

KPC CBO-C71

99-06 GM 1500 SERIES

CANTILEVER KIT



INSTALLATION INSTRUCTIONS

NOTE: You must have previously installed a KP Components Bolt on 4-link to utilize this Cantilever kit. If you are installing both kits at the same time, wait to install the bed until both kits are installed.

1. Jack the vehicle and support it with stands under the frame on all four corners. The suspension must be left hanging.
2. Remove and discard the rear factory leaf spring brackets. **Figure 1.**
3. Align the rear four holes in the cantilever brackets with the stock leaf spring bracket holes left empty in step two and temporarily install eight 7/16" x 1 1/4" bolts and eight 7/16" locking nuts to hold these brackets in place.
4. Mark or transfer, punch the forward holes using your brackets as a template. **Figure 2.**
5. Remove the Cantilever brackets and drill the holes marked in step four to 7/16".
6. Permanently install the cantilever brackets using twenty 7/16" x 1 1/4" bolts, twenty 7/16" flat washers, (placed between the frame and the nuts) and twenty 7/16" locking nuts.
7. Assemble the cantilever bars and links by installing the urethane bushings and steel sleeves as shown in **Figure 3.**
8. Attach the cantilever links to the cantilever arms using two 9/16" x 3" bolts and two 9/16" locking nuts. **Figure 4.**
9. Attach the cantilever assembly to the cantilever brackets with the two 9/16" x 4" bolts and two 9/16" locking nuts. Then attach the link to the axle brackets using two 9/16" x 3" bolts and two 9/16" locking nuts. These two bolts must be installed from the center of your vehicle outward. **Figure 5.**
10. Install the rear shocks using the supplied 1/2" x 3 1/2" bolts going through the upper cantilever bracket and secure them with the provided lock nut. Use the supplied 1/2" x 3" bolts with the 1/2" locking nuts on the bottom.

NOTE: It is important that on the lower shock mount you place the .3" thick spacer between the mount and shock eye as illustrated in Figure 6 to insure proper shock clearance. The upper shock mount only requires one washer on the outside of the shock.

11. You can now install your air bags onto the cantilever system. The shorter ends of the two threaded studs supplied with your kit must be screwed into the bags before they are installed onto the cantilever arm. **Figure 7.**
12. Now install your bed and rear bumper and your installation is complete.

99-06 GM 1500 SERIES BOLT-ON CANTILEVER INSTALLATION ILLUSTRATIONS

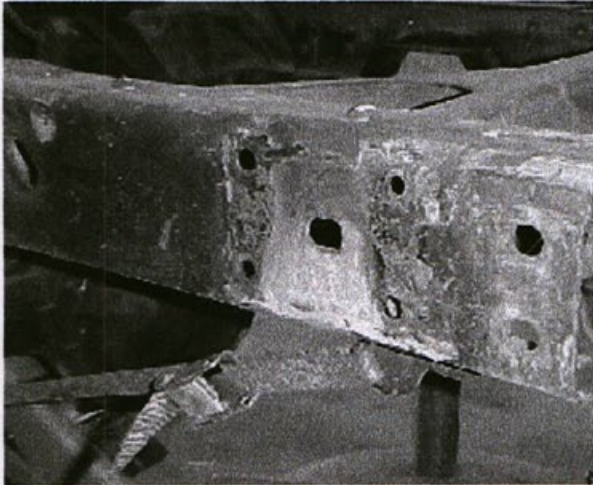


Figure 1

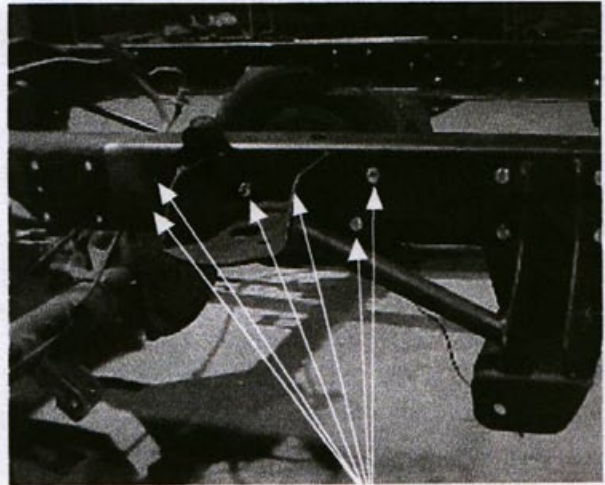
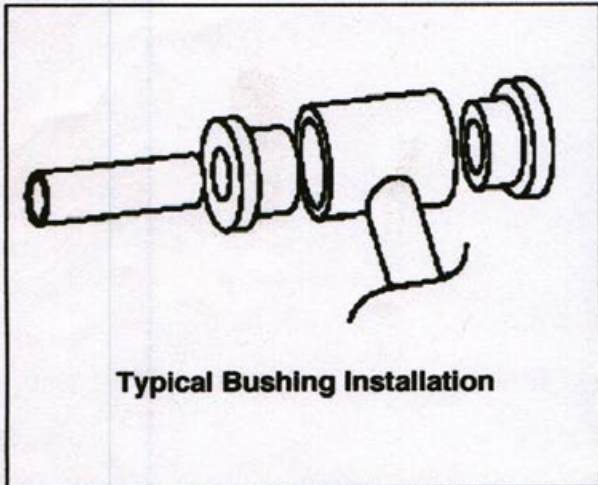


