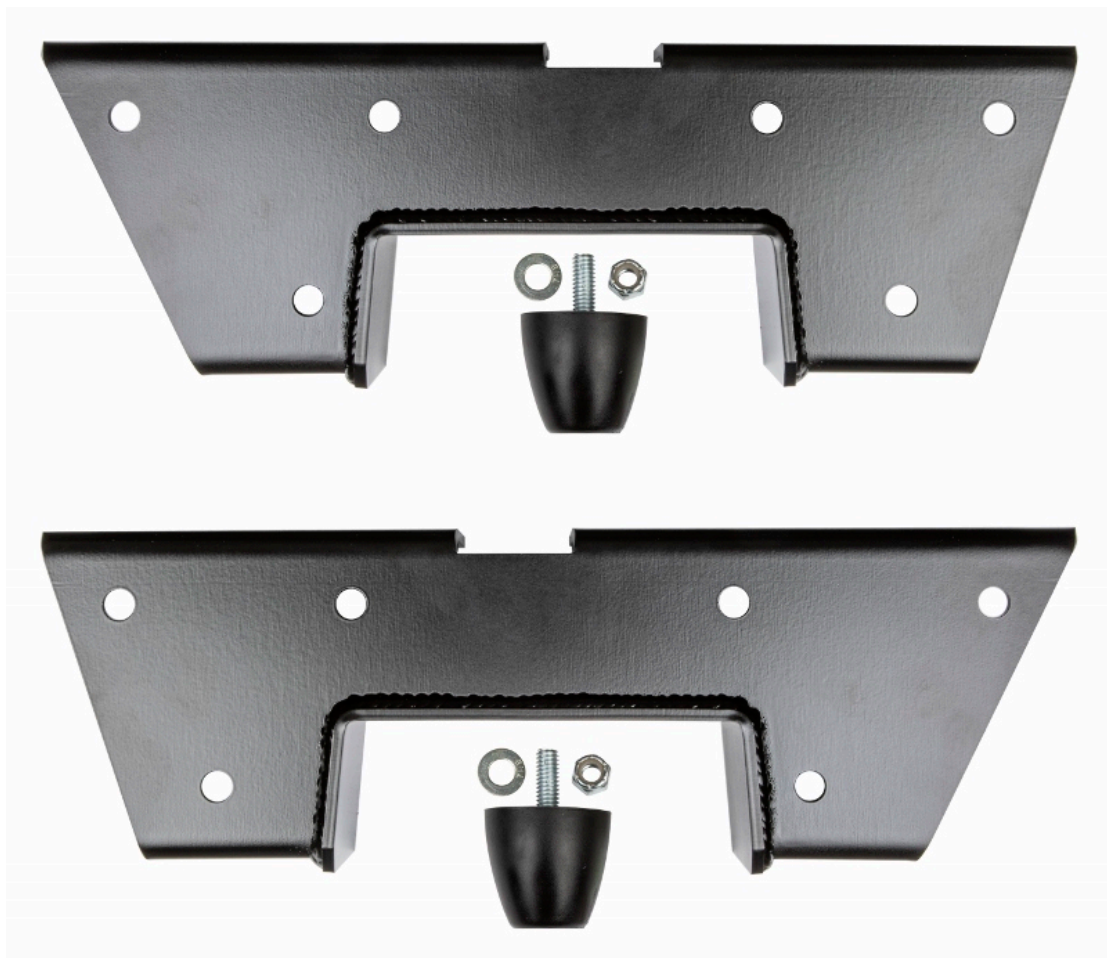




Detroit Speed, Inc.
Leaf Spring Frame Notch Bracket Kit
1973-87 GM Square Body Truck
P/N: 040115

The Detroit Speed leaf spring frame notch bracket kit is designed to give you rear axle to frame rail clearance when dropping the ride height of your 1973-87 GM C10 Square Body truck. This kit is recommended when installing the Detroit Speed Flip Kit (P/N: 040116). The frame notch brackets are manufactured from high quality 3/16" thick steel and powder coated black for durability. All mounting hardware and bump stops are included in this kit.



