

# INSTALLATION GUIDE

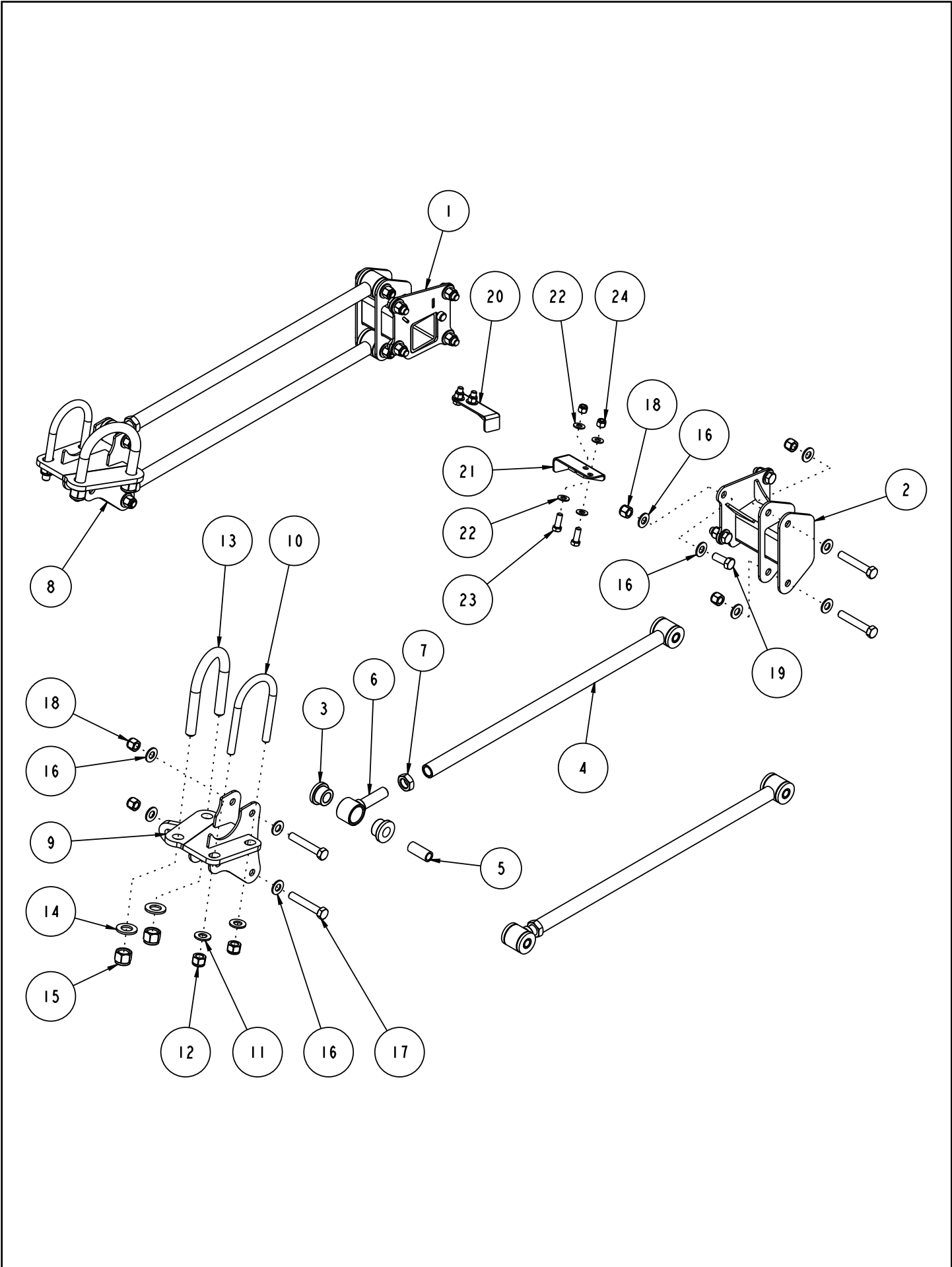


## KPC 4LBO-C31

**Bolt-On 4-Link Kit  
1963-1972 Chevrolet and GMC C10 Pickup**



**Description:** Bolt-on, urethane-bushed 4-link rear suspension for 1963-1972 Chevrolet and GMC C10 pickup . Includes bolt-on frame- and axle-brackets, adjustable-length suspension links, urethane end bushings, and mounting hardware.



