

## 1937 -1939 Chevy Rear Leaf-Spring Kit Installation Instructions

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**Read and understand these instructions before starting any work!**  
**SUPPORT VEHICLE WITH JACK STANDS BEFORE DOING ANY**  
**WORK!**

**INSTALLATION IS FOR DRIVER SIDE. REPEAT FOR PASSANGER SIDE**  
**Welding should be done by a qualified welder!**

1. Start by raising the car and supporting it with jack stands. Remove old suspension components. (Shock, Rear-end, Leaf spring etc.)

2. We will start by installing the driver's side front leaf-spring hanger bracket (Part stamped "L"). When removing the leaf-spring bracket, make sure to mark the two existing front rivet holes (Fig. 1), as these holes will be used to locate the TCI front leaf spring bracket. With the supplied fasteners tighten the front leaf-spring bracket into place. (Diag. 1a). (Slotted holes must be pointed towards the front of the car) Making sure that the bracket is square with the frame. Next, you will need to drill 2 additional 3/8" holes. (Clamping the bracket to the frame will make the drilling easier)

- **Note:** After drilling each hole, insert another bolt and tighten it to the specified torque. This will help keep the bracket in position. Finish by tightening all hardware to the specified torque (see note below).

3. Next we will install the TCI rear shackle bracket. First remove the old shackle bracket. Making sure to mark the front most hole (Fig. 2). As this will be used to locate the TCI rear shackle bracket (Diag. 2a). Locate the bracket to the frame using the existing front hole (3/8"-16 X 1"). Next, you will need to drill 3 additional 3/8" holes. (Clamping the bracket to the frame will make the drilling easier). Make sure to install the frame spacer in the two front holes.(Diag. 2a)

**Note:** After drilling each hole, insert another bolt (3/8"-16 X 1") and tighten it to the specified torque. This will help keep the bracket in position. Finish by tightening all hardware to the specified torque (see note below).

4. Continue installation on the passenger side. Once the installation of the brackets is complete measure the following:

- TCI Front Leaf Spring Hanger Center to Center: 42 1/4"  $\pm 1/8''$
- TCI Rear Shackle Hanger Center to Center: 42 1/4"  $\pm 1/8''$
- If you are using your old rear-end TCI will provide you with the 2" lower TCI leaf-spring pad bracket. Center to Center: 42 1/4"  $\pm 1/16''$
- Rear-end pinion angle:  $-3^\circ$  (Pointing down)  $\pm .05^\circ$   
(Reference from the face of the 3<sup>rd</sup> member mount)

5. Before installing the leaf-spring into position, it will be easier to mount the TCI Rear Upper Shock X-member now. Start by removing the rear body mounting bolt and replace it with the equipped bolt (3/8"-16 X 5 1/2"). Next remove the rivets that fasten the old rubber bump stop, mark the front most mounting hole as this will be used to locate the TCI Rear Upper Shock X-member (Fig. 3). Once the X-member is mounted in position tighten it to the specified torque. Drill the remaining 4 holes (2-Left / 2-Right) [3/8"-16 X 1"]. Finish by installing the bump stop on the TCI Rear Upper Shock X-member.

6. Now we can start by mounting the leaf-spring into position using the supplied 1/2"-20 X 4 1/2" NF Hex Bolt. Pre-assemble the leaf-spring by inserting the urethane bushing into position. The built in rubber bushing on the leaf-spring mounts towards the front of the vehicle. Before mounting the leaf-spring & shackle to the frame, lift the rear-end into position onto a jack and mount the shackle to the frame. Make sure that the aligning pin on the leaf-spring is positioned on the rear-end. Next, place the U-bolt and 5-hole plate into position (Fig. 4) and fastened it with the equipped 1/2"-20 Full Height Nyloc. Mount the lower shock stud into the 5-hole plate and tighten the fastener to the specified torque.

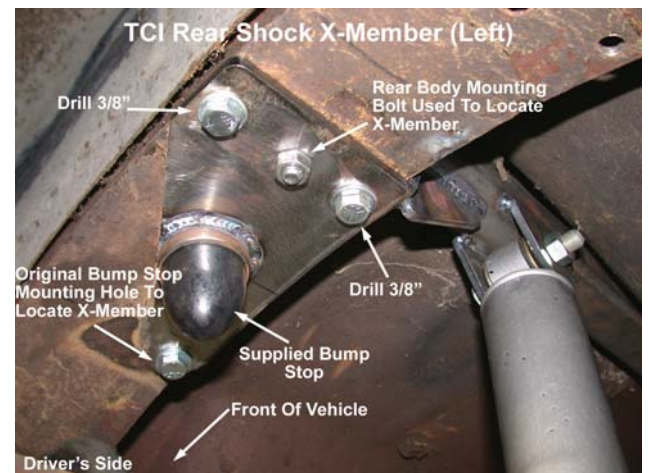
7. Finish by installing the rear shock (Fig. 5, 6).

