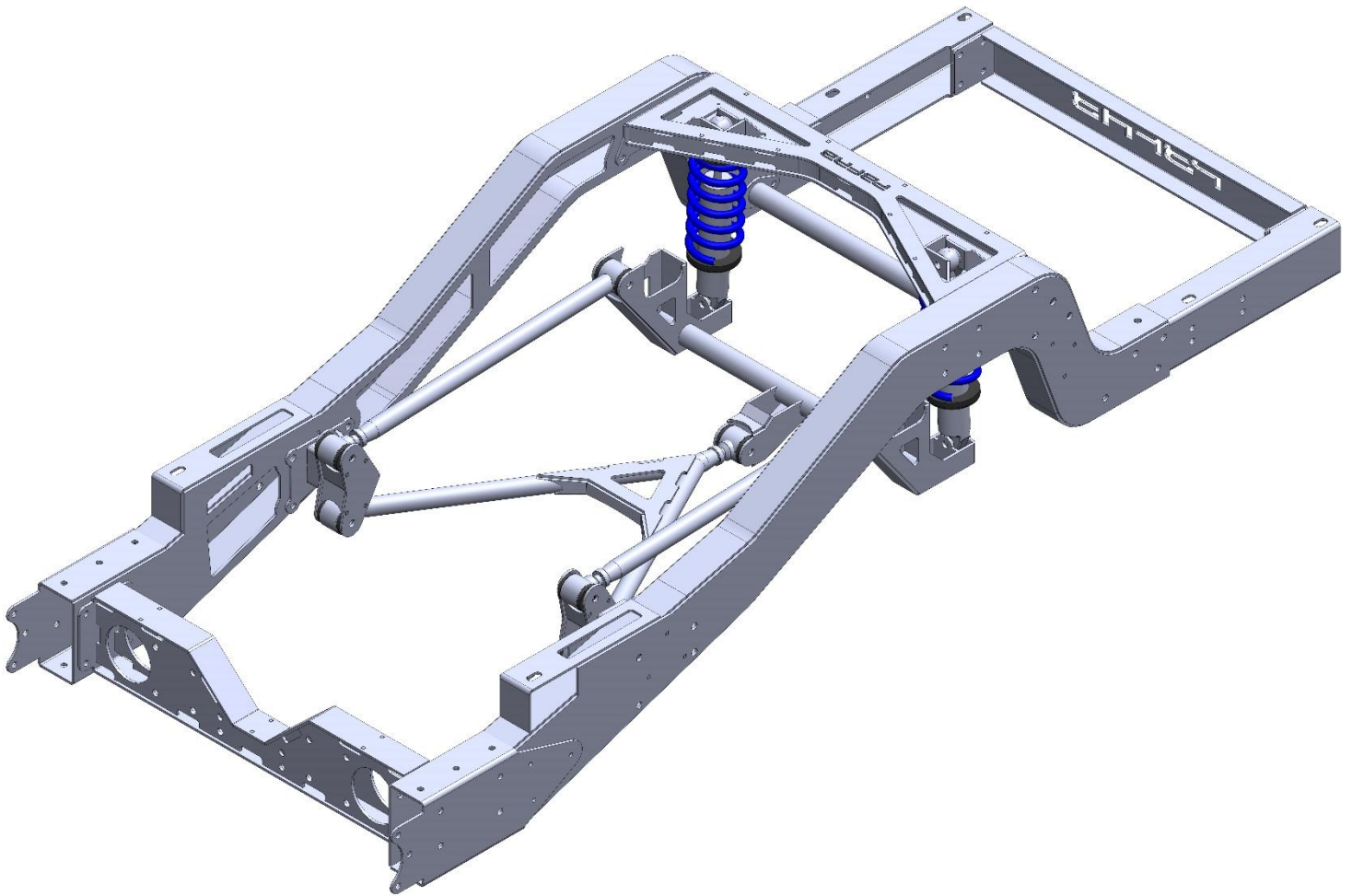


PORTERBUILT DROPMEMBER REAR 63-72 COMPLETE BACK-HALF INSTALLATION GUIDE

(LEVEL 2 INBOARD COIL OVER INBOARD 4-LINK)

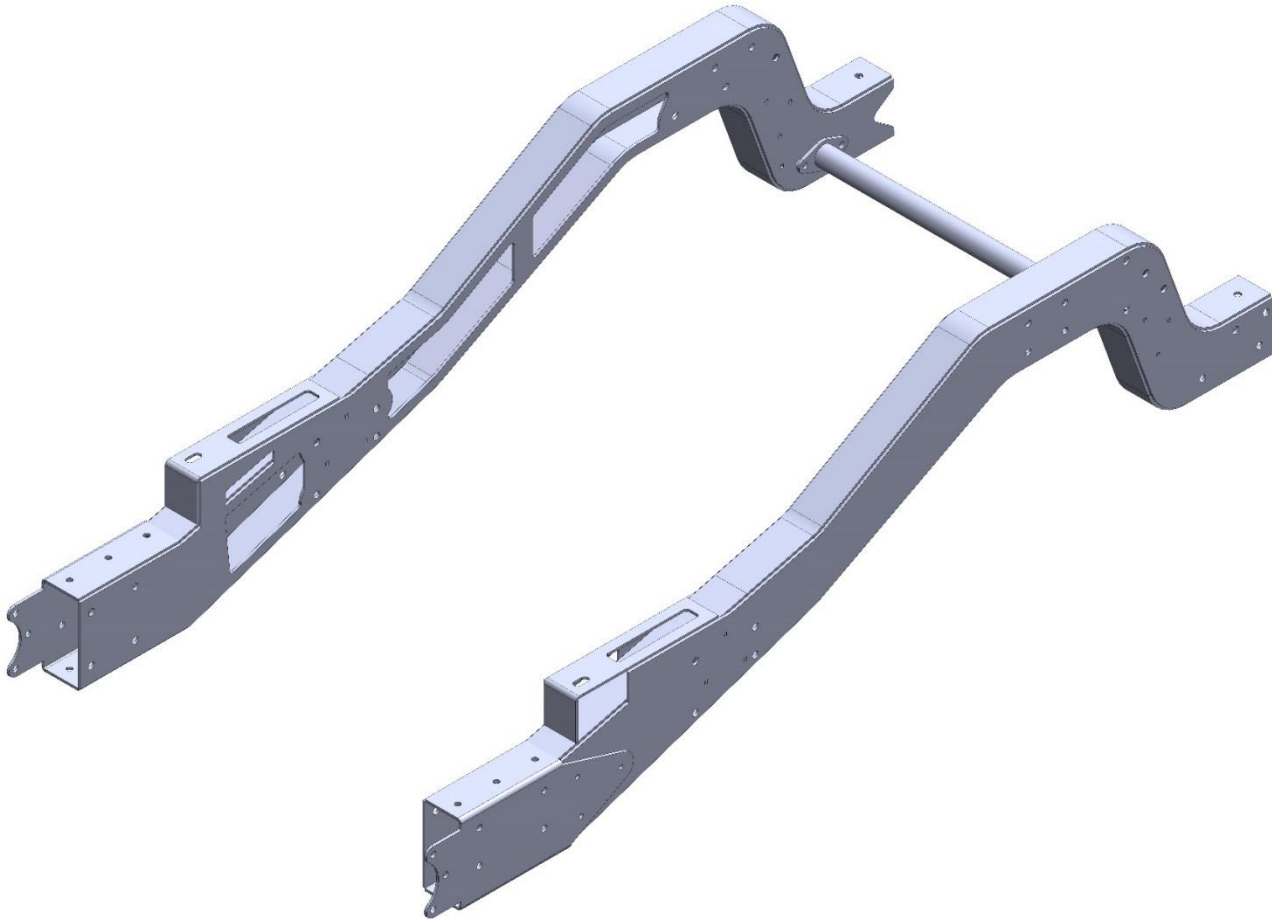


12/6/2019

SECTION 1: INDIVIDUAL PARTS IDENTIFICATION WITH HARDWARE DESCRIPTIONS

PART# BH6372-I4L-IC-2

DESCRIPTION: BACK HALF; 63-72; INBOARD COIL OVER; LEVEL 2



HARDWARE DESCRIPTION:

7/16 X 1.25 GRADE 8 BOLT USS (QTY. 26)

7/16 X 1.5 GRADE 8 BOLT USS (QTY. 4)

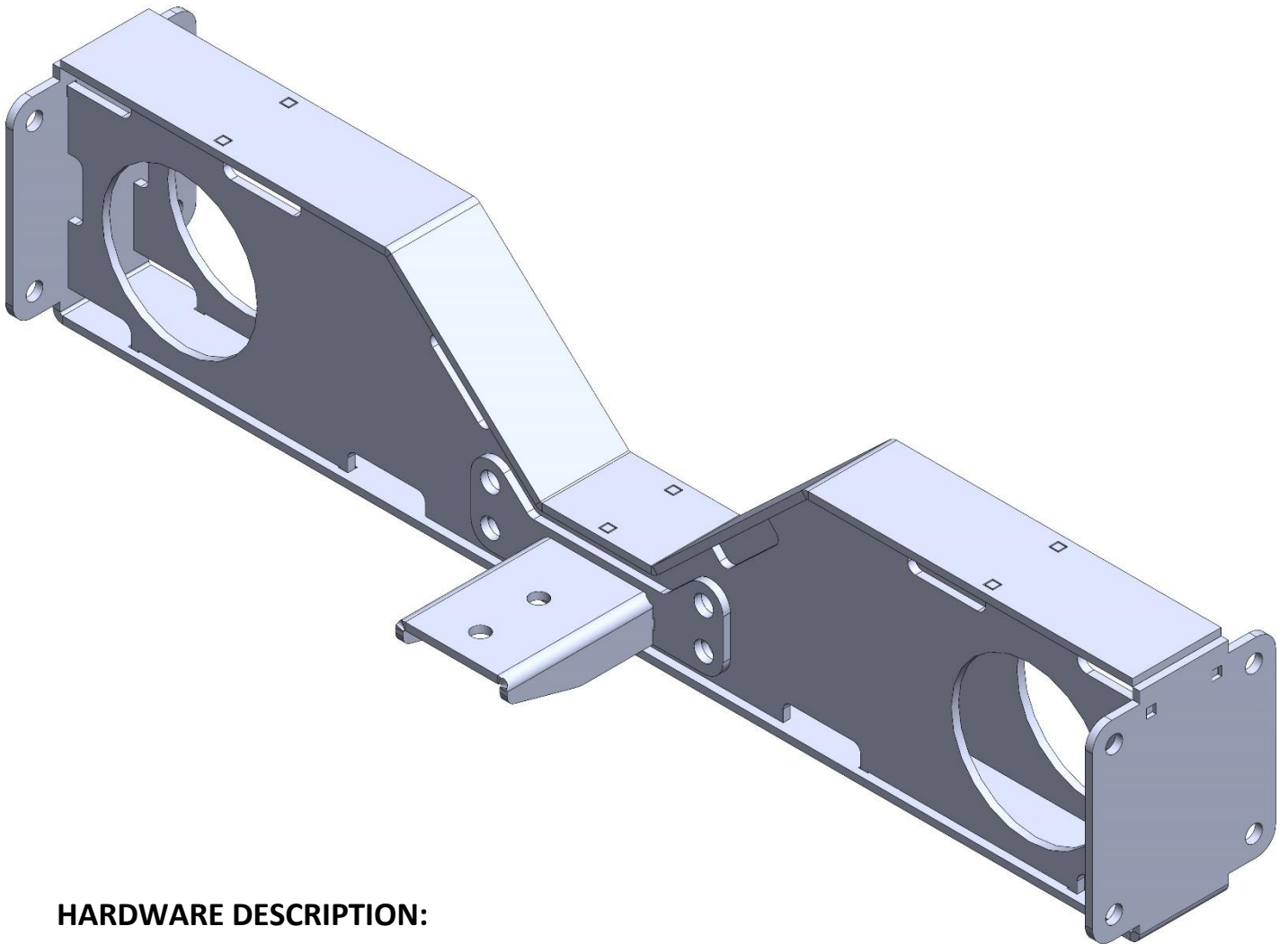
7/16 GRADE 8 NYLOC NUT USS (QTY. 26)