ITEM	QTY	PART NO.	DESCRIPTION
1	1	7930-101	FRAME MOUNT #101, DRIVER, 4-LINK, 63-72 CHEVY C10
2	1	7930-102	FRAME MOUNT #102, PSGR, 4-LINK, 63-72 CHEVY C10
3	16	3141-2440-0.88	POLYURETHANE BUSHING 1.63 x .750 x .750
4	4	7930-011-24.70	LINK BAR WELDMENT, 24.70 OAL, 3/4-16 x 90°, 1.25 ID POLY
5	8	3140-1624-056	SLEEVE, POLY BUSHING, Ø 3/4 x .50 x 1.750
6	4	7930-003	POLY EYE WELDMENT, 3/4-16 x 1 1/4 BORE
7	4	3102-075-16RC	JAM NUT, 3/4-16 RIGHT, CLEAR ZINC
8	1	7930-105	AXLE BRACKET WELDMENT #105, DRIVER, 4-LINK, 63-72 GM C10
9	1	7930-106	AXLE BRACKET WELDMENT #105, PSGR, 4-LINK, 63-72 GM C10
10	2	3147-300.56-525	U-BOLT, AXLE TUBE, 9/16-18 x 3.00 x 5.75
11	4	3120-056S-Y	FLAT WASHER, 9/16 SAE, HARDENED
12	4	3131-056-18Y	LOCKNUT, 9/16-18, GRADE 8, NYLON INSERT, YELLOW ZINC
13	2	3147-348.75-525	U-BOLT, AXLE TUBE, 3/4-16 x 3.48 x 5.25
14	4	3120-075S-Y	FLAT WASHER, 3/4 SAE, HARDENED
15	4	3101-075-16C	LOCKNUT 3/4-16, GRADE 5, NYLON INSERT, CLEAR ZINC
16	32	3157-050S-C	WASHER, 1/2 SAE, ZINC PLATED, 1/2 ID x 1 1/16 OD x 3/32 THICK
17	8	3100-050C3.00Y	HEX BOLT, 1/2-13 x 3, GRADE 8, YELLOW ZINC
18	16	3101-050-13C	LOCKNUT 1/2-13, GRADE 5, NYLON INSERT, CLEAR ZINC
19	8	3100-050C1.25Y	HEX BOLT, 1/2-13 x 1 1/4, GRADE 8, YELLOW ZINC
20	1	7930-133	BRACKET, E-BRAKE CABLE, DRIVER, 63-72 GM PICKUP
21	1	7930-134	BRACKET, E-BRAKE CABLE, PASSENGER, 63-72 GM PICKUP
22	8	3157-038S-C	WASHER, 3/8 SAE, ZINC PLATED, 13/32 ID x 13/16 OD x 1/16 THICK,
23	4	3100-038C1.00Y	HEX BOLT, 3/8-16 x 1, GRADE 8, YELLOW ZINC
24	4	3101-038-16C	LOCKNUT 3/8-16, GRADE 5, NYLON INSERT, CLEAR ZINC

DESCRIPTION		4 LINK, BOLT-ON, 63-72 1500 GM PICKUP	
Chris Alston's CHASSISWORKS INC. 8661 YOUNGER CREEK DRIVE SACRAMENTO, CA 95828 (916) 388-0288 FAX 388-0295		PART NO.	KPC 4LBO-C31
		3/2/09	DWG: 7927-4LBO-C31

