

Detroit Speed
Frame Notch Bracket Kit – Coil Spring Rear
1967-72 GM C10 Truck
P/N: 040117DS

The Detroit Speed Coil Spring Frame Notch Bracket Kit is 100% Bolt-on and is designed to give you clearance between the rear axle and the frame rail when dropping the ride height of your 1967-72 GM C10 truck. Our unique bracket design adds rigidity at the coil spring mounting point on the frame rail, separating our design from the competition. The frame notch brackets are manufactured from high quality 3/16" thick steel. All mounting hardware and bump stops are included in this kit. This kit is designed to work with both the DSE Speed Kits and the QUADRALink on factory coil spring frame rails only.



Item #	Description	Quantity
1	Leaf Spring Frame Notch Assembly, LH and RH	2
2	Rear Axle Jounce Bumper Kit	1
3	Frame Notch Cut Template	1
4	Frame Notch Hardware Kit	1
5	Instructions	1

Hardware Kit Checklist - Detroit Speed Frame Notch Bracket Kit			
Part Number	Description	Quantity	Check
200114	Frame Notch Bracket Hardware Bag	1	
950042FS	7/16"-20 x 1-1/4" L Hex Head Bolt	30	
960050FS	7/16"-20 Nylock Nut	30	
970043FS	7/16" SAE Washer	60	

IMPORTANT:

All work should be performed by a qualified technician. Please read the entire set of instructions and fully understand all the steps involved before beginning the project. Always make sure to wear the appropriate safety equipment for the job and properly support the vehicle. If you have any questions before, during, or after the installation, feel free to contact Detroit Speed by phone at (704) 662-3272 or by email at tech@detroitsspeed.com.

Installation:

1. Remove the bed from the truck. Raise the vehicle up on jack stands so that the frame is level with the ground. Support the rear axle so the rear brake lines are not in tension. **NOTE:** We also recommend placing two jack stands behind the rear axle to help support the frame rails during installation.
2. Disconnect the rear brake line in the passenger side frame rail. Remove the clip holding the flex line to the hardline. The flex line goes to the rear axle through a hole in the upper spring perch plate bracket. Remove the flex line from the chassis (Figure 1).



Figure 1 - Remove Brake Line

3. Removing the rear shocks from the frame are not required however it may help to unbolt them from the frame during installation. Remove the rear axle jounce bumper bracket from both sides of the frame by removing the rivets from the frame rails (Figure. 2 on the next page).



Figure 2 - Remove Rear Axle Bump Stop Bracket

4. Remove the upper spring perch plate from the bottom side of the frame rail and crossmember. Start by removing the two rivets on the top of the frame crossmember by grinding them down. Use a punch to remove the rivets from the crossmember. Grind the holes smooth (Figure 3).



Figure 3 - Remove Rivets

5. Remove the spring perch plate by removing the two rivets on the bottom side of the framerail. Use a punch to remove the rivets and pry the spring perch plate from the framerail (Figure 4).

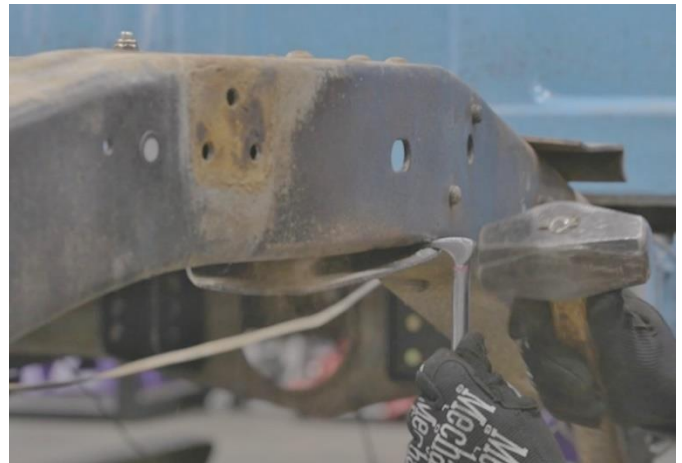


Figure 4 - Remove Spring Perch Plate

6. Grind the remaining rivets down and remove them from the framerail using a punch (Figure 5 on the next page).



Figure 5 – Remove Rivets

7. Remove the factory panhard bar mount bracket on the driver side frame rail by removing the four rivets on the bottom side of the frame rail (Figure 6).



