



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 52896 Front Sway bar

'63-'87 Chevrolet/GMC C10, '63 - '86 C20, '87-91 R20 Pickup

TOOLS AND SUPPLIES REQUIRED

- Floor Jack
- Jack Stands
- Blue Thread Locker
- Wrench Set
- Ratchet & Socket Set
- Drill with 3/8" bit
- Grinder and/or Air Chisel

1963-1966 Trucks

The frame brackets on '63-'66 trucks will not use the existing frame holes described in these instructions. Begin installation starting at step 9 to attach the bar to the lower control arms first. With the frame bushings and mounts installed on the sway bar and the truck at ride height, swing the bar up to the frame. Use the frame brackets to show where the mounting bolt holes should be marked and drilled. Refer to step 6 for frame bracket hardware description.



Pre-Installation Note

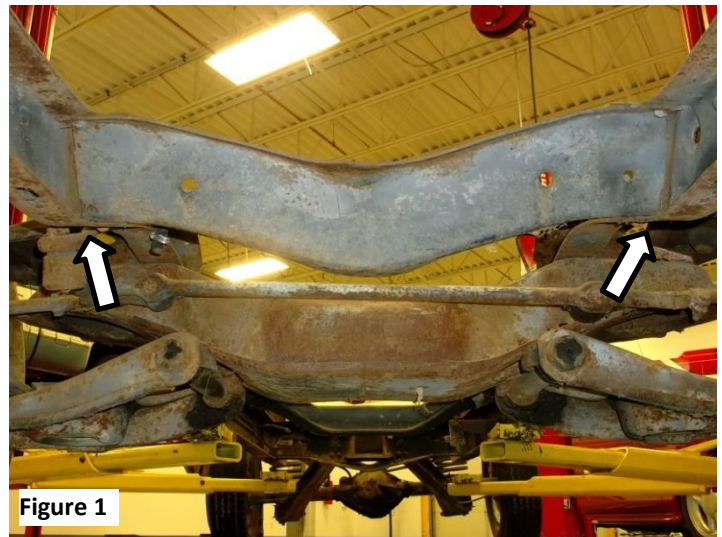
Part number 52896 requires the removal of the factory front sway bar frame brackets and the installation of the supplied QA1 sway bar brackets. '67-'72 trucks not originally equipped with a sway bar will require the removal of two cross member rivets. A grinder and punch or air chisel is recommended for removal.

Installation Instructions

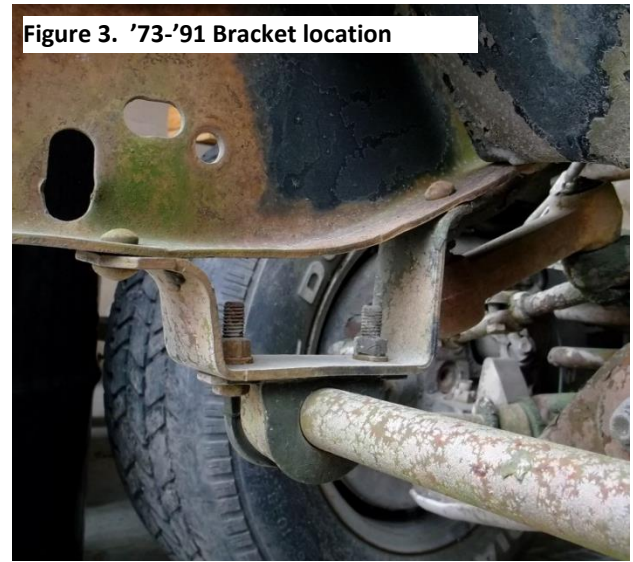
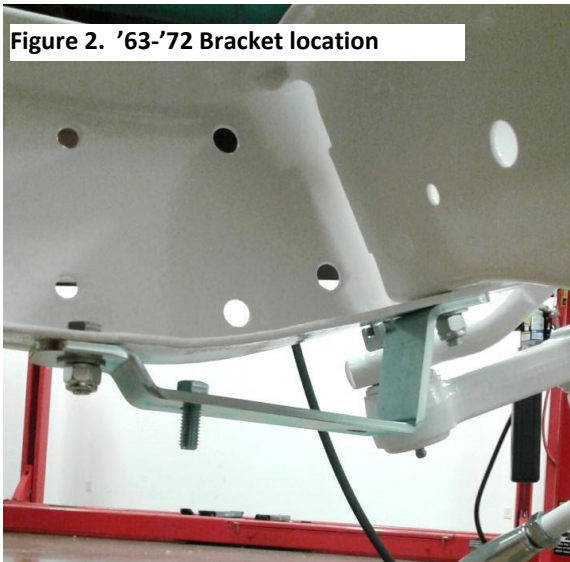
1. Raise the vehicle and support with jack stands on a stable surface.
2. Unbolt and remove the OEM sway bar if equipped.

