

QA1
GO DRIVE IT.



QA1 REAR SWAY BAR 99-06 CHEVROLET SILVERADO 1500/GMC SIERRA 1500, 2007
SILVERADO 1500 CLASSIC/SIERRA 1500 CLASSIC—INSTALLATION INSTRUCTIONS: 52880

WELCOME TO QA1!

OUR COMMITMENT

Congratulations on your purchase of this high-quality QA1 99-06 SILVERADO 1500/SIERRA 1500, 2007 SILVERADO 1500 CLASSIC/SIERRA 1500 CLASSIC sway bar kit. It is engineered to the highest standards, utilizes the finest materials, and is built with exceptional craftsmanship and attention to detail.

While we understand your eagerness to start your build, please remember that your safety is our utmost priority. Always use an approved and appropriately rated jack, jack stand, or automotive lift, and take all necessary safety precautions to ensure the job is completed safely and correctly.

Before you start, read and understand all instructions thoroughly. With hand tools and essential equipment, you can do the main assembly and setup of your new sway bar in your home garage, but if you feel unsure of your abilities during the assembly or installation and need some help or have any uncertainties, please seek the assistance of a qualified mechanic or automotive repair shop.

If you have any product questions or need guidance, please don't hesitate to call and speak with QA1 technical support at 952-985-5675.

Remember, we're here to support you every step of the way and are committed to ensuring your assembly and installation process is successful and enjoyable. We wish you all the best!

BEFORE INSTALLATION

Before you begin the QA1 99-06 SILVERADO 1500/SIERRA 1500, 2007 SILVERADO 1500 CLASSIC/SIERRA 1500 CLASSIC sway bar kit installation, read and understand these instructions carefully. If instructions are not correctly followed, personal injury, equipment, or product damage can result.

Products that have been installed are not eligible for returns. To prevent mistakes, thoroughly read these instructions before you start the sway bar assembly procedure.

Check your order as soon as possible upon delivery. QA1 has provided parts list tables and images, as shown on pages 4 and 5. Compare your order's contents against the tables. Call your authorized dealer immediately if you discover anything missing from your order.

This kit requires no welding to assemble and install.

It is important to wear the appropriate personal protective equipment (PPE). However, the responsibility does not end there. Follow the manufacturer's instructions for safe use when working with power tools, and be cautious and responsible in your work. Make sure to ventilate combustible vapors and remove any nearby flammable materials.

ABOUT THIS MANUAL

PURPOSE

These instructions outline the installation of the QA1 rear sway bar kit. This system is designed to work with the factory leaf springs and fits the following vehicles:

- 1999-2006 Chevrolet Silverado 1500 w/Coil Spring Front Suspension
- 2007 Chevrolet Silverado 1500 w/Classic Coil Spring Front Suspension
- 1999-2006 GMC Sierra 1500 w/Coil Spring Front Suspension
- 2007 GMC Sierra 1500 w/Classic Coil Spring Front Suspension

ITS CONTENTS

The information that follows is described in this instruction set:

- Required tools and supplies.
- Safety, hazard, and warning rules.
- Product overview and included parts.
- Installation and the setup procedures required for use.

Pages with images will have paragraphs and sentences with callout numbers that refer to their respective images, steps, and parts.

Procedures, once described in the text, are generally not repeated. When it is necessary to refer to another procedure, the page and step reference will be given.

REQUIRED TOOLS AND SUPPLIES

- Floor Jack
- Jack Stands
- SAE and Metric Wrench Set
- SAE and Metric Socket Set
- Torque Wrench (lb-ft)

SAFETY FIRST

- Work on your vehicle in an appropriate location.
- Park your car on a level surface.
- Use wheel chocks to prevent vehicle roll.
- Check your owner's manual for the correct jack lift points.
- Always support your vehicle with jack stands.
- Wear personal protection like safety glasses, gloves, and a fine particle respirator mask.
- Never use compressed air to clean brake or metal grinding dust from the brake, suspension components, frame, or rear axle housing.
- Grind metal only in a well-ventilated area, and wear a respirator until the dust has settled and the work area air has been cleared.
- Dispose of damaged or old parts in accordance with local laws. Do not throw any hazardous waste in the trash.
- Follow the manufacturer's instructions for safe use when working with power tools, and be cautious and responsible in your work.

