

**Detroit Speed**  
**Frame Notch Bracket Kit – Coil Spring Rear**  
**1967-72 GM C10 Truck**  
**P/N: 040117DS**

The Detroit Speed Coil Spring Frame Notch Bracket Kit is 100% Bolt-on and is designed to give you clearance between the rear axle and the frame rail when dropping the ride height of your 1967-72 GM C10 truck. Our unique bracket design adds rigidity at the coil spring mounting point on the frame rail, separating our design from the competition. The frame notch brackets are manufactured from high quality 3/16" thick steel. All mounting hardware and bump stops are included in this kit. This kit is designed to work with both the DSE Speed Kits and the QUADRALink on factory coil spring frame rails only.



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

| Hardware Kit Checklist - Detroit Speed Frame Notch Bracket Kit |                                   |          |       |
|--|-----------------------------------|----------|-------|
| Part Number  | Description                       | Quantity | Check |
| 200114   | Frame Notch Bracket Hardware Bag  | 1        |       |
| 950042FS   | 7/16"-20 x 1-1/4" L Hex Head Bolt | 30       |       |
| 960050FS   | 7/16"-20 Nylock Nut               | 30       |       |
| 970043FS   | 7/16" SAE Washer                  | 60       |       |

***IMPORTANT:***

All work should be performed by a qualified technician. Please read the entire set of instructions and fully understand all 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](mailto:sales@detroitsspeed.com).

**Installation:**

1. Remove the bed from the truck. Raise the vehicle up on jack stands so that the frame is level with the ground. 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. Disconnect the rear brake line in the passenger side frame rail. The hardline will connect to a flex line that goes to the rear axle through a hole in the upper spring perch plate bracket.
3. 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 by removing the rivets from the frame rails (Figure. 1).



**Figure 1 - Remove Rear Axle Bump Stop Bracket**

4. Remove the upper spring perch plate from the bottom side of the frame rail by removing the rivets on the top and bottom of the frame rail (Figure 2 on the next page).

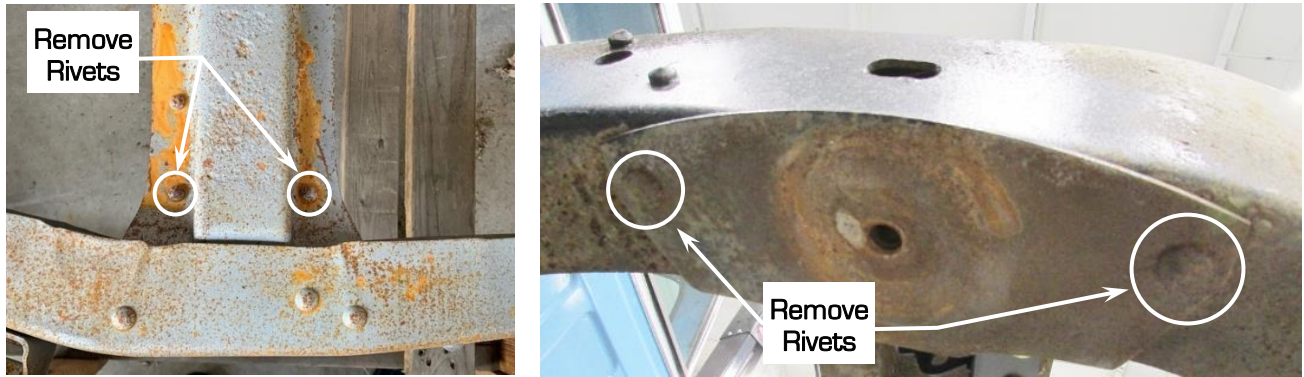


Figure 2 – Remove Spring Perch Plate

5. Remove the factory panhard bar mount bracket on the driver side frame rail by removing the four rivets on the bottom side of the frame rail (Figure 3).

