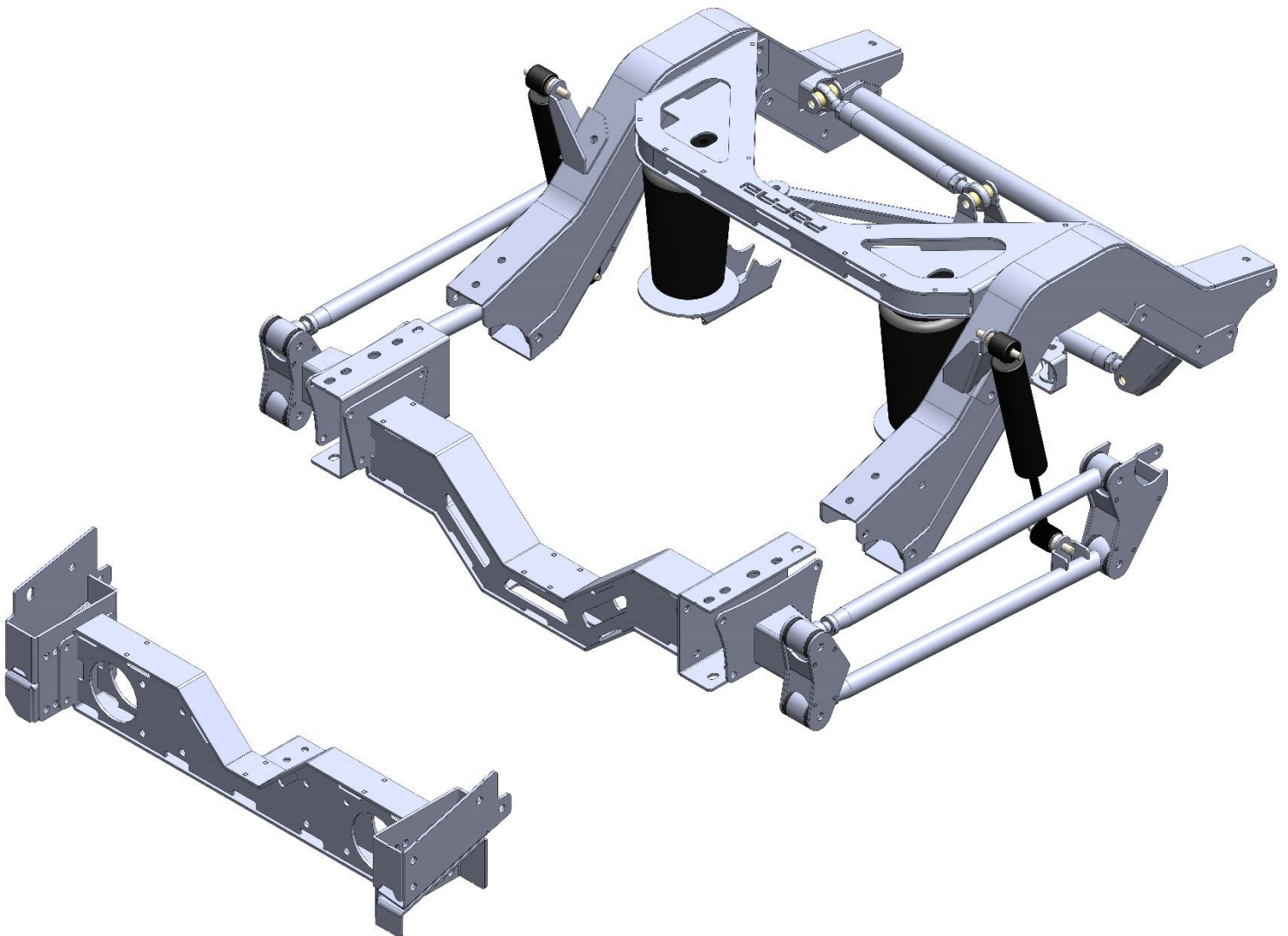


PORTERBUILT FABRICATION

DROPMEMBER REAR 73-87 LEVEL 3 INBOARD BAGS OUTBOARD 4-LINK KIT INSTALL GUIDE



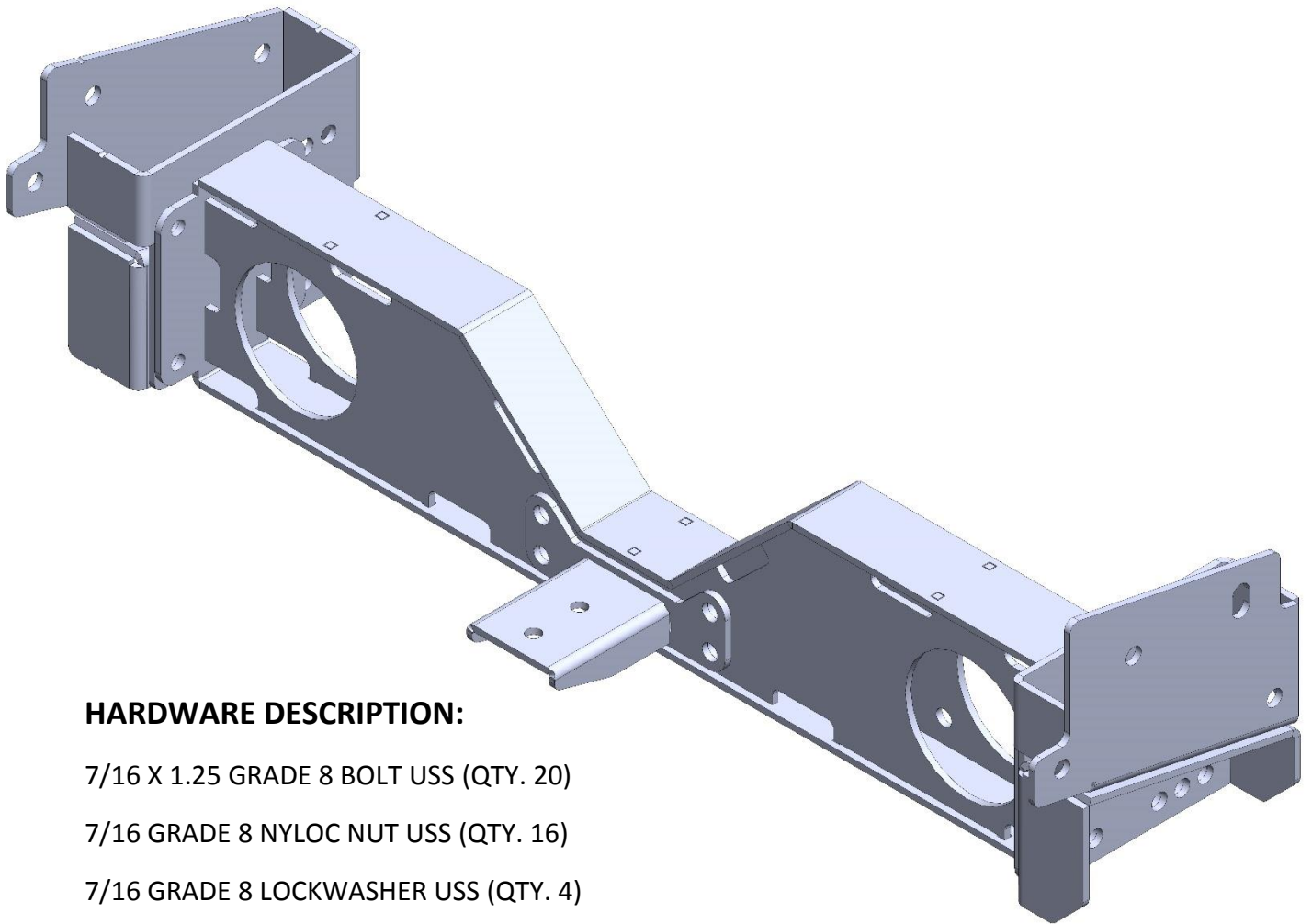
12/2/2019

SECTION 1: INDIVIDUAL COMPONENTS WITH HARDWARE DESCRIPTIONS.

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

PART# CBXM7387

DESCRIPTION: CARRIER BEARING X-MEMBER; 73-87 C10



HARDWARE DESCRIPTION:

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

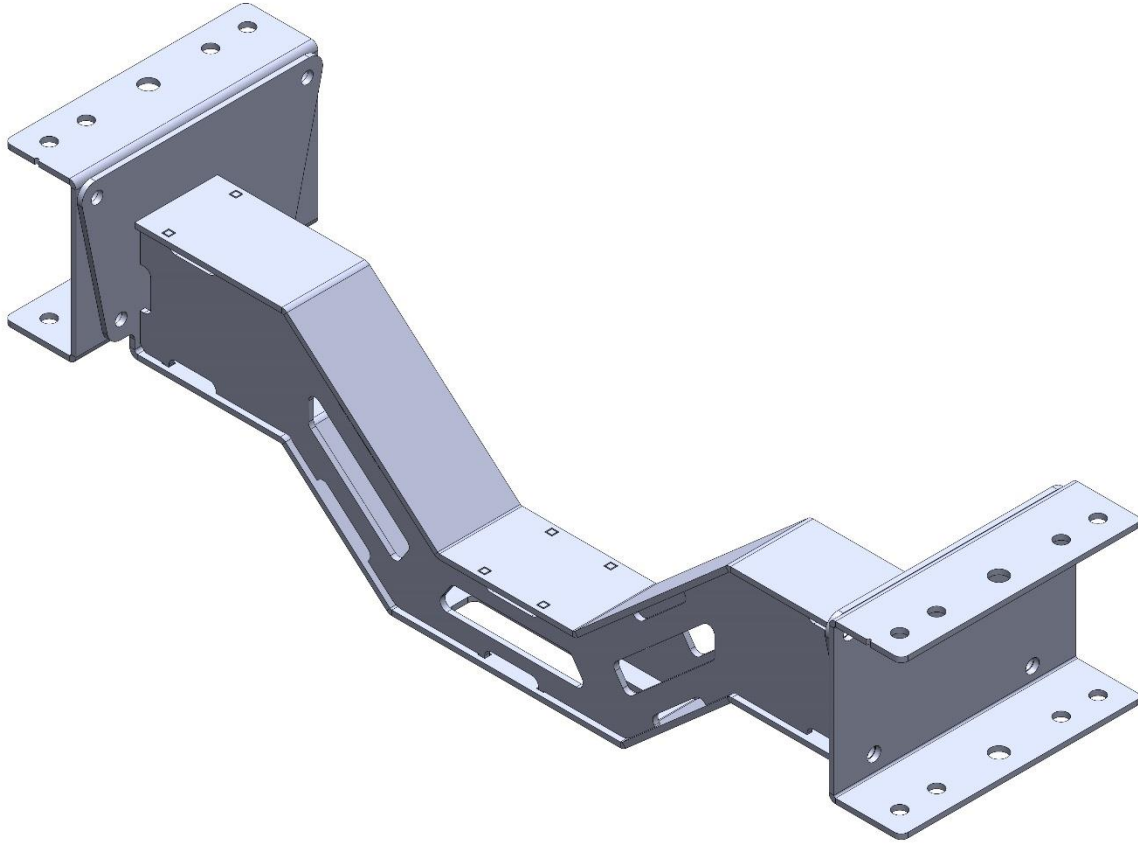
7/16 GRADE 8 NYLOC NUT USS (QTY. 16)

