

INSTRUCTIONS

**910-31909
COMPLETE KIT**

**916-31909
BRACKET KIT ONLY**
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'37-'48 FORD SPINDLE 5 1/2" B.C. BRAKE KIT

THIS KIT WILL NOT WORK WITH FORGED AFTER MARKET STEERING ARMS!

— This kit will work with spindles having original steering arms or with flat plate steering arms. —
Wheels must have a 3 7/16" center hole and be designed for disc brake applications.

PLEASE READ INSTRUCTIONS COMPLETELY BEFORE STARTING YOUR INSTALLATION!

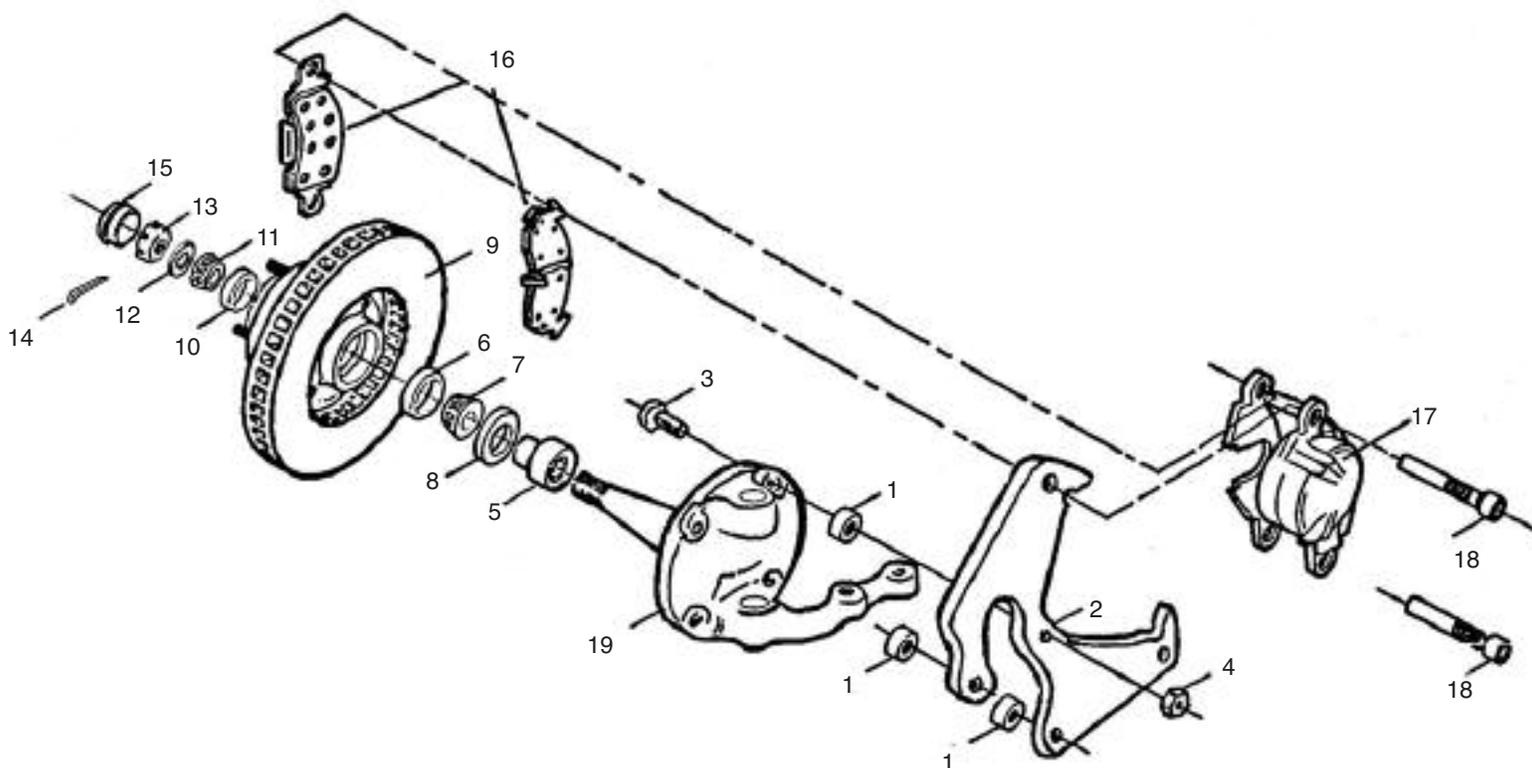
This disc brake kit installs '73-'77 Ford 1/2 ton 2WD pickup rotors and '71-'76 Chevy Impala calipers on '37-'48 Ford spindles.