# PARTS LIST

## KPC 4LBO-C31 - Bolt-on 4-Link Suspension, '63-72 C10

Qty	Part Number	Description
4	7930-011-24.70	Link bar weldment 24.70 OAL x 3/4-16 right x 90° - 1.25 bore poly housing
1	7930-101	4-link frame mount driver side weldment 63-72 GM
1	7930-102	4-link frame mount passenger side weldment 63-72 GM
1	7930-105	4-link axle mount driver side weldment 63-72 GM
1	7930-106	4-link axle mount passenger side weldment 63-72 GM
1	7930-133	Bracket E-brake cable driver side 63-72 GM
1	7930-134	Bracket E-brake cable passenger side 63-72 GM

## 7926-4LBOC31 - Hardware Bag

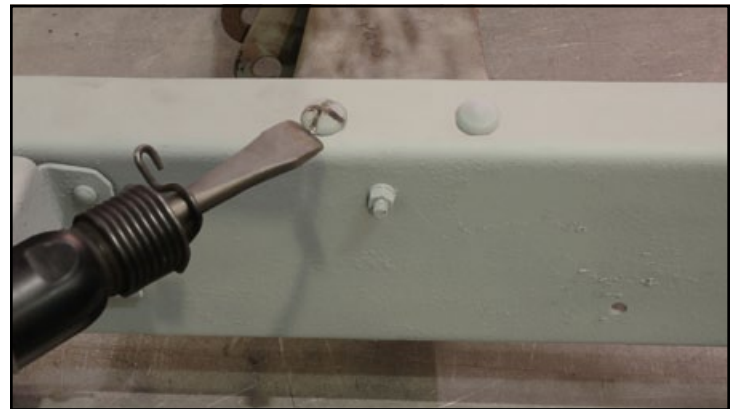
Qty	Part Number	Description
4	3100-0381.00Y	Bolt 3/8-16 x 1" hex head cap screw
8	3100-050C1.25Y	Bolt 1/2-13 x 1-1/4" hex head cap screw
8	3100-050C3.00Y	Bolt 1/2-13 x 3" hex head cap screw
4	3101-038-16C	Locknut 3/8-16 nylon insert
16	3101-050-13C	Locknut 1/2-13 nylon insert
4	3101-075-16C	Locknut 3/4-16 nylon insert
4	3102-075-16RC	Jam nut 3/4-16 RH grade 5 clear zinc
4	3120-056S-Y	Washer 9/16 hardened SAE flat
4	3120-075S-Y	Washer 3/4 hardened SAE flat
4	3131-056-18Y	Locknut 9/16-18 nylon insert grade NE8 yellow zinc
8	3140-1624-056	Sleeve 1/2 ID x 3/4 OD x 1-3/4" long
16	3141-2440-0.88	Poly bushing .75 bore x .875 OAL
2	3147-300.56-525	U-bolt 9/16-18 x 5-1/4" long for 3" ID
2	3147-348.75-525	U-bolt 3/4-16 x 5-1/4" long for 3.5" ID
2	3151-1/2OZ	Poly lube 1/2 oz. cup
8	3157-038S-C	Washer flat 3/8 SAE plated
32	3157-050S-C	Washer flat 1/2 SAE plated
4	7930-003	Poly eye 3/4-16 right weldment

# INSTRUCTIONS

1. Raise the truck and support with jack stands placed under the frame, between the cab and front of the boxed mounting brackets.
2. Remove all stock suspension components, the drive shaft, and the axle housing.
3. The crossmembers and brackets highlighted in this photo will need to be removed.