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

3/8 GRADE 8 FLAT WASHER USS (QTY. 36)

PART# 4LXM7387-O4L

DESCRIPTION: 4-LINK CROSSMEMBER 73-87 OUTBOARD 4-LINK



HARDWARE DESCRIPTION:

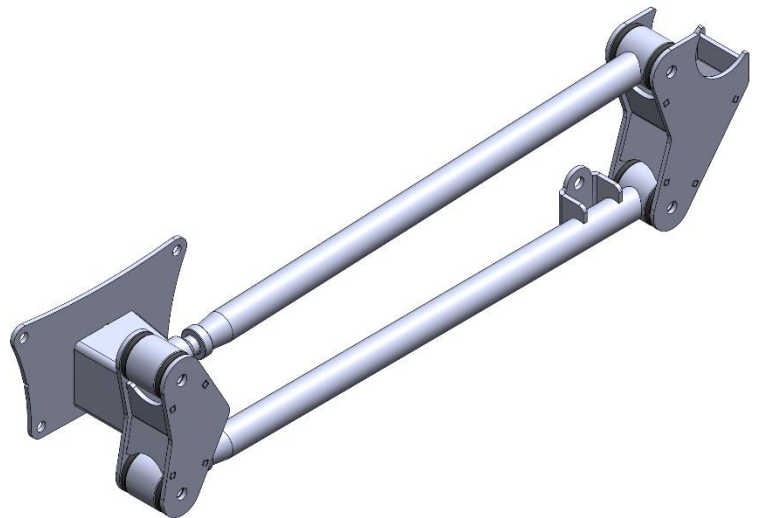
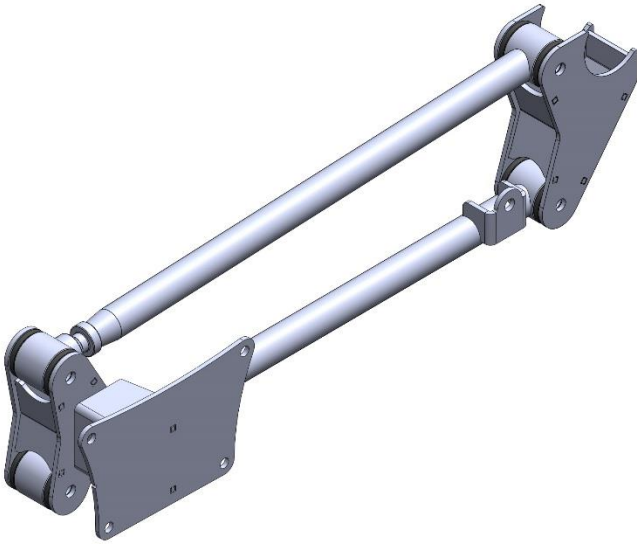
7/16 X 1.25 GRADE 8 BOLT USS (QTY. 16)

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

3/8 GRADE 8 FLAT WASHER (QTY. 32)

PART# 4L7387-3

DESCRIPTION: 4 LINK; 73-87; LEVEL 3



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)

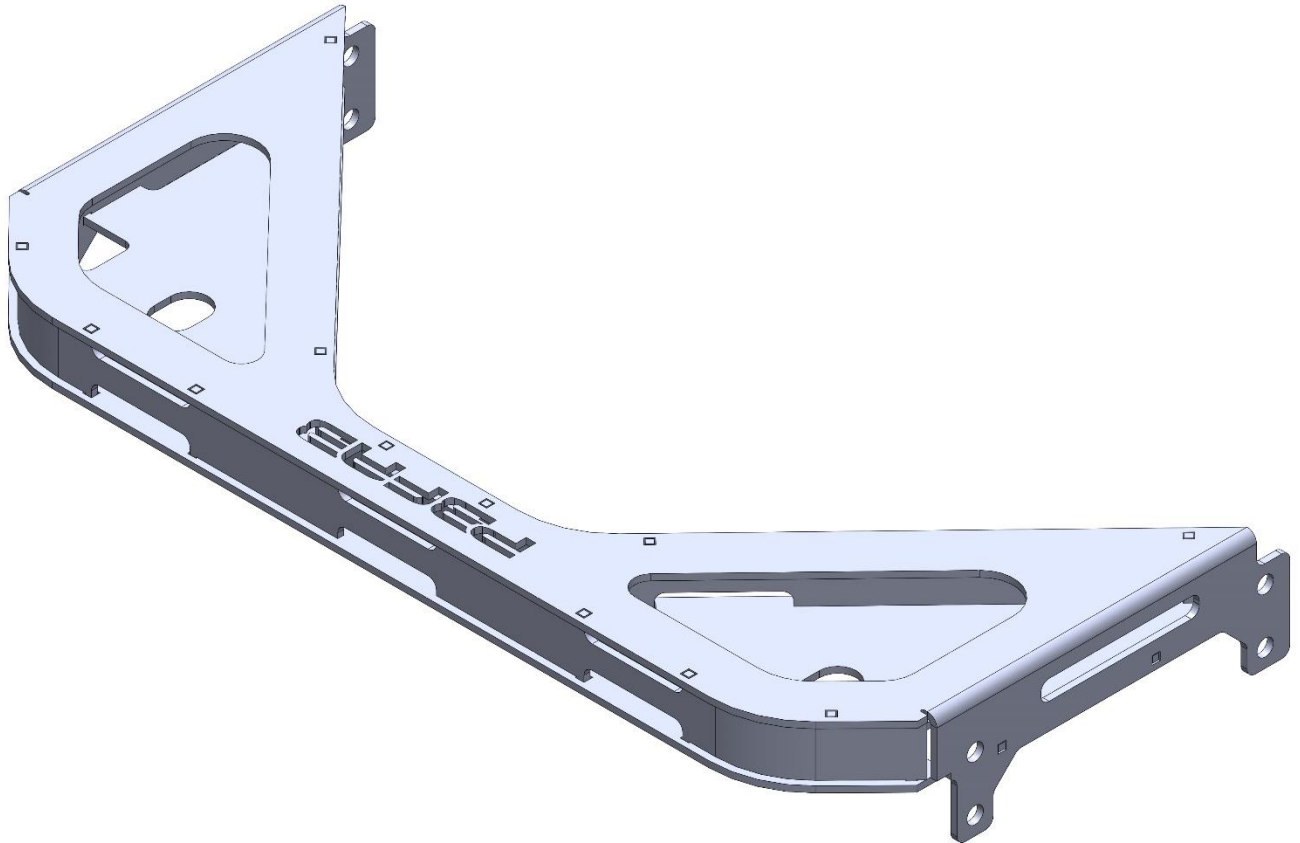
POLY BUSHING HALF; 4-LINK SPECIFIC (QTY. 16)

4-LINK BUSHING CRUSH TUBE (QTY. 8)

ZERK FITTINGS (QTY. 8)

PART# BA7387-IB-OS

DESCRIPTION: BRIDGE ASSEMBLY; 73-87 C10 GM; INBOARD BAG; OUTBOARD SHOCK. (COMPATIBLE WITH MULTIPLE REAR KITS)



HARDWARE DESCRIPTION:

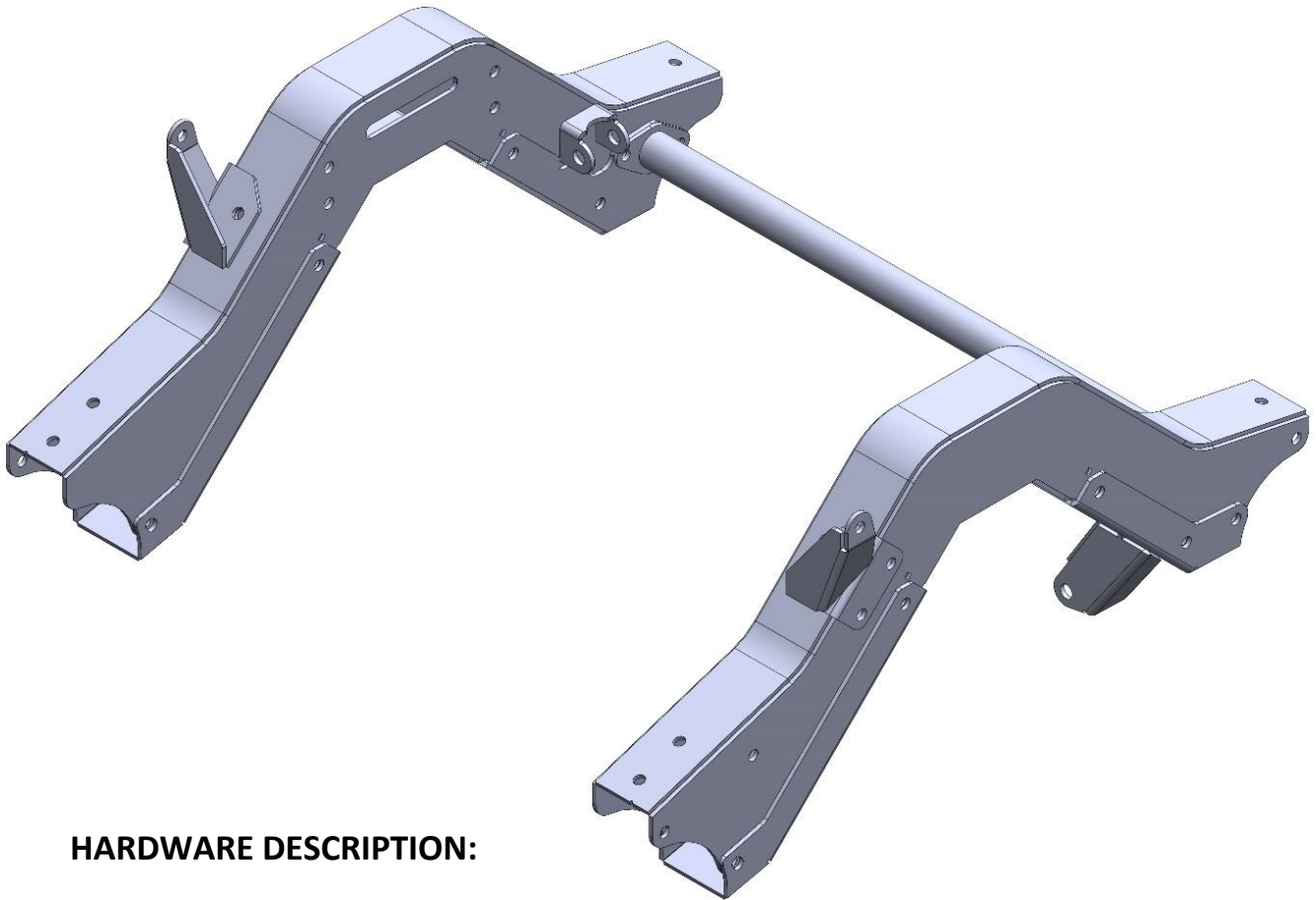
7/16 X 1.25 GRADE 8 BOLT USS (QTY. 8)