7/16 GRADE 8 LOCKWASHER USS (QTY. 4)

3/8 GRADE 8 FLAT WASHER USS (QTY. 56)

PART# CBXM6372-BH

DESCRIPTION: CARRIER BEARING X-MEMBER; 63-72; BACK HALF SPECIFIC



HARDWARE DESCRIPTION:

7/16 X 1.25 GRADE 8 BOLT USS (QTY. 12)

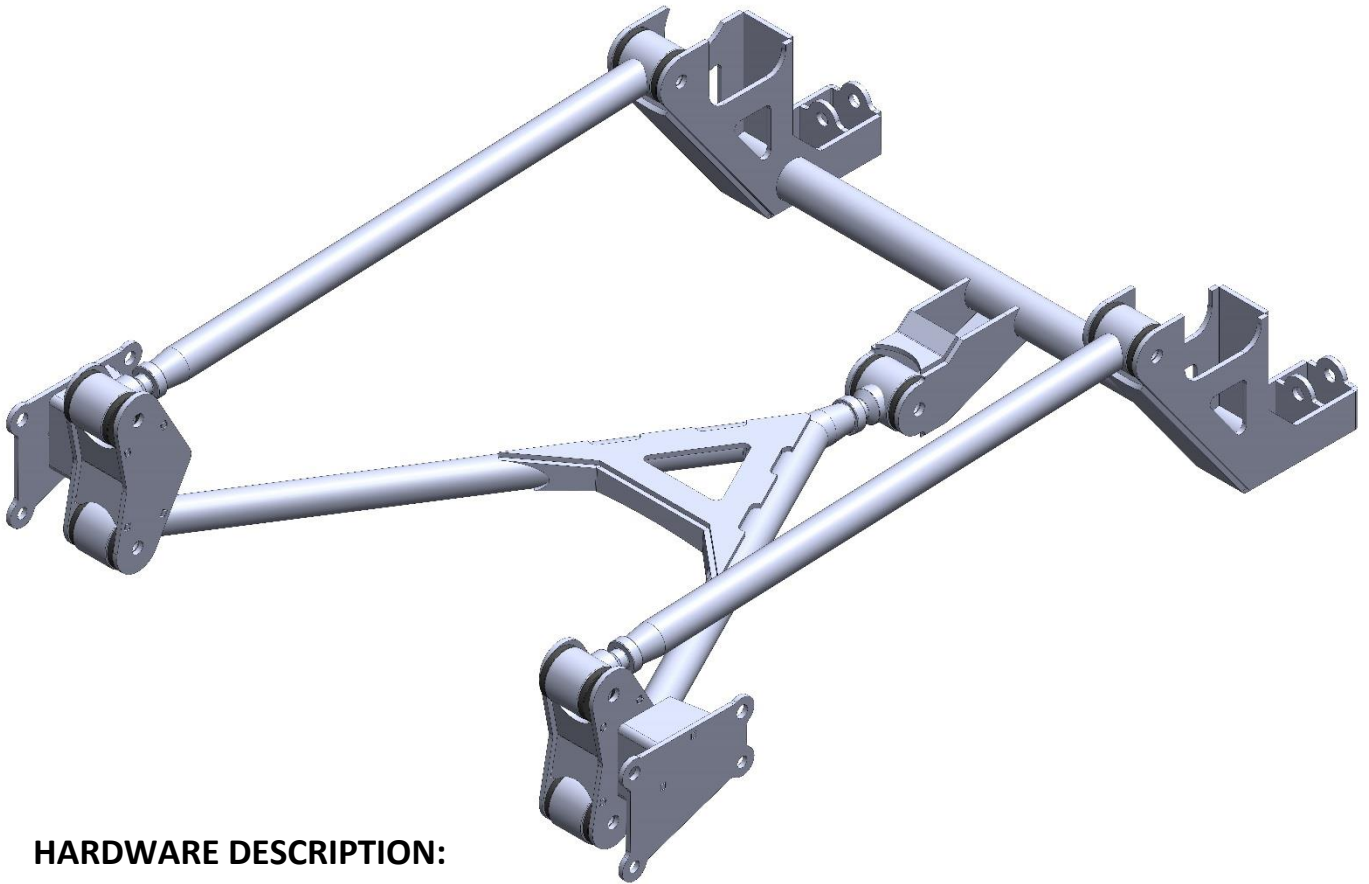
7/16 GRADE 8 NYLOC NUT USS (QTY. 8)

7/16 GRADE 8 LOCKWASHER USS (QTY. 4)

3/8 GRADE 8 FLAT WASHER USS (QTY. 20)

PART# 4L6372-BH-I4L-IC-2

DESCRIPTION: 4 LINK; 63-72; BACK HALF SPECIFIC; INBOARD COIL OVER; LEVEL 2



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)

1/2 X 2.5 GRADE 8 BOLT USS (QTY. 2) ***LOWER COIL OVER MOUNTING BOLT***

1/2 X 3.25 GRADE 8 BOLT USS (QTY. 7)

7/16 GRADE 8 FLAT WASHER USS (QTY. 18)

1/2 GRADE 8 NYLOC NUT (QTY. 9)

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

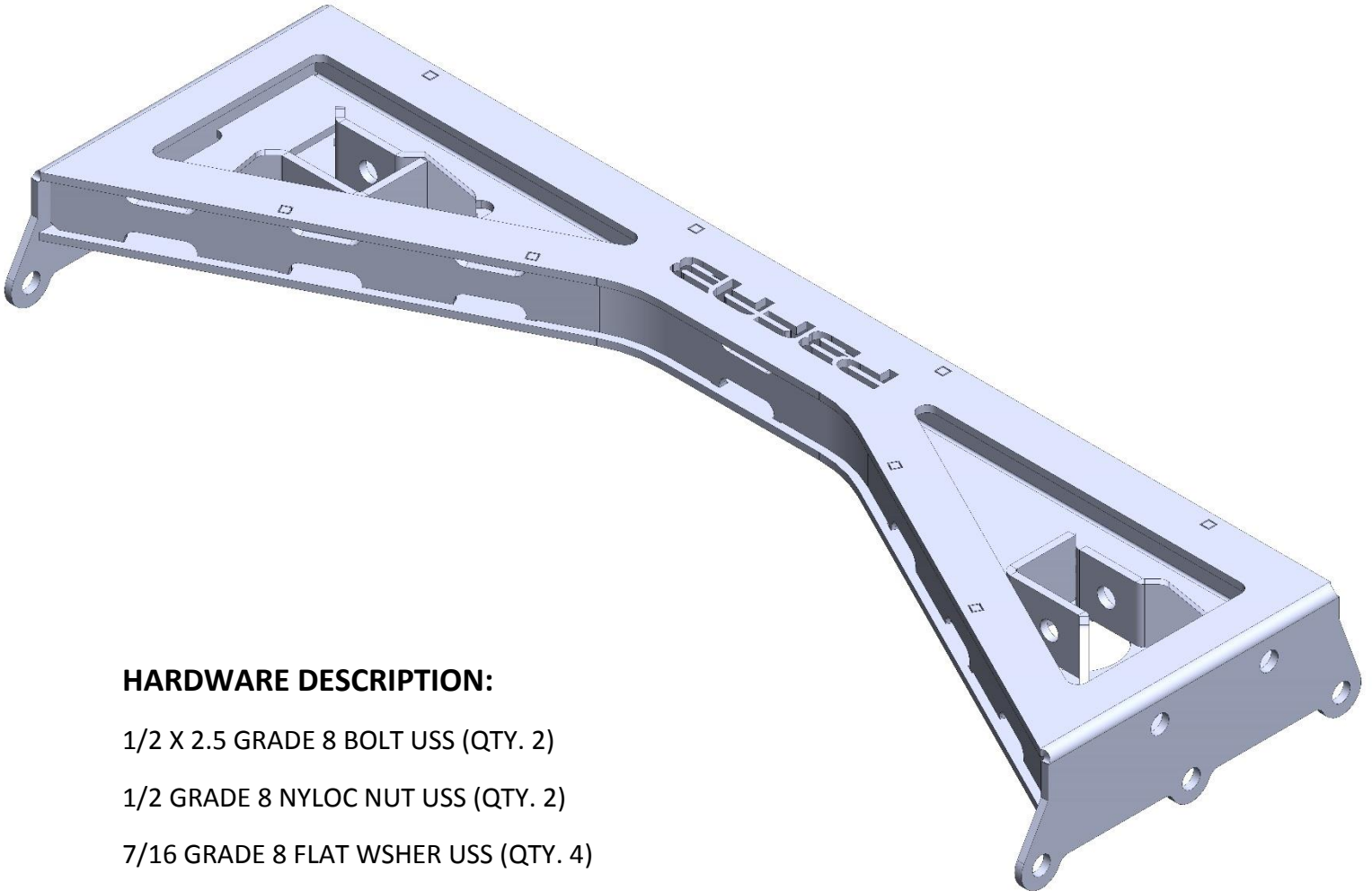
POLY BUSHING HALF; 4-LINK SPECIFIC (QTY. 14)

4-LINK BUSHING CRUSH TUBE (QTY. 7)

ZERK FITTINGS (QTY. 7)

