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INSTALLATION INSTRUCTIONS FOR #115 SH (CAT 5) DEL-A-LUM BUSHING & SHACKLE KIT.

Parts list:

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|---|---|
| 4 Shackle halves | 4 ½ x20 stove lock nuts |
| 2 Aluminum bushing inserts | 2 Aluminum frame bushings |
| 2 Long grease fittings | 2 Front spring eyelet housings with bearing |
| 2 (.300) thick thrust washers | 2 Rear spring eyelet housings with bearings |
| 2 (.075) thick thrust washers | 2 Steel retaining sleeves (small) |
| 2 Front housing retaining rings | 2 Rear housing retaining rings |
| 4 Steel bearing spacers (rear eyelet) | 4 Steel bearing spacers (front eyelet) |
| 2 steel bearing retaining sleeves (large) | |

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

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

The gas tank must be dropped in order to press fit the rear frame bushings. Be sure to plug all fuel lines coming from the tank before removing it from the vehicle.

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.

Locate in your kit two aluminum bushings. Each bushing has a hole drilled and taped for a grease fitting. Align the grease fitting hole at an angle about 70 degrees pointing down in the frame. This angle will allow easy access to the grease fitting after assembly complete.



Rear frame bushings must be pressed in from the outboard side of the car, **Do Not** attempt installation from the inboard side; bushings will not go in from this direction. Grease fittings must be located on the inside of the frame. **Installation hint:** You can use all-thread ½ inch and a couple of heavy flat washers to facilitate frame bushing installation. Use the tool to pull the bushing into place in the frame rail. A large

socket or tube can be used to finalize the installation. **Remember** the bushing must be installed so the grease fitting is on the inside of the frame rail.

1. Next, install the white plastic inserts. Be sure to grease the inserts before installation.
2. Locate the grease fitting in your kit and install them into the bushings now.

Remove the bushings out of your leaf springs. The front bushing will require pressing and the rear should pop out.

3. The front spring bushing housings are the large diameter units. They already have the bearings and retaining sleeves installed. Press the housing in the leaf until the bushing lip bottoms against the spring. Take one outer retaining ring and press it over the bearing housing. Press it up against the spring.
 4. Locate a rear housing and bearing assembly and do the same as the front. Again locate a small retaining ring and press it up against the spring.
 5. 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 spring and the bearing do not over heat.
 6. Locate 4 front inner bearing spacers. They are the ones with a small 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.
 7. The remaining spacers go in the rear spring bearing eyelet. Install the rear bearing housing and assembly the same as the front eye.
 8. Slide the front assembly into the spring perch and torque to 70 foot pounds.
 9. Take one shackle halve and slide a .300 white thrust washer over the bolt. Slip the bolt (shackle halve) through the frame bushing. Once the bolt protrudes through the bushing, slide another .075 white thrust washer over the bolt. Note; The .075 washer goes next to the grease fitting in the bushing.
15. Take the other halves 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. Re-install car's gas tank.
20. Lubricate all bushings via their grease fittings!

Global West also manufactures or supplies the following items for your application.

SUBFRAMES	CONTROL ARM BUSHINGS	BODY MOUNTS
FRONT SPRINGS	REAR SPRINGS	SWAY BARS
TUBULAR TIE ROD SLEEVES	SHOCKS	BRAKES UP TO 13 INCH