7/16 GRADE 8 LOCKWASHER (QTY. 8)

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

PART# RN7387-3-B-WL

DESCRIPTION: REAR NOTCH; 73-87 C10; LEVEL 3; BOLT IN; WATTS LINK SPECIFIC



HARDWARE DESCRIPTION:

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

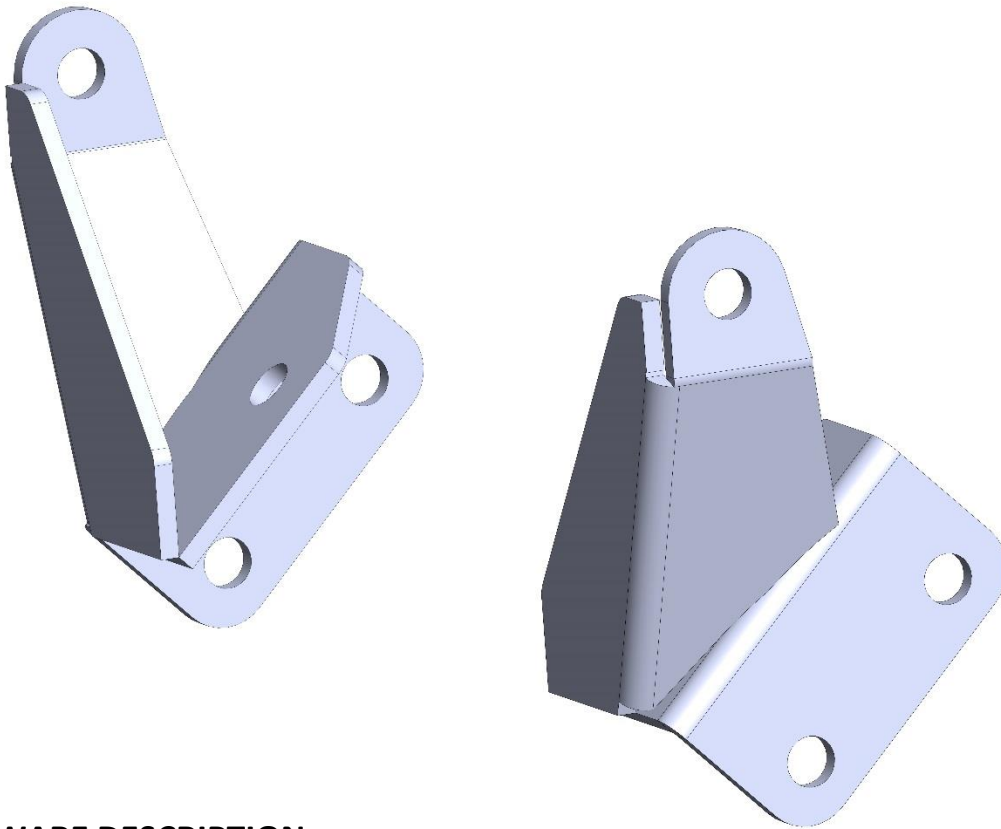
7/16 GRADE 8 NYLOC NUT USS (QTY. 26)

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

3/8 GRADE 8 FLAT WASHER USS (QTY. 66)

PART# RUSM7387-OB

DESCRIPTION: REAR UPPER SHOCK MOUNT 73-87; OUTBOARD SHOCK



HARDWARE DESCRIPTION:

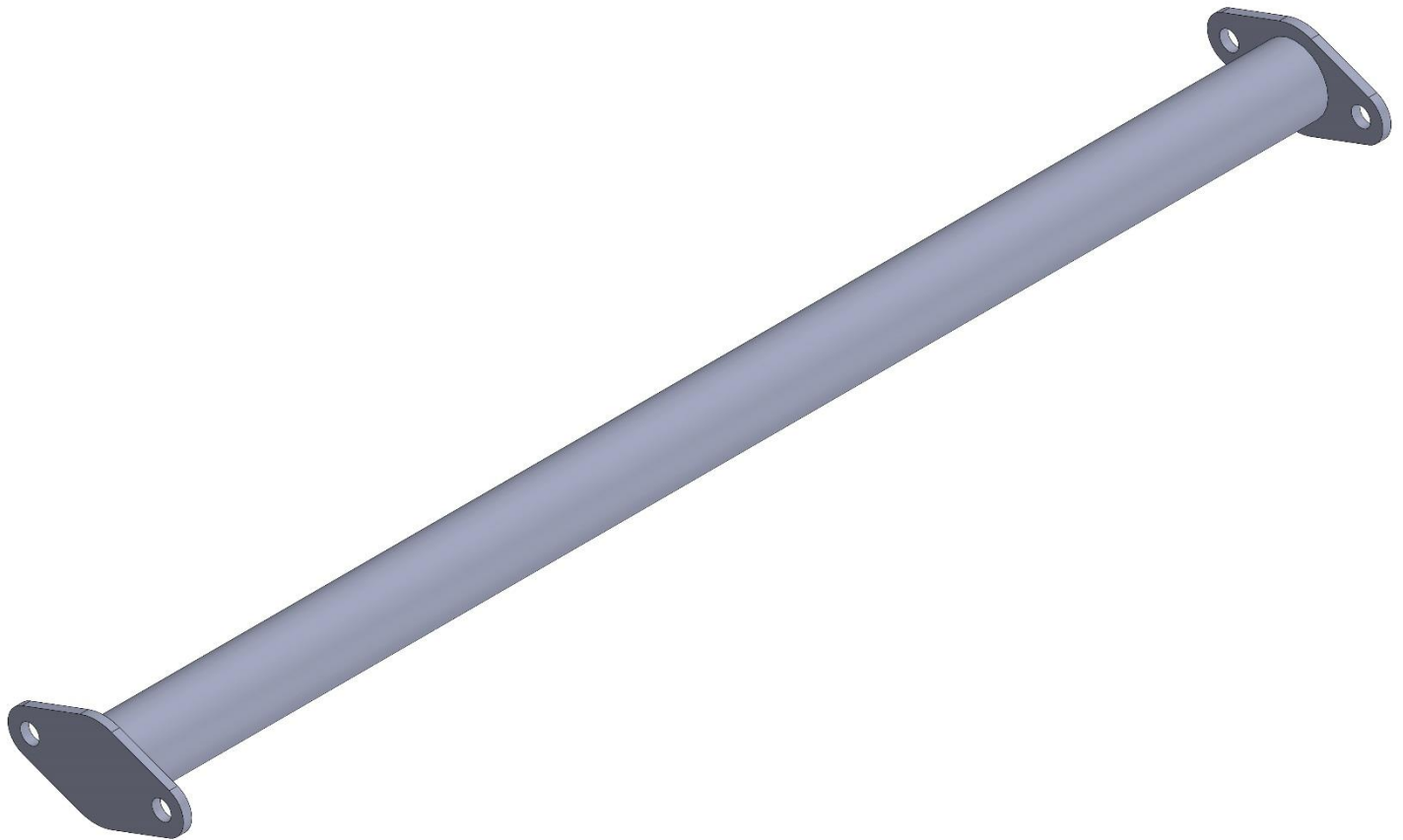
7/16 X 1.25 GRADE 8 BOLT USS (QTY. 6)

7/16 GRADE 8 LOCKWASHER USS (QTY. 6)

3/8 GRADE 8 FLAT WASHER USS (QTY. 6)

PART# RNXM275

DESCRIPTION: REAR NOTCH CROSS MEMBER 27 ½ INCHES OVERALL LENGTH



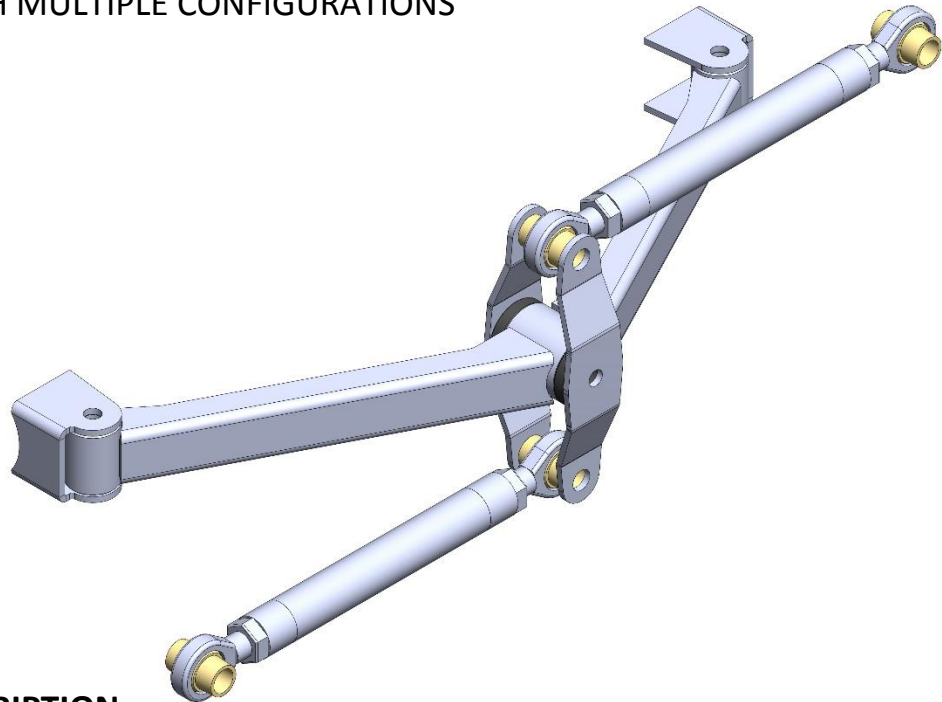
HARDWARE DESCRIPTION:

