

READ ALL INSTRUCTIONS COMPLETELY AND THOROUGHLY UNDERSTAND THEM BEFORE DOING ANYTHING.  
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## INSTALLATION GUIDE



### 6154 g-Machine 1" Anti-Roll Bar

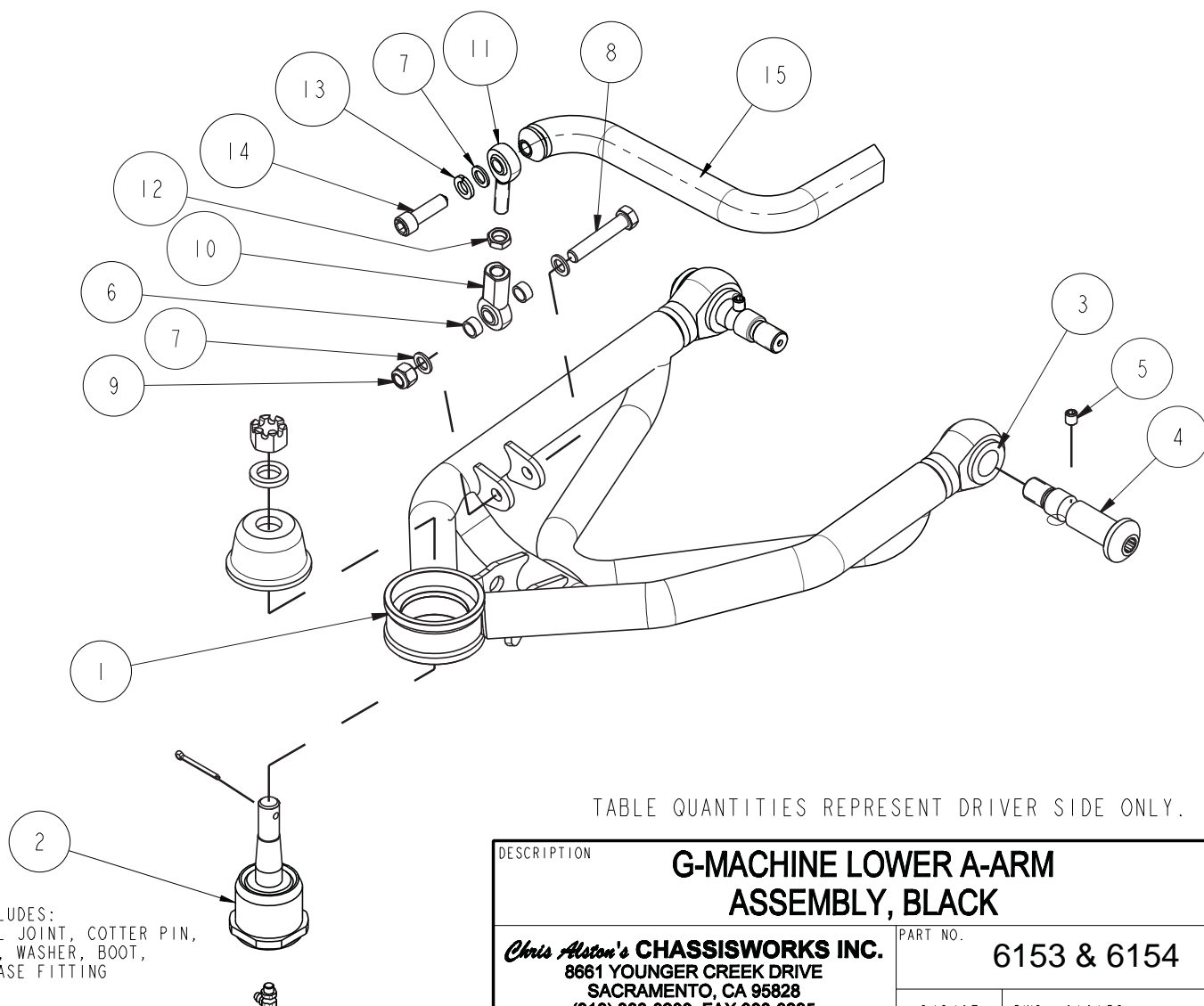


**Description:** g-Machine anti-roll bar, matte flat black with spherical end-link assemblies for Street Machine crossmember

**Note:**

1. Installation requires use of Street Machine crossmember and Street-Machine or g-Machine lower A-arms.
2. The assembly drawing (page 2) shows components for 6153 (Items 1-5) and 6154 (Items 6-15).

