

# INSTALLATION GUIDE



## KPC 4LBO-C71

**Bolt-On 4-Link Kit**

**1999-2006 Chevrolet and GMC 1500 Series Pickup**



**Description:** Bolt-on, urethane-bushed 4-link rear suspension for 1999-2006 Chevrolet and GMC 1500 series pickup . Includes bolt-on frame- and axle-brackets, adjustable-length suspension links, urethane end bushings, and mounting hardware.

# PARTS LIST

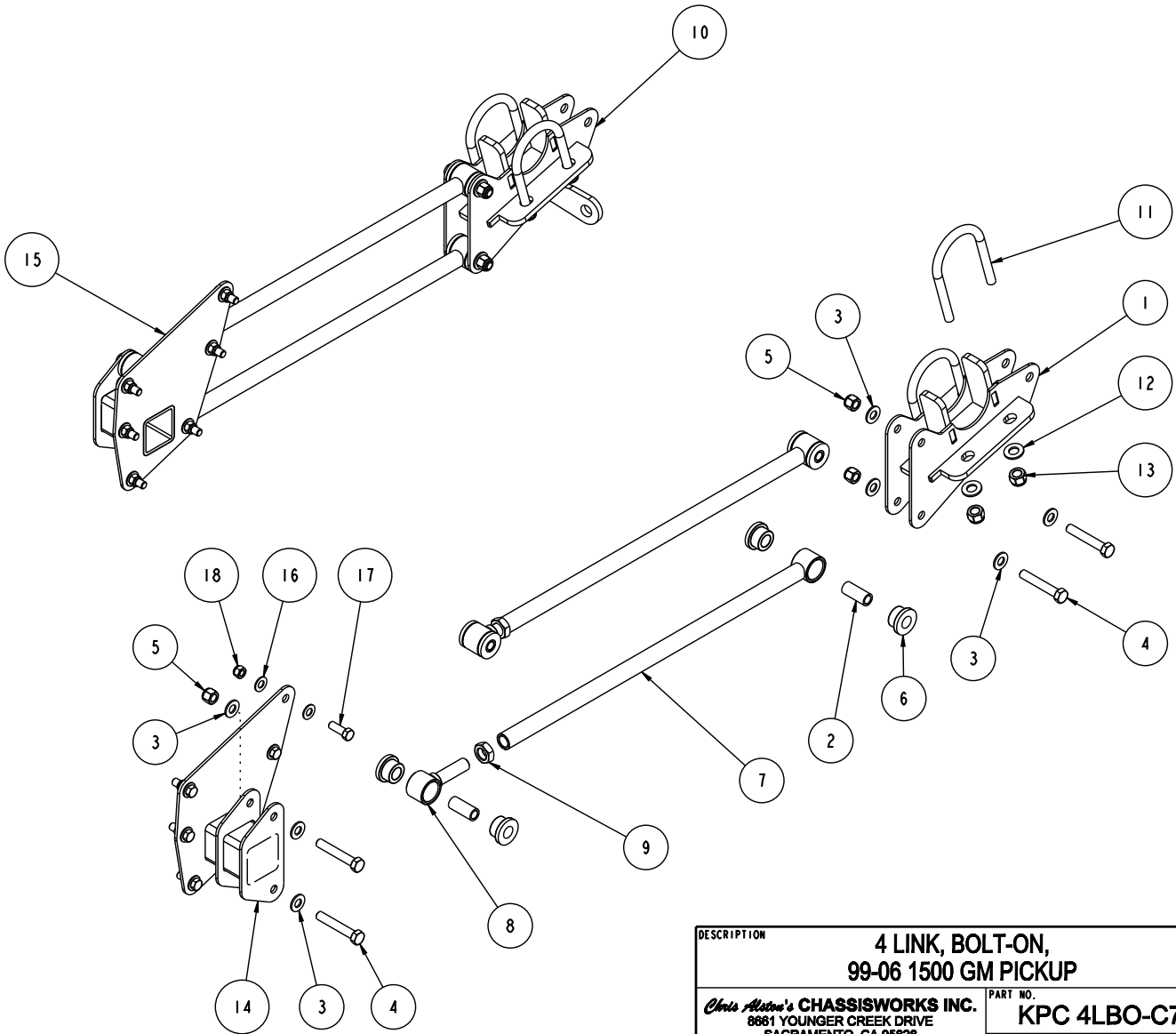
## KPC 4LBO-C71 - Bolt-on 4-Link Suspension, '99-06 GM 1500 series