Figure 2

Mark and drill six holes
to 7/16"



Typical Bushing Installation

Figure 3



Figure 4

Install the Cantilever Link bolts from the center out

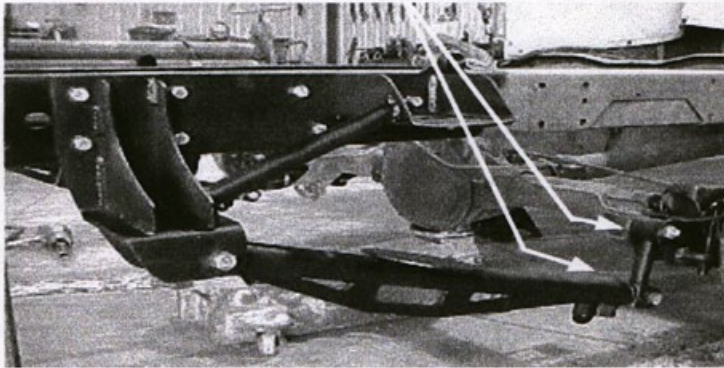


Figure 5

A single .3" thick spacer is used on the inside and a single washer on the outside.



Figure 6

Insert the bag stud with the short threads into the bag

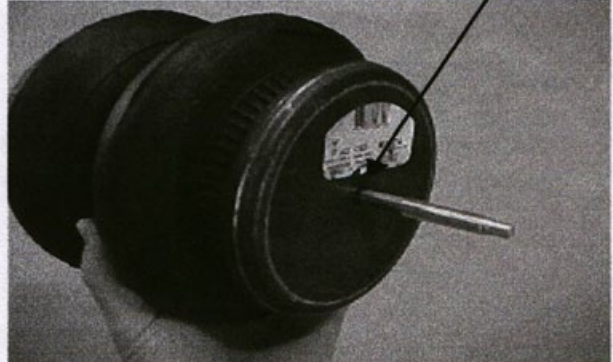
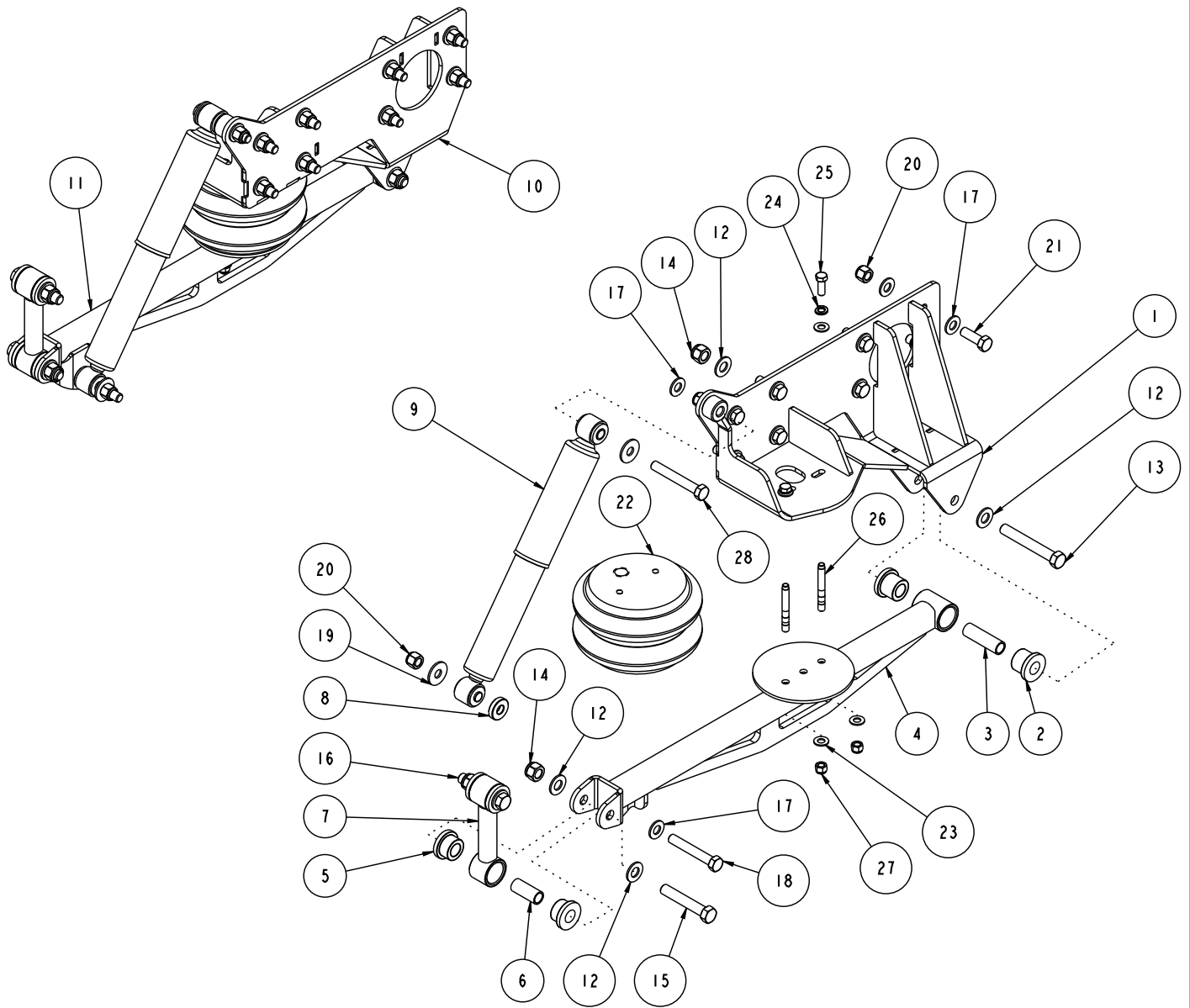