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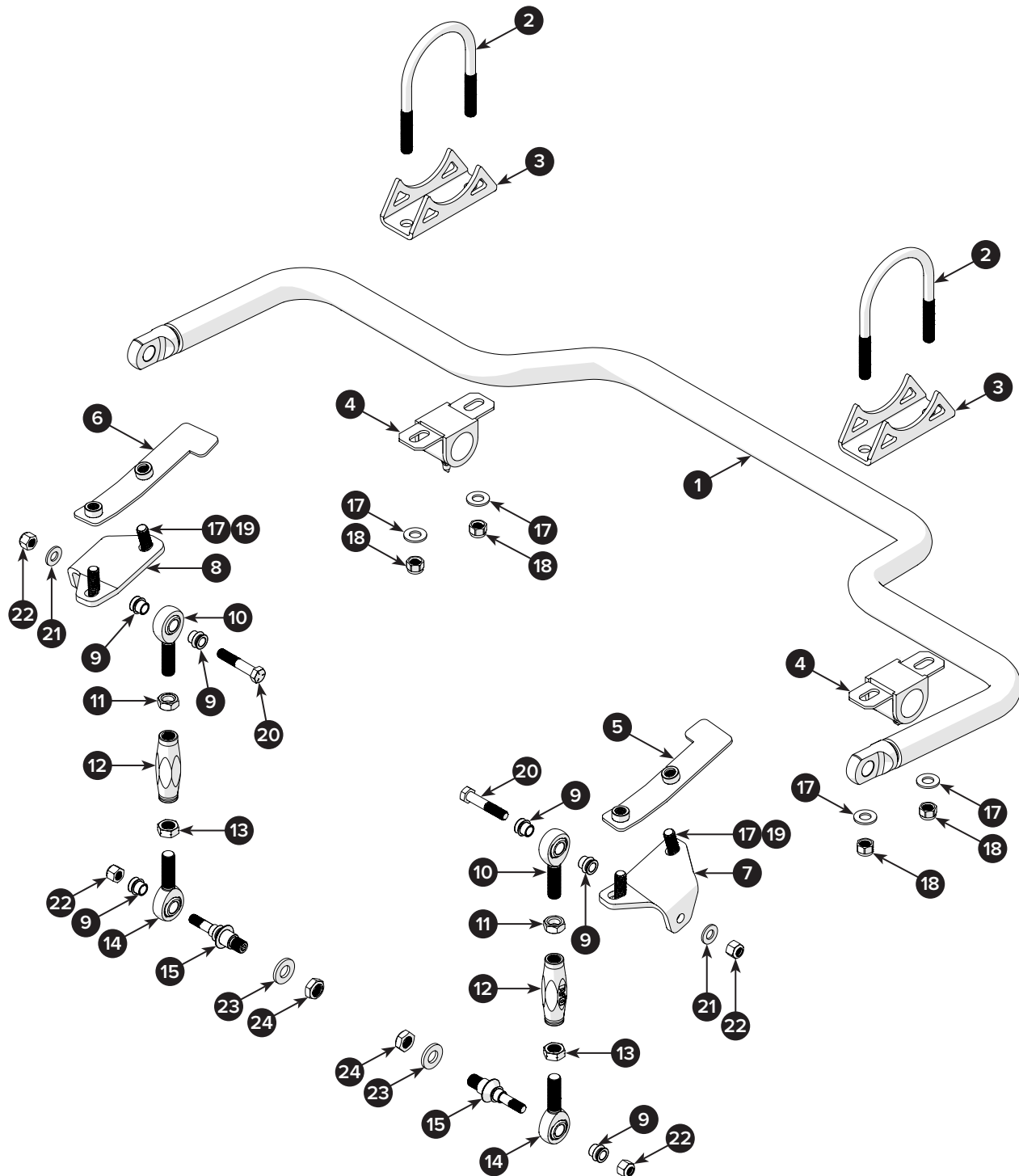
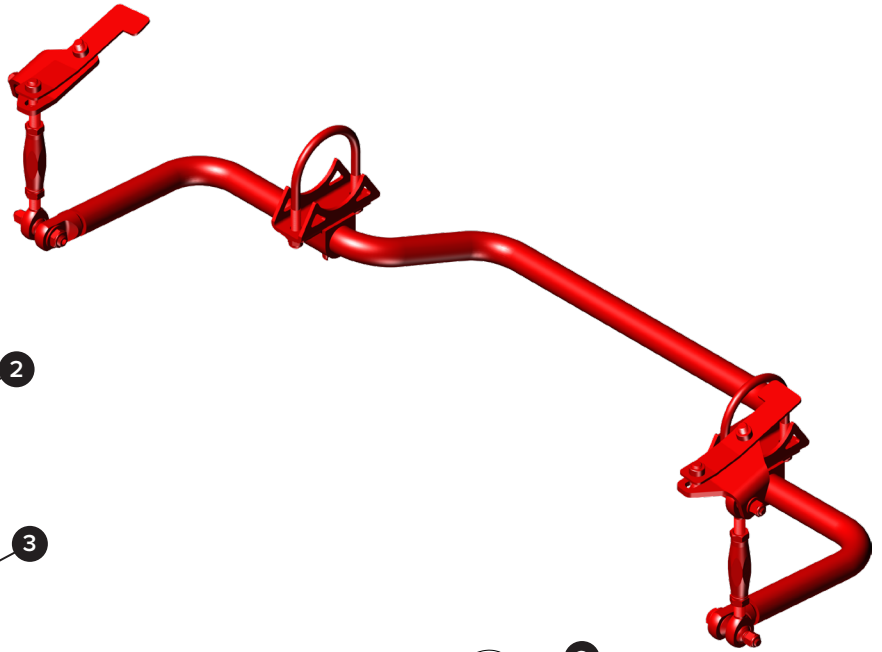
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99-06 SILVERADO 1500/SIERRA 1500, 2007
SILVERADO 1500 CLASSIC/SIERRA 1500
CLASSIC REAR SWAY BAR KIT 52880



1999-2007 SILVERADO/SIERRA SWAY BAR

POSITION	PART #	DESCRIPTION	QTY	TORQUE SPECIFICATION
1	7838-1122	SWAY BAR, REAR 1 1/4", BLACK	1	—

1999-2007 CHEVROLET SILVERADO REAR SWAY BAR INSTALL KIT 7039-447

POSITION	PART #	DESCRIPTION	QTY	TORQUE SPECIFICATION
2	9012-204	U-BOLT, 7/16-20 X 3.125" X 4.5"	2	—
3	9037-628	BRACKET, AXLE SADDLE MOUNT, 3 INCH	2	—
4	9032-171	BUSHING, SWAY BAR FRAME MOUNT ASSY, 1-1/4"	2	—
5	9039-559	NUT PLATE, SWAY BAR, LH	1	—
6	9039-558	NUT PLATE, SWAY BAR, RH	1	—
7	9039-519	BRACKET, REAR SWAY BAR MOUNT, LH	1	—
8	9039-520	BRACKET, REAR SWAY BAR MOUNT, RH	1	—
9	SG8-64	HIGH MISALIGNMENT SPACER, .5" OD	6	—
10	XMR8	ROD END (X) ENDURA ALLOY HT	2	—
11	JNR8S	JAM NUT, STEEL 1/2-20 RH	2	—
12	9033-550	SLEEVE, ALUMINUM HEX, .875" X 3.00"	2	—
13	JNL8S	JAM NUT, STEEL 1/2-20 LH	2	—
14	XML8	ROD END (X) ENDURA ALLOY HT	2	—
15	9029-309	HIGH MISALIGNMENT STUD	2	—
16	9071-109	TUBE, TEFLON LUBE, POLY BUSHING, (NOT SHOWN)	2	—

1999-2007 SILVERADO/SIERRA SWAY BAR HARDWARE KIT 7039-440

POSITION	PART #	DESCRIPTION	QTY	TORQUE SPECIFICATION
17	9005-243	WASHER, FLAT 7/16" SAE	8	—
18	NA	NUT, NYLOCK 7/16-20	4	49 LB-FT
19	NA	BOLT, HEX 7/16-14 X 1.50"	4	—
20	9012-249	BOLT, HEX 3/8-16 X 2"	2	—
21	9005-256	WASHER, FLAT 3/8" SAE	2	—
22	NA	NUT, NYLOCK 3/8-16	4	31 LB-FT
23	9005-228	WASHER, FLAT 1/2" SAE	2	—
24	9014-309	NUT, HEX, 1/2-20	2	36 LB-FT



Installer's Note: This instruction set shows only the frame and chassis of the 99-06 Silverado/Sierra pickup truck. The body has been removed for visual clarity.