NO HARDWARE

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)

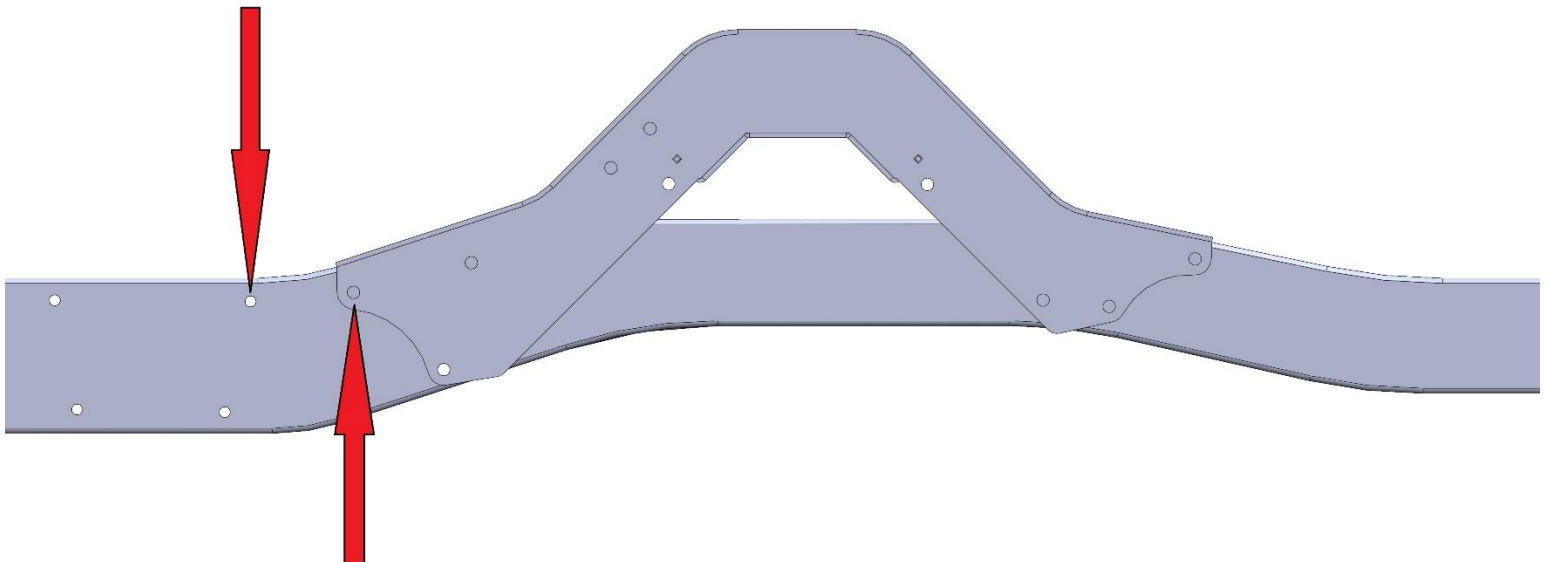
SECTION 2: PARTS INSTALLATION

REAR NOTCH INSTALLATION

- IT WILL BE NECESSARY TO TRIM FRAME RAILS SO THAT THE NOTCH WILL EASILY SLIDE OVER RAIL WITHOUT RESISTANCE
- USE MEASUREMENT BELOW FOR PROPER FORE-AFT LOCATION
- 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)
- 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*****)

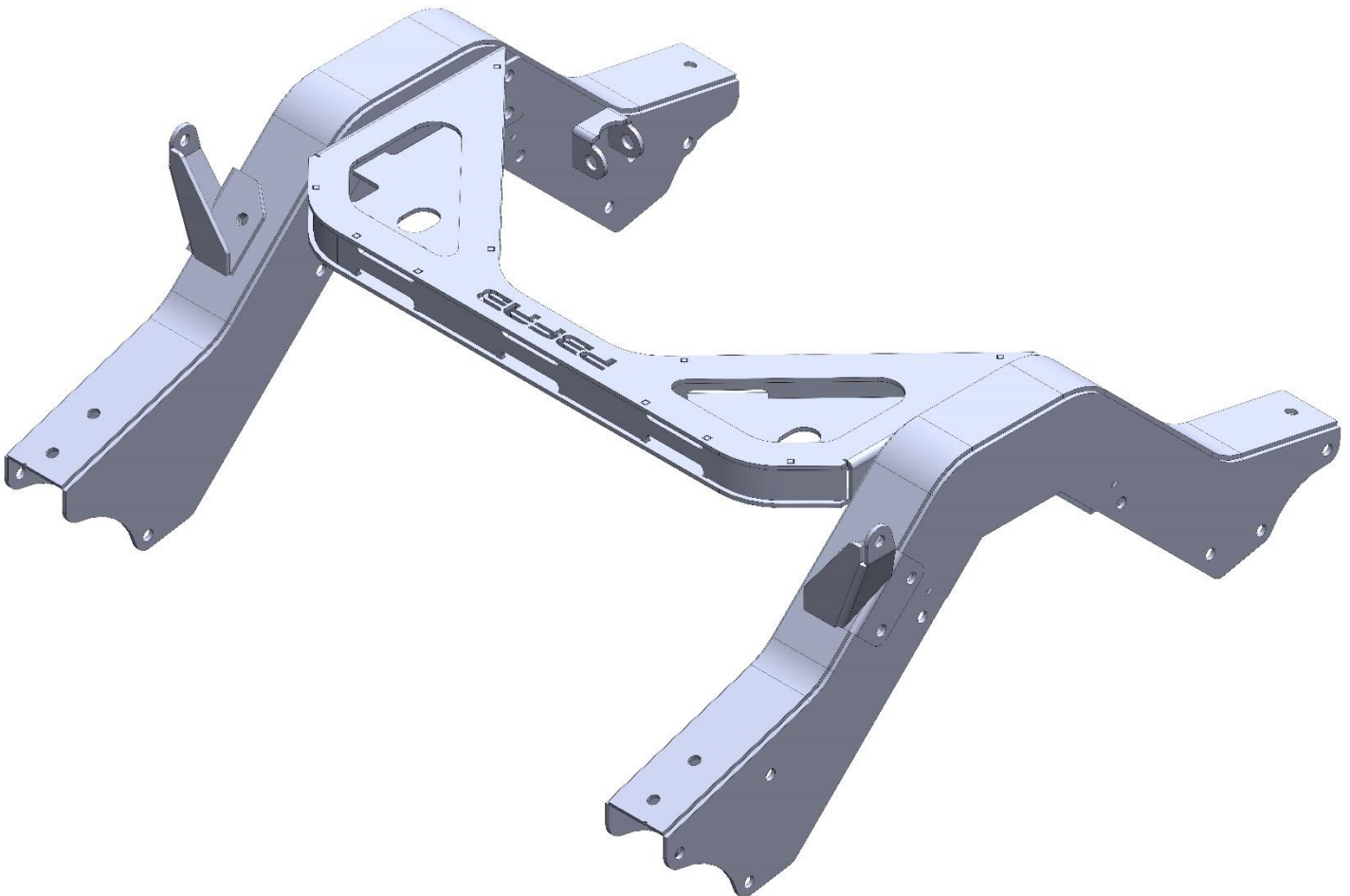
73-87 LEVEL 3 BOLT IN NOTCH MOUNTING LOCATION

SET DISTANCE BETWEEN UPPER REAR MOUNTING HOLE FOR FRONT LEAF SPRING HANGER AND FRONT-MOST MOUNTING HOLE IN NOTCH TO 4 1/8 INCHES