Figure 7



ITEM	QTY	PART NO.	DESCRIPTION
1	1	7931-029	FRAME BRACKET #29 WELDMENT, DRV, CANTILEVER, 99-06 GM PICKUP
2	4	3141-2440-1.19	POLYURETHANE BUSHING 1.63 x .750 x .938
3	2	3140-1824-080	SLEEVE, POLY BUSHING \varnothing 9/16 x 3/4 x 2 1/2
4	1	7931-016	CANTILEVER BAR, 26" CENTERS, DRIVER, 2.5" SHOCK MOUNT
5	8	3141-2440-0.88	POLYURETHANE BUSHING 1.63 x .750 x .750
6	4	3140-1824-056	SLEEVE, POLY BUSHING, \varnothing 9/16 x 3/4 x 1 3/4
7	2	7931-005	DOG BONE LINK WELDMENT, 20 RIM
8	2	7931-084	SPACER, \varnothing 1 1/4 OD x \varnothing 1/2 ID x .300 LONG
9	2	KPC SANS-UCR	STEEL BODY SHOCK, UNIVERSAL, F/S CANTILEVER
10	1	7931-030	FRAME BRACKET #30 WELDMENT, PSGR, CANTILEVER, 99-06 GM PICKUP
11	1	7931-017	CANTILEVER BAR, 26" CENTERS, PASSENGER, 2.5" SHOCK MOUNT
12	12	3157-056S-C	WASHER, 9/16 SAE, ZINC PLATED, 19/32 ID x 1 5/32 OD x 3/32 THICK
13	2	3100-056C4.00Y	HEX BOLT, 9/16-12 x 4, GRADE 8, YELLOW ZINC
14	6	3101-056-12C	LOCKNUT, 9/16-12, GRADE C, NYLON INSERT, CLEAR ZINC
15	2	3100-056C3.25Y	HEX BOLT, 9/16-12 x 3 1/4, GRADE 8, YELLOW ZINC
16	2	3100-056C3.00Y	HEX BOLT, 9/16-12 x 3, GRADE 8, YELLOW ZINC
17	36	3157-050S-C	WASHER, 1/2 SAE, ZINC PLATED, 1/2 ID x 1 1/16 OD x 3/32 THICK
18	2	3100-050C3.25Y	HEX BOLT, 1/2-13 x 3 1/4, GRADE 8, YELLOW ZINC
19	4	899-044.51-1.36	STEEL WASHER \varnothing 1.360 x .510 ID x .105 THICK
20	20	3101-050-13C	LOCKNUT 1/2-13, GRADE 5, NYLON INSERT, CLEAR ZINC
21	16	3100-050C1.50Y	HEX BOLT, 1/2-13 x 1 1/2, GRADE 8, YELLOW ZINC
22	2	3470-RE7	AIR BAG, 200 PSI, 7" DIAMETER
23	8	3157-038S-C	WASHER, 3/8 SAE, ZINC PLATED, 13/32 ID x 13/16 OD x 1/16 THICK,
24	4	3108-038L-C	LOCK WASHER, HELICAL SPRING \varnothing 3/8, STEEL, ZINC
25	4	3100-038C1.00Y	HEX BOLT, 3/8-16 x 1, GRADE 8, YELLOW ZINC
26	4	3163-06C-3.00B	STUD 3/8-16 x 3.0 OAL 7/16 THREAD - 1 3/8 THREAD, 1/4 NOSE
27	4	3101-038-16C	LOCKNUT 3/8-16, GRADE 5, NYLON INSERT, CLEAR ZINC
28	2	3100-050C3.50Y	HEX BOLT, 1/2-13 x 3 1/2, GRADE 8, YELLOW ZINC

DESCRIPTION		CANTILEVER SYSTEM, BOLT-ON 99-06 1500 GM PICKUP	
<i>Chris Alston's</i> CHASSISWORKS INC. 8661 YOUNGER CREEK DRIVE SACRAMENTO, CA 95828 (916) 388-0288 FAX 388-0295		PART NO. KPC CBO-C71	
		3/24/09	DWG: 7927-CBO-C71

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