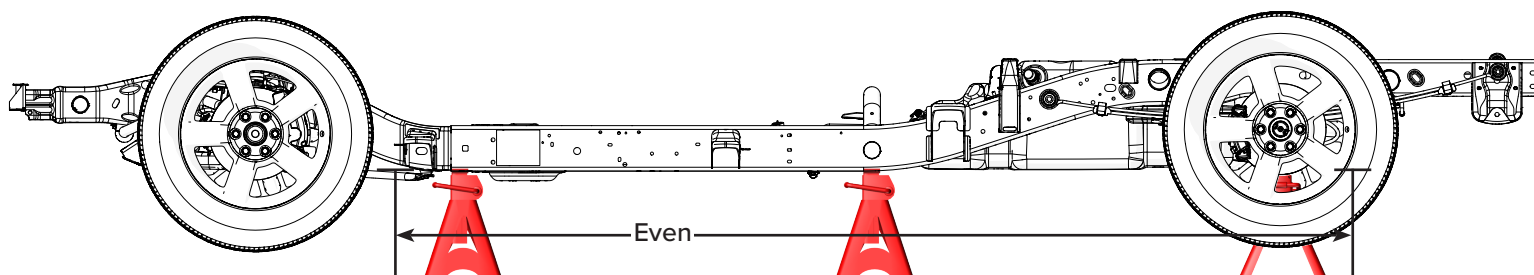
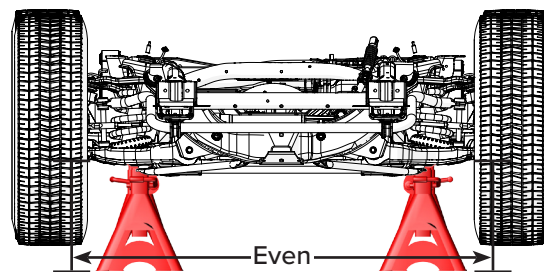
1

Use a floor jack and lift the vehicle at its designated lift points.

To access the front and rear suspension, set the vehicle on jack stands (shown) or a hydraulic lift under the frame as shown.

Note: Jack stands must be level and evenly positioned for safe vehicle load. Adjust the jack stands as necessary.

In this image, jack stands are also shown under the rear differential.

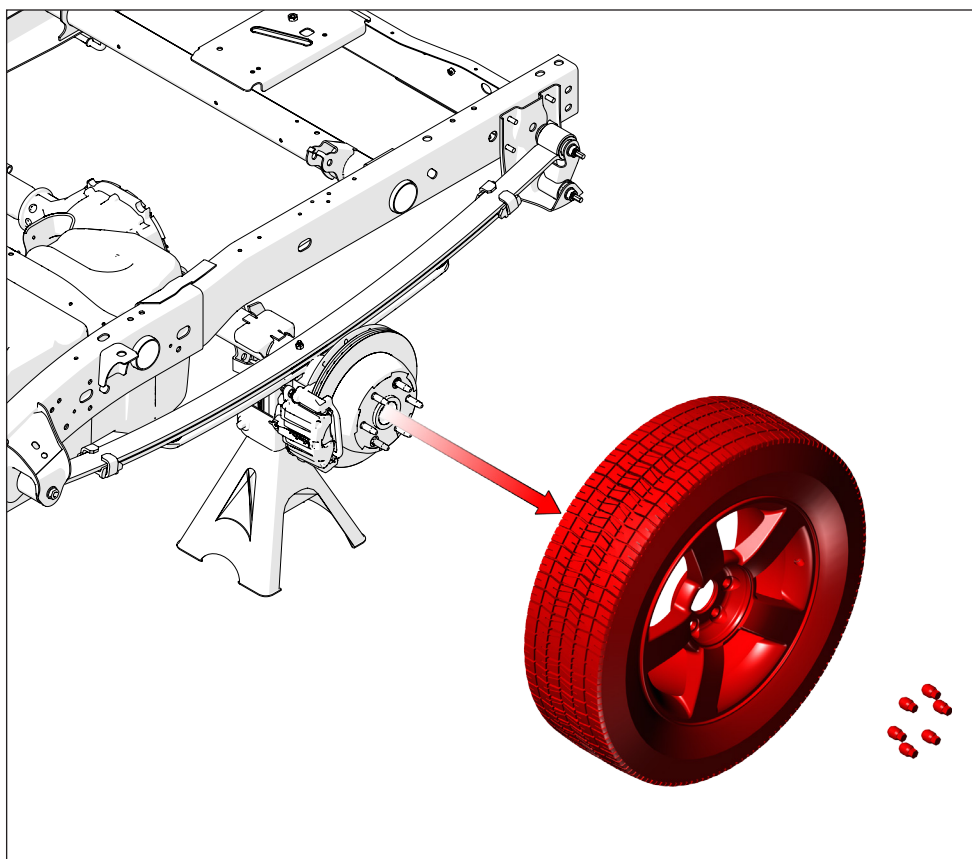


2

First, remove the lug nuts and wheels from both the left and right sides of the rear of the vehicle.

Then, remove the factory sway bar assembly, if equipped.

Discard the sway bar and all parts, as they will not be reused.



Installer's note: For proper sway bar installation and adjustment, make sure that the front ends (A) of the sway bar point downward, as shown.

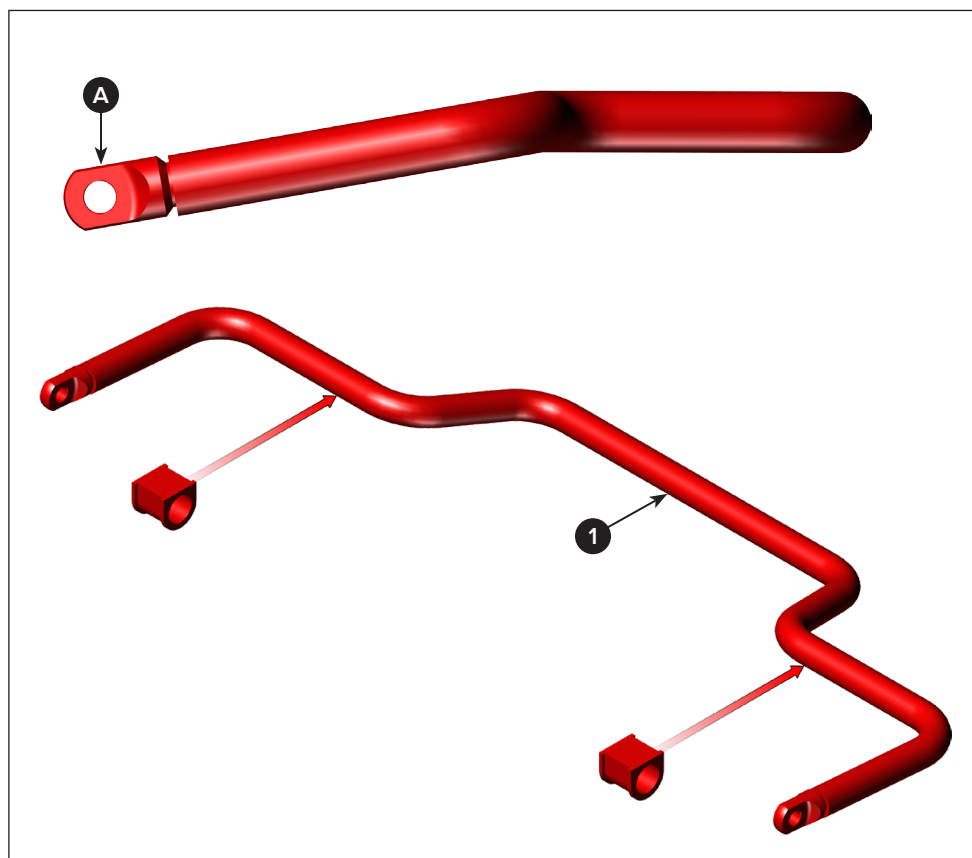
3

Remove the sway bar bushings from the mounts.

