

HOTCHKIS SPORT SUSPENSION

2253/2273 FRONT AND REAR SPORT SWAY BAR SET 65-70 CHEVROLET B-BODY



This installation will require drilling new mounting holes for both the front and rear sway bars. ***Please read instructions carefully to avoid unnecessary drilling.***

INSTALLATION OF HOTCHKIS PERFORMANCE FRONT SWAY BAR

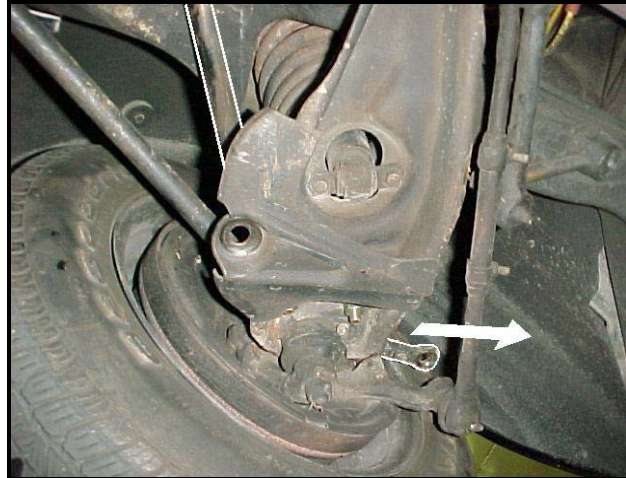
- 1) Securely block the rear wheels of the vehicle. Use a jack to raise the vehicle and support with jack stands only if you need additional clearance under the vehicle. *You will have to lower the vehicle onto its wheels in a later step to remove and install the front sway bar.*
- 2) Unbolt the stock sway bar bushing brackets. Remove the bushings once the brackets are loose. Unbolt and remove the end links from each end of the bar. The bar should now be free moving and is held in the vehicle only by the two holes in the frame. Retain the stock bushing retainer bolts. You may discard the end links, as they will not be re-used.



- 3) Turn the front wheels to point straight ahead. If you jacked up the front of the vehicle, you should now lower the vehicle so that the weight is on the front tires. Slide the stock bar towards the passenger side of the vehicle. *The end of the sway bar should contact the rear edge of the brake drum preventing you from fully removing the sway bar.*



Turn the front wheels to the left until the end of the bar can slide past the rear edge of the brake drum. *On some disk brake applications it may be necessary to remove the caliper to allow the sway bar to slide past.*



- 4) Move the sway bar end towards the rear on the passenger side of the vehicle until the opposite end of the bar clears the slot in the frame on the driver's side.



- 5) The end of the bar on the driver's side should now be free. Pull the end of the bar towards the front bumper and rotate as necessary to remove the bar from the vehicle. Do not straighten the front wheels at this time. They should still be turned slightly towards the driver's side of the vehicle.



- 6) With the stock bar now removed, insert the Hotchkis bar by reversing the previous directions. Make sure the center "hoop" of the bar points down when installing the bar. *If the bar is put in backwards, then the bar will contact the balance pulley on the front of the motor.* Start by inserting the end of the bar into the round hole on the passenger side of the vehicle frame

NOTE: To avoid damage to the powder coat surface of the bar, cover the edges of the holes in the frame. Use a towel, duct tape or similar product to accomplish this.



- 7) Slide the end of the Hotchkis bar between the coil spring and the brake drum in the same fashion as was used to remove the stock bar.



The leading end of the bar should eventually swing into the slot in the frame on the driver's side of the vehicle. The bar will be free moving, but in the proper orientation in the vehicle.



- 8) Use the grease pack provided to put a heavy coat of grease on the inside of the sway bar bushings. Place the bushings over the bar with the cut in the bushing towards the rear of the vehicle. Push the bushing retainer brackets into place on the bar and bolt them into place using the stock mounting hardware in the front holes only. **Do not** tighten the stock hardware.



