

035-X-HSP

2001-2010 Chevrolet / GMC 58"-75" Bolt On Traction Bars 3.5" Axle Diameter



(Above picture includes HSP U-bolt flip kit for Ford and Dodge pickups. Actual product may vary depending on application)

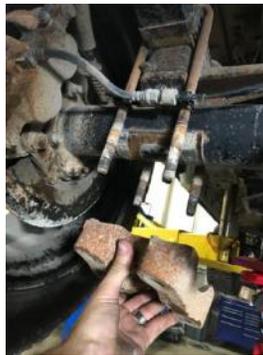
Tools Required

- ½" Drive Standard Socket Set up to 1"
- Standard wrench set up to 1"
- 3/8" Drill bit
- ½" Drill bit
- Drill
- Torque Wrench

1. Start by parking the vehicle on a clean level surface. Some trucks may require the use of jack stands to gain enough room to remove the U-bolts.
2. Spray penetrating oil on the threads and nuts of the U-bolts.
3. If you're U-bolts look like this STOP and order new U-bolts. The factory U-bolt size is $2\frac{1}{2}$ "x5/8"x14". We do offer U-bolts just give us a call and we can get some coming for you.



4. Remove the nuts from the U-bolts. It is recommended to do one side at a time to avoid the axle from shifting. With the nuts removed slide the lower plate off the U-bolts.



5. If there is heavy rust scale on the axle tube where the lower bracket was it is recommended to clean the surface so the new brackets have a solid flat surface to sit on.
6. Slide the new bracket into place and reinstall the nuts and washers. Be sure the U-bolts are sitting in the proper position on the top of the leaf spring. Apply anti-seize to the threads of the U-bolts to prevent galling of the threads. Torque the nuts to 100 ft-lbs in an x pattern making sure the u bolt length is equal side to side and front to back. If new U-bolts were used it may be necessary to trim the excess thread off for a clean look.



7. With one side done do the same procedure to the other side.
8. Now that the rear brackets are in place install the bars into the rear brackets using the supplied 5/8" bolts. The Rear brackets will use the longer bolts. The end of the bar with the polyurethane bushings will be used in the rear. Torque the 5/8" bolts to 50 ft-lbs.
9. Thread the heim joints into the front of the traction bar all way, and then back out 7 full turns. It maybe necessary to do ½ of a turn extra so the zerk fitting is facing down for easy access.
10. Install the front mount onto the heim joint so the hole is at the back of the bracket. Lift the bar and bracket up to the fame so that the bracket sits flush on the frame and securely clamp it in place. With the bracket clamp you may not remove the traction bar to help keep the bracket in place.



11. You must now drill ½" holes in the frame using a ½" drill bit. It is best to drill one hole at a time and install the bolt and washers after each hole and torque to 30 ft-lbs. Use a ½" drill bit first to mark a center hole then drill through with a 3/8" drill bit. After the 3/8" hole is drilled then use the ½" bit to open the hole up the rest of the way.



12. With all 4 holes drilled re-torque the ½” bolts to 30 ft-lbs.



13. With the brackets in place torque the front 5/8” bolts to 50 ftlbs.

14. It is recommended to recheck all fastener torques after 500mile of driving. We also recommend greasing the front heim joints at every oil changer interval.