

HOTCHKIS HOTCHKIS SPORT SUSPENSION

1215 DOUBLE ADJUSTABLE UPPER TRAILING ARMS 67-70 CHEVROLET B-BODY

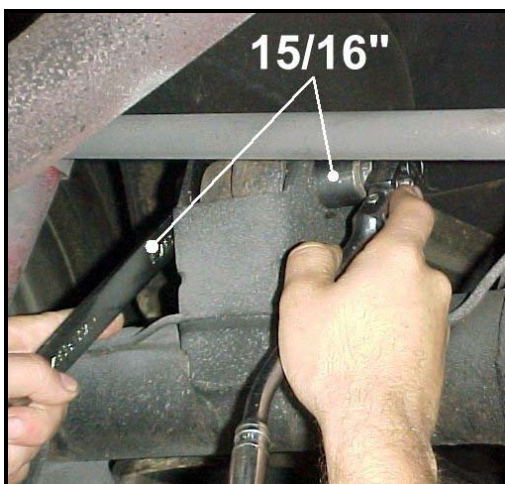


This installation will require:

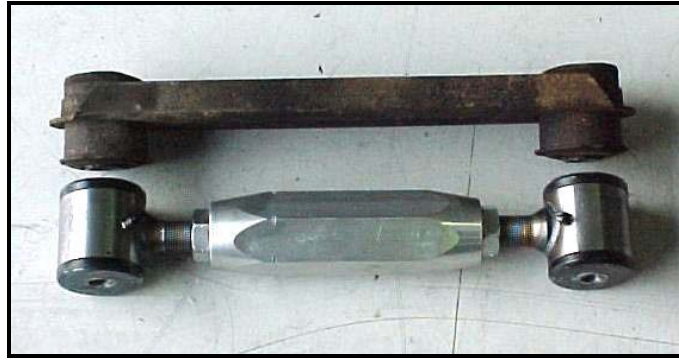
- A hydraulic jack, jack stands
- The following wrenches or sockets: 15/16"
- Adjustable wrench (1-1/4" – 1-9/32" range of adjustment) for jam nuts.

INSTALLATION OF HOTCHKIS PERFORMANCE DOUBLE ADJUSTABLE 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) Use a 15/16" wrench or socket to loosen and remove the stock upper trailing arm hardware. **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. You may discard the stock hardware and upper arm(s).



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

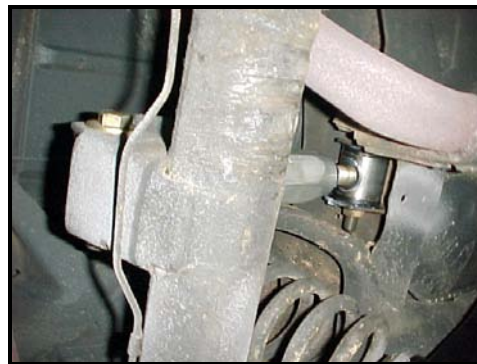


If the Hotchkis arm does not match the center-to-center length of the stock arm then you should adjust the length to match. Loosen the jam nuts at each end and turn the **center** section only! **Do not** turn the ends individually, as this will shorten the range of adjustment for the arm. Loosely tighten the jam nuts against the center section 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 arms with the **zerk fittings facing towards the ground** for easy access later. Insert the included hardware into the ends, and tighten the hardware at each end.