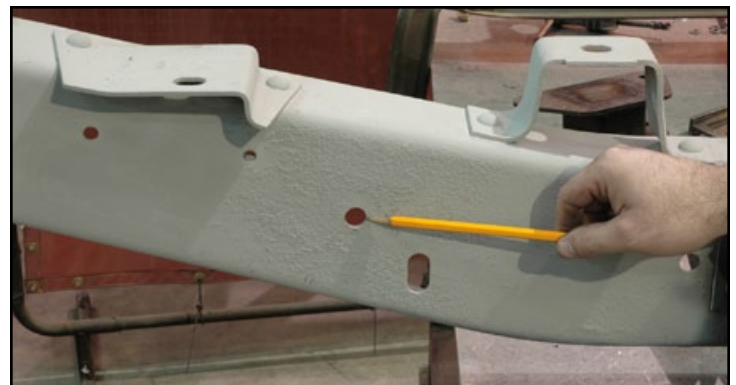
4. Use a cutoff wheel to grind an "X" into the heads of the rivets attaching the crossmember to the frame rail.
5. Once the "X" is ground deep enough, an air chisel can be used to remove the rivet head.



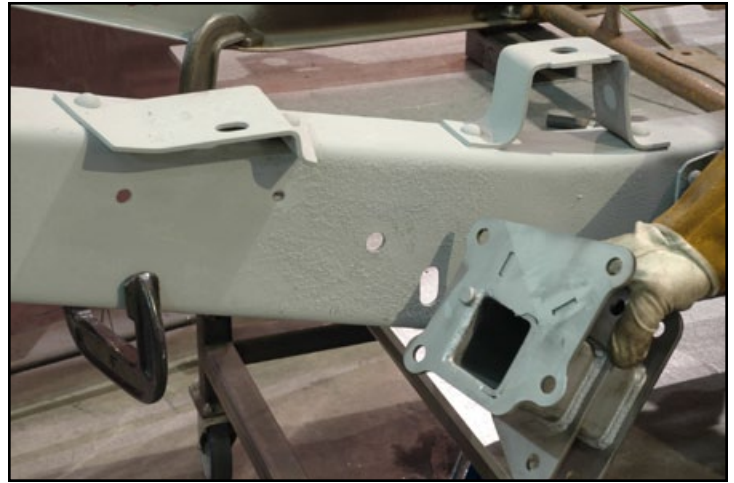
6. A round-tip air-hammer tool can be used to drive the rivets through the frame and crossmember.



7. This large hole will be used to locate the front 4-link frame mount.



8. Insert the bracket's dowel pin into the large hole in the frame rail.



9. Use a large C-clamp to hold the 4-link bracket against the frame rail.

10. A large carpenter's square should be used to square the front edge of the 4-link bracket with the bottom edge of the frame just below the cab mounting bracket.



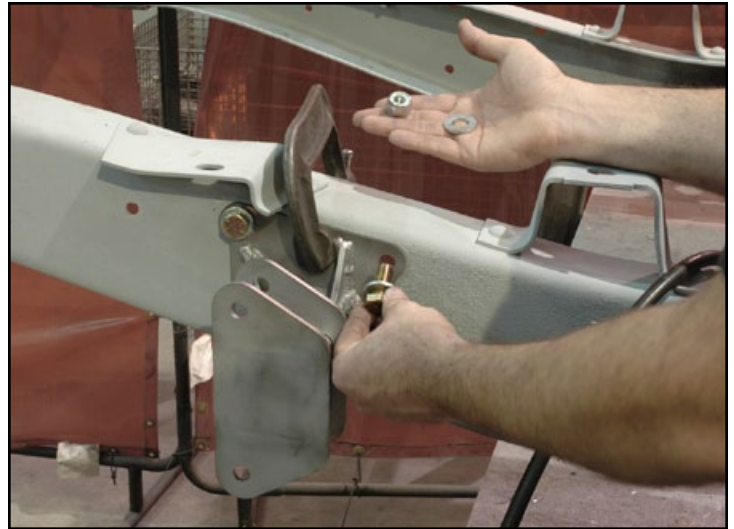
11. Place a second C-clamp on the 4-link frame bracket as shown.



