

This brake kit uses Speedway Motors metric calipers and 11" Speedway Motors rotors 4-1/2" or 4-3/4" Bolt Circle to Speedway Motors Modified 49-54 Chevy spindles.

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

These brake kits will require spindle modifications if you are using OEM 49-54 GM spindles!

You can purchase spindles from Speedway Motors and eliminate having to find spindles or having yours machined. Or if you already have spindles you can send them to Speedway Motors and we will do all the machine work for you.

916-32100 NEW 49-54 Chevy modified forged steel spindles

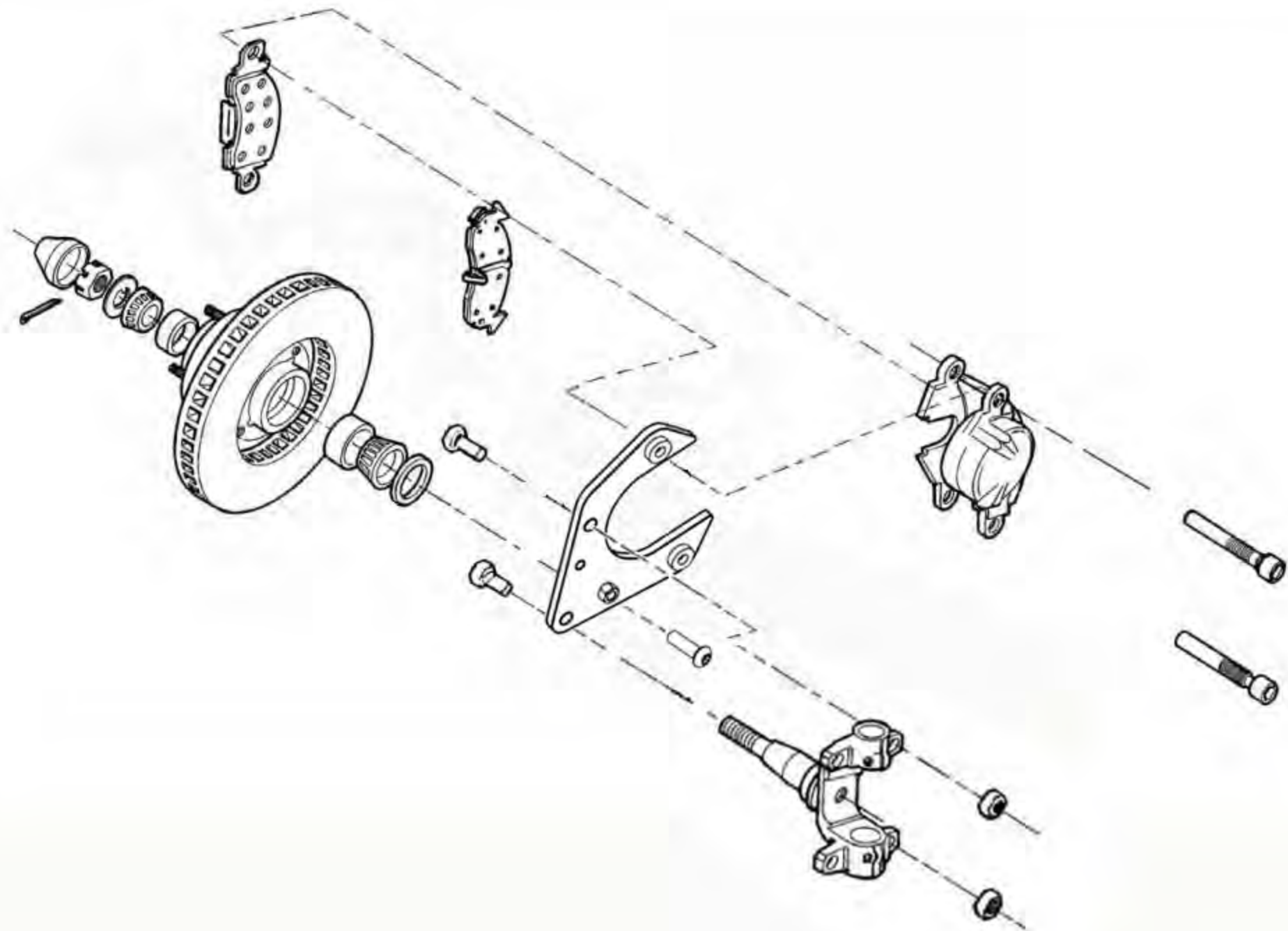
916-32101 machining of your 49-54 Chevy spindles