Press the sway bar bushings onto the sway bar (1).

Make sure the round sides of the bushings face down.

Note: The bushings come packaged pre-installed into the sway bar bushing mounts.

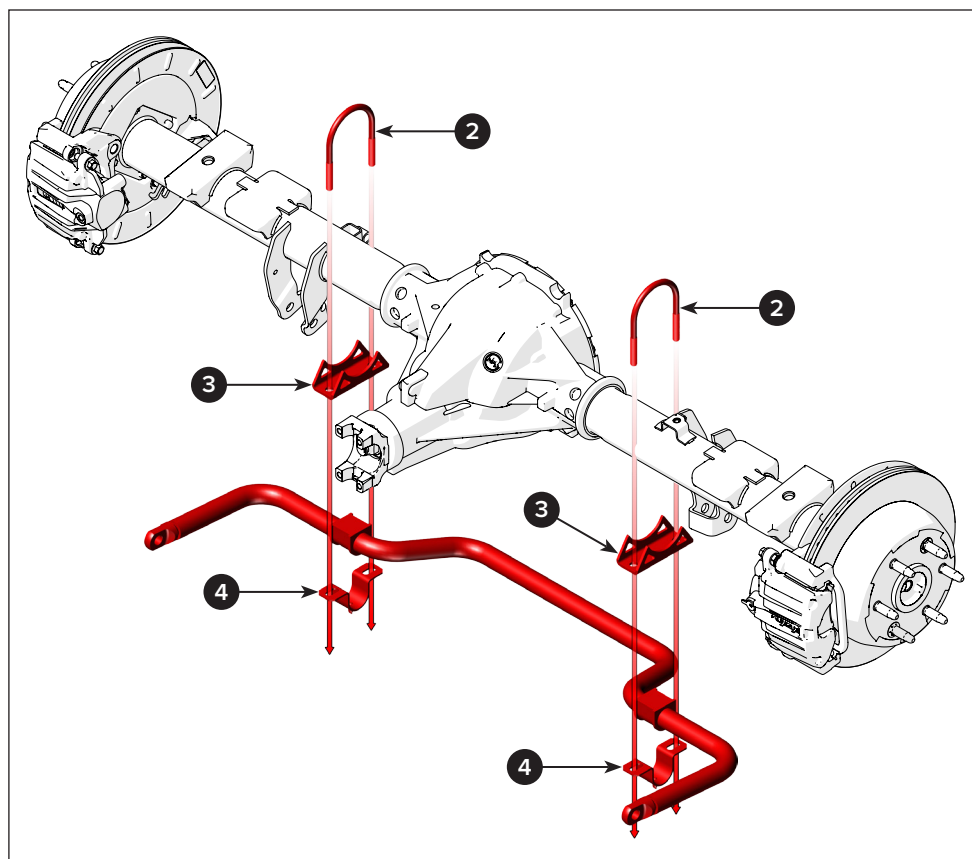
**4**

Put two sway bar mount brackets (3) under the axle housing tubes.

Put two U-bolts (2) over the axle housing tubes and through the mount brackets.

Put two sway bar frame mounts (4) on the bushings. The round ends will fit together.

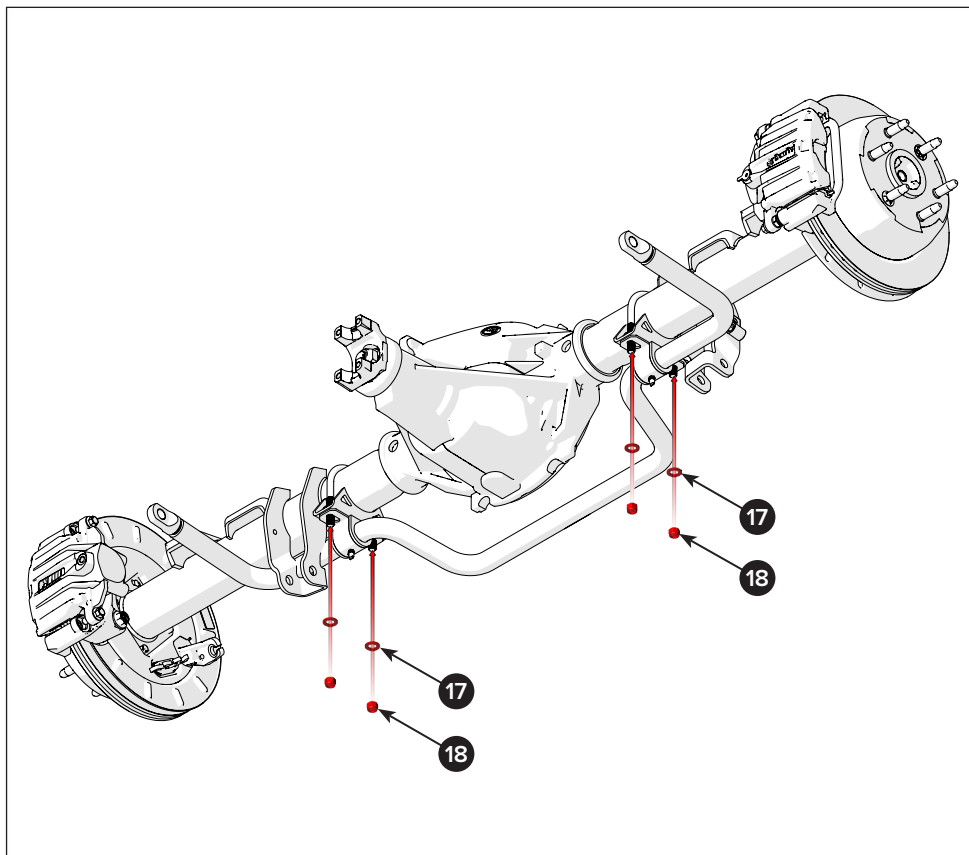
Squeeze the U-bolts to fit into the mount bracket, if needed.



5

Attach the sway bar with four flat washers (17) and four Nylock nuts (18).

Leave the fasteners loose during installation to adjust the sway bar mounts. They will be torqued during step 14.