Qty	Part Number	Description
4	7930-011-25.70	Link bar weldment 25.70 OAL x 3/4-16 RH x 90° - 1.25 bore poly housing
1	7930-042	4-link frame mount driver side weldment
1	7930-043	4-link frame mount passenger side weldment
1	7930-047	4- link axle mount driver side weldment
1	7930-048	4-link axle mount passenger side weldment with panhard bar tab

## 7926-4LBOC71 - Hardware Bag

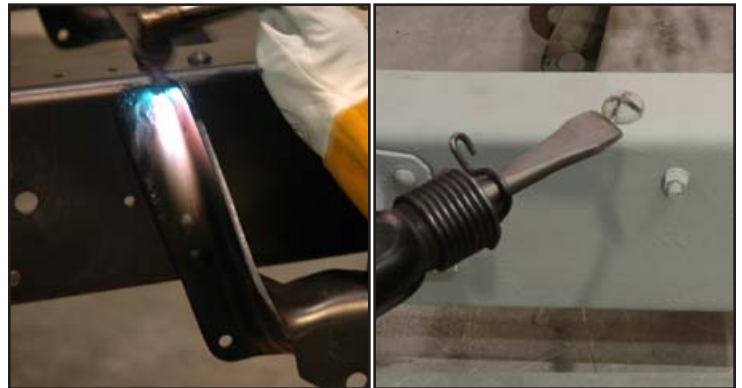
Qty	Part Number	Description
12	3100-044C1.25Y	Bolt 7/16-14 x 1-1/4" hex head cap screw
8	3100-050C3.00Y	Bolt 1/2-13 x 3" hex head cap screw
12	3101-044-14C	Locknut 7/16-14 nylon insert
8	3101-050-13C	Locknut 1/2-13 nylon insert
4	3102-075-16RC	Jam nut 3/4-16 RH Grade 5, clear zinc
8	3120-056S-Y	Washer 9/16" hardened SAE flat
8	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
4	3147-300.56-525	U-bolt 9/16-18 x 5-1/4" long for 3" round tube
2	3151-1/2OZ	Poly lube 1/2 oz. cup
24	3157-044S-C	Washer 7/16" SAE flat, plated
16	3157-050S-C	Washer 1/2" SAE flat, plated
4	7930-003	Poly eye 3/4-16 RH weldment

