



These instructions can be found in color and expandable at QA1.net

Technical Support Line: (952) 985-5675 Email: sales@QA1.net

INSTALLATION INSTRUCTIONS

QA1 P/N 52883 Front Sway Bar with QA1 Crossmember
'63 - '86 Chevrolet/GMC C Series Pickup, '87 - '91 Chevrolet/GMC R Series Pickup

TOOLS AND SUPPLIES REQUIRED

- Floor Jack
- Jack Stands
- Drill
- Crescent Wrench
- Two Clamps
- 3/8" Drill Bit
- SAE Socket Set

PRE INSTALLATION NOTES:

This sway bar is designed to work with the QA1 front coil-over suspension with QA1 crossmember. This sway bar **WILL NOT WORK** with factory control arms.

1963-1966 Trucks

The frame brackets on '63-'66 trucks WILL NOT use the existing frame holes described in these instructions. Begin installation starting at step 14 to attach the bar to the lower control arms first. With the frame bushings and mounts installed on the sway bar and the truck at ride height, swing the bar up to the frame. Use the frame brackets to show where the mounting bolt holes should be marked and drilled. Refer to step 6 for frame bracket hardware description.



SWAY BAR INSTALLATION:

NOTE:

On '67-'91 trucks, the sway bar mounting bracket will need to be mounted to the truck frame dependent on the year of the truck. See the specific instructions for the year ranges below.

'67-'72 Trucks:

1. Trucks equipped with a factory sway bar will have factory mounting brackets that share the crossmember rivet hole while the QA1 bracket will need to be mounted 1.5" forward of the crossmember rivet hole. Trucks not equipped with a factory front sway bar will have a rivet securing just the crossmember. Measure 1.5" forward of the crossmember rivet/hole and drill using a 3/8" drill bit. (Figure 1)



- If a factory sway bar bracket was removed leaving the crossmember mounting hole empty, use a bolt to secure this now empty hole to re-fasten the crossmember connection. **(Figure 2)**
- Install the high-offset side of the QA1 bracket into the hole drilled 1.5" forward of the crossmember hole using the included 3/8" x 1" hardware with two washers and one nyloc nut per connection. **(Figure 2)**
- Before fully installing the bracket to the frame, install two 3/8" x 1" bolts into the center holes of the bracket facing down. **(Figure 3)**

