

INSTRUCTIONS

916-31931

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5 LUG DISC BRAKE KIT - FOR 1955-64 GM FULLSIZE CARS

PARTS LIST

Rotors: 910-65390	1969-'72 GM Midsize 11"	Outer Bearing	912-TLM11949
Calipers: 910-31045	1978+ GM Metric Calipers	Inner Bearing	912-TLM67048
		Inner Seal	912-S18543

NOTE: Before beginning installation, make sure your wheels fit on the disc rotor. Also, this kit works only with 15" and larger wheel, due to the 11" rotors.

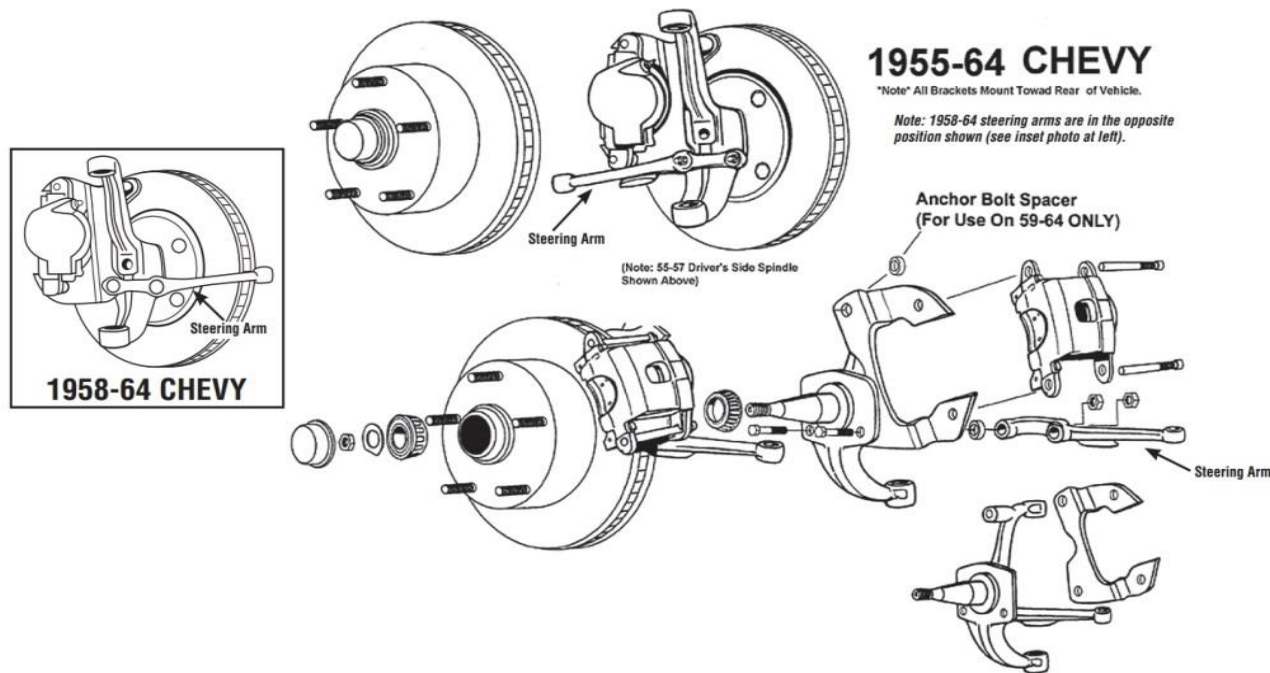
NOTE: 5/8" I.D. spacer is for use on 1959-64 only. Discard this spacer for 1955-58 applications.

INSTRUCTIONS:

1. **Remove the drum and backing plate** assemblies so all that remains are the stock spindles. Inspect the bearing surfaces on the spindle. Use a piece of 180-grit emery cloth to remove any corrosion or other imperfections on the spindle.
2. **Install the caliper** mounting bracket and steering arms to the spindle. Install the 5/8" bolt through the bracket and into the threaded hole in the top of the spindle. (1959-1964 cars will use the larger spacer between the upper mounting boss on the spindle and the caliper bracket). The bracket is positioned so that the caliper mounts towards the rear of the car and the bends in the bracket mounts the caliper farther away from the rotor. The lower portion of the bracket will be located where the steering arm was bolted to the spindle. The rear of the steering arm will now be bolted to the bracket, and the front will be bolted to the spacer
3. **Pack the inner bearing** with grease and install it along with the seal.
4. **Slide rotor onto spindle.** Pack and install outer bearing and secure with spindle washer and spindle nut.
5. **Set the bearing preload.** Start by tightening the nut while rotating the rotor. Once the nut is good and tight, stop rotating the rotor and back the nut off 1 full turn. Now, hand-tighten the nut until it just starts to get tight. Back the nut off until the slots in the nut are aligned with the hole in the spindle. Install the cotter pin and dust cap.
6. **Install the caliper** with the bleeder on the top. Install brake hoses. Make sure everything is tight and proceed to bleed the system.

WARNING: Stock drum brake wheels may not work with disc brake conversions. Drum brake wheels were not made with disc brakes in mind so there may be wheel to caliper clearance problems. Before installing this kit, make sure your wheels fit the brake assembly.

For those wanting to keep stock wheels that interfere with the installation, there are companies such as, Stockton Wheel Co. and Wheel Vintiques that can remove the original wheel centers and re-install them into a new disc brake rim.



IMPORTANT

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