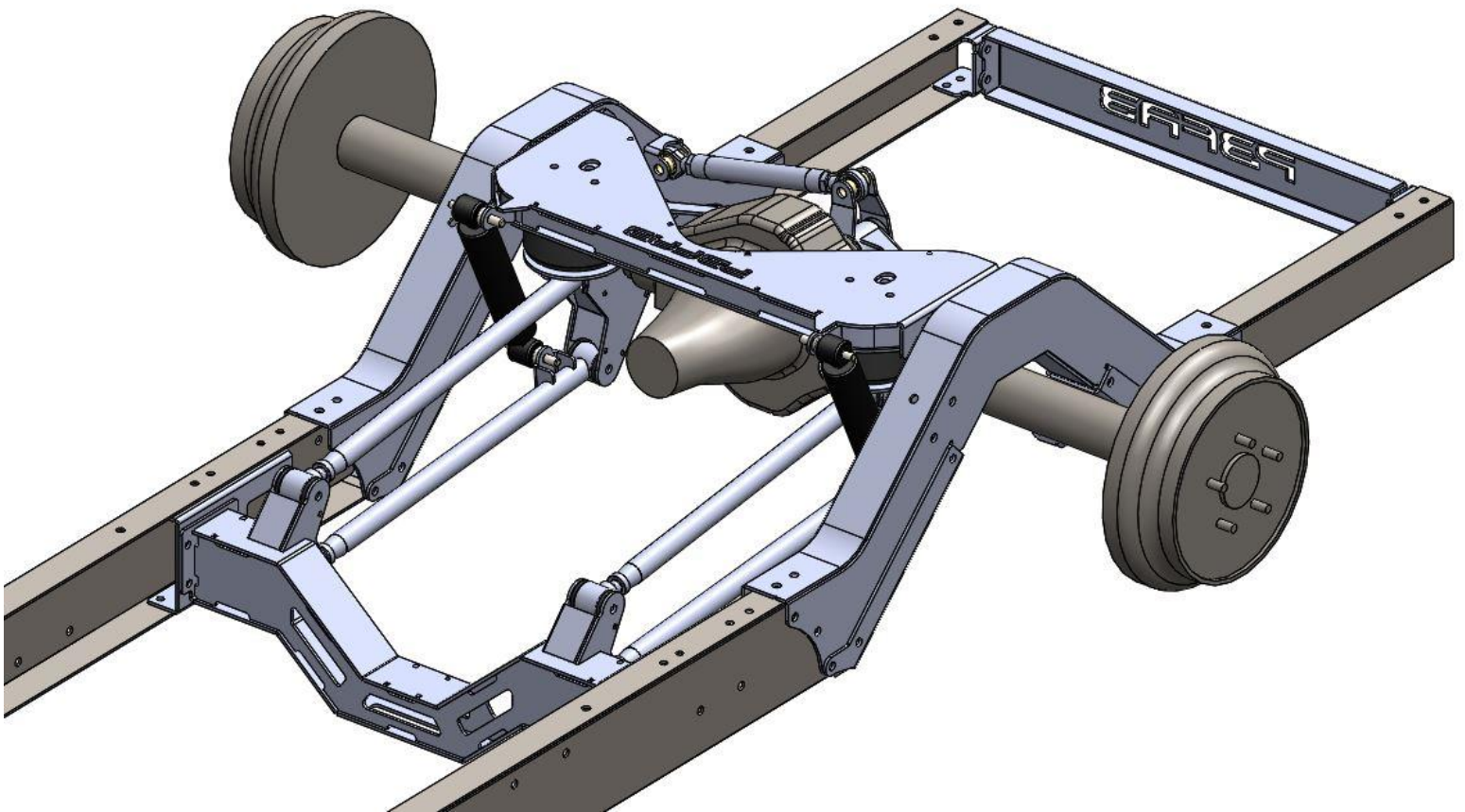


PORTERBUILT FABRICATION

DROPMEMBER REAR 55-59 LEVEL 3 INBOARD 4-LINK INSTALL GUIDE



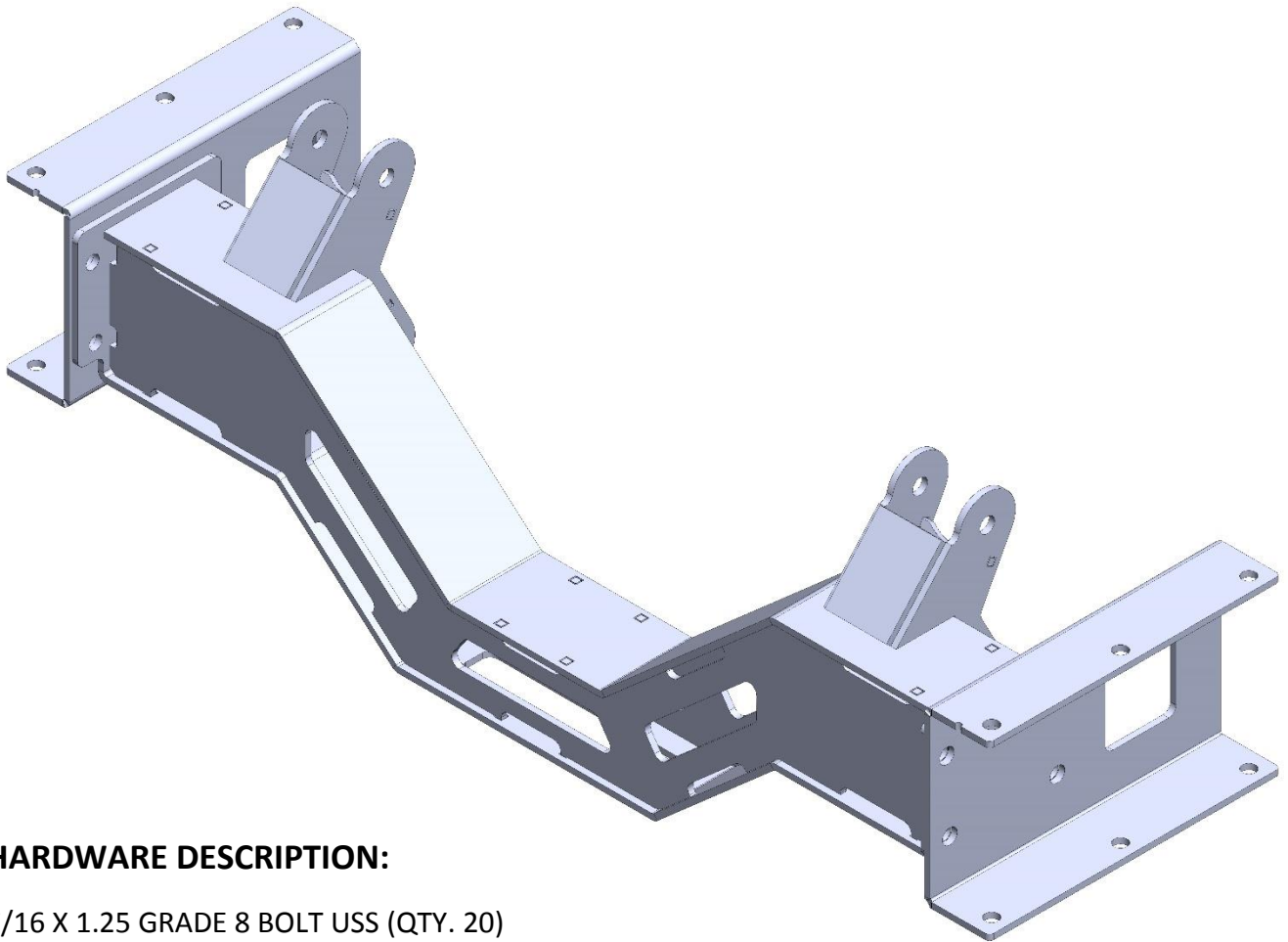
MAY 2020

SECTION 1: INDIVIDUAL COMPONENTS WITH HARDWARE DESCRIPTIONS.

***** HARDWARE BAGS WILL HAVE LABEL WITH PART NUMBER THAT CORRELATE TO EACH PART*****

PART# 4LXM5559-I4L

DESCRIPTION: 4-LINK CROSSMEMBER 55-59 INBOARD 4-LINK



HARDWARE DESCRIPTION:

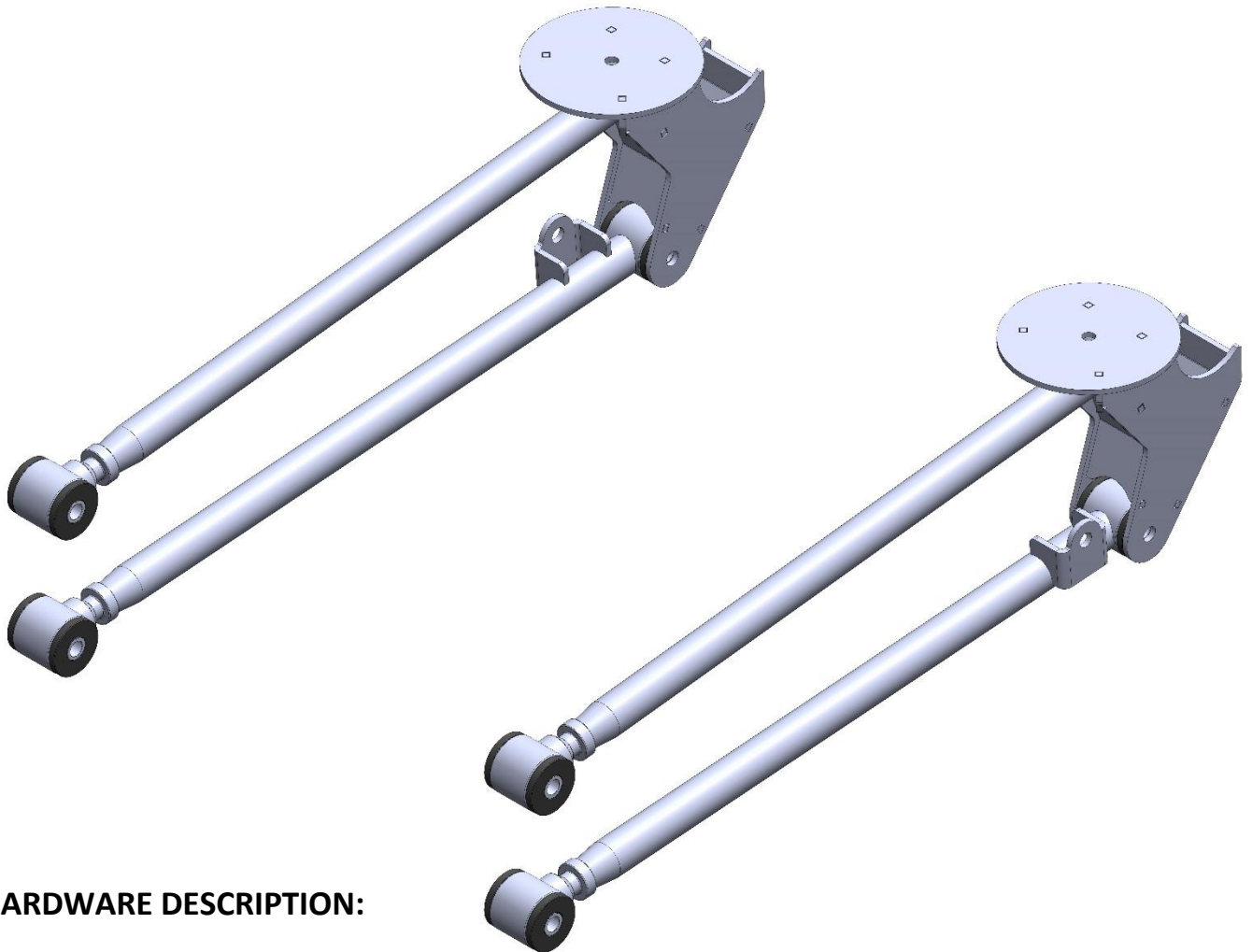
7/16 X 1.25 GRADE 8 BOLT USS (QTY. 20)