PART# BA6372-BH-IC-2

DESCRIPTION: BRIDGE ASSEMBLY; 63-72 LEVEL 2 BACK HALF; INBOARD COIL-OVER

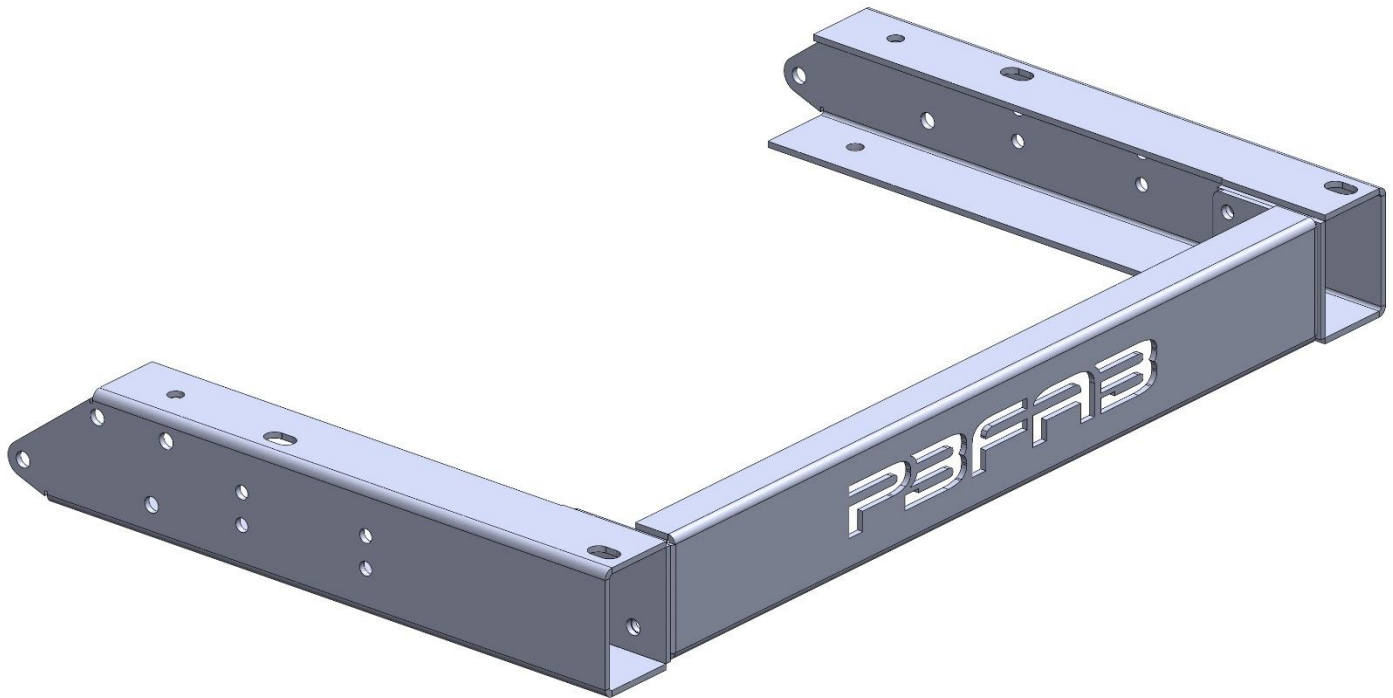


HARDWARE DESCRIPTION:

- 1/2 X 2.5 GRADE 8 BOLT USS (QTY. 2)
- 1/2 GRADE 8 NYLOC NUT USS (QTY. 2)
- 7/16 GRADE 8 FLAT WSHER USS (QTY. 4)
- 7/16 X 1.25 GRADE 8 BOLT USS (QTY. 18)
- 7/16 GRADE 8 LOCKWASHER (QTY. 10)
- 7/16 GRADE 8 NYLOC NUT USS (QTY. 8)
- 3/8 GRADE 8 FLAT WASHER (QTY. 26)

PART# RFR6372-BH

DESCRIPTION: REAR FRAME ASSEMBLY; 63-72; BACK HALF SPECIFIC



HARDWARE DESCRIPTION:

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

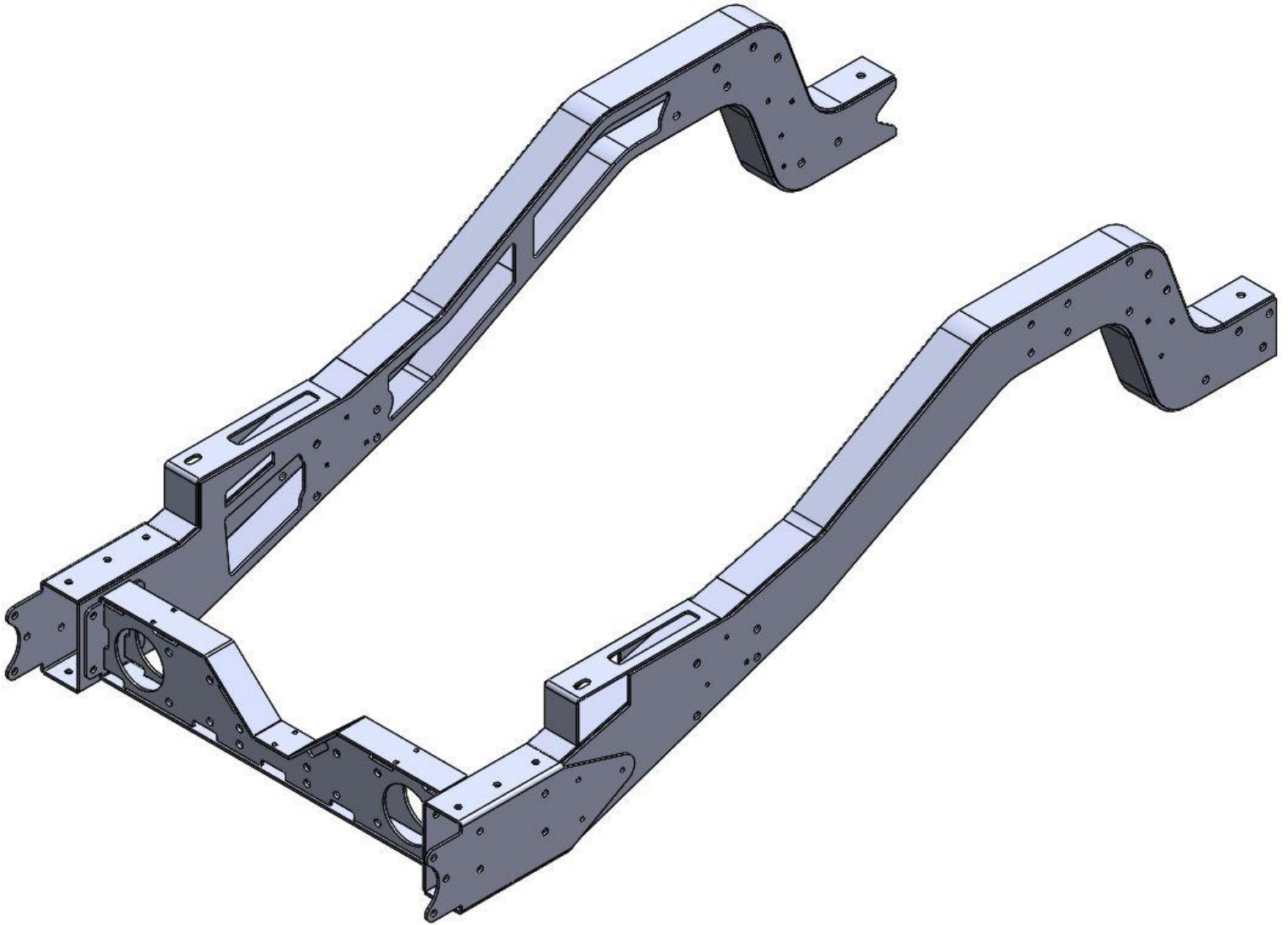
7/16 GRADE 8 NYLOC NUT USS (QTY. 20)

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

*****EACH HARDWARE BAG WILL HAVE A LABEL WITH PART NUMBER AND DESCRIPTION THAT CORRELATES TO THE INDIVIDUAL PARTS TO AID IN HARDWARE IDENTIFICATION*****

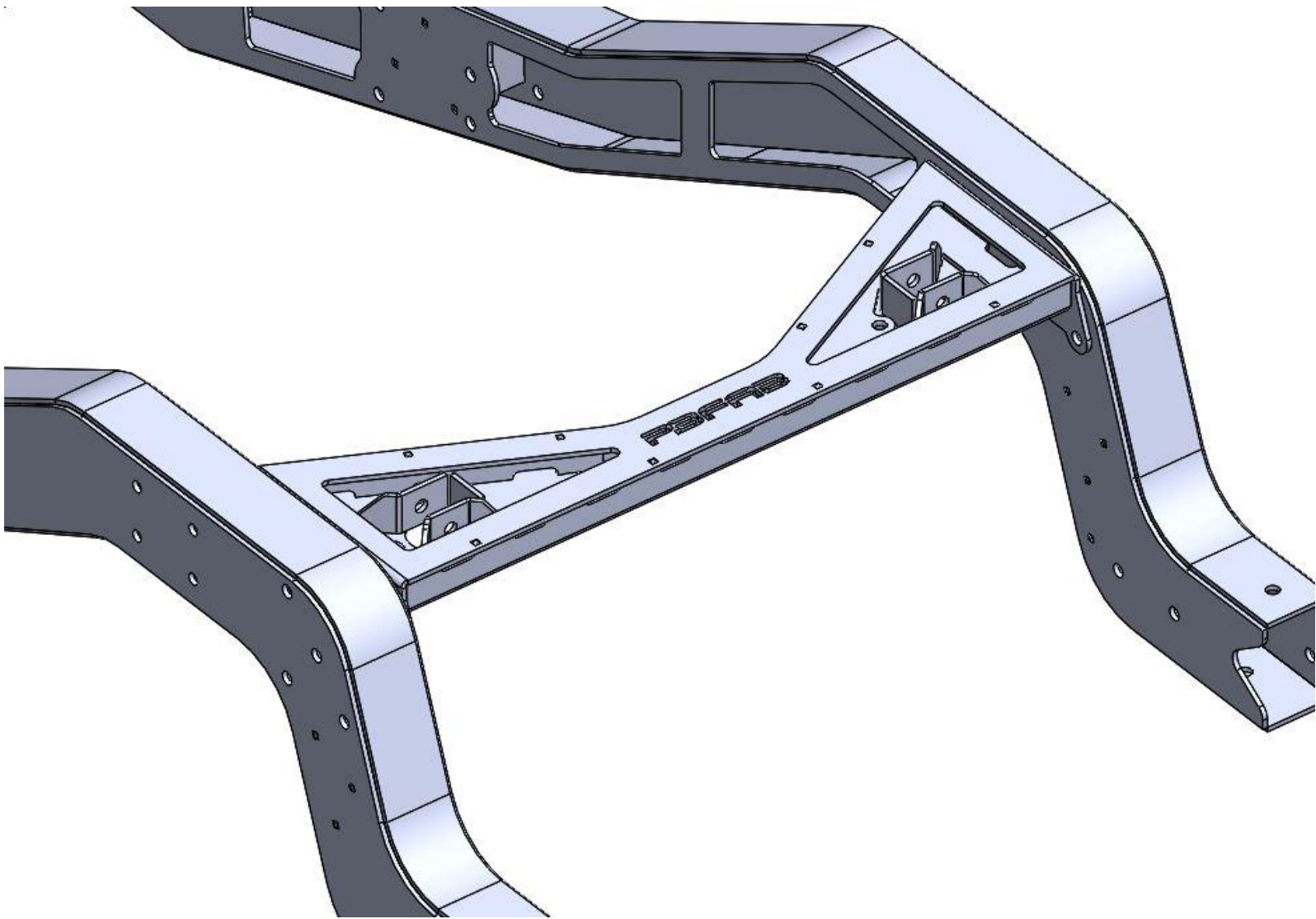
**-ATTACH MAIN RAILS TO CARRIER BEARING CROSSMEMBER USING SUPPLIED
GRADE 8 HARDWARE.**