- 9) With the brackets in place, install the new end links included in the Hotchkis kit at each end of the bar to establish the proper fit of the front bar. *The vehicle weight should be on the front wheels to establish the proper ride position of the sway bar in the vehicle.*



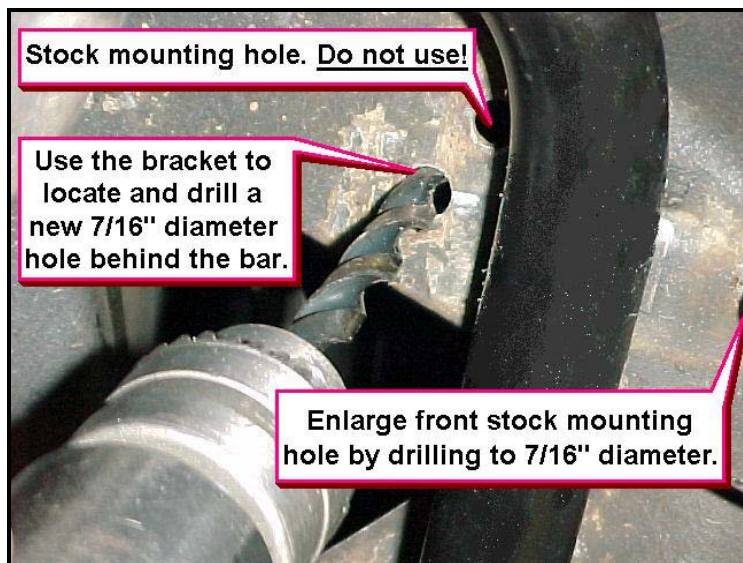
- 10) With the final position of the bar now determined, you will need a scribe or some other tool to mark with. Mark the center position of the holes for the rear side of the bracket. Remove the brackets, bushings, end links, and stock hardware. Drill the existing front mount hole out to a 7/16" diameter and drill a new rear mount hole at the same size where you marked the frame.



Stock mounting hole. **Do not use!**

Use the bracket to locate and drill a new 7/16" diameter hole behind the bar.

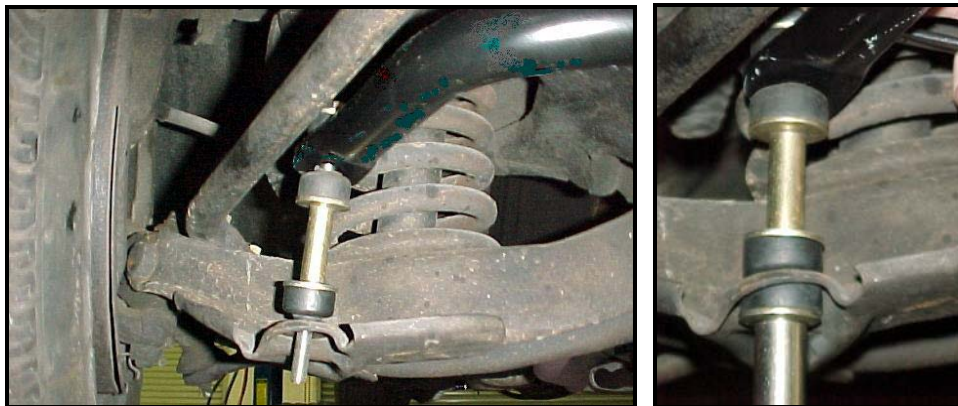
Enlarge front stock mounting hole by drilling to 7/16" diameter.



- 11) Use the 3/8" bolts from **hardware kit #1735** to attach the Hotchkis bar. Drop the bolts down through the drilled out holes in the frame. Start the washers and nylock nuts onto the ends of the bolts. You will use only four of each nut, washer and bolt. **DO NOT THROW THE EXTRA HARDWARE AWAY, as it is used for the rear sway bar.** Torque the hardware to 35 ft/lbs.



- 12) Re-place the end links removed in step 10 and tighten them into place. Tighten the end links until the nut meets slightly stiff resistance. The bushings will have a slight bulge when tight.



- 13) Re-check all hardware for tightness. Cover the zerk fittings in the brackets with the grease caps that came attached to the brackets. You are finished with the front sway bar installation



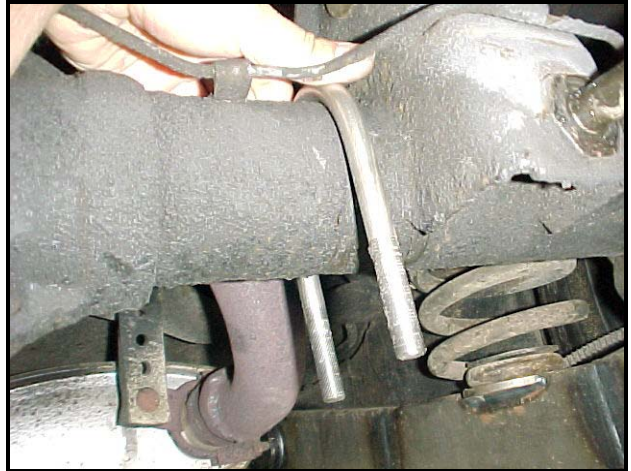
IMPORTANT: For maintenance, use the zerk fittings to grease the bushings at least once a year (15,000 miles) or when excessive noise occurs. Use a non-lithium based grease only! A lithium-based grease can wash out with water and should not be used.

