

INSTRUCTIONS

'37-'48 FORD SPINDLES 11" GM MID SIZE CALIPERS AND '73-'77 GM ROTORS

910-31941

**COMPLETE BRAKE
KIT-CAD PLATED**

916-31901

BASIC KIT CAD PLATED

916-31902

BASIC KIT CHROME PLATED

NOTE: NOT FOR USE WITH BOLT ON STEERING ARMS.

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

This disc brake kit allows you to install '73-'77 11" GM rotors and '69-'77 GM mid size calipers on your

Parts List

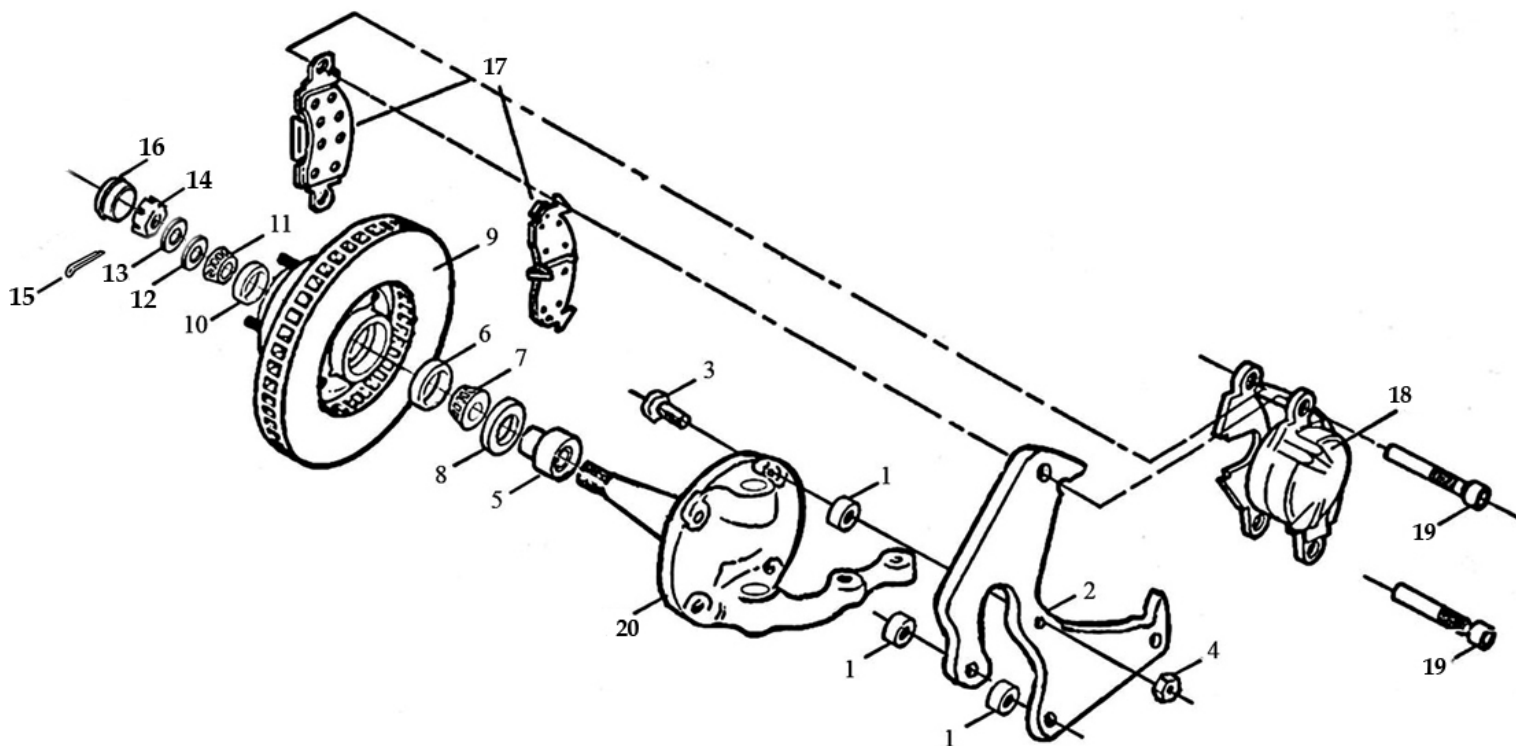
Index No.	Description	Part Number	Quantity
*	Hardware kit	916-31901-4	1
1	Bracket spacers	in hardware kit	6
2*	Caliper mounting brackets cad plated	916-31901-1-ZINK	2
2*	Caliper mounting brackets chrome plated	91631901-2	2
3	1/2"-20 x 11/4" GR 8bolts	in hardware kit	6
4	1/2"-20 Self locking nuts	in hardware kit	6
5	Bearing adapter	910-09301	2
6*	Inner bearing cup	912-TL68110	2
7*	inside bearing cone	912-TL68149	2
8*	Grease seal	912S18562	2
9	11" 73-77 GM rotors	910-31063	2
10	Outer bearing cup	912-TLM11910	2
11	Outer bearing cone	912-TLM11949	2
12	Spacer washer	in hardware kit	2
**	Spindle nut kit	910-616004	1
13	Spindle washer	in spindle nut kit	2
14	Spindle nut	in spindle nut kit	2
15	Cotter pin	in spindle nut kit	2
16**	Dust cap (pr)	550-2486	1
17	Brake pads 69-77 GM (set)	9193382	1
18	Calipers 69-77 Intermediate GM right	910-31035-R	1
	Caliper 69-77 Intermediate GM left	910-31035-L	1
19	Caliper bolts	835-23005422	4
20**	Spindle (pr)	916-32104	1
Other parts needed			
**	16" Stainless steel brake line kit 7/16-20 thread	617-8562	1