7/16 GRADE 8 NYLOC NUT (QTY. 20)

3/8 GRADE 8 FLAT WASHER (QTY. 40)

PART# 4L5559-3-I4L

DESCRIPTION: 4 LINK; 55-59 LEVEL 3, INBOARD 4-LINK



HARDWARE DESCRIPTION:

1/2 X 3.25 GRADE 8 BOLT USS (QTY. 8)

7/16 GRADE 8 WASHER USS (QTY. 16)

1/2 GRADE 8 NYLOC NUT (QTY. 8)

3/4-16 RH JAM NUT (QTY. 4)

POLY BUSHING HALF; 4-LINK SPECIFIC (QTY. 16)

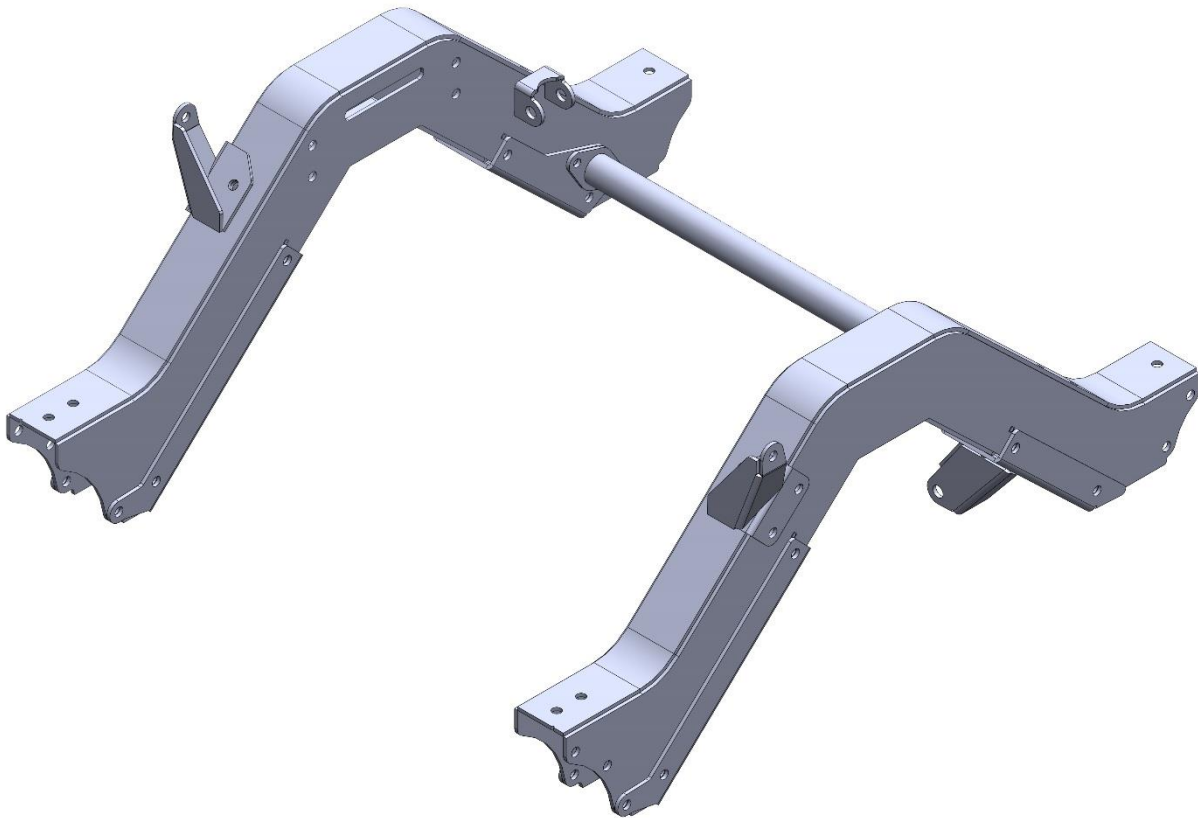
4-LINK BUSHING CRUSH TUBE (QTY. 8)

ZERK FITTINGS (QTY. 8)

PART# RN5559-3-B-STEPSIDE

DESCRIPTION: REAR NOTCH; 55-59 GM; LEVEL 3; BOLT IN; STEPSIDE SPECIFIC (SET UP FOR 28 INCH TALL TIRE)

*****NOTE: UPPER SHOCK MOUNTS SHOWN IN IMAGE ARE NOT USED IN THIS CONFIGURATION*****



HARDWARE DESCRIPTION:

7/16 X 1.25 GRADE 8 BOLT USS (QTY. 40)

7/16 X 1.5 GRADE 8 BOLT USS (QTY. 4) *****FOR REAR NOTCH CROSS MEMBER*****

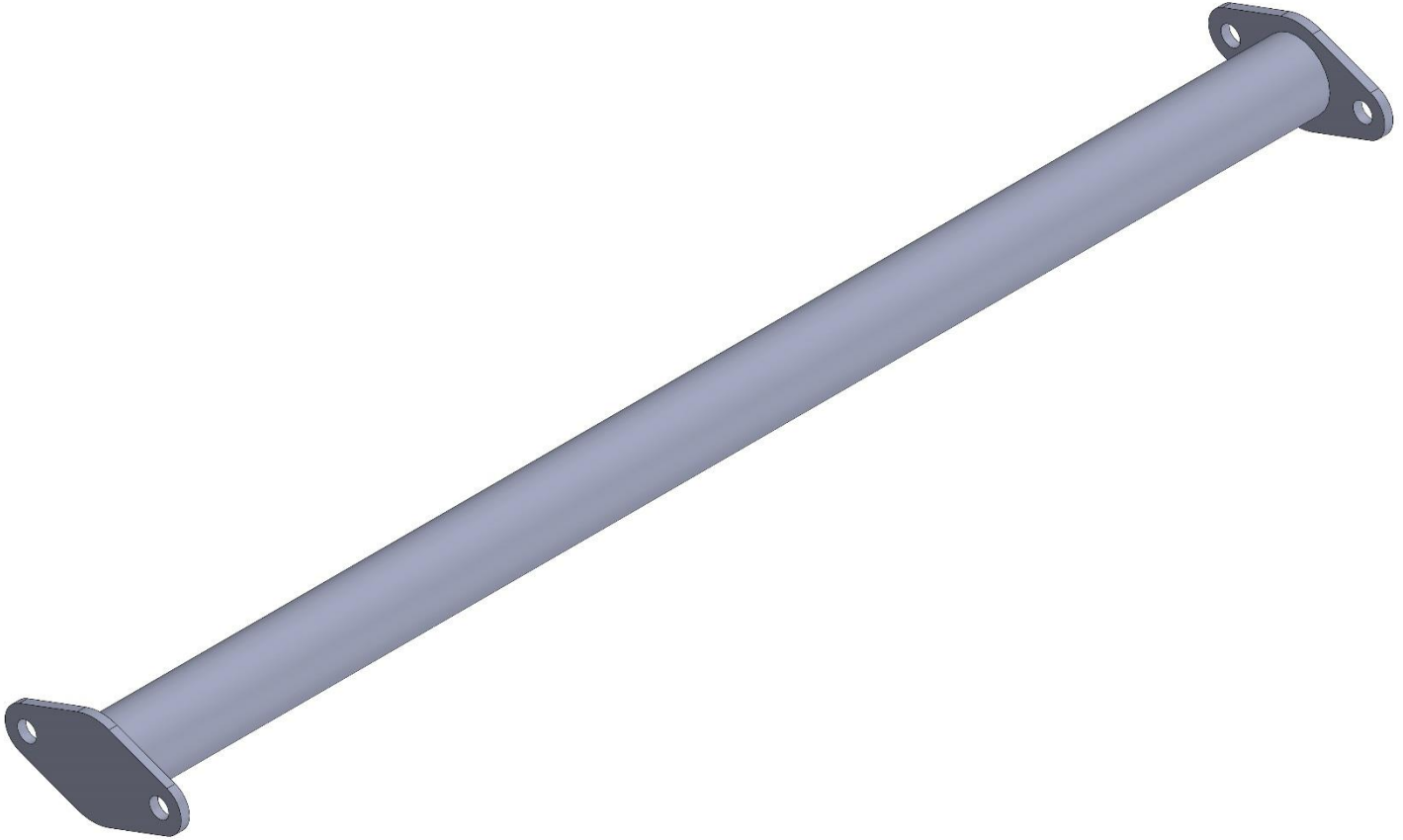
7/16 GRADE 8 NYLOC NUT USS (QTY. 30)

7/16 GRADE 8 LOCKWASHER USS (QTY. 14)

3/8 GRADE 8 FLAT WASHER USS (QTY. 84)

PART# RNXM275

DESCRIPTION: REAR NOTCH CROSS MEMBER 27 ½ INCHES OVERALL LENGTH

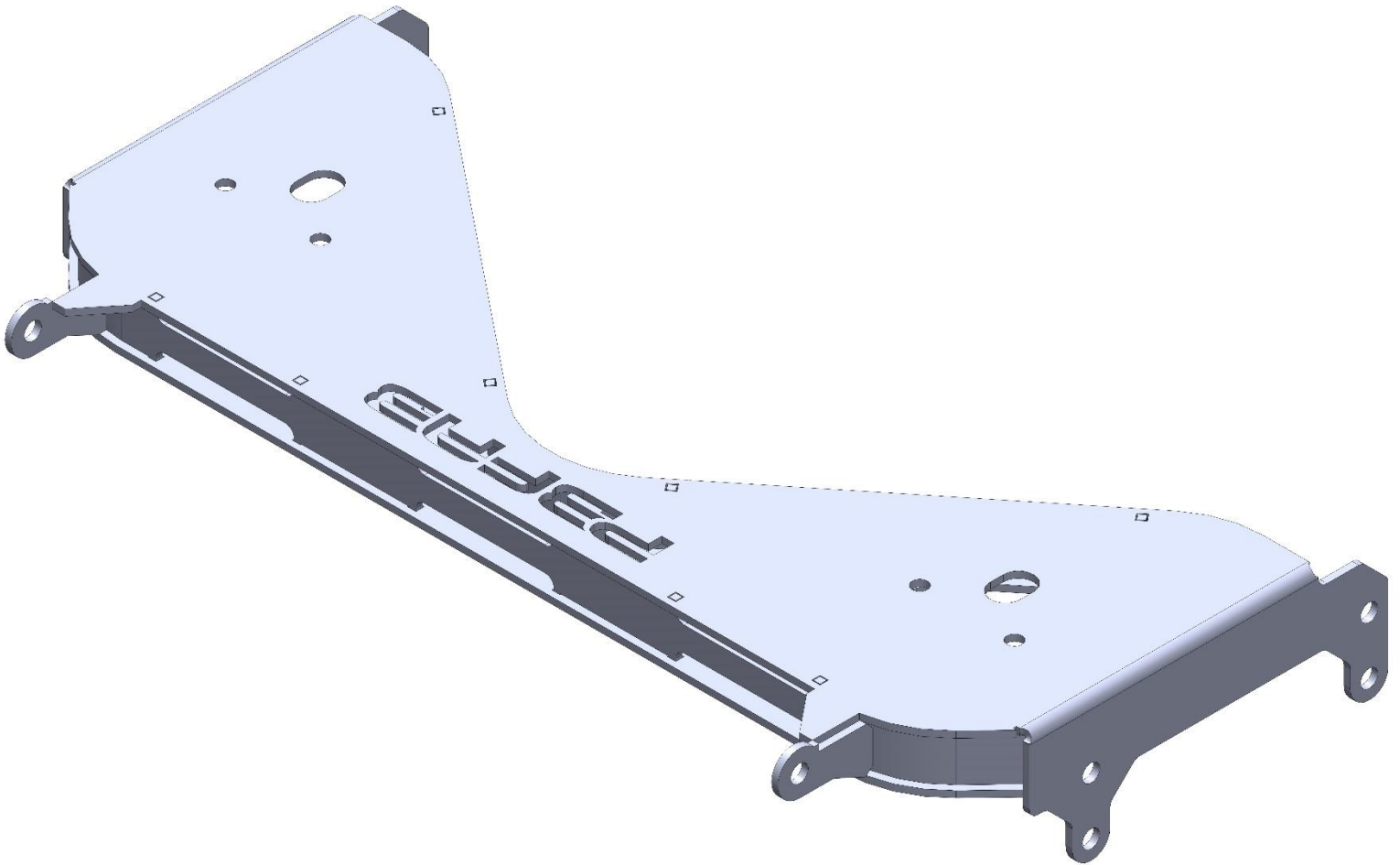


HARDWARE DESCRIPTION:

