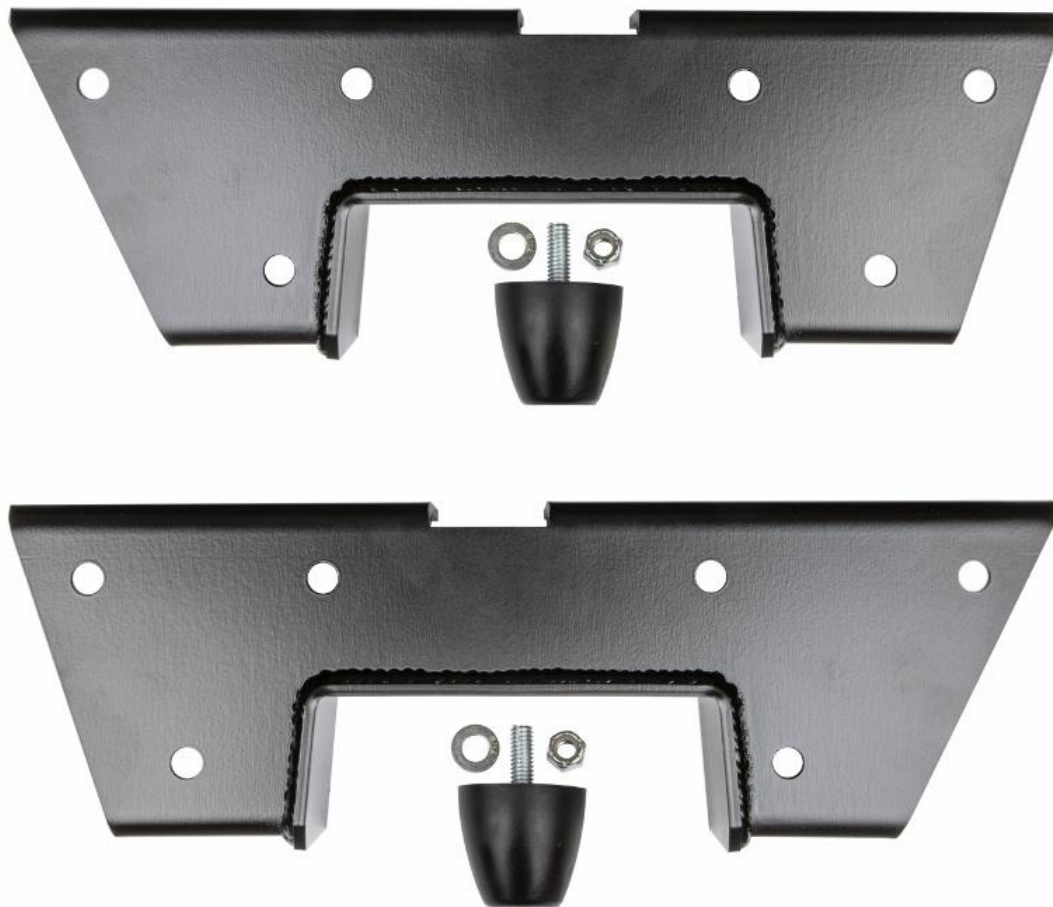


Detroit Speed
Leaf Spring Frame Notch Bracket Kit
1973-87 GM Square Body Truck
P/N: 040115DS

The Detroit Speed leaf spring frame notch bracket kit is designed to give you clearance between the rear axle and the frame rail when dropping the ride height of your 1973-87 GM C10 Square Body truck. This kit is required when installing the Detroit Speed Flip Kit (P/N: 040116DS). The frame notch brackets are manufactured from high quality 3/16" thick steel and powder coated black for durability. All mounting hardware and bump stops are included in this kit.



Item #	Description	Quantity
1	Leaf Spring Frame Notch Assembly, LH and RH	2
2	Rear Axle Jounce Bumper	2
3	Frame Notch Cut Template	1
4	Frame Notch Hardware Kit	1
5	Instructions	1

IMPORTANT:

All work should be performed by a qualified technician. Please read the entire set of instructions and fully understand all of the steps involved before beginning the project. Always make sure to wear the appropriate safety equipment for the job and properly support the vehicle. If you have any questions before, during, or after the installation, feel free to contact Detroit Speed by phone at (704) 662-3272 or by email at sales@detroitsspeed.com.