ITEM	QTY	PART NO.	DESCRIPTION
1	1	5060	G-MACHINE LOWER A-ARM DRIVERS, MILD STEEL, PLAIN
2	1	3304	FA395 BALL JOINT CHRYSLER SCREW IN
3	4	3333	PLASTIC BUSHING
4	2	1652	PIVOT STUD STAINLESS STEEL .75 X 2.50 X 5/8-18 THREAD
5	2	3106-31C00.38S	OVAL POINT SET SCREW, 5/16-18 x 3/8, STAINLESS
6	2	3140-1216-08	SLEEVE, Ø1/2 x .384 x 1/4
7	3	3109-038-S-2-Y	AIRCRAFT WASHER, 3/8 x .062 THICK
8	1	3100-038F2.00Y	HEX BOLT, 3/8-24 x 2, GRADE 8, YELLOW ZINC
9	1	3101-038-24C	LOCKNUT, 3/8-24, GRADE 8, NYLON INSERT, CLEAR ZINC
10	1	3127-038X038-RT	ROD END 3/8 x 3/8 BORE RT FEMALE, CF6
11	1	3111-038X038-RT	ROD END 3/8 x 3/8 BORE 4130 RT MALE, CM6
12	1	3102-038-24RC	JAM NUT, 3/8-24 RIGHT, CLEAR ZINC
13	1	3108-038L-C	LOCKWASHER, 3/8 MEDIUM, PLATED
14	1	3103-038F1.25C	SOCKET HEAD CAP SCREW, GRADE 8, 3/8-24 x 1 1/4, CLEAR ZINC
15	1	5050-XX	1 1/4" FRONT SWAY BAR ASSEMBLY FOR G/M A-ARM CROSSMEMBER



# PARTS LIST

Qty	Part Number	Description
1	305X	Hardware Box g-Machine 1" Anti-roll Bar
1	3058-XX	g-Machine 1" Anti-roll Bar

## OPTION: Street-Machine Lower A-Arm

3055 - Stem-Mount Hardware

Qty	Part Number	Description
2	1406-2	Anti-roll Bar Bushing Housing
2	3150-D-1.00-B	Urethane Bushing for 1" Anti-roll Bar
4	2042	End-link Grommet Washer, 1-1/4 OD
4	3101-038-16C	Locknut 3/8-16 Nylon Insert, Clear Zinc
4	3103-038C2.50C	Allen Head 3/8-16 x 2-1/2 Socket Head Cap Screw
2	3103-038F1.25C	Allen Head 3/8-24 x 1-1/4 Socket Head Cap Screw
2	3103-038F3.00C	Allen Head 3/8-24 x 3 Socket Head Cap Screw
4	3108-038L-C	Lock Washer 3/8 Regular
2	3109-038-S-2-Y	Aircraft Washer 3/8 Small OD
2	3127-038X038-RT	Rod End Female 3/8 RH x 3/8 Bore
2	3140-1224-024	Sleeve 3/8 ID x 3/4 OD x 3/4
2	3144-25-28-0	Grease zerk fitting, straight, 1/4-28 tapered thread
1	3151-5ML	Silicone Grease Packet
4	3153-38.70-37-B	Stem-mount poly bushing 3/8 bore x .70 nipple