NO HARDWARE

PART# BA5559-IB-IS-I4L

DESCRIPTION: BRIDGE ASSEMBLY; 55-59 GM; INBOARD BAG; INBOARD SHOCK;
INBOARD 4-LINK



HARDWARE DESCRIPTION:

7/16 X 1.25 GRADE 8 BOLT USS (QTY. 8)

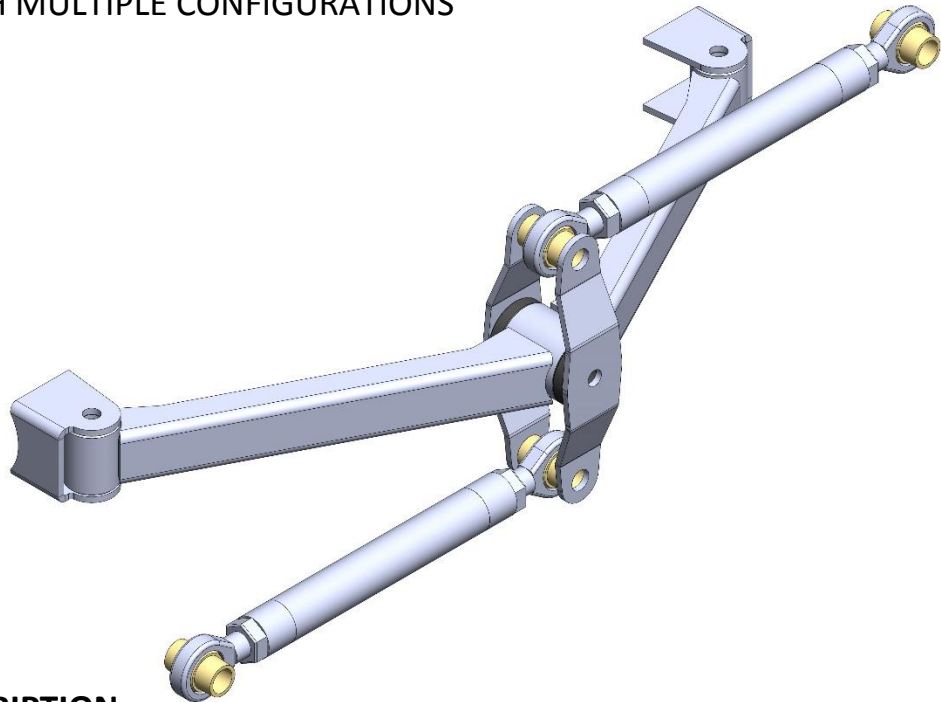
7/16 GRADE 8 LOCKWASHER USS (QTY. 8)

3/8 GRADE 8 FLAT WASHER USS (QTY. 8)

PART# WL6387

DESCRIPTION: WATTS LINK ASSEMBLY; 63-87;

COMPATIBLE WITH MULTIPLE CONFIGURATIONS



HARDWARE DESCRIPTION:

1/2 X 3.25 GRADE 8 BOLT USS (QTY. 2)

1/2 X 4 GRADE 8 BOLT USS (QTY. 1)

1/2 GRADE 8 NYLOC NUT USS (QTY. 3)

7/16 GRADE 8 FLAT WASHER USS (QTY. 6)

5/8 X 3.25 GRADE 8 BOLT USS (QTY. 4)

5/8 GRADE 8 NYLOC NUT USS (QTY. 4)

5/8 GRADE 8 FLAT WASHER SAE (QTY. 8)

PHB CONE SPACERS (CS10) (QTY. 8)

3/4 X 5/8 RH ROD END WITH JAM NUT (QTY. 2)

3/4 X 5/8 LH ROD END WITH JAM NUT (QTY. 2)

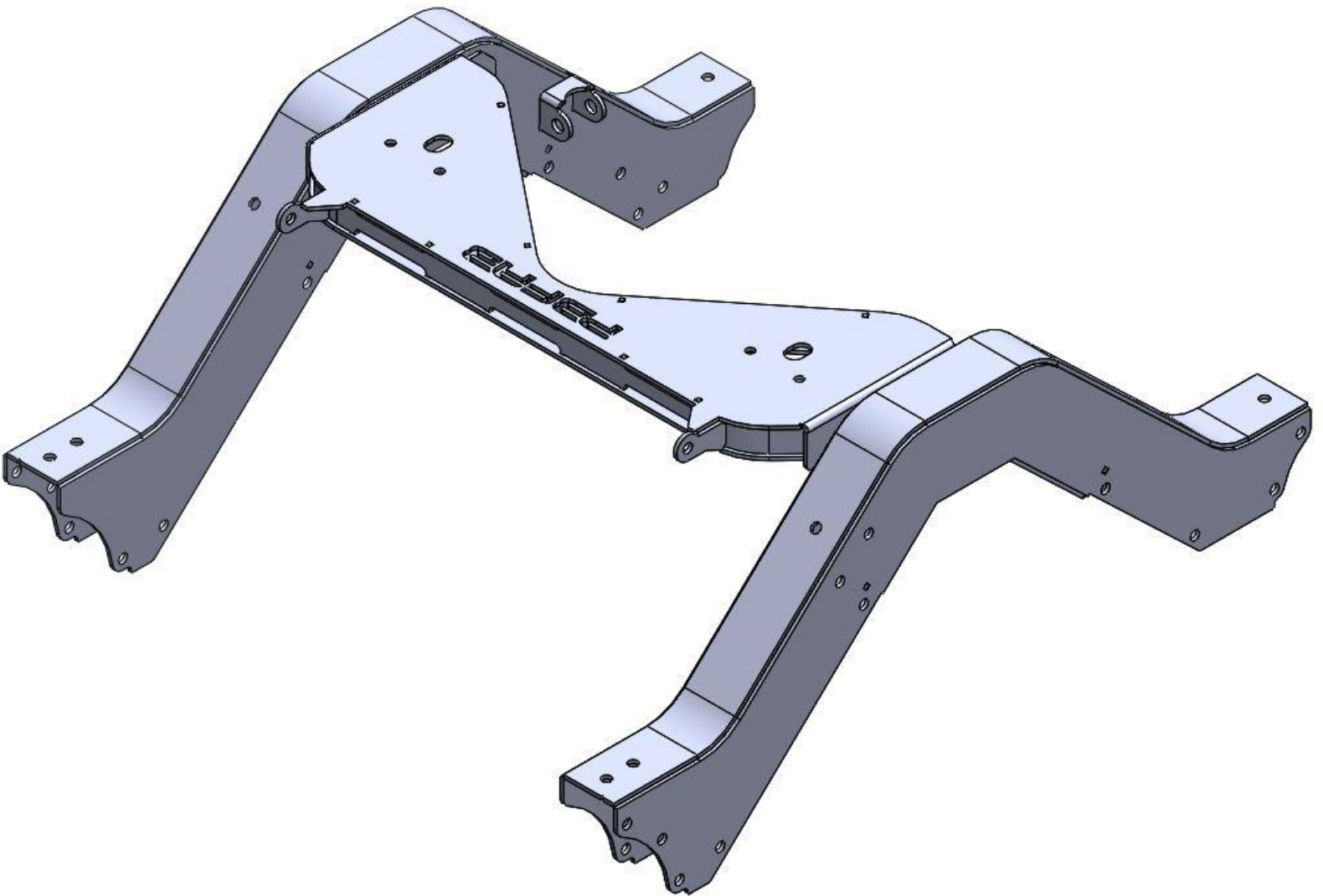
DM-V6 BUSHING HALF (QTY. 2)

DM-V6 CRUSH TUBES (QTY. 1)

ZERK FITTING (QTY. 1)

REAR NOTCH INSTALLATION

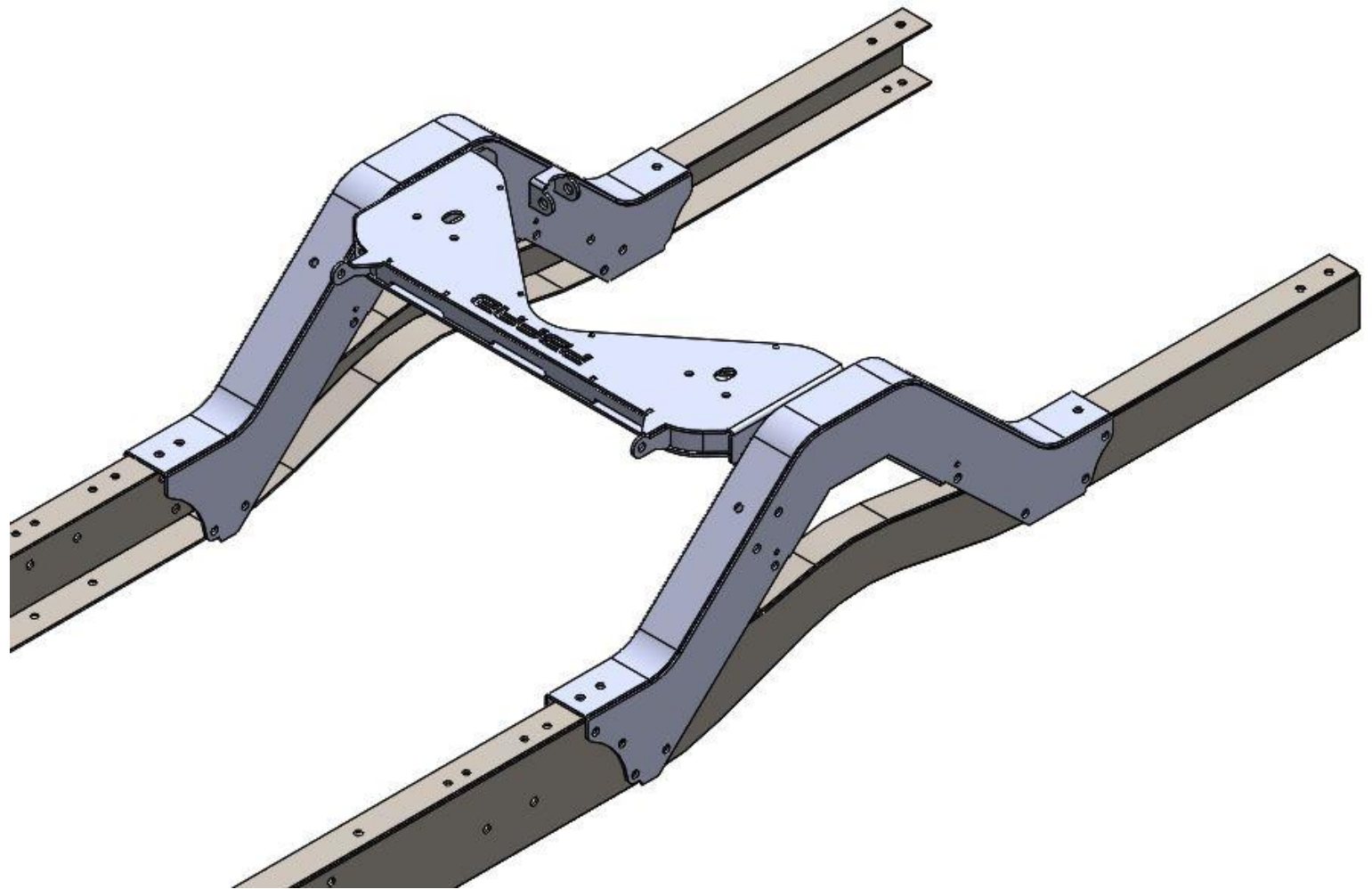
- BOLT BRIDGE ASSEMBLY BETWEEN NOTCHES
- INSTALL SUPPLIED GRADE 8 HARDWARE SO THAT BOLTS ARE HAND TIGHT
- DO NOT FULLY TIGHTEN BRIDGE ASSEMBLY MOUNTING HARDWARE AT THIS TIME