Hardware Kit Checklist – Detroit Speed Frame Notch Bracket Kit			
Part Number	Description	Quantity	Check
200078	Frame Notch Bracket Hardware Bag	1	
950042FS	7/16"-20 x 1-1/4" L Hex Head Bolt	22	
960050FS	7/16"-20 Nylock Nut	22	
970042FS	7/16" SAE Washer	44	
980035FS	3/8"-24 x 1-1/4" L Hex Head Bolt	4	
960032FS	3/8"-24 Nylock Nut	4	
970023FS	3/8"-24 SAE Washer	8	
960033FS	5/16"-18 Nylock Nut	2	
970027FS	5/16" SAE Washer	2	

Installation:

1. Raise the vehicle on jack stands so that the frame is level with the ground. Remove the bed from the truck. Support the rear axle so the rear brake lines are not in tension. **NOTE:** We also recommend placing two jack stands behind the rear axle to help support the frame rails during installation.
2. Removing the rear shocks from the frame are not required however it may help to unbolt them from the frame during installation. Remove the rear axle jounce bumper bracket from both sides of the frame (Figure. 1).

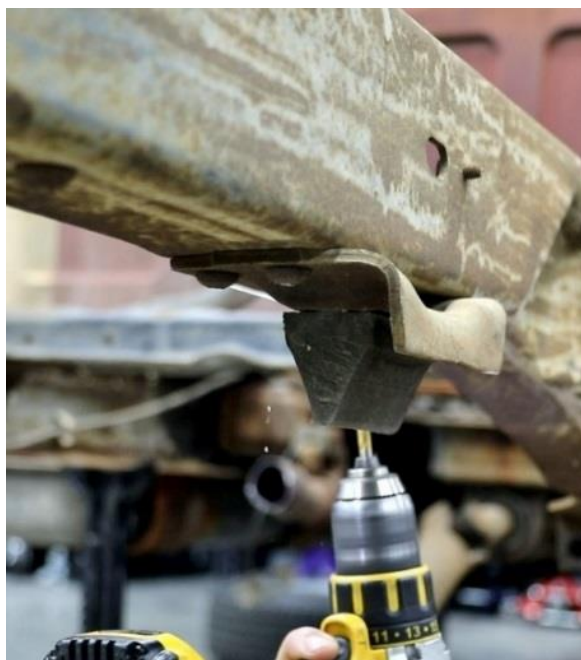


Figure 1 – Remove Rear Axle Bump Stop Bracket

3. Remove the brake line clamp from inside the passenger frame rail. Move the brake line away from the frame rail (Figure 2).



Figure 2 - Remove Brake Line Clamp

4. With the rear frame rails level, locate the centerline of the frame notch location on the side of the frame. Using the top rear hole of the front leaf spring bracket, measure back 21-3/8". Mark this centerline location (Figure 3). **NOTE:** Make sure the tape measure is level when you mark this location.



Figure 3 - Locate Notch Centerline

5. Place the C-notch template so it sits on the top of the frame and wraps around the outside frame rail. Line up the centerline mark of the C-notch with the slot in the template (Figure 4).



Figure 4 - Frame Notch Template

6. Use the template and trace the frame notch cutout onto the side of the frame rail. Use a straight edge and transfer the cut lines to the bottom side of the frame rail (Figure 5).

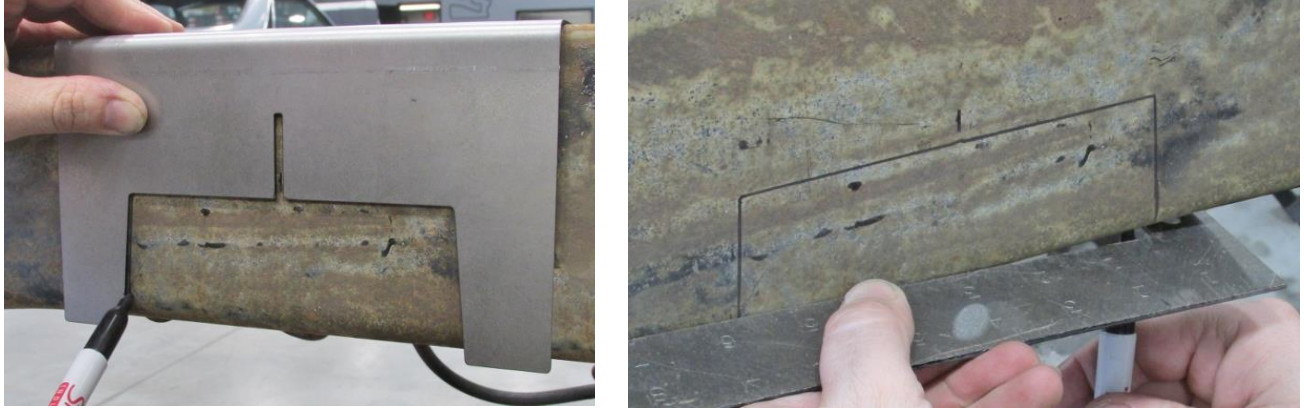


Figure 5 - Trace Frame Notch Cutout

7. Cover the fuel tank[s] with a welding blanket and cut along the traced lines to notch the frame rail. Grind all edges smooth (Figure 6). **NOTE:** We recommend cutting the frame and installing the frame notch bracket on one side of the frame before cutting the other frame rail for strength.



