Detroit Speed, Inc.

Leaf Spring Flip Kit
1973-87 GM Square Body Truck
P/N: 040116

The Detroit Speed leaf spring flip kit is designed to lower the ride height of your 1973-87 GM C10 Square Body truck. The flip kit axle pad and plate are manufactured from high quality 1/4" thick steel and powder coated black for durability. Detroit Speed has designed this kit with two leaf spring pin hole locations in the axle pad to have adjustability in centering up your rear axle. There are new U-bolts and hardware are included in this kit and are electroplated to help against corrosion.

Item #	Description	Quantity
1	Leaf Spring Flip Kit Axle Pad Assembly	2
2	Leaf Spring Flip Kit Plate	2
3	5/8"-18 U-Bolts	4
4	5/8"-18 Tall Hex Nuts	8
5	5/8" Flat Washer	8

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@detroitspeed.com.

Installation:

1. Raise the vehicle on jack stands so that the frame is level with the ground. It is not required to remove the bed from the vehicle however it will make installation easier. **NOTE:** You will need to remove the bed to install the required frame notch bracket kit (P/N: 040115) so this would be a good time to install both kits with the bed removed.

2. Remove the rear wheels from the rear axle. Support the rear axle with a floor jack so the rear brake lines are not in tension.

3. Unbolt the shocks from the axle brackets to let the rear axle drop down. With the rear axle in full droop, place a jack stand underneath the pinion yoke and the rear axle tubes to keep the rear axle from rotating forward.

4. Remove the U-bolts that attach the rear axle to the leaf spring on one side of the truck. Move the leaf spring underneath the rear axle. **NOTE:** We recommend unbolting the leaf spring from the truck to help move the leaf spring below the rear axle.

5. Re-install the leaf spring back into the truck. Do not install the U-bolts at this time. Repeat Steps 4-5 for the other leaf spring.

6. With the rear axle ontop of the leaf springs, install the flip kit axle pads between the leaf springs and the rear axle (Figure 1).

Figure 1 – Install Flip Kit Axle Pad

7. The bottom of the flip kit axle pad has two holes that the stock leaf spring bolt will locate (Figure 2 on the next page). The hole should be towards the front of the truck so the axle pad moves the rear axle towards the rear of the truck. **NOTE:** The axle pad has a V-notch on one end (Figure 3 on the next page). When installing the axle pads, the V-notch should be on the same side of the axle on the left and right hand side of the rear axle. We recommend the V-notch to be towards the rear of the truck.

Figure 2 – Locate Axle Pad

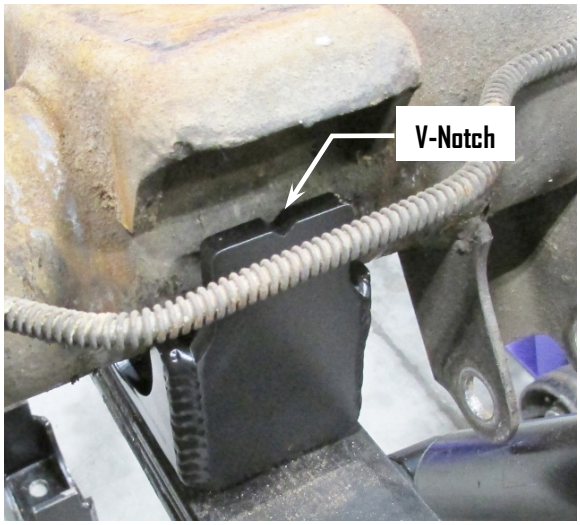

Figure 3 – Axle Pad V-Notch

8. Install the provided U-bolts over the rear axle and through holes on the new Detroit Speed flip kit plates placed underneath the leaf springs (Figure 4). Use anti-seize on the provided U-bolt hardware and draw up the U-bolts until they are snug. Continue to tighen the U-bolts in a cross pattern and torque to 95 ft.-lbs.

Figure 4 – Install Flip Kit Plate

9. Re-install the shocks into the rear axle brackets and torque to 50 ft.-lbs. Re-install your wheels and torque to the recommended setting. Set the truck on the ground. Installation in now complete.

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