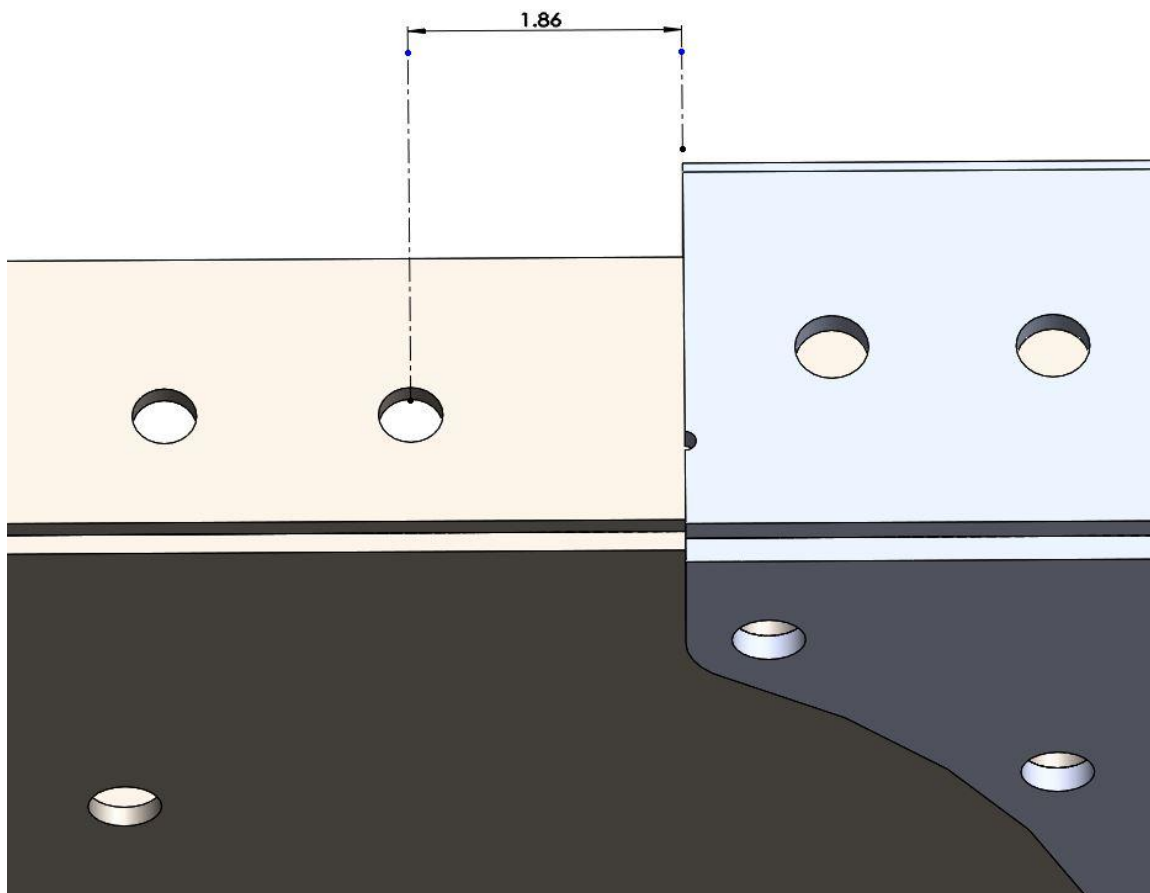
-REMOVE FACTORY FRAME CROSSMEMBERS

-IT IS RECOMMENDED TO LEAVE THE FACTORY REAR FRAME CROSSMEMBER AT THIS TIME TO HELP KEEP THE FRAME SQUARE DURING INSTALLATION

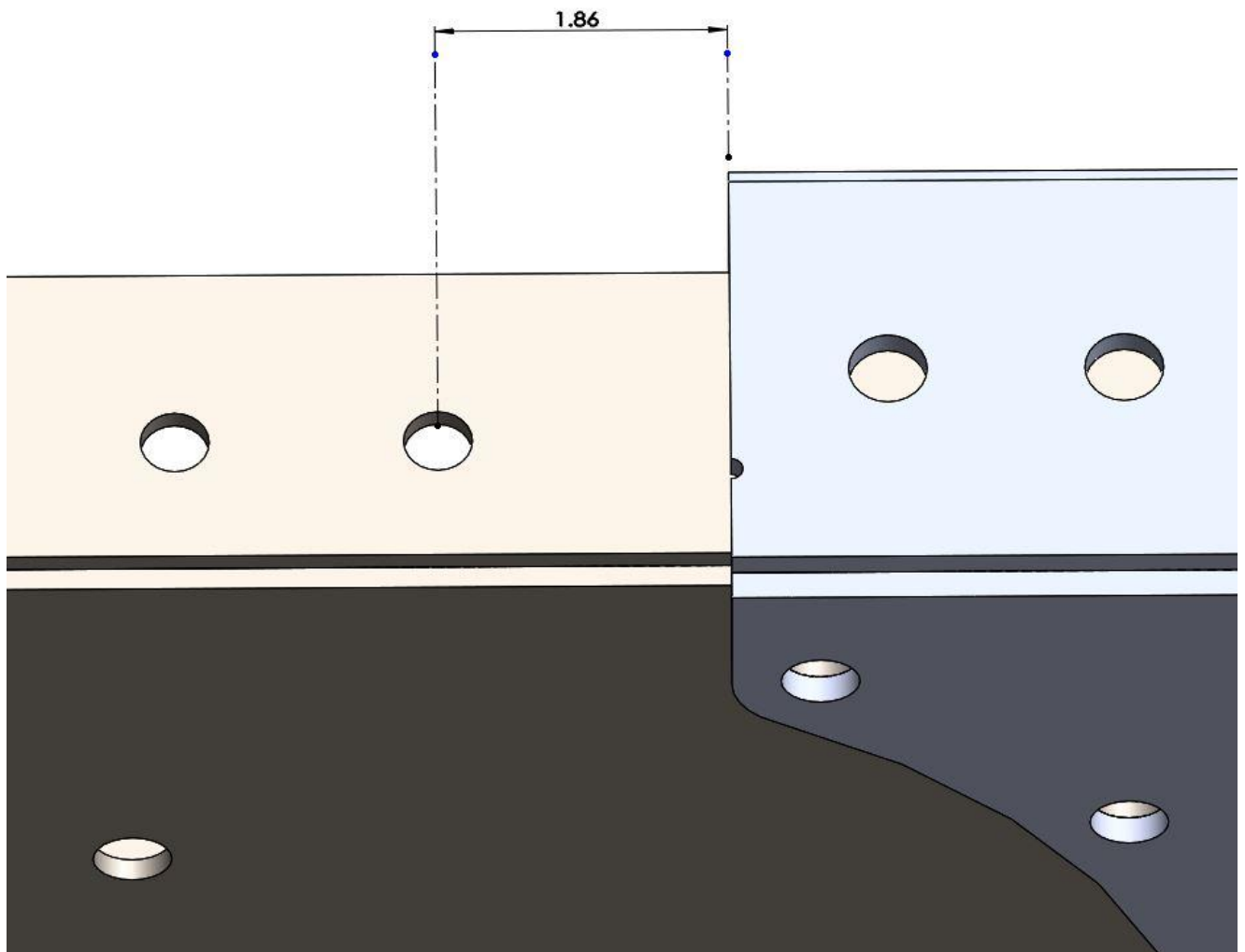
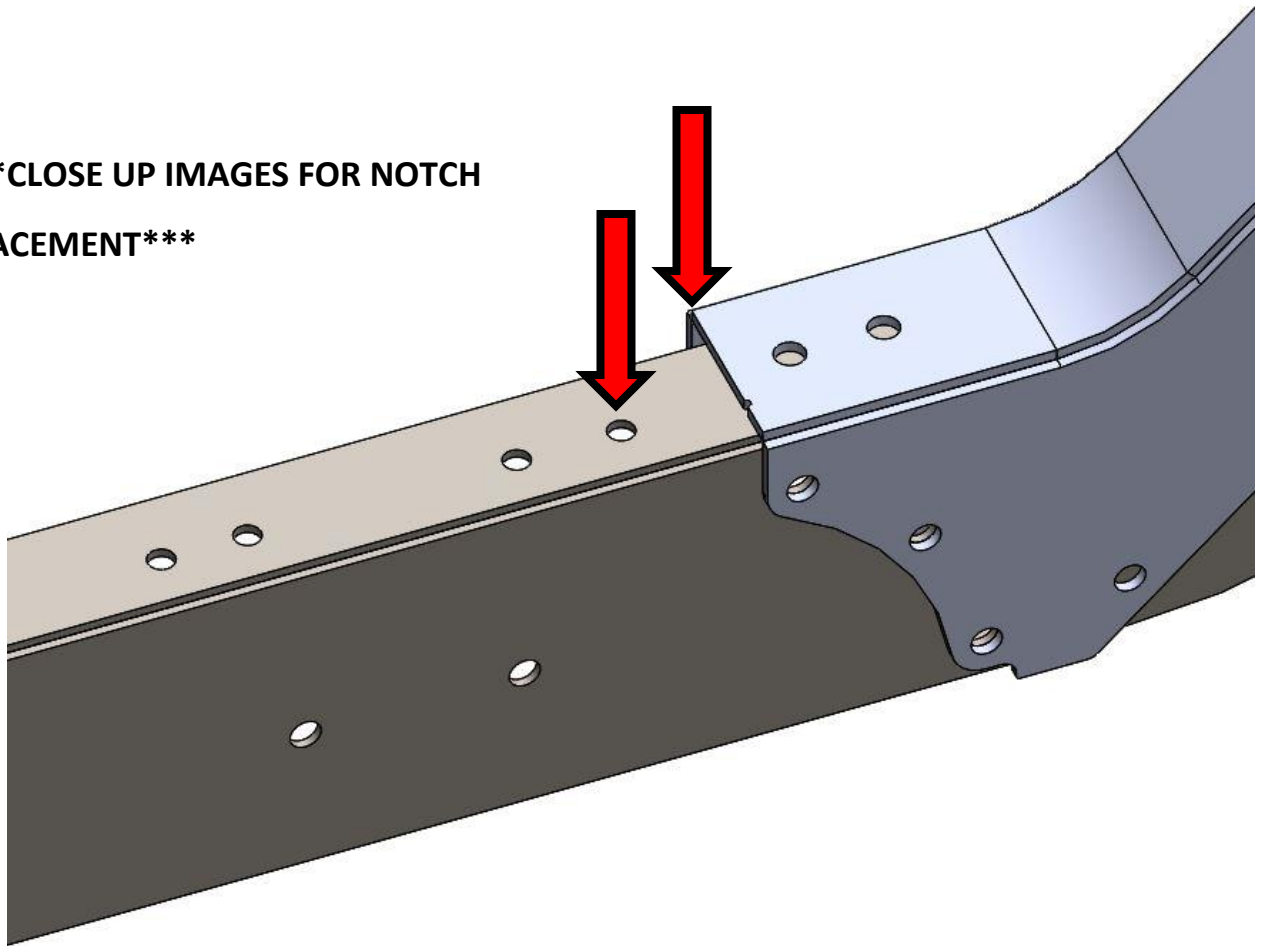
-SLIDE BRIDGE/NOTCH ASSEMBLY OVER FACTORY FRAME RAILS