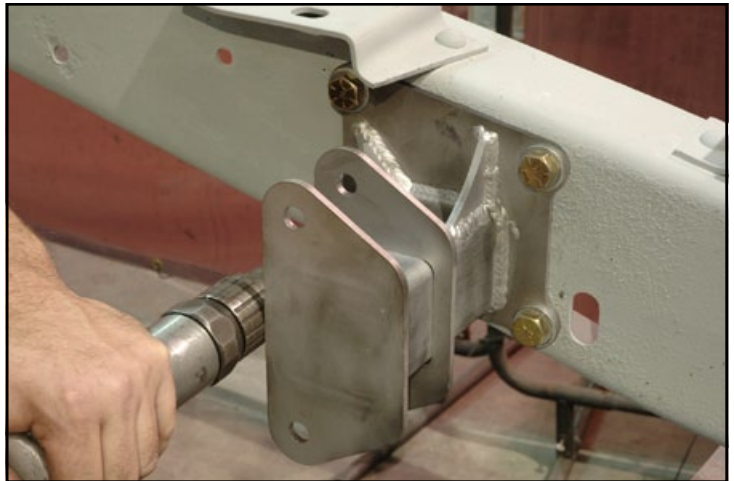
12. Using a 1/2"-diameter drill bit, drill the three holes in the frame using the 4-link frame bracket as a guide.



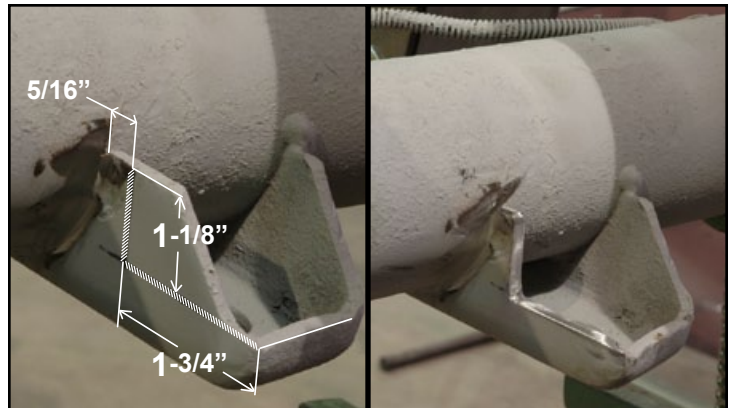
13. Use three 1/2-13 x 1-1/4" hex bolts, flat washers, and locknuts to bolt the 4-link bracket to the frame. Tighten the bolts and torque to 45 lb-ft.



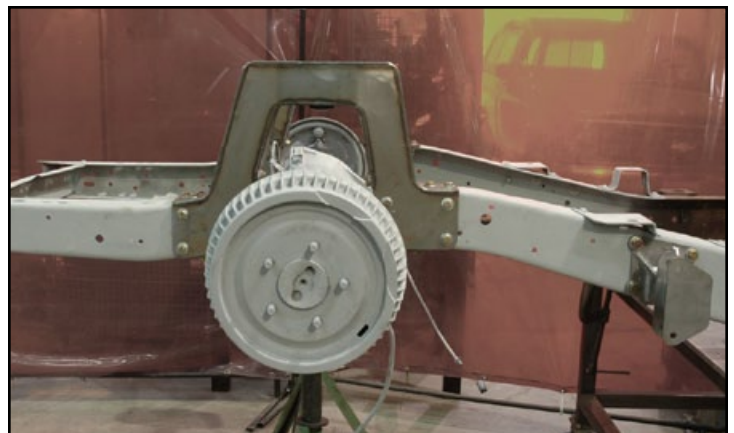
14. Remove the C-clamps and drill the fourth hole that was previously covered by the lower C-clamp.
15. Secure with a 1/2-13 x 1-1/4" hex bolt, flat washer and locknut.
16. Mount the driver side 4-link frame bracket before continuing.