## OPTION: g-Machine A-Arm

3057 - Rod-End-Mount Hardware

Qty	Part Number	Description
2	1406-2	Anti-roll Bar Bushing Housing
2	3150-D-1.00-B	Urethane Bushing for 1" Anti-roll Bar
2	3100-038F2.00Y	Bolt 3/8-24 x 2" Hex Cap Screw
4	3101-038-16C	Locknut 3/8-16 Nylon Insert, Clear Zinc
2	3101-038-24C	Locknut 3/8-24 Nylon Insert, Zinc Plated
2	3102-038-24RC	Jam Nut 3/8-24 RH Grade 5, Clear Zinc
4	3103-038C2.50C	Allen Head 3/8-16 x 2-1/2 Socket Head Cap Screw
2	3103-038F1.25C	Allen Head 3/8-24 x 1-1/4 Socket Head Cap Screw
2	3108-038L-C	Lock Washer 3/8 Regular
6	3109-038-S-2-Y	Aircraft Washer 3/8 Small OD
2	3111-038X038-RT	Rod End Male 3/8 RH x 3/8 Bore
2	3127-038X038-RT	Rod End Female 3/8 RH x 3/8 Bore
4	3140-1216-008	Sleeve 3/8 ID x 1/2 OD x 1/4
2	3144-25-28-0	Grease zerk fitting, straight, 1/4-28 tapered thread
1	3151-5ML	Silicone Grease Packet

# INSTRUCTIONS

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

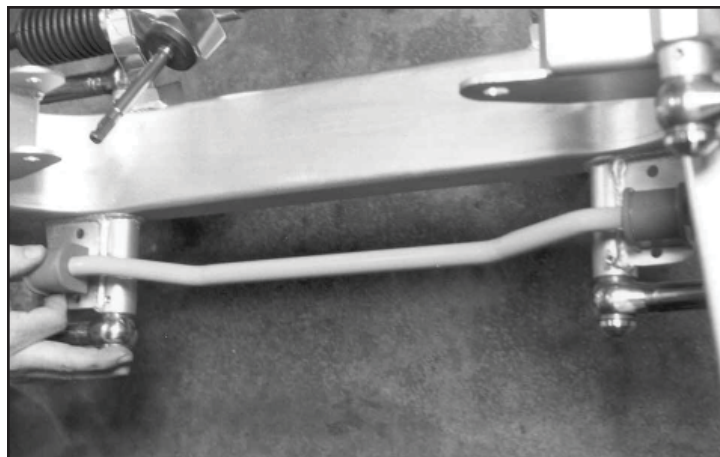
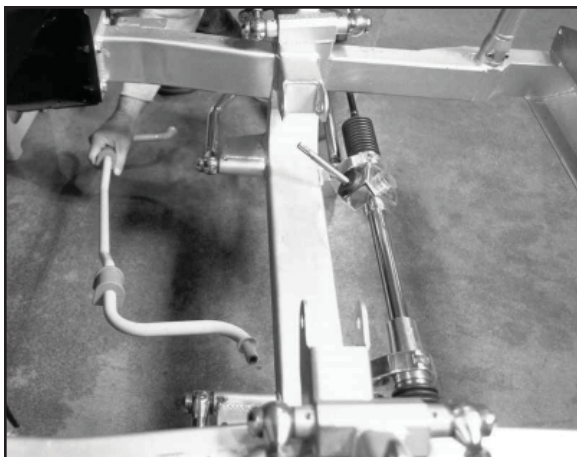
1. Use the supplied silicone grease to coat all sides of the urethane bushing that contact a metal surface. Failure to properly grease the bushing may lead to squeaking and shortened service life. A thin screwdriver can be used to smear silicone grease around the inside of the bushing. Take extra care not to get in unwanted areas.