- USE MEASUREMENT BELOW FOR PROPER FORE-AFT LOCATION
- FRONT EDGE OF NOTCH WILL BE LOCATED 1.875 (1 7/8) INCHES REARWARD OF THE FACTORY LEAF SPRING HANGER CROSSMEMBER MOUNTING HOLE SHOWN IN IMAGE
- CLAMP NOTCH SO THAT THE NOTCH IS FLUSH AGAINST THE TOP OF FRAME RAIL AND OUTSIDE OF FRAME RAIL (*****FAILURE TO DO SO WILL CAUSE IMPROPER FITMENT OF REMAINING COMPONENTS*****)
- WITH NOTCH PROPERLY CLAMPED IN PLACE, USE NOTCH AS TEMPLATE TO DRILL MOUNTING HOLES IN FRAME (*****USE A 7/16 DRILL BIT*****)
- INSTALL 7/16 GRADE 8 HARDWARE TO SECURE NOTCH TO FACTORY FRAME (TORQUE TO 65 FT.-LBS)



*****CLOSE UP IMAGES FOR NOTCH
PLACEMENT*****

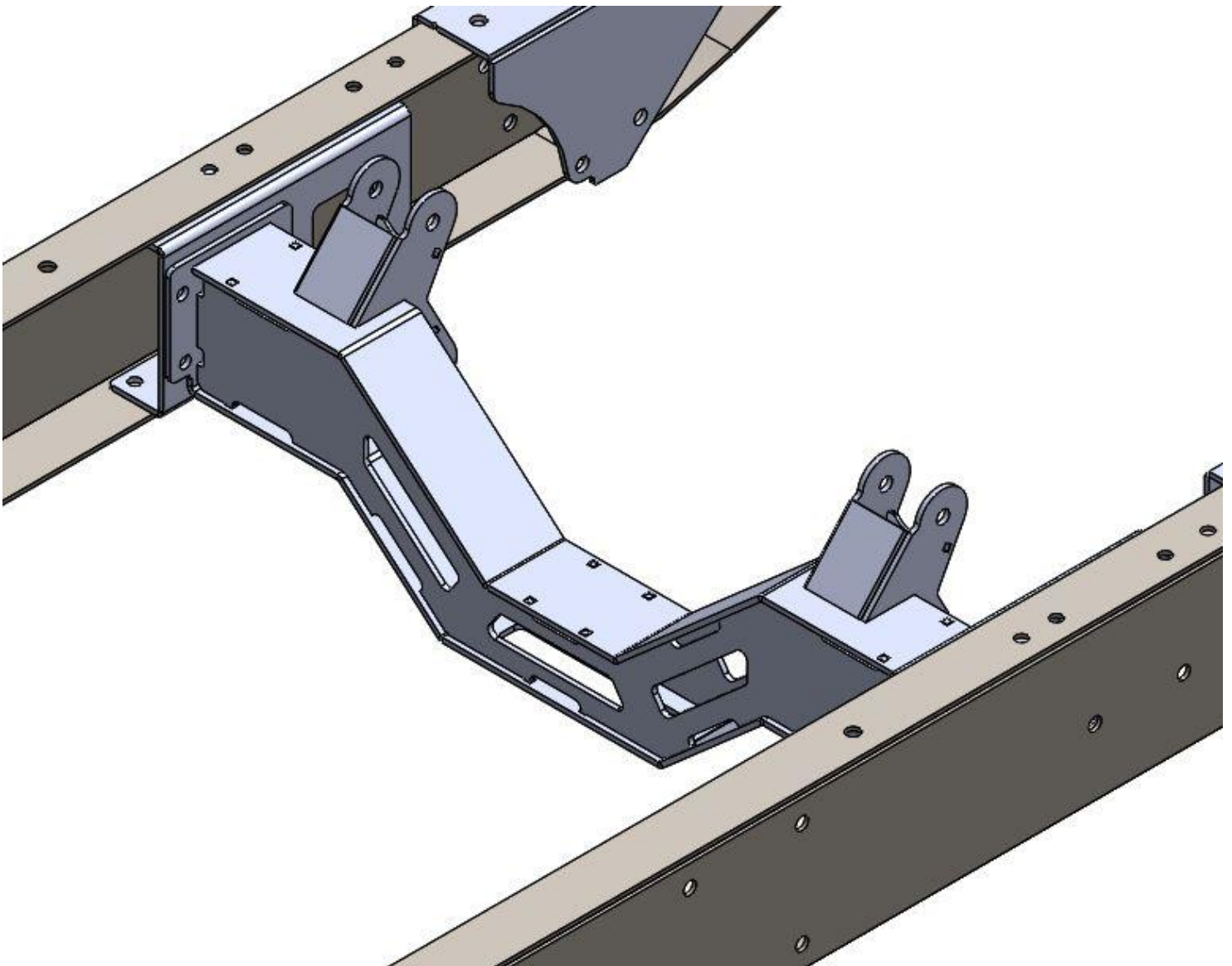


4-LINK CROSSMEMBER INSTALLATION

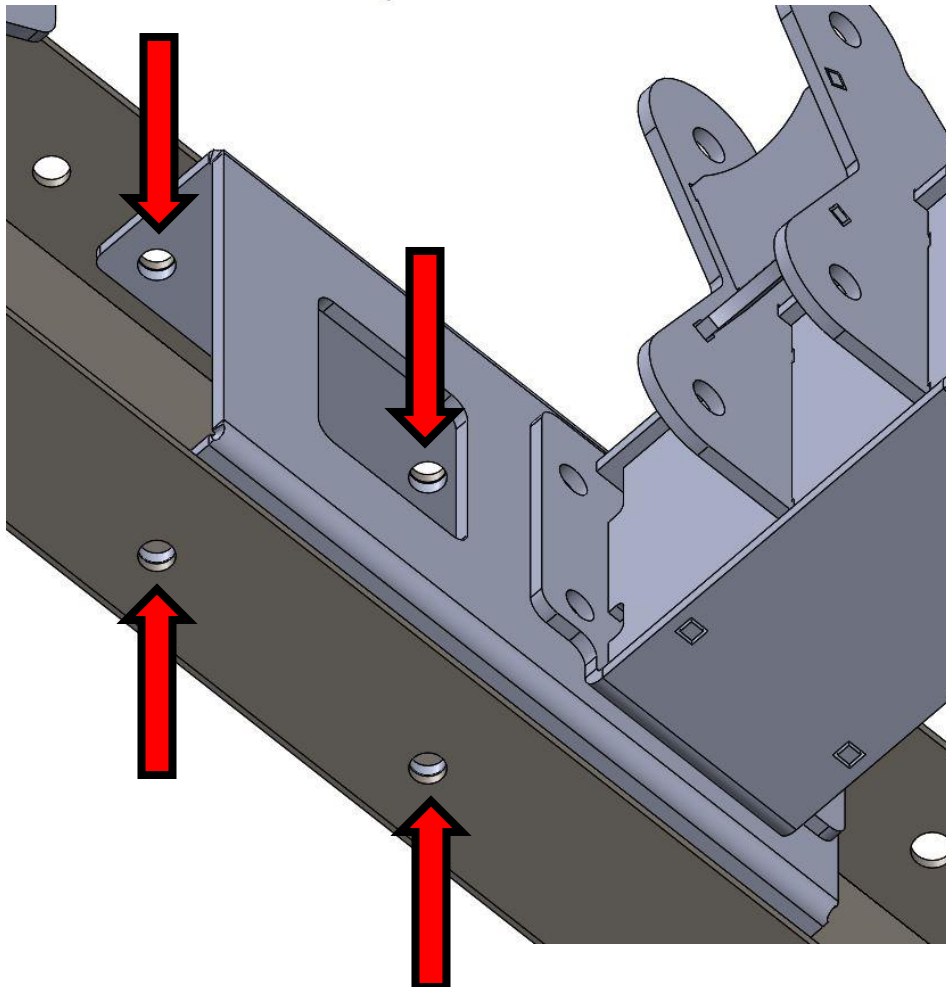
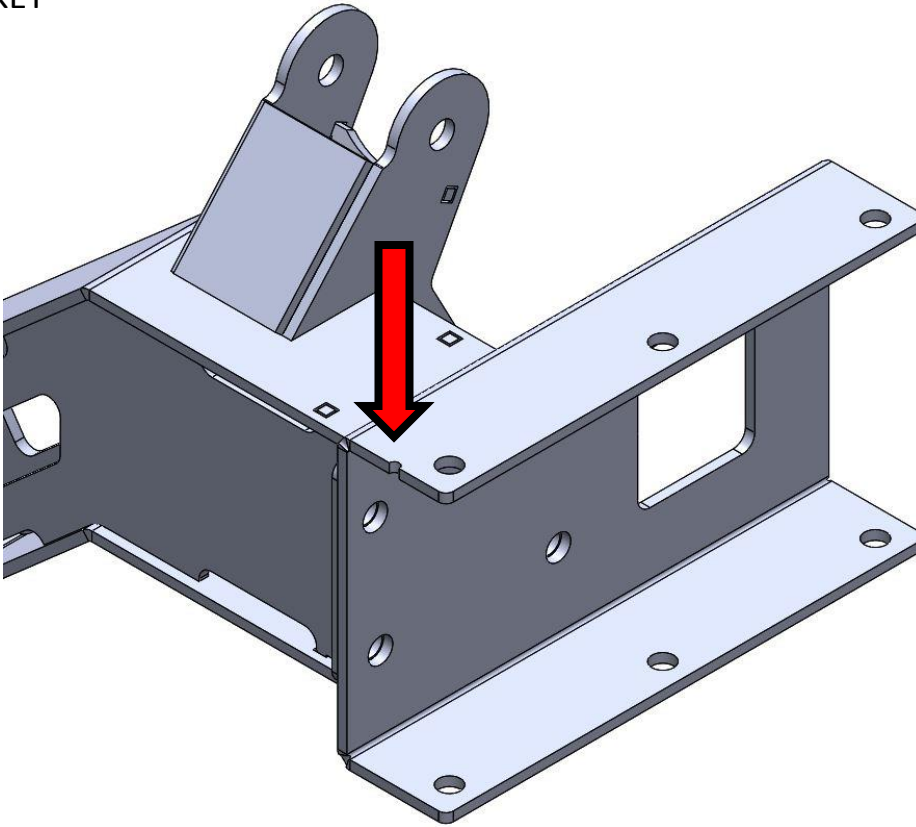
-4-LINK CROSSMEMBER TO FRAME MOUNTING BRACKETS WILL ALIGN WITH TWO FACTORY LEAF SPRING CROSSMEMBER MOUNTING HOLES ON TOP SIDE OF FRAME AND TWO FACTORY HOLES ON BOTTOM SIDE OF FRAME **(SEE IMAGES BELOW FOR REFERENCE)**