		<b>Parts list</b>	
Index	Part number	Description	Qty
	91096267	Bracket kit	1
2	-91096267.3-L	Left bracket	1
2	-91096267.3-R	Right bracket	1
	-91096267.1	hardware kit	1
3	-HZ8HCSF-.44-1.50	7/16"-20 x 1-1/2" GR 8 hex bolts	4
4	-HZ8HCSF-.44-1.75	7/16"-20 x 1-3/4" GR 8 hex bolts	2
5	-HZ5NLNF-.44	7/16"-20 Nylock nut	6
6	-HZ5HNF-.38	3/8"-24 hex nut	2
7	-HB8BSCSF-.38-1.25	3/8"-24 x 1-1/4" Button head bolt	2
8	912TLM67048	Inner bearing cone	2
9	912S18565	Seal	2
10	91031070	Speedway brake rotor 4-3/4 BC	2
10	91031066	Speedway brake rotor 4-1/2" BC	2
11	912TLM11949	Outer bearing cone	2
	910616005	Spindle nut kit	1
12	-910615065	Spindle washer	2
13	-910618013	Spindle nut	2
14	-HZ0CP-.13-1.75	Cotter pin	2
15	91031071	Dust cap set	1
16	9193381	Brake pad set	1
17	91031045-L	IMCA Metric caliper left	1
17	91031045-R	IMCA Metric caliper right	1
18	8352300542	Slide bolt	4

**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. Speedway Motors, Inc. makes no warranties, either expressed or implied, including any warranty of merchantability or fitness for a particular purpose, other than those contained in its current catalog or website with respect to the goods identified on the face of the invoice. There is no warranty expressed or implied as to whether the goods sold hereby will protect the purchaser or ultimate user of such goods from injury or death.

## Brake kit installation

1. The caliper brackets mount to the rear of the spindle and on the outboard side of the mounting flanges. The welded bosses on the brackets face to the inside. Install the caliper brackets #2 on to the spindle #1, using the 7/16"-20 x 1-1/2" GR 8 bolts #3 and the 7-16"-20 nylock nuts #5 on the upper mounting flanges. Use the longer 7/16"-20 x 1-3/4" GR 8 bolts # 4 and the 7-16"-20 nylock nuts #5 on the lower mounting flanges. **NOTE:** The lower bolt also bolts the steering arms to the spindle. Use the remaining 7/16"-20 x 1-1/2" GR 8 bolts and nylock nuts to bolt the front of the steering arm to the spindle. Torque the bolts to 80 ft. lbs.
2. Install the 3/8"-24 nut #6 and the 3/8"-24 button head bolt #7 into the threaded hole on the inside of the caliper bracket. This is your steering stop and will be adjusted in a later step.
3. Pack and install the inner bearings #8 with fresh disc brake bearing grease and install the grease seals #9. Seals must be installed straight; we recommend using a seal installation tool to install the seal.
4. Install the rotor #10 on to the spindle #1. Pack and install the outer bearing #11. Install the spindle washer #12 and spindle nut #13. Adjust the bearing preload as normal. Install the cotter pin #14 and dust cap #15.
5. Install the brake pads #16 into the calipers #17 and install the calipers on to the mounting brackets #2 with the bleeders pointing up. Only use the correct GM mounting bolts # 18. **NOTE: Some GM metric calipers have a small tab cast into the body that will interfere with the caliper brackets. This can be easily ground off for clearance.**
6. Adjust your steering stops. Turn your steering box from lock to lock and check for any interference with brake and suspension components. Adjust the 3/8" button head bolt #7 accordingly and tighten the 3/8" nut #6.
7. Install the brake lines making sure you check that the lines have clearance through the entire suspension travel, and turning radius. Bleed the system as normal.
8. 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.



# 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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