

READ ALL INSTRUCTIONS COMPLETELY AND THOROUGHLY UNDERSTAND THEM BEFORE DOING ANYTHING.  
CALL CHASSISWORKS TECH SUPPORT (916) 388-0288 IF YOU NEED ASSISTANCE.

## INSTALLATION GUIDE



### 5806-Q10 g-Bar Splined-End Anti-Roll Bar 1960-1965 Falcon and Comet



**Description:**

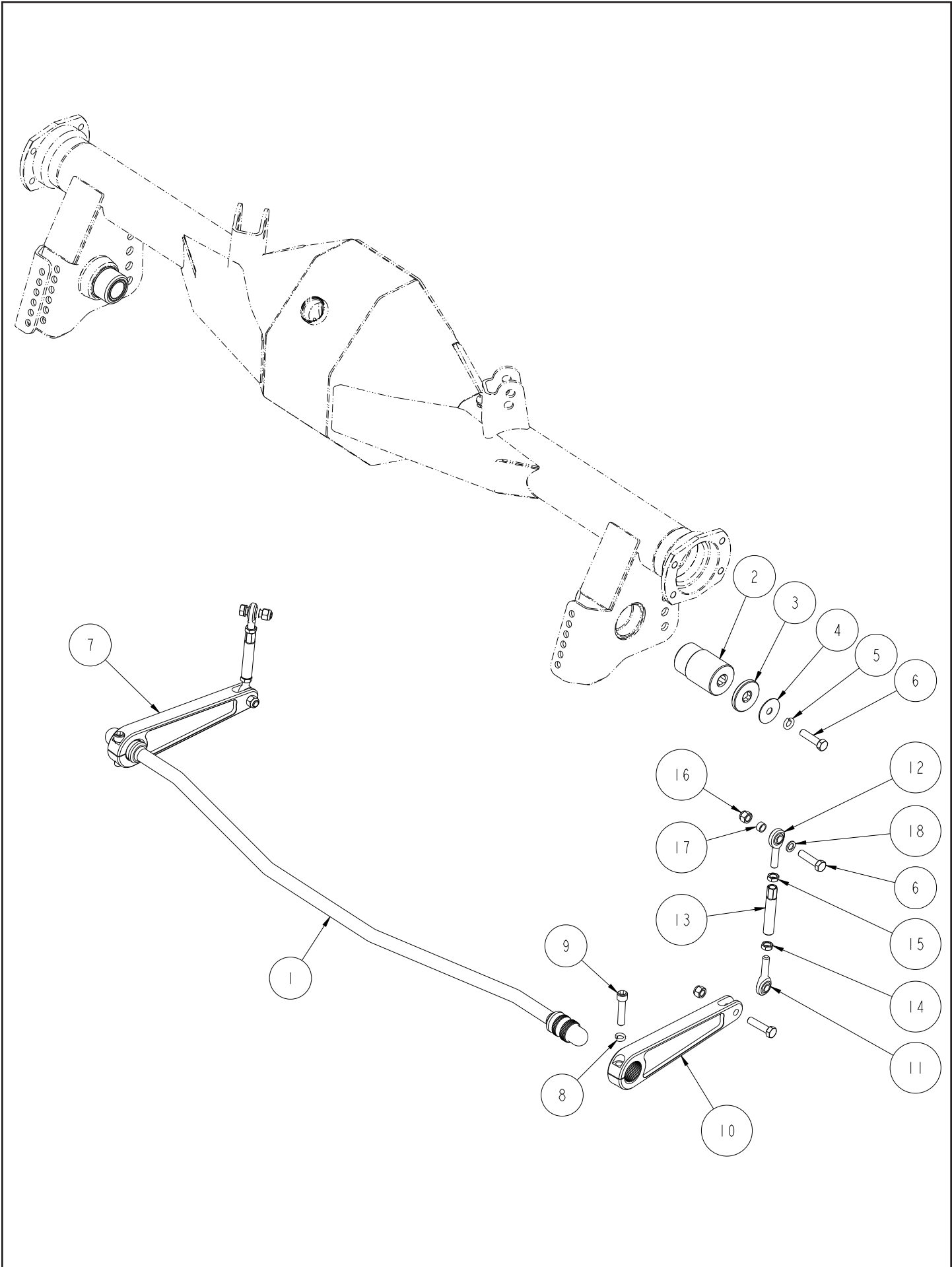
Splined-end anti-roll bar for 1960-65 Falcon and 1960-65 Comet g-Bar rear suspension.