MOVE ON TO THE REAR SWAY BAR INSTALLATION

This installation will require drilling new mounting holes for both the front and rear sway bars. **Please read instructions carefully to avoid unnecessary drilling.**

INSTALLATION OF HOTCHKIS PERFORMANCE REAR SWAY BAR

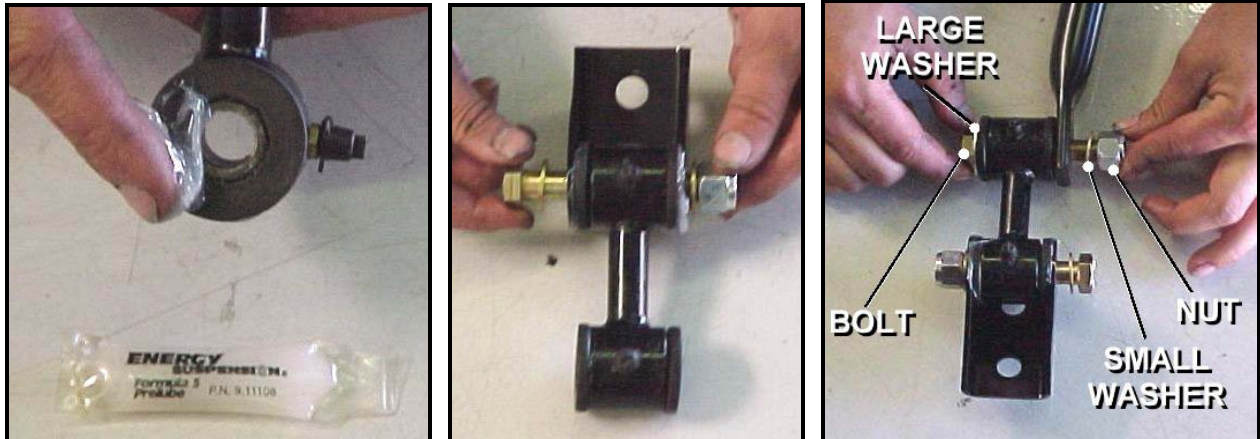
- 1) Securely block the front wheels of the vehicle. *You will not need to jack up the rear end of the vehicle to perform this installation.*
- 2) Begin by placing the u-bolts provided over the rear axle. Place them roughly the same distance from the center of the axle, with the ends of the u-bolts pointed straight down.



- 3) Use the grease pack provided to apply a heavy coat of grease to the inside of the sway bar bushings. Place the bushings over the bar. *The split in the bushings should face towards the rear of the vehicle with the bar installed.* Push the brackets over the sway bar bushings.



- 4) Use the grease provided to apply a heavy coat of grease to the sides of the bushings on the “dog bone” end links. Attach the mounting brackets to the end links using **hardware kit #T1712**. Attach the other end of the links to the sway bar. Leave the attaching hardware loose.



The large washer should be used to contact bushing surfaces and the small washer should be used to contact metal surfaces. This prevents the bolt from pulling through the bushing. *You will have 2 large washers and 2 small washers left over. This is extra hardware and may be discarded.*

- 5) Hang the sway bar from the u-bolts on the axle. Place the axle brackets over the ends of the u-bolts first. Slide the bushing brackets over the u-bolts to rest against the axle brackets. Install with the nuts loosely started onto the u-bolts so that the sway bar hangs freely from the axle.