**TORQUE CHART:**

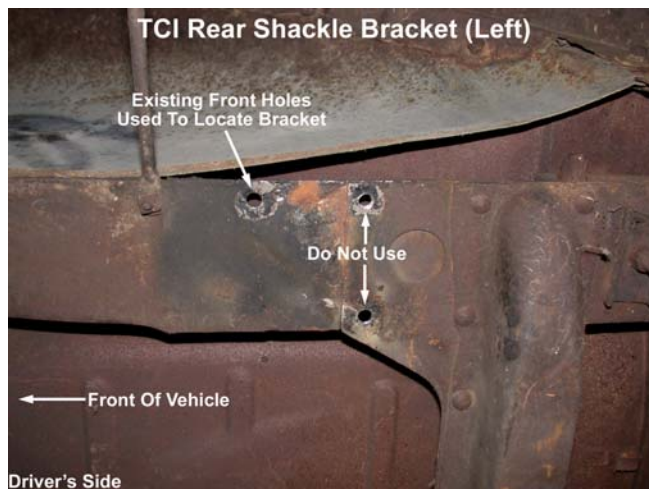
3/8"-16	30 lb. ft
7/16"-20	50 lb. ft
1/2"-20	70 lb. ft
5/8"-18	140 lb. ft



**Fig 1**



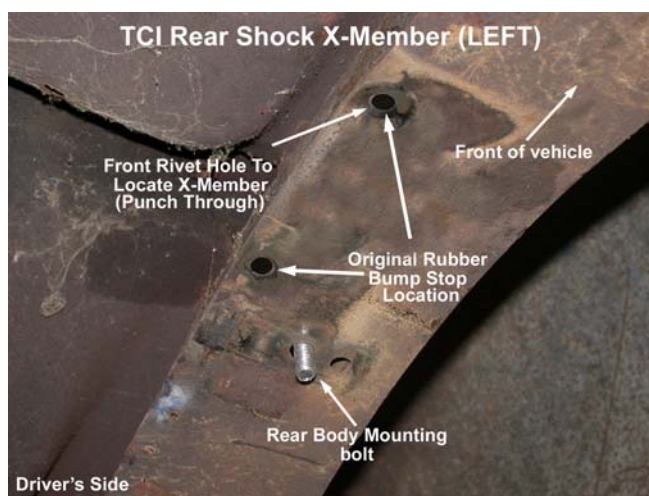
**Fig 4**



**Fig 2**



**Fig 5**



**Fig 3**



**Fig 6**

<b>Component:</b>	<b>Qty.</b>	<b>Description</b>
TCI Front Leaf-Spring	1 pr.	(L & R)
Includes:	8	3/8"-16 X 1" NC Hex Bolt
	8	3/8" Flat Washer (Bracket Side)
	8	3/8"-16 Full Height Nyloc
Rear Shackle Hanger Bracket	1 pr.	(L & R)
Includes:	8	3/8"-16 X 1" NC Hex Bolt
	8	3/8" Flat Washer (Bracket Side)
	8	3/8"-16 Full Height Nyloc
	1 Set	TCI Rear Leaf-Spring Mounting Hardware Kit
Includes:	8	Rear Urethane Leaf Hanger
		Bushing (Shackle & Leaf Spring)
	4	Rear Shackle Pins (7/16"-20)
		(Shackle & Leaf Spring)
	10	7/16"-20 Full Height Nyloc
		(Shackle & Leaf Spring)
	4	Rear Leaf Dog Bone (7/16" Hole)
		(Shackle & Leaf Spring)
	2	1/2"-20 X 4 1/2" NF Hex Bolt
		(Mount Front Leaf-Spring)
	12	1/2"-20 Full Height Nyloc
	2	Lower Shock Mount Stud (5-Hole Stud)
	2	7/16" Flat Washer (Lower Shock Stud to Shock)
	4	2" Extended U-Bolt 1/2"-20
	2	5-Hole Plate (Left & Right)
	1 Set	2" Lower Leaf Spring Pad (Only Without Rear-End Purchase)
	1 pr.	35"- 48" Rear Leaf-Spring
	1 pr.	Rear Shock
	1	37"- 39" TCI Rear Upper Shock Crossmember & Bump Stop Bracket
Includes:	1 pr. (L&R)	5 Hole Plate
	2	Lower Shock Mounting Stud (Mounts to 5-Hole Plate)
	2	1/2"-20 U-Bolt / 2" Longer
	8	1/2"-20 Full Height Nyloc
	2	Rubber Bump Stop (Long)
		(Cut Threads to 5/8" Long)
	4	7/16"-20 Full Height Nyloc
	2	7/16"-20 X 2 1/2" NF Hex Bolt (Upper Shock Mount)
	2	7/16" Flat Washer