



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 52883 Front Sway Bar with QA1 Crossmember  
'63 - '86 Chevrolet/GMC C Series Pickup, '87 - '91 Chevrolet/GMC R Series Pickup

### TOOLS AND SUPPLIES REQUIRED

- Floor Jack
- Jack Stands
- Drill
- Crescent Wrench
- Two Clamps
- 3/8" Drill Bit
- SAE Socket Set

### PRE INSTALLATION NOTES:

This sway bar is designed to work with the QA1 front coil-over suspension with QA1 crossmember. This sway bar **WILL NOT WORK** with factory control arms.

## 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 14 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.



### SWAY BAR INSTALLATION:

#### NOTE:

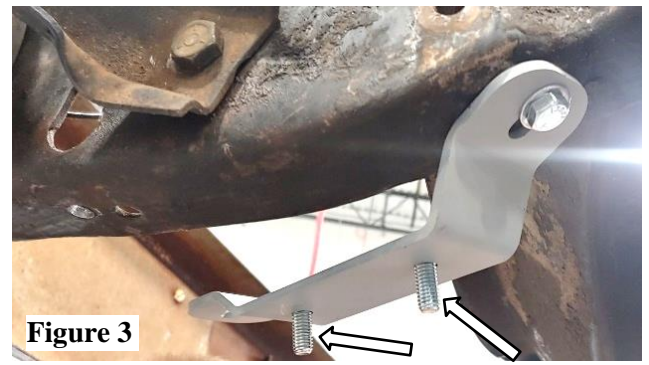
On '67-'91 trucks, the sway bar mounting bracket will need to be mounted to the truck frame dependent on the year of the truck. See the specific instructions for the year ranges below.

## '67-'72 Trucks:

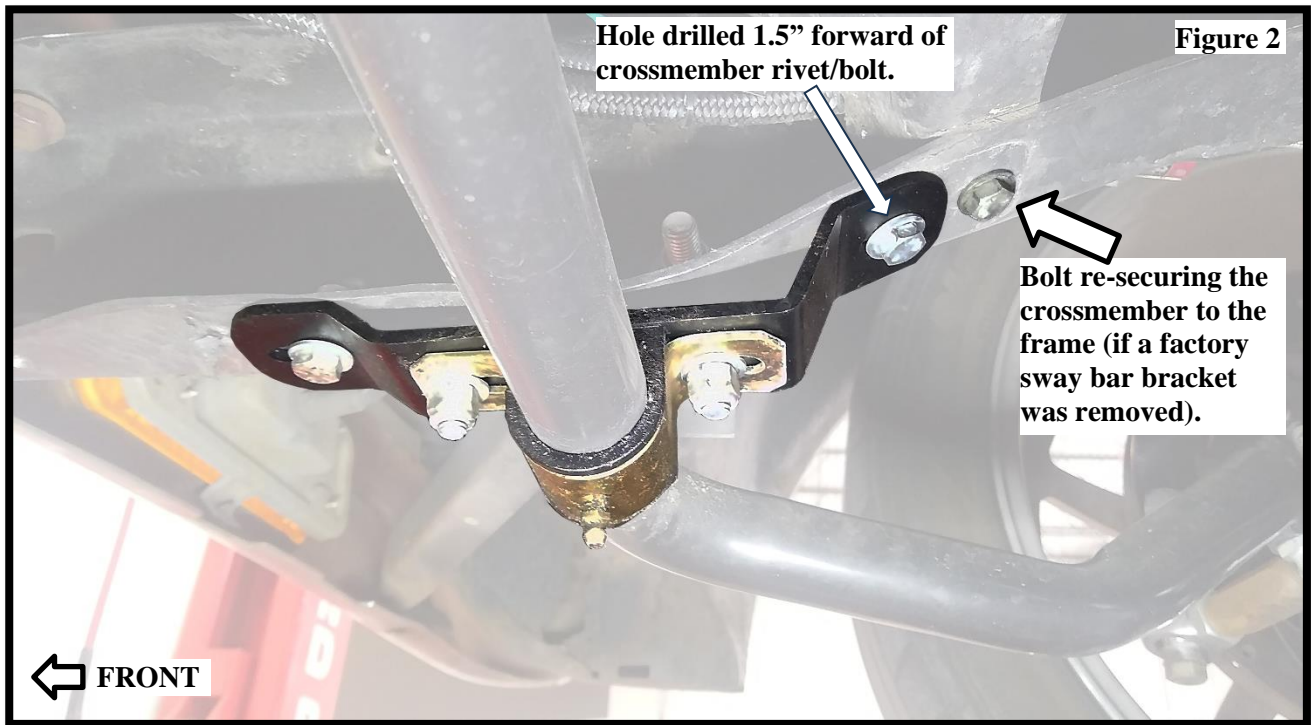
1. Trucks equipped with a factory sway bar will have factory mounting brackets that share the crossmember rivet hole while the QA1 bracket will need to be mounted 1.5" forward of the crossmember rivet hole. Trucks not equipped with a factory front sway bar will have a rivet securing just the crossmember. Measure 1.5" forward of the crossmember rivet/hole and drill using a 3/8" drill bit. (Figure 1)



