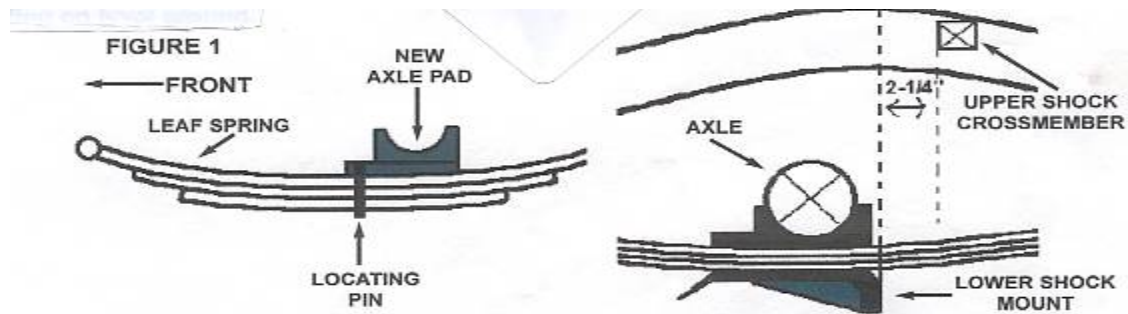




RA-400

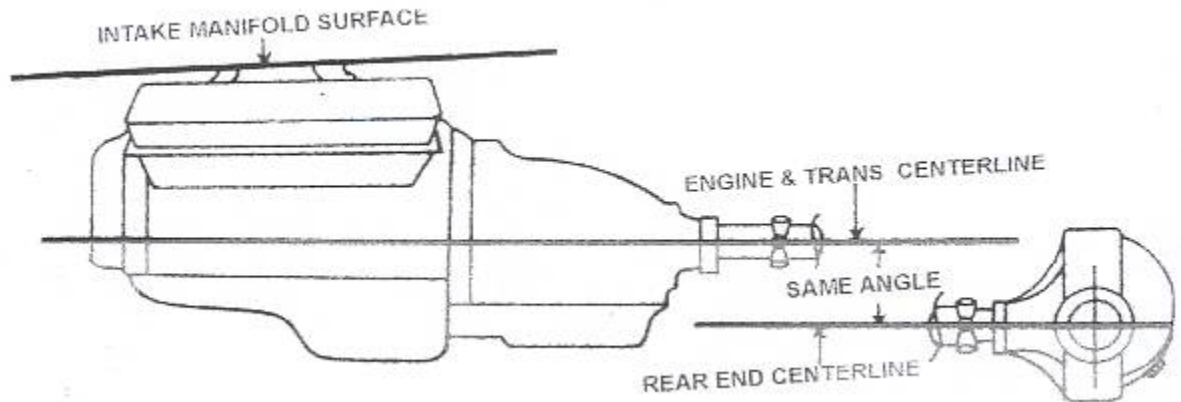
This kit is designed to mount a late model “open drive” rear axle onto the stock – or stock style replacement leaf springs. 47-53 Chevy pickups. The axle pads and u-bolts are designed to fit 3” diameter axle housings.

1. Set the axle pads in the leaf springs so that the axle saddle is behind the location pin. (fig. 1)
2. Set the new rear axle into the saddles. Adjust the position of the axle to make it even side to side. Then set the pinion angle – (page 2). Tack weld the axle to the saddles.
3. Assemble the u-bolts and shock mount U-bolt plates around the axle and springs. Snug the bolts.
4. Position the upper shock crossmember in the frame. Set this as high as possible. The shock crossmember should be 2 ¼” behind the lower shock mount. Be careful to protect the mount angle of the lower shock mount up to the frame. Tack weld the crossmembers (fig. 2)
5. Double check everything, disassemble and weld completely.
6. The shock length measurements are taken at “ride-height” with the finished truck sitting on level ground.



SETTING THE REAR PINION ANGLE

The centerline of the transmission output shaft and centerline of the rear axle pinion shaft should be parallel when the vehicle is under load. A leaf spring suspension will accommodate a reasonable amount of axle twist when torque is applied to the pinion shaft, i.e. the axle has a tendency to rotate upward when under load. The leaf springs will allow the pinion shaft to angle upward from 1 to 2 degrees when the vehicle is moving forward. For that reason, set the downward angle of the transmission output shaft to 4 degrees so the carburetor mounting flange will be level with the ground, then adjust the upward angle of the pinion angle from 2-3 degrees when the vehicle is static. When the vehicle is under power, deflection will allow the pinion to rotate from 1-2 degrees upward, aligning it with the transmission output shaft. All adjustments should be made with the suspension weighted.



!!!YOU HAVE NO SHOCKS!!!

NAME _____ INV# _____

YEAR _____ MAKE _____

EYE TO EYE AT A RIDE HEIGHT _____

WE HAVEN'T SENT THEM TO YOU YET. DUE TO INSTALLATION CHANGES, ONE SHOCK WON'T FIT ALL APPLICATIONS. SO WE OWE YOU A PAIR THAT WILL FIT. THIS KIT INCLUDES A PAIR OF MONROE SHOCKS. JUST TELL US THE RIDE HEIGHT MEASUREMENT AND WE WILL SHIP THEM TO YOU. IF YOU WOULD LIKE CHROME PRO SHOCKS, CHROME CARRERA HYPERSHOCKS, OR ADJUSTABLE ALUMINUM HAL SHOCKS – THEY ARE AVAILABLE AS AN UPGRADE.

PRO SHOCKS	\$65.00
CARRERA HYPERSHOCKS	\$129.00
HAL ADJUSTABLE SHOCKS	\$195.00
ADD A REAR SWAY BAR FOR	\$150.00