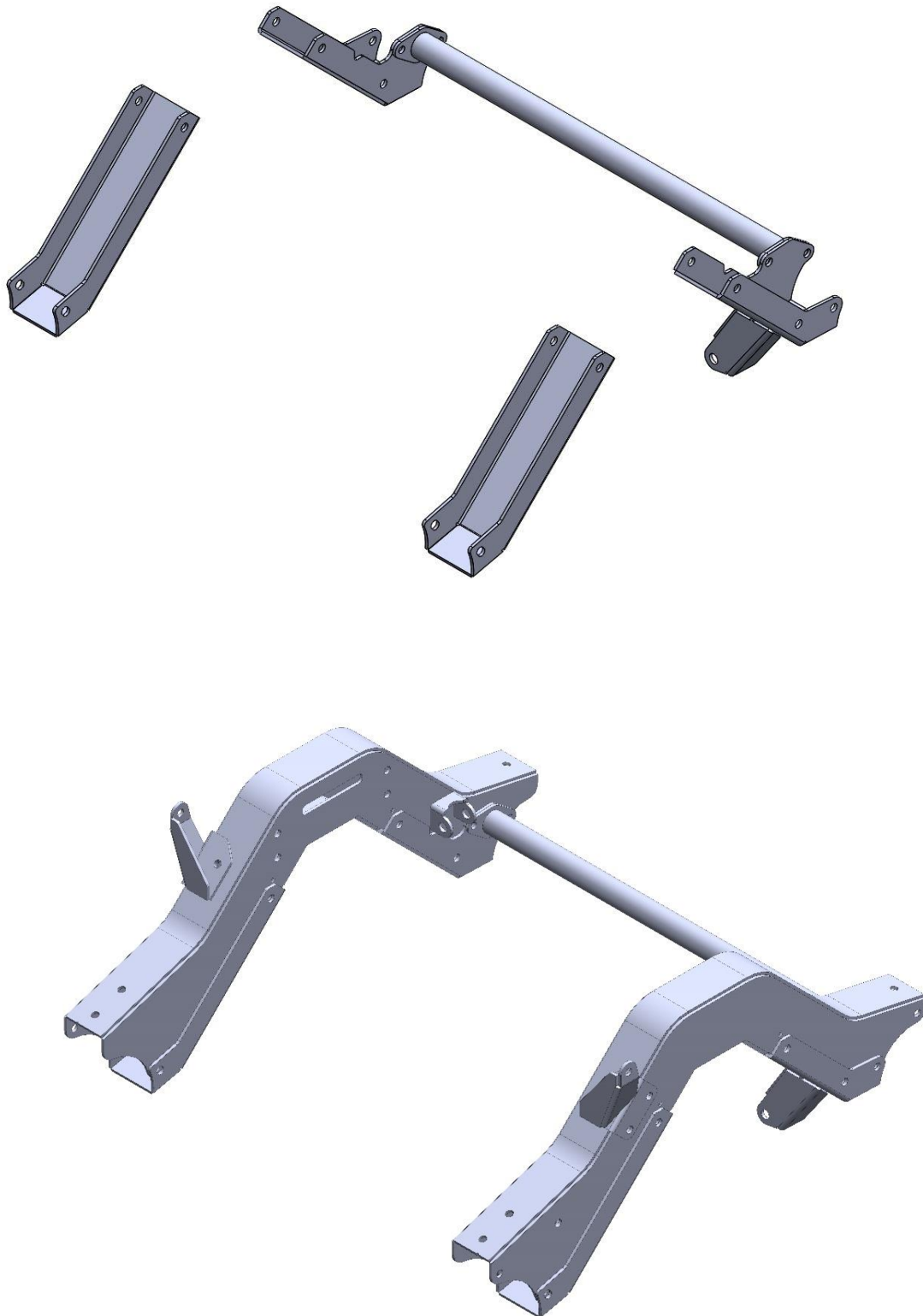
BRIDGE ASSEMBLY INSTALLATION

- INSTALL BRIDGE ASSEMBLY USING SUPPLIED GRADE 8 HARDWARE
- INSTALL REAR UPPER SHOCK MOUNTS
- DO NOT YET FULLY TIGHTEN BRIDGE ASSEMBLY MOUNTING HARDWARE (**WILL DO SO AFTER NOTCH CAP AND REAR NOTCH CROSSMEMBER INSTALLATION**)



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



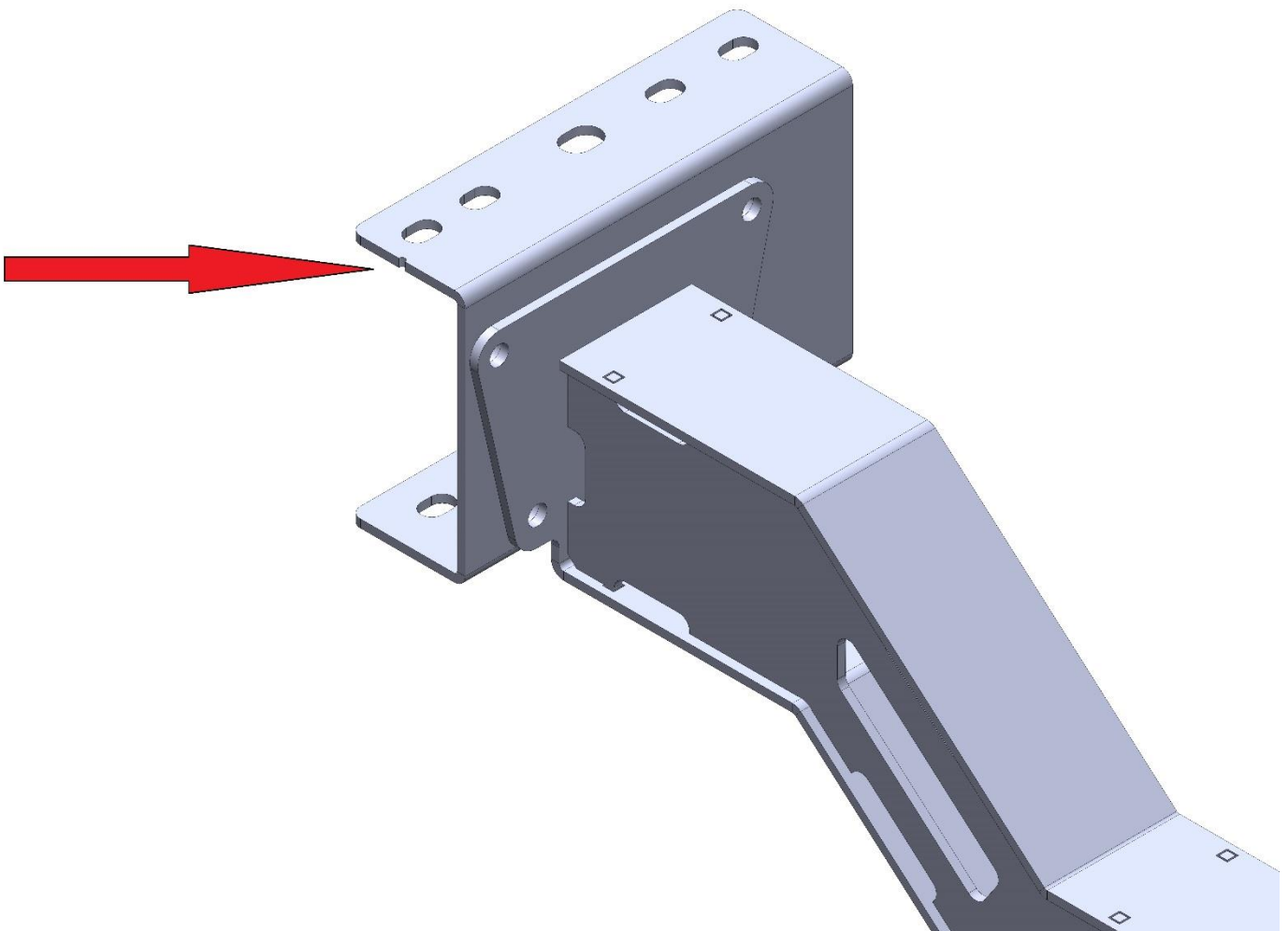
4-LINK CROSSMEMBER INSTALLATION

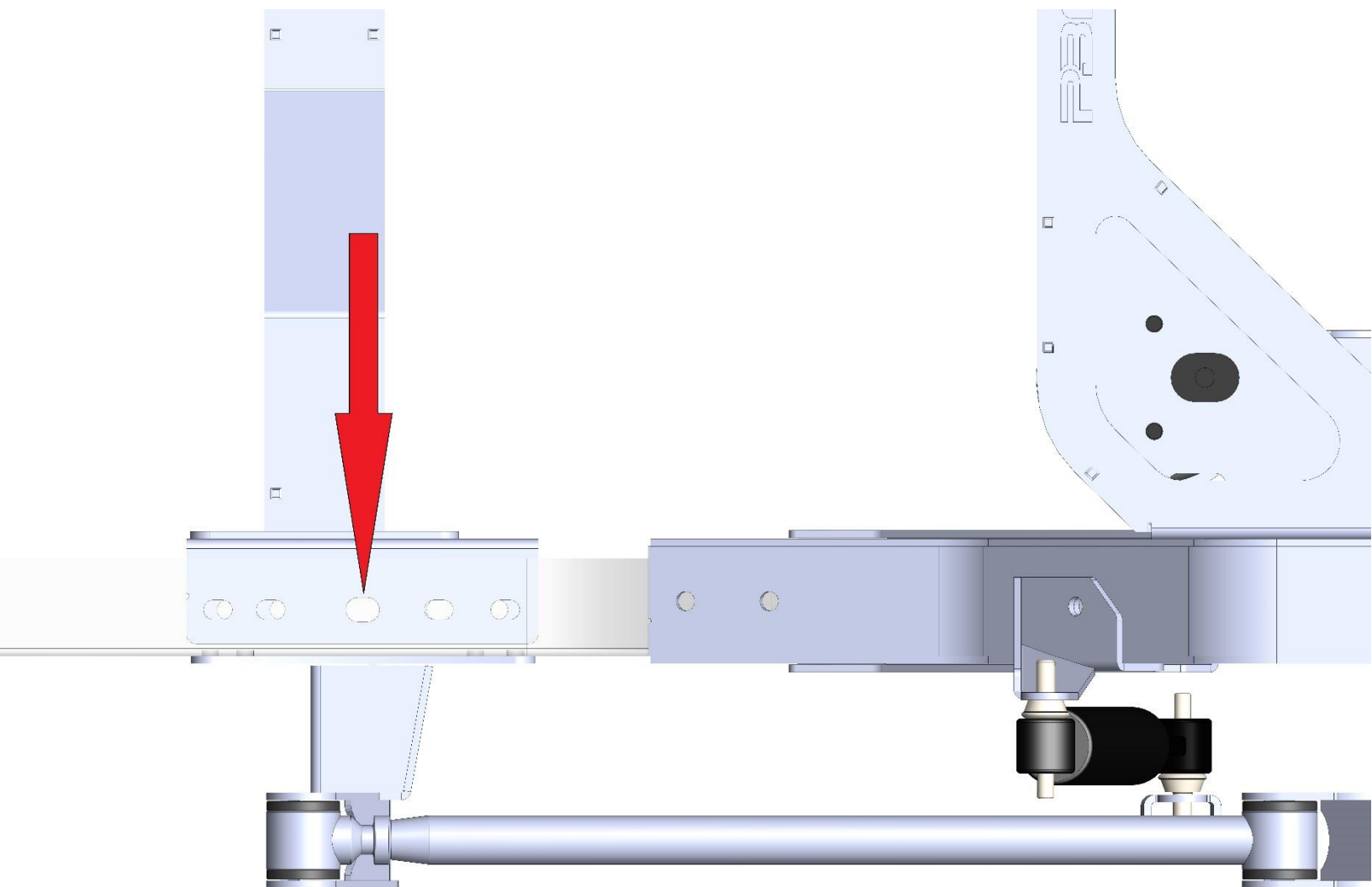
-BEFORE INSTALLING 4-LINK X-MEMBER PLEASE REVIEW IMAGES ON THIS PAGE AND FOLLOWING PAGE

-NOTCH IN C-CHANNEL MOUNTING BRACKET INDICATES TOP AND FRONT

-CENTER HOLE IN TOP OF FRAME C-CHANNEL MOUNTING BRACKET COINCIDES WITH FACTORY BED MOUNTING HOLE (SEE IMAGE ON NEXT PAGE)

