

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



5735-WELD-1.25 Custom-Fit Splined End Anti-Roll Bar



Description: Bolt-on style, splined anti-roll bar with weld-on frame mounts and billet arms.

Includes: 1-1/4" diameter tube anti-roll bar, weld-on splined ends, billet-steel arms, bearing-mount housings, and endlink assemblies. Maximum width is 40".

Notes: Welding is required for assembly of the anti-roll bar and chassis mount.

PARTS LIST

5735-WELD-1.25 - Custom-Fit Splined Anti-Roll Bar

Qty	Part Number	Description
1	7950-5735-WELD	Hardware box
1	A20.188-036.000	Tube 1-1/4 x .188 x 36", 4130

7950-5735-WELD - Hardware Box

Qty	Part Number	Description
2	1161-0.870	Splined bar end 1-1/4"-48, billet-steel
1	7952-5735	Hardware bag
1	7962-0117	Anti-roll bar left arm 1-1/4"-48 x 6.5"
1	7962-0118	Anti-roll bar right arm 1-1/4"-48 x 6.5"
2	7962-0122-125	Anti-roll bar bushing assembly 1-1/4 x 3"

7952-5735 - Hardware Bag

Qty	Part Number	Description
2	3100-038F2.25Y	Bolt 3/8-24 x 2-1/4" hex head cap screw
2	3101-038-24C	Locknut 3/8-24 nylon insert
2	3102-038-24RC	Jam nut 3/8-24 RH
2	3103-031F1.25C	Allen head 5/16-24 x 1-1/4" socket head cap screw
4	3103-038C1.25C	Allen head 3/8-16 x 1-1/4" socket head cap screw
2	3103-038F1.75C	Allen head 3/8-24 x 1-3/4" socket head cap screw
2	3108-031H-S	Lock washer 5/16" high collar
4	3108-038H-C	Lock washer 3/8" high collar
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 3/8-24 RH male x 3/8" bore
2	3127-038X038-RT	Rod end 3/8-24 RH female x 3/8" bore
8	3140-1216-008	Sleeve 3/8" ID x 1/2" OD x 1/4" long

OPTION - Frame Mounts, Weld-On

Qty	Part Number	Description
2	7962-0119	2"-wide frame mount adapters
1	7962-0154	2-1/2"-wide frame mount adapters
1	7962-0120	3"-wide frame mount adapters