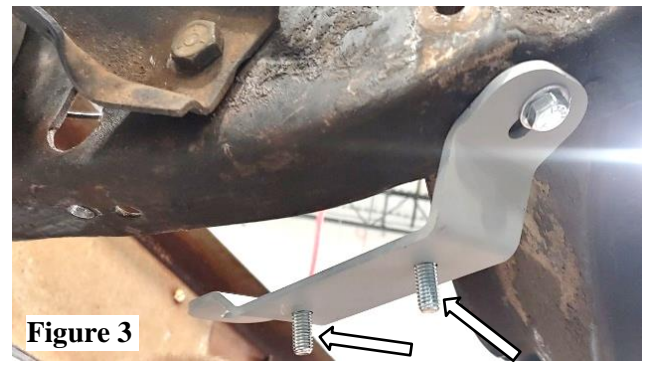


Figure 3

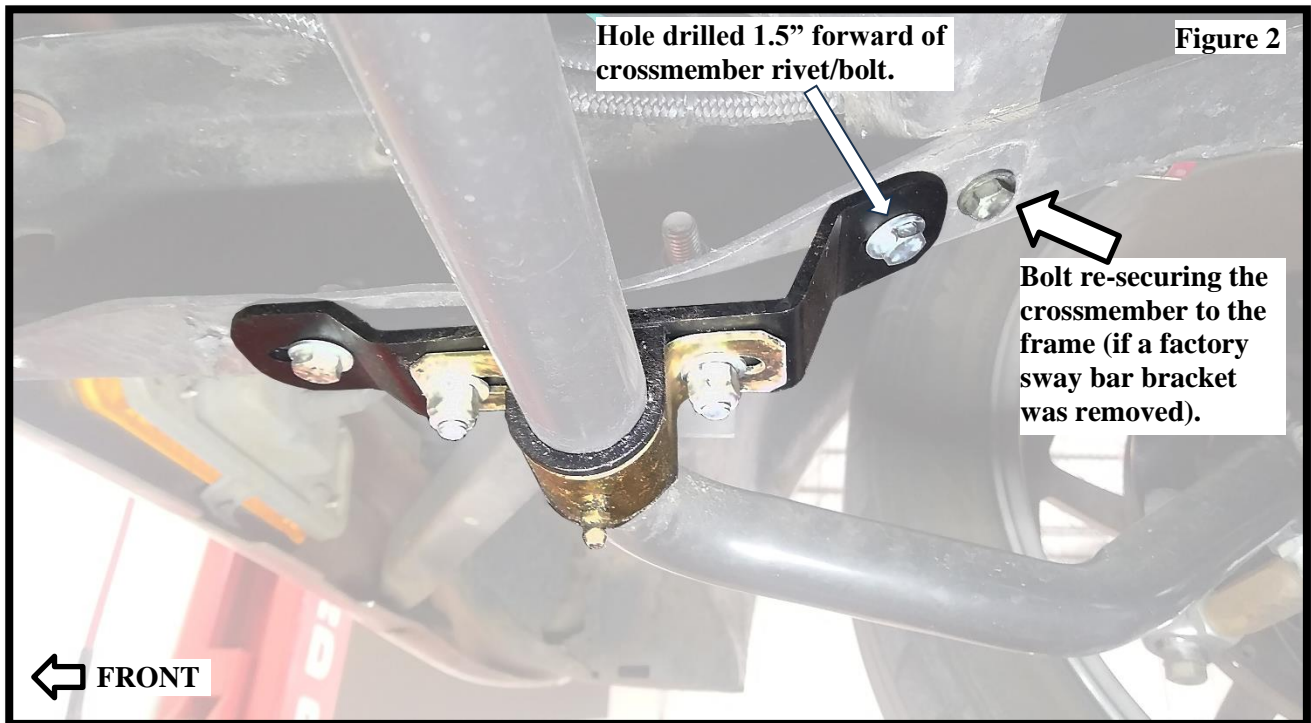


Figure 2

- The front hole of the QA1 bracket will land on a larger slotted hole in the frame. Secure this connection using the larger washers included in the hardware kit with 3/8" x 1" bolts and nyloc nuts.
- Torque all bracket hardware to 31 lb. ft.

'73-'91 Trucks:

- '73 – '91 trucks equipped with a factory sway bar will use the factory bracket holes for the QA1 bracket. **(Figure 4)**
- '73 – '91 trucks NOT equipped with a factory sway bar will not have factory sway bar brackets, but the rearward hole that the bracket would have mounted to will be present. Mount the larger offset side of the QA1 bracket to the rearward hole using 3/8" x 1" hardware with two washers and one nyloc nut per connection.

