



## INSTALLATION INSTRUCTIONS

6300

### FLIP KIT

#### CHEVY ASTRO VAN / GMC SAFARI VAN

**Congratulations! You were selective enough to choose a BELLTECH PRODUCT. We have spent many hours developing our line of products so that you will receive maximum performance with minimum difficulty during installation.**

- Note: Confirm that all of the hardware listed in the parts list is in the kit. **Do not** begin installation if any part is missing. Read the instructions thoroughly before beginning this installation.
- Warning:** **DO NOT** work under a vehicle supported by only a jack. Place support stands securely under the vehicle in the manufacturer's specified locations unless otherwise instructed.
- Warning:** **DO NOT** drive vehicle until all work has been completed and checked. Torque all hardware to values specified.
- Reminder: Proper use of safety equipment and eye/face/hand protection is absolutely necessary when using these tools to perform procedures!
- Note: It is very helpful to have an assistant available during installation.

#### **RECOMMENDED TOOLS:**

- Properly rated floor jack, support stands, and wheel chocks
- Combination wrench set
- Torque wrench: *0-75 lb ft. range*
- Ratcheting socket wrench and socket sets
- Air Chisel / Die grinder W/ cut off wheel
- Safety Glasses

#### **! NOTICE**

Please note that this kit (6300 or 6302) was not designed to be used with the factory rear Anti-Sway Bar. You will need to use the Belltech Anti-Sway Bar in place of the OEM bar for added clearances (Part Number 5528). This bar will also fit on a stock vehicle.

#### **KIT INSTALLATION**

1. Open the hardware kit and remove all of the contents. Refer to the part list (Page 3) to verify that all parts are present.
2. Remove the rear wheels. Remove the U-bolts and inner axle tube retaining plates.
3. Remove the ground cable from the battery. Loosen the screw clamp on the fill tube going into the gas tank. Pull the protective plastic shroud around the passenger side of the tank away from the body. This will most likely break the plastic fasteners. New ones are provided in the hardware kit. Unscrew the four bolts holding the gas tank support straps in place. The fill hose will pull away from the tank.  
**CAUTION:** Let the tank down slowly so the connecting hoses won't be damaged. Gasoline fumes are extremely flammable; extinguish all open flames and no smoking during this period of time. (Picture #3)
4. Remove the two bolts holding the front springs into the hanger housing. Save these bolts for use in re-installation. (Pictures #4 & #5) Lubricant may have to be used in aiding the bolt removal. Lower the

floor jack slightly so the spring bracket will slide out of the hanger housing. (Picture #6) (Note: Power tools may be of help in the removal and re-installation process.)

5. Remove the bottom bolts on the rear shackles. Lower the floor jack slightly so the rear spring bracket will slide out of the shackle. Remove the upper bolts holding the shackle to the frame. Remove the stock shackle and save stock mounting bolts for use in the re-assembly process. (Picture #7) Note the direction of the stock shackles to be able to install the new shackles in the correct direction.
6. Remove the fiberglass spring assemblies from both sides of the vehicle, by prying the rear axle perch assembly away from the rubber cushion from the spring. (Picture #8)
7. Carefully remove the spring saddle away from the rubber spring cushion. Be careful not to damage the rubber cushion. Again, do not remove the upper or lower rubber cushion from the spring.
8. Apply the lubricant on the rubber spring cushion. Place the new saddle on the rubber cushion. **(NOTE: There is a right and a left side on these parts, the portion of the saddle that has the up right welded edge with the recess for the axle tube faces out on both sides.)** Line up the ridges on the cushion and the recesses on the saddle and set into place with a rubber mallet.
9. Install the front spacer plates into the spring hanger pockets with the joggle in the plates out away from the spring pockets and the slots facing up. Slide the round spacer tubes between the spring plates and use the new 9/16 by 6" bolts and nuts to connect the assembly together. Snug these only, you will tighten these later. (Picture #9)
10. Slide the spring assembly under the rear end housing. You will have to raise the axle housing some for the next steps.
11. Open the brake line clamp on the axle housing and slide the steel line out of the clamp and away from the housing slightly.
12. Lift the front of the spring up and fit the spring into pockets between the new spacer plate. Slide the stock hanger bolts through the front holes of the spacer plates and springs. Lift the rear of the spring higher to line up the rear holes and slide the rear two bolts through the other holes in the plates and springs. (Picture #10)
13. Install the new rear shackles to the frame using the stock hardware removed in step #5. Lift the spring into place in the bottom portion of the new shackle and insert the stock bolts. Thread on and snug these bolts only. You will tighten these later. (Picture #11)
14. Lower the axle assembly into place, making sure that the steel brake lines are cleared. The vertical tabs on the new saddles will position themselves into place in the spring perches on the axle when the axle is at rest. (Picture #12) **Caution: Be certain the saddle tabs seat inside the axle perches.**
15. Install the new U-bolts over the axle and through the new saddles. Place the new bottom plate with the dimple facing down away from the springs, on to the U-bolts. (Picture #12) Insert the two short spacer tubes between the axle spring perch and new saddle. (Picture #13) Insert the 7/16 by 3" hex head cap screws (2) through the spacer tubes, saddle and new lower plate. Place the new locking nut on the U-bolts and 7/16 cap screws and snug tighten only. Lower the floor jack completely so that the axle assembly is in its correct position. Re-check the axle location, making sure the brake line clearance is sufficient. (Picture #13)

16. AT THIS POINT, TIGHTEN ALL THE NUTS AND BOLTS, FRONT, REAR, AND CENTER. ITS IMPORTANT TO DOUBLE CHECK THIS PROCEDURE, MAKING SURE THAT ALL HARDWARE HAS BEEN TIGHTENED COMPLETELY.
17. Lift the gas tank and re-install reversing the procedure in step #3.
18. Re-install the rear wheels, lifting the rear end with the floor jack if necessary.
19. When wheels are on, installation is complete.
20. After 1,000 miles, check and re-tighten all hardware used in the installation process. Repeat this operation every six months.

### PART LIST FOR 6300 FLIP KIT

PART No.	DESCRIPTION	QTY.
6300-001	Shackle	2
6300-005	Spacer w/ Joggle	4
6300-010	Back-Up Plate w/ Dimple	2
6300-015	Saddle	2
6000-003	U-Bolt ½ x 3" x 7"	2
110403	½"-20 Ny Lock Nut	4
110660	Flat Washer ½"	4
6300-020	Pivot Bushing Urethane	4
6300-025	Spacer Tube .688" x .120" x 1.625"	4
6300-027	Spacer Tube .813" x .120" x 4.375"	6
110313	7/16"-20 x 3" HHCS	4
110303	7/16"-20 Stover Lock Nut	4
110645	Flat Washer 7/16"	8
110451	9/16-18 x 6.0"	4
110453	9/16"-18 Stover Lock Nut	4
110670	Flat Washer	8
6300-030	Aveco Retainer Clip #19418	4





