

INSTRUCTIONS

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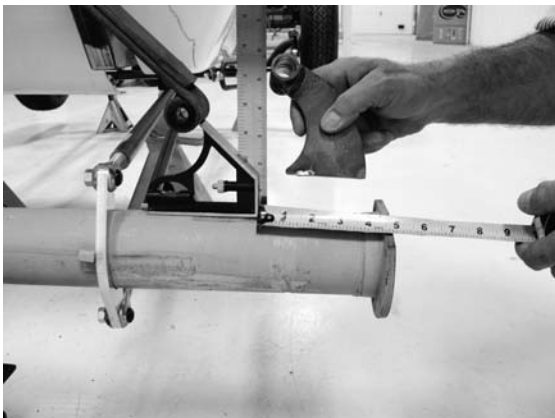
MODEL T & A REAR AXLE BRACKETS

1) Install rear spring on frame mounts of chassis. Secure with U-bolts; hand tighten. Measure spring to assure that it is centered in the chassis and is perpendicular to the chassis centerline. Torque U-bolts to 50 ft. lbs.



NOTE: It is critical that the rear end housing be positioned properly in the chassis prior to installing the spring mounting brackets to eliminate suspension binding and provide a long service life for the shackle bushings. The housing must be centered side to side, perpendicular to the chassis center line, and pinion angle adjusted correctly.

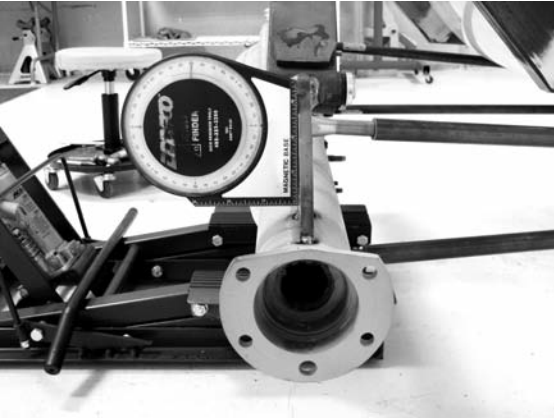
2) Position rear end under car. Install 4-bar or radius rods to properly locate the rear axle assembly in the chassis. Adjust suspension links so that the centerline of the rear axle is directly below the centerline of the leaf spring.



3) To determine the position of the brackets on the axle housing, you must estimate the sprung weight of the rear of your vehicle. Sprung weight is the total rear weight (scaled weight) less the weight of the rearend, wheels and tires. Once the approximate weight has been calculated, use the chart below to obtain the initial mount spacing:

500 lbs. = 44 inches	750 lbs. = 45 inches
1000 lbs. = 46 inches	1250 lbs. = 47 inches

4) Note the dimension determined in step #3. This is the desired distance from one spring mounting bracket eyelet to the other. Mark this dimension on the rear axle housing, centered from side to side. Double check pinion angle and wheelbase to assure that axle is located properly.



5) Position the spring mounting bracket on the axle housing with the eyelet centered on the mark made in **step #4**. Make certain the bracket is centered on axle tube, and that eyelet is parallel to the spring eye. Check again, this is critical. Tack weld in place.

6) With both spring mounting brackets securely tack welded to the axle housing, install the spring shackles and lower vehicle to the ground and check ride height. Double check all dimensions and finish welding brackets in place.



IMPORTANT

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