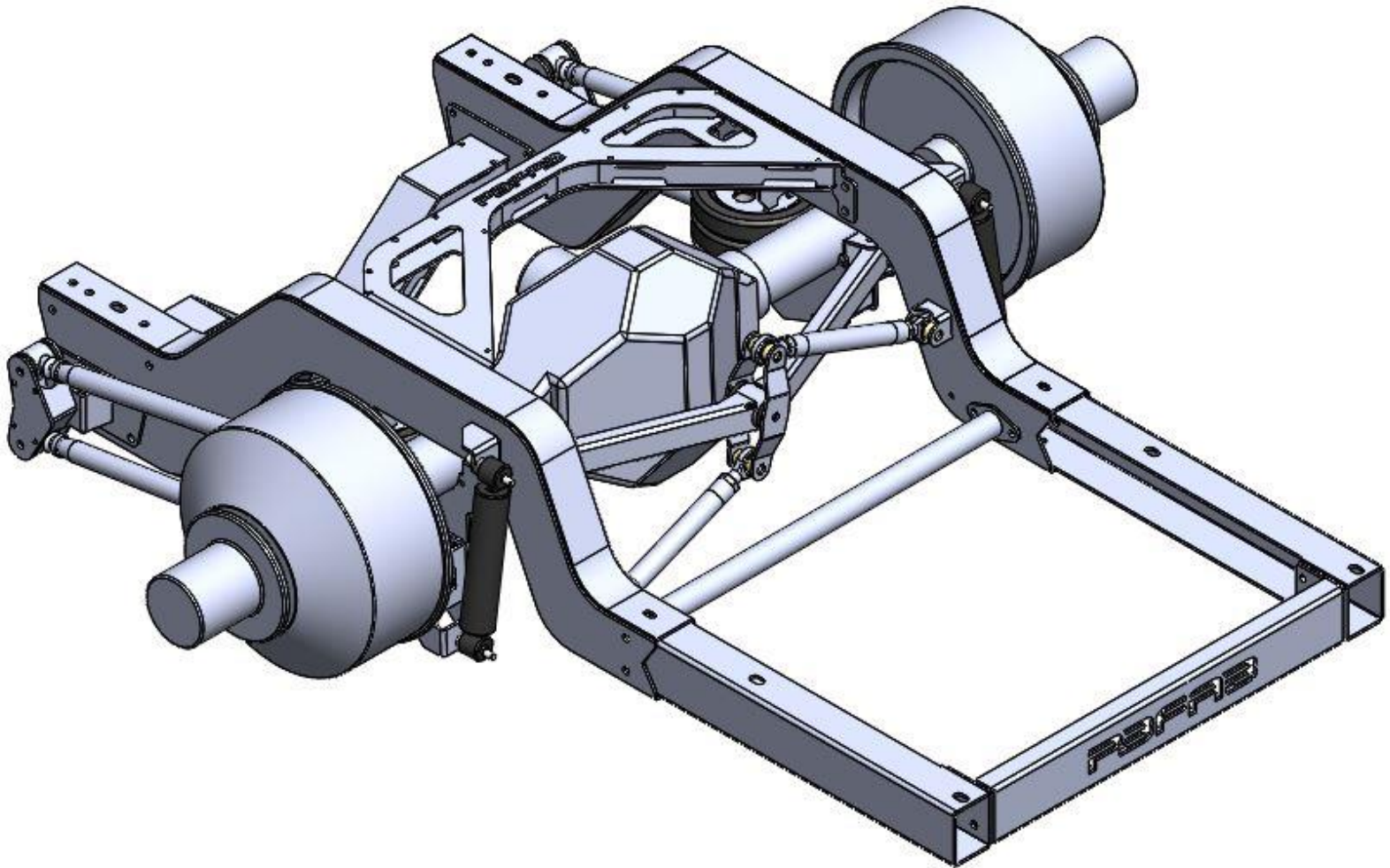


# **PORTERBUILT FABRICATION**

## **DROPMEMBER REAR 73-87 C30**

### **INSTALLATION GUIDE**



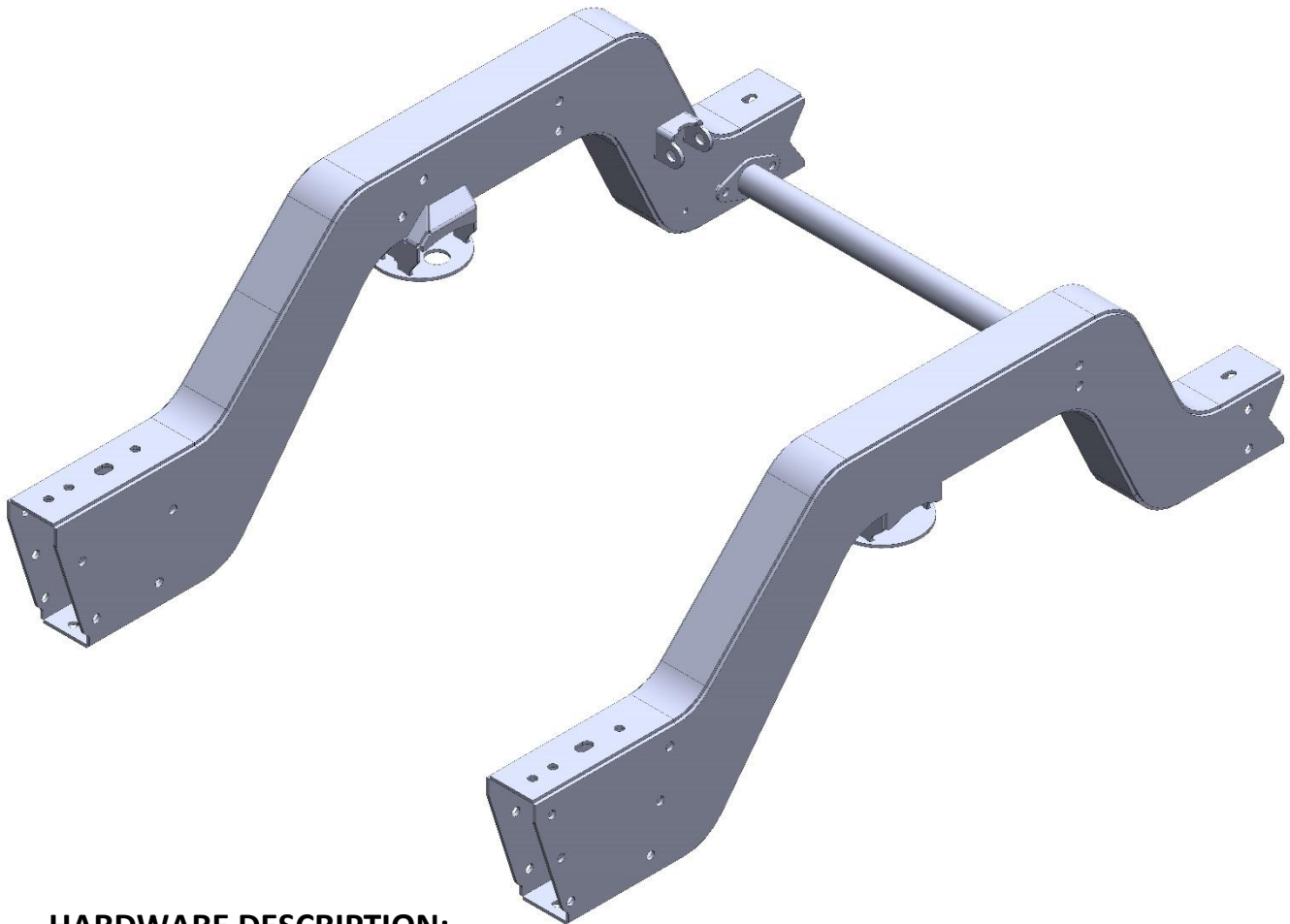
APRIL 2020

## **PARTS IDENTIFICATION**

(EACH PART WILL HAVE HARDWARE BAGGIES WITH CORRESPONDING PART NUMBER AND HARDWARE BREAK-OUT LABELS)