*****DO NOT FULLY TIGHTEN AT THIS TIME*****



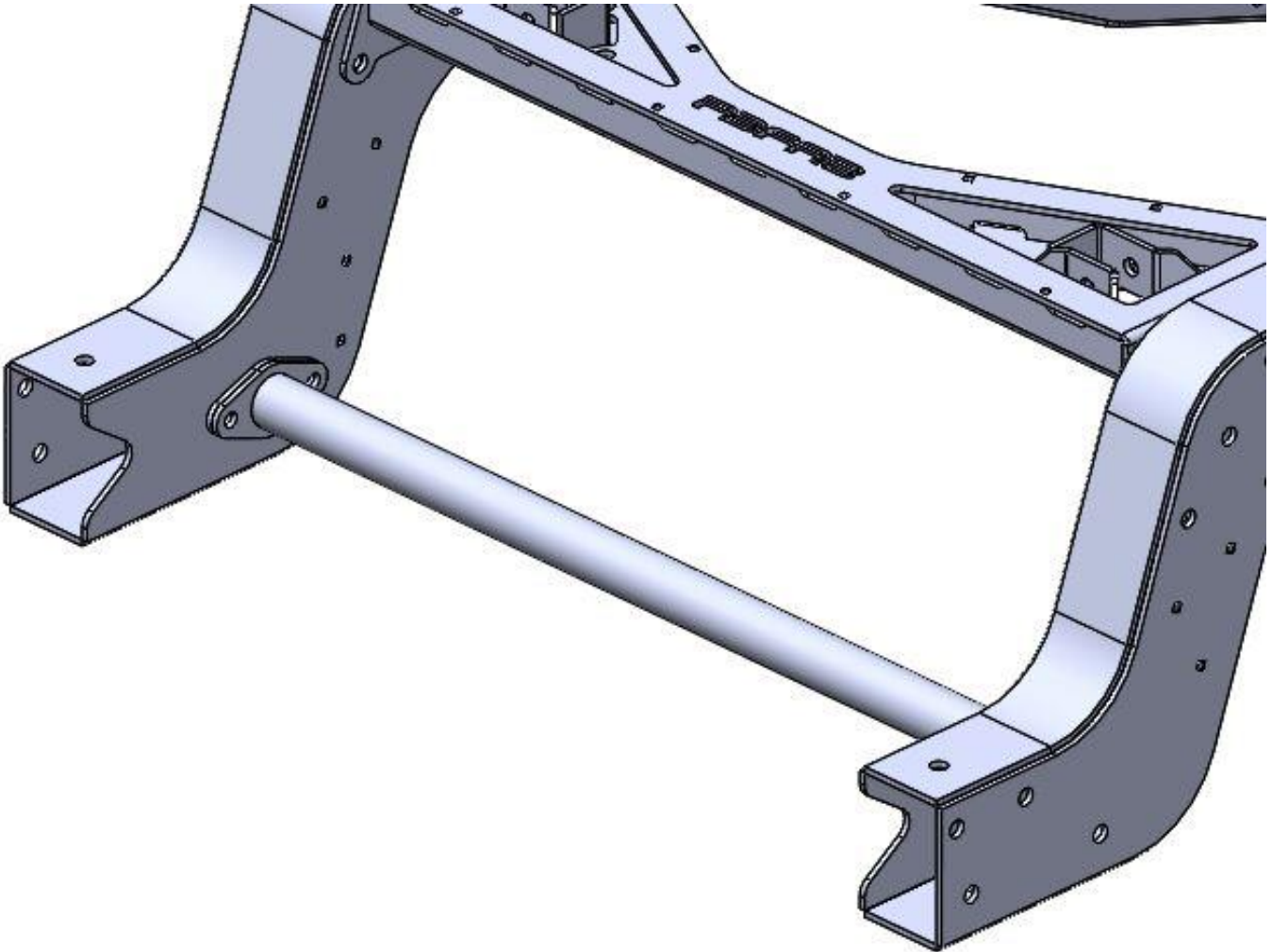
-INSTALL BRIDGE ASSEMBLY BETWEEN MAIN RAILS USING SUPPLIED GRADE 8 HARDWARE.

*****DO NOT FULLY TIGHTEN AT THIS TIME*****

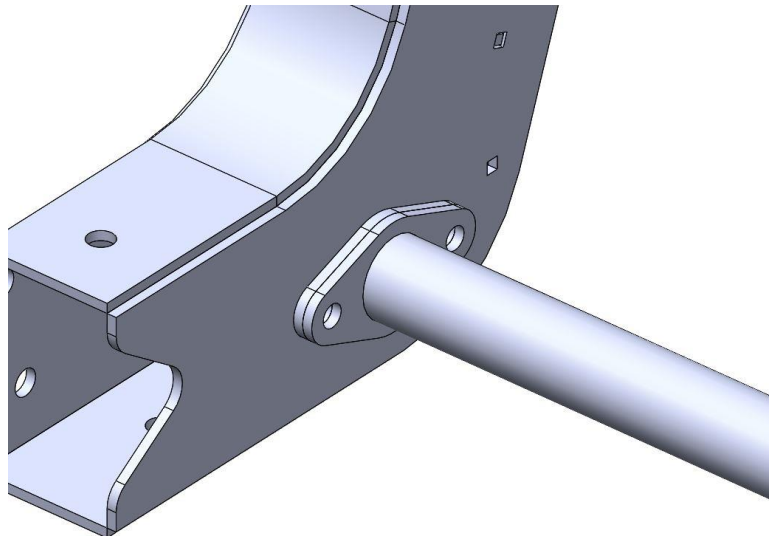


-INSTALL REAR NOTCH CROSSMEMBER USING SUPPLIED GRADE 8 HARDWARE.

