

Detroit Speed
Leaf Spring Flip Kit
1973-87 GM Square Body Truck
P/N: 040116DS

The Detroit Speed Leaf Spring Flip Kit is designed to lower the ride height of your 1973-87 GM C10 Square Body truck. The flip kit axle pad and plate are manufactured from high quality 1/4" thick steel and powder coated black for durability. Detroit Speed has designed this kit with two leaf spring pin hole locations in the axle pad to have adjustability in centering up your rear axle. New U-bolts and hardware are included in this kit and are electroplated to help against corrosion.



Item #	Description	Quantity
1	Leaf Spring Flip Kit Axle Pad	2
2	Leaf Spring Flip Kit Plate	2
3	Leaf Spring Flip Kit Lower Shock Mount	2
4	Leaf Spring Hardware Kit	1
5	Leaf Spring Installation Kit	1
6	Instructions	1

NOTE: This kit is designed for 3/1 leaf springs only.

IMPORTANT:

All work should be performed by a qualified technician. Please read the entire set of instructions and fully understand all of 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 tech@detroitsspeed.com.

Hardware Kit Checklist – DSE Leaf Spring Flip Kit			
Part Number	Description	Quantity	Check
200079	Flip Kit Hardware Bag	1	
980026FS	1/2"-20 x 2-1/2" L Hex Head Bolt	2	
980040FS	1/2"-20 x 1-1/4" L Hex Head Bolt	2	
980131FS	9/16"-18 x 2-3/4" L Hex Head Bolt	2	
960004FS	1/2"-20 Nylock Nut	4	
930109FS	9/16"-18 Half Height Nylock Nut	2	
970037FS	1/2" SAE Washer	8	
970020FS	9/16" SAE Washer	4	
970071FS	5/8" Flat Washer	8	
99040040	5/8" U-Bolt with Nuts	4	
99040701	Lower Shock Mount Crush Tube	2	

Installation:

1. Raise the vehicle on jack stands so that the frame is level with the ground. It is not required to remove the bed from the vehicle however it will make installation easier. **NOTE:** You will need to remove the bed to install the required frame notch bracket kit (P/N: 040115DS) so this would be a good time to install both kits with the bed removed.
2. Remove the rear wheels from the rear axle. Support the rear axle with a floor jack so the rear brake lines are not in tension.
3. Remove the shocks from the axle brackets to let the rear axle drop down. With the rear axle in full droop, place a jack stand underneath the pinion yoke and the rear axle tubes to keep the rear axle from rotating forward.
4. Remove the U-bolts that attach the rear axle to the leaf spring on one side of the truck. Move the leaf spring underneath the rear axle. **NOTE:** We recommend unbolting the leaf spring from the truck to help move the leaf spring below the rear axle.
5. Re-install the leaf spring back into the truck. Do not install the U-bolts at this time. Repeat Steps 4 and 5 for the other leaf spring.
6. With the rear axle ontop of the leaf springs, install the flip kit axle pads between the leaf springs and the rear axle (Figure 1).



Figure 1 – Install Flip Kit Axle Pad

7. The bottom of the flip kit axle pad has two holes to locate the stock leaf spring bolt (Figure 2). The hole should be offset towards the front of the truck so the axle pad moves the rear axle towards the rear of the truck. **NOTE:** The axle pad has a V-notch on one end (Figure 3). When installing the axle pads, the V-notch should be on the same side of the axle on the left and right hand side of the rear axle. We recommend the V-notch to be towards the rear of the truck.



Figure 2 - Locate Axle Pad

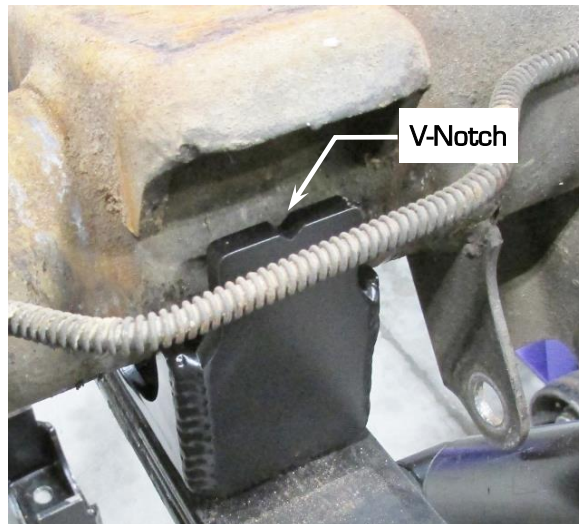


Figure 3 - Axle Pad V-Notch

8. Install the provided U-bolts over the rear axle and through the holes on the new Detroit Speed flip kit plates placed underneath the leaf springs (Figure 4). Use anti-seize on the provided U-bolt hardware and draw up the U-bolts until they are snug. Continue to tighten the U-bolts in a cross pattern and torque to 95 ft.-lbs.



