



Detroit Speed, Inc.
Rear Anti-Roll Bar Kit
1982-92 Camaro/Firebird
P/N: 042219, 042222

The Detroit Speed Inc., Rear Anti-Roll Bar Kit offers multiple advantages over the stock rear bar. This DSE kit comes with a 1" OD tubular bar for added strength and works for most street applications. The bar is powder coated in a high gloss black finish, includes all necessary hardware and has split lock collars that positively locates the anti-roll bar in the correct location. The anti-roll bar offers dual rate adjustment for increased vehicle tuning.



Item	Part Description	Quantity
1	1" OD Tubular Rear Anti-Roll Bar	1
2	1" OD Polyurethane Anti-Roll Bar Bushing	2
3	Anti-Roll Bar Bushing Mount	2
4	2-3/4" Rear Anti-Roll Bar Axle Clamp (P/N: 042219)	2
4	3" Rear Anti-Roll Bar Axle Clamp (P/N: 042222)	2
5	1" Split Lock Collar	2
6	7/16"-20 x 2-3/4" x 4-1/2" U-Bolt (P/N: 042219)	2
6	7/16"-20 x 3" x 4-7/8" U-Bolt (P/N: 042222)	2
7	7/16"-20 Nylock Nut	4
8	7/16" Flat Washer	4
9	Anti-Roll Bar End Links	2
10	Super Grease	1
11	Instructions	1

Fastener Torque Specifications	
Application	Torque (ft-lbs)
Anti-Roll Bar Mounting U-Bolts	25
Split Lock Collar	15

1. To begin installation, loosen the rear lug nuts and raise the front and rear of the vehicle. Support the vehicle in the front and rear on jack stands so the vehicle is sitting level. The rear suspension must be supported so that the rear suspension is at ride height in relation to the body. Remove the rear wheels.
2. Remove the existing anti-roll bar from the vehicle. Place the 7/16"-20 x 2-3/4" x 4-1/2" U-bolts (P/N: 042219) or the 7/16"-20 x 3" x 4-7/8" U-bolts (P/N: 042222) over the rear axle tubes. **NOTE:** It may be necessary to move the brake lines slightly to allow the U-bolts to slide under the brake line.
3. Position the clamps so they line up correctly on the rear axle tube. For P/N: 042219 only, the rear axle clamps have a notch to locate on the tab on the factory rear axle tube (Figure 1 and 2).

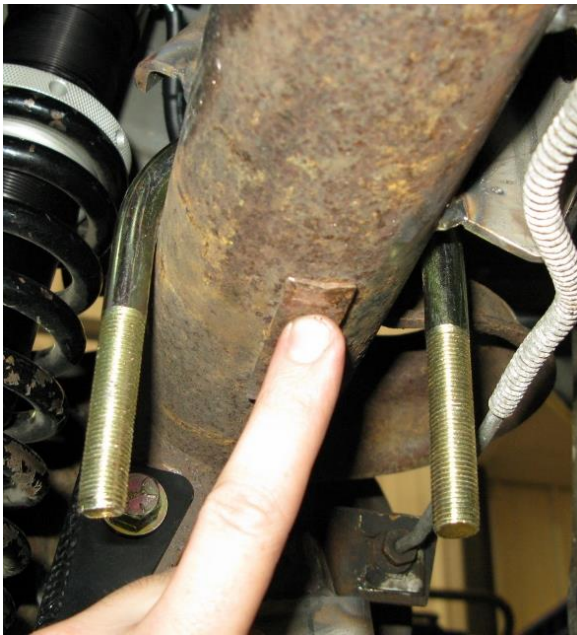


Figure 1 - Locating Tab (P/N: 042219)



Figure 2 - Rear Axle Clamp (P/N: 042219)

4. Install the urethane bushings on the anti-roll bar using the provided Super Grease and position the anti-roll bar bushings as close to the 90° bends on the anti-roll bar as possible. Place the anti-roll bar mounting clamps on the bushings at this time.
5. Position the anti-roll bar on the rear axle clamp through the U-bolt. Thread the 7/16"-20 Nylock nuts and washers on the U-bolt. Repeat this for both sides. Leave the Nylock nuts finger tight at this point (Figure 3 on the next page).



Figure 3 - Anti-Roll Bar Mounting Bracket

6. Disassemble the anti-roll bar end links and re-assemble the end links between the anti-roll bar and the anti-roll bar factory mount. **NOTE:** It may be necessary to reposition the anti-roll bar in the mounts to better line up the end links. Do not over tighten the end links. The end links are tight when the polyurethane bushings start to compress (Figure 4). Repeat this for both sides.



Figure 4 - Anti-Roll Bar End Links

7. There are 2 mounting points on the anti-roll bar for the anti-roll bar end links. The chart below lists the rates for each hole (Figure 5). DSE recommends using the rearward mounting hole.

Anti-Roll Bar Rates	
Front Hole	620 lbf/in
Rear Hole	784 lbf/in

Figure 5 - Anti-Roll Bar Rates

8. With the anti-roll bar installed, verify the bar is centered on the rear axle and tighten the brackets at the rear axle. Torque these bolts to 55 ft-lbs.
9. Separate the split lock collar into two pieces and place them around the anti-roll bar to the inside of the anti-roll bar clamps on the rear axle. Reassemble the collar using medium strength blue Loctite 242 on the bolts and torque to 15 ft-lbs. Repeat this step for both sides. **NOTE:** Position the collars tight to the urethane bushings when installing (Figure 6).

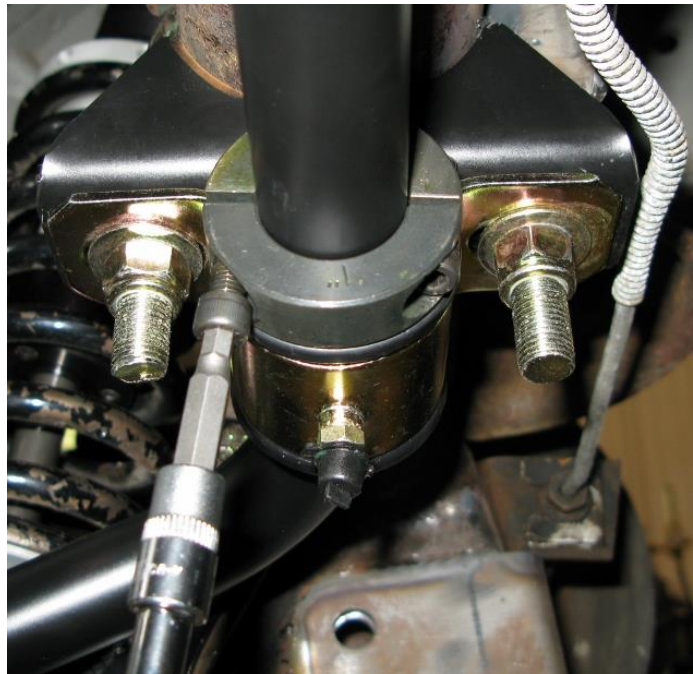


Figure 6 - Split Lock Collars

10. After installation, lubricate the bushings with quality chassis grease. Detroit Speed offers Driven Extreme Pressure chassis grease available as P/N: 140103 if needed.
11. Reinstall the rear wheels and torque to the manufacturer's recommended torque specs. Lower the vehicle to the ground. The installation is now complete.

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

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