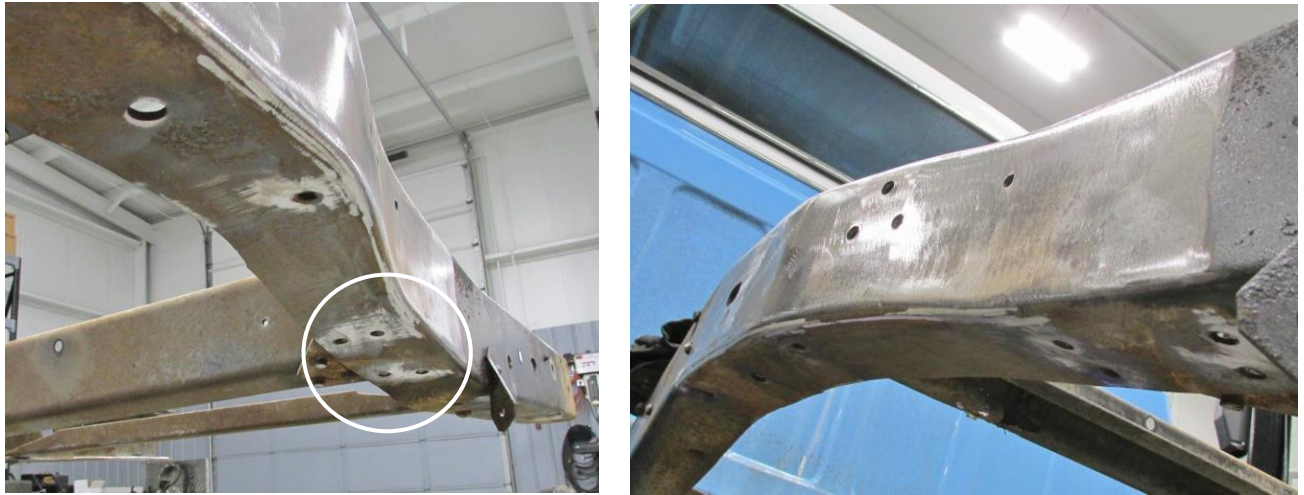


Figure 3 – Remove Factory Panhard Bar Bracket

6. Prepare the frame rails by grinding smooth the area of the frame rails that will have the frame notch bracket installed (Figure 4).



Figure 4 – Prepare Frame Rails

7. With the rear frame rails level, locate the centerline of the frame notch location on the side of the frame. Using the factory hole on the frame rail, measure back 14". Mark this centerline location (Figure 5). **NOTE:** Make sure the tape measure is level when you mark this location.



Figure 5 - Locate Notch Centerline

8. Place the frame notch template so it sits on the outside frame rail. Line up the centerline mark on the template with the centerline location marked on the frame rail from the previous step. Wrap the bottom of the template around the bottom side of the frame rail and tape the template in place (Figure 6).



Figure 6 - Frame Notch Template

9. 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 7).



Figure 7 - Trace Frame Notch Cutout

10. Drill two holes in the corners of the traced lines on the frame rail to make it easier to cut around the corners of the frame notch (Figure 8).



Figure 8 - Drill Frame Notch Corners

11. Cut along the traced lines to notch the frame rail. Grind all edges smooth (Figure 9). **NOTE:** We recommend cutting the frame rail and installing the frame notch bracket on one side of the frame before cutting the other frame rail for strength.



Figure 9 - Notch Frame Rail

12. 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 10).



Figure 10 - Frame Notch Assembly

13. Test fit the frame notch assembly to the frame. Locate the frame notch by aligning these four holes with the factory rivets holes that were drilled out in Step 5. Trim and grind any frame rail material away if needed so the frame notch assembly fits tight to the frame rails (Figure 11).

