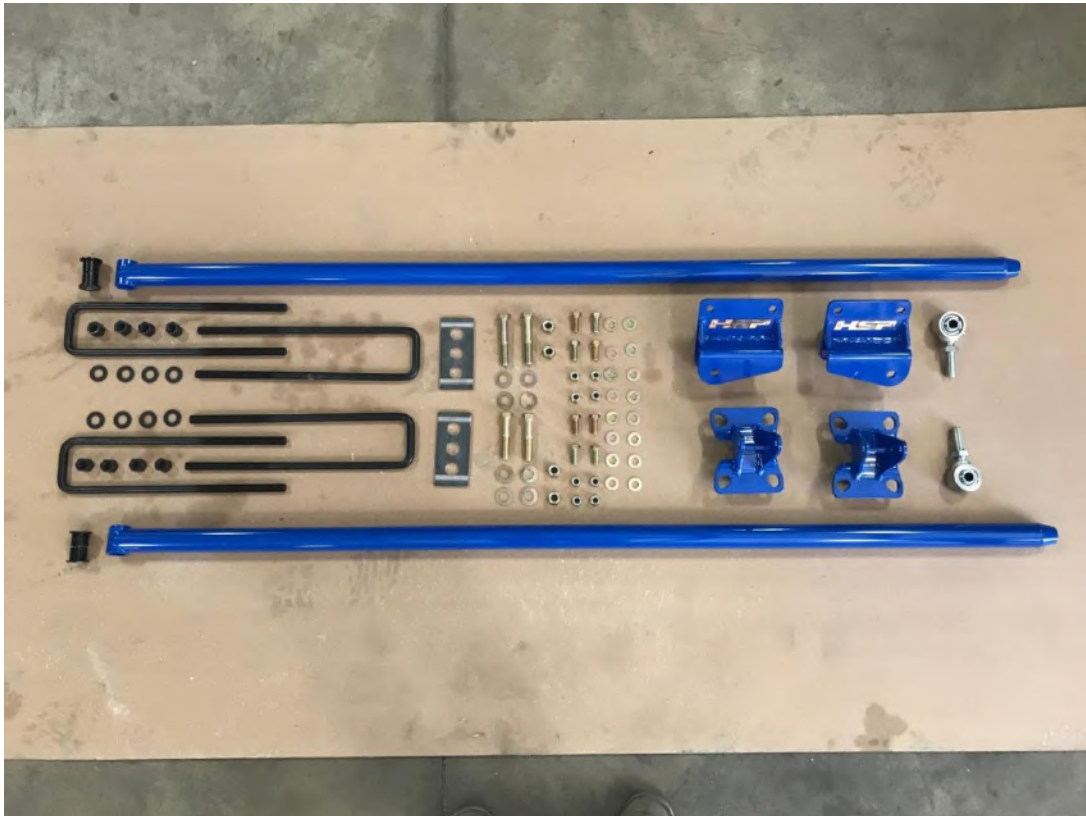


## 535-X-HSP

### 2011-2018 Chevrolet / GMC 58"-70" Bolt On Traction Bars 4" Axle Diameter



(Above picture includes HSP U-bolt flip kit for Ford and Dodge pickups. Actual product may vary depending on application)

#### Tools Required

- ½" Drive Standard Socket Set up to 1"
- Standard wrench set up to 1"
- 8mm 6 point socket
- 3/8" Drill bit
- ½" Drill bit
- Drill
- Torque Wrench
- Step Drill at least 1 1/8" In diameter
- Large C clamp

1. Start by parking the vehicle on a clean level surface. Some trucks may require the use of jack stands to gain enough room to remove the U-bolts.
2. Spray penetrating oil on the threads and nuts of the U-bolts.
3. If your U-bolts look like this STOP and order new U-bolts. The factory U-bolt size is 3"x5/8"x14". We do offer U-bolts just give us a call and we can get some coming for you.



4. Remove the nuts from the U-bolts. It is recommended to do one side at a time to avoid the axle from shifting. With the nuts removed slide the lower plate off the U-bolts.



5. If there is heavy rust scale on the axle tube where the lower bracket was it is recommended to clean the surface so the new brackets have a solid flat surface to sit on.
6. Slide the new bracket into place and reinstall the nuts and washers. Be sure the U-bolts are sitting in the proper position on the top of the leaf spring. Apply anti-seize to the threads of the U-bolts to prevent galling of the threads. Torque the nuts to 100 ft-lbs in an x pattern making

sure the u bolt length is equal side to side and front to back. If new U-bolts were used it may be necessary to trim the excess thread off for a clean look.



7. With one side done do the same procedure to the other side.
8. Now that the rear brackets are in place install the bars into the rear brackets using the supplied 5/8" bolts. The Rear brackets will use the longer bolts. The end of the bar with the polyurethane bushings will be used in the rear. Torque the 5/8" bolts to 50 ft-lbs.
9. Locate the hardware for the front brackets. They will be the (8) black Bolts (8) black washers and (8) black lock nuts. There will also be a pull wire in your kit.



10. Clamp the front bracket to the frame so the front hole is centered over the doubled section of frame.



11. Use a 1/2" Drill bit to mark the center location of the hole. Next use a 3/8" drill bit to drill a pilot hole through the frame. Once the pilot hole is drilled all the way through then use the 1/2" Drill to open the hole up.



12. Now on the inside of the frame rail in the oval section where the frame is the thinnest, drill a 3/8" pilot hole and then open it up with a step bit until the head of the bolt fits through the hole (about 1 1/8")



13. Locate the pull wire supplied with your hardware kit. It will be necessary to modify the wire slightly so it properly fits the supplied bolts. Using a pair of pliers gently bend the wire open to clear the Hex cut in the end of the bolt.



14. Feed the wire through the hole drilled in the back side of the frame rail and gently pull the wire and bolt through the hole drilled for the bracket.



15. Install the washer over the pull wire and use it to help hold the bolt in place while removing the pull wire. With the pull wire removed install the lock nut onto the bolt. Use an 8mm socket to hold the bolt while tightening the nut with a  $\frac{3}{4}$ " wrench. Make sure the 8mm socket stays fully engaged on the bolt to prevent stripping the hex.



16. With the bolt tightened to ensure the bracket doesn't move drill the remaining three holes and repeat the same procedure on the other side.

17. With all 4 holes drilled torque the  $\frac{1}{2}$ " bolts to 30 ft-lbs

18. With the front brackets in place, adjust the heim joints so they align in the hole of the bracket making sure the zerk fitting is on the bottom so it is accessible to grease the joints. Install the  $\frac{5}{8}$ " bolts and torque to 50 ftlbs.

19. It is recommended to recheck all fastener torques after 500mile of driving. We also recommend greasing the front heim joints at every oil change interval.