*****DO NOT FULLY TIGHTEN AT THIS TIME*****

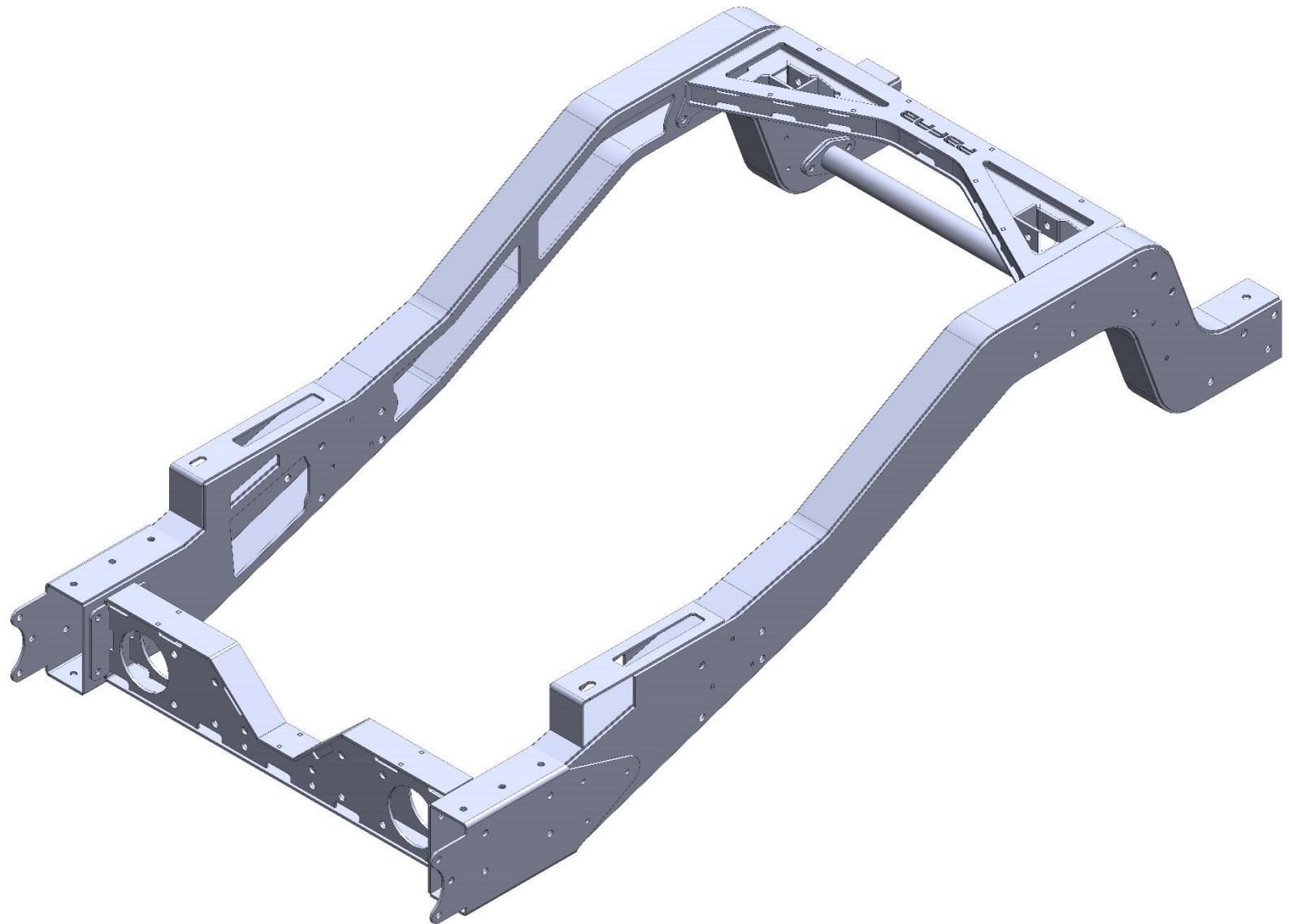


*****REAR NOTCH CROSSMEMBER SHIM
INSTALLS BETWEEN REAR FRAME RAIL
AND REAR NOTCH CROSSMEMBER
FLANGE*****



-BEGIN TIGHTENING CROSSMEMBERS OF REAR BACK HALF ASSEMBLY TAKING TIME TO ENSURE ASSEMBLY REMAINS LEVEL AND SQUARE

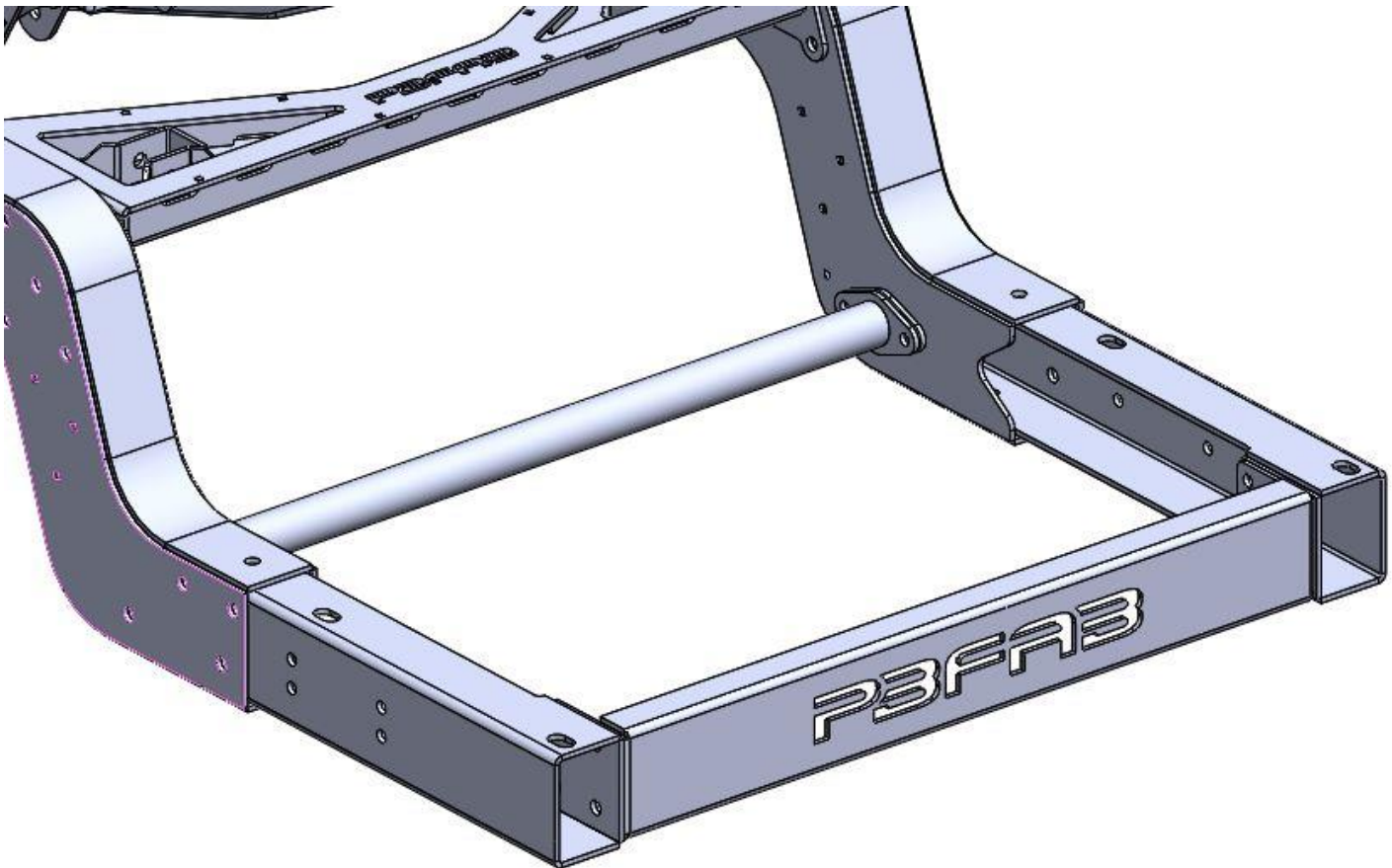
*****TORQUE ALL 7/16 GRADE 8 HARDWARE TO 65 FT LBS*****



