

# INSTRUCTIONS

**910-31923**

**910-31928**

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## **910-31923 11-5/8" Rear Disc Brake Kit for 7.5 GM Rear End**

## **910-31928 11-5/8" Rear Disc Brake Kit for 7.5 GM Rear End with Emergency Brake Calipers**

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

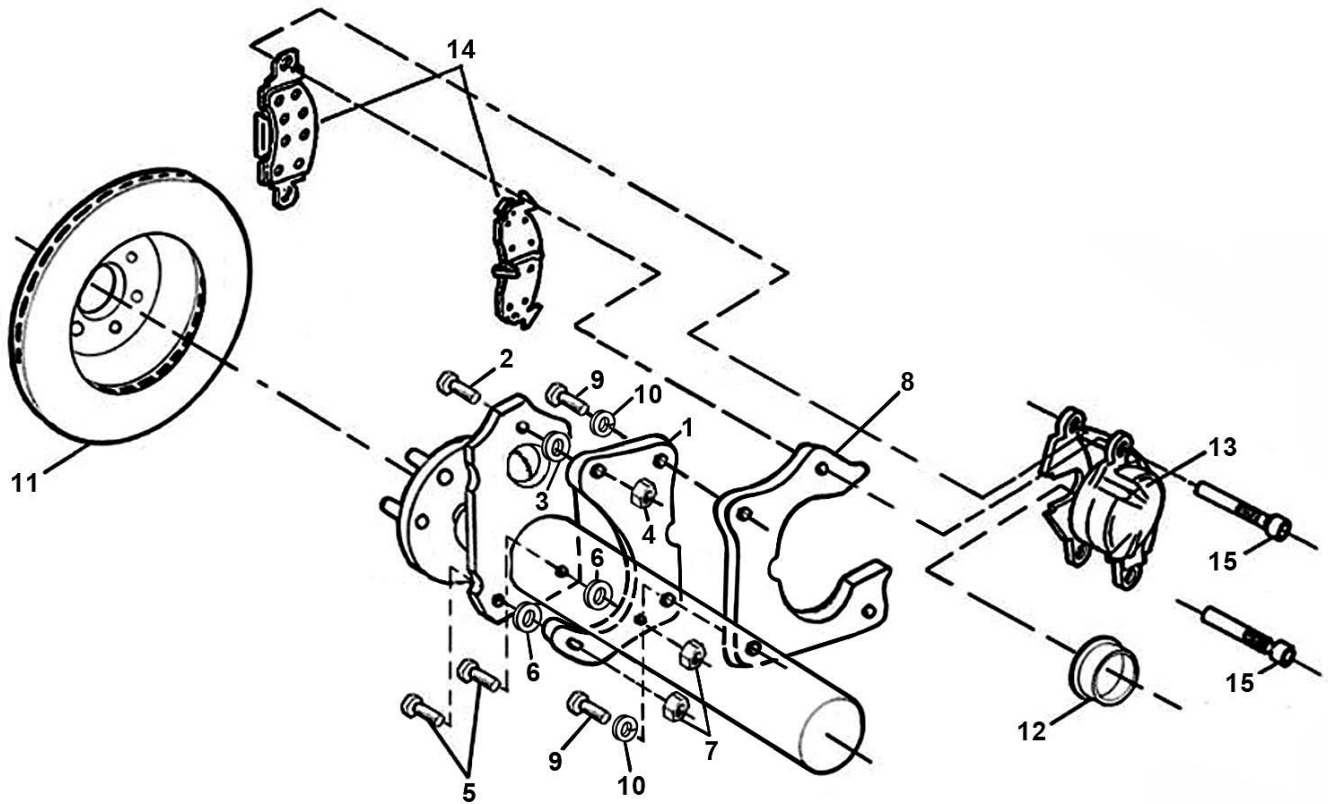
This bolt-on rear disc brake kit adapts GM '93-'97 Camaro 11 5/8" rotors and '78-'88 GM metric front calipers or '79-'85 Cadillac Seville metric rear calipers with emergency brakes to 7.5 GM rear ends.