**PART#** RN7387-C30-3-B-WL

**DESCRIPTION:** REAR NOTCH; 73-87 C30; LEVEL 3; BOLT IN; WATTS LINK SPECIFIC



## **HARDWARE DESCRIPTION:**

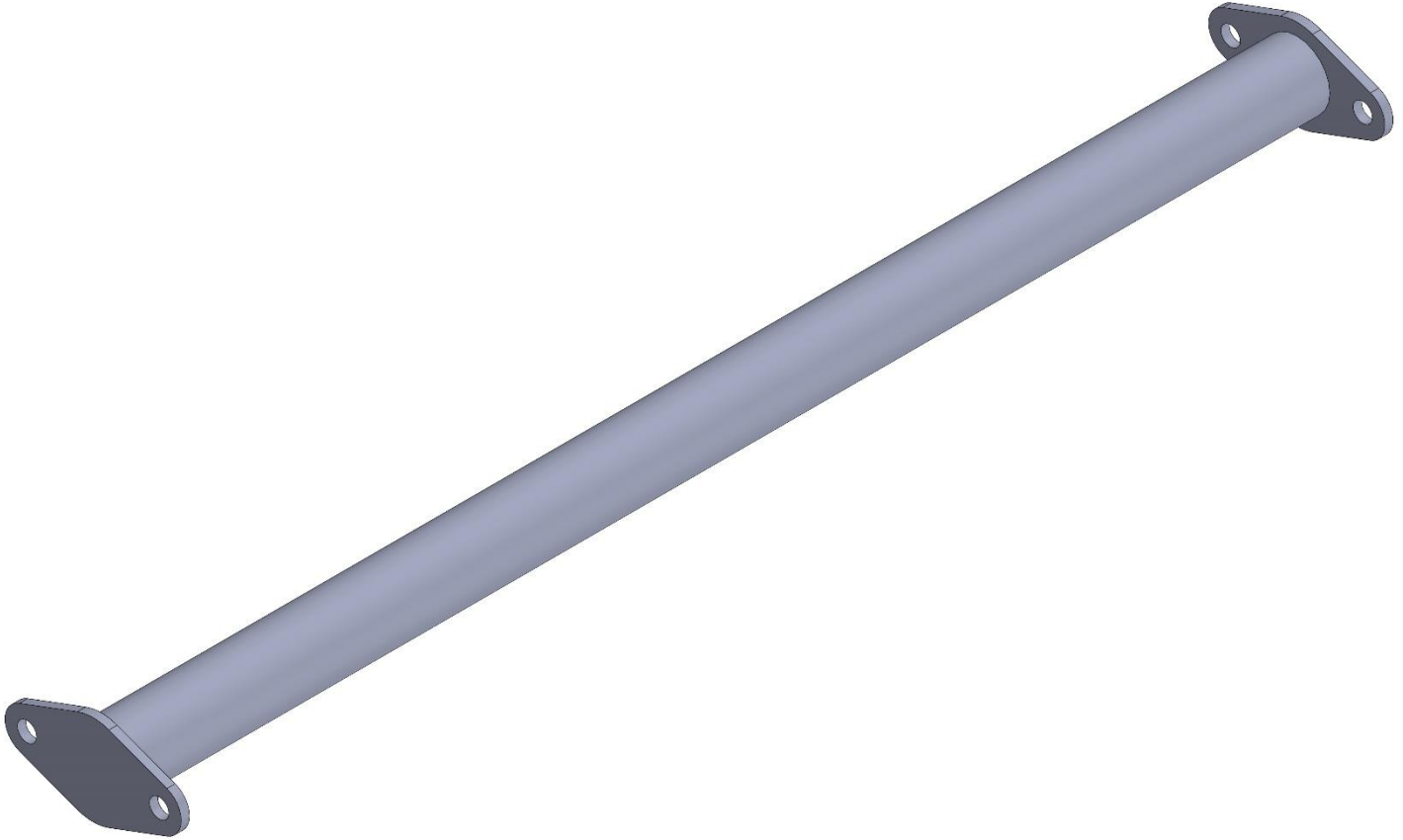
7/16 X 1.25 GRADE 8 BOLT USS (QTY. 20)