Parts List

Index No.	Description	Part Number	Quantity
*	Hardware kit	916-31909-2	1
1	Bracket spacers 5/8"	In hardware kit	6
1	Bracket spacers 1/4"	In hardware kit	4
2*	Caliper mounting brackets	916-31909-1	2
3	1/2" -20x2" GR 8 bolts	In hardware kit	6
	1/2" -20x1 1/4" GR 8 bolts	In hardware kit	2
4	1/2" -20 Locking nut	In hardware kit	6
5*	Bearing adapters	910-09301	2
6	Inner bearing cup	Supplied in rotor	2
7	Inner bearing cone	912-TL68149	2
8	Grease seal	912-S18580	2
9	5 1/2" bolt circle rotors	910-31068	2
10	Outer bearing cup	912-TLM11910	2
11	Outer bearing cone	912-TLM11949	2
16	Brake pad (set)	919-3382	1
17	'71-'76 Chevy Impala caliper-L	910-31044-L	1
17	'71-'76 Chevy Impala caliper-R	910-31044-R	1
18	Caliper bolts	835-2300542	4
Other Parts needed:			
**	Spindle nut kit	910-616004	1
12	Spindle washer	In spindle nut kit	2
13	Spindle nut	In spindle nut kit	2
14	Cotter pin	In spindle nut kit	2
19**	'37-48' Ford spindle (pr)	916-32104	1
**	16" Stainless steel brake line kit (7/16-20 thread for speedway calipers)	617-8562	1
* bracket kit parts only			
** not included			

BRAKE INSTALLATION ALERT: The selection and installation of brake components should only be done by personnel experienced in the proper installation and operation of braking systems. The installer must use his/her own discretion to determine the suitability of the brake components and brake kits for every particular application

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1. Using the parts list, double check that you received all the parts in this kit. If there are any missing parts, please contact the customer service department.
2. Carefully install the bearing adapter (#5) onto the spindle, making sure the flanged side goes toward the spindle and is fully seated. You can use a press to install the adaptor on the spindle or the adaptor can be heated at 400 degrees for 20 minutes then slid onto the spindle. Allow to cool slowly at room temperature.
3. Remove the stock Ford outer bearing race from the rotor. Install the new bearing race (#10) supplied in the kit. **NOTE:** The stock outer bearing race **WILL NOT WORK WITH THIS KIT**. It must be replaced with the new bearing race supplied in the kit.
4. Bolt the caliper bracket (#2) to the spindle. The bracket mounts on the axle side of the spindle and the caliper mounts to the rear. From the wheel side of the spindle, install the three 1/2"-20x2" GR 8 hex head bolts (#3), followed by the 5/8" spacer (#1), the caliper bracket (#2). Secure with the three 1/2"-20 locking nuts (#4) and torque to 38-57 fit lbs.

If you are using bolt on flat plate steering arms, use the 1/4" spacers supplied on both lower mounting holes. On the lower rear mounting hole, install the 1/2"-20x2" bolt through the spindle followed by the 1/4" spacer, the steering arm and then the caliper bracket. Secure with the 1/2"-20 locking nut. Use the 1/2"-20x1 1/4" GR 8 bolt and locking nut to mount the front of the steering arm to the spindle. Torque to 38-57 ft. lbs.

5. Pack and install the inner bearings (#7) with fresh disc brake bearing grease and install the grease seal (#8). The seals must be installed straight. A seal installation tool works well for this.

6. Install the rotor (#9) on to the spindle, pack and install the outer bearing (#11). Install the spindle washer (#12) and spindle nut (#13). Adjust the bearing preload as normal. Install the cotter pin (#14) and dust cap (#15).
7. Install the brake pads (#16) into the calipers (#17) and install the calipers on to the mounting brackets (#2) with the bleeders pointing up. Only use the correct GM mounting bolts (#18).
8. Install new brake lines making sure you check that the lines have clearance through the entire suspension travel and turning radius. Bleed the system as normal.
9. Before operating the vehicle, test the brakes under controlled conditions. Make several stops in a safe area from low speeds and gradually work up to operating speeds.

NOTE: Some wheels will not clear the snout on the rotors. Wheels must have a 3^{7/16}" center hole and be designed for disc brake applications to work with this kit.

IMPORTANT

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