

HOTCHKIS SPORT SUSPENSION

1213 ADJUSTABLE UPPER TRAILING ARMS 59-64 CHEVROLET B-BODY



INSTALLATION OF HOTCHKIS PERFORMANCE ADJUSTABLE UPPER TRAILING ARMS

- 1) Securely block the front wheels of the vehicle. Use a jack to raise the rear of the vehicle and support with jack stands to the frame.
- 2) Remove the stock upper trailing arm by unbolting it from the frame and axle. **For Vehicles with two upper arms, remove and replace only one arm at a time** as this will help keep the axle aligned properly and make it easier for removal and replacement.



- 3) Check the stock arm mounting hole center-to-center measurement. The stock arm length should match the length of the Hotchkis upper arm center-to-center measurement.



If the Hotchkis arm does not match the center-to-center length of the stock arm then you should adjust the length to match. Loosen the jam nut and rotate the head. Turn the head **clockwise to shorten** the length, and **counter-clockwise to extend** the arm. Hand-tighten the jam nut against the head to hold it in place for the installation.

- 4) With the stock arm length matched, use the grease pack provided to apply a thick coat of grease to the bushing sides at each end of the arm. Apply a light coat of grease to the bushing contact areas on the frame and axle.



- 5) Install the Hotchkis arm with the bend in the arm towards the top and the adjustable head nearest to the axle. Insert the included hardware into the ends, and tighten the hardware at each end.



- 6) With the arm(s) in place, determine if any pinion angle adjustment is necessary. *For stock vehicles no adjustment should be required.* If the pinion angle needs to be adjusted **downwards**, the arm length needs to be **shortened**. If the angle needs to be adjusted **upwards**, the arm length should be **extended**.

You should only remove the bolt at the axle end of the arm to rotate the head once the arm is installed in the vehicle. One full rotation of the head (360deg) is approximately equal to 1/16" (.0625") of travel and 1/2 degree of camber adjustment.

The **stock Chevrolet** upper arm center-to-center length is **13-3/4" (13.750")**

The **maximum suggested** center-to-center length of the **Hotchkis** upper arm is **14" (14.00")**



The **minimum suggested** center-to-center length of the **Hotchkis** upper arm is **13-1/2" (13.50")**

Hotchkis arms can be lengthened or shortened 4 turns or 1/4" length over stock for a total of 2 degrees of positive pinion angle or 2 degrees negative.

IMPORTANT! There **MUST** be a **minimum of 1/2 inch** of thread engagement into the head for maximum strength!

- 7) Tighten the jam nut to secure the arm at the desired length and pinion angle.



IMPORTANT! The jam nut **MUST** be tight before usage. Then re-torque the jam nut after the first use.

- 8) Make sure the grease fittings are covered with the included zerk caps, and that all hardware has been properly tightened. Remove jack stands from under the vehicle with a jack and you're done!

IMPORTANT! Check all hardware after the first five miles. For maintenance, use the zerk fittings to grease the bushings at least once a year (15,000 miles) or when excessive noise occurs. Use a non-lithium based grease only. Lithium based grease can wash out with water.