**Includes:**

3/4" diameter bent-tube anti-roll bar, billet-aluminum arms, pivot sockets, endlink assemblies

**Notes:**

Threaded mounting socket is part of lower axle-housing bracket and ships with g-Bar suspension system. Chassis endlink mounts are integrated into weld-in g-Bar upper control mounts.



ITEM	QTY	PART NO.	DESCRIPTION
1	1	5071	ANTI-ROLL BAR ASSEMBLY, $\varnothing$ 3/4, BALL PIVOT, G-BAR, 67-69 CAMARO
2	2	3701	PRELOAD ADJUSTER ASSEMBLY BALL END ANTIROLL BAR
3	2	1262	LOCKING RING, 1 7/8-20 THREAD 1/2 DRIVE, BALL END ANTIROLL BAR
4	2	3157-038F-C	FENDER WASHER, 3/8 x 1 1/2, ZINC PLATED
5	2	3108-038L-C	LOCK WASHER, HELICAL SPRING $\varnothing$ 3/8, STEEL, ZINC
6	6	3100-038F1.50Y	HEX BOLT, 3/8-24 x 1 1/2, GRADE 8, YELLOW ZINC
7	1	1465-L	ANTIROLL 4° ARM, LEFT 1 1/4-48 SPLINE, 8.20 LONG
8	2	3108-038H-C	HIGH COLLAR LOCKWASHER, 3/8 STEEL, CLEAR ZINC
9	2	3103-038C1.75C	SOCKET HEAD CAP SCREW, GRADE 8, 3/8-16 x 1 3/4, CLEAR ZINC
10	1	1465-R	ANTIROLL 4° ARM, RIGHT 1 1/4-48 SPLINE, 8.20 LONG
11	2	3111-038X038-RT	ROD END, 3/8-24 RIGHT x 3/8 BORE, MALE, TEFLON, CM6T
12	2	3111-038X038-LT	ROD END, 3/8-24 LEFT x 3/8 BORE, MALE, TEFLON, CML6T
13	2	1086	ADJUSTER, 3.0 x 3/8-24, ANTI-ROLL BAR
14	2	3102-038-24RC	JAM NUT, 3/8-24 RIGHT, CLEAR ZINC
15	2	3102-038-24LY	JAM NUT, 3/8-24 LEFT, YELLOW ZINC
16	4	3101-038-24C	LOCKNUT, 3/8-24, GRADE 5, NYLON INSERT, CLEAR ZINC
17	2	3140-1216-008	SLEEVE, $\varnothing$ 1/2 x .384 x 1/4
18	2	3109-038-S-2-Y	AIRCRAFT WASHER 3/8 x .062 THICK

DESCRIPTION		<b>ARB, gBAR, gLINK, SPLINED, <math>\varnothing</math> 3/4, 1960-65 FALCON, COMET, RANCHERO</b>	
<i>Chris Alston's</i> <b>CHASSISWORKS INC.</b> 8661 YOUNGER CREEK DRIVE SACRAMENTO, CA 95828 (916) 388-0288 FAX 388-0295		PART NO.	<b>5806-Q10</b>
		10/17/22	DWG: 915806-Q10

# PARTS LIST

Prior to beginning installation use the following parts lists to verify that you have received all components required for installation.