6

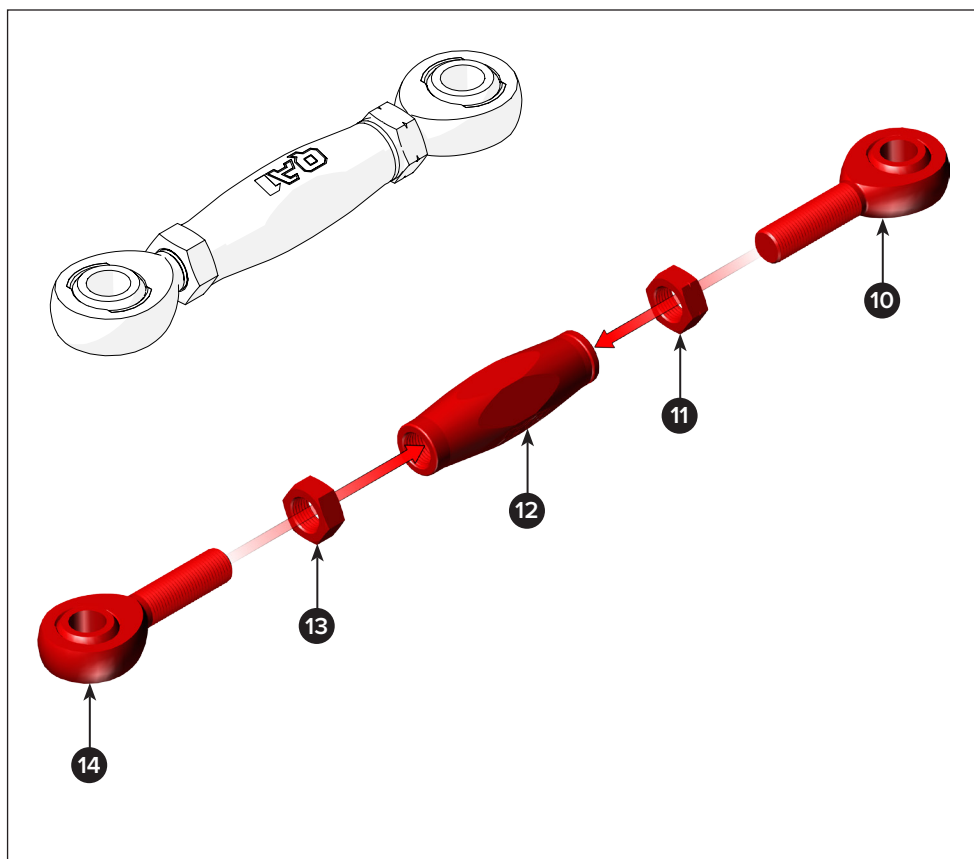
First, thread the right-hand (RH) jam nut (11) onto the right-hand (RH) rod end (10) until it is fully seated.

Next, screw the RH rod end assembly into the adjustable aluminum sleeve (12) until it is fully seated.

Then, thread the left-hand (LH) jam nut (13) onto the left-hand (LH) rod end (14) until it is fully seated.

After that, screw the LH rod end assembly into the adjustable aluminum sleeve until it is fully seated.

Finally, repeat this assembly procedure for the other sway bar link assembly.

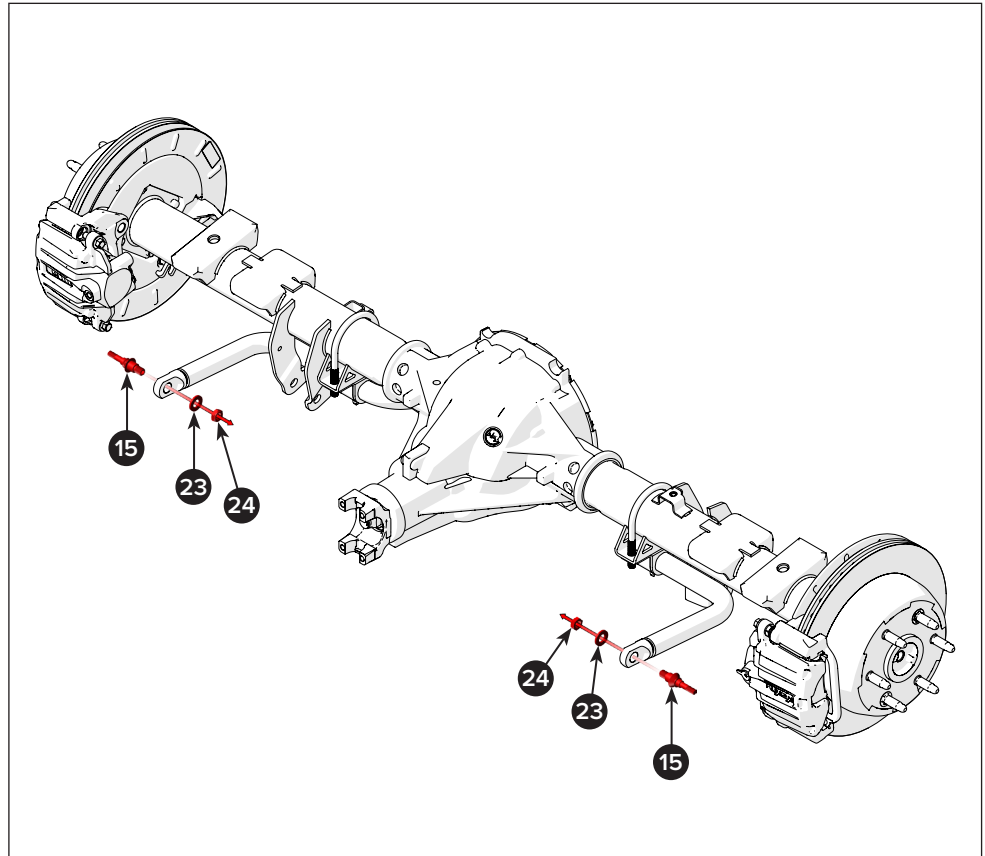


7

Fasten the high alignment studs (15) to the sway bar ends with one flat washer (23) and one Nylock nut (24).

Note: Use a 1/4" hex key or bit socket to hold the alignment stud in place while the nut is tightened.

Torque the nuts to 36 lb-ft.