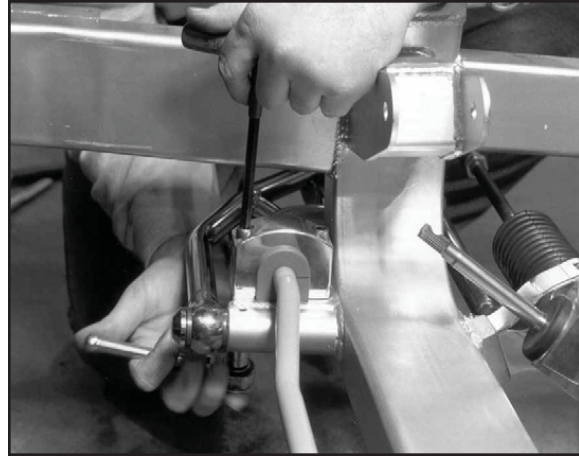
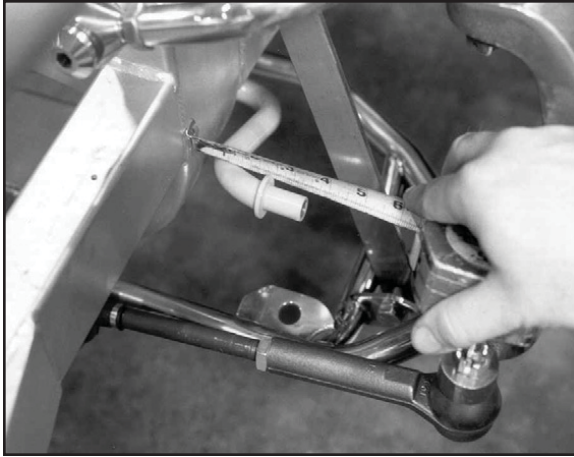
2. Use the handle end of the balljoint wrench to pry bushings open and slip over the anti-roll bar.



3. With both bushings on the bar, raise the anti-roll bar into position from underneath the car and set onto the welded mounting pads. Center the bushings between the mounting holes on each pad.



4. Center the anti-roll bar in relation to the frame by measuring from the side of the frame to the end of the bar. Measurements for both driver and passenger sides must be equal.
5. Slide the billet aluminum cap over the bushing and secure with 3/8-16 x 2-1/2" socket head cap screws and locknuts.
6. Screw grease zerks into threaded holes of aluminum bushing housings, and then lubricate with standard grease gun.



### **OPTION: Stem-Mount Lower A-Arm**

#### **Install Endlink Assembly**

6. Place a 3/8" lockwasher onto the 1-1/4"-long socket head allen, followed by 3/8" aircraft washer.
7. Insert the allen screw through the female rod end bearing and screw into the anti-roll bar.
8. Tighten to 35 lb-ft.
9. Repeat procedure for opposite end link.
10. Place a 3/8" lockwasher onto the 3"-long socket head, followed by the large grommet washer.
11. Apply silicone grease to the bushing on all contact surfaces before placing onto the allen screw. Nipple end of bushing must point away from bolt head and washers.
12. Insert the allen screw through the lower-arm mounting tab.
13. Apply silicone grease to the second bushing and place over the screw threads with the nipple end towards the A-arm, followed by a large grommer washer, and finally the spacer sleeve.
14. Apply Loctite™ to the socket allen threads and screw into the female rod end.
15. Tighten only until the bushings begin to crush.
16. After installation is complete, cycle the suspension throughout its full range of travel to check for any clearance or binding issues. Do this with the spindle turned full left, full right, and centered. The driver- and passenger-side suspension must be raised and lowered at the same time due to the anti-roll bar linking the two sides together.

### **OPTION: Rod-End-Mount Lower A-Arm**

#### **Install Adjustable Linkage** (Refer to drawing on page two.)

6. Thread 3/8-24 jam nuts onto male rod ends until there are 3/4" of threads between the jam nut and end of the shank.
7. Apply anti-seize to male rod ends, then screw into female rod ends until the jam nuts are seated.
8. Bolt rod end assembly to lower control arm, as shown in diagram on page two. Tighten to 35 lb-ft.
9. Bolt top end of rod end assembly to anti-roll bar, as shown in diagram on page two. Tighten to 35 lb-ft.
10. Repeat procedure for opposite end link.  
NOTE: Make sure there is no preload on the anti-roll bar when fitting the second side. The suspension's ride height position must be the same on both sides of the vehicle. The rod end assembly may need to be adjusted to allow the Allen bolt to thread in easily.
11. After installation is complete, cycle the suspension throughout its full range of travel to check for any clearance or binding issues. Do this with the spindle turned full left, full right, and centered. The driver- and passenger-side suspension must be raised and lowered at the same time due to the anti-roll bar linking the two sides together.

**WARRANTY NOTICE:**

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