Figure 6 – Remove Factory Panhard Bar Bracket

8. Prepare the frame rails by grinding smooth the area of the frame rails that will have the frame notch bracket installed (Figure 7).



Figure 7 – Prepare Frame Rails

9. With the rear frame rails level, locate the rear edge of the frame notch location on the side of the frame. Using the factory hole on the frame rail, measure forward 10-1/2". Mark this location (Figure 8). **NOTE:** Make sure the tape measure is level when you mark this location.



Figure 8 - Frame Notch Bracket Location

10. Cut out the provided frame notch template. Place it on posterboard if desired. Place the frame notch template so it sits on the outside frame rail. Locate the rear edge of the template to the marked location from the previous step. Wrap the bottom of the template around the bottom side of the frame rail and tape the template in place. With the frame notch location exposed from the template, remove the template and place masking tape on that area of the framerrail (Figure 9).



Figure 9 - Locate Frame Notch Template

11. Locate the template back onto the side of the framerrail. Use the template and trace the frame notch cutout onto the side of the frame rail (Figure 10).



Figure 10 - Trace Frame Notch Location

12.Center punch and drill two holes in the corners of the traced lines on the frame rail to make it easier to cut around the corners of the frame notch area (Figure 11).

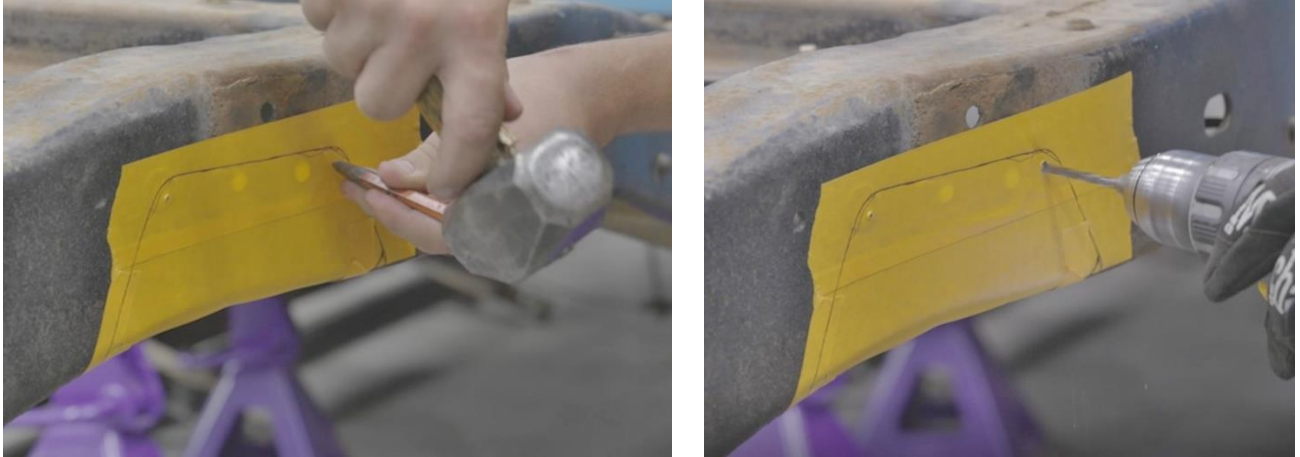


Figure 11 - Drill Corner Holes

13.Cut along the traced lines to notch the frame rail. Grind all edges smooth (Figure 12). **NOTE:** We recommend cutting the frame rail and installing the frame notch bracket on one side of the frame before cutting the other frame rail for strength.



Figure 12 - Cutout Frame Notch

14.Grind the notch area smooth to remove any burrs from the framerrail (Figure 13).



Figure 13 - Grind Notch Area

15. Locate the frame notch bracket assemblies from the kit. There is a left and right hand side bracket so make sure you use the correct bracket for the correct side of the frame (Figure 14).