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

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

**PART#** RNXM280

**DESCRIPTION:** REAR NOTCH CROSS MEMBER 28 INCHES OVERALL LENGTH

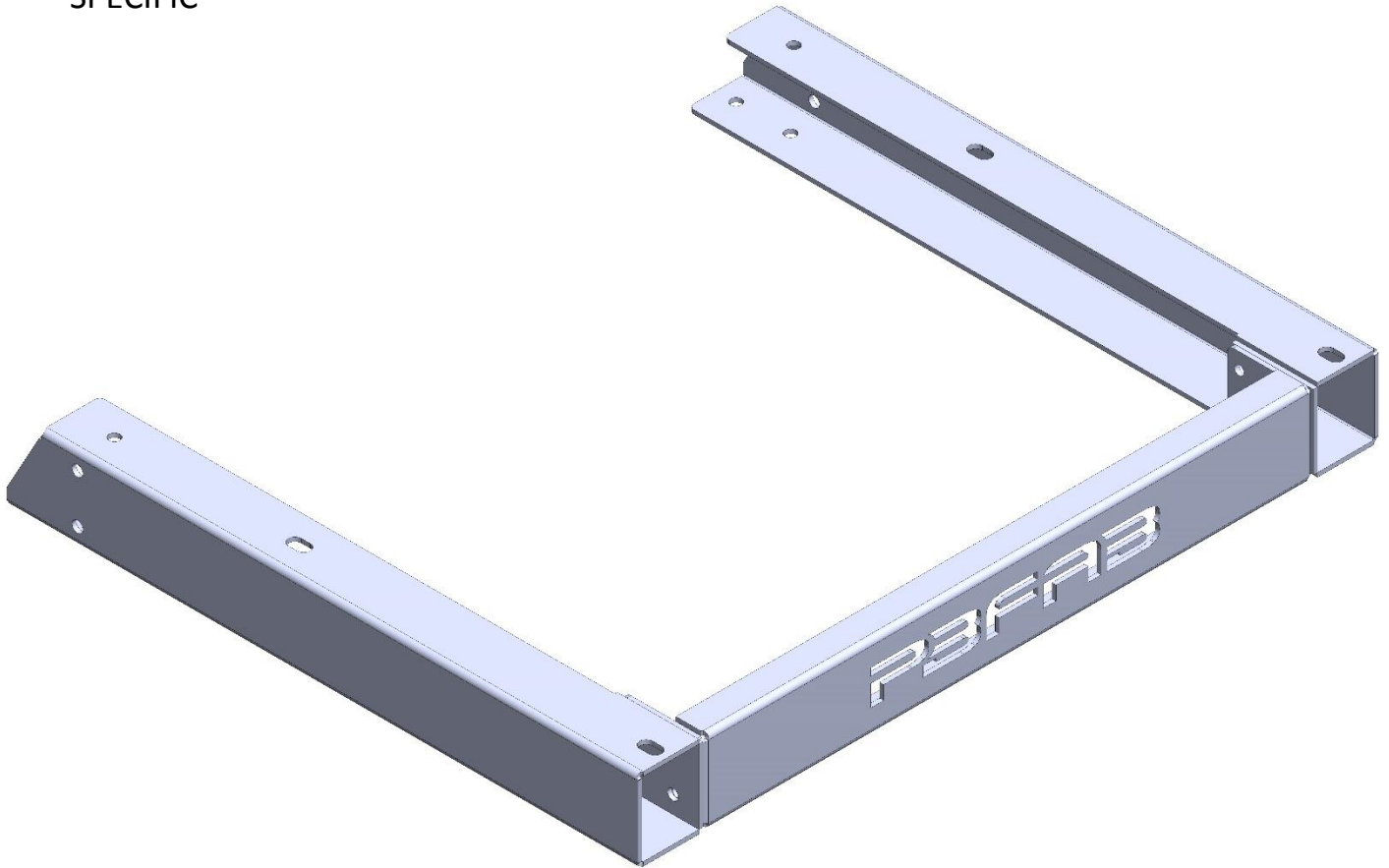


**HARDWARE DESCRIPTION:**

\*\*\*USES MOUNTING HARDWARE SUPPLIED IN REAR NOTCH KIT\*\*\*

**PART#** RFR7387-C30-LWB

**DESCRIPTION:** REAR FRAME RAIL ASSEMBLY 73-87 C30 LONG WHEEL BASE  
SPECIFIC



**HARDWARE DESCRIPTION:**

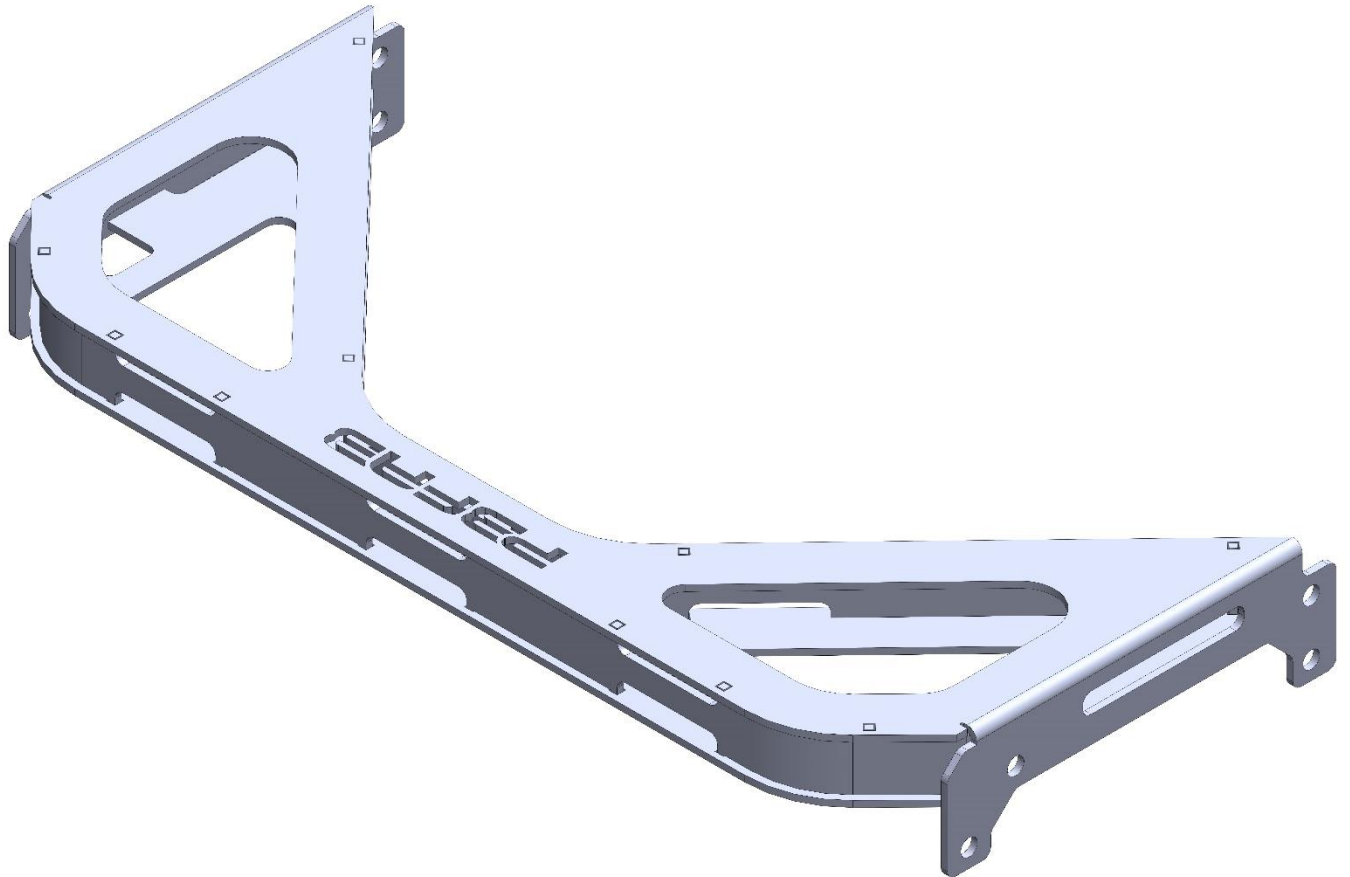
7/16 X 1.25 GRADE 8 BOLT USS (QTY. 20)

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

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

**PART#** BA7387-C30

**DESCRIPTION:** BRIDGE ASSEMBLY 73-87 C30 SPECIFIC



**HARDWARE DESCRIPTION:**

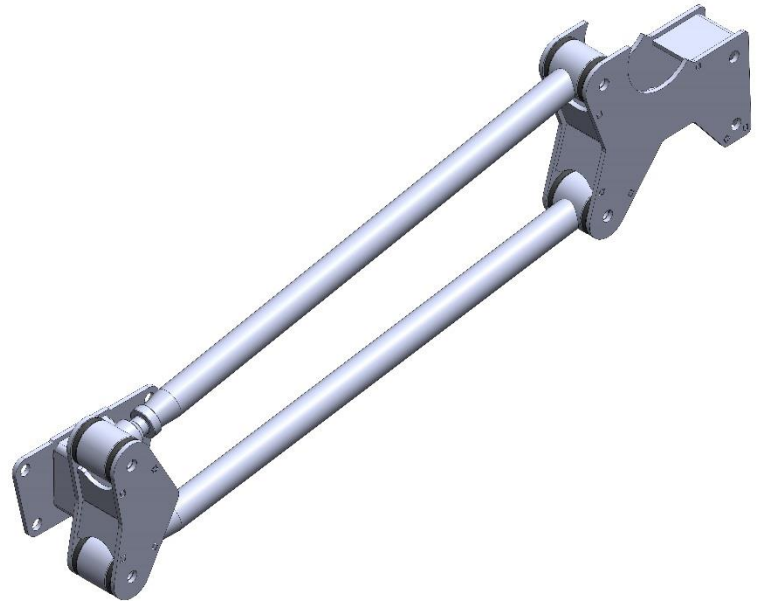
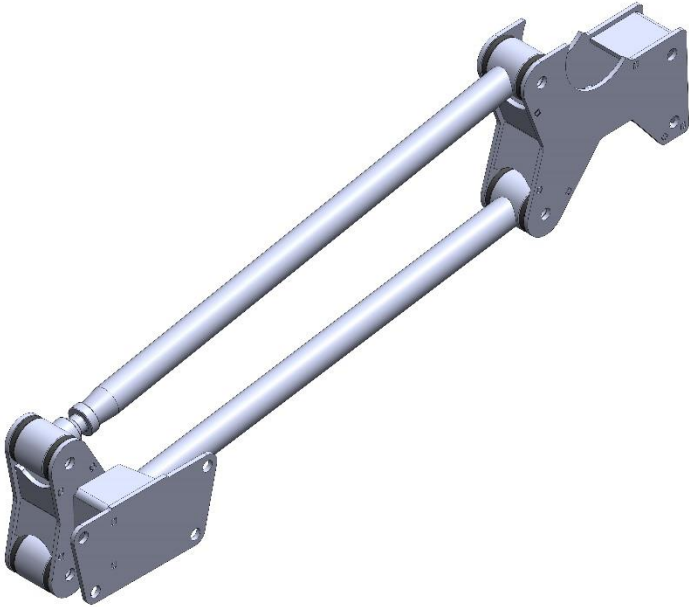
7/16 X 1.25 GRADE 8 BOLT USS (QTY. 8)

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

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

**PART# 4L7387-C30-WL**

**DESCRIPTION: 4 LINK 73-87 C30 WATTS LINK SPECIFIC**



**HARDWARE DESCRIPTION:**

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

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

3/8 GRADE 8 FLAT WASHER USS (QTY. 16)

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)