OPTION - 7950-5735-SM - Endlink Hardware for Stem-Style Lower Control Arms

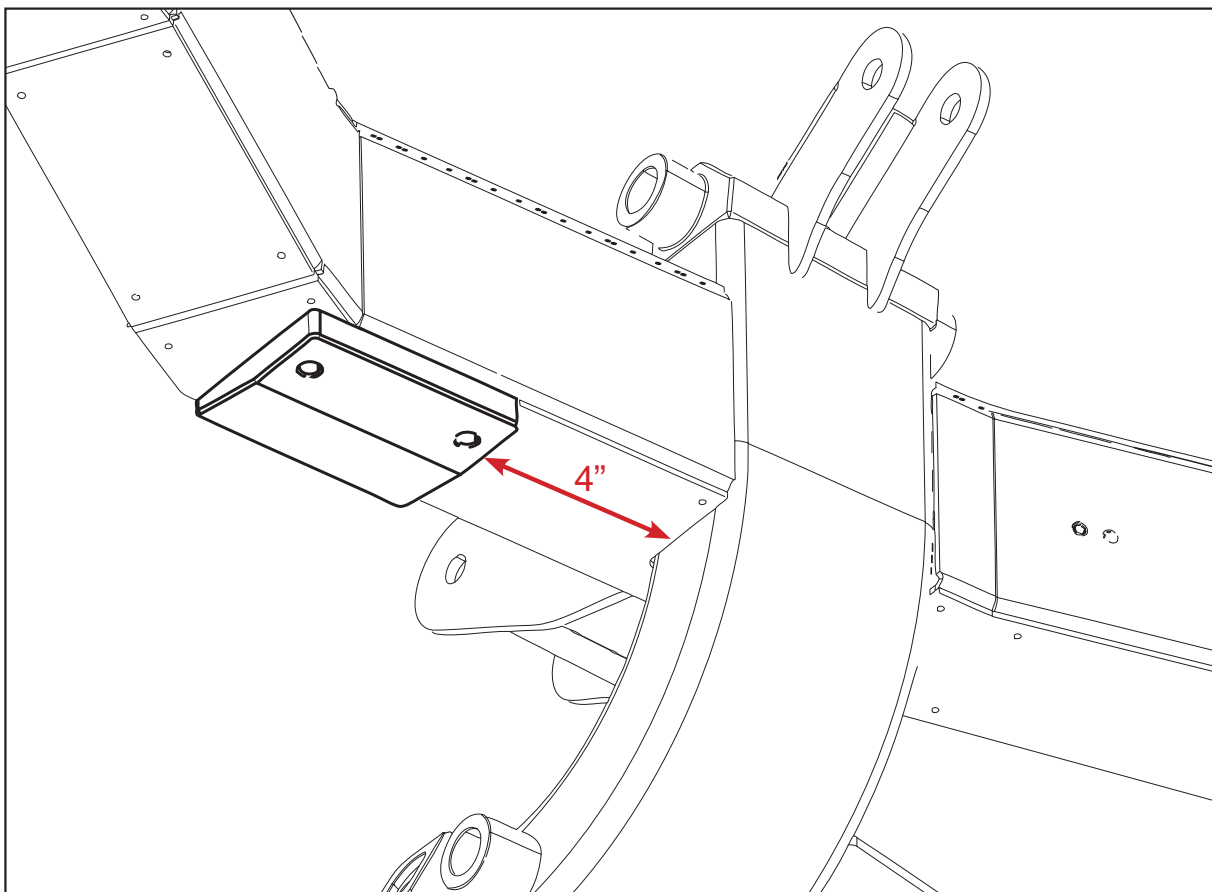
Qty	Part Number	Description
4	2042	Endlink grommet washer
2	3103-038F3.00C	Allen head 3/8-24 x 3" socket head cap screw
2	3108-038L-C	Lock washer 3/8" regular
2	3140-1224-024	Sleeve 3/8" ID x 3/4" OD x 3/4" long
1	3151-5ML	Poly lube 5ml tube
4	3153-38.70-37-B	Bushing 3/8" bore with .70" nipple

INSTRUCTIONS

Bar Mounts and Anti-Roll Bar Length

You will need to mockup assembly of the bar and mounts to determine placement of the mounts on the frame and cut length of the tube. The anti-roll bar is used as a welding jig to ensure the frame plates are correctly aligned.

1. Bolt the bearing mounts to the frame plates. Do not screw the bolts in past the backside of the frame plate so that the frame plate sits flat against the frame rail. Bushing flange must be facing the short side of the frame adapter, so that it extends past the adapters edge.
2. Slide the bushing mounts over the 1-1/4" tube; bushing flanges facing outward.
3. Bolt the billet arms to the splined bar ends and tighten the pinch bolt to remove any play.
4. Insert the splined adapter with arm attached into ends of tube.
5. Position the frame adapters flush with the outside edge of the frame rail and four inches forward of the suspension crossmember. Tack weld to the frame in multiple locations to secure their position.
6. Slide the driver side arm so that it contacts the bearing flange. A clamp can be used to hold it against the flange.
7. On the passenger side, measure the distance between the outside of the bushing flange and inside surface of the billet arm. This is the length that must be cut from the tubing to achieve the correct length. Leaving the tube too long allows unwanted side-to-side slack, but can easily be shortened. Cutting slightly too short leaves a gap between the tube and splined end that can be filled during final welding.
8. Remove the bearing mounts and anti-roll bar before completely welding the frame plates.
9. After the welds have completely cooled, pilot holes must be drilled through the bottom of the frame rail at the threaded hole locations.
10. Use a 3/8-16 tap to extend the mounting plate threads into the bottom wall of the frame rail.
11. The frame clip should then be painted before beginning installation of the anti-roll bar.