ITEM	QTY	PART NO.	DESCRIPTION
1	1	7930-047	AXLE MOUNT WELDMENT, 4-LINK, DRIVER, 99-06 GM PICKUP
2	8	3140-1624-056	SLEEVE, POLY BUSHING, $\varnothing 3/4$ x .50 x 1.750
3	16	3157-050S-C	WASHER, 1/2 SAE, ZINC PLATED, 1/2 ID x 1 1/16 OD x 3/32 THICK
4	8	3100-050C3.00Y	HEX BOLT, 1/2-13 x 3, GRADE 8, YELLOW ZINC
5	8	3101-050-13C	LOCKNUT 1/2-13, GRADE 5, NYLON INSERT, CLEAR ZINC
6	16	3141-2440-0.88	POLYURETHANE BUSHING 1.63 x .750 x .750
7	4	7930-011-25.70	LINK BAR WELDMENT, 25.70 OAL, 3/4-16 x 90°, 1.25 ID POLY
8	4	7930-003	POLY EYE WELDMENT, 3/4-16 x 1 1/4 BORE
9	4	3102-075-16RC	JAM NUT, 3/4-16 RIGHT, CLEAR ZINC
10	1	7930-048	AXLE MOUNT WELDMENT, 4-LINK, PASSENGER, 99-06 GM PICKUP
11	4	3147-300.56-525	U-BOLT, AXLE TUBE, 9/16-18 x 3.00 x 5.25
12	8	3120-056S-Y	FLAT WASHER, 9/16 SAE, HARDENED
13	8	3131-056-18Y	LOCKNUT, 9/16-18, GRADE 8, NYLON INSERT, YELLOW ZINC
14	1	7930-042	FRAME MOUNT WELDMENT #42, 4-LINK, DRIVER, 99-06 GM PICKUP
15	1	7930-043	FRAME MOUNT WELDMENT #43, 4-LINK, PSGR, 99-06 GM PICKUP
16	24	3157-044S-C	WASHER, 7/16 SAE, ZINC PLATED, 7/16 ID x 1 1/8 OD x 1/16 THICK
17	12	3100-044C1.25Y	HEX BOLT, 7/16-14 x 1 1/4, GRADE 8, YELLOW ZINC
18	12	3101-044-14C	LOCKNUT 7/16-14, GRADE 5 NYLON INSERT, CLEAR ZINC



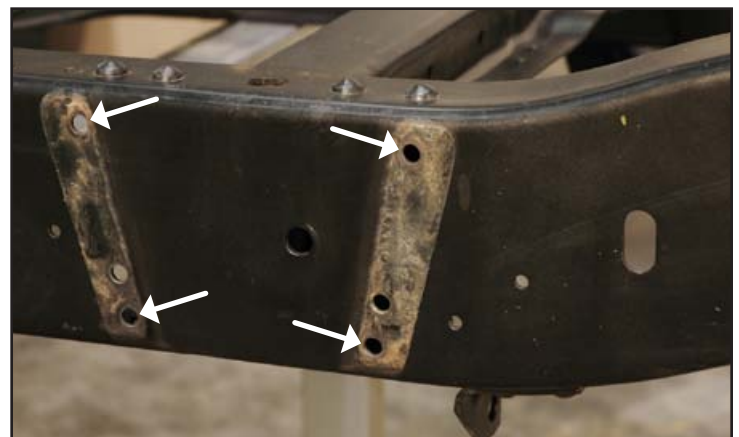
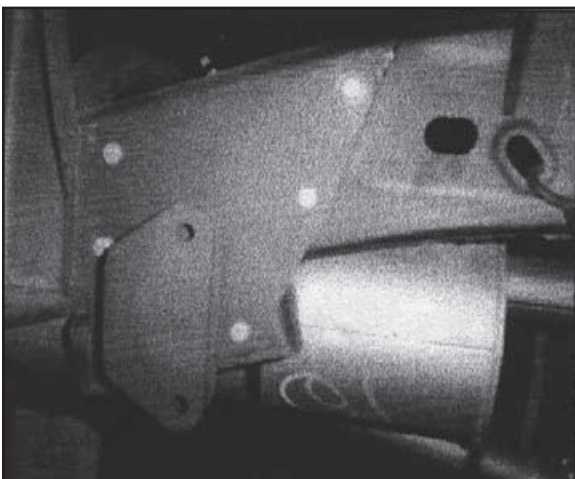
DESCRIPTION		<b>4 LINK, BOLT-ON, 99-06 1500 GM PICKUP</b>	
Chris Aston's CHASSISWORKS INC. 8861 YOUNGER CREEK DRIVE SACRAMENTO, CA 95828 (916) 388-0288 FAX 388-0295		PART NO.	<b>KPC 4LBO-C71</b>
		5/27/09	DWG: 7927-4LBO-C71