-ONCE FORE/AFT PLACEMENT IS CONFIRMED MARK, DRILL, AND INSTALL GRADE 8 MOUNTING HARDWARE; TORQUE TO 65 FT-LBS





*****CENTER HOLE IN TOP OF FRAME C-CHANNEL MOUNTING BRACKET
COINCIDES WITH FACTORY BED MOUNTING HOLE*****

4-LINK FRAME MOUNTING BRACKET INSTALLATION

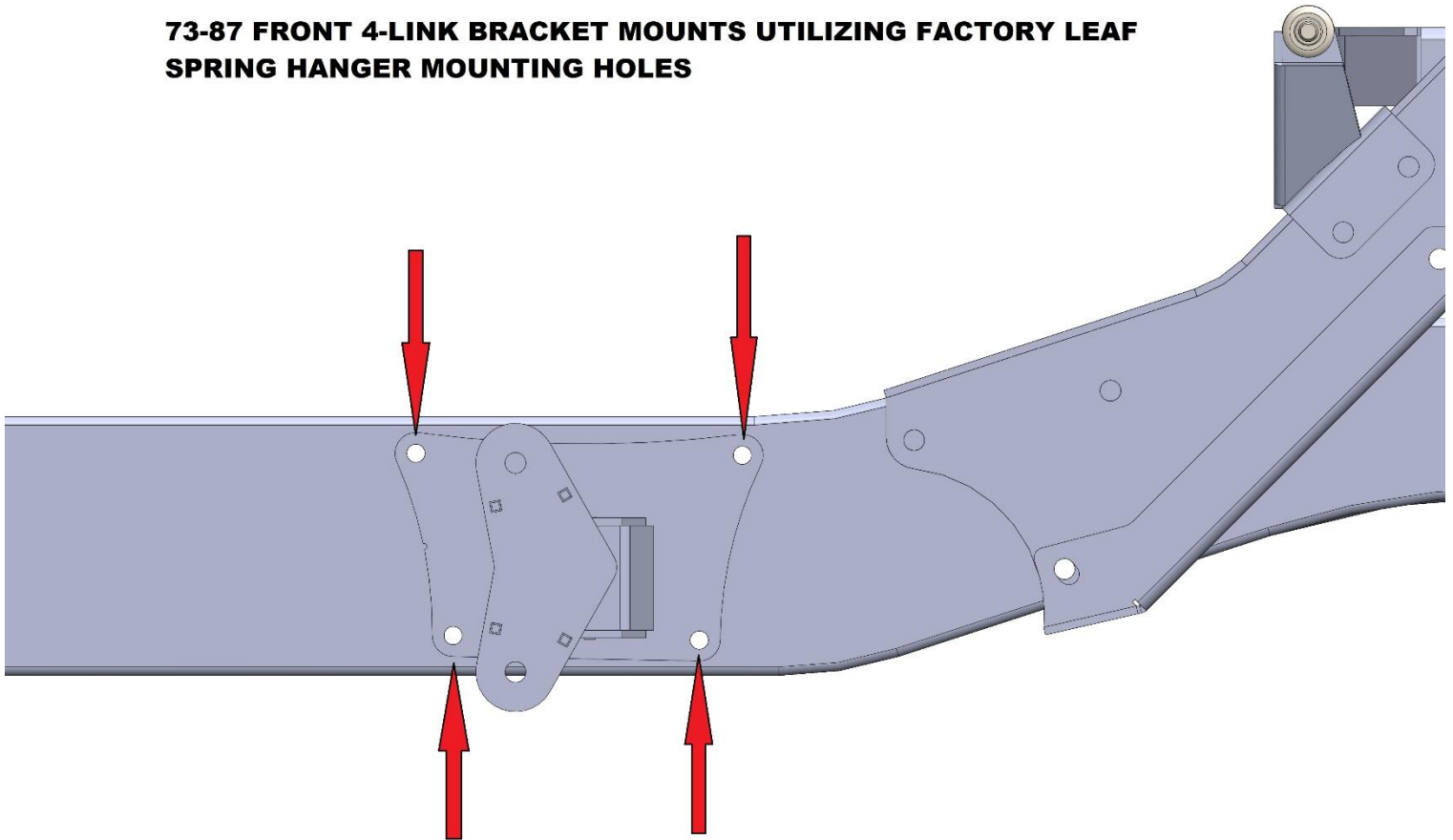
-4-LINK FRAME MOUNTING BRACKET WILL INSTALL UTILIZING FACTORY FRONT LEAF SPRING HANGERS ORIGINAL MOUNTING HOLES

*****SEE IMAGE BELOW*****

-IT MAY BE NECESSARY TO ENLARGE HOLES IN FROM TO 7/16 INCHES

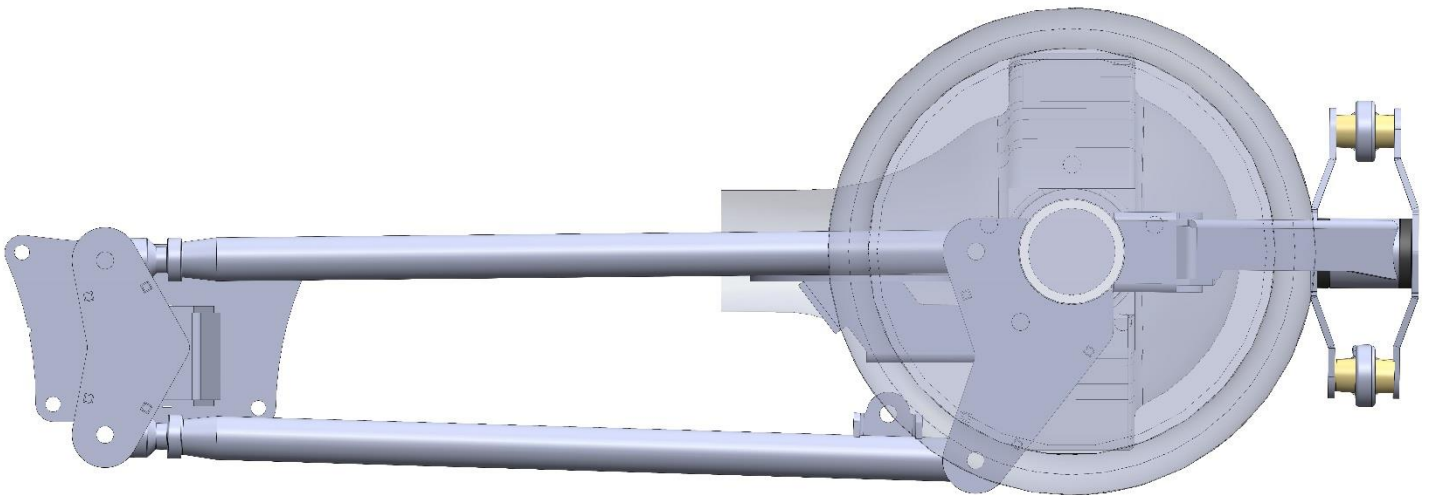
-UTILIZE SUPPLIED GRADE 8 HARWDARE; TORQUE TO 65 FT-LBS

73-87 FRONT 4-LINK BRACKET MOUNTS UTILIZING FACTORY LEAF SPRING HANGER MOUNTING HOLES



4-LINK BAR AND AXLE BRACKET 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