-ADDITIONAL MOUNTING HOLES IN TOP SIDE OF BRACKET WILL NEED TO BE MARKED AND DRILLED IN FACTORY FRAME

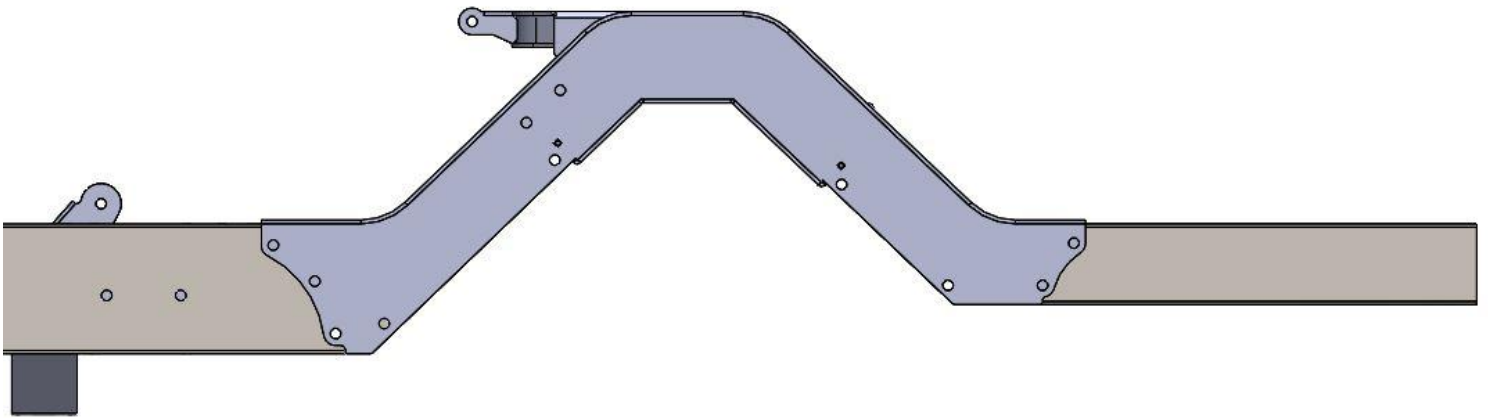
-INSTALL USING SUPPLIED GRADE 8 HARDWARE (TORQUE TO 65 FT LBS)



-NOTCH IN FRAME MOUNTING BRACKETS INDICATES TOP AND FRONT OF BRACKET

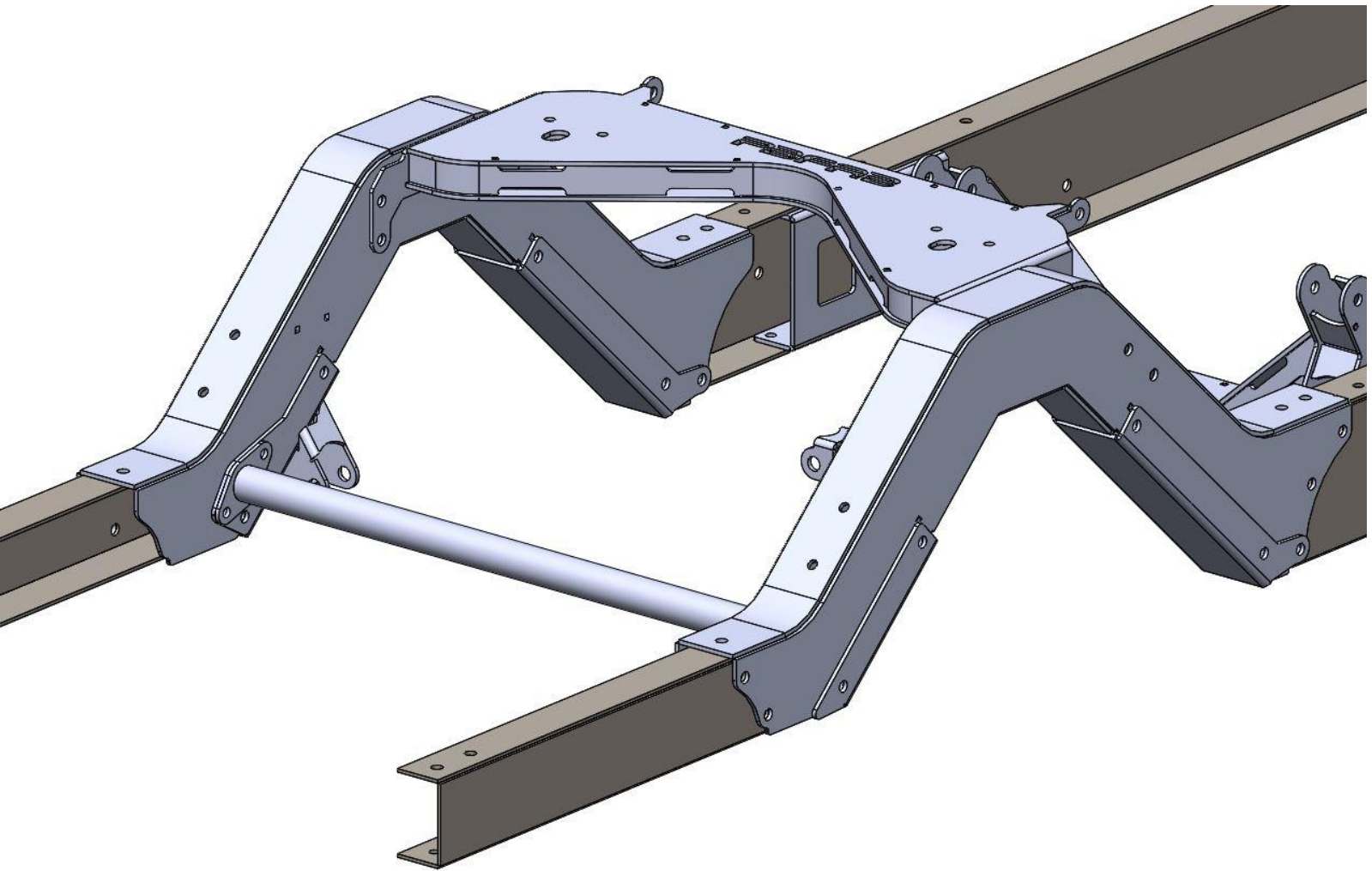


-WITH NOTCH SECURELY BOLTED INTO FRAME, USE A SAWZALL OR CUT-OFF WHEEL TO REMOVE FACTORY FRAME SECTION (*****TAKE CARE TO NOT CUT INTO OR DAMAGE NOTCH*****)



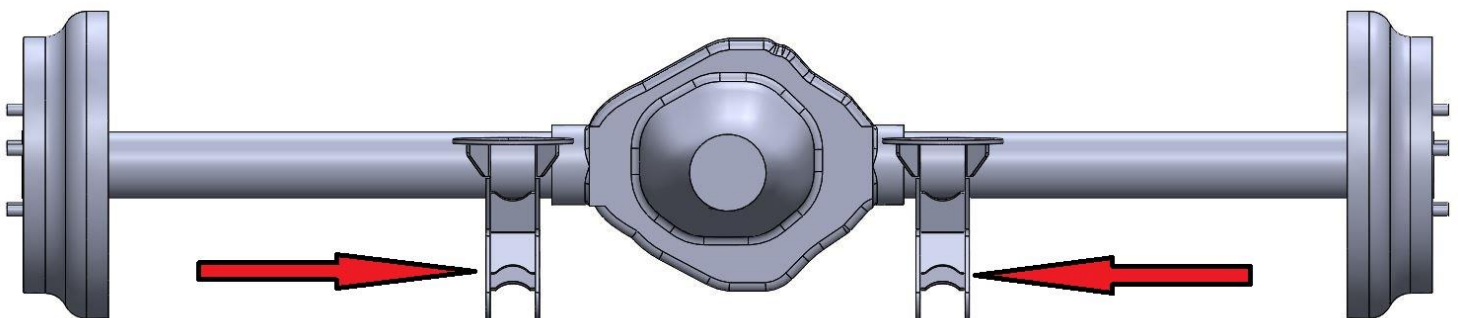
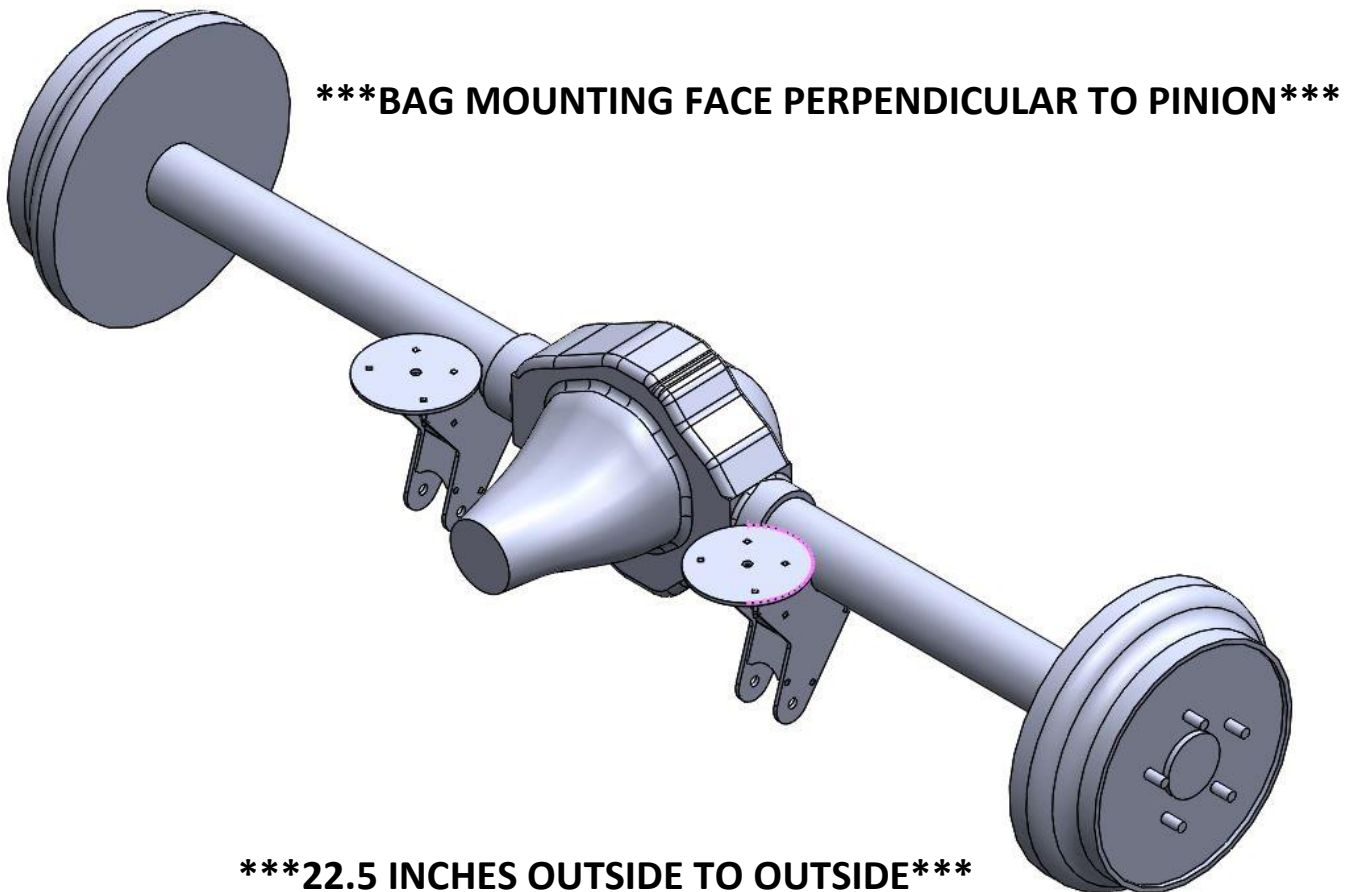
NOTCH CAP AND REAR NOTCH CROSSMEMBER INSTALLATION