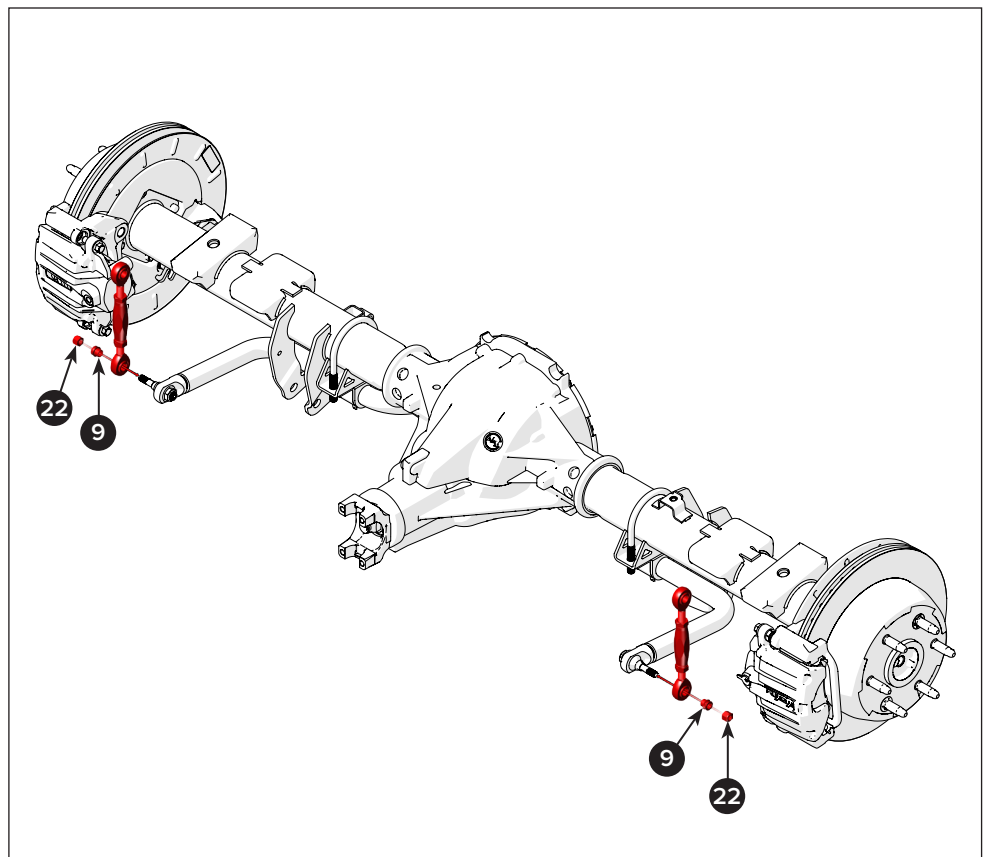


8

Install the sway bar links, assembled in step 6, onto the high alignment studs.

Use one high alignment spacer (9) and one Nylock nut (22).

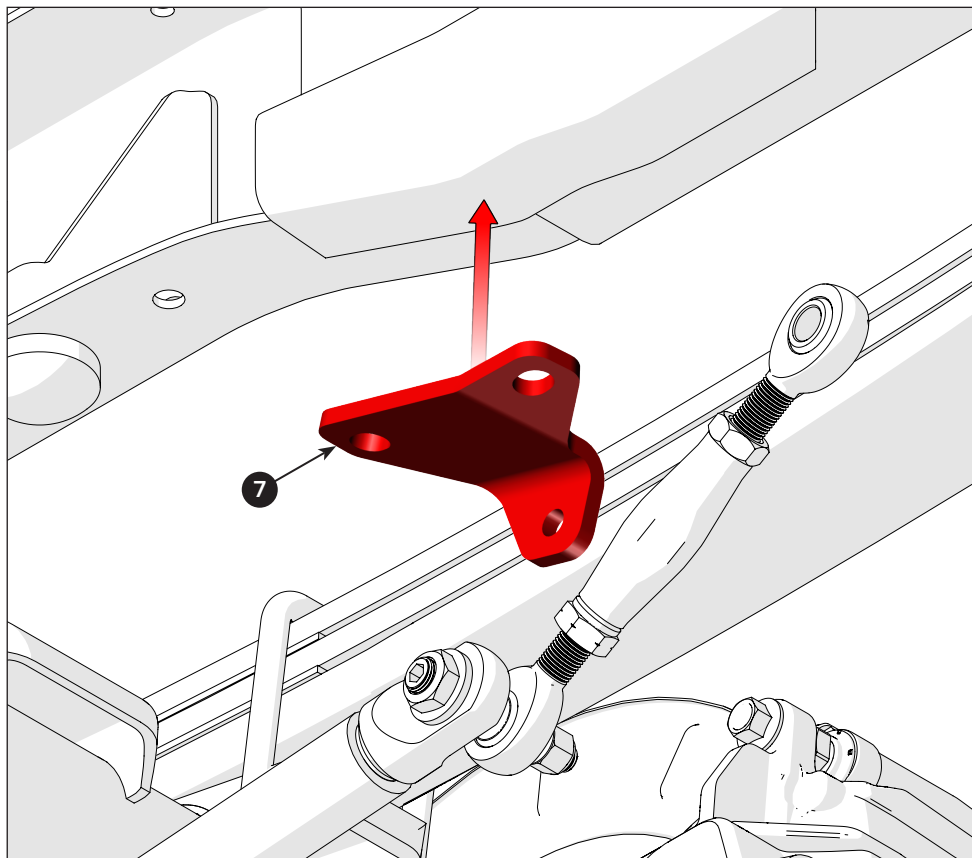
Keep the fasteners loose during installation to allow for adjustment of the sway bar links. They will be tightened during step 14.



Installer's note: For visual reference, steps 9 through 13 will show the vehicle's chassis and rear axle assembly.

These steps outline the left-hand mount bracket installation procedure. The right-hand side procedure is identical.

- 9** First, place one rear sway bar mount bracket (7) on each side of the upper sway bar link.



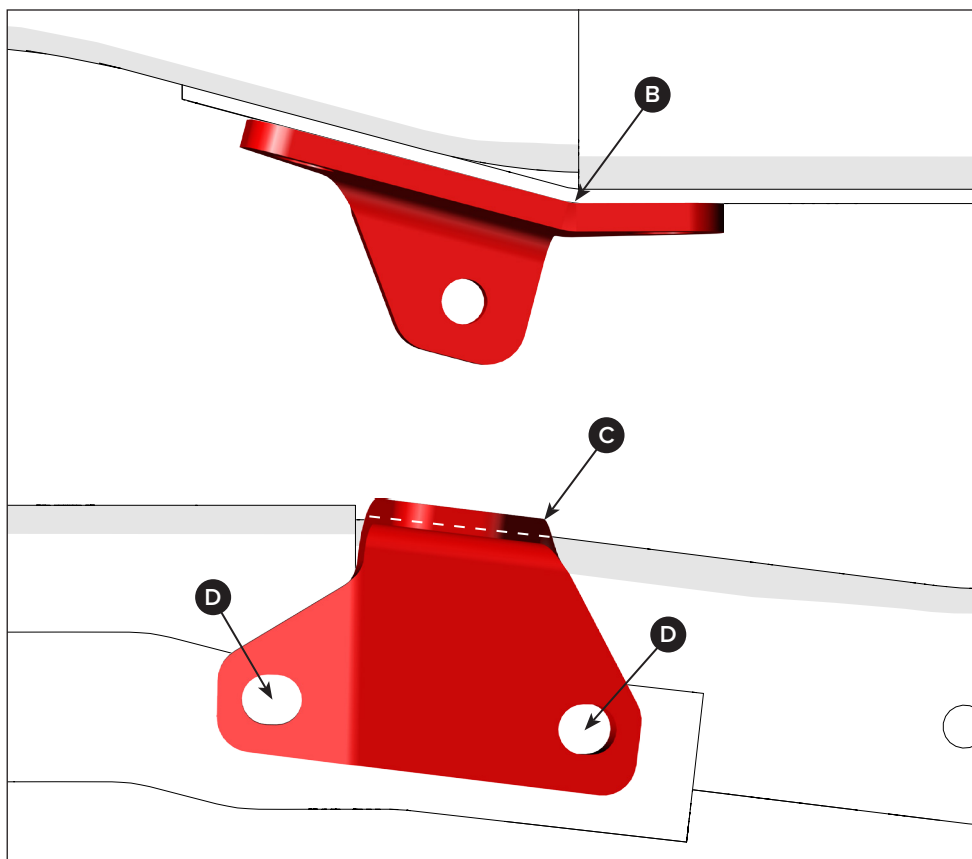
- 10** Then, align the mount bracket with the bend in the frame (B), as shown in the illustration.