## Splined-End Anti-Roll Bar - 300-0137

Qty	Part Number	Description
1	5071	Anti-roll bar 3/4" diameter, 1-1/4" 48 spline with 1" ball pivot ends

## Mounts and Hardware - 300-0220

Qty	Part Number	Description
1	1465-L	Billet anti-roll bar arm 1-1/4" 48-spline, 4-degree, driver side
1	1465-R	Billet anti-roll bar arm 1-1/4" 48-spline, 4-degree, passenger side
2	3701	Preload adjuster assembly
2	90300-0220.12	Hardware bag 1
2	90300-0220.22	Hardware bag 2

## Hardware Bag-1 - 90300-0220.12

2	1262	Lock ring 1-7/8-20
6	3100-038F1.50Y	Bolt 3/8-24 x 1-1/2 hex head Grade 8
2	3108-038L-C	Lock washer 3/8 regular
2	3157-038F-C	Fender washer 3/8 x 1-1/2 OD

## Hardware Bag-2 - 90300-0220.22

2	1086	Adjuster rod 3/8-24 x 3"
4	3101-038-24C	Locknut 3/8-24 nylon insert
2	3102-038-24LY	Jam nut 3/8-24 LH Grade 5, yellow zinc
2	3102-038-24RC	Jam nut 3/8-24 RH Grade 5, clear zinc
2	3103-038C1.75C	Allen head 3/8-16 x 1-3/4 socket head cap screw
2	3108-038H-C	Lock washer 3/8 high collar
2	3109-038-S-2-Y	Aircraft washer 3/8 small OD
2	3111-038X038-LT	Rod end 3/8-24 LH x 3/8 bore
2	3111-038X038-RT	Rod end 3/8-24 RH x 3/8 bore
2	3140-1216-008	Sleeve 3/8" ID x 1/4" long

# INSTRUCTIONS

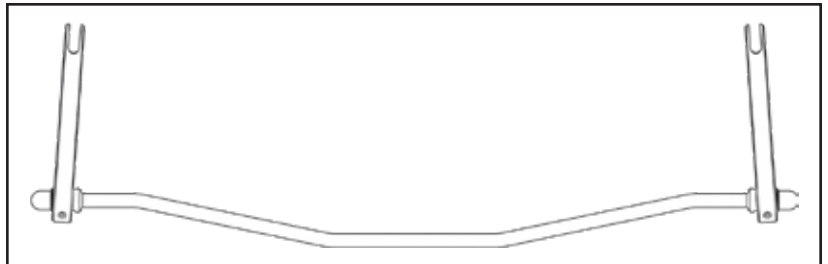
## Anti-Roll-Bar Assembly

The anti-roll bar must be assembled to correctly position the bend for maximum center section clearance.

1. Place billet arms and anti-roll bar on a flat working surface. The arm's bolt counter-bores must be facing down.
2. Orient the anti-roll bar with the bend pointing the opposite direction that arms extend.
3. Rotate the bar approximately 45 degrees, so that the bent section is raised and insert a splined-end into the first arm until the splines are slightly engaged.
4. With the inserted arm laying flat on the table, raise the opposite end of the bar and slightly engage the splines. Make sure the arms are indexed the same so that they are flat to each other.



*Billet arms have a 4-degree offset and must angle toward each other.*



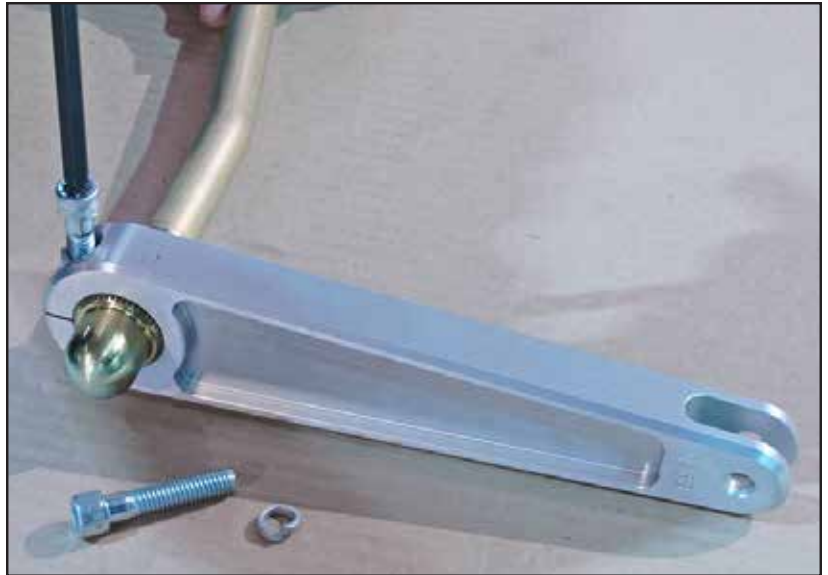
5. When correctly indexed, the top of the bend should be approximately 2-1/2" to 2-5/8" from the working surface. If the bend height is outside this range, disengage splines, rotate bar, reassemble, and then measure again.

