

INSTRUCTIONS

910-32117

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1949-54 Chevy Cars Deluxe Kingpin Kit

**PLEASE READ INSTRUCTIONS COMPLETELY
BEFORE STARTING YOUR INSTALLATION**

NOTE: Spindle modification is required to install this needle bearing king pin kit. The I.D. of the kingpin bore must be machined out to 1.062/1.063. Failure to machine the kingpin bore to this dimension will result in damaged kingpin bearings.

PARTS LIST

Index no.	Description	Qty
	Installation tool	1
1	Needle bearing	8
2	King Pin	2
3	Thrust bearing	2
4	Shims	4
5	Lock pin	2
6	3/8"-24 nut	2
7	3/8" Lock washer	2
8	O-ring	4
9	Grease fitting cap	4
10	Grease fitting	4
11	SS Set Screw	4

1. Using the parts list above, double check that you received all the parts in the kit. Please report any missing parts to our customer service department.

If you purchased Speedways Spindles & Deluxe king pin kit 910-32108 you can skip down to step #3.

2. Remove the brake assemblies and any front end components as required to allow removal the old kingpins. With the king pins removed separate the spindle from the axle and remove the bushings from the spindle. The I.D. of the kingpin bores in your spindles need to be machined.

Most local machine shops should be able to perform this operation. The I.D. of the kingpin bores will need to machined out to 1.062 min./1.063max.

NOTE: Failure to machine the king pin bores to this dimension will result in damaged kingpin bearings. Remove any burrs or sharp edges which could cause damage to the new bearings

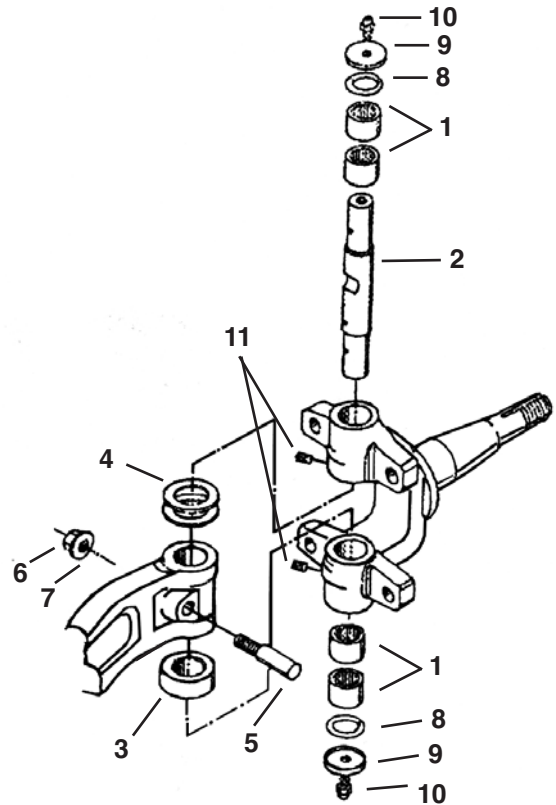
3. Begin the installation by driving or pressing the needle bearings into the lower spindle boss using the installation tool provided. Install the bearings with the flat side of the bearing towards the installation tool. Drive or press the outer bearings in first, they should be driven in until they are flush with the edge of the snap ring grooves. Drive or press the inner bearing in on the lower spindle boss next, the bearings should be pressed in flush with the inner edge of the spindle.

4. Place the thrust bearing onto the lower spindle boss with the flat ground surface pointing down.
5. Slide the spindle into place over the axle and align the king pin bores. Carefully slide the king pin through the axle, thrust bearing and all the way into the needle bearings all ready installed in the lower spindle boss.

NOTE:

The end of the king pin with the extra hole for greasing the thrust bearing must be installed down.

6. Check the spindle for excessive end play. While maintaining upward pressure on the spindle use a feeler gage to check the clearance between the top of the axle boss and the bottom side of the upper spindle boss. If this clearance exceeds .006 remove the kin pin and install one or two of the supplied shims until this clearance is less than .006. Be sure the center hole in the shim is aligned with the king pin hole to prevent bending the shim while installing the king pin.
7. Rotate the king pin so that the lock pin notch in the king pin is aligned with the lock pin hole in the spindle. Insert the threaded end of the lock pin into the lock pin hole from the front side of the axle, making sure it engages the notch in the king pin. Install the lock washer, nut and leave hand tight.
8. Support the spindle with a floor jack or blocks of wood and install one of the bearing into the upper spindle boss. Drive the bearing in using the installation tool making sure the flat side of the bearing is toward the installation tool; drive the bearing in until it just touches the top of the axle boss. Install the last bearing in the same manner until it is flush with the edge of the snap ring groove.
9. Move the spindle back and forth to make sure it rotates freely and doesn't have excessive end play. Torque the lock pin nuts to 55-65 ft. lbs. Install the snap rings in both the upper and lower spindle bores.
10. Install the rubber o-rings into the lip of the end caps and install the caps onto both ends of the king pins securing them with the grease fittings.
11. The king pins will now be greased through the grease fittings on the ends of the king pins. Remove the original grease fitting from the stock location and replace them with the set screws (#11) supplied. The set screws should be installed so they are flush with the spindle surface. **DO NOT** turn the set screws all the way in which could damage the bearings. A small drop of Loctite on the set screws will insure that they will not back out.
12. Using a grease gun grease both ends of the king pins.
13. Re-assemble the brakes, brake lines and front suspension. Double check the steering for smooth operation. Installation is now complete.



IMPORTANT

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BRAKE INSTALLATION ALERT

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Some items are not legal for sale or use in California on pollution controlled motor vehicles. These items are legal in California for racing vehicles only which may never be used upon a highway.

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