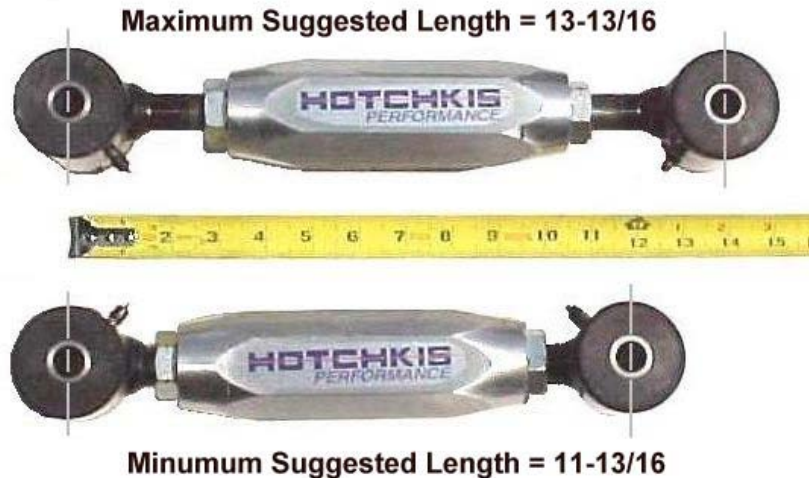


- 6) With the arms in place determine if any pinion angle adjustment is necessary. **For stock vehicles no adjustment should be required**, and you may move on to step 7. If the pinion angle needs to be adjusted **downwards** the arm length needs to be **shortened**. If the angle needs to be adjusted **upwards** the arm length should be **lengthened**.

- 7) To adjust the arm, loosen the jam nuts at **both** ends of the center section. With the jam nuts loose, rotate the **center** section until the desired pinion angle is reached. **One rotation (360deg)** of the center section will equal approximately **1deg** and **.125"** of length. **One half of a rotation (180deg)** of the center will equal approximately **1/2deg** and **.0625"** of length.

Stock arm length from center to center is **12.813" (12-13/16")**

The **maximum** suggested length of the arm from center to center is **13.813" (13-13/16")**



The **minimum** suggested length of the arm from center to center is **11.813" (11-13/16")**

IMPORTANT! There **MUST** be a minimum of 1.25 inches of thread engagement into **BOTH** sides of the center section for maximum strength!

- 8) Tighten the jam nuts to secure the arm at the desired length and pinion angle.

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

- 9) Make sure the zerk fitting caps are closed and all hardware has been properly tightened. Remove jack stands from under the vehicle with a jack and you're done!

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

65-66 Chevrolet B-Body Adj. Upper Trailing Arm Kit, Parts List P/N 1214

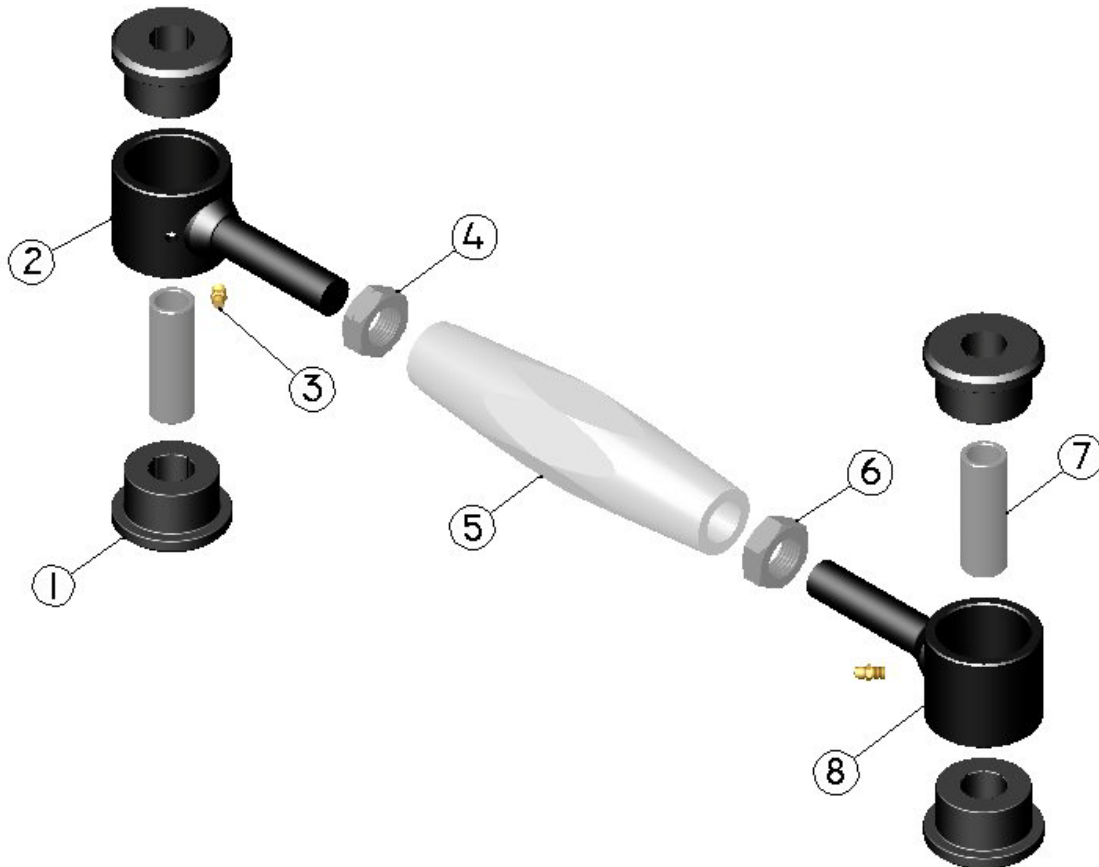
	Hotchkis P/N	Item Description	Quantity Per Kit
1	2255G	Bushing for 1305 Impala	4
2	12510006	Trailing Arm Head, Left Hand Thread - 65-70 Chevy B-body	1
3	7201	Zerk Fitting, Short	2
4	7/8-14 LTJAM	7/8" Left Hand Jamb Nut	1
5	12990006	Anodized Center Section, 65-66 Chevy B-body	1
6	7/8-14 JAM	7/8" Right Hand Jamb Nut	1
7	16410006	Trailing Arm Bushing Sleeve, 65-70 Chevy B-body	2
8	12610006	Trailing Arm Head, Right Hand Thread - 65-70 Chevy B-body	1