NOTE: Assembly orientation is upside down from actual installation orientation.



- Secure arms with 3/8-16 x 1-3/4" socket head cap screws and high-collar lock washers. Use a small amount of Loctite™ on the threads.

NOTE: This pinch-bolt configuration applies pressure against the spline to remove all play.



### Preload Adjuster Assembly

- Make sure 1-7/8" female threads in lower axle brackets are clear before beginning assembly. Use a wire-tooth brush in a rotating motion to clean the bores. The fine thread is easily seized up by debris or powder-coat residue.
- Apply a small amount of Anti-Seize™ to the internal threads of the sleeves.



- The preload adjuster assemblies thread into the brackets with the bearing toward the inside.



10. Use a 1/2"-drive ratchet and extension to thread the preload adjuster assemblies into the threaded sockets until they are even with the inside edge of the socket closest to the rear end center section.

DO NOT USE IMPACT WRENCHES OR FORCEFULLY THREAD THE ASSEMBLY TOGETHER TO AVOID DAMAGING THE THREADS.



11. Place the anti-roll bar assembly between the preload adjusters with the arms toward the front of the car and the pinch-bolt heads facing up.



12. Continue to tighten both adjusters evenly until the ball end of the anti-roll bar is bottomed out against the bearing.



13. Verify that the anti-roll bar is centered. Billet arms must be equal distance from the axle brackets.
14. Tighten both preload adjusters an additional 1/4 turn. Do not overtighten. Doing so will cause the anti-roll bar to flex.



15. Thread the locking ring into the axle bracket socket, so that it is seated tight against the preload assembly. Tighten to 50 lb-ft.



16. Secure with 3/8" fender washer, lock washer, and 3/8-24 x 1-1/2" hex bolt.
17. Tighten to 35 lb-ft.
18. Repeat steps for opposite side.





## Endlink Adjuster Assembly

19. Chase the endlink threads using 3/8-24 right- and left-hand taps.



20. Thread 3/8"-24 jam nuts onto each rod end until 3/4" of threads have passed the jam nut. This will position the jam nut at approximately half travel. Yellow-zinc jam nut indicates left-hand threads.

21. Thread the endlink adjuster tube onto the rod ends. Hex end of the adjuster indicates left-hand threads. Do not force threads.



22. Attach the endlink adjuster assemblies to the billet arms. Use 3/8-24 x 1-1/2" hex bolts and locknuts provided. Torque mounting hardware to 35 lb-ft.



## Endlink Chassis Mount

*The endlink mounting tab extends from the g-Bar upper control arm chassis mount; previously welded.*

23. Raise the rearend housing to ride-height position.
24. Install the endlink using the 3/8-24 x 1-1/2" bolt, aircraft washer, spacer sleeve and locknut. The locknut is placed directly against the mounting tab.
25. Torque mounting hardware to 35 lb-ft.



26. Check for any clearance issue with the anti-roll bar throughout the suspension's range of travel. This must be done without springs installed on the shocks or without air pressure if using air-spring shocks.



Ride Height



Full Extension



Full Compression

27. Adjuster links should be in a neutral position, meaning that there is NO preload placed upon the anti-roll bar. If there is any preload present, adjuster links will be difficult to turn by hand. If necessary, adjust one of the link assemblies to a shorter length until preload is neutral.

DO NOT add preload to the chassis using adjuster links.

28. Rotate each rod end body so that it is centered within its clevis, then tighten jam nuts.

29. Verify that all mounting hardware is correctly installed and torqued to specification.



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