

#011506, 011508, #011509

Installation Instructions

Rear Axle Flip

Chevrolet/GMC 5" ZR2 Kit



READ AND UNDERSTAND ALL INSTRUCTIONS AND WARNINGS PRIOR TO INSTALLATION OF SYSTEM AND OPERATION OF VEHICLE.

Parts List

011506

Part#	Qty	Description
01146-1	2	Axle Flip—Top Plate
01147-1	1	Axle Flip—Bottom Plate D.S.
01153-1	1	Axle Flip—Bottom Plate P.S.
N96FH	8	9/16" Fine High Nut
W96S	8	9/16" SAE Flat Washer
T86FBB	1	Brake Line Drop Bracket
B381G2	1	3/8 x 1" Bolt
LW38	1	3/8" Lock Washer
N38SS	1	3/8-16 Hex Nut
962340700R	4	9/16 x 2-3/4 x 7" Round U-Bolt
380412FCP	2	3/8 x 4.5" Center pin & Nut
723	1	Bolt Pack
25-1	2	1-1/8" O.D. x 1-1/8" Long Sleeve
36-1	2	3/4" O.D. x 1-3/8" Long Sleeve

011508

Part#	Qty	Description
01146-1	2	Axle Flip—Top Plate
01147-1	1	Axle Flip—Bottom Plate D.S.
01153-1	1	Axle Flip—Bottom Plate P.S.
960305-1	2	S-10 Torsion Bar Drop Link
N96FH	8	9/16" Fine High Nut
W96S	8	9/16" SAE Flat Washer
T86FBB	1	Brake Line Drop Bracket
B381G2	1	3/8 x 1" Bolt
LW38	1	3/8" Lock Washer
N38SS	1	3/8-16 Hex Nut
SB58BK	2	5/8" I.D. Hourglass Bushing
962340700R	4	9/16 x 2-3/4 x 7" Round U-Bolt
380412FCP	2	3/8 x 4.5" Center pin & Nut
723	1	Bolt Pack
25-1	2	1-1/8" O.D. x 1-1/8" Long Sleeve
36-1	2	3/4" O.D. x 1-3/8" Long Sleeve

011509

Part#	Qty	Description
01146-1	2	Axle Flip—Top Plate
01147-1	1	Axle Flip—Bottom Plate D.S.
01154-1	1	Axle Flip—Bottom Plate P.S.
01150-1	1	Track Bar Bracket

514	1	ZR2 Track Bar Bolt Kit
N96FH	8	9/16" Fine High Nut
W96S	8	9/16" SAE Flat Washer
T86FBB	1	Brake Line Drop Bracket
B381G2	1	3/8 x 1" Bolt
LW38	1	3/8" Lock Washer
N38SS	1	3/8-16 Hex Nut
962340700R	4	9/16 x 2-3/4 x 7" Round U-Bolt
380412FCP	2	3/8 x 4.5" Center pin & Nut
723	1	Bolt Pack
25-1	2	1-1/8" O.D. x 1-1/8" Long Sleeve
36-1	2	3/4" O.D. x 1-3/8" Long Sleeve

BOLT PACK 723

Qty	Description
2	5/8"-11 x 4" bolt
2	5/8"-11 prevailing torque nut
4	5/8" SAE flat washer

Installation Instructions

1. Block and secure the front of the vehicle. Use a hydraulic jack or equivalent to raise the rear of the vehicle. Place jack stands under the frame just in front of the spring hangers.
2. Remove the wheels and tires. Remove the OE shocks.
3. Remove the retainer holding the brake line to the frame bracket. Slit the OE bracket to remove the brake line. Be sure not to damage the brake line. Bend the bracket open and remove the line. Bend the bracket back flat.
4. Install the supplied brake line drop bracket to the OE bracket using the supplied 3/8" x 1-1/4" bolt, nut and washers. Attach the line to the key slot in the drop bracket.
5. Support the rear axle with a hydraulic jack. Disconnect the emergency brake cable guide from the frame.

Pick-up Only

6. Disconnect the rear track bar at the frame mount by removing the OE bolt.

Blazer/Jimmy Only

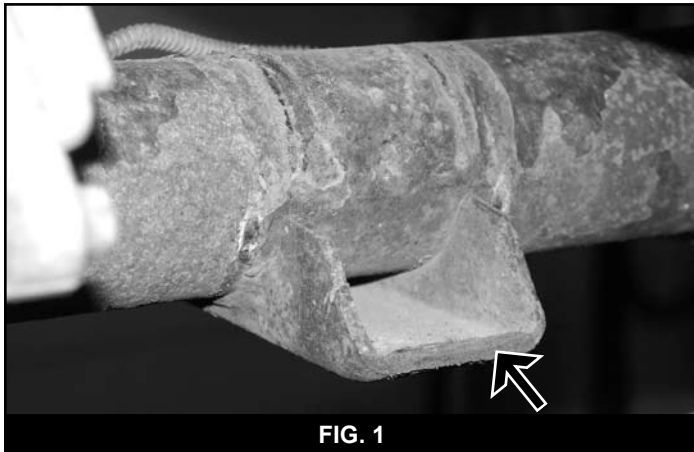
7. Disconnect the rear sway bar at the frame link mount. This is done by removing the nut that attaches the sway bar to the link that comes down from the frame.

All Models

8. Remove the spring U-bolts and remove the springs from the vehicle.
9. Clamp the leaf spring with two large c-clamps on both sides of the center pin. Remove the center pin and insert it through the bottom of the spring. Torque 3/8" nut to 35 ft.lbs.