Also, make sure the bracket aligns approximately 1/8" outside the frame (C), as shown.

Now that the mount bracket is aligned, it can be clamped or taped to retain its position.

Finally, use a 15/32" drill bit and drill through the bracket's bolt holes (D) and entirely through the frame.

Note: The dotted line represents 1/8" into the bracket.

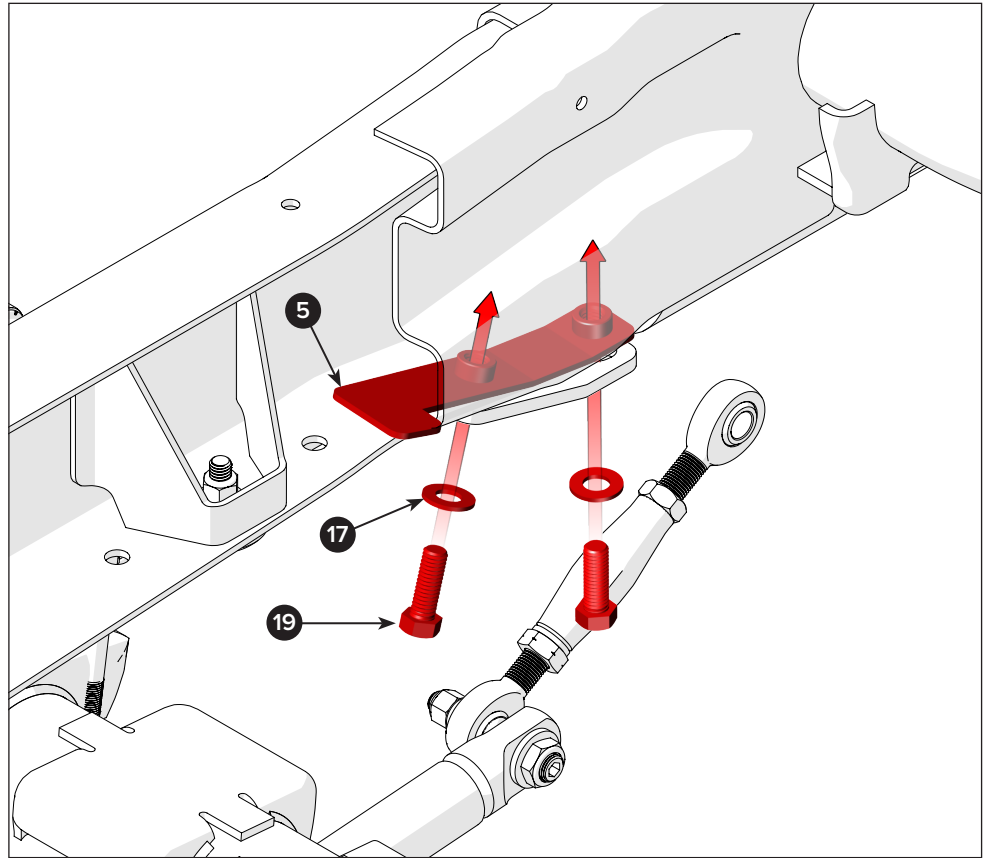


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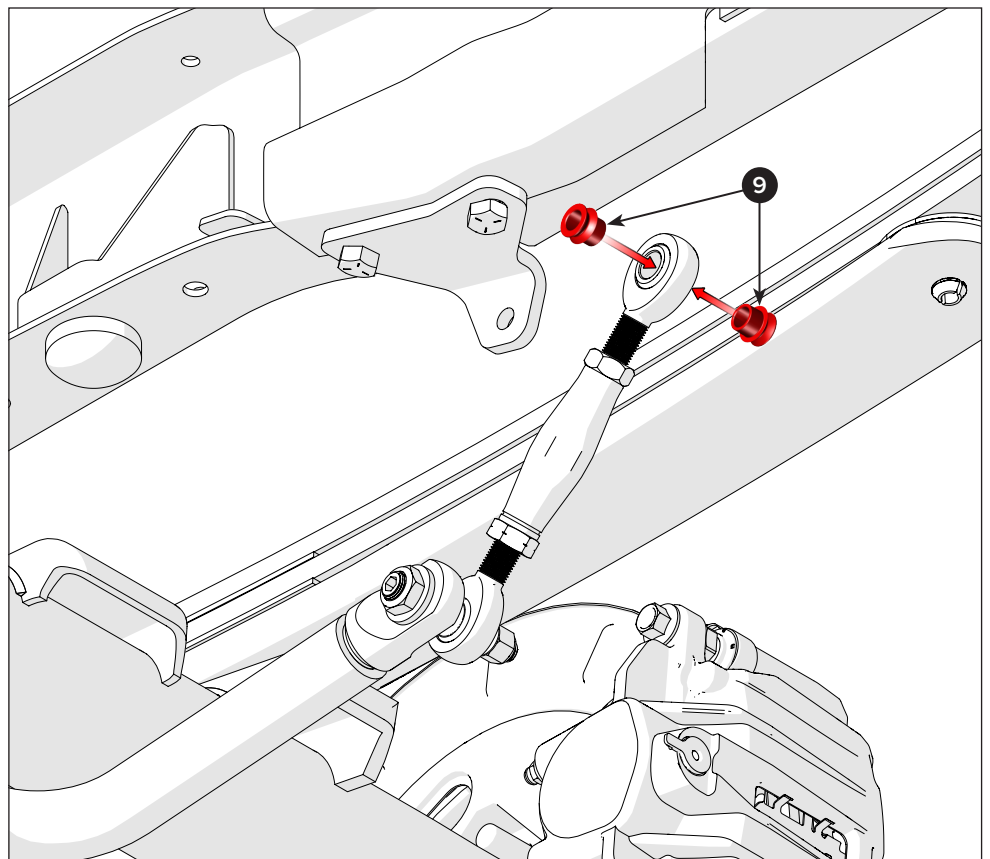
Put the left-side sway bar nut plate (5) into the frame pocket and behind the support bracket for the fuel tank's rear crossmember.

Turn two hex bolts (19) and flat washers (17) through the sway bar mount bracket, frame, and nut plate.

Torque the bolts to 49 lb-ft.