Figure 6 - Notch Frame Rail

8. Locate the frame notch bracket assemblies from the kit. There is a left and right hand side bracket so make sure you use the correct bracket for the correct side of the frame (Figure 7).



Figure 7 - Frame Notch Assembly

9. Test fit the frame notch assembly to the frame. Trim and grind any material away if needed so the frame notch assembly fits tight to the frame rails.
10. Once the frame notch assembly fits around the frame rails, transfer punch the frame rail using the frame notch assembly as a template. There will be eleven locations to mark for 7/16"-20 hardware for the top, bottom and outside frame rail for each side. You will also need to transfer punch the two locations to mark the 3/8"-24 hardware for the top frame rail for each side. **NOTE:** The two 3/8" holes in the bracket will be towards the rear of the truck (Figure 8).

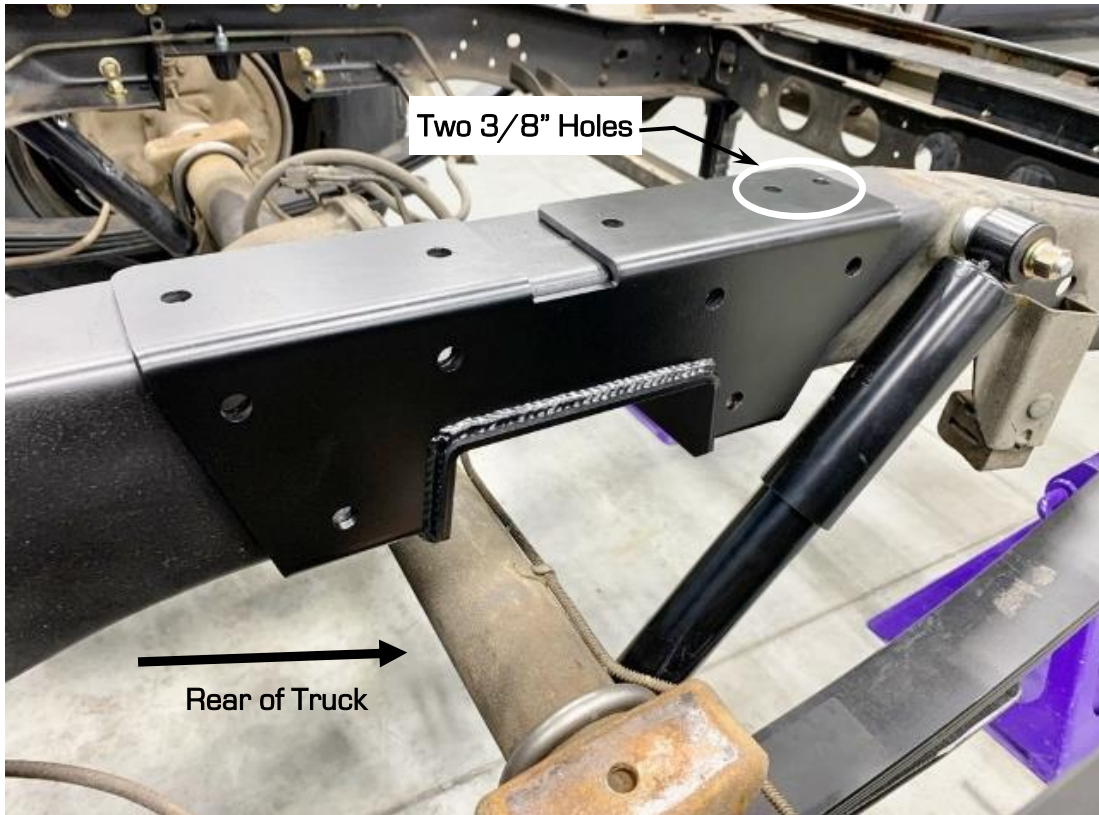


Figure 8 - Mark Drill Locations

11. Remove the frame notch assemblies and drill out all eleven locations on the frame rail for the 7/16"-20 hardware to a final drill size of 15/32". Drill out the two locations on the frame rail for the 3/8"-24 hardware using a final drill size of 13/32" (Figure 9).

