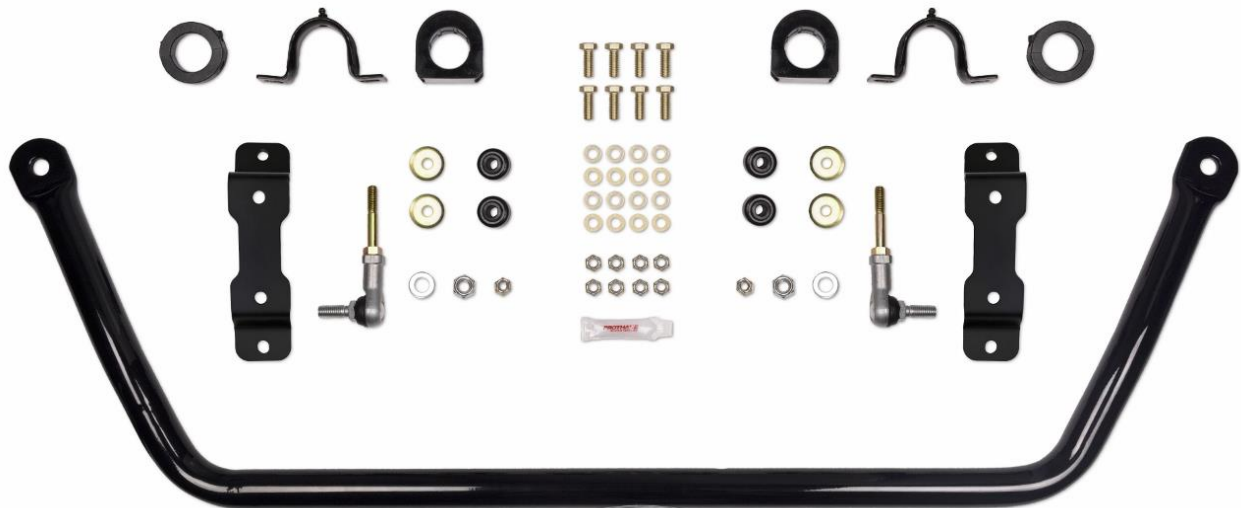


Detroit Speed
Front Sway Bar Kit
1967-87 GM Square Body Truck
P/N: 031419DS

The Detroit Speed Front Tubular Sway Bar Kit is designed to improve cornering and reduce body roll on your 1967-87 GM C10 Square Body Truck. DSE's larger than stock, 1-7/16" O.D. hollow sway bar is powder coated black and comes with everything you need to bolt it on including, grease-able polyurethane bushings and end links. Sway bar control is further improved by relocating the end-link outward on the factory lower control arm. Sway bar brackets are raised on the chassis to correct sway bar angles and improve ground clearance on lowered trucks.



Item	Part Description	Quantity
1	1-7/16" O.D. Tubular Sway Bar	1
2	Polyurethane Sway Bar Bushing	2
3	Sway Bar Bushing Mounting Bracket	2
4	Sway Bar End Link Assembly	2
5	Sway Bar Chassis Bracket	2
6	1-7/16" Double Split Lock Collar Assembly	2
7	Sway Bar End Link Grommets	4
8	Sway Bar End Link Stamped Washers	4
9	3/8"-16 x 1" L Hex Head Bolt	8
10	3/8"-16 Nylock Nut	10
11	3/8" AN Washer	12
12	M12-1.75 Nylock Nut	2
13	M12 Washer	2
14	Super Grease	1
15	Instructions	1

Fastener Torque Specifications	
Application	Torque (ft-lbs.)
Sway Bar Chassis Bracket	35
Sway Bar End Link	53
Split Lock Collar	15 (Blue Loctite)

Installation Instructions

1. To begin installation, chock the rear wheels. Raise the front of the vehicle and support the vehicle under the front control arms so the front suspension is at ride height.
2. Remove the existing sway bar from the vehicle if equipped, by removing the 3/8" hardware at the lower control arms. If you have a 1973-87 truck, continue to the next step. If you have a 1967-72 truck, skip to Step 5.

1973-1987 Trucks

3. Remove the factory sway bar mounting brackets from the frame by removing the rivets from the frame rails (Figure 1). **NOTE:** Vehicles not equipped with a factory sway bar will not have this bracket. The holes required for installation will be in the frame.



Figure 1 - Remove Factory Brackets

4. Install the provided DSE chassis brackets to the frame rails where the factory sway bar brackets were installed on both sides of the truck. Use the provided 3/8"-16 hardware and torque to 35 ft-lbs. **NOTE:** DSE recommends placing the 3/8"-16 x 1" L hex head bolts and 3/8" AN washers through the holes of both chassis brackets. The bolts will be pointing down before the brackets are fully installed (Figure 2). Skip to Step 9.