12

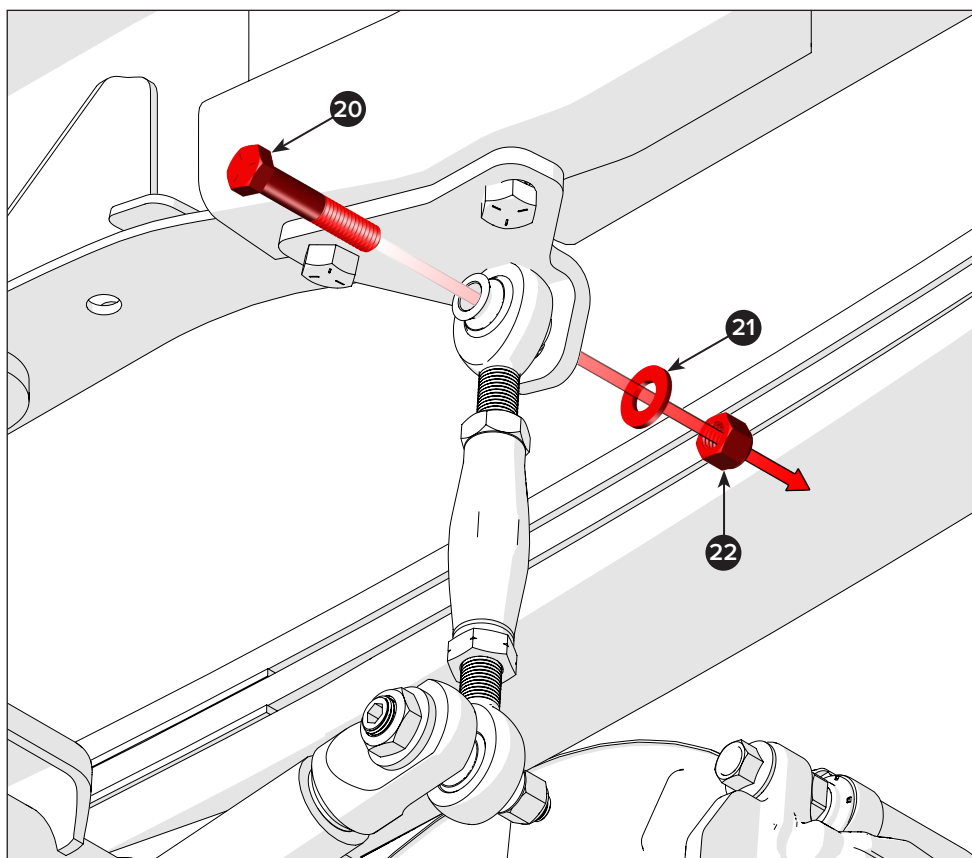
Push two high alignment spacers (9) into each side of the upper rod end.



- 13** Attach the sway bar upper link's rod end to the mount bracket with one bolt (20), one flat washer (21), and one Nylock nut (22).

Keep the fasteners loose during installation to allow for adjustment of the sway bar links. They will be tightened in the next step.

Repeat steps 9 through 11 to attach the right-side rod link assembly to the frame.



- 14** With the sway bar assembly complete, it is time to adjust the mounts and links, if needed, and torque all fasteners.

First, adjust the sway bar mounts and make sure both sides are set to the same angle (E).

Then make sure the sway bar links are evenly adjusted and set to the same distance (F).

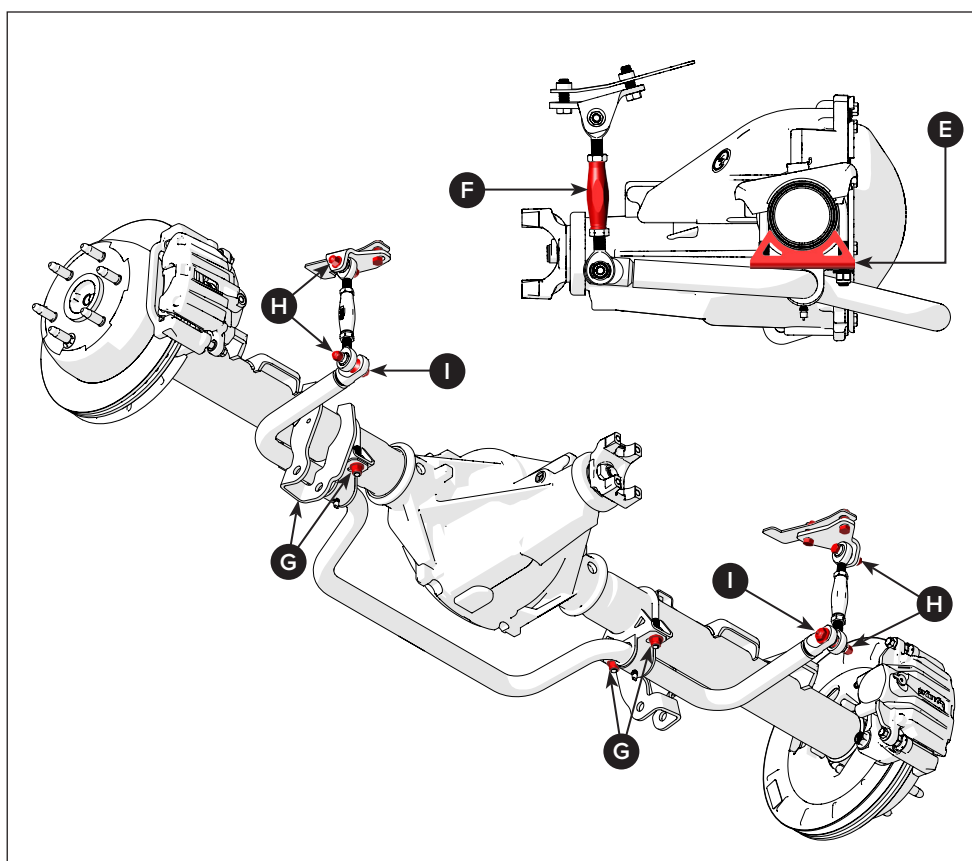
With the mounts and links set, torque the fasteners to the given specifications:

Torque the sway bar mount nuts (G) to frame bolts to 49 lb-ft.

Torque the sway bar link to sway bar bolts (H) to 31 lb-ft.

Torque the crossmember to sway bar link bolts (I) to 36 lb-ft.

Note: For optimal performance, handling, and ride quality, make any additional sway bar adjustments after the tires are on and the vehicle is level on the ground.



DISCLAIMER / WARRANTY

QA1 warrants the products to be free from defects in material and workmanship for one year from the date of sale to the original purchaser. QA1 makes no other warranty of any kind, expressed or implied.

QA1 shall have no obligation under the preceding warranty where the defect results from improper or abnormal use, your negligence, vehicle accident, inappropriate 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 preceding warranty shall be limited to the repair or replacement of the defective products at QA1's option.

The user understands and recognizes that racing parts, specialized street rod equipment, and all parts and services sold by QA1 are exposed to many varied conditions due to the manner in which they are installed and used. It is the user's responsibility to determine the proper use or application of QA1 products.

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 to the buyer arising out of or connected with using any QA1 products.

Motorsports are inherently risky; therefore, no warranty or representation is made as to the product's ability to protect the user from injury or death. The user is fully aware and assumes that risk.



