



INSTALLATION INSTRUCTIONS

- BRK-1014 14 Bolt Weld-On Brake Caliper Brackets**
- BRK-1015 Dana 60 Weld-On Brake Caliper Brackets**
- BRK-1016 Dana 70 Weld-On Brake Caliper Brackets**

Ballistic Fabrication produces products for custom vehicles. Many products require general welding and fabrication skills. Welding should only be done by a competent welder. Ballistic Fabrication is not liable for improper installation. Check with local laws if your vehicle is driven on the street as some Ballistic Products may not be street legal in all states.

Included Parts

Two (2) Weld On Caliper Brackets (Enough for one (1) axle)

Additional Parts

Brake Rotor and Hub Assembly (2) 73-87 Chevy ¾ ton K20 - Napa Part Number NB 4886287

Brake Caliper (2) 73-87 Chevy ¾ ton K20 - Napa Part Number left-CAL N4674 right-CAL N4677

Brake pads 73-87 Chevy ¾ ton K20 - Napa Part Number SS728AM

Rubber Brake Line (2) 73-87 Chevy ¾ ton K20 - Napa Part Number UP36958

Brake Caliper Housing Bolt 73-87 Chevy ¾ ton K20 - Napa Part Number UP82205W

Optional Parts

Brake components from a 76-78 Cadillac Eldorado may be used in order to maintain an emergency brake.

Disassembly

- Remove original drum brake assembly.
- Cut or remove original hard brake line. Depending on the condition of the original brake lines they may need to be replaced.

Pre-Assembly

- Assemble brake rotor and hub per manufacturers recommendations.
- Temporarily secure the rotor and hub assembly to the axle.
- Attach brake caliper to the Ballistic Weld On Caliper Bracket using the correct hardware for the brake caliper.
- Install new brake pads inside the brake caliper.
- Position caliper on brake rotor. Ensure the bleeder is positioned at the highest point to facilitate proper brake bleeding.
- Center the caliper on the brake rotor. The most efficient and accurate method is to apply air pressure to the caliper via the bleeder hole.
- Ensure that there is space between the brake rotor and the caliper to avoid rubbing. A washer may be used as a spacer for set up.
- Once the caliper is positioned correctly place tack welds on both sides of the bracket to hold it in position.
- Dis-assemble the entire disk brake assembly leaving only the caliper bracket in place.

Final Assembly

- Finish welding both sides of the Ballistic Weld On Caliper Bracket. Final welding **MUST** be done by a competent welder. Inferior welds on brake parts can led to disastrous results.
- Ensure that the hub bearings are greased and reassemble the hub and rotor assembly to the axle. Tighten the axle nut to 180 lb/ft per manufacturers specifications.
- Install the brake caliper and pads and secure to the caliper bracket. Tighten caliper bolts to 63 lb/ft per manufacturers specifications.
- Since the 73-87 Calipers are floating calipers a rubber brake hose is necessary to account for the movement. Modification to the brake lines will be necessary.
- Bleed brakes per manufacturers specifications.

