



VAS 505-101

Spherical-Bearing Chassis Mount for Stem-Top Strut Installation Guide



NOTE: Product for use with 11/16" diameter strut stems only.

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PARTS LIST

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

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Part Number	Qty.	Description
1166	2	Bearing housing for strut chassis top mount
1268	2	Safety nut 5/8-18 stem strut
1328	2	Thrust stand .692" bore x .340" offset
2064	2	Strut top chassis mount 1.75" bore, 1/8" 4130
2065	4	Strut top mount gusset, 1/8" 4130
3117-063-18C	2	Half locknut 5/8-18 nylon insert
3395	2	Spherical bearing 1-3/8" OD x 3/4" bore
3679	2	Spirolox 1.442" OD x .043" thick

INSTRUCTIONS

Refer to your chassis drawing for details on the exact placement of the upper strut mount.

1. Insert the stepped-down shoulder of the bearing housing into the strut top mount plate until seated and hold together using a clamp. Clamp tightly, tack weld in four places, and then TIG weld completely around the bearing housing.
2. Once the assembly has cooled, press the spherical bearing into the housing until firmly seated. Do not install the spirolox at this time.
3. Temporarily install the strut to verify that the position of the upper mount is correct.
 - The body of the bearing housing must be on the strut side of the plate.
 - The thrust stand fits over the strut's piston shaft, above the upper spring seat, and is inserted into the spherical bearing.
 - The safety nut threads onto the strut stem with the shaft fitting into the bearing.
4. Following the drawing supplied with your chassis kit, position the mounting plate on the chassis 1/2" higher than specified to compensate for the bearing-assembly offset.
 - The bearing should be centered, not misaligned, with the strut at ride height.
 - The plate must be ground to properly fit the chassis' forward strut tube.
5. Tack weld the mounting plate to the chassis, and then move the strut through its full range of travel to check for binding. You may have to adjust the mount plate position to eliminate any binding.
6. Place one gusset plate along each edge of the plate. Their directions should be staggered so that one is pointing up and the opposite down. The chassis' forward strut-tube design will determine which way the gussets are staggered.
7. Once the gussets are correctly positioned, tack weld them in place and remove the strut.
8. Remove the spherical bearing from the housing before final welding the mount to the chassis. If you do not remove the bearing it will be damaged from the heat when welding.
9. Once the mount is completely cooled, you can reinstall the spherical bearing and secure it with the spirolox retaining ring.
10. The strut can now be installed. Torque the safety nut to 50 lb-ft., and then install the half locknut above the safety nut and torque to 45 lb-ft.