59-64 Chevrolet B-Body Adj. Rear Upper Arm Kit, Parts List
P/N 1213

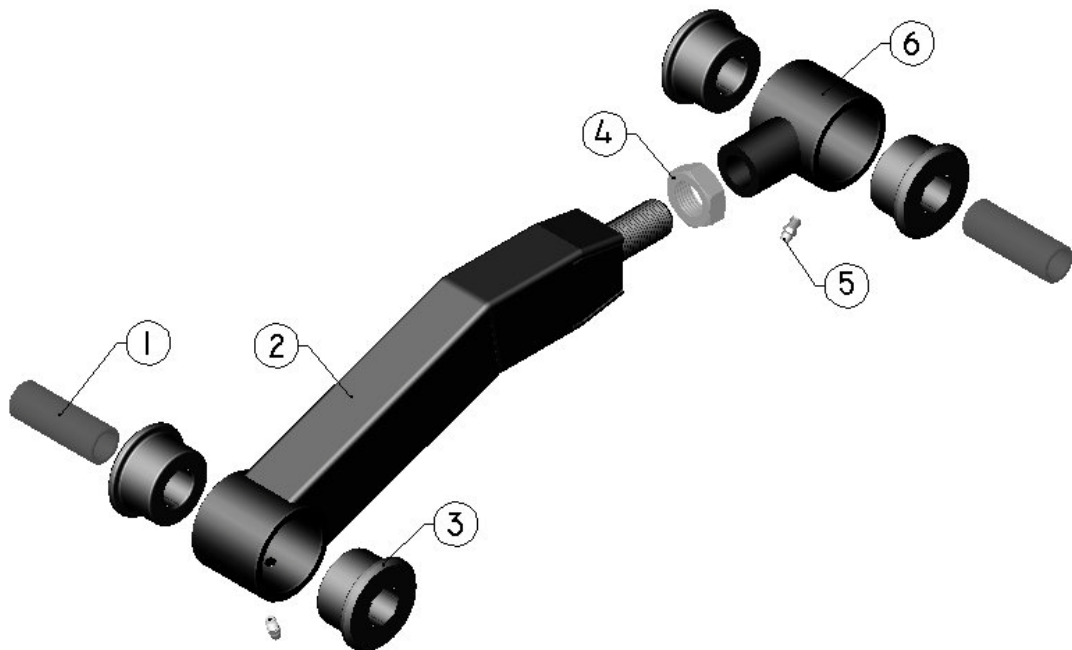
	Hotchkis P/N	Item Description	Quantity Per Kit
1	16410005	Bushing Sleeve, 59-64 Chevrolet B-body	2
2	12910005	Upper Trailing Arm Body, 59-64 Chevrolet B-body	1
3	2438.01	Trailing Arm Bushing, 59-64 Chevrolet B-body	4
4	7/8-14 JAM	7/8" Right Hand Jamb Nut	1
5	7201	Short Zerk Fitting	2
6	12410148	Adjustable Head, 1200 Series	1

Hardware Included in Kit 1733 (one per kit 1213)

7	5/8-18X4HEX	5/8" Hex Head Bolt	2
8	5/8 SAE	5/8" Flat Washer	4
9	5/8-18NYLOCK	5/8" Nylock Nut	2

Items Not Shown

10	GC-5B	Grease Zerk Caps, Black	2
11	9.11108	Grease Pack	1
12	n/a	Instruction Set	1



TMS

TOTAL VEHICLE SYSTEM

CHECK OUT EVERYTHING ELSE HOTCHKIS PERFORMANCE MAKES FOR YOUR 59-64
B-BODY CHEVROLET!!



Tubular front and rear sport sway bar set!

- ✓ *Improves handling without adding extra pounds!*
- ✓ *Includes brackets to add a stock power steering unit and front end-link mounts for cars without a stock sway bar!*



Boxed lower trailing arms to help stiffen up the rear end!



Double adjustable pan-hard rod to help center the axle!

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1313 LOWER TRAILING ARMS 59-64 CHEVROLET B-BODY



INSTALLATION OF HOTCHKIS PERFORMANCE LOWER TRAILING ARMS

WARNING: This installation involves the removal and re-installation of the rear coil springs. Springs should be removed and installed by a trained technician for your safety.

- 1) Securely block the front wheels of the vehicle. Use a jack to raise the rear of the vehicle and support with jack stands to the frame.
- 2) Remove the screw retaining the brake line to the top of the trailing arm. Keep the stock hardware for re-installation later.