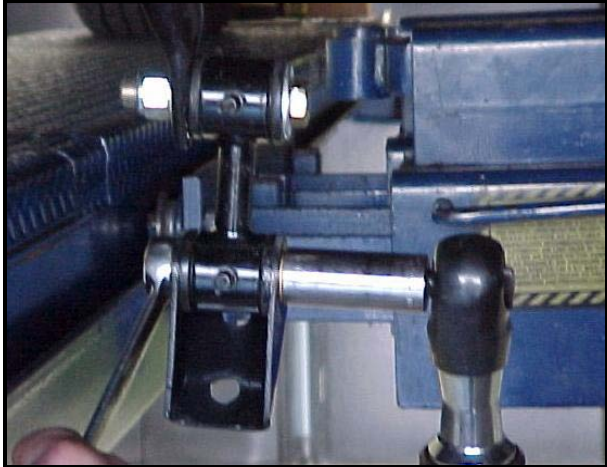


Use the anti-seize provided with the u-bolts to lubricate the threads. *Failure to lubricate the threads can destroy the nuts and possibly break the u-bolt or seize the nut in place when tightened.*

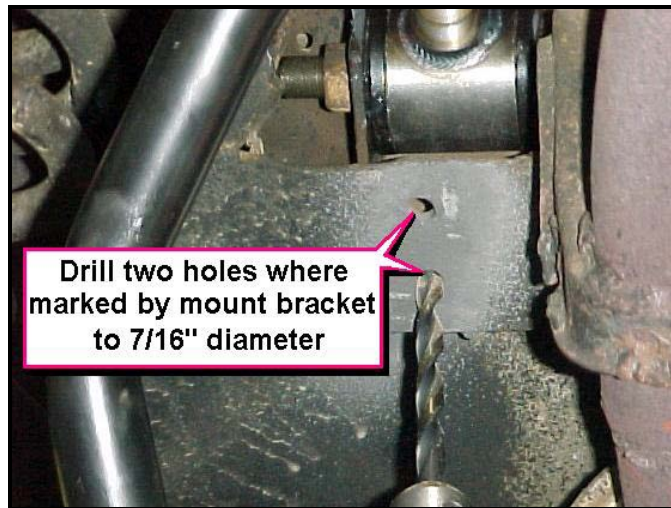
- 6) Slide the u-bolts along the axle until the bar is centered with the vehicle. Tighten down the nuts on the u-bolts to secure the position of the u-bolts and brackets. Tighten the nuts evenly to avoid pulling the u-bolt to one side of the axle!



- 7) Snug down the hardware connecting the end links and brackets to the bar. **Do not** fully tighten the hardware at this stage. *You should still be able to rotate the end links without difficulty.*



- 8) Rotate the bar upwards, so that the brackets are resting against the frame. Once the brackets are in place use a scribe or some other tool to mark the center of each hole for drilling.



Drill out the holes for the brackets to 7/16" diameter. *To accurately determine the location of the holes the end links must not be loose enough to move left or right. **Make certain the axle is at its normal driving height for an accurate fit.***

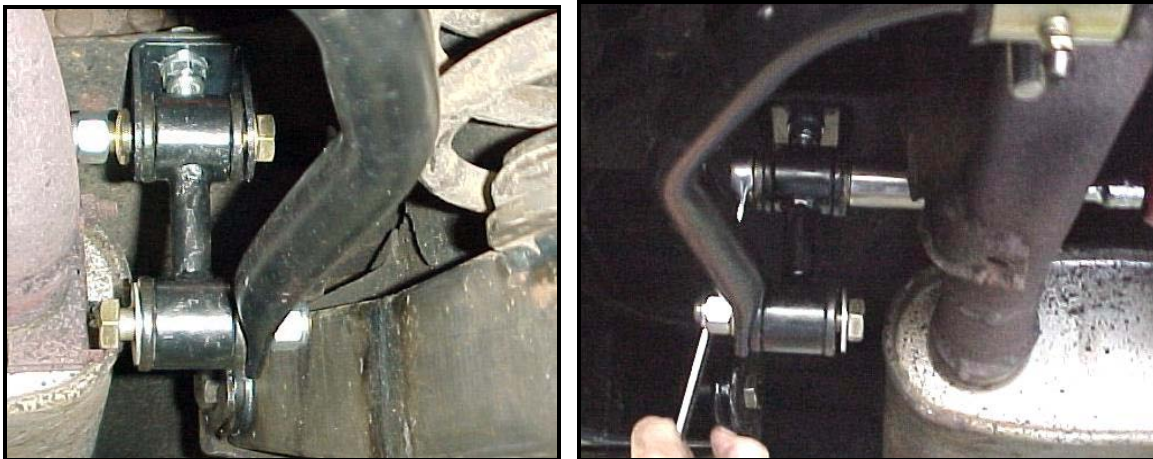
- 9) Once the holes are drilled, drop the remaining 3/8" bolts from **hardware kit #1735** in through the top of the frame with the bolts hanging down for the brackets to attach to.