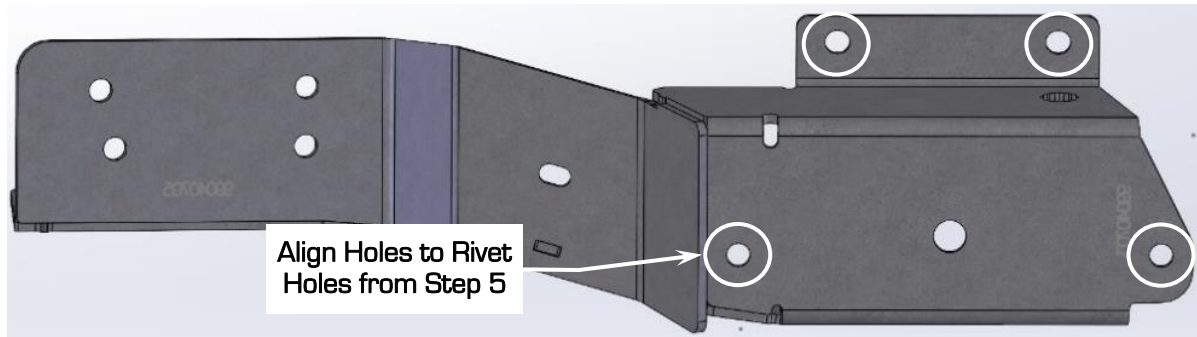


Figure 11 - Test Fit Frame Notch Bracket

14. Once the frame notch assembly fits around the frame rails, clamp the bracket in place and transfer punch the frame rail using the frame notch bracket assembly as a template. There will be seven locations to mark on the outside frame rail. **NOTE:** If you plan on installing the DSE track bar kit, there are four additional holes on the driver side that you need to transfer punch and drill. If you plan on installing the DSE QUADRALink, there are four additional holes on the passenger side frame rail that you need to transfer punch and drill. (Figure 12).

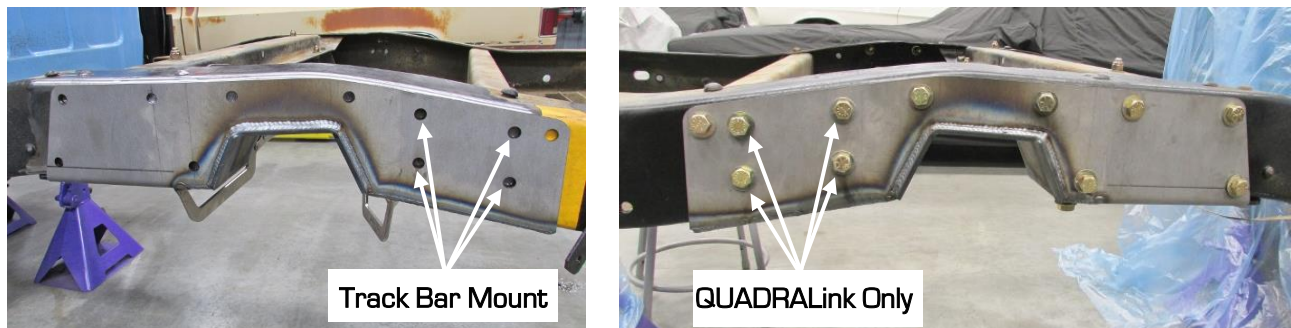


Figure 12 - Track Bar Mounting Holes

15. Transfer punch the bottom side of the frame rail using the frame notch bracket assembly as a template. There will be six locations to mark on the bottom frame rail.

16. Using a 15/32" drill bit, drill through the two mounting holes on the inside of the frame notch bracket that line up with the two holes in the cross member. These holes were left open when the rivets were removed in Step 4.

17. Remove the frame notch bracket assembly and drill out all thirteen locations on the frame rail for the 7/16"-20 hardware to a final drill size of 15/32" (Figure 13). **NOTE:** It is recommended that pilot holes be drilled first before drilling the 15/32" holes.



Figure 13 - Drill Frame Rail

18. Before installing the frame notch bracket assembly, DSE recommends painting/ powdercoating the bracket and the area of the frame rail that will be covered by the bracket to prevent surface rust.