Figure 2 - Install Chassis Brackets

1967-1972 Trucks

5. Remove the rivets connecting the steering crossmember to the bottom of the frame rail on both sides of the truck. This crossmember is located in front of the suspension crossmember (Figure 3).



Figure 3 - Remove Steering Crossmember Rivets

6. Install the provided DSE chassis brackets to the frame rails. Align the rear hole of the frame brackets through the rivet holes using the supplied 3/8"-16 hardware.
7. Align the sway bar chassis brackets so they are parallel with the frame rails. Using the brackets as a guide, mark the location to drill a 13/32" hole on both sides of the truck. **NOTE:** It is recommended that a pilot hole be drilled first before drilling the 13/32" hole.
8. Install the chassis brackets to the frame rails using the provided 3/8"-16 hardware and torque to 35 ft-lbs. **NOTE:** DSE recommends placing the 3/8"-16 x 1" L hex head bolts and 3/8" AN washers through the holes of both chassis brackets before the brackets are fully installed.

All Trucks 1967-1987

9. Cut out and align the provided template (Figure 14 on page 7) with the factory sway bar mounting holes. Fold the template around the lower control arm and mark the location of the sway bar end link on the lower control arm. Drill the mounting hole to 17/32" (Figure 4). **NOTE:** It is recommended that pilot holes be drilled first before drilling the 17/32" hole. Repeat this process for the opposite side of the lower control arm.



Figure 4 - Drill Mounting Hole

10. Install the urethane bushings on the sway bar using the provided Super Grease. Slide the sway bar bushing brackets over the bushings. **NOTE:** You can leave the plastic sleeve on the bar to protect the powder coat while installing the bar.
11. Position the DSE sway bar to the truck and bolt it up to the chassis brackets using the provided 3/8"-16 hardware. **NOTE:** The bolts will be installed in the chassis brackets, so they are pointing down. The bushing brackets will be installed onto the threads of the bolts (Figure 5).



Figure 5 - Position Sway Bar

12. Hold the sway bar in place by threading the provided 3/8"-16 Nylock nuts and washers over the threads of the bolts. Center the sway bar in the truck and tighten the bolts. Do not torque at this time.
13. Install the sway bar end links into the holes that were drilled into the lower control arms from Step 9. Install and tighten the end links with the provided M12-1.75 Nylock nuts and washers (Figure 6).



Figure 6 - Install Sway Bar End Links

NOTE: You may need to cut a relief in the flange to make clearance for the end links on some factory or aftermarket lower control arms (Figure 7).



Figure 7 - End Link Clearance

14. Before the sway bar can be installed onto the end links, rotate the factory tie rod adjuster clamps to face upward. **NOTE:** DSE offers tubular billet steel tie rod adjusters to replace the factory adjusters. For 1967-70 C10 truck use PN 090101BDS and for 1971-87 C10 truck use PN 090102BDS (Figure 8).



Figure 8 - DSE Billet Steel Tubular Tie Rod Adjusters

15. Install the sway bar end link to the sway bar by placing one of the stamped washers over the thread on the end link hex adapter followed by one of the grommets. Place this end of the end link through the sway bar mounting hole (Figure 9).



Figure 9 - Position Sway Bar to End Link

16. Place another sway bar grommet over the threads and onto the sway bar mounting hole followed by another stamped washer. Thread the provided 3/8"-16 Nylock nut onto the end link just enough to keep the bar on the end link (Figure 10). Repeat this process for the opposite side of the sway bar.



Figure 10 - Install Grommet & Washer

17. Tighten the 3/8-16 Nylock nuts on both end links. Do not over tighten, the end links are tight when the polyurethane bushings start to compress. (Figure 11).

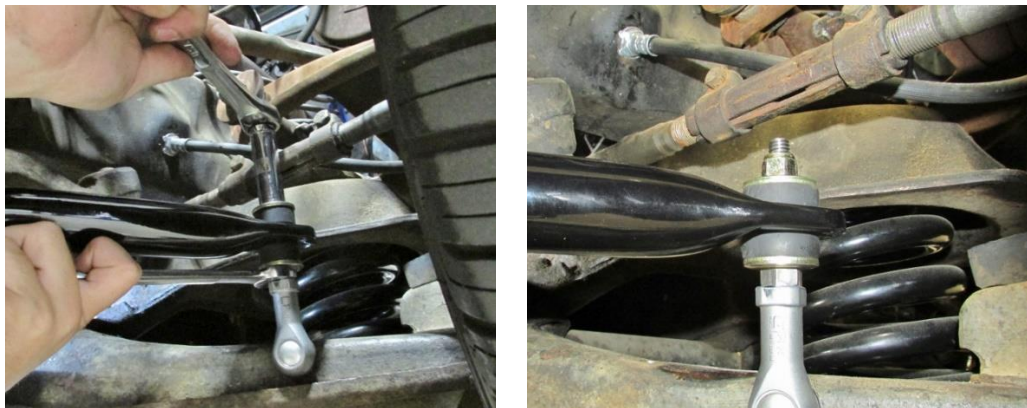


Figure 11 - Tighten End Links

18. Next, torque the 3/8"-16 fasteners that were installed in steps 11 & 12 in the sway bar bushing brackets to 35 ft-lbs. Torque the M12 hardware on the end links to 53 ft-lbs. that were installed in Step 13.