Figure 14 - Frame Notch Assembly

16. Test fit the frame notch assembly to the frame (Figure 15).



Figure 15 - Test Fit Frame Notch Assembly

17. Locate the frame notch by aligning these four holes with the factory rivets holes that were drilled out in Steps 4-6. Trim and grind any frame rail material away if needed so the frame notch assembly fits tight to the frame rails (Figure 16).

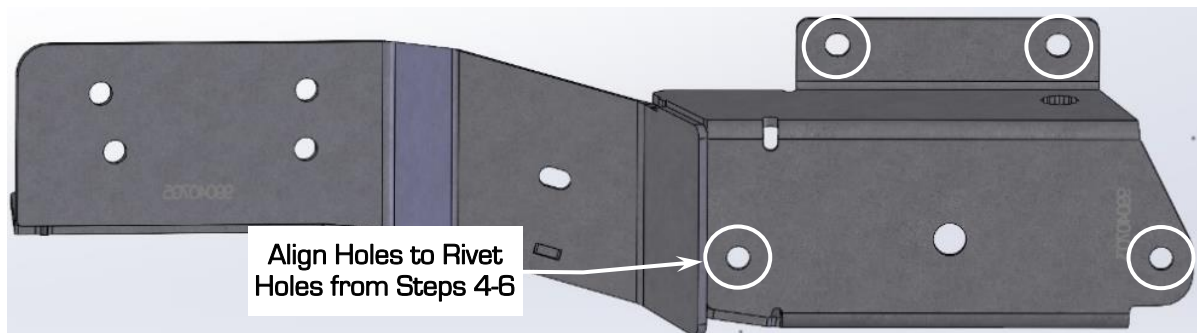




Figure 16 - Test Fit Frame Notch Bracket

18. Once the frame notch assembly fits around the frame rails, clamp the bracket in place and transfer punch the frame rail using the frame notch bracket assembly as a template. There will be seven locations to mark on the outside frame rail. **NOTE:** If you plan on installing the DSE track bar kit, there are four additional holes on the driver side that you need to transfer punch and drill. If you plan on installing the DSE QUADRALink, there are four additional holes on the passenger side frame rail that you need to transfer punch and drill. (Figure 17).



Figure 17 - Track Bar Mounting Holes

19. Center punch and drill two mounting holes above the frame notch to a final drill size of 15/32". Install two sets of provided 7/16"-20 x 1-1/4" L hex head bolts, washers and Nylock nuts to hold the bracket assembly in place (Figure 18). Use anti-seize on the threads of the bolts.

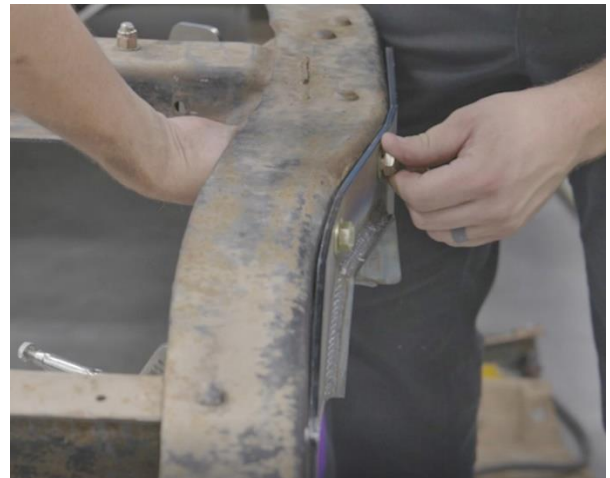


Figure 18 - Mount Frame Notch

20. Transfer punch the bottom side of the frame rail using the frame notch bracket assembly as a template. There will be six locations to mark on the bottom frame rail.
21. Using a 15/32" drill bit, drill through the two mounting bores on the inside of the frame notch bracket that line up with the two holes in the cross member. These holes were left open when the rivets were removed in Step 4.
22. Remove the frame notch bracket assembly and drill out all locations on the framerrail for the 7/16"-20 hardware to a final drill size of 15/32" (Figure 19). **NOTE:** It is recommended that pilot holes be drilled first before drilling the 15/32" holes.