-INSTALL REAR FRAME RAIL ASSEMBLY USING SUPPLIED GRADE 8 HARDWARE

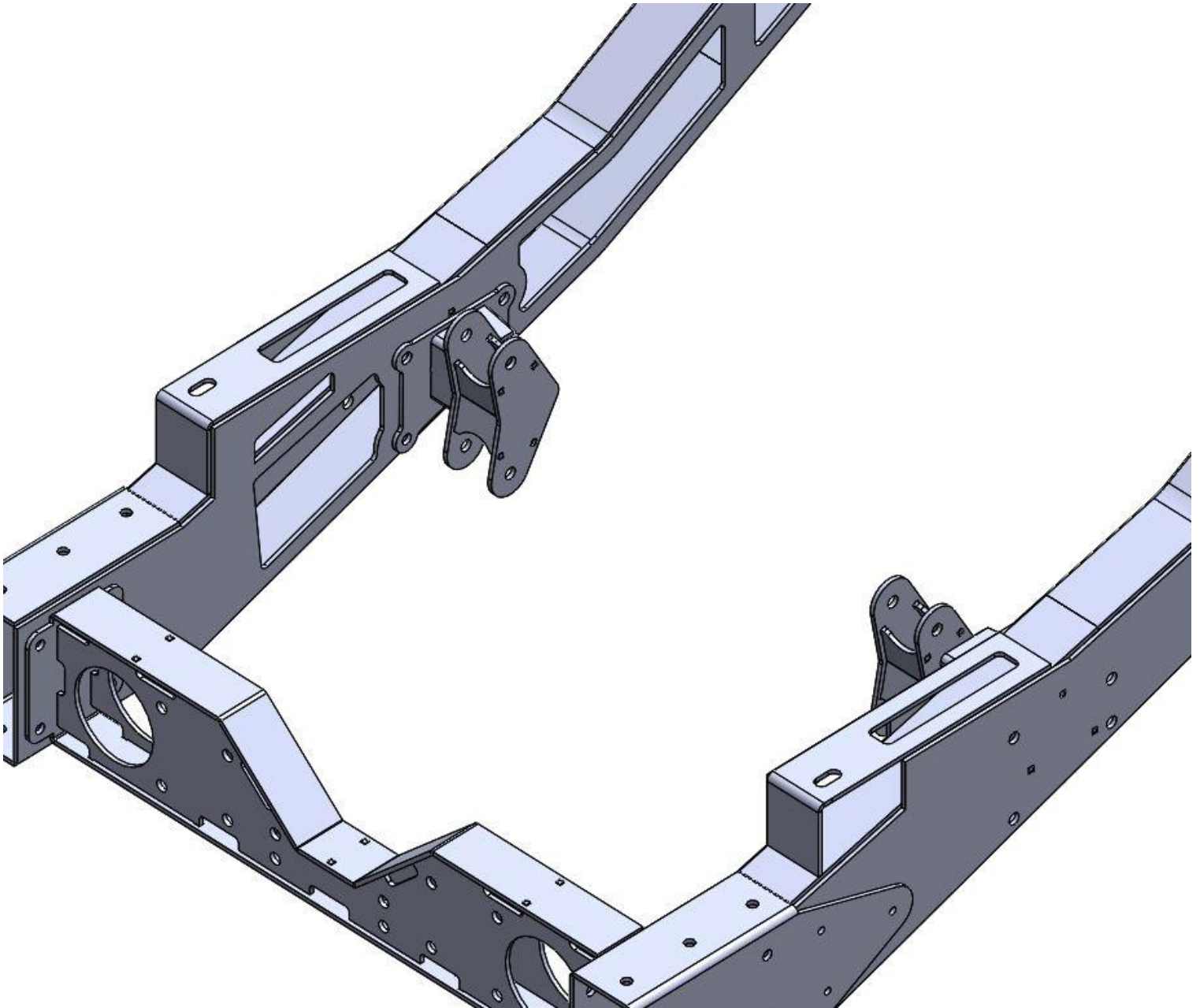
-TAKE TIME TO ENSURE IT IS LEVEL AND SQUARE TO BACK HALF ASSEMBLY

*****TORQUE 7/16 GRADE 8 HARDWARE TO 65 FT. LBS*****



-INSTALL FOUR LINK TO FRAME MOUNTING BRACKETS USING SUPPLIED GRADE 8 HARWDARE

*****TORQUE 7/16 GRADE 8 HARDWARE TO 65 FT. LBS*****



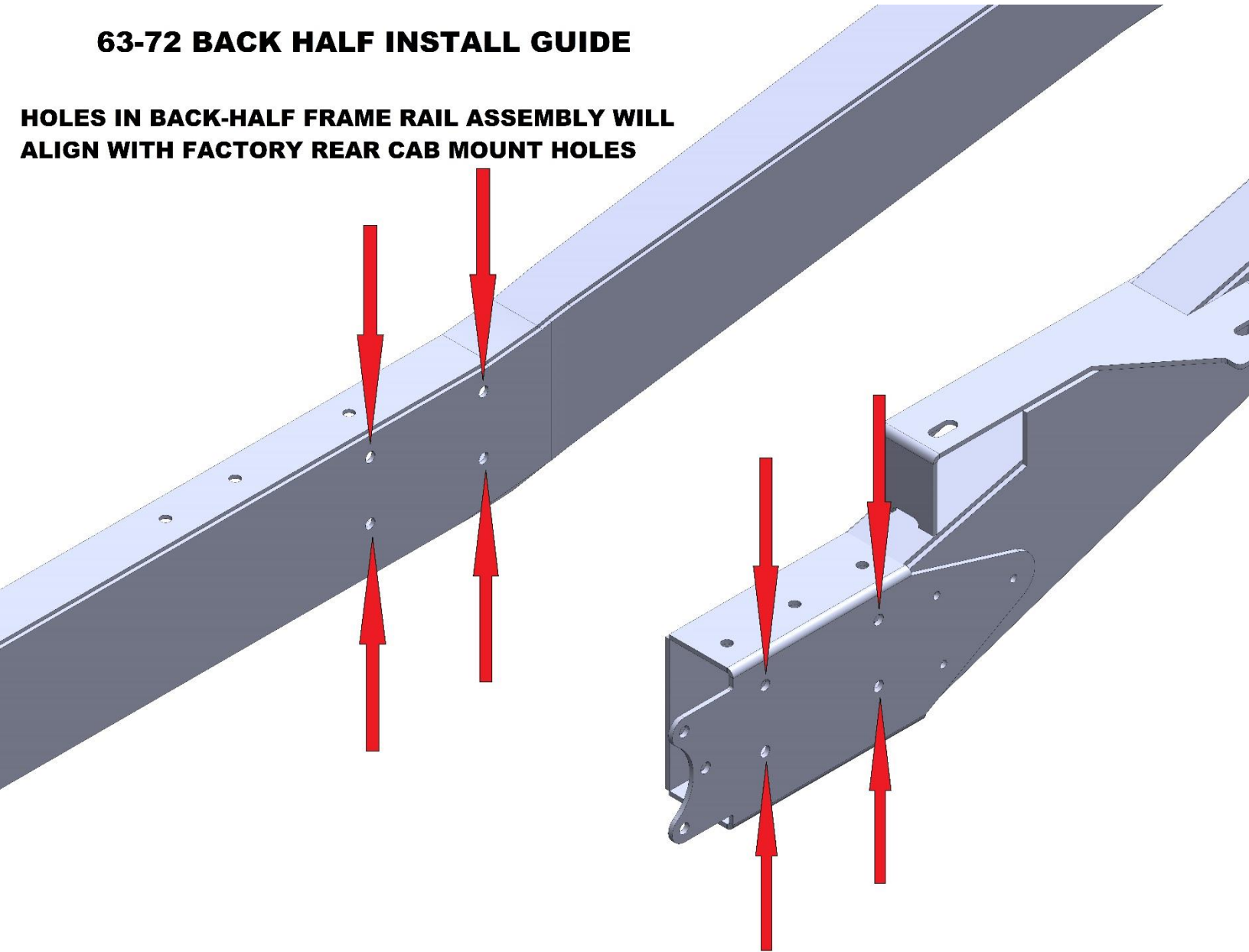
-CUT FACTORY FRAME FOR BACKHALF INSTALLATION

-SEE IMAGES BELOW AND ON NEXT PAGE FOR CUT DIMENSIONS AND BACK HALF LOCATION

-ALL 7/16 GRADE 8 HARDWARE WILL BE TORQUED TO 65 FT-LBS

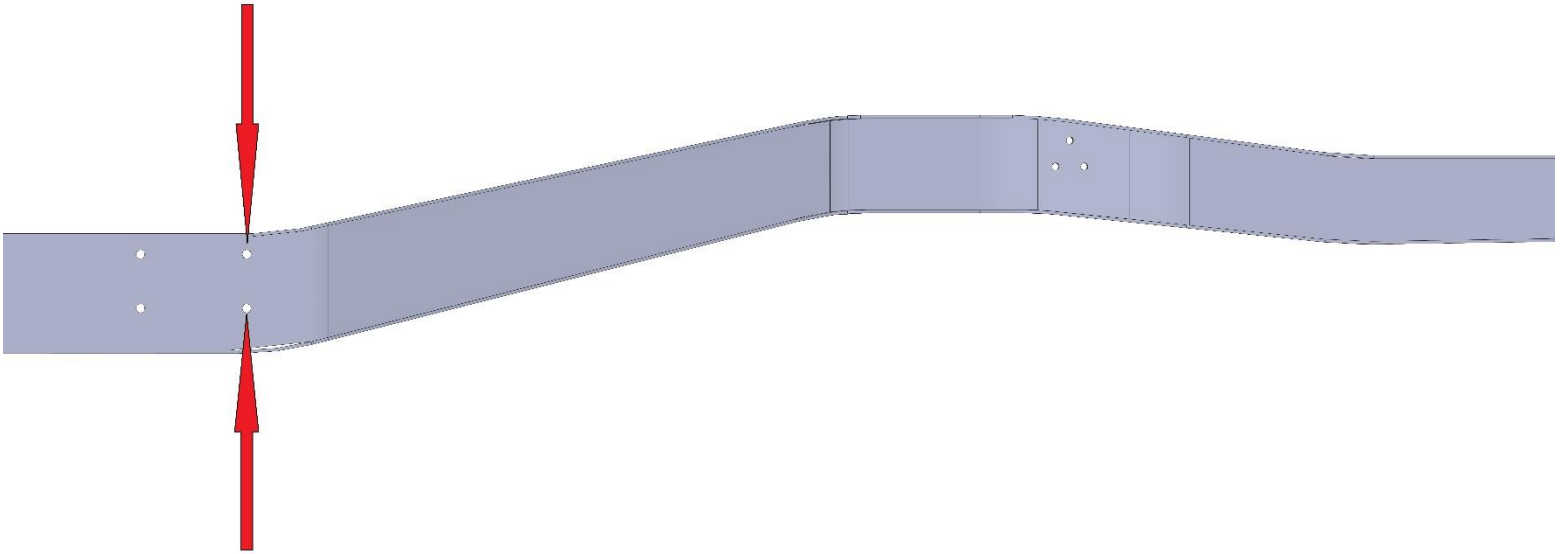
63-72 BACK HALF INSTALL GUIDE

HOLES IN BACK-HALF FRAME RAIL ASSEMBLY WILL ALIGN WITH FACTORY REAR CAB MOUNT HOLES



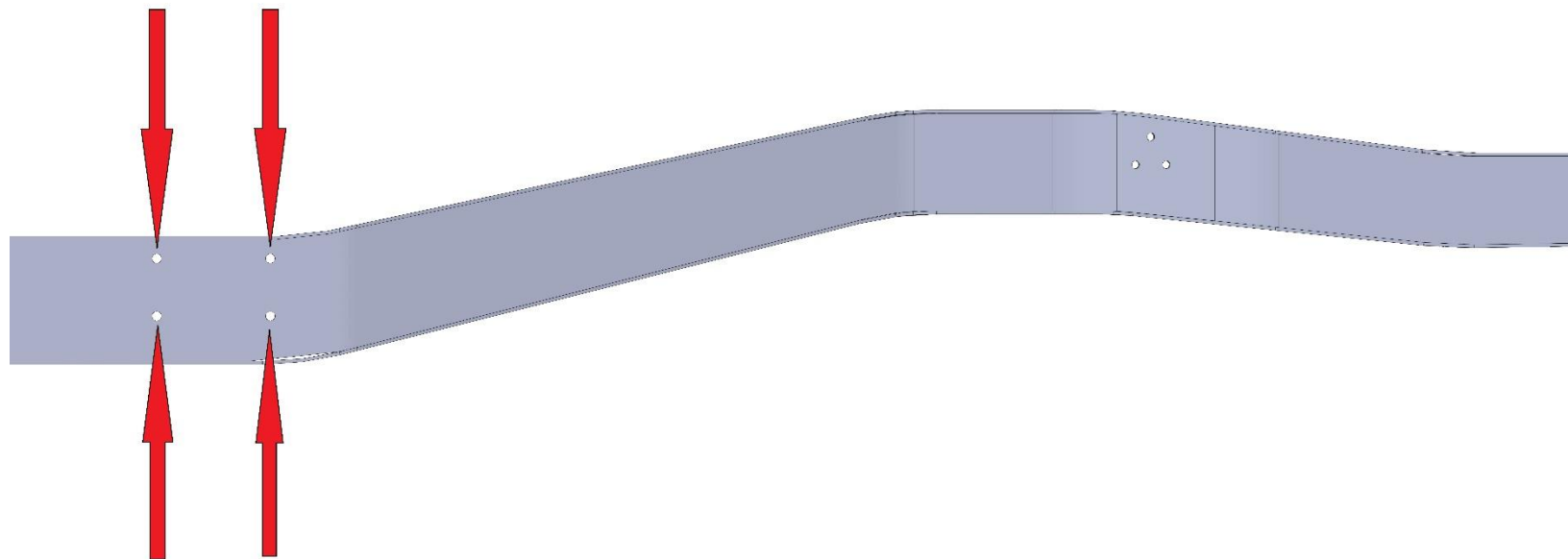
63-72 BACK HALF INSTALL GUIDE

CUT THE REAR SECTION OF THE FRAME OFF AT 1 1/2 INCHES REARWARD OF THE REAR MOUNTING HOLES CENTERLINE FOR FACTORY REAR CAB MOUNT BRACKET

