



DON'T FORGET

These instructions can be found in color and expandable at QA1.net

Technical Support Line: (952) 985-5675 Email: sales@QA1.net

INSTALLATION INSTRUCTIONS

QA1 P/N 5275 Lower Trailing Arm Relocation Brackets
1982-2002 Camaro/Firebird

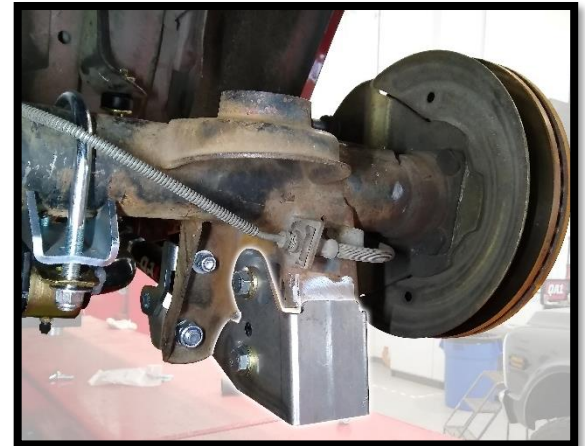
TOOLS AND SUPPLIES REQUIRED

- Floor jack and jack stands
- Tire chocks
- Lug wrench
- 18mm socket and combination wrench
- Hand grinder
- Torque wrench
- Mig welder

REMOVAL OF STOCK TRAILING ARMS

1. Place the vehicle on a level surface and place tire chocks in front of and behind front tires.
2. Support the rear of the vehicle on jack stands and remove the rear wheels.
3. Place a floor jack under the differential and lift slightly to remove tension from the trailing arm bolts. Make sure not to lift the vehicle off the jack stands. *NOTE: Keep the floor jack under vehicle during the complete removal and installation procedure.*

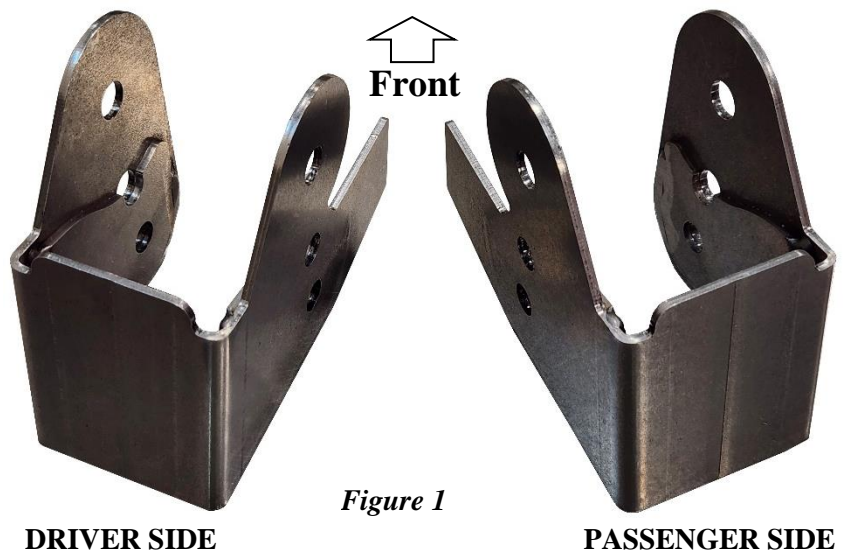
CAUTION: Do not remove both trailing arms at the same time or the axle will rotate and the trailing arm installation will be much more difficult.



4. Remove the rear bolt from the trailing arm and rotate the arm out of the way.
5. Identify the driver (left) and passenger (right) side brackets. **(Figure 1)**
6. Using the relocation bracket as a reference, clean the surface of the stock trailing arm mounting bracket for welding.

Notes:

- a. The parking brake cable retaining bracket on later model cars will need to be modified.
- b. The spacer sleeves in this kit are to be mounted in the factory trailing arm location. Using the supplied bolts, nuts and thick washers, install the relocation bracket onto the stock trailing arm bracket. The relocation brackets should sit tight against the stock bracket for proper welding (torque bolts to 65 lb. ft.).



INSTALLATION

1. Using the supplied bolts, nuts, and thick washers, attach the trailing arm to the relocation bracket. Snug but do not torque at this time.

DESCRIPTION	PART NUMBER	QTY
Washer, flat ½" hardened	9005-252	8
Bolt, M12 x 1.75 x 100mm	9012-210	4
Nut, Nyloc M12 x 1.75	9014-430	4
Sleeve, .48" I.D. x .75" O.D. x 2.425"	9032-156	2
Tube, Teflon lube (poly bushing lube)	9071-109	2

2. Make several tack welds around the edges of the relocation bracket. Remove the trailing arm from the relocation bracket and stitch weld around edges of the relocation bracket. **Note: Welding should be done by an experienced welder.**
3. After welding is complete, coat the brackets and welded areas to prevent corrosion.
4. Re-install the trailing arm into the relocation bracket and torque to 65 lb. ft.
5. Repeat steps 4-8 on the other side of the vehicle.



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READ ALL INSTRUCTIONS CAREFULLY AND THOROUGHLY PRIOR TO STARTING INSTALLATION. PRODUCTS THAT HAVE BEEN INSTALLED ARE NOT ELIGIBLE FOR RETURN. USE THE PROPER JACKING LOCATIONS. DEATH OR SERIOUS INJURY CAN RESULT IF INSTRUCTIONS ARE NOT CORRECTLY FOLLOWED. A GOOD CHASSIS MANUAL, AVAILABLE AT YOUR LOCAL PARTS STORE, MAY ALSO AID IN YOUR INSTALLATION.

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