* Basic kit parts only
** Not included

Speedway Motors Inc., P.O. Box 81906
Lincoln, NE 68501 (402) 323-3200
www.speedwaymotors.com



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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. We recommend the use of all new or remanufactured components for this installation. If you are using any used components, it is the installers responsibly to determine the acceptably of the parts.
3. Carefully press the bearing adaptor (#5) onto the spindle, making sure the flanged side goes toward the spindle. Make sure the adaptor is fully seated against the spindle. We recommend using a hydraulic press for pressing on the bearing adaptor. Or the adaptor can be heated at 400° for 20 minutes and then slide onto the spindle, allow to cool slowly at room temperature.
4. Remove the stock GM inner bearing race from you rotor and replace it with the inner bearing race #6 supplied in the kit. **NOTE:** The stock inner bearing race will not work with this kit. It must be replaced with the race supplied.
5. Bolt the caliper bracket (#2) to the spindle (#20), it mounts to the back side of the spindle from the axle side and the caliper mounts to the rear. Install the 1/2"-20 x 1 1/4" mounting bolts (#3) from the rotor side of the spindle. Install the .120 thick spacers #1 between the spindle (#20) and the caliper bracket (#2). Install the 1/2"-20 locking nuts (#4) and torque them to 38-57 ft. lbs. making sure you use loctite on the threads.
6. Pack and install the inner bearing (#7) with fresh disc brake bearing grease, and install the grease seal (#8) into the rotor. The seals must be installed straight; we recommend a seal installation tool for this.
7. Install the rotor (#9) on to the spindle (#20), pack and install the outer bearing #(11). Install the spacer washer (#12), spindle washer (#13) and spindle nut (#14). Adjust the bearing preload as normal. Install the cotter pin (#15) and the dust cap (#16).
8. Install the brake pads (#17) into the calipers (#18) and install the calipers on to the mounting brackets #1 with the bleeders pointing up. Only use the correct GM mounting bolts (#19).
9. Install new brake lines making sure you check that the lines have clearance through, the entire suspension travel and turning radius. Bleed the system as normal.

NOTE: Some wheels will not clear the snout on the rotors. If necessary the rotor can be machined for clearance. Some brands of wheels may interfere with the top of the caliper. If necessary you can grind a small amount of material off the top of the caliper, at the point of contact.

IMPORTANT

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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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