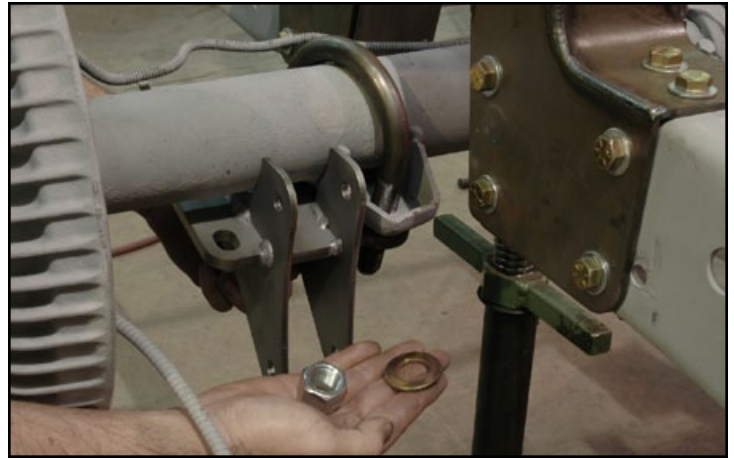
17. The control-arm mounting pad will need to be notched, using a cutoff wheel, on the front side of the axle tube. The notch is 1-3/4" long from the front edge of the pad, 1-1/8" down from the top edge, and must be parallel to the bottom of the pad.
18. Grind the OEM weld smooth where it meets the axle tube, so that the KP axle bracket can seat properly.



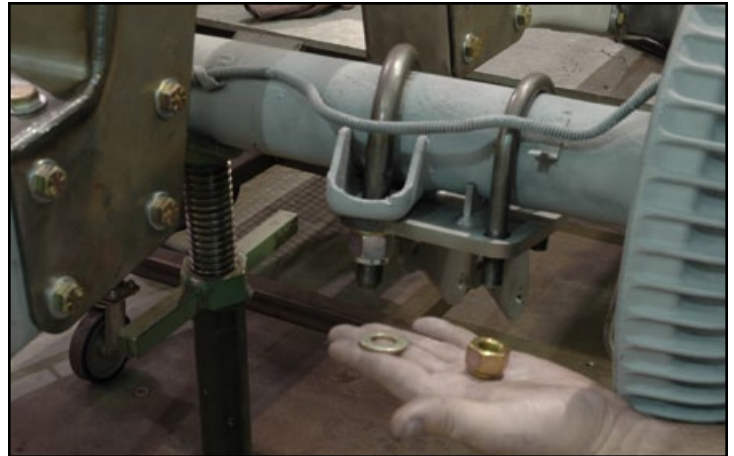
19. Position the axle housing on jack stands with the top of the axle tube just above the bottom of the frame rail and centered in the frame notch. This is the approximate ride height of the suspension.



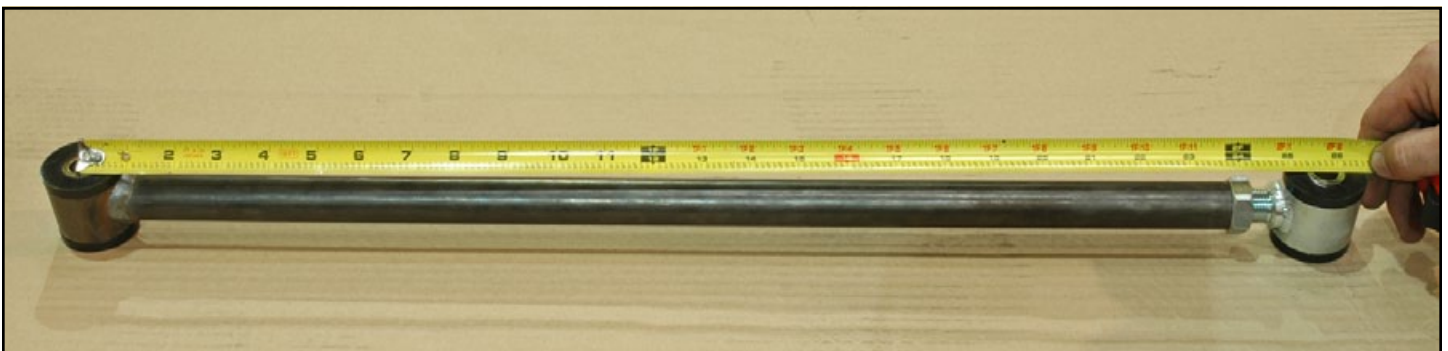
20. Place the 3/4" U-bolt over the axle tube and through mounting pad holes. Slide the passenger-side 4-link bracket over the U-bolt.
21. Secure the bracket using the 3/4-16 locknuts and hardened flat washers.