19. Install the frame notch bracket assembly onto the frame rail using the provided fifteen sets of 7/16"-20 x 1-1/4"L hex head bolts, Nylock nuts and washers (Figure 14). Use anti-seize on the threads of the bolts. Tighten the hardware on the outside of the frame rail first, and then tighten the bottom hardware. Torque the 7/16"-20 hardware to 50 ft-lbs.



Figure 14 - Install (LH, Driver Side) Frame Rail Notch Bracket

20. Repeat Steps 4 through 19 for the other side of the truck (Figure 15).

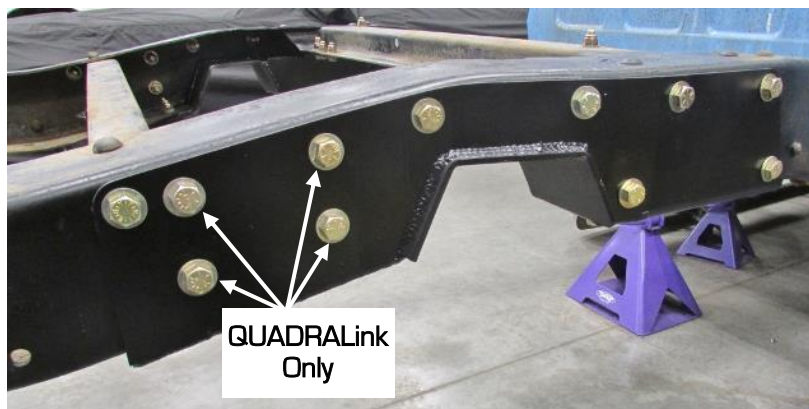


Figure 15 - Frame Notch Assembly (RH, Passenger Side)

21. If you are re-using the factory panhard bar, re-install the panhard bar bracket to the driver's side frame rail using hardware. DSE recommends using PN: 040118DS, Track Bar and Shock Relocation Kit.
22. Install the jounce bumper into each frame notch assembly at the frame notch using the provided 3/8"-16 Nylock nut and washer and tighten (Figure 16).

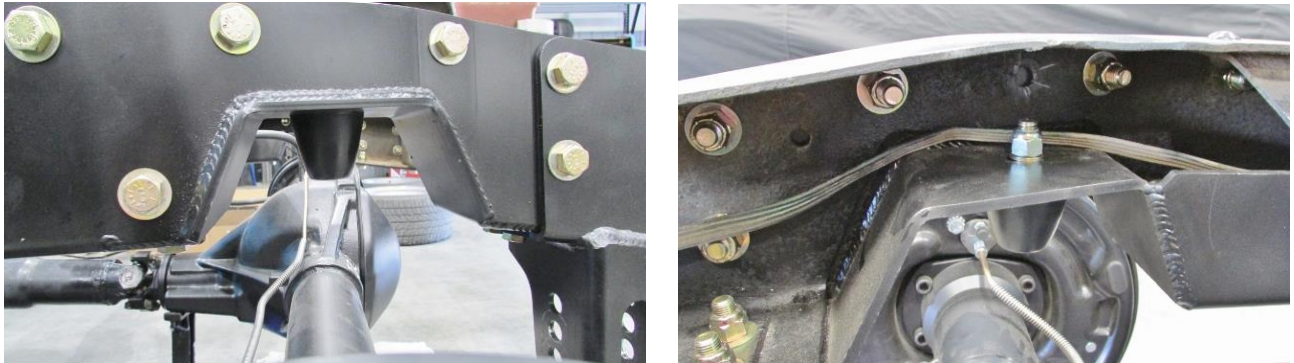


Figure 16 - Install Jounce Bumper

23. Re-connect the brake line fitting through the brake line hole in the passenger side frame notch bracket assembly. Tighten the fitting between the hardline and the flex line at the frame notch bracket (Figure 17).



Figure 17 - Re-connect Brake Line

24. Bleed the brakes once the brake hose has been reconnected. The installation is now complete.

If you have any questions before or during the installation of this product, please contact Detroit Speed at [sales@detroitsspeed.com](mailto:sales@detroitsspeed.com) or 704.662.3272