Figure 4 - Install Flip Kit Plate

9. Install the provided lower shock mount crush tube in between the tabs of the factory lower shock mount on the factory axle bracket. Make sure the crush tube lines up with the lower shock bolt hole in the factory axle mount (Figure 5).

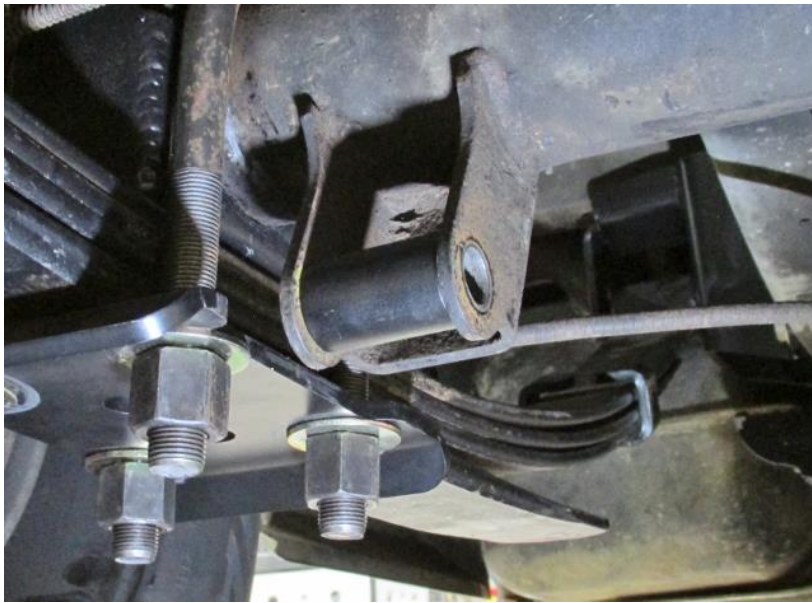


Figure 5 - Lower Shock Mount Crush Tube

10. Place the provided lower shock bracket around the factory lower shock mount on the rear axle. Install the provided 1/2"-20 x 1-1/4"L hex head bolt and 1/2" washer through the front side of the lower shock bracket and through the hole in the factory lower shock mount. Place the provided 1/2"-20 Nylock nut and 1/2" washer on the threads of the bolt (Figure 6). Use anti-seize on the threads of the fasteners and tighten.