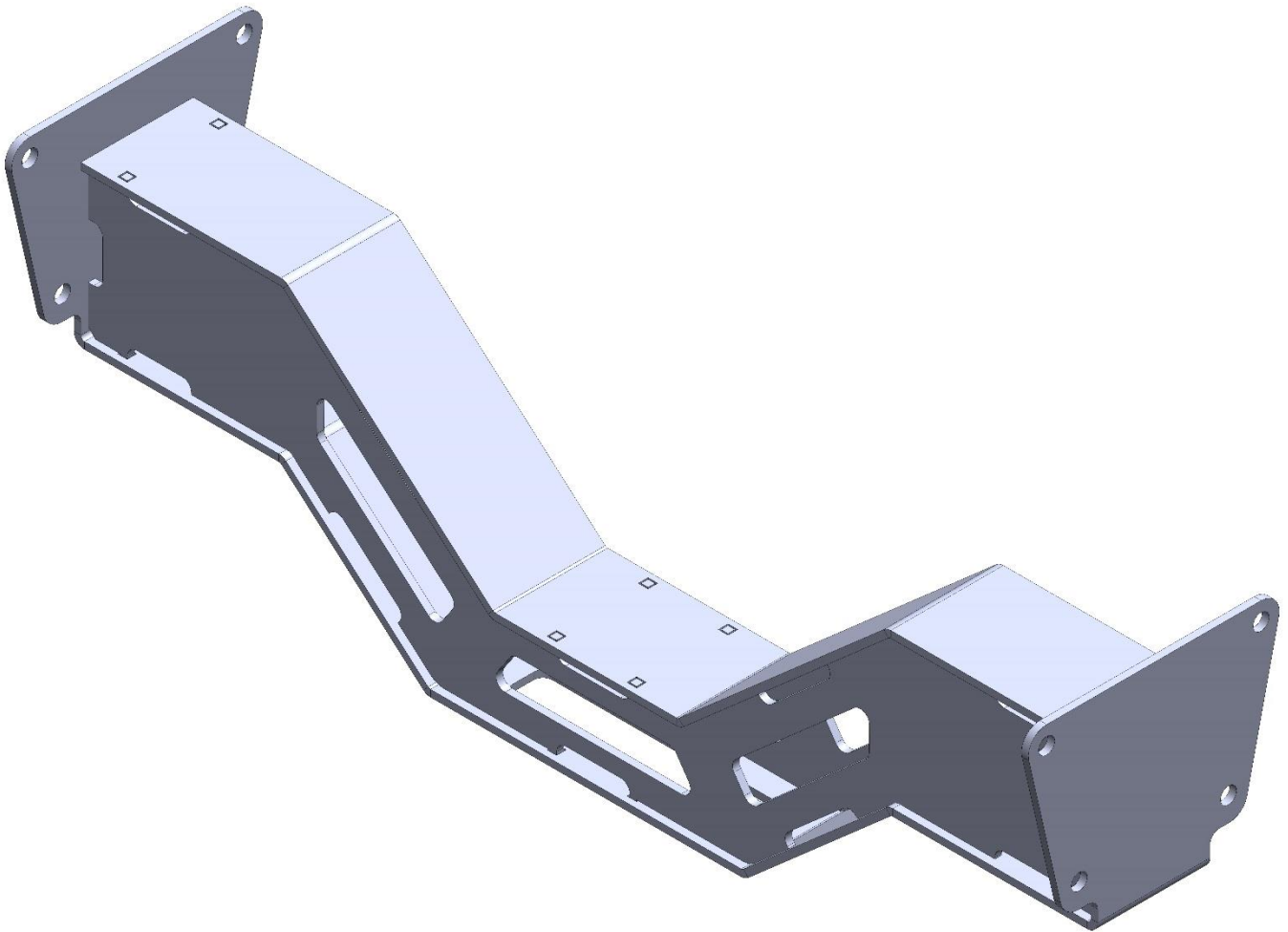
POLY BUSHING HALF; 4-LINK SPECIFIC (QTY. 16)

4-LINK BUSHING CRUSH TUBE (QTY. 8)

ZERK FITTINGS (QTY. 8)

**PART# 4LXM7387-C30**

**DESCRIPTION:** 4 LINK CROSSMEMBER 73-87 C30 KIT SPECIFIC



**HARDWARE DESCRIPTION:**

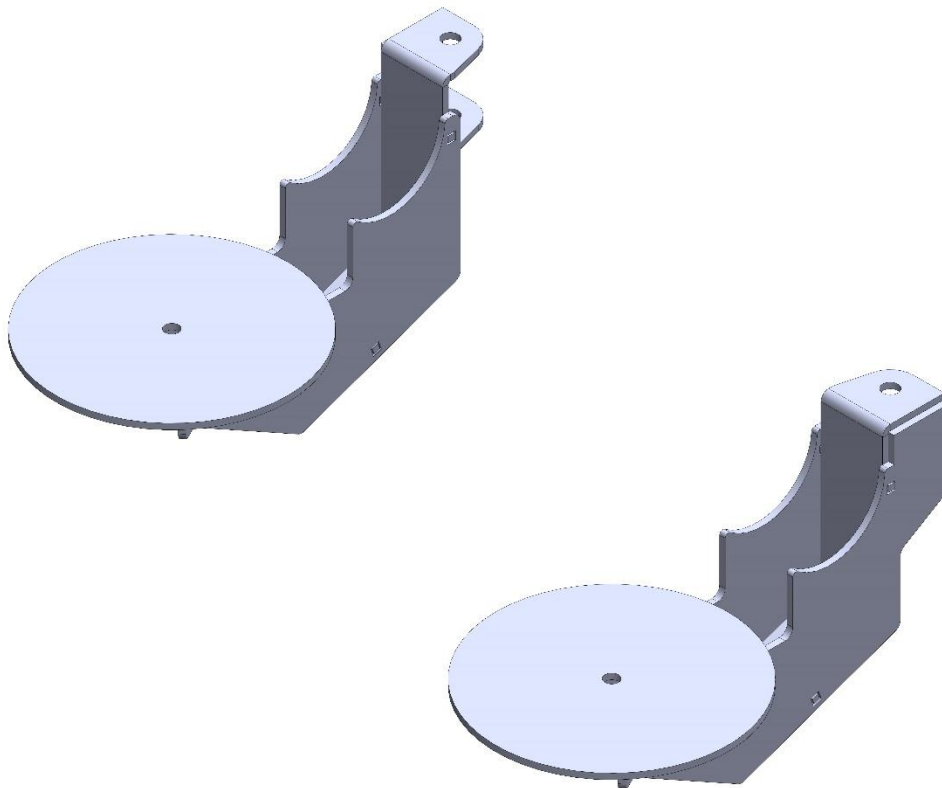
7/16 X 1.25 GRADE 8 BOLT USS (QTY. 8)

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

3/8 GRADE 8 FLAT WASHER USS (QTY. 16)