2. If a factory sway bar bracket was removed leaving the crossmember mounting hole empty, use a bolt to secure this now empty hole to re-fasten the crossmember connection. **(Figure 2)**
3. Install the high-offset side of the QA1 bracket into the hole drilled 1.5" forward of the crossmember hole using the included 3/8" x 1" hardware with two washers and one nyloc nut per connection. **(Figure 3)**
4. Before fully installing the bracket to the frame, install two 3/8" x 1" bolts into the center holes of the bracket facing down. **(Figure 3)**



**Figure 3**

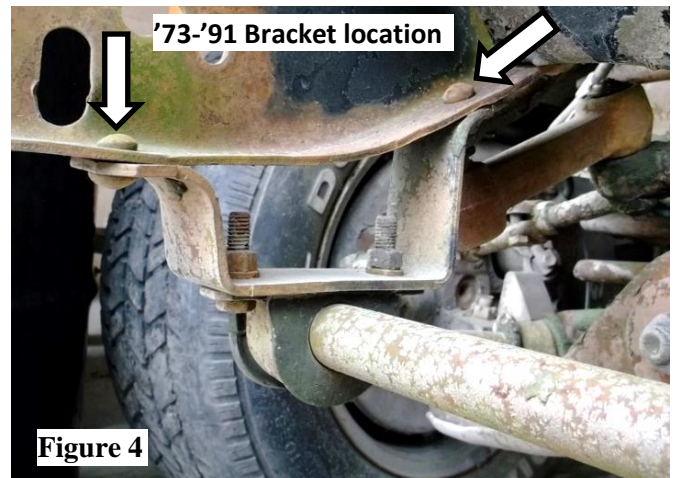


**Figure 2**

5. The front hole of the QA1 bracket will land on a larger slotted hole in the frame. Secure this connection using the larger washers included in the hardware kit with 3/8" x 1" bolts and nyloc nuts.
6. Torque all bracket hardware to 31 lb. ft.

## '73-'91 Trucks:

7. '73 – '91 trucks equipped with a factory sway bar will use the factory bracket holes for the QA1 bracket. **(Figure 4)**
8. '73 – '91 trucks NOT equipped with a factory sway bar will not have factory sway bar brackets, but the rearward hole that the bracket would have mounted to will be present. Mount the larger offset side of the QA1 bracket to the rearward hole using 3/8" x 1" hardware with two washers and one nyloc nut per connection.



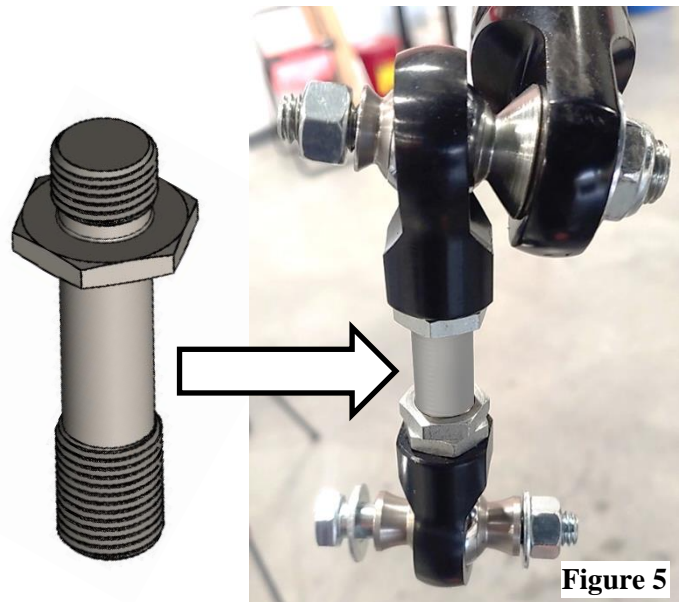
**Figure 4**

9. Before installing the bracket to the frame, install two 3/8" x 1" bolts into the center holes of the bracket facing down. **(Figure 3)**
10. Mount the front connection of the QA1 bracket to the existing factory bracket hole (if truck was equipped with a sway bar) or mark and drill the front hole of the bracket onto the frame with a 3/8" drill bit.
11. Secure the front bracket connection using 3/8" x 1" hardware, with two washers and one nyloc nut per connection. Torque to 31 lb. ft.

**AFTER THE BRACKET IS MOUNTED:**

12. Lightly grease the inner bushings before wrapping them around the sway bar followed by the included bushing straps. Raise the bar up to the downward facing bolts installed earlier and secure the bar to the bracket using one washer and 3/8" nyloc nut. **(Figure 6)**
13. Center the sway bar to the frame.
14. Assemble the two female rod ends onto the included stud with one jam nut on the non-hex side of the stud. A small amount of Loctite should be used on the fixed hex head end of the stud before installing the rod end. **(Figure 5)**

15. Insert the small diameter face of the misalignment stud into the bore of the rod end with one SG8-64 spacer into the opposite side of the rod end bore. Secure with 3/8" nut. **(Figure 5)**
16. Insert the large face of the misalignment stud into the end of the bar on the outboard side and fasten using one 1/2" washer and nyloc nut. **(Upper portion of Figure 5)**
17. On the control arm side of the linkage, insert one SG8-67 misalignment spacer in each side of the rod end bore. **(Lower portion of Figure 5)**
18. Insert the end link into the tabs on the lower control arm and fasten with 3/8" x 2.5" hardware with two washers and one nyloc nut. Torque to 31 lb. ft.