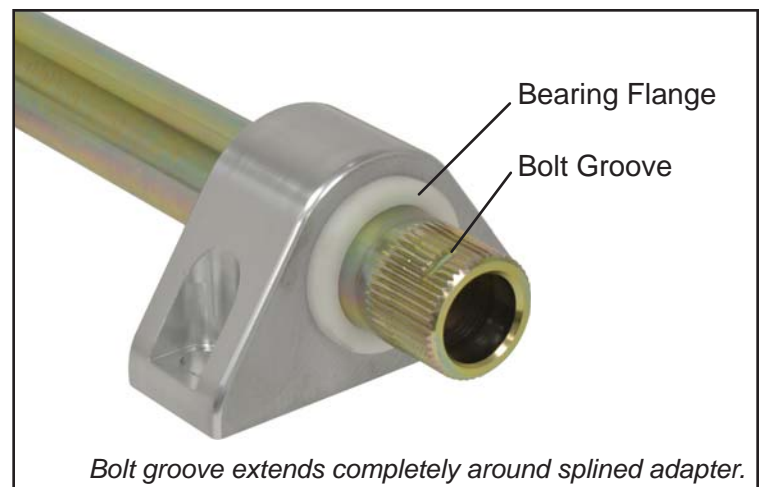


Welding The Splined Adapters

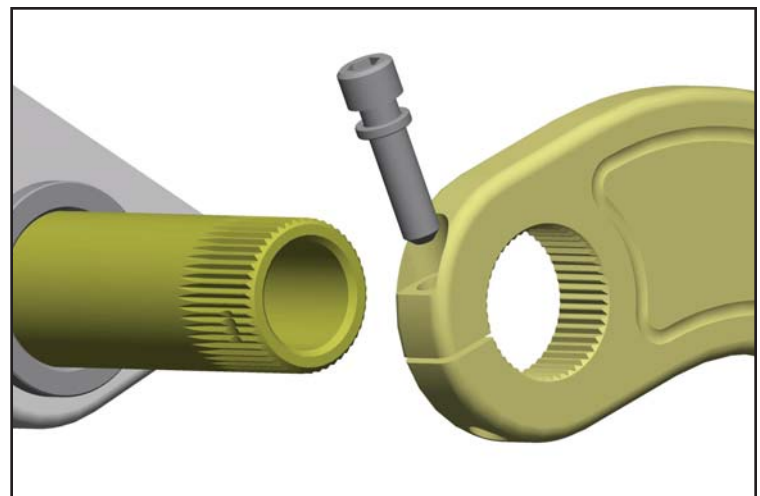
12. At each end of the 1-1/4 OD inner tube, drill three evenly spaced 5/16" holes, 1/2" from the end. These holes will be used to rosette weld the splined adapters to the center tube and hold their correct position.
13. Insert one of the splined adapters into the inner tube. Weld the holes to form rosette welds, filling the hole from the adapter to the outer surface of the tube.
14. After the welds are completely cooled, slide a billet arm onto the splined end. Secure the arm with the 5/16-18 x 1-1/2" socket head cap screw and high-collar lock washer. When tightened the bolt pinches the joint closed and removes all free play.
15. With only the single arm attached, insert the bar through both bushings on the frame then put the second arm and splined adapter into position.
16. Insert the second splined adapter with the arm attached, into the anti-roll bar tube.
17. IMPORTANT – The arms must be correctly indexed to each other while they are held against the bushing flanges, so that the splines are in time and any free play is removed before tack welding the splined end into the tube.
18. When you are confident of the bar and arm positions, place multiple tack welds to hold the splined end position in the tube.
19. Unbolt the arms and complete the rosette welds first, allow to completely cool, then neatly TIG weld the circumference of each bar end. Oversized weld beads will need to be ground flush in order to pass through the bushings.

Final Installation

20. Slide the bearing housing mount over the bar end. The bearing flange must face outward.



21. Slide the arm onto the bar. The machined groove must be aligned with the pinch bolt in the billet arm. A light lubricant can be used to allow easier assembly.
22. Use a small amount of Loctite® on the threads and tighten the pinch bolt. This pinch-bolt configuration applies pressure against the spline to remove all play.
23. Repeat procedure for opposite bar end.
24. After the second arm has been installed, place the bar on a flat surface to ensure the arms are square.



25. The anti-roll bar can now be bolted onto the clip and the end-links assembled.



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