**PART#** LBM7387-C30-DOM2600

**DESCRIPTION:** LOWER BAG MOUNTS 73-87 C30 SPECIFIC

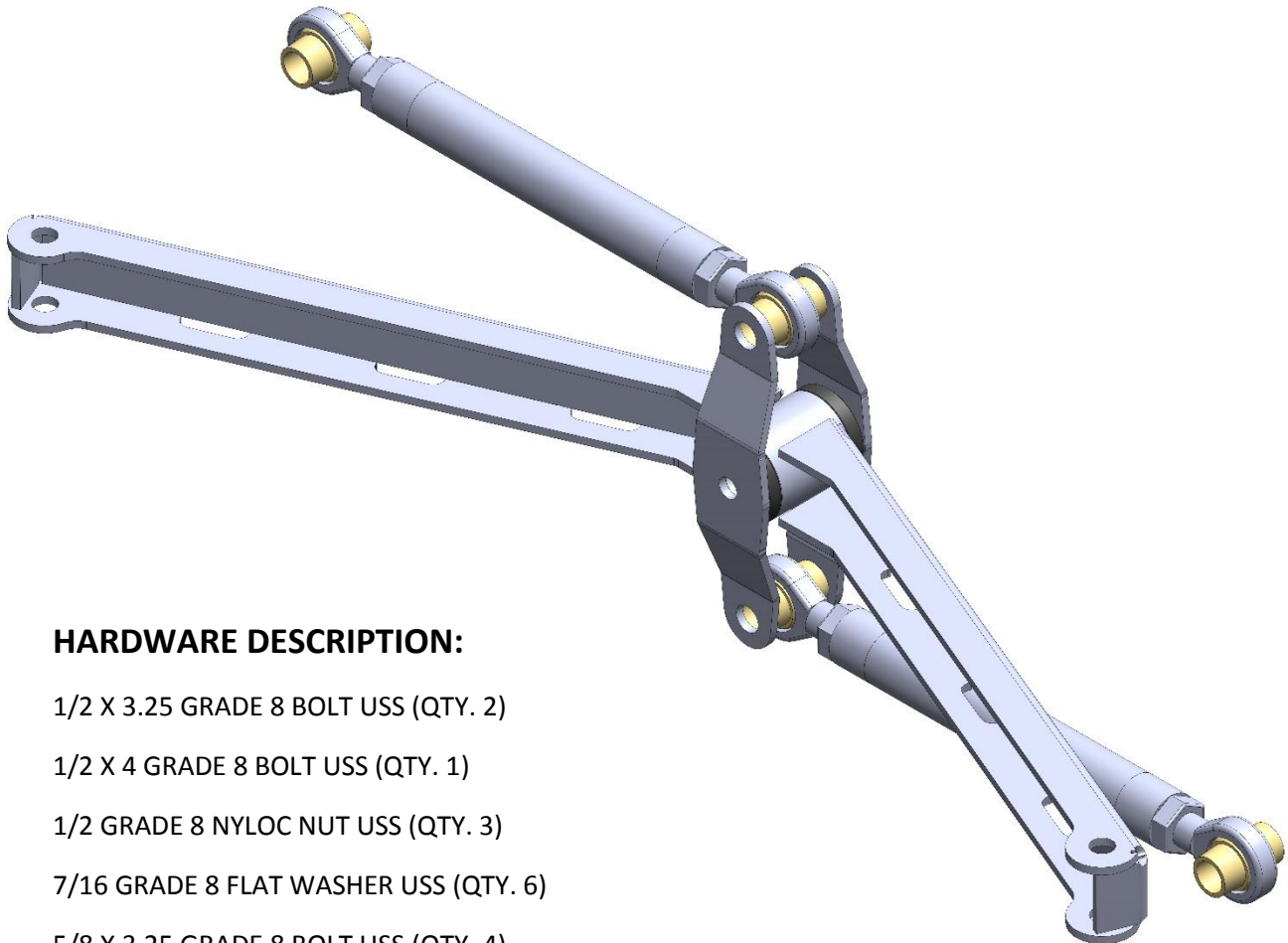


**HARDWARE DESCRIPTION:**

\*\*\*NO HARWDARE\*\*\*

**PART# WL6387-C30**

**DESCRIPTION:** WATTS LINK ASSEMBLY; 63-87 C30 SPECIFIC



**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)

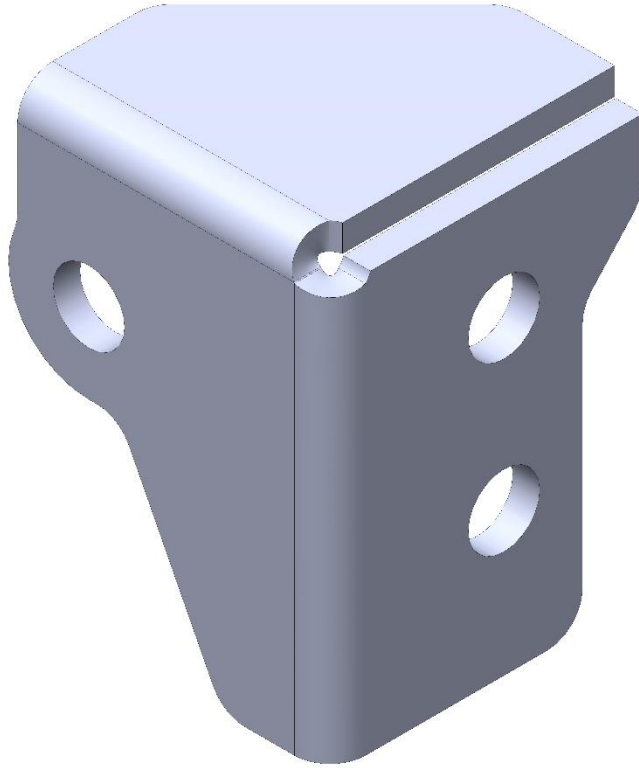
DM-V6 BUSHING HALF (QTY. 2)

DM-V6 CRUSH TUBES (QTY. 1)

ZERK FITTING (QTY. 1)

**PART#** RUSM7387-C30

**DESCRIPTION:** REAR UPPER SHOCK MOUNT 73-87 C30 SPECIFIC (COMES AS A PAIR)



**HARDWARE DESCRIPTION:**

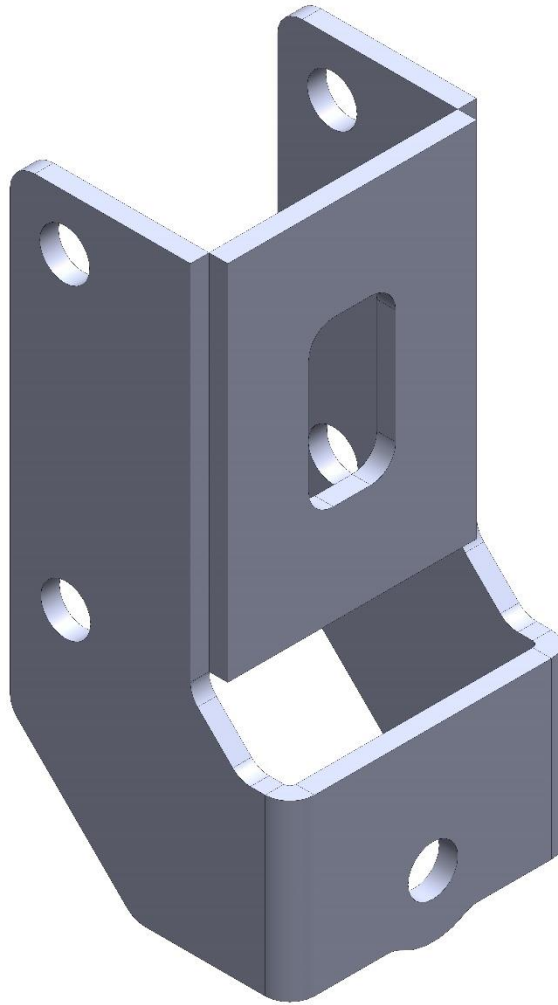
7/16 X 1.25 GRADE 8 BOLT USS (QTY. 4)

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

3/8 GRADE 8 FLAT WASHER USS (QTY. 4)

**PART#** RLSM7387-C30

**DESCRIPTION:** REAR LOWER SHOCK MOUNT 73-87 C30 SPECIFIC (COMES AS A PAIR)



**HARDWARE DESCRIPTION:**

1/2 X 3.75 GRADE 8 BOLT USS (QTY. 4)

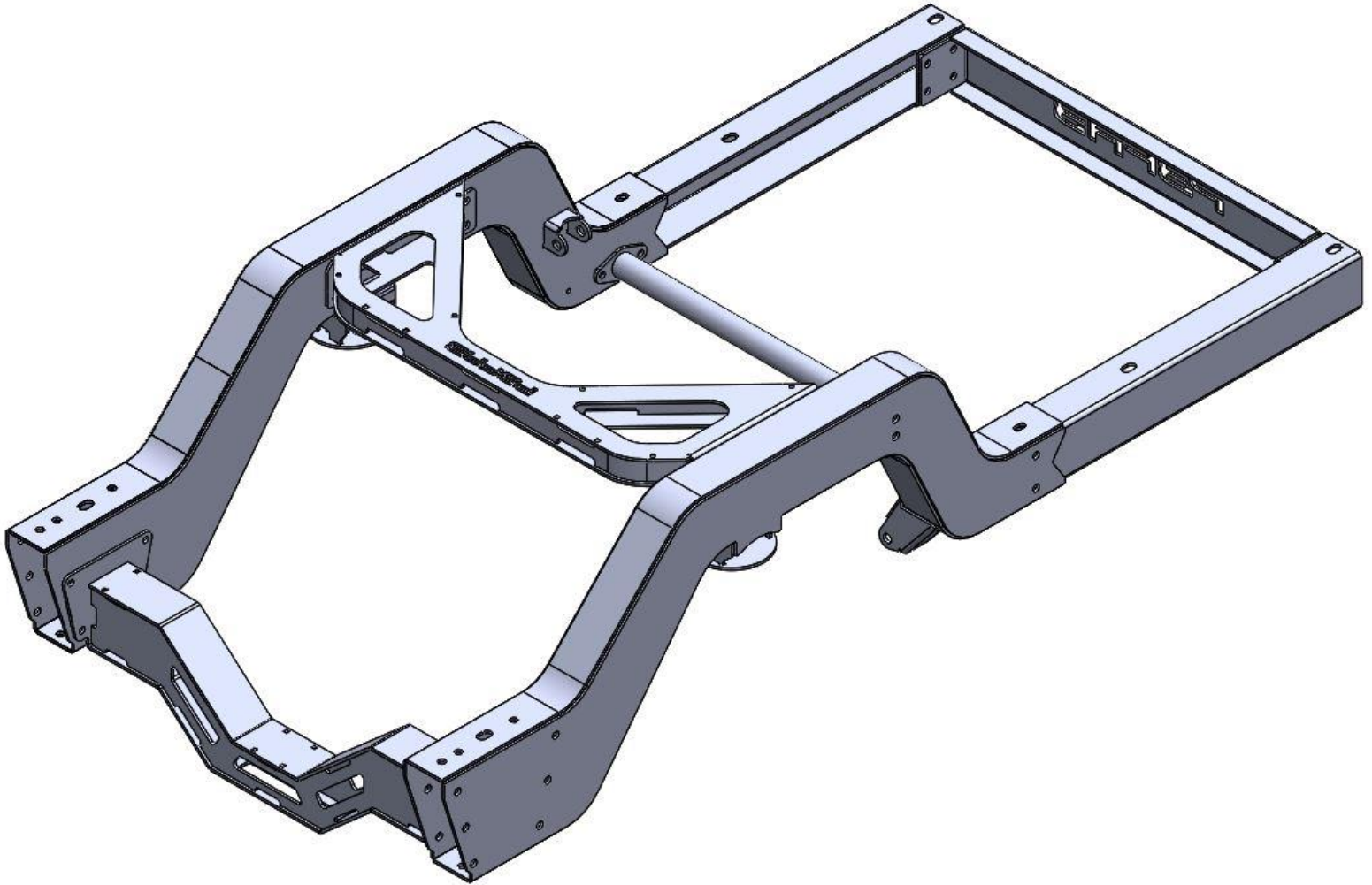
7/16 GRADE 8 WASHER USS (QTY. 8)