Figure 19 - Drill Frame Rail

23. Before installing the frame notch bracket assembly, DSE recomends painting/ powdercoating the frame notch bracket and the area of the frame rail that will be covered by the bracket to prevent surface rust.
24. Install the frame notch bracket assembly onto the frame rail using the provided fifteen sets of 7/16"-20 x 1-1/4"L hex head bolts, Nylock nuts and washers (Figure 20). Use anti-seize on the threads of the bolts. Tighten the hardware on the outside of the frame rail first, and then tighten the bottom hardware. Torque the 7/16"-20 hardware to 50 ft-lbs.



Figure 20 - Install Frame Rail Notch Bracket

25. Repeat Steps 4 through 24 for the other side of the truck (Figure 21).

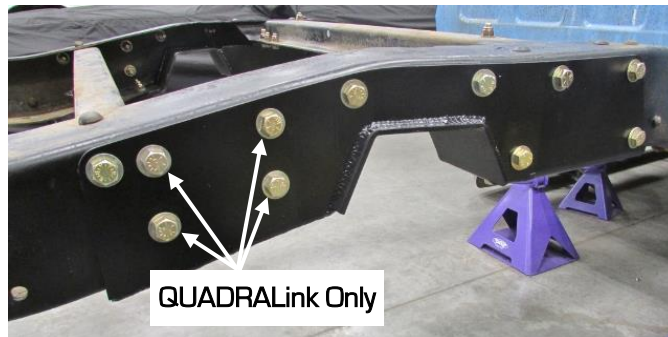


Figure 21 – Frame Notch Assembly (RH, Passenger Side)

26. If you are re-using the factory panhard bar, re-install the panhard bar bracket to the driver's side frame rail using hardware. DSE recommends using PN: 040118DS, Track Bar and Shock Relocation Kit.

27. Install the jounce bumper into each frame notch assembly at the frame notch using the provided 3/8"-16 Nylock nut and washer and tighten (Figure 22).

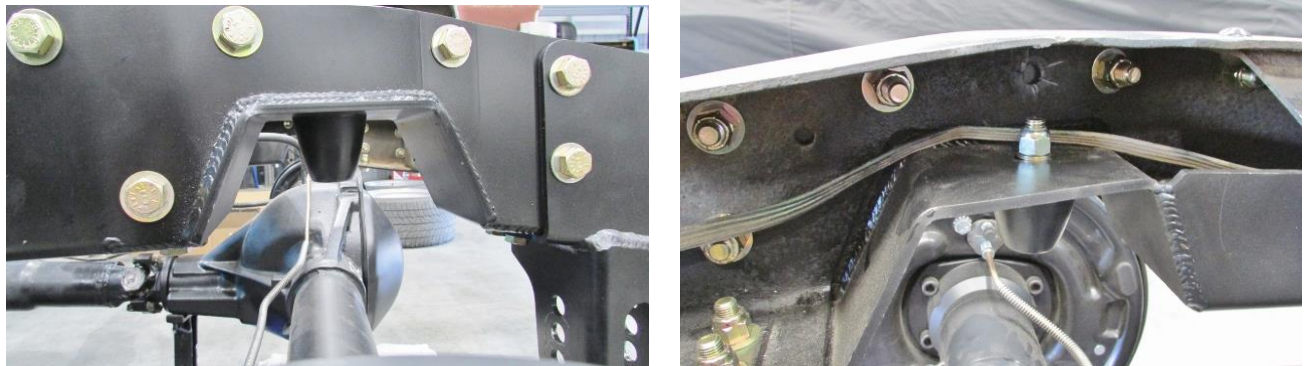


Figure 22 – Install Jounce Bumper

28. Re-connect the brake line fitting through the brake line hole in the passenger side frame notch bracket assembly. Tighten the fitting between the hardline and the flex line at the frame notch bracket (Figure 23).



Figure 23 – Re-connect Brake Line

29. Bleed the brakes once the brake hose has been reconnected. The installation is now complete.

If you have any questions before or during the installation of this product, please contact Detroit Speed at tech@detroitsspeed.com or 704.662.3272

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