1. Raise the truck and support with jack stands placed under the frame between the cab and forward leaf-spring mounting brackets.
2. Remove the bed and the rear bumper.
3. Support the axle housing under the frame on jack stands with the suspension hanging, there should be no weight on the leaf springs.
4. Unbolt the leaf springs from the axle housing, remove all stock suspension components.
5. The front leaf-spring mounting brackets must be removed by taking out the factory rivets.
6. Remove each rivet head using a cutting torch or by using a cutoff wheel to grind a deep "X" into the heads of the rivets, and then removing the rivet head with an air chisel.
7. Once the rivet heads are removed, a round-tip air-hammer tool can be used to drive the rivets clear of the bracket and frame.
8. Bolt the driver side front 4-link bracket to the frame using 7/16-14 x 1-1/4" hex bolts, flat washers and locknuts. There should be flat washers under the bolt head and locknut. Torque to 35 lb-ft.

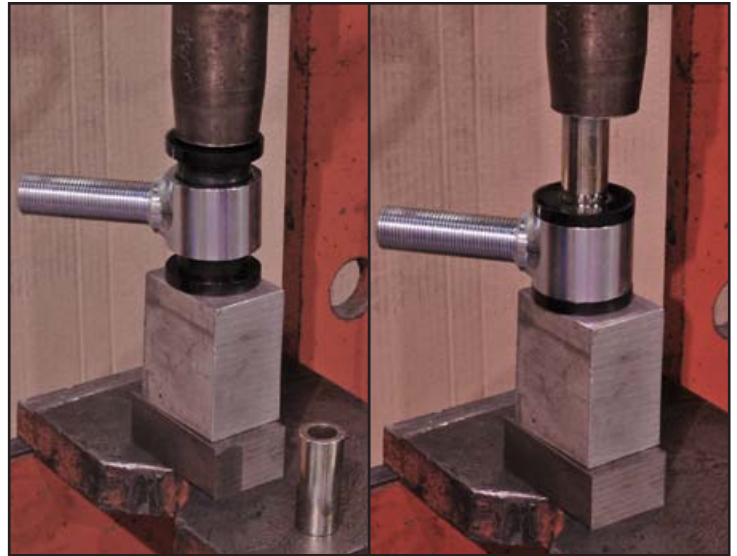


*Brackets shown may differ slightly from your exact application.*

**Instructions for installing front 4-link brackets on a crew cab truck on pages 7-8.**



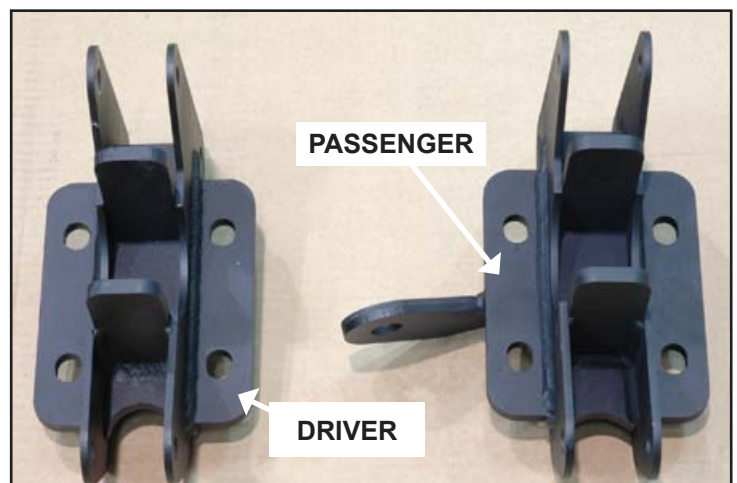
9. Insert two poly bushings into each 4-link eye.
10. Apply poly lube to the inside of the bushings and outside of the steel sleeves.
11. Press the steel sleeves into the bushings until they are centered.