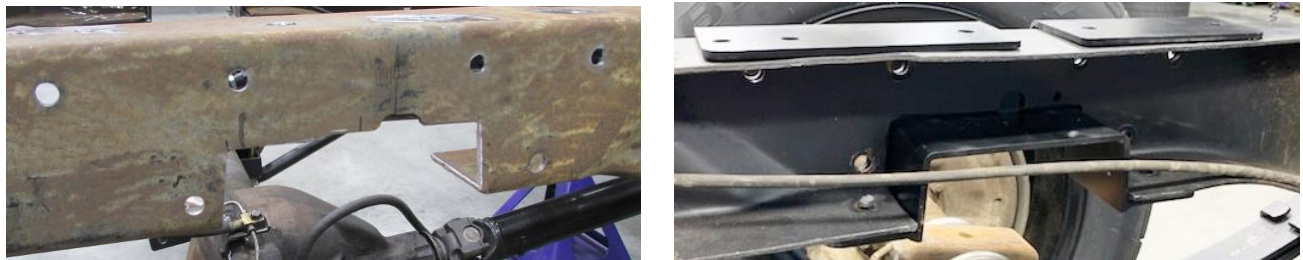


Figure 9 - Drill Frame Rail

12. Once all hole locations are drilled out, install the frame notch bracket assembly to the frame using the provided 7/16"-20 x 1-1/4" L hex head bolts, Nylock nuts and washers. Then, install the 3/8"-24 x 1-1/4" L hex head bolts, Nylock nuts and washers (Figure 10 on the next page). Use anti-seize on the threads of the bolts. Torque the 7/16"-20 hardware to 50 ft-lbs. and the 3/8"-24 hardware to 30 ft-lbs. Repeat Steps 4 through 12 for the other side of the truck.

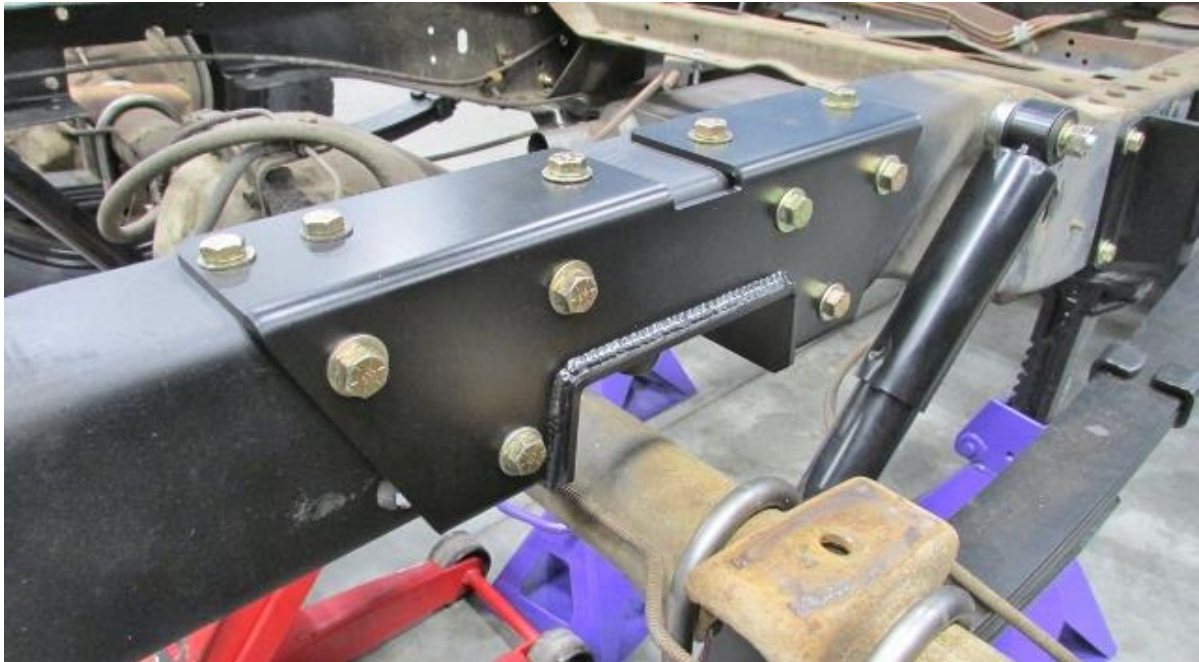


Figure 10 – Install Frame Notch Assemblies (RH, Passenger Side)

13. Install the jounce bumper into each frame notch assembly at the C-notch using the provided 5/16"-18 Nylock nut and washer and tighten (Figure 11).



Figure 11 – Install Jounce Bumper

If you have any questions before or during the installation of this product, please contact Detroit Speed at tech@detroitsspeed.com or 704.662.3272

Legal Disclaimer: *Detroit Speed is not liable for personal, property, legal, or financial damages from the use or misuse of any product we sell. The purchaser is solely responsible for the safety and performance of these products. No warranty is expressed or implied.*