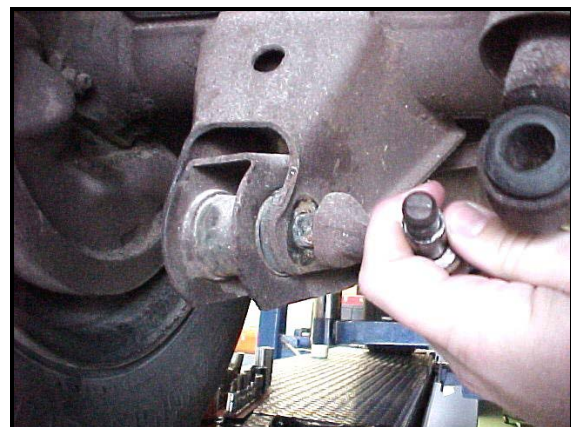
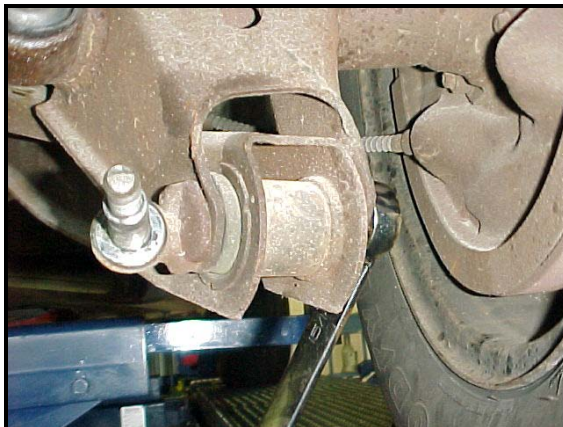
- 3) Unbolt the shock from the rear axle, and pull it clear of the mounting stud.



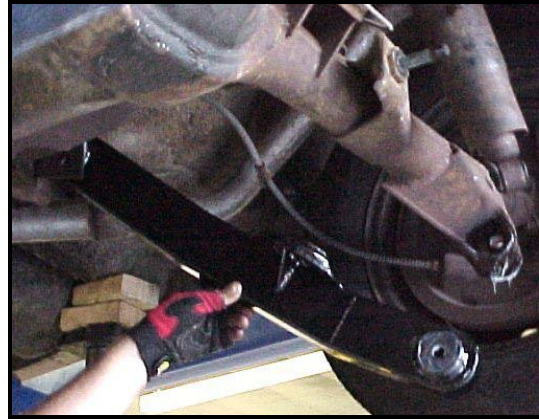
- 4) Remove the springs. Only a trained technician should attempt this. **USE EXTREME CAUTION!** *The stock springs are under a heavy stress load and can cause injury if removed improperly.*
- 5) With the springs no longer loading the arms you may loosen and remove the hardware attaching the arms to the body and axle. **Each arm should be removed and replaced separately** to help maintain the alignment of the axle. You may have to move the exhaust system to remove the bolt at the front of the arm.



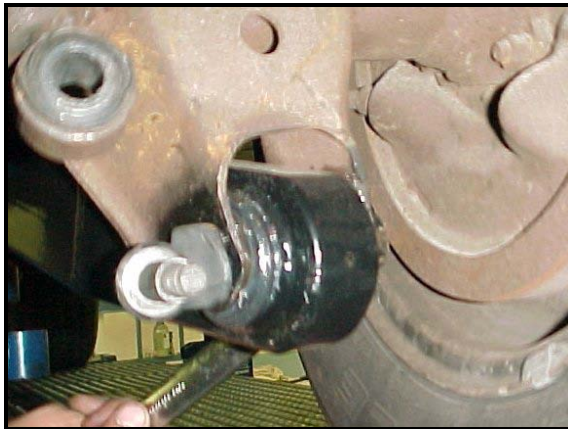
The hardware at the rear of the arm is easily accessed and should be removed. Retain the stud for later use. With all the hardware removed the stock arm should drop out of place.



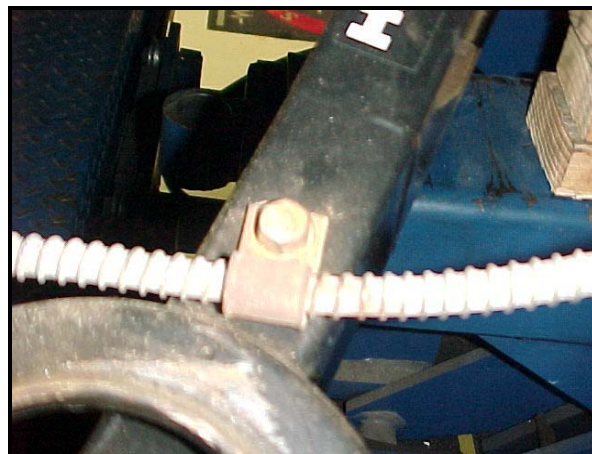
- 6) Use the grease provided to apply a heavy coat of grease to the bushings at both ends of the Hotchkis arm. Apply a light coat of grease to the bushing contact areas on the frame and axle.