22. Slide the 9/16" U-bolt over the axle tube and through axle-bracket holes.
23. Secure the bracket using the 9/16-18 locknuts and hardened flat washers.
24. Tighten the U-bolts evenly until the bracket is tight against the axle tube.
25. Repeat this for the driver-side axle bracket.
26. Insert two poly bushings into each 4-link eye.
27. Apply poly lube to the inside of the poly bushings and outside of the steel sleeves.

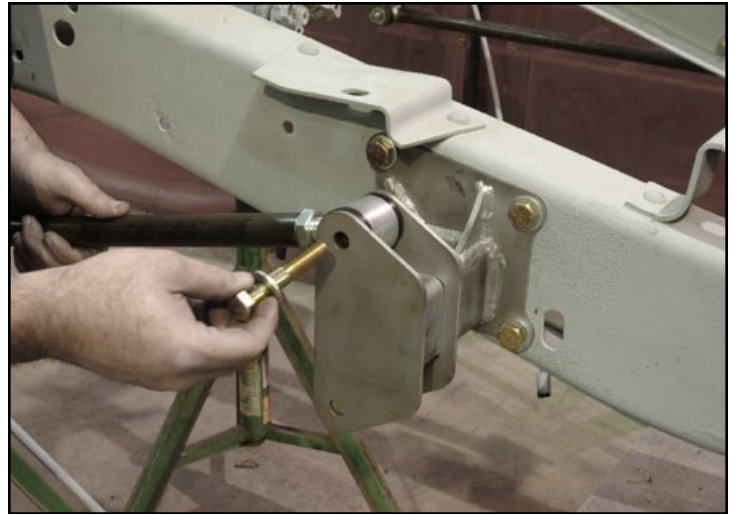


28. Press the steel sleeves into the poly bushings until they are centered in the eyes.
29. Thread the 3/4-16 jam nuts onto the threaded eyes until there are 4-5 threads remaining between the jam nut and the shoulder.
30. Make sure the threads are free from debris or burrs; chase threads if necessary.
31. Apply a small amount of anti-seize to the male threads and screw it into the link bar until the jam nut contacts the tube.
32. The center-to-center length of the link bar must measure 25-3/4" before installing.

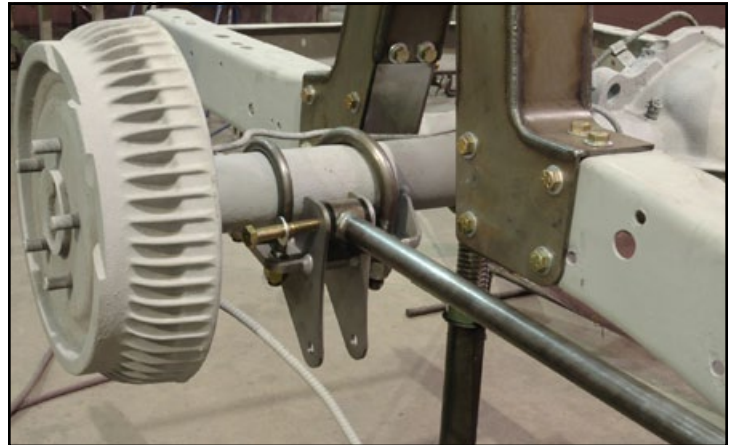




33. Place the adjustable end of the upper link bars into the frame brackets and secure with 1/2-13 x 3" hex bolts, flat washers, and locknuts.