- INSTALL FRONT AND REAR NOTCH CAPS AND REAR NOTCH CROSSMEMBER USING SUPPLIED GRADE 8 HARDWARE
- AFTER INSTALLING NOTCH CAPS AND REAR NOTCH CROSSMEBER TORQUE ALL HARWDARE TO 65 FT-LBS



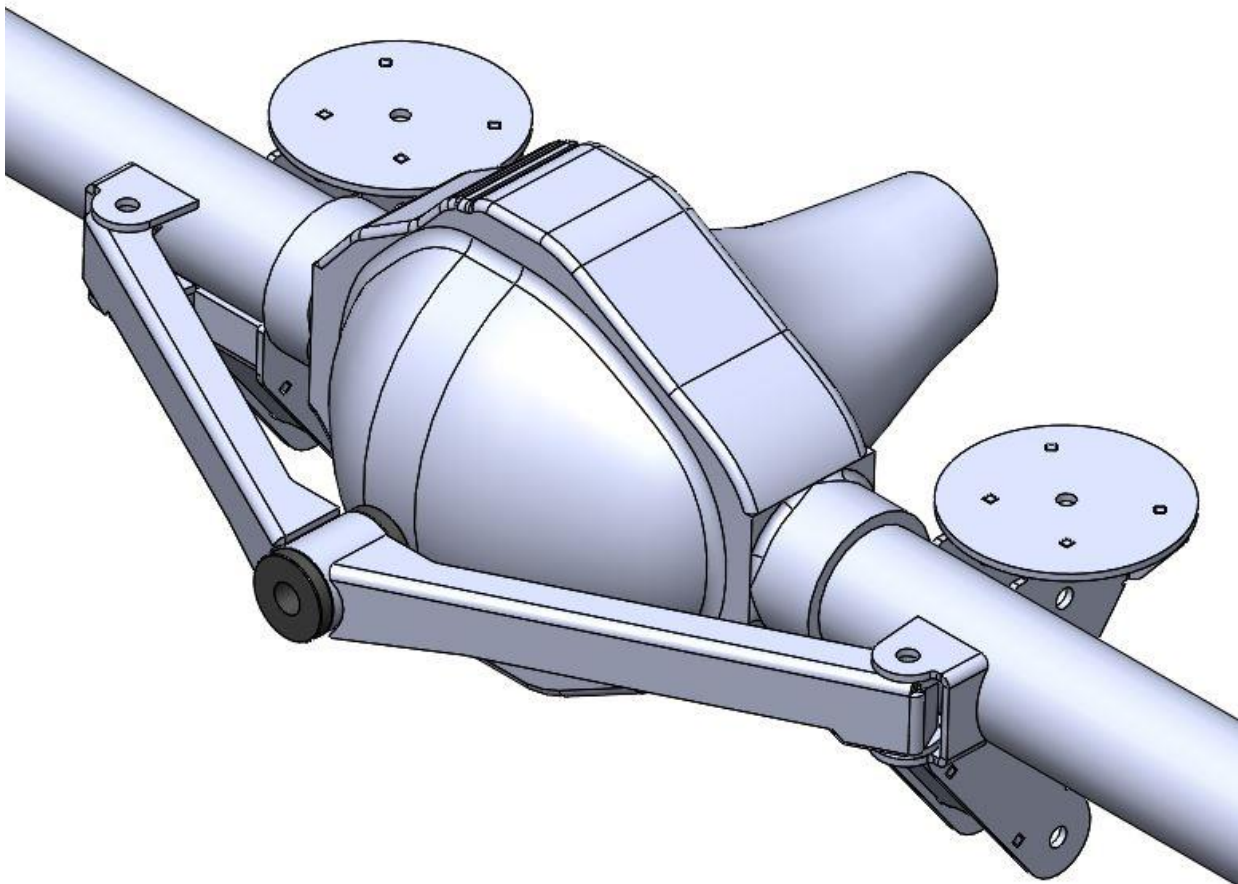
4-LINK AXLE BRACKET INSTALLATION

- SET DISTANCE FROM OUTSIDE EDGE TO OUTSIDE EDGE OF 4-LINK AXLE BRACKETS TO 22.5 INCHES
- SET BAG MOUNTING SURFACE OF 4-LINK AXLE BRACKETS PERPENDICULAR TO PINION
- TACK 4-LINK/BAG MOUNTING BRACKETS TO AXLE HOUSING AT THIS TIME (*****DO NOT YET FULLY WELD BRACKETS UNTIL AFTER DRIVE-TRAIN AND DRIVE-SHAFT ARE INSTALLED AND PROPER DRIVE-LINE ANGLES ARE CONFIRMED*****)



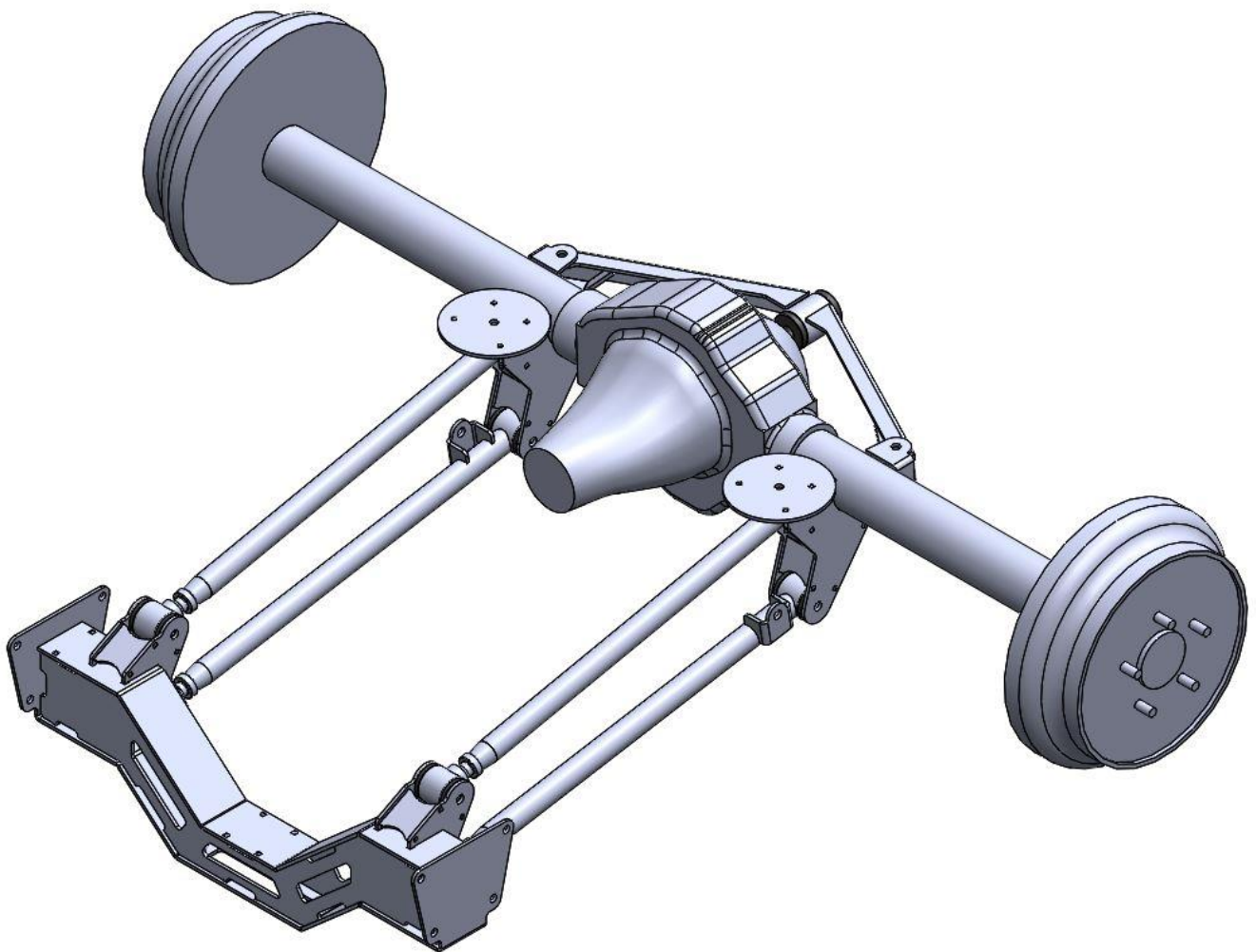
WATTS LINK MOUNTING BRACKET INSTALLATION

- ASSEMBLE WATTS LINK MAIN PIVOT BRACKET WITH AXLE MOUNTING TABS TO SET BRACKET DISTANCE DURING INSTALLATION
- SET WATTS LINK ASSEMBLY SO THAT IT IS CENTERED ON AXLE HOUSING
- SET WATTS LINK ASSEMBLY SO THAT BUSHING FACE IS PARALLEL TO PINION
- TACK WELD WATTS LINK AXLE MOUNTING BRACKETS TO REAR DIFFERENTIAL (*****DO NOT YET FULLY WELD BRACKETS UNTIL AFTER DRIVE-TRAIN AND DRIVE-SHAFT ARE INSTALLED AND PROPER DRIVE-LINE ANGLES ARE CONFIRMED*****)



LINK BAR INSTALLATION

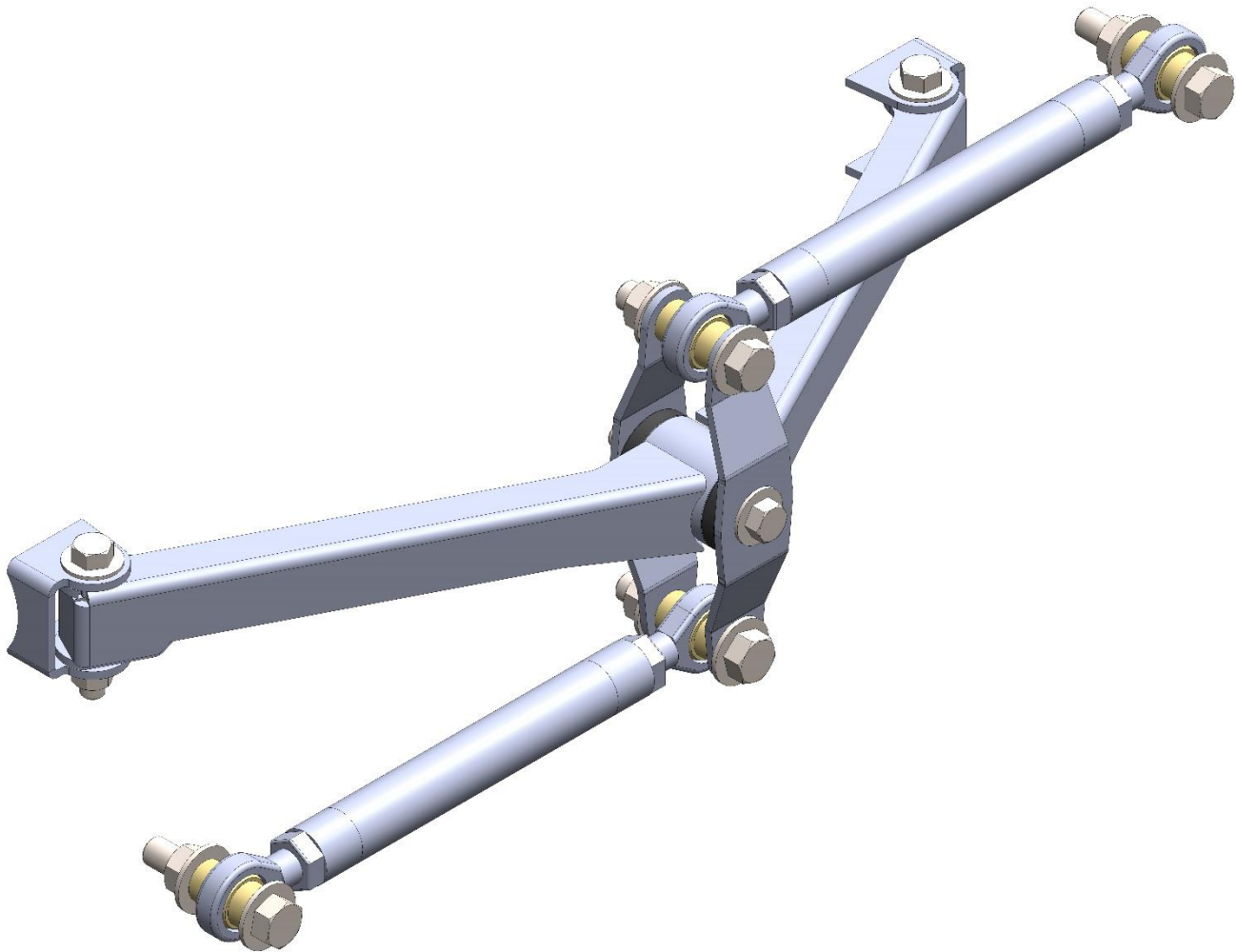
- SET MOUNTING DISTANCE OF 4-LINK BARS TO 25" CENTER TO CENTER
- LOWER LINK BARS ARE INSTALLED WITH SHOCK TABS POINTED UP AND ON OUTSIDE (**SEE IMAGE BELOW FOR REFERENCE**)
- USE SUPPLIED GRADE 8 MOUNTING HARDWARE
- WITH 4-LINK BARS SET TO PROPER LENGTH, REAR DIFFERENTIAL WILL BE CENTERED IN NOTCH WHEN FULLY COMPRESSED