19. Check the clearance of the rod end and inner tie rod at full droop. Full droop is where these items will be closest to each other. Additional clearance can be gained by sliding the sway bar frame mount forward in its slotted holes.



# HARDWARE KIT

| 1st Description               | 2nd Description     | Qty. |
|-------------------------------|---------------------|------|
| Bolt, 3/8-16 x 2.5"           | Grade 5, Clear Zinc | 2    |
| Bolt, 3/8-16 x 1.25"          | Grade 5, Clear Zinc | 2    |
| Bolt, 3/8-16 x 1"             | Grade 5, Clear Zinc | 8    |
| Bolt, 3/8/16 x .875"          | Grade 5, Clear Zinc | 2    |
| Washer, SAE, 3/8              | Grade 5, Clear Zinc | 24   |
| Washer, SAE, 1/2              | Grade 5, Clear Zinc | 2    |
| Nut, Nylock, 3/8-16           | Grade 5, Clear Zinc | 14   |
| Nut, Nylock, Thin Jam, 3/8-16 | Grade 5, Clear Zinc | 2    |
| Nut, Nylock, Thin Jam, 1/2-20 | Grade 5, Clear Zinc | 2    |



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

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.

• DISCLAIMER / WARRANTY •

QA1 WARRANTS THAT THE PRODUCTS WILL BE FREE FROM DEFECTS IN MATERIAL AND WORKMANSHIP FOR ONE YEAR FROM DATE OF SALE TO THE ORIGINAL PURCHASER. QA1 MAKES NO OTHER WARRANTY OF ANY KIND, EXPRESS OR IMPLIED. QA1 SHALL HAVE NO OBLIGATION UNDER THE FOREGOING WARRANTY WHERE THE DEFECT IS THE RESULT OF IMPROPER OR ABNORMAL USE, YOUR NEGLIGENCE, VEHICLE ACCIDENT, IMPROPER OR INCORRECT INSTALLATION OR MAINTENANCE, NOR WHEN THE PRODUCT HAS BEEN REPAIRED OR ALTERED IN ANY WAY. QA1'S LIABILITY IN THE CASE OF DEFECTIVE PRODUCTS SUBJECT TO THE FOREGOING WARRANTY SHALL BE LIMITED TO THE REPAIR OR REPLACEMENT, AT QA1'S OPTION, OF THE DEFECTIVE PRODUCTS.

THE USER UNDERSTANDS AND RECOGNIZES THAT RACING PARTS, SPECIALIZED STREET ROD EQUIPMENT, AND ALL PARTS AND SERVICES SOLD BY QA1 ARE EXPOSED TO MANY AND VARIED CONDITIONS DUE TO THE MANNER IN WHICH THEY ARE INSTALLED AND USED. QA1 SHALL BEAR NO LIABILITY FOR ANY LOSS, DAMAGE OR INJURY, EITHER TO A PERSON OR TO PROPERTY, RESULTING FROM THE INSTALLATION, DIRECT OR INDIRECT USE OF ANY QA1 PRODUCTS OR INABILITY BY THE BUYER TO DETERMINE PROPER USE OR APPLICATION OF QA1 PRODUCTS. WITH THE EXCEPTION OF THE LIMITED LIABILITY WARRANTY SET FORTH ABOVE, QA1 SHALL NOT BE LIABLE FOR ANY CLAIMS, DEMANDS, INJURIES, DAMAGES, ACTIONS, OR CAUSES OF ACTION WHATSOEVER TO BUYER ARISING OUT OF OR CONNECTED WITH THE USE OF ANY QA1 PRODUCTS. MOTORSPORTS ARE DANGEROUS; AS SUCH, NO WARRANTY OR REPRESENTATION IS MADE AS TO THE PRODUCT'S ABILITY TO PROTECT THE USER FROM INJURY OR DEATH. THE USER ASSUMES THAT RISK!

## DEDICATED TECH SUPPORT

QA1 is dedicated to providing quality support and instructions. We employ passionate racers and car enthusiasts that know our products and the industry to better serve you.

**CHECK US OUT ON YOUTUBE!**



- Frequently Asked Questions
- Quick Tips
- Install Information
- Tuning and Repair Guides
- Other Technical Information



- [linkedin.com/company/qa1](https://www.linkedin.com/company/qa1)
- [instagram.com/qa1motorsports](https://www.instagram.com/qa1motorsports)
- [facebook.com/qa1motorsports](https://www.facebook.com/qa1motorsports)

[www.qa1.net/tech](http://www.qa1.net/tech)

[youtube.com/qa1tech](https://www.youtube.com/qa1tech)