1/2 GRADE 8 NYLOC NUT USS (QTY. 4)

## ASSEMBLE REAR CLIP

UTILIZING PART AND HARDWARE DESCRIPTIONS ABOVE, ASSEMBLE NOTCH-BACK (PICTURED BELOW)

**\*\*\*DO NOT FULLY TIGHTEN OR TORQUE HARDWARE AT THIS TIME\*\*\***



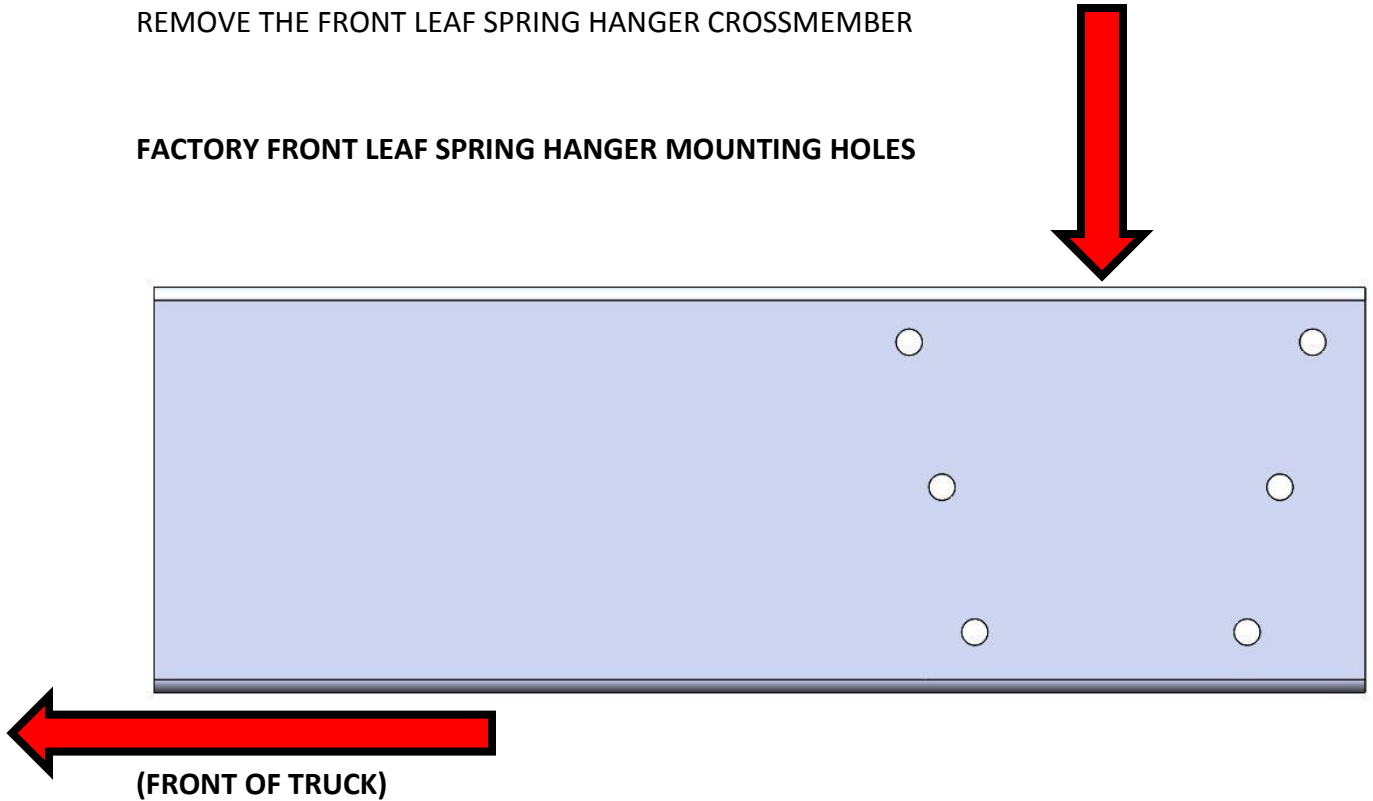
## **PREP FACTORY FRAME FOR NOTCH BACK INSTALLATION**

THE REAR NOTCH LOCATES OFF THE FRONT LEAF SPRING HANGER MOUNTING HOLE

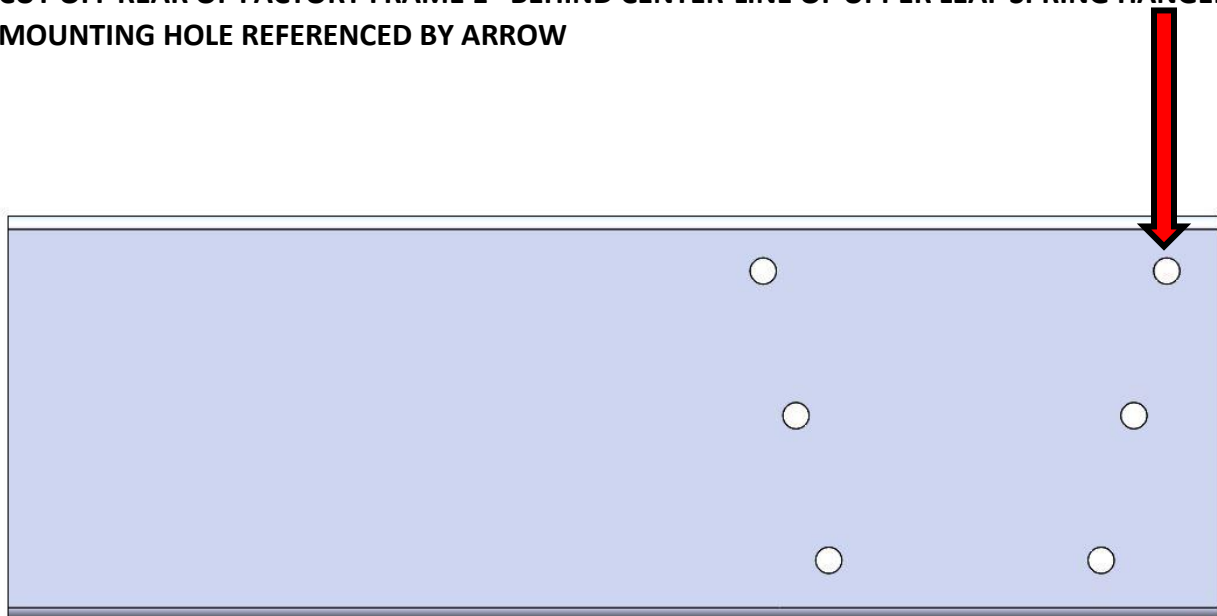
REMOVE THE FRONT LEAF SPRING HANGERS

REMOVE THE FRONT LEAF SPRING HANGER CROSSMEMBER

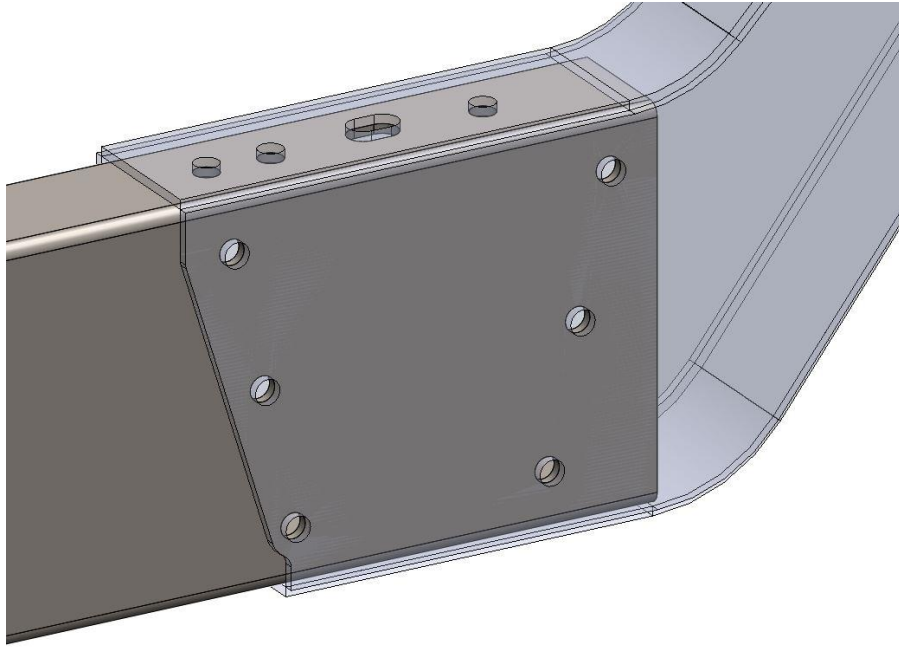
**FACTORY FRONT LEAF SPRING HANGER MOUNTING HOLES**