Item #	Description	Quantity
1	Leaf Spring Frame Notch Assembly, LH and RH	2
2	Rear Axle Jounce Bumper	2
3	Frame Notch Cut Template	1
4	Frame Notch Hardware Kit	1

IMPORTANT:

All work should be performed by a qualified technician. Please read the entire set of instructions and fully understand all of the steps involved before beginning the project. Always make sure to wear the appropriate safety equipment for the job and properly support the vehicle. If you have any questions before, during, or after the installation, feel free to contact Detroit Speed by phone at (704) 662-3272 or by email at tech@detroitsspeed.com.

Hardware Kit Checklist – Detroit Speed Frame Notch Bracket Kit			
Part Number	Description	Quantity	Check
200078	Frame Notch Bracket Hardware Bag	1	
950042FS	7/16"-20 x 1-1/4"L Hex Head Bolt	11	
960050FS	7/16"-20 Nylock Nut	11	
970042FS	7/16" SAE Washer	22	
980035FS	3/8"-24 x 1-1/4"L Hex Head Bolt	4	
960032FS	3/8"-24 Nylock Nut	4	
970023FS	3/8"-24 SAE Washer	8	
960033FS	5/16"-18 Nylock Nut	2	
970027FS	5/16" SAE Washer	2	

Installation:

1. Raise the vehicle on jack stands so that the frame is level with the ground. Remove the bed from the truck. Support the rear axle so the rear brake lines are not in tension. **NOTE:** We also recommend placing two jack stands behind the rear axle to help support the frame rails when cutting into them.
2. Removing the rear shocks from the frame are not required however it may help during installation. Remove the rear axle jounce bumper bracket from both sides of the frame (Fig. 1).

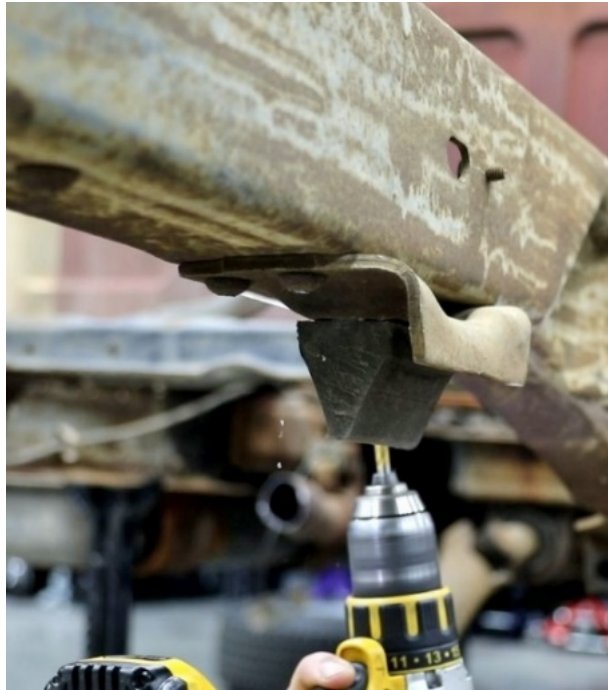


Figure 1 – Remove Rear Axle Bump Stop Bracket

3. Remove the brake line clamp from inside the passenger framerail and move the line away from the framerail (Figure 2).



Figure 2 – Remove Brake Line Clamp

4. With the rear frame rails level, locate the centerline of the frame notch location on the side of the frame. Using the top rear hole of the front leaf spring bracket, measure back 21-3/8". Mark this centerline location (Figure 3). **NOTE:** Make sure the tape measure is level when you mark this location.



Figure 3 - Locate Notch Centerline

5. Place the C-notch template so it sits on the top of the frame and wraps around the outside framerail. Line up the centerline mark of the C-notch with the slot in the template (Figure 4).