19. Separate the split lock collars into two pieces and place them around the sway bar to the inside of the sway bar bushings. Re-assemble the collars using medium strength blue Loctite 242 on the bolts and torque to 15 ft-lbs. (Figure 12). **NOTE:** Position the collars tight to the urethane bushings when installing.



Figure 12 - Install Split Lock Collars

20. The installation is now complete (Figure 13).



Figure 13

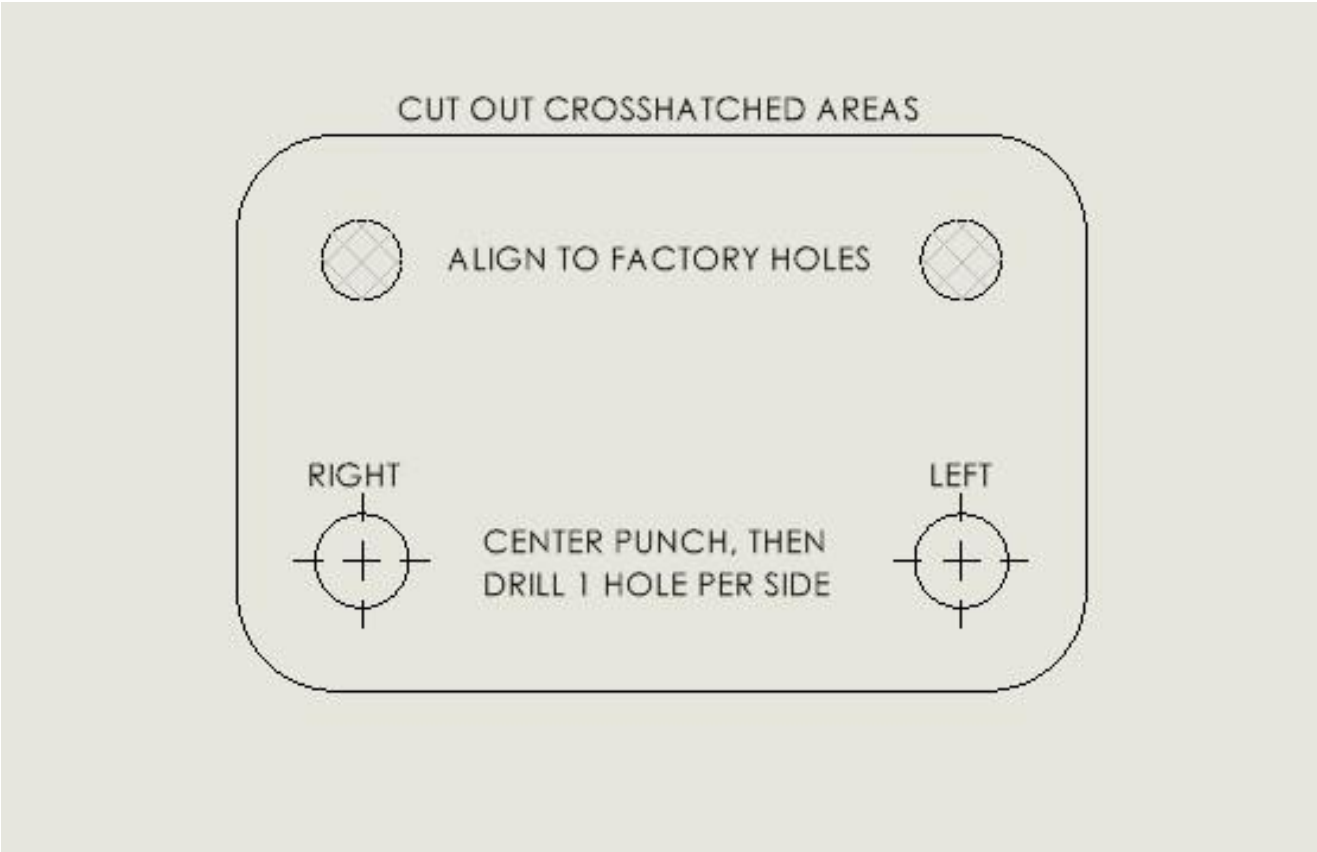


Figure 14 - End Link Drilling Template

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