34. Place the other end of the upper link bars into the rear brackets and secure with 1/2" hardware.



35. Repeat this procedure for lower link bars.

36. Tighten the bolts and torque to 45 lb-ft.

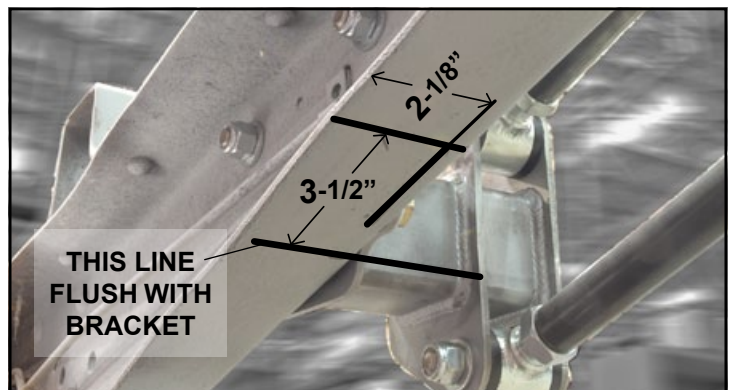
37. This completes the 4-link installation.



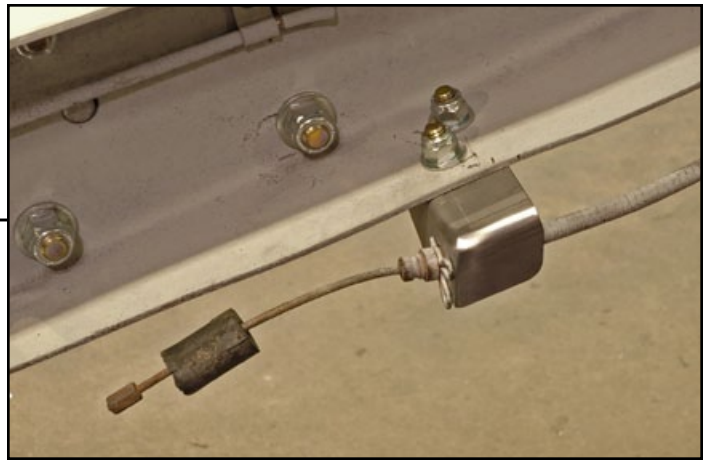
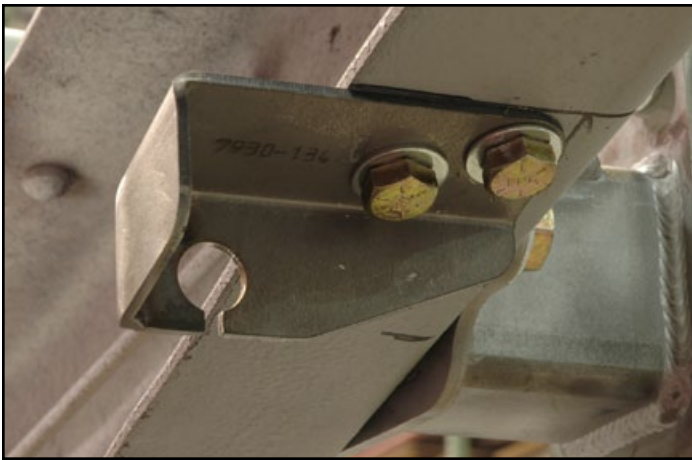
38. The emergency brake cable brackets will be installed next. Make a mark even with the 4-link frame bracket and parallel to the frame rail.

39. Mark 3-1/2" toward the rear from the reference line.

40. Mark 2-1/8" from the inside of the frame rail. This marked corner is where the bracket will be positioned.



41. Clamp the E-brake bracket to the frame against the lines marked on the frame rail.
42. Use a 3/8"-diameter bit to drill through the frame. Use the E-brake bracket as a guide.
43. Fasten the bracket to the frame using two 3/8-16 x 1" hex bolts, flat washers, and locknuts.
44. The E-brake cable will attach to the bracket with the OEM clip. Repeat steps for the driver-side bracket.



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