Caution: Sway bars are heavy steel parts that can cause injury if unsupported during removal or installation.

3. For '67-'72 trucks not originally equipped with a front sway bar, remove the bottom rivets in the frame cross member. See **Figure 1**.



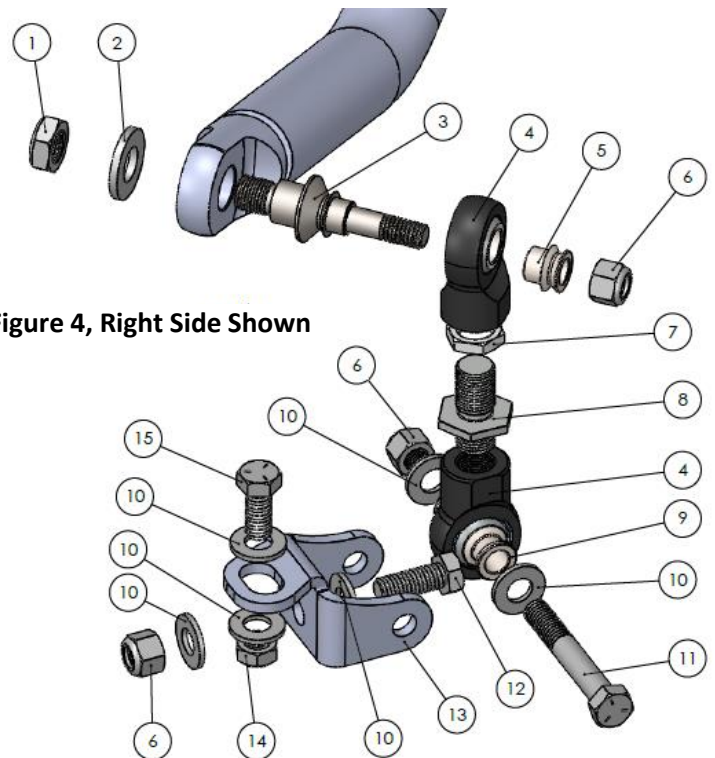
- If originally equipped with a front sway bar, remove the rivets from the factory frame mounts. See **Figure 2**.
- 1973 and later trucks not originally equipped with a sway bar will have the holes in the frame already and the QA1 frame brackets will bolt on using those holes. The factory brackets will need to be replaced with QA1 brackets for trucks originally equipped with a front sway bar. See **Figure 3**.



- Use the supplied hardware to install the QA1 sway bar brackets to the frame and torque to 30 lb.-ft. The 3/8" x 1 1/4" bolts should be used for the cross member location for '63-'72 Trucks. **Note:** It is best to install the sway bar mounting bolts in the brackets before the brackets are installed on the frame. See **Figure 2**.
- Grease and install the bushings on the QA1 sway bar and mount to the new frame brackets. Torque to 30 lb.-ft.
- Assemble the sway bar end links as shown in **Figure 4**. The double ended stud (#8) and rod ends (#4) are right hand threads. Use Loctite on the short stud before fully threading one rod end onto the stud. Thread the jam nut onto the longer studded side, then one rod end. Leave one thread between the hex and the jam nut visible to allow rotation of the rod end during end link installation. Tighten the jam nut into the rod end after the sway bar is installed.