Figure 4 - Frame Notch Template

6. Use the template and trace the frame notch cutout onto the side of the framerail. Use a straight edge and transfer the cut lines to the bottom side of the framerail (Figure 5).



Figure 5 - Trace Frame Notch Cutout

7. Cover the fuel tank(s) with a welding blanket and cut along the traced lines to notch the framerail. Grind all edges smooth (Figure 6). **NOTE:** We recommend cutting the frame and installing the frame notch bracket on one side of the frame before cutting the other framerail for strength.



Figure 6 - Notch Frame Rail

8. Locate the frame notch bracket assemblies from the kit. There is a left and right hand side bracket so make sure you use the correct bracket for the correct side of the frame (Figure 7).

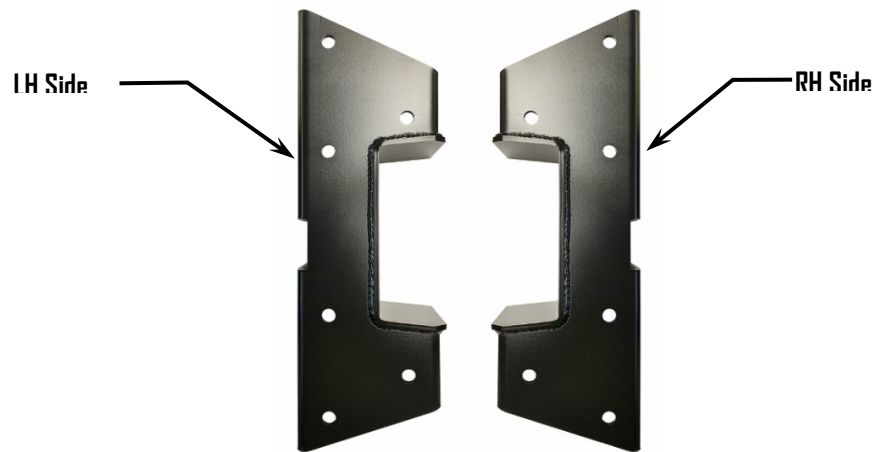


Figure 7 - Frame Notch Assembly

9. Test fit the frame notch assembly to the frame. Trim and grind any material away if needed so the frame notch assembly fits tight to the frame rails.
10. Once the frame notch assembly fits around the framerrails, transfer punch the framerrail using the frame notch assembly as a template. There will be eleven locations to mark for 7/16"-20 hardware for the top, bottom and outside frame rail for each side. You will also need to transfer punch the two locations to mark the 3/8"-24 hardware for the top frame rail for each side.
11. Remove the frame notch assemblies and drill out all eleven locations on the framerrail for the 7/16"-20 hardware to a final drill size of 15/32". Drill out the two locations on the framerrail for the 3/8"-24 hardware using a final drill size of 13/32" (Figure 8).



Figure 8 - Drill Framerrail

12. Once all hole locations are drilled out, install the frame notch bracket assembly to the frame using the provided 7/16"-20 x 1-1/4"L hex head bolts, Nylock nuts and washers. Then, install the 3/8"-24 x 1-1/4"L hex head bolts, Nylock nuts and washers (Figure 9). Use anti-seize on the threads of the bolts. Torque the 7/16"-20 hardware to 50 ft-lbs. and the 3/8"-24 hardware to 30 ft-lbs. Repeat Steps 4-12 for the other side of the truck.



Figure 9 – Install Frame Notch Assemblies (RH, Passenger Side)

13. Install the jounce bumper into each frame notch assembly at the C-notch using the provided 5/16"-18 Nylock nut and washer and tighten (Figure 10).



Figure 10 – Install Jounce Bumper

If you have any questions before or during the installation of this product please contact Detroit Speed at tech@detroitsspeed.com or 704.662.3272

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