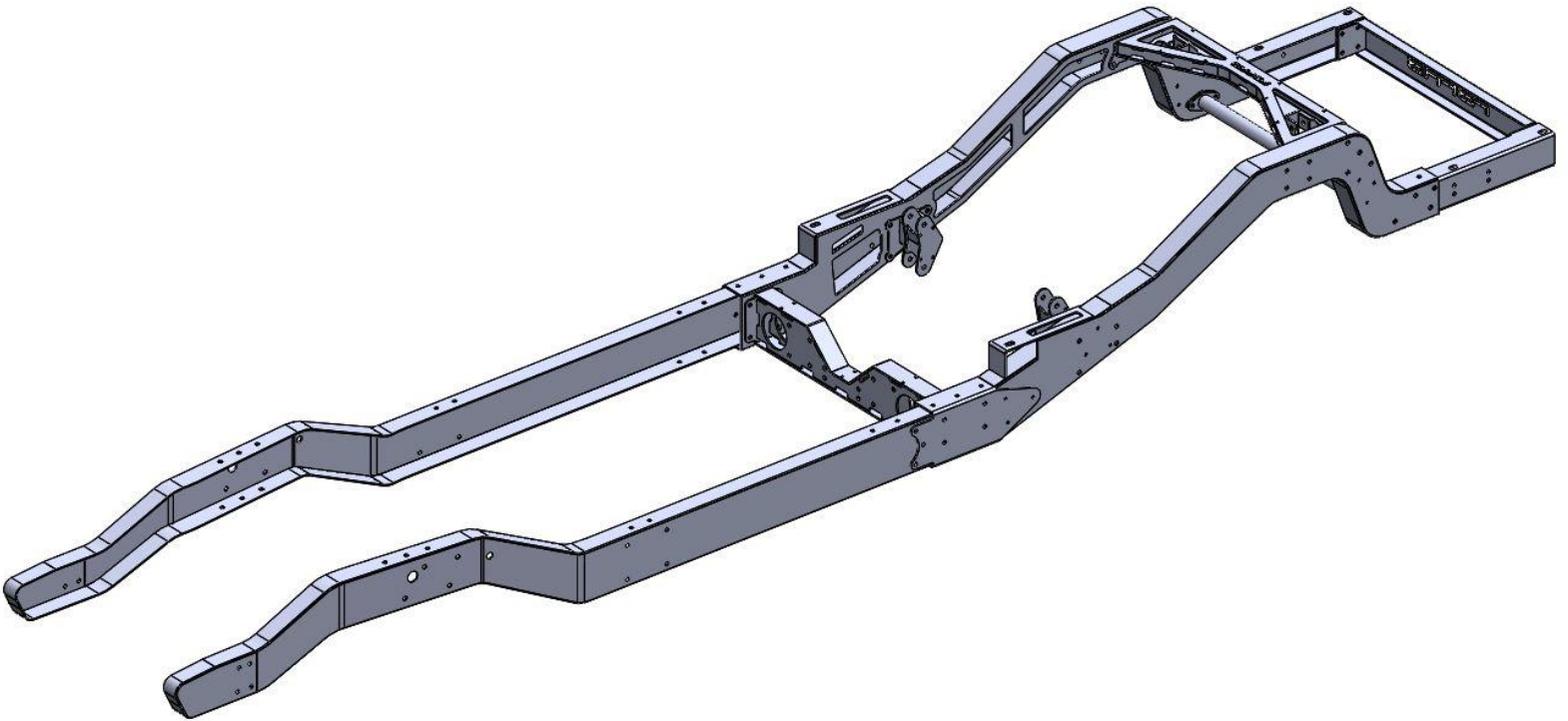


63-72 BACK HALF INSTALL GUIDE

THE FACTORY REAR CAB MOUNTING HOLES WILL BE USED FOR REAR FRAME RAIL ALIGNMENT/INSTALLATION



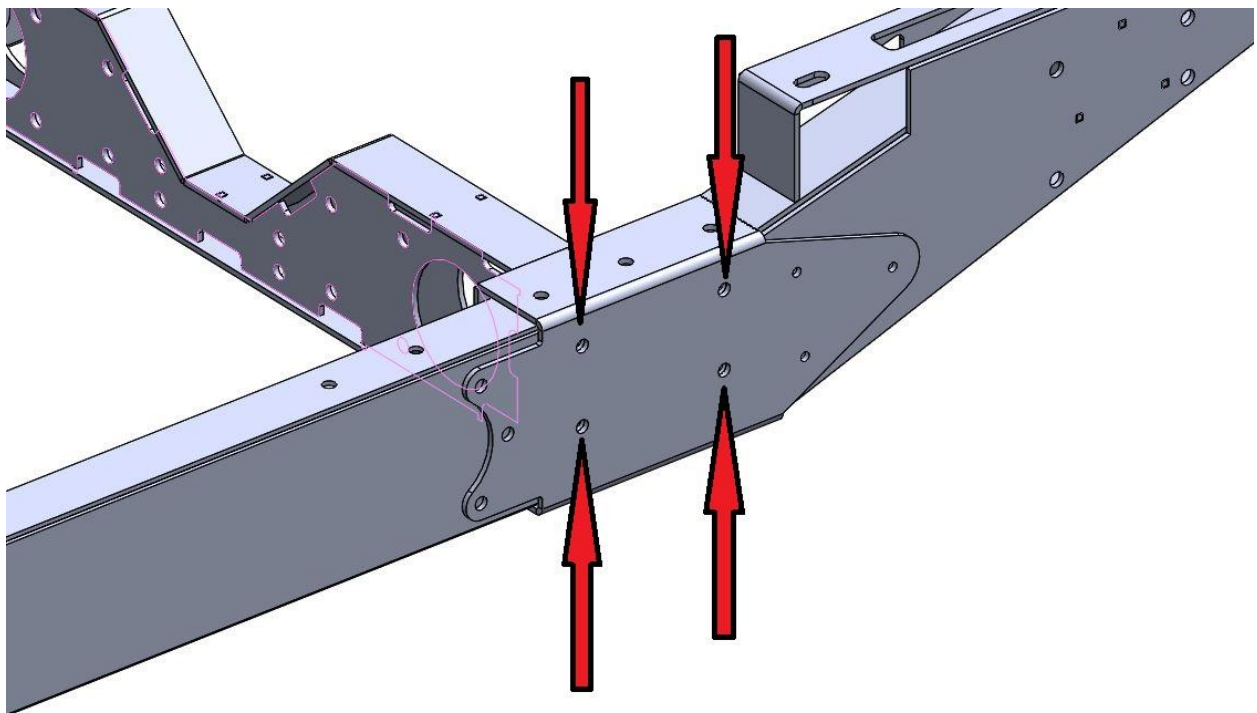
AFTER CUTTING FACTORY FRAME RAILS SLIDE BACKHALF ASSEMBLY INTO PLACE



-FACTORY REAR CAB MOUNT HOLES WILL ALIGN WITH HOLES IN SIDE OF BACK HALF FRAME RAIL ASSEMBLY

-INSTALL SUPPLIED GRADE 8 MOUNTING HARDWARE ENSURING BACKHALF ASSEMBLY IS SQUARE TO FACTORY FRAME RAILS

*****TORQUE 7/16 GRADE 8 HARDWARE TO 65 FT. LBS*****

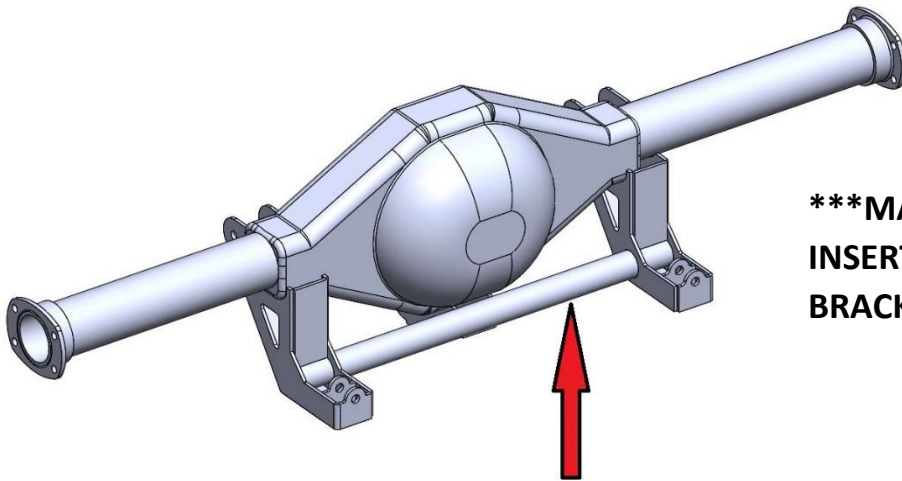
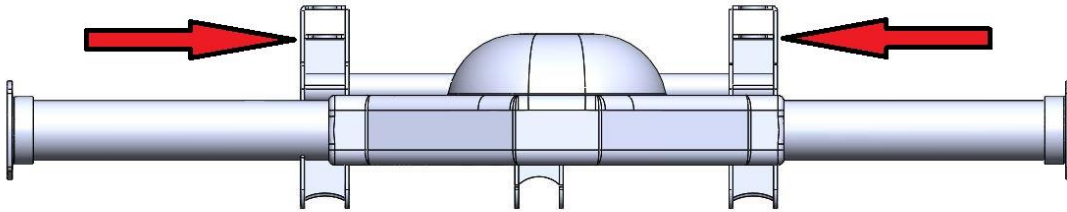


4-LINK/COIL-OVER MOUNTING BRACKET INSTALLATION

- SET DISTANCE FROM OUTSIDE EDGE TO OUTSIDE EDGE OF 4-LINK AXLE MOUNTING BRACKETS TO 24 INCHES
- ENSURE SPREADER TUBE IS INSERTED INTO THE MOUNTING BRACKETS
- SET REAR FACE OF 4-LINK MOUNTING BRACKETS PARALLEL TO FACE OF AXLE HOUSING
- TACK 4-LINK/BAG MOUNTING BRACKETS TO AXLE HOUSING AT THIS TIME

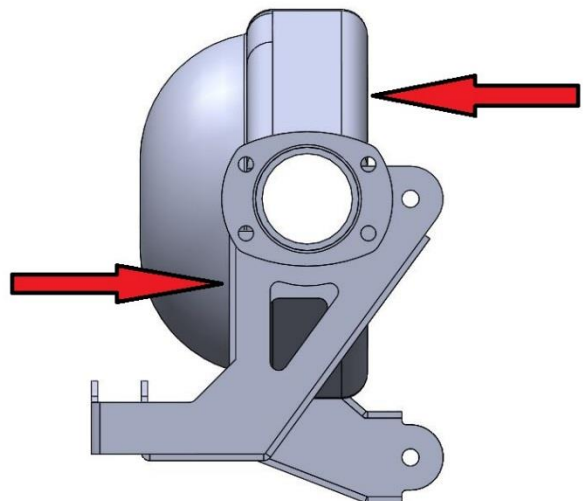
(*DO NOT YET FULLY WELD BRACKETS UNTIL AFTER DRIVE-TRAIN AND DRIVE-SHAFT ARE INSTALLED AND PROPER DRIVE-LINE ANGLES ARE CONFIRMED***)**