NOTE: Suspension will need to be loaded to connect end links.

- If the vehicle is using QA1 control arms, attach the sway bar end links to the control arm using the supplied hardware and spacers. The wider SG8-67 spacers are used at the control arm mount. See **Figure 5**.
- If the vehicle is using stock control arms, attach the end links to the sway bar. Install the included control arm mount brackets and lower the vehicle to ride height. **Figure 4**
- Install the top bolt through the existing bolt hole in the lower control arm and position the bracket so the end links are vertical with the truck sitting at ride height. See **Figure 6**.
- Mark the remaining hole location on the lower control arm and move the mounting bracket out of the way.



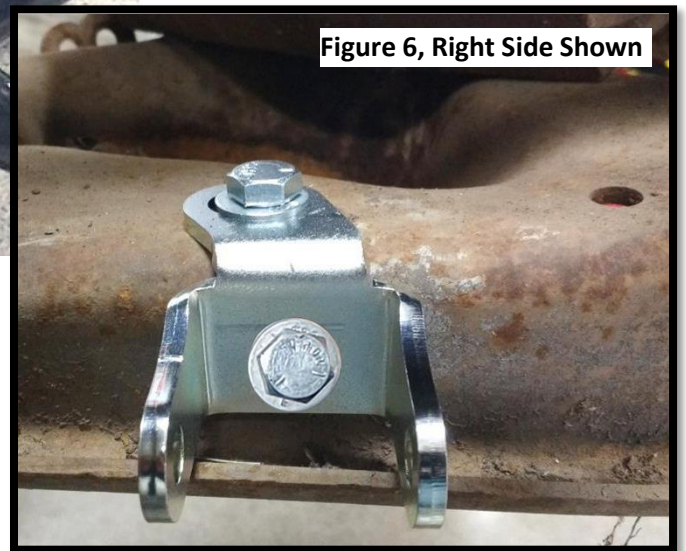
Balloon #	Item #	DESCRIPTION	QTY.	Balloon #	Item #	DESCRIPTION	QTY.
1		NUT, NYLOCK JAM, 1/2-20 LH, YELLOW	2	11		BOLT, 3/8-16 X 2.5" RH	2
2		WASHER, 1/2 SAE	2	12		BOLT, 3/8-16 X 1.0" RH	8
3	9029-309	HIGH MISALIGNMENT STUD	2	13	9037-594	BRACKET, STOCK LCA, RIGHT SIDE	1
4	AFR8-901	ROD END, 1/2" X 9/16-18	4	14		NUT, NYLOCK JAM, 3/8-16 RH	2
5	SG8-64	HIGH MIS SPACER, SS	2	15		BOLT, 3/8-16 X 0.875 RH	2
6		NUT, NULOCK, 3/8-16 RH	6		9037-584	SWAY BAR FRONT, 1 3/8"	1
7	9014-113	NUT, JAM 9/16-18 RH	2		9037-593	BRACKET, CHASSIS TO FRONT SWAY BAR	2
8	9037-596	LINKAGE FASTNER, MALE TO MALE	2		9037-595	BRACKET, STOCK LCA, LEFT SIDE	1
9	SG8-67	HIGH MIS SPACER, SS	4		9032-170	BUSHING, SWAY BAR FRAME MOUNT 1-3/8"	2
10		WASHER, 3/8" SAE	20			BOLT, 3/8-16 X 1.25" RH	2
11		BOLT, 3/8-16 X 2.5" RH	2				

13. Using a 3/8" drill bit, drill the hole in the lower control arm and mount the bracket with the 7/8" long bolt and thin nut in the vertical position.
14. Repeat steps 10-13 on the other side of the vehicle.
15. Re-install the end links and tighten the bolts to 30 lb.-ft. **NOTE: DO NOT OVER-TIGHTEN THE BOLTS!** Over-tightening can deform the spacers causing the bolts to stick in the spacers.
16. Tighten sway bar bracket bolts and bushing bolts.

Figure 5, Right Side shown



Figure 6, Right Side Shown





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