Hardware Included in Kit 1733 (one per kit 1214)

9	5/8-18X4HEX	5/8 x 4" Long Bolt, Hex Head	2
10	5/8 SAE	5/8" Flat Washer	4
11	5/8-18NYLOCK	5/8" Nylock Nut	2

Items Not Shown

12	GC-5B	Black Grease Caps	2
13	9.11108	Grease Pack	1
14	1733	Instruction Set	1





CHECK OUT EVERYTHING ELSE HOTCHKIS PERFORMANCE MAKES FOR YOUR 65-70 B-BODY CHEVROLET!!



Tubular front and rear sport sway bar set!



*Boxed lower trailing arms to help stiffen up the rear end!
Features a welded spring seat for easier spring installations!*



Double adjustable panhard rod to properly center your axle!

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1314 LOWER TRAILING ARMS 65-70 CHEVROLET B-BODY



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

INSTALLATION OF HOTCHKIS PERFORMANCE LOWER 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) Use a 1/2" socket or wrench to remove the screw retaining the brake lines to the trailing arms. Discard the stock hardware, as you will not be reusing it.



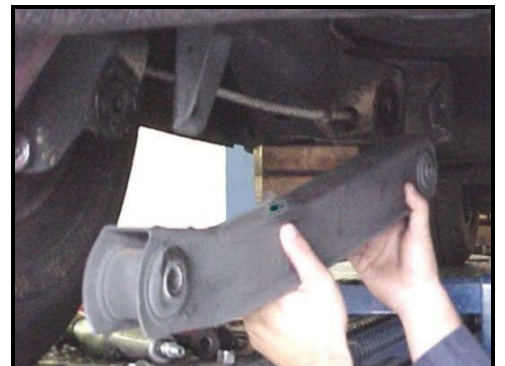
- 3) Unbolt the shock from the rear axle, and pull it clear of the mounting stud. Then remove the coil spring retainer plate from the trailing arm. **USE EXTREME CAUTION!** There will be **nothing holding the spring** to the trailing arm except the weight of the vehicle.



- 4) Remove the springs. **Only a trained technician should attempt this.** *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. **Only one arm should be removed and replaced at one time** to help maintain the alignment of the axle and for ease of replacement. Use a wrench in the access hole at the front of the arm in the frame to reach the connecting hardware. You may have to move the exhaust system to remove the bolt.



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



- 6) Using the grease provided, **apply a heavy coat of grease to the sides of the bushings** at both ends. Apply a light coat of grease to the surface contact areas of the bushing on the frame and axle too.



