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Kit PHC-32K - --- 1993-02 Camaro/Firebird rear track rod and upper brace

Kit includes:

- 1 ---- Upper cross rod (brace)
- 1 ---- Multi-hole bracket for cross brace
- 1 ---- Adjustable track rod (assembled with adjuster, rod end, jam nuts, spacers)
- 1 ---- Multi-hole rear end bracket
- 1 ---- Sheet metal screw
- 2 ---- Steel spacers 1-7/8 long
- 2 --- 1/2 inch bolts
- 2 --- 1/2 inch lock nuts
- 4 --- 1/2 inch washers
- 4 --- 9/16 bolts
- 4 --- 9/16 lock nuts
- 8 --- 9/16 flat washers

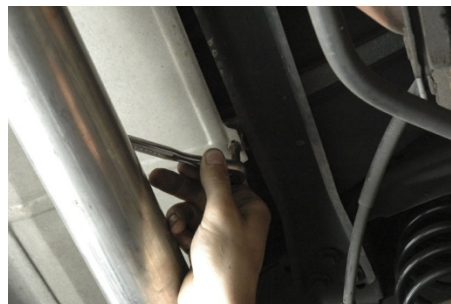


Note: Installation of the kit requires welding.

1. Installation requires lifting the vehicle up and removing the left rear tire. Make sure the car is supported securely for performing the installation. Welding will be required on the rear end mount that attaches the track bar.
2. Remove the factory track bar and cross brace. There are 3 bolts on the driver side holding the upper cross brace in place and one on the passenger side.



You will also have to remove one of the bolts that hold the factory heat shield.





3. Once the rear brace is removed it is time to install the frame bracket. Installing the new multi hole bracket will require squaring off the bottom of the frame mount. The photo below will show you what is required. The key is to get the bracket to sandwich the frame mount and line up with the original mounting holes. Note: You do not want to remove too much material from the factory mount on the frame.



4. After you have the bracket capable of being installed so the holes line up, you will have to open up the top hole using a $\frac{1}{2}$ inch bit. The lower hole will require using a $\frac{9}{16}$ drill bit. Both holes will require drilling.



5. After the holes are opened up, install the bracket and the upper cross brace. Line the new bracket up on the frame mount and slide the upper bolt through assembly. Using the $\frac{1}{2}$ inch bolt provided in the kit. The brace will line up with the original mounting holes on the body. Install the three upper bolts and tighten them down. Do not tighten the $\frac{1}{2}$ inch bolt yet.

6. Next swing the new bracket up so it indexes with the cross brace. Slide a $\frac{1}{2}$ inch bolt provided in your kit through the



assembly. Next install the 9/16 bolt through the lower 2nd hole in the bracket. You will require using one of the steel sleeves (spacer) furnished in your kit. As you install the bolt through the bracket and frame mount, place the steel spacer in the middle and slide the bolt through. This will keep the bracket from distorting when you eventually tighten the bolt. At this time you can tighten the two 1/2 inch bolts holding the new bracket and cross brace (70 foot pounds).

7. In the kit there is a self tapping sheet metal screw, use it to reinstall the heat shield to the cross brace.

8. Next proceed to the rear end mount. You will require opening up the hole to 9/16.



9. Next slide the bracket up over the rear end mount and line the holes up. In some cases depending on the rear end mount, you may have to grind a little off the rear end so the holes line up.

10. Install a 9/16 bolt and washer through the bracket and using the other 1 7/8 spacer from your kit, place it in the middle of the mount and slide the bolt through. Do not tighten it down all the way.



11. Using an angle finder set the bracket 90 degrees to the housing.

12. Tack weld the bracket to the rear end.



13. With the bolt holding the units together weld the edges around the bracket to the rear end mount. Weld the seam on the inside as well. Remove the bolt after cooling.

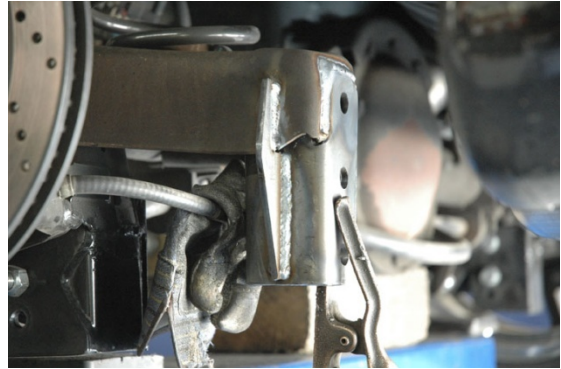


14. Next you are going to install the support gusset. The gusset goes on the back side of the rear end mount in the middle.

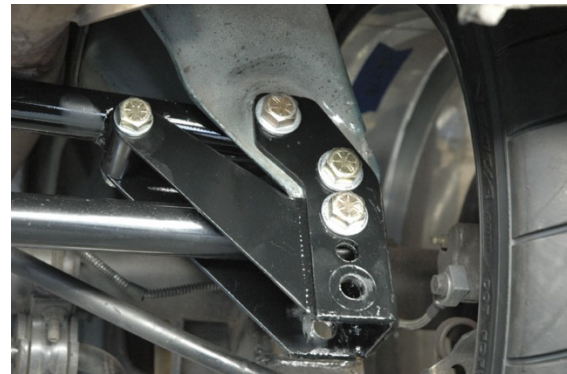


Weld the gusset to the rear end and bracket.

15. After the bracket cools down, paint the unit.



16. Install the track bar --- Install the track bar so the adjuster is on the driver side. Slide the bar into the passenger side mount. You can mount the bar in anyone of the three locations. Just make sure the rod is parallel to the ground when you are finished. Note: the location of the bar determines the rear roll center. The lower the bar is positioned the lower the rear roll center and vice-versa.



17. Install the track bar in the same hole as the other side. It should be parallel. Make sure you reinstall the top bolt and spacer as shown in the photo. Tighten to 80 foot pounds.



18. The track bar is adjustable for centering the rear end in the chassis. Simply loosen the jam nuts on the adjuster and rotate the adjuster till the rear end is centered and then retighten the jam nuts. Installation is complete.