### **Parts List**

| <b>Index No.</b>                                           | <b>Description</b>                    | <b>Part Number</b> | <b>Quantity</b> |
|------------------------------------------------------------|---------------------------------------|--------------------|-----------------|
| <b>PARTS LIST: 910-31923 NON EMERGENCY BRAKE CALIPERS</b>  |                                       |                    |                 |
|                                                            | Hardware kit                          | 910-31923-2        | 1               |
|                                                            | Caliper bracket set                   | 910-31928          | 2               |
| 1                                                          | Housing bracket                       | bracket kit        | 2               |
| 2                                                          | 9-16"-18 x 1-1/2" Gr. 8 hex bolt      | hardware kit       | 2               |
| 3                                                          | 9/16" ID x 7/8" OD x 1/8" thk. spacer | bracket kit        | 2               |
| 4                                                          | 9/16"-18 Nylock nut                   | hardware kit       | 2               |
| 5                                                          | 3/8"-24 x 1-1/4" Gr. 8 hex bolt       | hardware kit       | 4               |
| 6                                                          | 3/8" ID x 5/8" OD x 1/8" thk. Spacer  | bracket kit        | 4               |
| 7                                                          | 3/8"-24 nylock nut                    | hardware kit       | 4               |
| 8                                                          | Caliper bracket                       | bracket kit        | 2               |
| 9                                                          | 3/8"-24 x 1 Gr. 5 Hex bolt            | bracket kit        | 4               |
| 10                                                         | 3/8" Lock washer                      | bracket kit        | 4               |
| 11                                                         | 11-5/8" GM 93-97 Camaro rotor         | 910-31043          | 2               |
| 12                                                         | Brake pad spacer (non E-brake only)   | 910-41909          | 2               |
| 13                                                         | GM Metric caliper (left)              | 910-31047-L        | 1               |
| 13                                                         | GM Metric caliper (right)             | 910-31047-R        | 1               |
| 14                                                         | Brake pad set                         | 910-3381           | 1               |
| 15                                                         | Caliper bolts                         | 835-2300542        | 4               |
| <b>PARTS LIST: 910-31928 WITH EMERGENCY BRAKE CALIPERS</b> |                                       |                    |                 |
|                                                            | Hardware kit                          | 910-31923-2        | 1               |
|                                                            | Caliper bracket set                   | 910-31928          | 2               |
| 1                                                          | Housing bracket                       | bracket kit        | 2               |
| 2                                                          | 9-16"-18 x 1-1/2" Gr. 8 hex bolt      | hardware kit       | 2               |
| 3                                                          | 9/16" ID x 7/8" OD x 1/8" thk. spacer | bracket kit        | 2               |
| 4                                                          | 9/16"-18 Nylock nut                   | hardware kit       | 2               |
| 5                                                          | 3/8"-24 x 1-1/4" Gr. 8 hex bolt       | hardware kit       | 4               |
| 6                                                          | 3/8" ID x 5/8" OD x 1/8" thk. Spacer  | bracket kit        | 4               |
| 7                                                          | 3/8"-24 nylock nut                    | hardware kit       | 4               |
| 8                                                          | Caliper bracket                       | bracket kit        | 2               |
| 9                                                          | 3/8"-24 x 1 Gr. 5 Hex bolt            | bracket kit        | 4               |
| 10                                                         | 3/8" Lock washer                      | bracket kit        | 4               |
| 11                                                         | 11-5/8" GM 93-97 Camaro rotor         | 910-31043          | 2               |
| 13                                                         | GM Metric E-brake caliper (left)      | 910-31046-L        | 1               |
| 13                                                         | GM Metric E-brake caliper (right)     | 910-31046-R        | 1               |
| 14                                                         | Brake pad set                         | 919-15620          | 1               |
| 15                                                         | Caliper bolts                         | 835-2300542        | 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.

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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 9/16"-18 x 1-1/2" Gr. 8 bolt (#2) into the upper hole in the housing flange from the axle side of the flange. Install a 1/8" spacer (#3) and then install the housing bracket (#1) to the inside of the axle housing flange. Secure with the 9/16"-18 locking nut (#4) and leave hand tight.
6. Install the two 3/8"-16 x 1-1/4" Gr 8 bolts (#5) through the lower housing flange holes from the axle side. Install the 1/8" spacers (#6) between the housing flange and the caliper bracket. The caliper opening points to the rear. Secure with the two 3/8"-16 nylock nuts (#7). Tighten the two 3/8" bolts to 16-24 ft. lbs. and the 9/16" bolts to 53-81 ft. lbs.
7. Using the 3/8"-24 x 1 Gr. 5 bolts (#9) and the 3/8" lock washers (#10) bolt the caliper bracket (#8) to the outboard side (axle side) of housing bracket (#1). Torque the bolts to 16-24 ft. lbs.

8. Before installing the axles it's a good idea to install new axle seals.
9. Reinstall the axles.
10. Install the rotors (#11) 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.
11. Install the brake pad spacer (#12) into the piston of the caliper (#13). Non-E-brake caliper only. Install the brake pads (#14) into the calipers (#13). 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 (#15).
12. 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 10mm x 1.50 thread.
13. 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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