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INSTALLATION INSTRUCTIONS FOR **#107 SH (CAT 5)** DEL-A-LUM BUSHING & SHACKLE KIT.

Parts list:

4 Shackle halves
2 Aluminum bushing inserts
2 Long grease fittings
4 (.285) thick thrust washers
2 Steel retaining sleeves (small)
2 Front housing retaining rings
4 Steel bearing spacers (rear eyelet)
4 ½ x20 stove lock nuts
2 Aluminum frame bushings
2 Front spring eyelet housings with bearing
2 Rear spring eyelet housings with bearings
2 Rear housing retaining rings
2 steel bearing retaining sleeves (large)
4 Steel bearing spacers (front eyelet)

We recommend a competent shop install this kit because presswork and welding is required.

1. Remove rear springs from the vehicle. A Mitchell or Chilton's or factory service manual can be used, if you require assistance.

2. Remove the original rubber shackle bushings from the car's frame & thoroughly clean the frame holes removing all rust and dirt to allow for easy installation of the new bushing housing.

3. Locate in your kit two aluminum bushings. Each bushing has a hole drilled in it. This bushing is pressed into the frame bushing housing. The hole in the bushing goes to the outside of the car. **Note: For best results we use 1/2 inch All-Thread rod and two flat plates / washers to pull the bushings into the frame. All-thread is a rod that is threaded the entire length. It is found at most hardware stores.**
   Align the grease-fitting hole at an angle about 70 degrees pointing down in the frame. This angle allows easy access to the grease fitting after the assembly is complete. Install the bushing into the frame till it goes flush with the other side of the frame.

4. Take a #3 drill bit (.210 diameter) and drill a hole into the frame housing intersecting the hole in the bushing you just pressed in.
5. Thread the hole with a 1/4 x 28 tap and install the grease fitting supplied in your kit.
6. Clean out any metal chips in the bushing and install the white plastic insert. Be sure to grease the insert before installation.
7. Do the other side the same way.
8. Remove the bushings out of your leaf springs. The front bushing will require pressing work. The rear bushings should pop out.
9. The front spring bushing housings are the large diameter units. Press the housing into the

leaf until the bushing lip bottoms against the spring. Take one outer retaining ring and press it over the bearing housing until it bottoms against the spring.

10. Take the smaller bushing housing and press it into the rear spring eye. Again locate a small retaining ring and press it up against the spring.
11. Do the other spring the same way. Once they are assembled weld the retaining rings to the housings, **NOT TO THE LEAF SPRING**. Weld short duration's so the springs do not over heat.
12. Once the housings have cooled down press the large bearing into the front eye. Next press the front retaining ring into the housing up against the bearing. Use the same procedure for the rear spring eye using the small bearing.
13. Tack weld front and rear retaining rings into the housings. Place two 1/2 inch long welds 180 degrees apart from each other. (Bearings will not be damaged doing it this way).
14. Locate 4 front inner bearing spacers. They are the ones with a long stepped shoulder. Place one spacer on each side of the inner bearing. The step goes inside the bearing. You may need to tap them in place.
15. The remaining spacers go in the rear spring bearing eyelet. Install the rear bearing housing and assembly the same as the front eye.
16. Slide the front assembly into the spring perch and torque to 70 foot pounds.
17. Take one shackle halve and slide a .400 white thrust washer over the bolt. Slip the bolt (shackle halve) through the frame bushing. Once the bolt protrudes through the bushing, slide another .400 white thrust washer over the bolt.
15. Take the other halve of the shackle assembly and slide the bolt through the rear spring eyelet. Lift the spring and shackle up to the frame and slide the shackle bolts through each plate. Place a lock nut on each bolt (supplied in kit) and tighten down. Torque the bottom shackle bolt going through the leaf spring to 70 foot pounds.
16. Tighten the upper bushing shackle bolt down till the thrust washers contact the face of the shackle plates and turn 1/8 of a turn more or just one flat.

17. Do the other side the same way.

18. Assemble the rear differential to the springs accordingly.

19. Lubricate the frame bushings via their grease fittings!

Global West Suspension Components Inc. also offers the following items for your application.

SUBFRAMES AND SUPPORTS	TUBULAR CONTROL ARMS UPPER AND LOWER	SUSPENSION PACKAGES
FRONT SPRINGS	REAR SPRINGS	SWAY BARS
TUBULAR TIE ROD SLEEVES AND ADJUSTABLE STRUT RODS	SHOCKS	DISC BRAKES UP TO 13 INCH