

INSTRUCTIONS

910-31923

910-31928

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910-31923 11⁵/₈" REAR DISC BRAKE KIT FOR 7.5 GM REAR END

910-31928 11⁵/₈" REAR DISC BRAKE KIT FOR 7.5 GM REAR END WITH EMERGENCY BRAKE CALIPERS

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

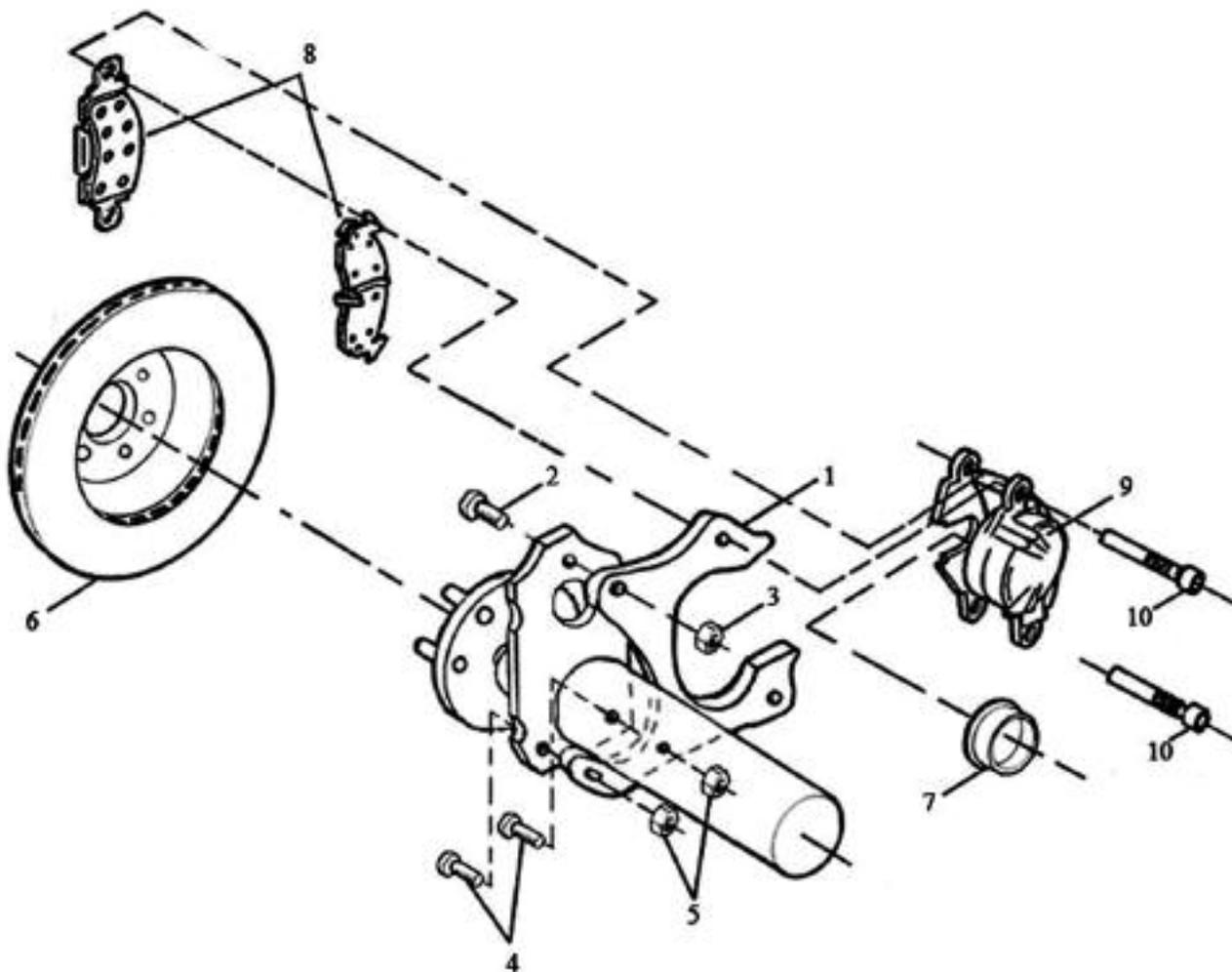
This bolt-on rear disc brake kit adapts GM '93-'97 Camaro 11⁵/₈" rotors and '78-'88 GM metric front calipers or '79-'85 Cadillac Seville metric rear calipers with emergency brakes to 7.5 GM rear ends.