- 7) Install the arm into the mounting locations on the frame and axle. Use the hardware kit provided and the original shock mount stud to secure the Hotchkis trailing arm in place. **Do not** tighten the hardware until both ends of the arm have been connected to the axle and frame.



- 8) Repeat removal and installation of the opposite lower arm.
- 9) Reinstall the springs. Only a trained technician should attempt this. Use the welded spring seat on the Hotchkis arms to center and mount the springs on each arm.
- 10) Reattach the brake line to the top of the Hotchkis arm using the tapped hole on the top of the trailing arm. Use the old mounting hardware.



- 11) Check that all hardware is in place and tightened. Cover the zerk fittings using the plastic caps provided. Remove the jack stands, and you're finished.



IMPORTANT! Check all hardware after the first five miles. For maintenance be sure to grease the bushings using the zerk fittings at least once a year (15,000 miles) or whenever excessive noise occurs. Use only a non-lithium based grease. Lithium based grease can wash out with water.



SEE NEXT PAGE FOR PARTS LIST

59-64 Chevrolet B-body Rear Lower Control Arms, Parts List P/N 1313

	Hotchkis P/N	Item Description	Quantity Per Kit
1	13910005	Lower Trailing Arm, 59-64 Chevrolet B-body	2
2	16410005	Bushing Sleeve, 59-64 Chevrolet B-body	4
3	2438.01	Bushing, 59-64 Chevrolet B-body	4

Hardware Included in Kit 1732 (one per kit 1313)

4	5/8-18X4HEX	5/8" Hex Bolt	2
5	5/8 SAE	5/8" Flat Washer	6
6	5/8-18NYLOCK	5/8" Nylock Nut	4
7	1/2SAEWSRPLT	1/2" Flat Washer	2
8	1/2-20 NUT	1/2" Nylock Nut	2

Items Not Shown

9	7203	Tall Zerk Fitting	4
10	GC-5B	Grease Zerk Caps, Black	4
11	9.11108	Grease Pack	1
12	n/a	Instruction Set	1



CHECK OUT EVERYTHING ELSE HOTCHKIS PERFORMANCE HAS FOR YOUR 59-64 CHEVY B-BODY!



Adjustable upper trailing arm eliminates pinion angle vibration!

Double adjustable panhard rod to help center the axle!

Sport Sway Bar set that includes a bracket to add stock power steering!

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1513 DOUBLE ADJUSTABLE PANHARD BAR 59-64 CHEVROLET B-BODY



INSTALLATION OF HOTCHKIS PERFORMANCE DOUBLE ADJUSTABLE PANHARD BAR

- 1) Securely block the front wheels of the vehicle. Use a jack to raise the rear of the vehicle and support with jack stands to the frame.
- 2) Loosen and remove the hardware attaching both ends of the stock panhard rod at the frame and the axle.



- 3) Remove the stock panhard rod. Rotate the top end of the bar out of the bracket on the frame and then pull the bar off the stud on the axle.



- 4) Match the Hotchkis panhard rod to the stock Chevy panhard rod. To adjust the Hotchkis panhard rod, loosen then jam nuts at each end. Rotate the middle section to shorten or lengthen the bar. DO NOT rotate the ends of the rod individually as this will affect the maximum and minimum adjustment of the bar.