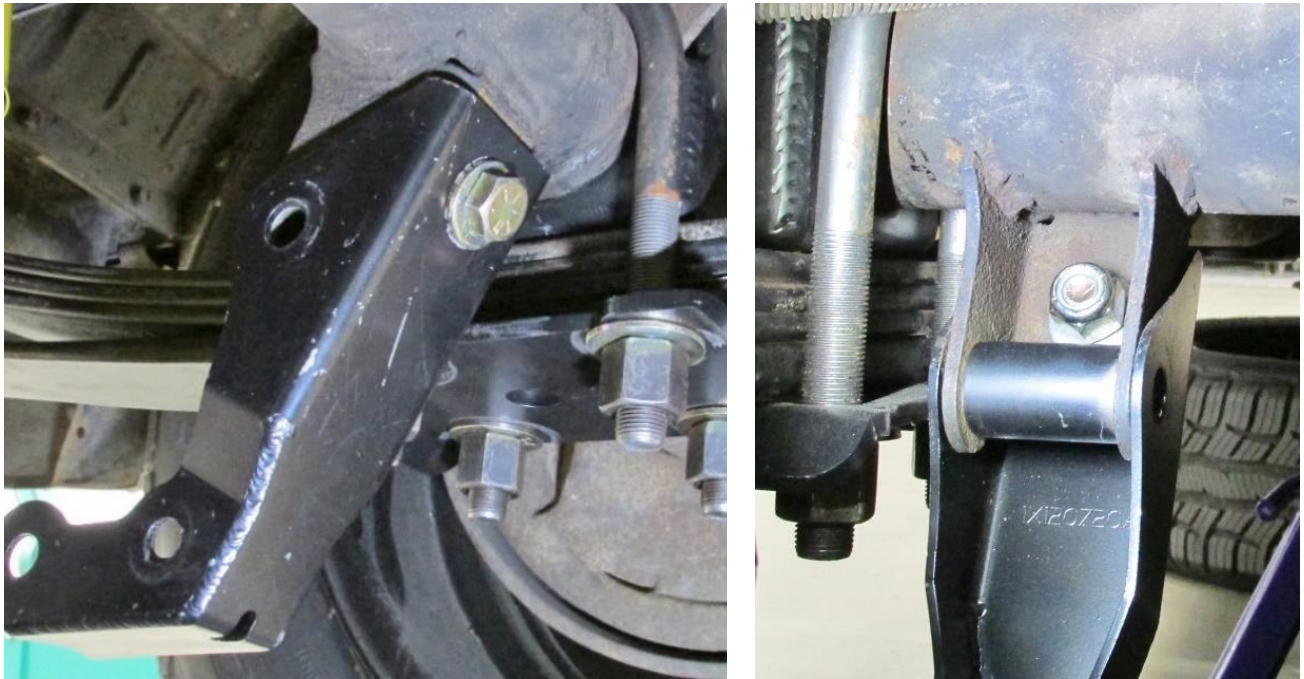


Figure 6 - Lower Shock Mount

11. Install the provided 9/16"-18 x 2-3/4"L hex bolt and 9/16" washer through the inboard side of the shock bracket and through the crush tube in the factory lower shock mount. Place the provided 9/16"-18 half height Nylock nut and 9/16" washer on the threads of the bolt (Figure 7 on the next page). Use anti-seize on the threads of the fasteners and tighten.

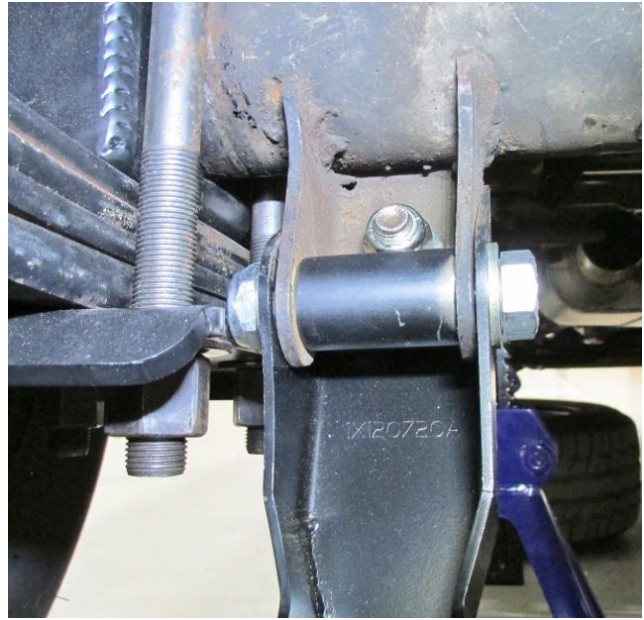
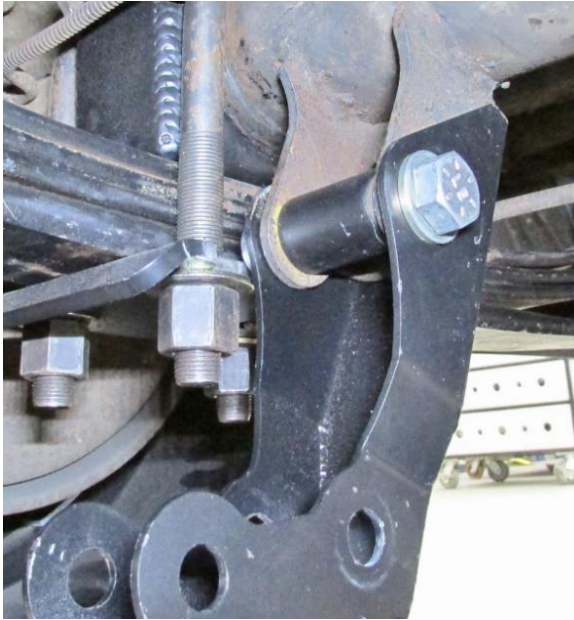


Figure 7 - Install Hardware

12. Torque the 1/2"-20 fasteners on the lower shock mount to 50 ft.-lbs. and the 9/16"-18 fasteners to 65 ft.-lbs.
13. Place the shock into the lower shock mount and install the provided 1/2"-20 x 2-1/4" L hex head bolt and 1/2" washer through the inboard side of the lower shock mount so it passes through the shock. **NOTE:** There are two shock mounting options in the lower shock brackets. On the driver side, the shock will mount in the hole closest to the rear axle. On the passenger side, the shock will mount in the hole furthest from the rear axle (Figure 8 and 9).



Figure 8 - Driver Side



Figure 9 - Passenger Side

14. Place the provided 1/2"-20 Nylock nut and 1/2" washer on the threads of the bolt. Use anti-seize on the threads of the fasteners and torque to 50 ft.-lbs. Repeat Steps 9 through 13 for the opposite side of the vehicle.
15. Re-install your wheels and torque to the recommended setting. Set the truck on the ground. Installation is now complete.

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

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