properly Installed.
2. Verify That All Mounting Hardware Is Tightened To The Specified Torque, All Brake Lines And ABS Wires Are Properly Routed And Secured, And No Components Are Loose, Misaligned, Twisted, Or Contacting Moving Parts.
3. Confirm That Every Installation Step Is Complete Before Lowering The Vehicle To The Ground And Proceeding With The Final Ride-Height Torque Procedure.



Limited Lifetime Warranty

Pro One Design Stands Behind The Quality Of Its Products And Warrants All Products Manufactured By Pro One Design To Be Free From Defects In Materials And Workmanship For The Original Purchaser. This Limited Lifetime Warranty Applies From The Original Date Of Purchase And Covers Defects Resulting From Normal Intended Use Of The Product.

For Complete Warranty Terms, Limitations, And Claim Procedures, Please Visit The Pro One Design Warranty Page On Our Website.