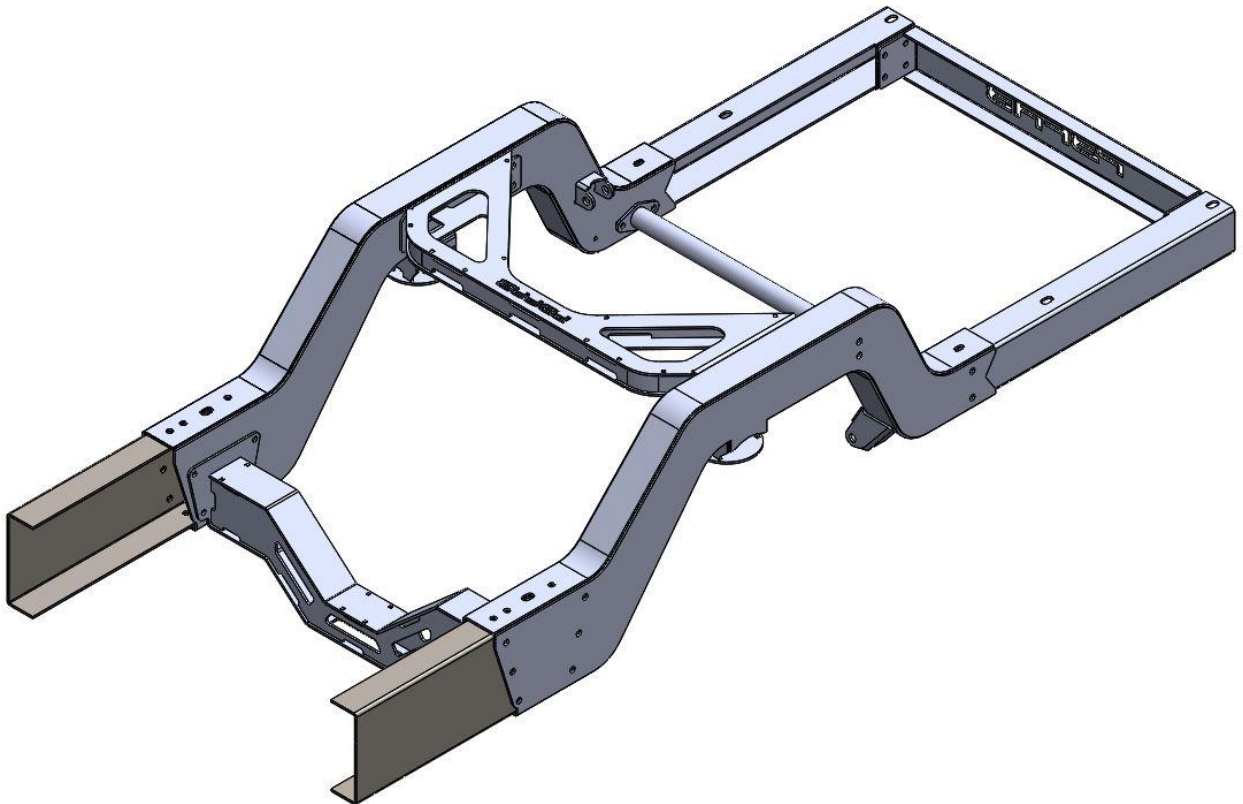
**CUT OFF REAR OF FACTORY FRAME 1" BEHIND CENTER-LINE OF UPPER LEAF SPRING HANGER MOUNTING HOLE REFERENCED BY ARROW**



**INSTALL NOTCH BACK ASSEMBLY ALIGNING HOLES IN FRONT OF NOTCHES WITH FRONT LEAF SPRING HANGER MOUNTING HOLES**



**DRILL ADDITIONAL MOUNTING HOLES IN FACTORY FRAME USING NOTCH AS TEMPLATE**

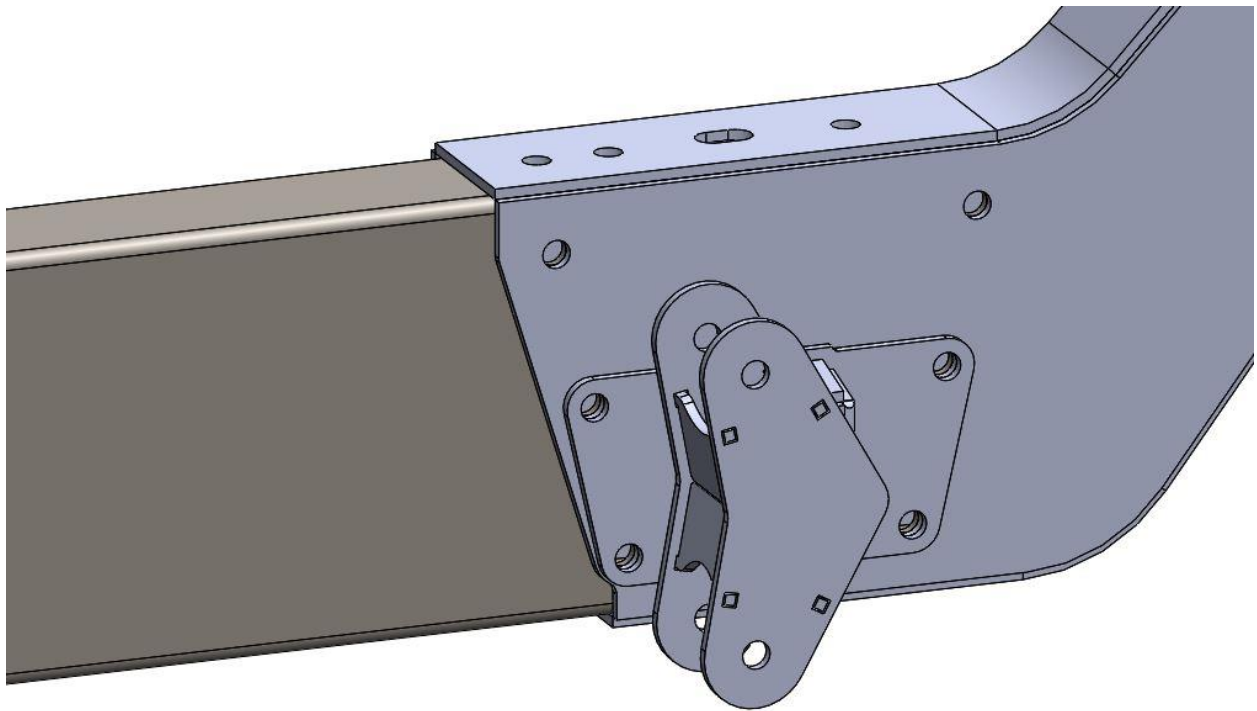


**BEFORE INSTALLING NOTCH BACK TO FRAME MOUNTING HARDWARE, INSTALL FRONT FOUR LINK MOUNTING BRACKETS (AS THEY WILL UTILIZE THE 4 LOWER MOUNTING BOLTS ON THE SIDE OF THE NOTCH BACK ASSEMBLY)**