Pick-up Only

10. The front of the passenger's side OE spring perch must be modified. Remove the front tab of the OE perch to provide clearance for the new BDS perch. (Fig. 1)



11. Install the new spring perch brackets on the axle tube. The long alignment tabs should fit in the rear of the OE axle perch. The shock mount should be facing the rear of the vehicle on the driver's side and the front of the vehicle on the passenger's side. The shock stud should point toward the center of the vehicle. **Note:** Some models have a brake line mounting bracket on the back of the axle tube right where the spring perch bracket mounts. If this is the case, the OE mount will have to be cut off. The surface should be ground flush and painted.

Blazer/Jimmy Only

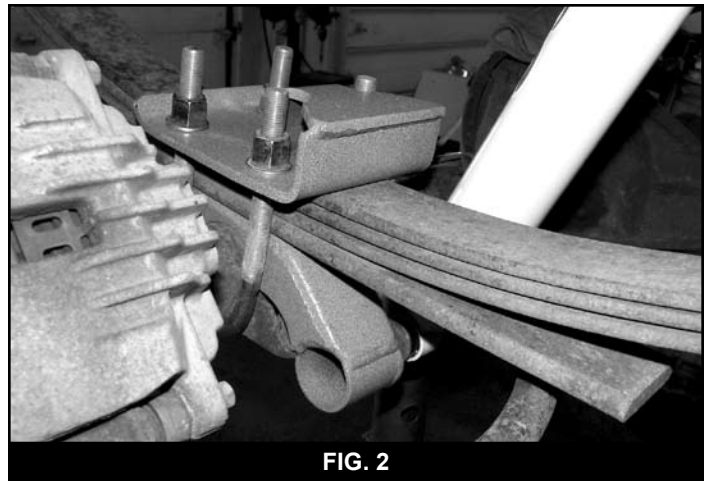
12. Install the new spring perch brackets on the axle tube. The long alignment tab should fit in the rear of the OE axle perch. The shock mount should be facing the rear of the vehicle and the shock stud should point toward the center of the vehicle. **Note:** Some models have a brake line mounting bracket on the back of the axle tube right where the spring perch bracket mounts. If this is the case, the OE mount will have to be cut off. The surface should be ground flush and painted.

All Models

13. Lower the axle while taking care not to over-extend the brake lines or bind the drive shaft. Install the leaf springs on top of the axle in the new perch brackets. Fasten the springs to the shackles and hanger with OE hardware. Do not tighten.
14. Install the new spring plate on top of the springs over the center pin with the bump stop pad toward the front of the vehicle. Install the new U-bolts around the axle and up through the new spring plate. Retain with provided high nuts and washers. Once both sides are installed and aligned torque the U-bolts to 100-120 ft-lbs. (Fig. 2)
15. Locate a safe location for the emergency brake guide. Drill a new hole and install using OE fasteners.

Pick-up Only

16. Install the supplied track bar drop bracket into the OE frame pocket. Fasten the bracket using the 3/8" bolt on the back of the bracket and the 1/2" bolt through the OE mount hole. Torque 3/8" bolts to 35 ft.lbs. and 1/2" bolts to 90 ft.lbs. **Note:** You may need to drill out the OE hole to accept the 1/2" bolt.
17. Attach the track bar to the drop bracket with the OE fasteners. Do not tighten.
18. Install the wheels and tires and lower the vehicle to the ground.



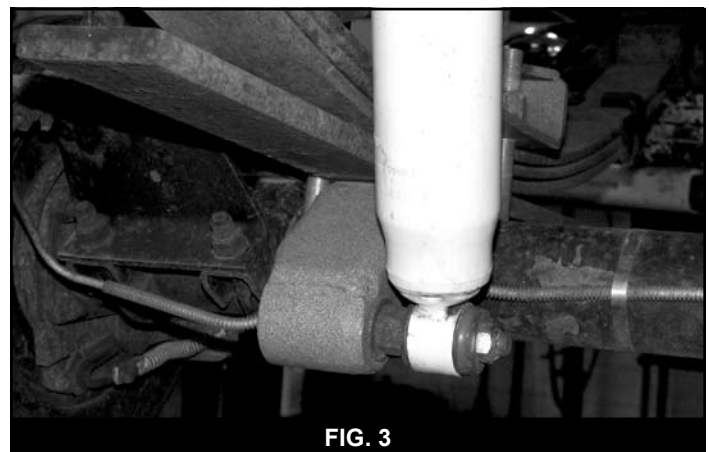
19. With the weight of the vehicle on the tires torque the track bar mounting bolt to 45 ft.lbs.

Blazer/Jimmy Only

20. Replace the existing sway bar link with the supplied link. Install the supplied sleeve in the eye of the supplied link and retain with factory hardware. Torque sway bar bolts.
2 door models:
Upper bolt 25 ft.lbs.
Lower bolt to 50 ft.lbs.
4 door models:
Upper bolt 50 ft.lbs.
Lower bolt 42 ft.lbs.

All Models

21. Install new BDS shocks using the bushings provided in the shock box. The 5/8" I.D. bushing is for the frame mount and the 3/4" I.D. bushing attaches to the new lower mount. Install the shock to the frame mount with OE fasteners. Tighten securely. (Fig. 3)



22. Install the supplied sleeve (3/4" O.D. x 1-3/8" long) in the lower bushing of the shock. Slide the 5/8" x 4" bolt through the mounting bracket so the nut end of the bolt is toward the center of the vehicle. Continue sliding on in the following order: 1-1/8" O.D. x 1-1/8" long spacer sleeve, 5/8" washer, shock, washer, and 5/8" nut. Tighten securely. (Fig. 3) **Note:** See bolt pack #723 for all provided hardware.
23. Bounce the rear of the vehicle to settle the rear suspension and Torque the front spring hanger bolt and the shackle bolts to 89 ft.lbs.
24. Check all fasteners for proper torque.