WATTS LINK INSTALLATION

-ASSEMBLE AND INSTALL WATTS LINK USING SUPPLIED GRADE 8 HARDWARE

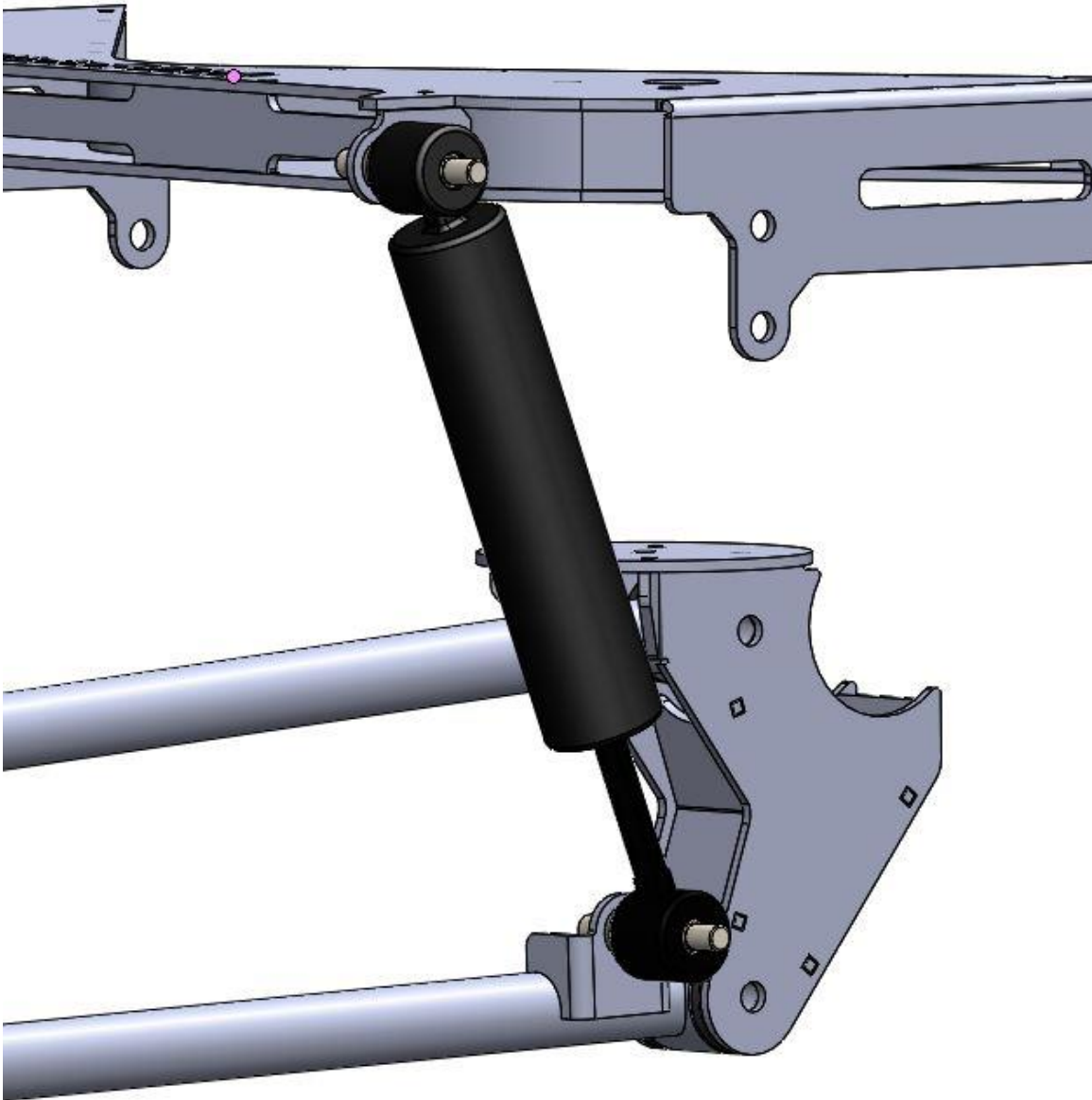
-TORQUE ALL HARDWARE TO 65 FT-LBS



SHOCK INSTALLATION

-INSTALLED VIEW OF PB SHOCK KIT PART#1924426-KIT-4L

(INCLUDES KYB SHOCK AND SHOCK MOUNTING STUDS**)**

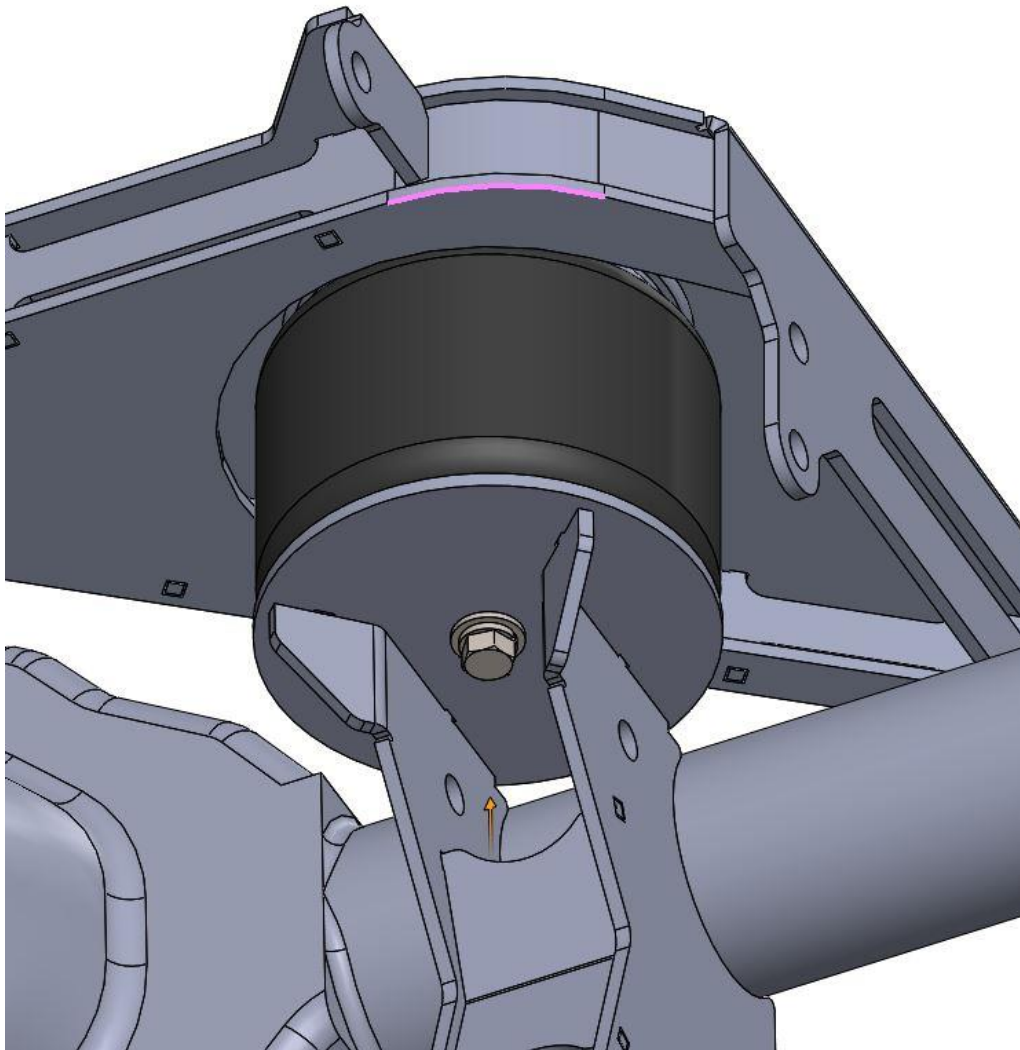


AIRBAG INSTALLATION

-INSTALLED VIEW OF PB AIRBAG KIT PART#F9000-KIT
(**INCLUDES FIRESTONE AIRSPRING AND MOUNTING
HARDWARE**)

***DO NOT LET AXLE WEIGHT HANG ON AIRSPRING; CORRECT
LENGTH SHOCK MUST BE INSTALLED TO ACT AS LIMITER. OVER
EXTENSION OF REAR AIR SPRING WILL LEAD TO DAMAGE AND VOID
ANY WARRANTY***

***MUST USE SUPPLIED 3/8 X .75 BOLTS, LOCKWASHER, AND FLAT
WASHER WHEN INSTALLING REAR SLEEVED BAGS. LONGER BOLTS
WILL DAMAGE AIRSPRING COMPOSITE ENDS AND VOID ANY
WARRANTY***



CONFIRM DRIVE-LINE ANGLES AND FINISH WELDING ON REAR AXLE BRACKETS

-IT IS IMPORTANT TO HAVE THE DRIVE TRAIN AND DRIVE-SHAFT FULLY MOCKED UP BEFORE FINISH WELDING OF ANY AXLE MOUNTED BRACKETS

-ENSURE THE FOLLOWING STEPS ARE TAKEN BEFORE FULLY WELDING MOUNTING BRACKETS ATTACHED TO THE AXLE:

-CONFIRM AND ADJUST DRIVE-LINE ANGLES IF NECESSARY

-CYCLE SUSPENSION MULTIPLE TIMES THROUGH ITS TRAVEL WITH ALL COMPONENTS MOCKED UP TO ENSURE NO BINDING OR CLEARANCE ISSUES ARE PRESENT

-CHECK AGAIN AND AGAIN.... MEASURE 100 MORE TIMES....

-THE MOUNTING BRACKETS ATTACHED TO THE REAR DIFFERENTIAL MAY NOW BE FULLY WELDED 😊

FOR ANY TECH HELP ALONG THE WAY FEEL FREE TO EMAIL OR TEXT MESSAGE FOR ASSISTANCE

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TEXT: 480-310-9847