- 10) Unbolt the bracket from the end link. Hold the bracket back up in position to the bolts hanging from the frame. Use the nylock nuts included to hold the bracket on the bolts. Tighten the hardware holding the bracket to the frame. Torque the nuts to 80 ft/lbs.



- 11) Re-attach the end links to the brackets and tighten the hardware into place. Torque the end link hardware to 80 ft/lbs.



- 12) Check that all hardware is tight. Use the caps provided to cover the zerk fittings and you're done installing the Hotchkis rear sway bar!



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 Sway Bar Kit, Parts List
P/N 2253/2273

	Hotchkis P/N	Item Description	Quantity per kit
1	22810006	Front Sway Bar, 65-70 Chevrolet B-body	1
2	23090074	Sway Bar Bushing Retainer Bracket, Greaseable Heavy Duty Universal	2
3	5637.01	1-1/4" Sway Bar Bushing, Greaseable Heavy Duty	2
4	T2211	Sway Bar Axle Mount Bracket Kit (two brackets per kit)	1
5	98128G	Endlink Kit, 65-70 Chevrolet B-body (two end links & hardware)	2
6	22910006	Rear Sway Bar, 65-66 Chevrolet B-body	1
7	T1722	3" U-bolts w/ hardware, kit (see <i>hardware kit listings</i>)	1
8	15.12.06.39	Sway Bar Bushing Retainer Bracket, Greaseable Car Style	2
9	25210035	3" End Link Kit, Dog Bone Style (two end links per kit)	1
10	5340G	1" Sway Bar Bushing, Greaseable Car Style	2
11	23410011	Rear Sway Bar Mount Bracket, 65-66 Chevrolet B-body	2

Hardware Included in Kit #T1712 (one per kit 2253)

12	12-20 X 3"	1/2" Bolt, 3" long	2
13	1/2-20X2.75"	1/2" Bolt, 2-3/4" long, Hex Head	2
14	7/16USS FW	7/16" Flat Washer	8
15	1/2AN	1/2" Flat Washer	4
16	1/2-20 NUT	1/2" Nylock Nut	4

Hardware Included in Kit #T1722 (one per kit 2253)

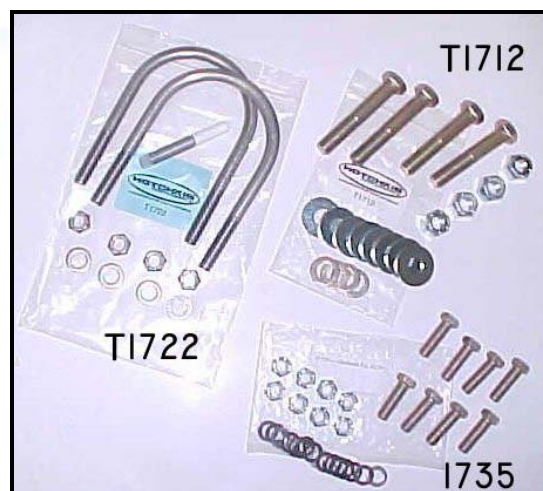
-	T1722	3" U-bolt, Stainless Steel	2
17	7/16AN	7/16" Flat Washer	4
18	7/16NYLOCK	7/16" Nylock Nut	4
19	ND907	Anti-Sieze, 1/8oz. Tube	1

Hardware Included in Kit #1735 (one per kit 2253)

20	3/8-24X1.25	3/8" Bolt, 1.25" Long, Hex Head	8
21	3/8AN	3/8" Flat Washer	16
22	3/8NYLOCK	3/8" Nylock Nut	8

Items Not Shown

23	9.11108	Grease Pack	2
24	5015	Puffy Black/ Chrome Sticker	1
25	n/a	Instruction Set	1



TMS

TOTAL VEHICLE SYSTEM

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



Double adjustable panhard rod to positively locate your axle and keep it in place! Perfect for re-centering the axle on a lowered car!



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



Double adjustable upper trailing arm to help reduce pinion angle vibrations!