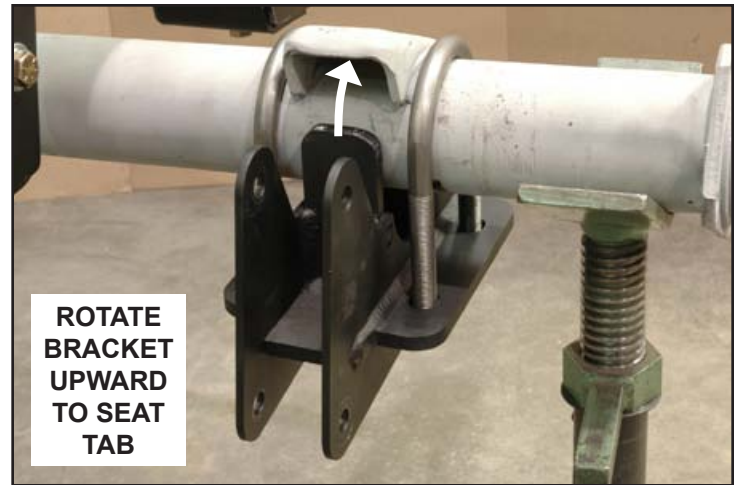
12. Use a 3/4-16 tap and die to chase the threads of the poly eyes and 4-link bars.
13. Thread the 3/4-16 jam nuts onto the threaded eyes until there are 4-5 threads remaining between the jam nut and the shoulder.
14. Apply a small amount of anti-seize to the male threads and screw it into the link bar until the jam nut contacts the tube.
15. The center-to-center length of the link bar must measure 26-3/4".



16. These are the 4-link axle brackets. The passenger-side mount has the panhard bar mounting tab.



17. Loosely bolt the 4-link bracket to the axle housing using the U-bolts, hardened washers, and locknuts.
18. Rotate the bracket to seat the large tab at the front of the bracket against the leaf-spring pad.
19. Tighten the U-bolts evenly to 60 lb-ft.
20. Install the 4-link bars with the adjustable eyes closest to the frame brackets.
21. The 1/2-13 x 3" hex bolts, flat washers, and locknuts are used on the frame and axle mounts. There should be a flat washer under each bolt head and locknut. Torque to 45 lb-ft.
22. Repeat procedure for the passenger side of the truck.



## CREW CAB INSTRUCTIONS

1. Before removing the rear suspension from the truck, measure the location of the rear axle centerline in relation back of the cab or the end of the frame rails. Record this dimension.
2. Check and record the angle of the pinion.
3. The front spring hangers will need to be cut from the frame. Carefully cut the inner and outer part of the spring hanger, do not cut into the frame.
4. Use a disc sander to clean up the frame so the 4-link front bracket can be installed.
5. Attach the 4-link axle mount plates to the axle housing with the U-bolts.
6. Set the axle housing under the frame on jack stands at the correct ride height in relation to your frame rail.
7. Place another jack stand under the pinion so the angle matches the one recorded earlier.



8. Check the front axle centerline to rear axle center line dimension recorded earlier to place the axle housing in the correct location front to rear.
9. Assemble the 4-link bars to the correct center to center dimension.
10. Attach the 4-link bars in the axle housing brackets with the adjustable end toward the front of the truck.
11. Attach the 4-link frame bracket to the link bars.
12. Swing the 4-link front frame mounts up along side the frame rails. They should be in the area where the spring hangers were removed. Clamp the front 4-link bracket to the frame. Do this on the driver and passenger side before proceeding.
13. The bracket should match the contour of the frame as shown.
14. Double check your rear axle location front to rear and pinion angle.
15. Use the 4-link bracket as a guide and drill the holes in the frame rail with a 1/2" drill bit.
16. Attach the front 4-link brackets to the frame with the 1/2-13 x 1-1/2" bolts, flat washers and locknut provided.



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