- 7) With the bushings greased, install the arm into the mounting locations on the frame and axle. Use the hardware kit provided to secure the Hotchkis trailing arm in place. **Do not** tighten the hardware until both ends have been connected to the axle and frame.



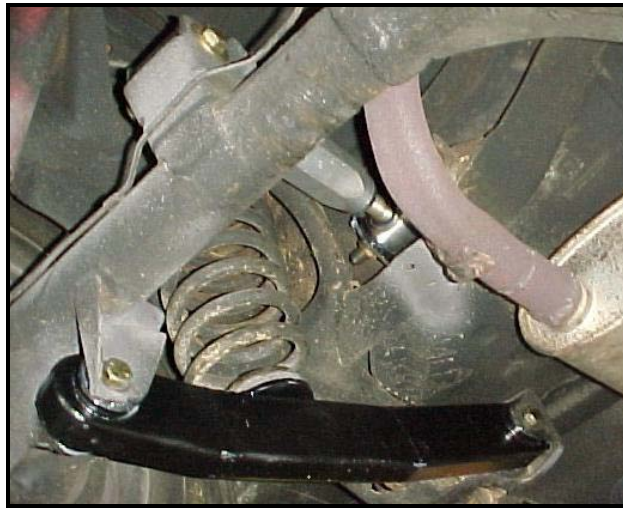
- 8) Repeat removal and installation of the opposite lower arm.
- 9) Re-install the springs. **Only a trained technician should attempt this.** Use the welded spring seat on the Hotchkis arms to center and mount the springs on each arm.
- 10) Place the spring retainer plate inside the center of the spring once it is centered on the seat properly. Use the hardware provided to hold the plate down. The plate will deform to fit each spring individually as it is tightened down.



- 11) Reattach the brake line to the side of the Hotchkis arm using the tapped hole on the outside of the trailing arm. Use the new hardware provided.



- 12) Check that all hardware is in place and tightened. Cover the zerk fittings using the plastic caps provided. Use a jack to remove the jack stands, and you're finished installing your new arms!



IMPORTANT! For proper 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

65-70 Chevrolet B-Body Lower Trailing Arm Kit, Parts List

P/N 1314

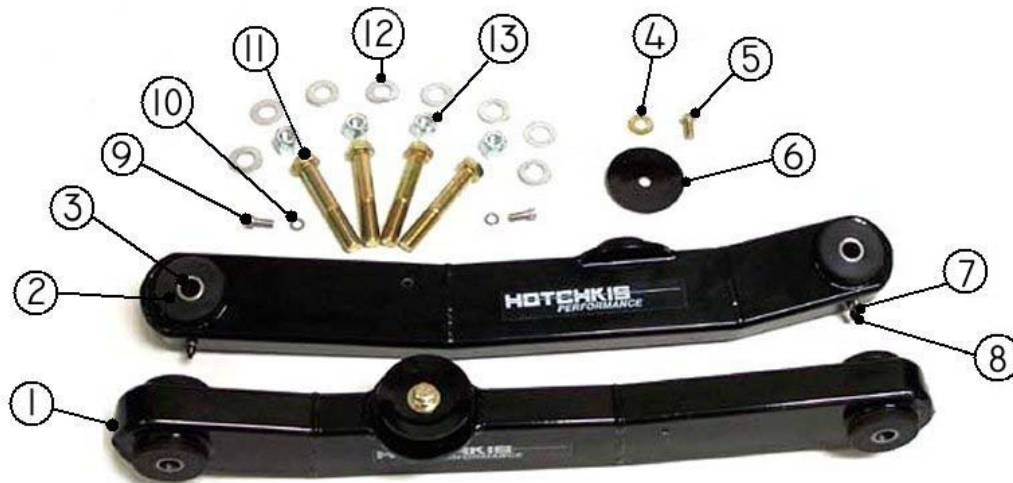
	Hotchkis P/N	Item Description	Quantity Per Kit
1	13910006	Lower Trailing Arm Body, 65-70 Chevy B-body	2
2	2255G	Trailing Arm Bushing, 65-70 Chevy B-body	8
3	16410006	Trailing Arm Bushing Sleeve, 65-70 Chevy B-body	4
4	3/8SAEG8WASH	3/8" Flat Washer	2
5	3/8-16X1.0"	3/8" Bolt, Hex Head	2
6	13410006	Spring Retainer Plate, 65-70 Chevy B-body	2
7	7203	Grease Fitting, Tall	4
8	GC-5B	Grease Cap, Black	4