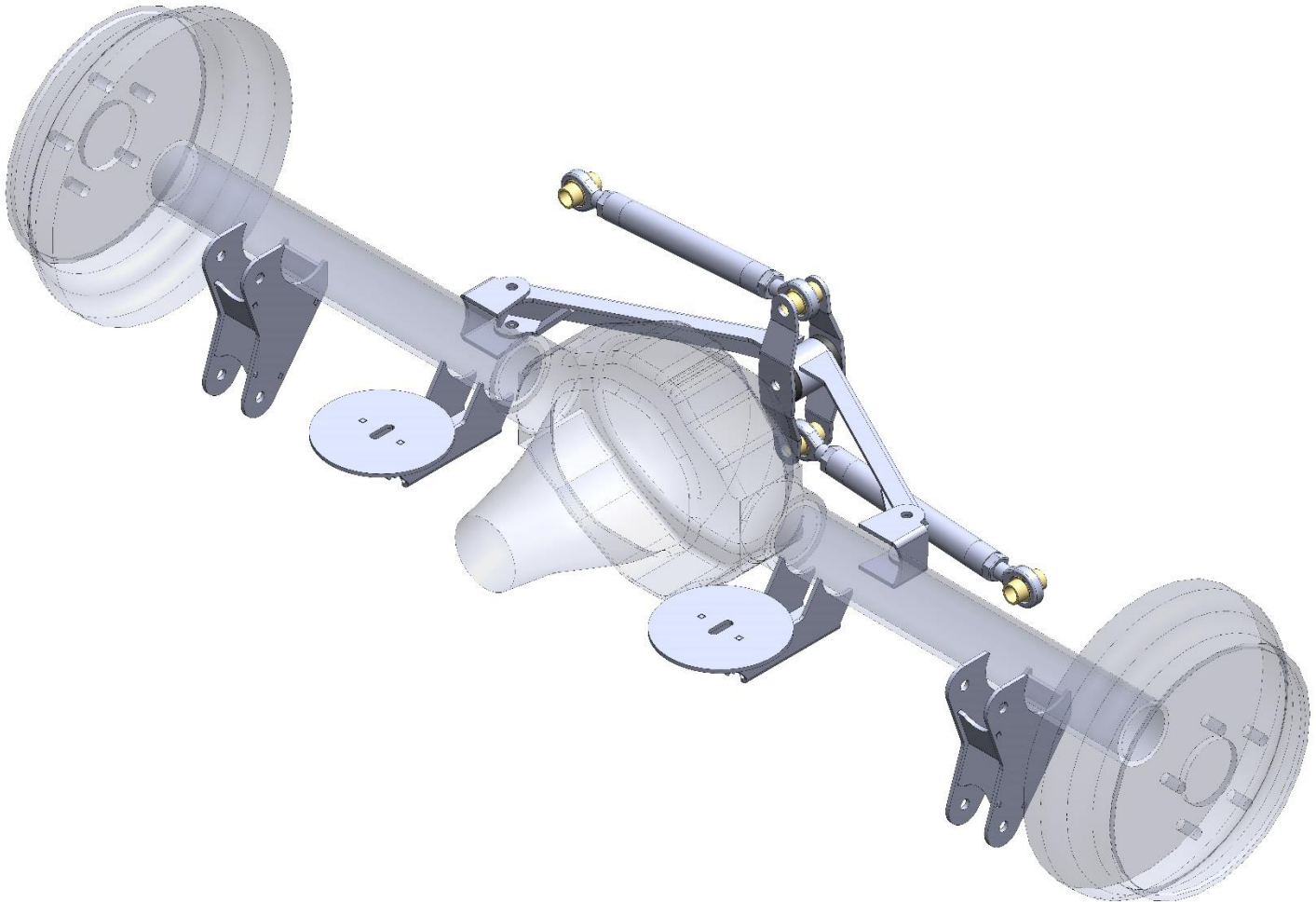


-SET DISTANCE FROM OUTSIDE EDGE TO OUTSIDE EDGE OF 4-LINK AXLE BRACKETS TO 45 7/8 INCHES

-SET PINION ANGLE TO ZERO WITH UPPER 4-LINK BAR PARALLEL TO GROUND

-TACK 4-LINK MOUNTING BRACKETS TO AXLE HOUSING AT THIS TIME; BE CAREFUL NOT TO OVERHEAT AND MELT POLYURETHANE BUSHINGS

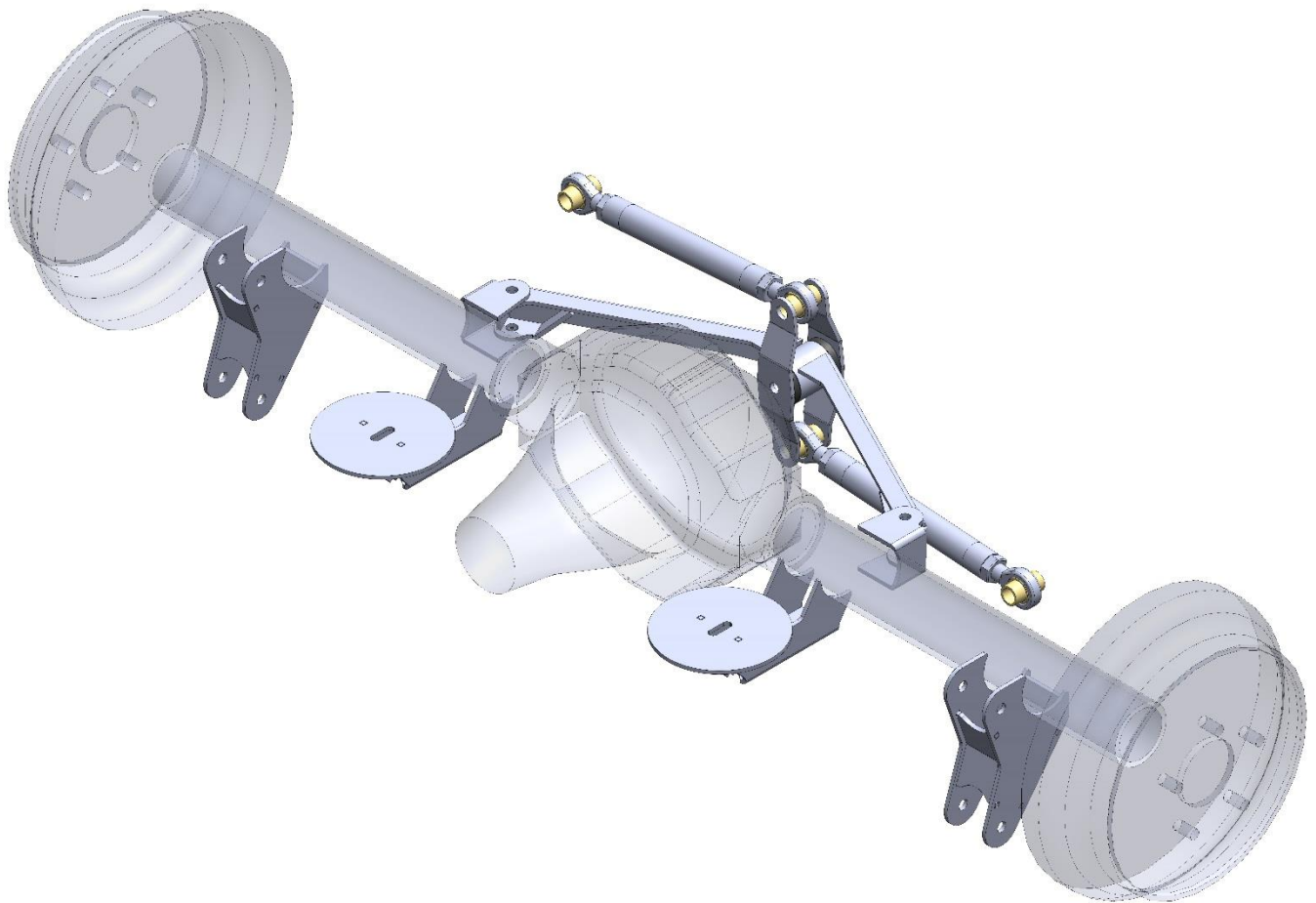
(*DO NOT YET FULLY WELD BRACKETS UNTIL AFTER DRIVE-TRAIN AND DRIVE-SHAFT ARE INSTALLED AND PROPER DRIVE-LINE ANGLES ARE CONFIRMED***)**



*****4-LINK AXLE BRACKETS 45 7/8 INCHES OUTSIDE TO OUTSIDE*****

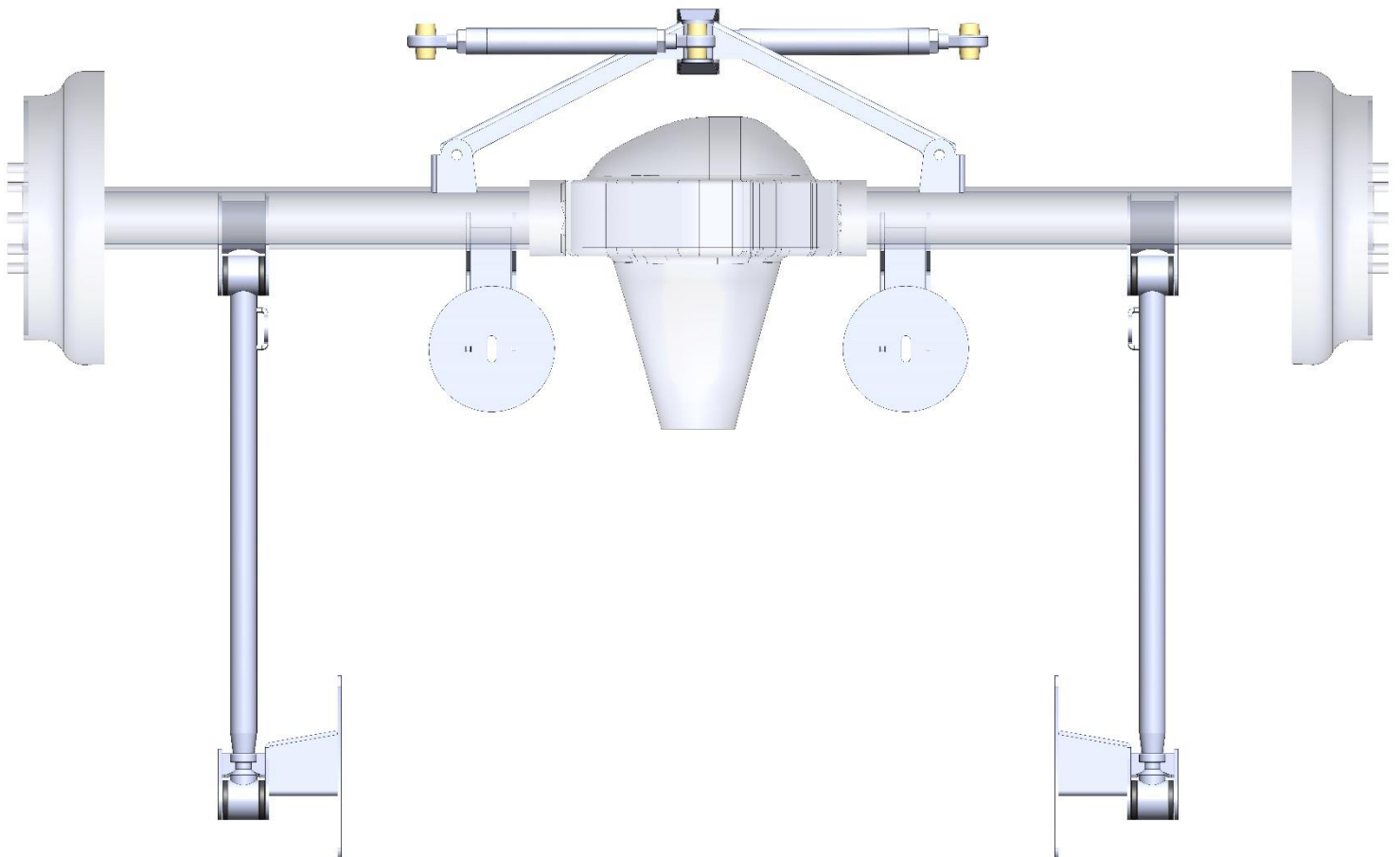
AIRBAG MOUNTING BRACKET INSTALLATION

- SET LOWER AIRBAG MOUNTING BRACKETS SO THAT THE BAG MOUNTING SURFACE IS PERPENDICULAR TO THE GROUND AT RIDE HEIGHT
- DISTANCE BETWEEN LOWER AIRBAG MOUNTING HOLES (CENTER TO CENTER) SHOULD MEASURE 19 5/8 INCHES
- TACK WELD LOWER BAG 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****))