Parts List

Index No.	Description	Part Number	Quantity
PARTS LIST: 910-31923 NON EMERGENCY BRAKE CALIPERS			
	Hardware kit	910-31923-2	1
1	Caliper brackets set	910-31923-1	1
2	9/16"-18 x 1 ¹ / ₂ " GR 8 hex bolt	in hardware kit	2
3	9/16"-18 locking nuts	in hardware kit	2
4	3/8"-24 x 1 ¹ / ₄ " GR 8 bolts	in hardware kit	4
5	3/8"-24 locking nuts	in hardware kit	4
6	11 5/8" GM 93-97 Camaro rotors	910-31043	2
7	Brake pad spacer	910-41909	2
8	Brake pad set	910-3381	1
9	GM metric caliper (left) non e/brake	910-31045-L	1
9	GM metric caliper (right) non e/brake	910-31045-R	1
10	Caliper bolts	835-2300542	4
PARTS LIST: 910-31928 WITH EMERGENCY BRAKE CALIPERS			
	Hardware kit	910-31923-2	1
1	Caliper brackets	910-31923-1	1
2	9/16"-18 x 1 ¹ / ₂ " GR 8 hex bolt	in hardware kit	2
3	9/16"-18 locking nuts	in hardware kit	2
4	3/8"-24 x 1 ¹ / ₄ " GR 8 bolts	in hardware kit	4
5	3/8"-24 locking nuts	in hardware kit	4
6	11 5/8" GM 93-97 Camaro rotors	910-31043	2
7	Brake pad spacer	910-41909	2
8	Brake pad set	919-15620	1
9	GM metric emergency brake caliper (left)	910-31046-L	1
9	GM metric emergency brake caliper (right)	910-31046-R	1
10	Caliper bolts	835-2300542	4
Other parts needed:			
	Emergency brake cables	491-80FU	1

BRAKE INSTALLATION ALERT: The selection and installation of brake components should only be done by personnel experienced in the proper installation and operation of braking systems. The installer must use his/her own discretion to determine the suitability of the brake components and brake kits for every particular application.

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1. Using the parts list supplied, double check that you received all the parts in this kit. If there are any missing parts, please contact the customer service department.
2. Remove the axles and backing plates from the rearend. Refer to a GM service manual for this procedure.
3. Clean and wire brush the housing flanges and inspect for damage or any burrs that would interfere with the mounting of the caliper brackets.
4. Drill out both lower holes in the housing flanges to 3/8".
5. Install the caliper bracket (#5) to the inside of the housing flange. The caliper opening points to the rear. Install the 9/16"-18 x 1 1/2" GR 8 bolt (#2) into the upper mounting holes, installing them from the axle side. Secure with the 9/16"-18 locking nuts (#3) Install the two 3/8"-24 x 1 1/4" GR 8 bolts (#4) into the lower mounting holes, installing them from the axle side. Secure with the 3/8"-24 locking nuts (#5). Make sure the caliper brackets mount flush to the housing flange. Torque the upper 9/16" bolt to 53-81 ft. lbs. and the lower 3/8" bolts to 16-24 ft. lbs.

6. Before installing the axles it's a good idea to install new axle seals.
7. Reinstall the axles.
8. Install the rotors (#6) on the axles, making sure that both the axle and the rotor surfaces are clean and free of any debris that would cause the rotor to wobble. Hold the rotor in place with a couple of lug nuts. In some cases the axle flanges may interfere with the I.D. of the rotor. In these cases the axles have to be turned down for the rotor to fit. This would must be done in a lathe by a machine shop.
9. Install the brake pad spacer (#7) into the piston of the caliper (#9). Install the brake pads (#8) into the calipers (#9). Slide the caliper over the rotor and into the caliper bracket, making sure the bleeders are pointing up. Use only use the correct GM mounting bolts (#10).
10. Install the brake hoses making sure you check that the line has clearance through the entire suspension travel. Bleed the system as normal. Note: The caliper fitting is a 7/16"-20 thread.
11. Before operating the vehicle, test the brakes under controlled conditions. Make several stops in a safe area from low speeds and gradually work up to operating speeds.

NOTE: Follow instruction sheet 910-31046 for setting and bleeding emergency brake caliper.

IMPORTANT

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