Hardware Included in Kit 1736 (one per kit 1314)

9	5/16-18X4HEX	5/16" x 3/4" Bolt, Hex Head	2
10	5/16AN	5/16" Flat Washer	2
11	5/8-18X4HEX	5/8" x 4" Bolt, Hex Head	4
12	5/8 SAE	5/8" Flat Washer	8
13	5/8-18NYLOCK	5/8" Nylock Hex Nut	4

Items Not Shown

14	9.11108	Grease Pack	1
15	n/a	Instruction Set	1



CHECK OUT EVERYTHING ELSE HOTCHKIS PERFORMANCE MAKES FOR YOUR 65-70 B-BODY CHEVROLET!!



- **Tubular sway bar sets!**
- **Double adjustable panhard rod to center your axle!**
- **Double adjustable trailing arms to reduce driveline vibration!**

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1514 DOUBLE ADJUSTABLE PANHARD BAR **65-70 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.

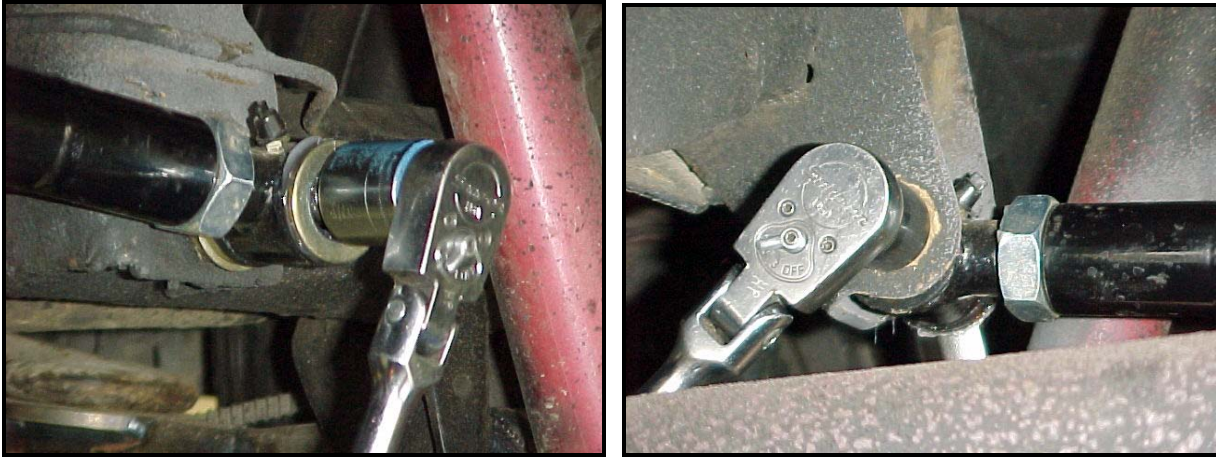


Loosely tighten the jamb nuts for installation once the bar is adjusted.

- 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 surfaces 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 over 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. Lengthen 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 **32-1/2"**

The **suggested maximum** center-to-center length of the **Hotchkis** panhard rod is **33"**

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

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

65-70 Chevrolet B-Body Adj. Panhard Bar Kit, Parts List
P/N 1514

	Hotchkis P/N	Item Description	Quantity Per Kit
1	15610005	Panhard Rod Right Hand Head, 59-70 Chevrolet B-body	1
2	7117.01	Panhard Rod Bushing, 65-70 Chevrolet B-body	4
3	7/8-14 JAM	7/8" Right Hand Jamb Nut	1
4	15410006	Panhard Rod Body, 65-70 Chevrolet B-body	1
5	7/8-14 LTJAM	7/8" Left Hand Jamb Nut	1
6	16420006	Bushing Sleeve, 65-70 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 1514)

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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