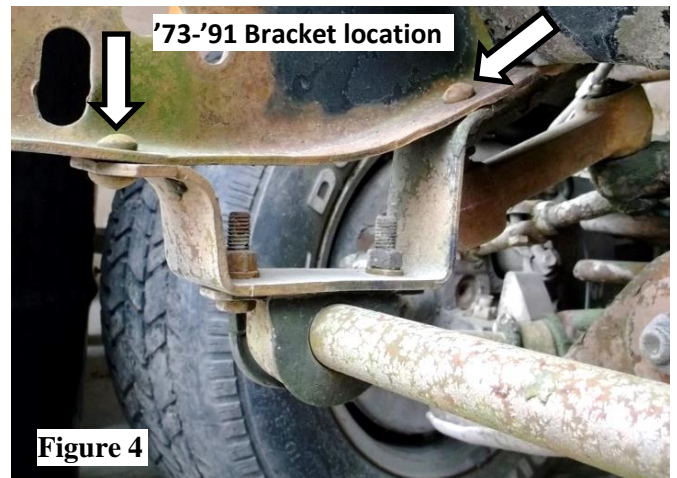


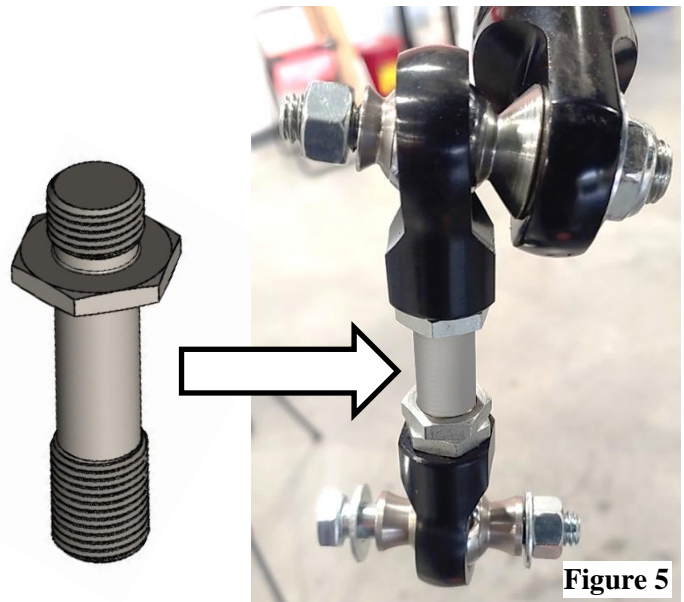
Figure 4

9. Before installing the bracket to the frame, install two 3/8" x 1" bolts into the center holes of the bracket facing down. **(Figure 3)**
10. Mount the front connection of the QA1 bracket to the existing factory bracket hole (if truck was equipped with a sway bar) or mark and drill the front hole of the bracket onto the frame with a 3/8" drill bit.
11. Secure the front bracket connection using 3/8" x 1" hardware, with two washers and one nyloc nut per connection. Torque to 31 lb. ft.

AFTER THE BRACKET IS MOUNTED:

12. Lightly grease the inner bushings before wrapping them around the sway bar followed by the included bushing straps. Raise the bar up to the downward facing bolts installed earlier and secure the bar to the bracket using one washer and 3/8" nyloc nut. **(Figure 6)**
13. Center the sway bar to the frame.
14. Assemble the two female rod ends onto the included stud with one jam nut on the non-hex side of the stud. A small amount of Loctite should be used on the fixed hex head end of the stud before installing the rod end. **(Figure 5)**

15. Insert the small diameter face of the misalignment stud into the bore of the rod end with one SG8-64 spacer into the opposite side of the rod end bore. Secure with 3/8" nut. **(Figure 5)**
16. Insert the large face of the misalignment stud into the end of the bar on the outboard side and fasten using one 1/2" washer and nyloc nut. **(Upper portion of Figure 5)**
Torque the end link to sway bar stud to 31 lb. ft.
17. On the control arm side of the linkage, insert one SG8-67 misalignment spacer in each side of the rod end bore. **(Lower portion of Figure 5)**
18. Insert the end link into the tabs on the lower control arm and fasten with 3/8" x 2.5" hardware with two washers and one nyloc nut. Torque to 31 lb. ft.



19. Check the clearance of the rod end and inner tie rod at full droop. Full droop is where these items will be closest to each other. Additional clearance can be gained by sliding the sway bar frame mount forward in its slotted holes.



HARDWARE KIT

1st Description	2nd Description	Qty.
Bolt, 3/8-16 x 2.5"	Grade 5, Clear Zinc	2
Bolt, 3/8-16 x 1.25"	Grade 5, Clear Zinc	2
Bolt, 3/8-16 x 1"	Grade 5, Clear Zinc	8
Bolt, 3/8/16 x .875"	Grade 5, Clear Zinc	2
Washer, SAE, 3/8	Grade 5, Clear Zinc	24
Washer, SAE, 1/2	Grade 5, Clear Zinc	2
Nut, Nylock, 3/8-16	Grade 5, Clear Zinc	14
Nut, Nylock, Thin Jam, 3/8-16	Grade 5, Clear Zinc	2
Nut, Nylock, Thin Jam, 1/2-20	Grade 5, Clear Zinc	2



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