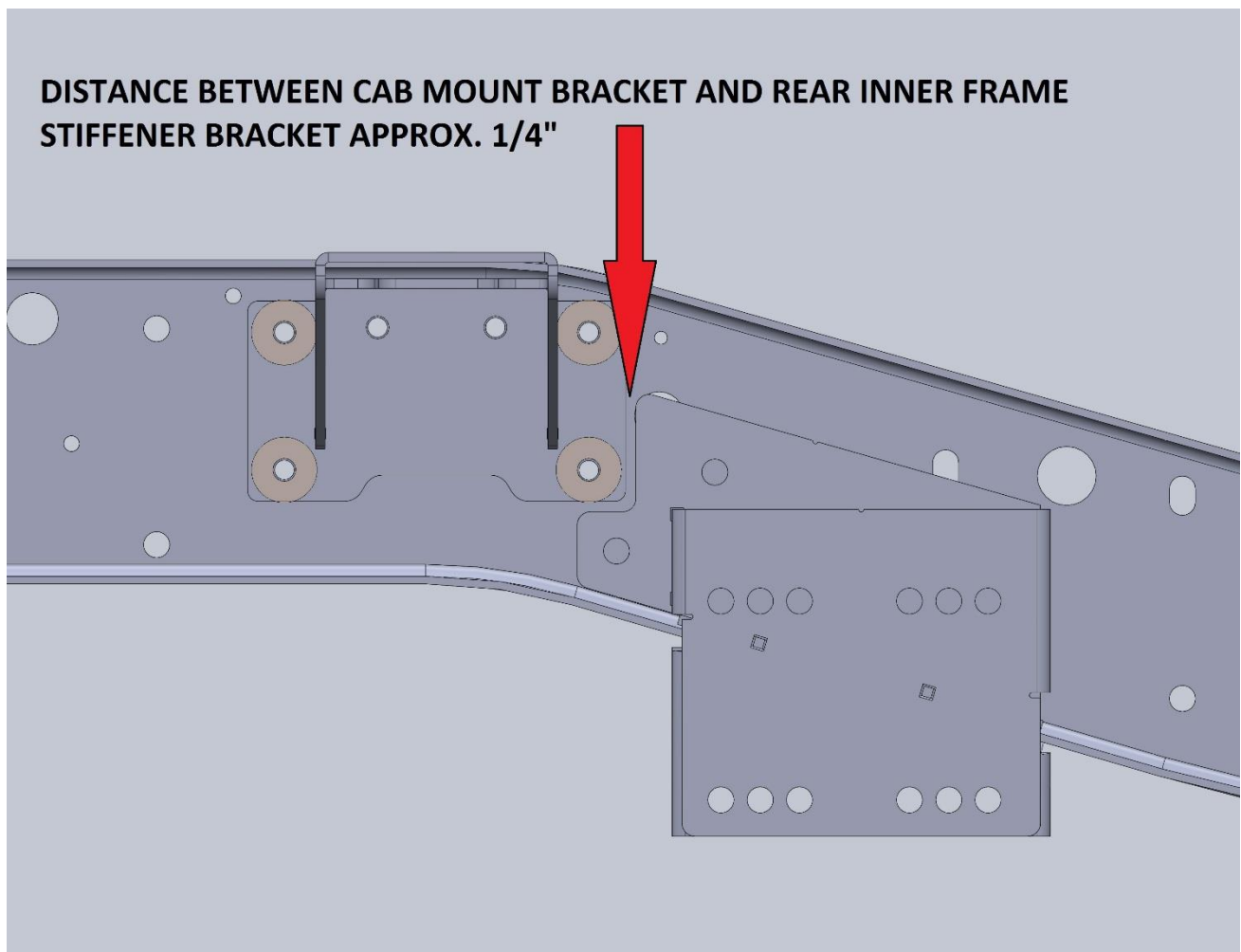
WATTS LINK MOUNTING BRACKET INSTALLATION

- 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*****)



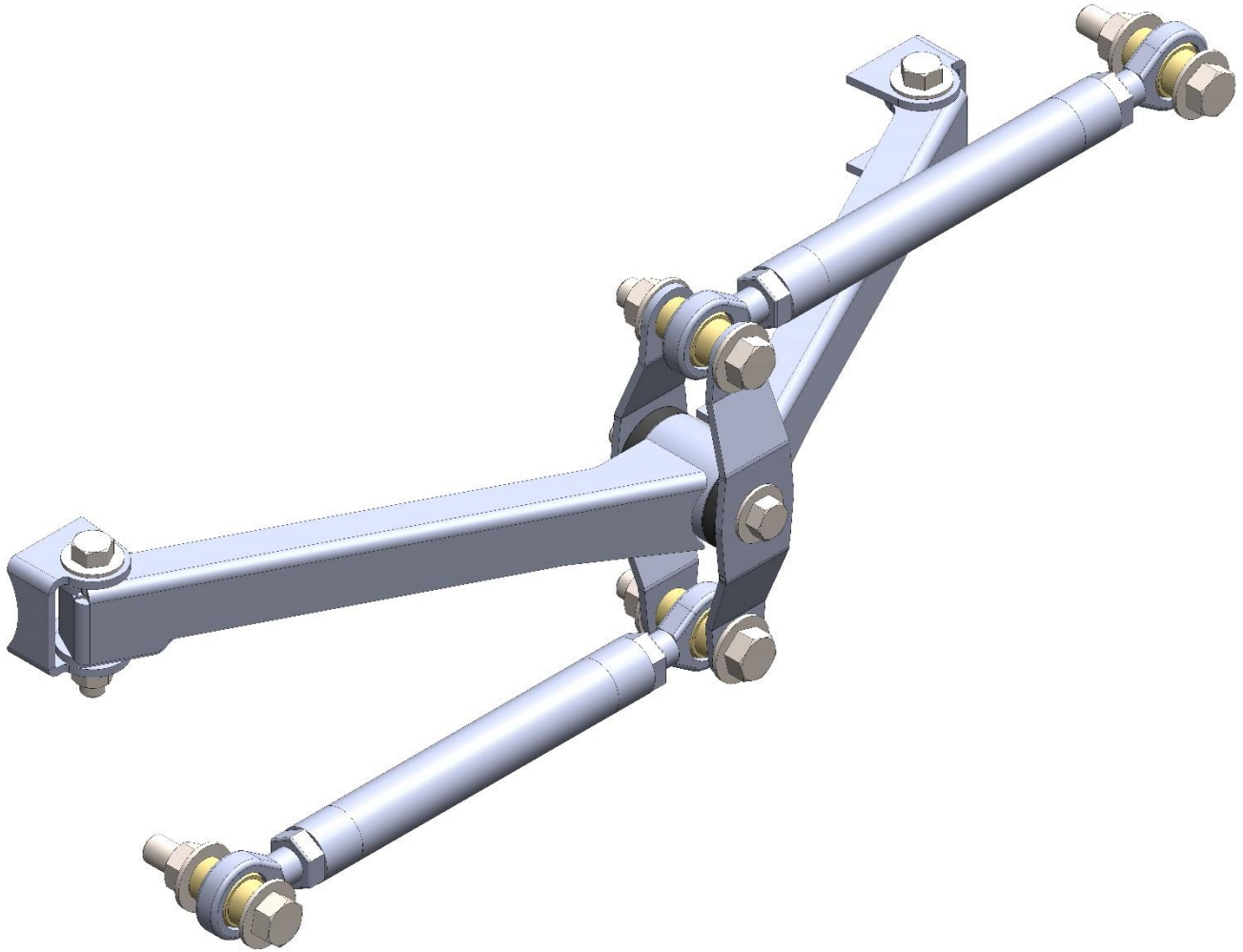
CARRIER BEARING CROSSMEMBER INSTALLATION

- SEE BELOW IMAGE FOR CARRIER BEARING MOUNTING BRACKETS LOCATION
- FRAME MOUNTING BRACKETS WILL DIFFER DEPENDING ON FACTORY CATALYTIC CONVERTER OR NO CAT OPTIONS
- AFTER CONFIRMING MOUNTING BRACKET LOCATION MARK AND DRILL MOUNTING HOLES
- INSTALL SUPPLIED GRADE 8 MOUNTING HARDWARE AND TORQUE TO 65 FT-LBS



WATTS LINK INSTALLATION

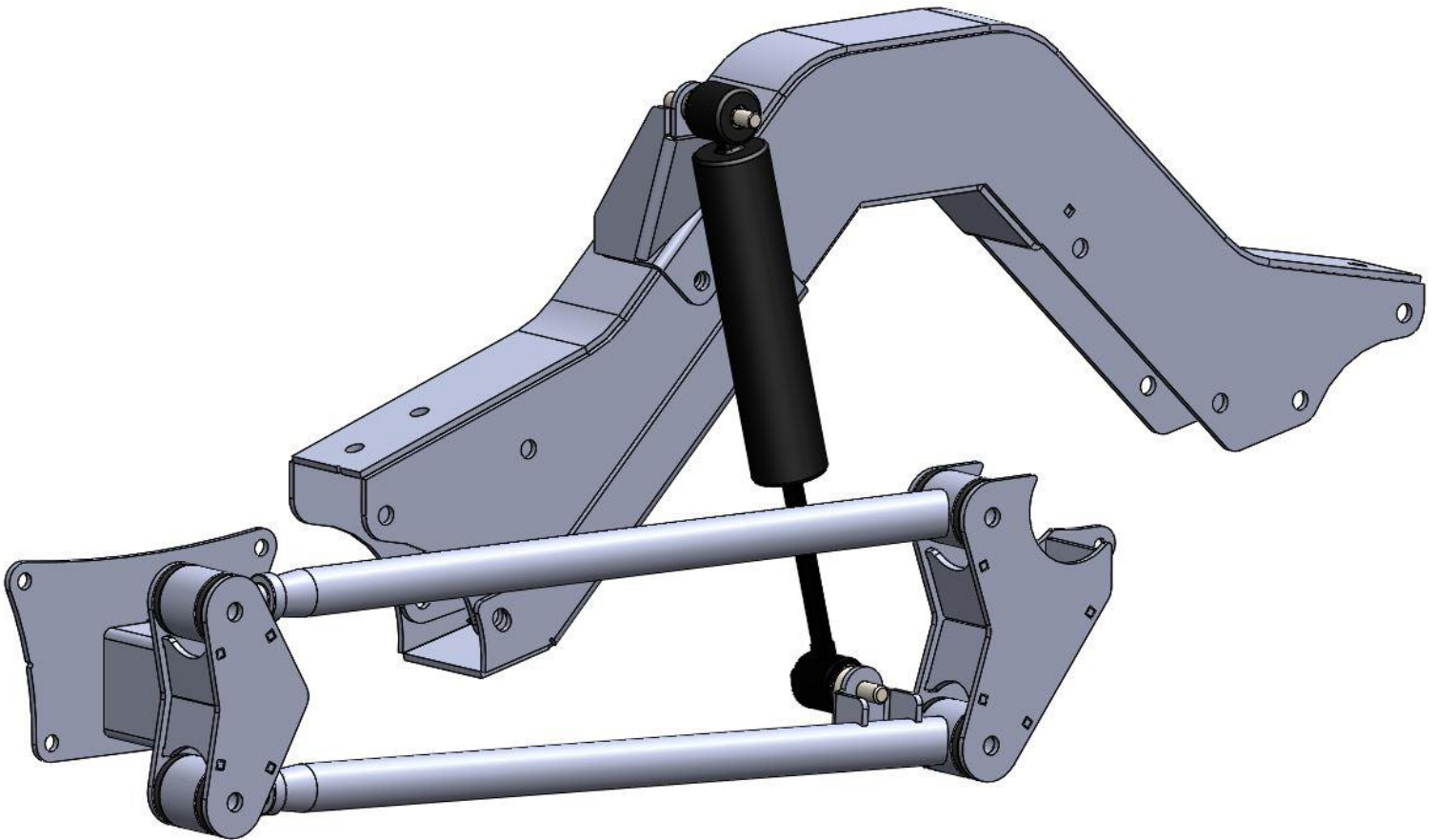
- ASSEMBLE AND INSTALL WATTS LINK USING SUPPLIED GRADE 8 HARDWARE
- TORQUE ALL HARDWARE TO 65 FT-LBS



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*****