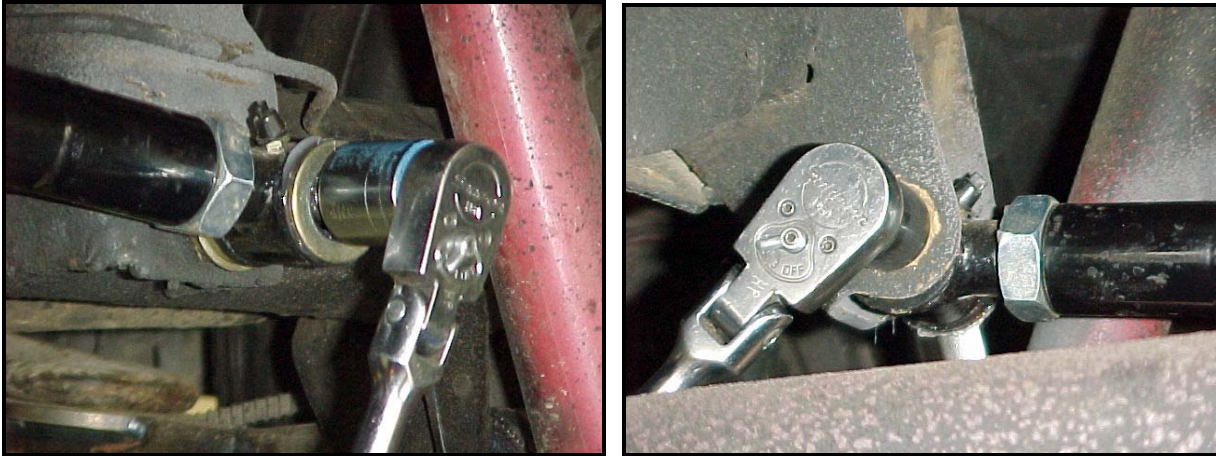


Loosely tighten the jamb nuts for installation once the bar is adjusted.

- 5) Use the grease packs provided to apply a heavy coat of grease to the sides of the bushings at each end of the rod. Apply a light coat of grease to the bushing contact areas at the base of the stud on the axle and inside the bracket on the frame.



- 6) Install the Hotchkis panhard rod by sliding the thick 9/16" washer over the stud on the axle. Then slide one end of the bar over the stud on the axle and place the 5/8" washer on the end of the stud. Rotate the bar up into the bracket on the frame and use the new hardware. Torque the hardware at each end of the panhard rod to 30ft/lbs.



- 7) With the ends of the panhard rod secured, you can make any final adjustments to the length of the bar by loosening the jam nuts and rotating the center section. Extend the bar to move the axle to the right. Shorten the bar to move the axle to the left.

The **stock Chevrolet** panhard bar center-to-center length is **31-1/2"**

The **suggested maximum** center-to-center length of the **Hotchkis** panhard rod is **32"**

The **suggested minimum** center-to-center length of the **Hotchkis** panhard rod is **31"**

Be sure to tighten the jam nuts after making any adjustments to the length of the bar.

IMPORTANT: Torque the jam nuts before use. Re-torque the jam nuts after the first use!

- 8) Re-check all hardware for tightness. Use the caps provided to cover the zerk fittings at each end of the bar. Use the jack to remove the jack stands and you're finished with the install!

IMPORTANT: For maintenance, use the zerk fittings to grease the bushings at least once a year (15,000 miles) or when excessive noise occurs. Use a non-lithium based grease only! A lithium-based grease can wash out with water and should not be used!



SEE NEXT PAGE FOR PARTS LIST

**59-64 Chevrolet B-Body Adj. Panhard Bar Kit, Parts List
P/N 1513**

	Hotchkis P/N	Item Description	Quantity Per Kit
1	15610005	Panhard Rod Right Hand Head, 59-70 Chevrolet B-body	1
2	7070G	Panhard Rod Bushing, 59-64 Chevrolet B-body	4
3	7/8-14 JAM	7/8" Right Hand Jamb Nut	1
4	15410005	Panhard Rod Body, 59-64 Chevrolet B-body	1
5	7/8-14 LTJAM	7/8" Left Hand Jamb Nut	1
6	15.10.42.39	Bushing Sleeve, 59-64 Chevrolet B-body	2
7	15510005	Panhard Rod Left Hand Head, 59-70 Chevrolet B-body	1

Hardware Included in Kit 1734 (one per kit 1513)

8	9/16X3.0HEX	9/16" Hex Head Long Bolt	1
9	9/16AN	9/16" Flat Washer	2
10	9/16-18NYLOC	9/16" Nylock Nut	2
11	9/16 SAEWSHR	9/16" Flat Washer, Thick	1
12	5/8 SAE	5/8" Flat Washer	1

Items Not Shown

13	7201	Short Zerk Fitting	2
14	GC-5B	Grease Zerk Caps, Black	2
15	9.11108	Grease Pack	1
16	n/a	Instruction Set	1



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