*****24 INCHES OUTSIDE TO OUTSIDE OF MOUNTING BRACKETS*****



*****ENSURE BACK EDGE OF MOUNTING BRACKETS ARE PARALLEL TO FACE OF AXLE HOUSING*****

*****MAKE SURE SPREADER TUBE IS INSERTED BEFORE WELDING BRACKETS TO AXLE*****



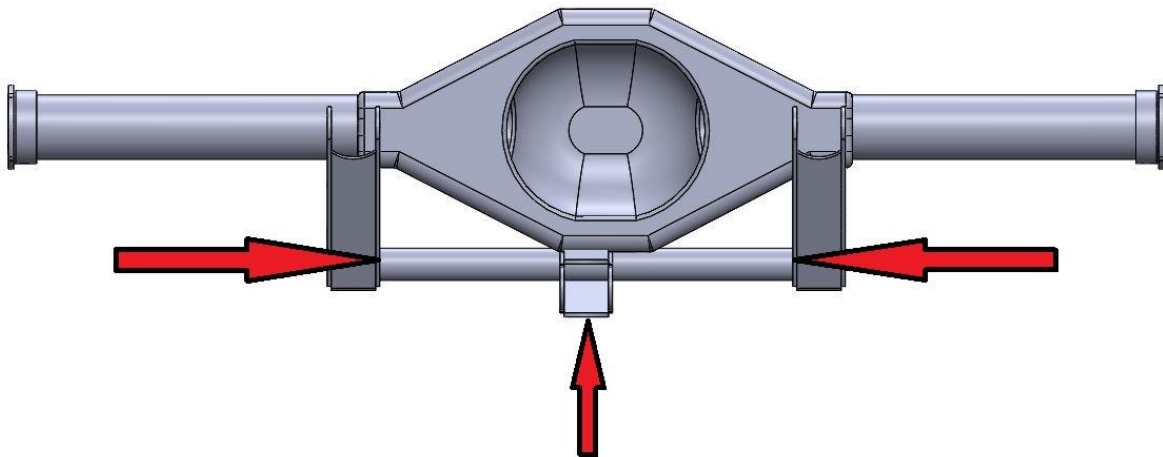
WISHBONE MOUNTING BRACKET INSTALLATION

-WISHBONE MOUNTING BRACKET WILL BE CENTERED BETWEEN 4-LINK/COIL OVER MOUNTING BRACKETS

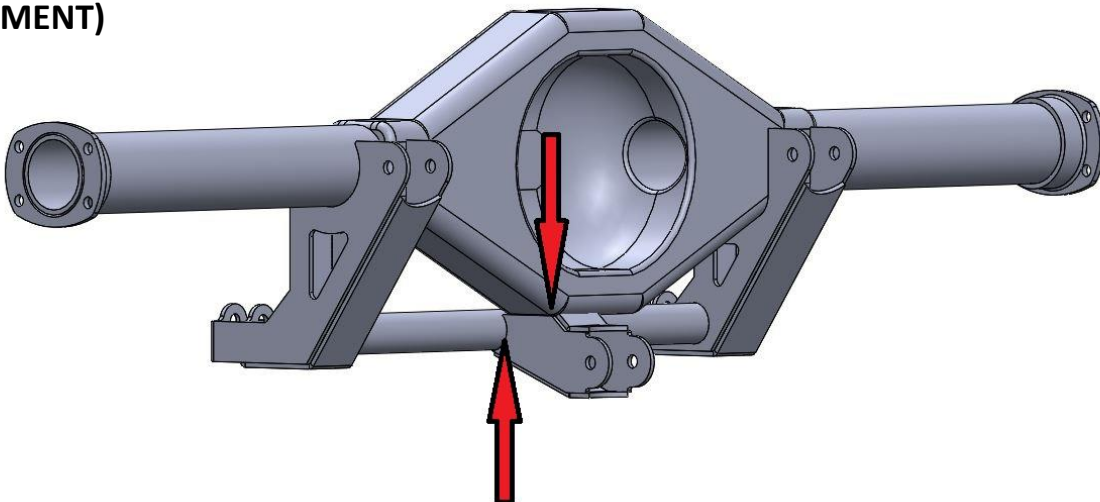
-WISHBONE MOUNTING BRACKET WILL ATTACH TO SPREADER TUBE AND BOTTOM OF REAR AXLE HOUSING (BRACKET MAY NEED TO BE TRIMMED FOR PRECISE FITMENT)

(*DO NOT YET FULLY WELD BRACKETS UNTIL AFTER DRIVE-TRAIN AND DRIVE-SHAFT ARE INSTALLED AND PROPER DRIVE-LINE ANGLES ARE CONFIRMED***)**

*****CENTER WISHBONE MOUNTING BRACKET*****

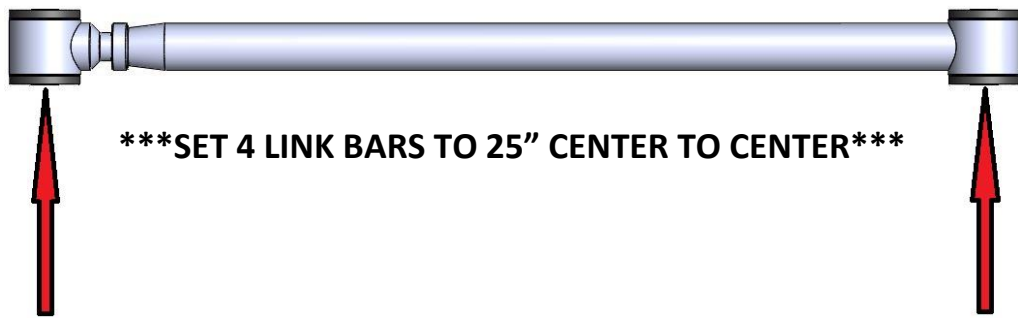


WISHBONE MOUNTING BRACKET WILL ATTACH TO SPREADER TUBE AND BOTTOM OF AXLE HOUSING (TRIMMING MAY BE NECESSARY FOR PRECISE FITMENT)

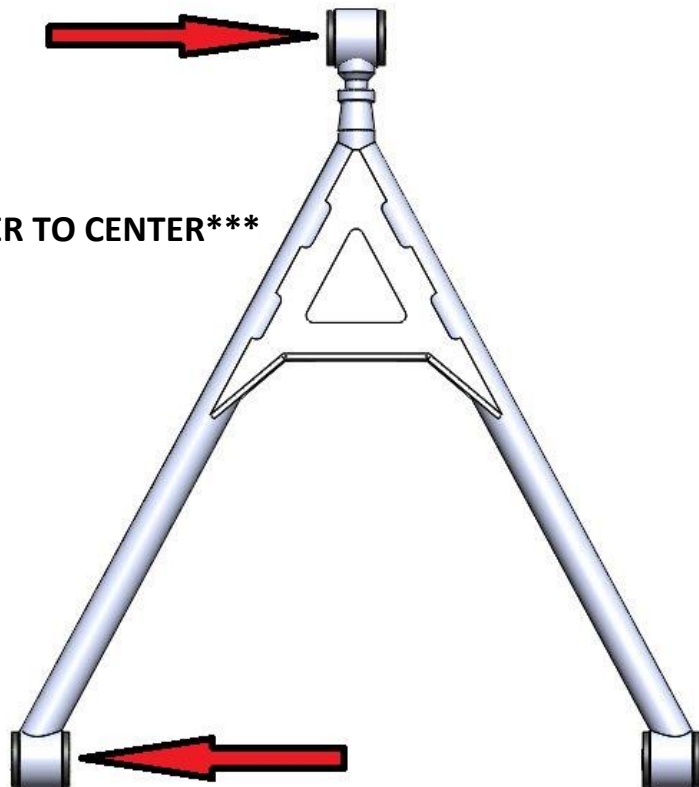


LINK BAR/WISHBONE INSTALLATION

- SET MOUNTING DISTANCE OF 4-LINK BARS TO 25" CENTER TO CENTER
- SET MOUNTING DISTANCE OF LOWER WISHBONE TO 25" CENTER TO CENTER

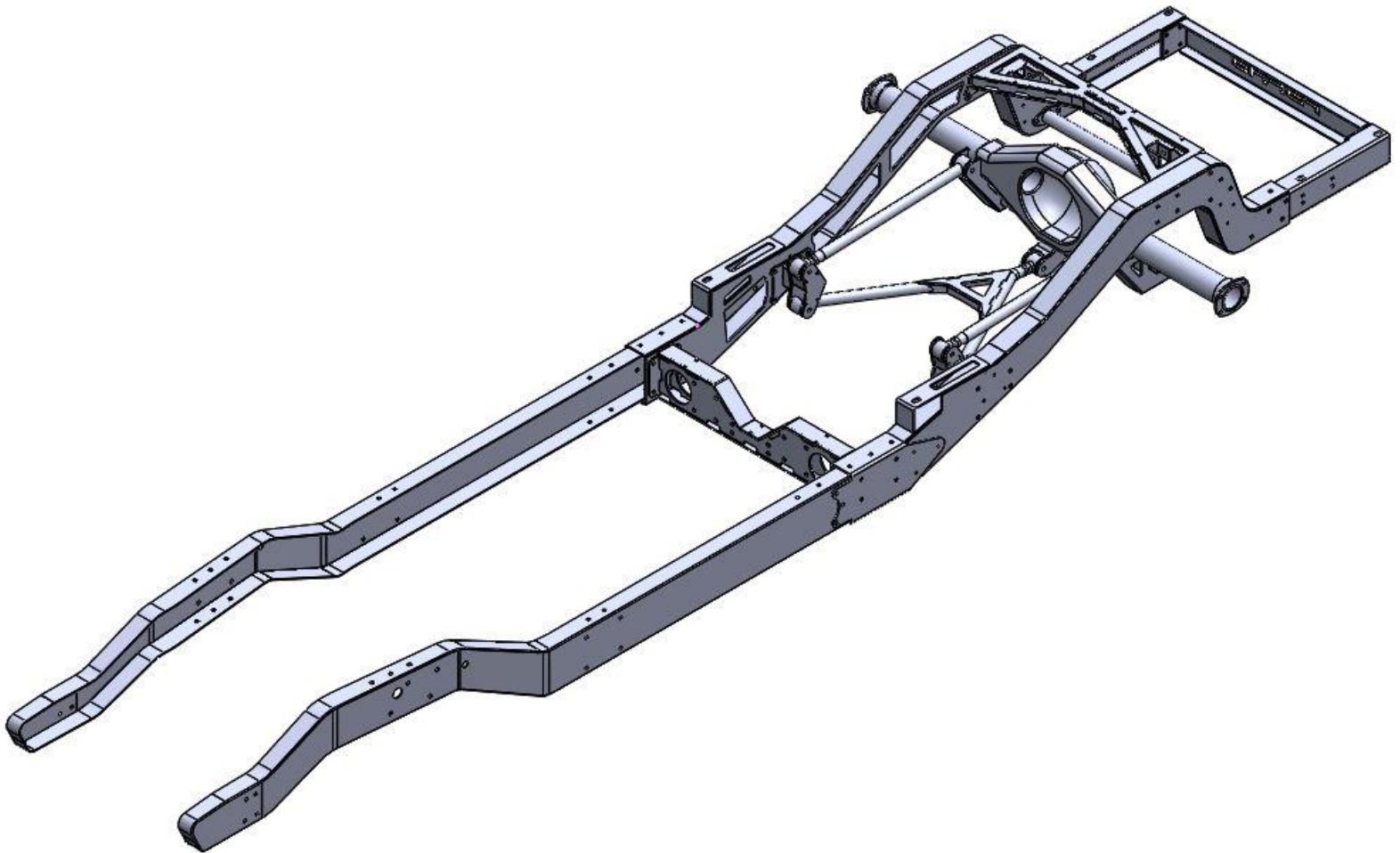


*****SET WISHBONE TO 25" CENTER TO CENTER*****



**INSTALL REAR DIFFERENTIAL, 4-LINK BARS, AND LOWER WISHBONE USING
SUPPLIED GRADE 8 HARDWARE**

*****TORQUE 1/2 GRADE 8 HARDWARE TO 75 FT. LBS*****



FOR ANY ADDITIONAL HELP OR INFORMATION PLEASE CONTACT PBFAB

TECH@PBFAB.COM

480-310-9847 (ACCEPTS PHONE CALLS AND TEXT MESSAGES)