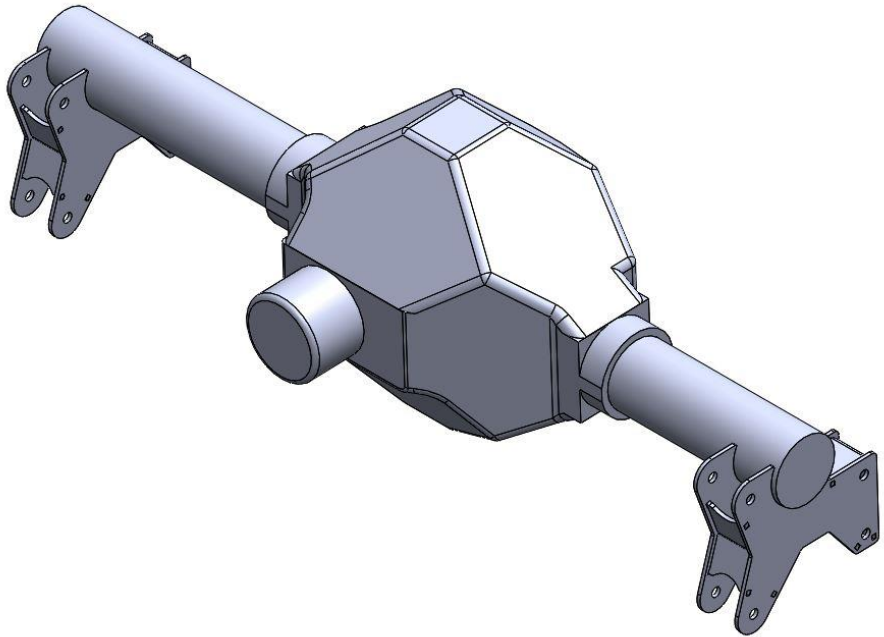
**SEE IMAGE BELOW TO ENSURE PROPER DIRECTION OF FRONT FOUR LINK MOUNTING BRACKETS**

**ENSURE THE NOTCH BACK ASSEMBLY IS SQUARE AND LEVEL TO FACTORY FRAME**

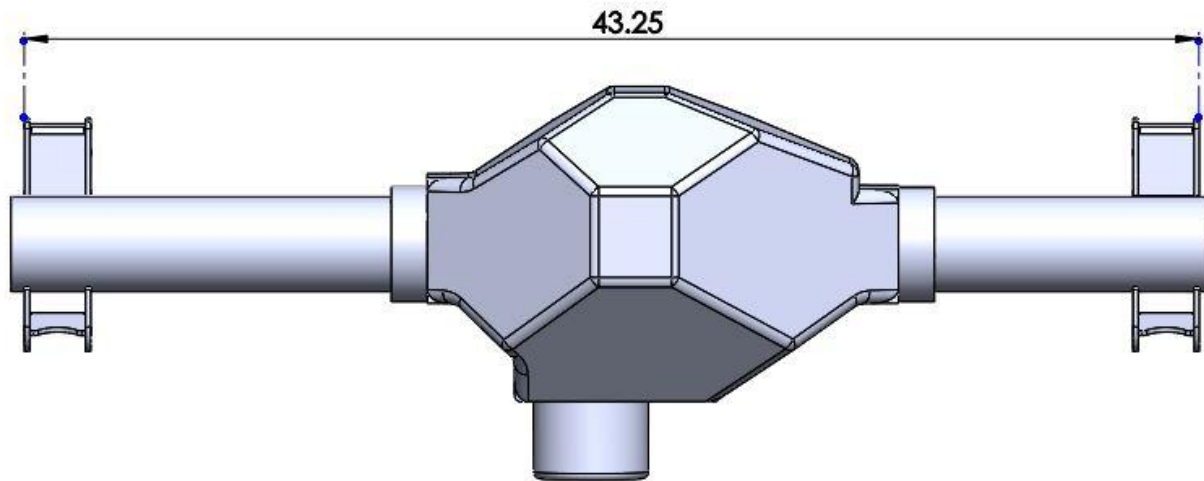
**TORQUE ALL 7/16 GRADE 8 MOUNTING HARDWARE TO 65 FT LBS**



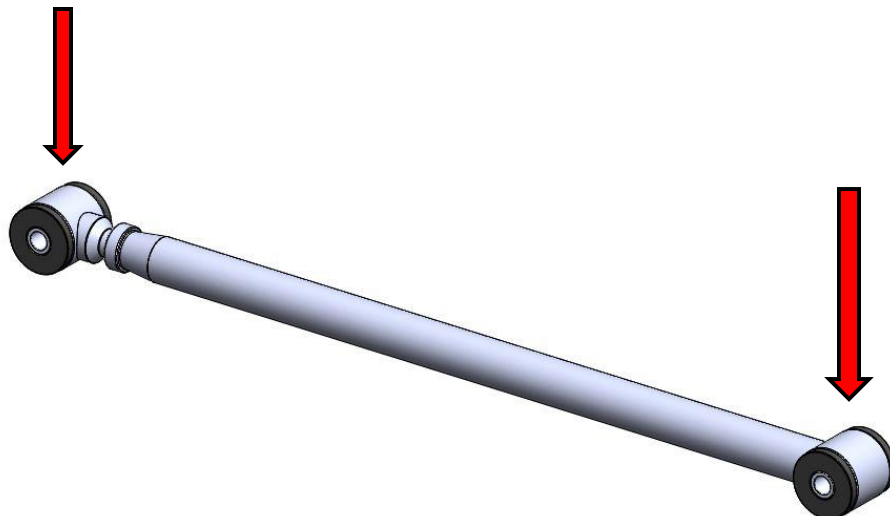
## FOUR LINK AND FOUR LINK BRACKET INSTALLATION



SET OUTSIDE TO OUTSIDE OF FOUR LINK AXLE BRACKETS TO 43.25 INCHES

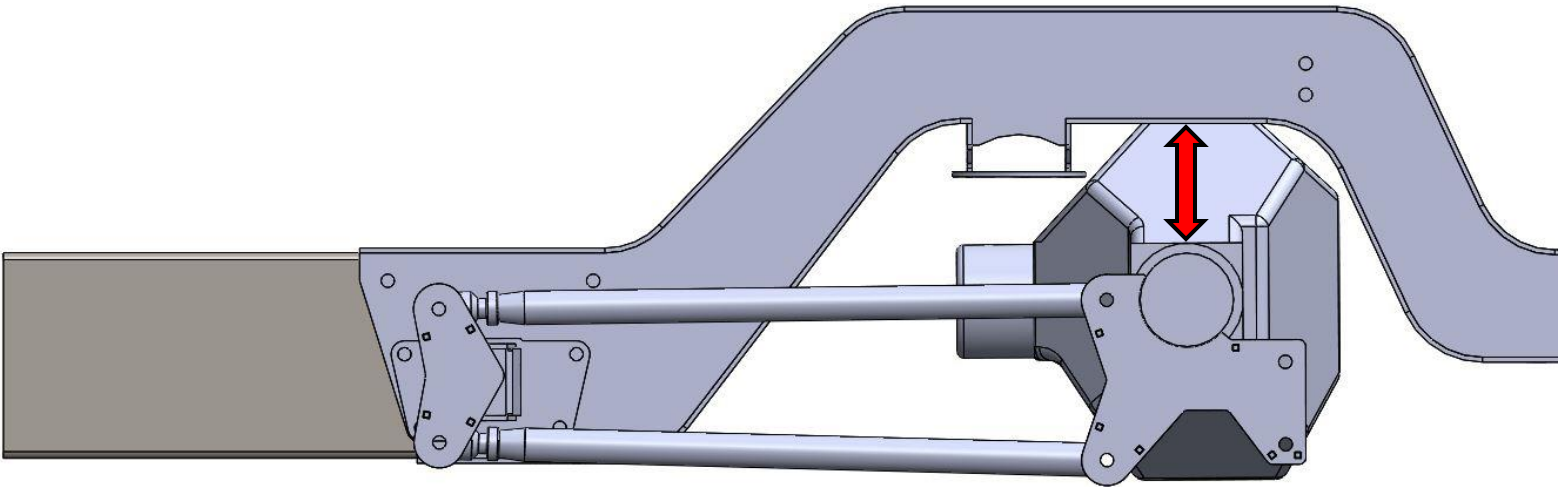


SET LENGTH OF 4-LINK BARS TO 25 INCHES CENTER TO CENTER



**MOCK-UP REAR DIFFERENTIAL; 4-LINK BARS; AND 4-LINK MOUNTING BRACKETS**

**SET DISTANCE BETWEEN TOP OF AXLE TUBE AND BOTTOM OF NOTCH TO 4.5 INCHES**



**SET REAR EDGE OF AXLE MOUNTED 4-LINK BRACKETS PERPENDICULAR TO THE GROUND**

**SET PINION ANGLE TO ZERO (PERPENDICULAR TO GROUND)**

**ENSURE DISTANCE FROM OUTSIDE EDGE TO OUTSIDE EDGE OF AXLE MOUNTED 4-LINK BRACKETS MEASURE 43.25 INCHES**

**TACK WELD AXLE MOUNTED 4-LINK BRACKETS TO REAR DIFFERENTIAL**

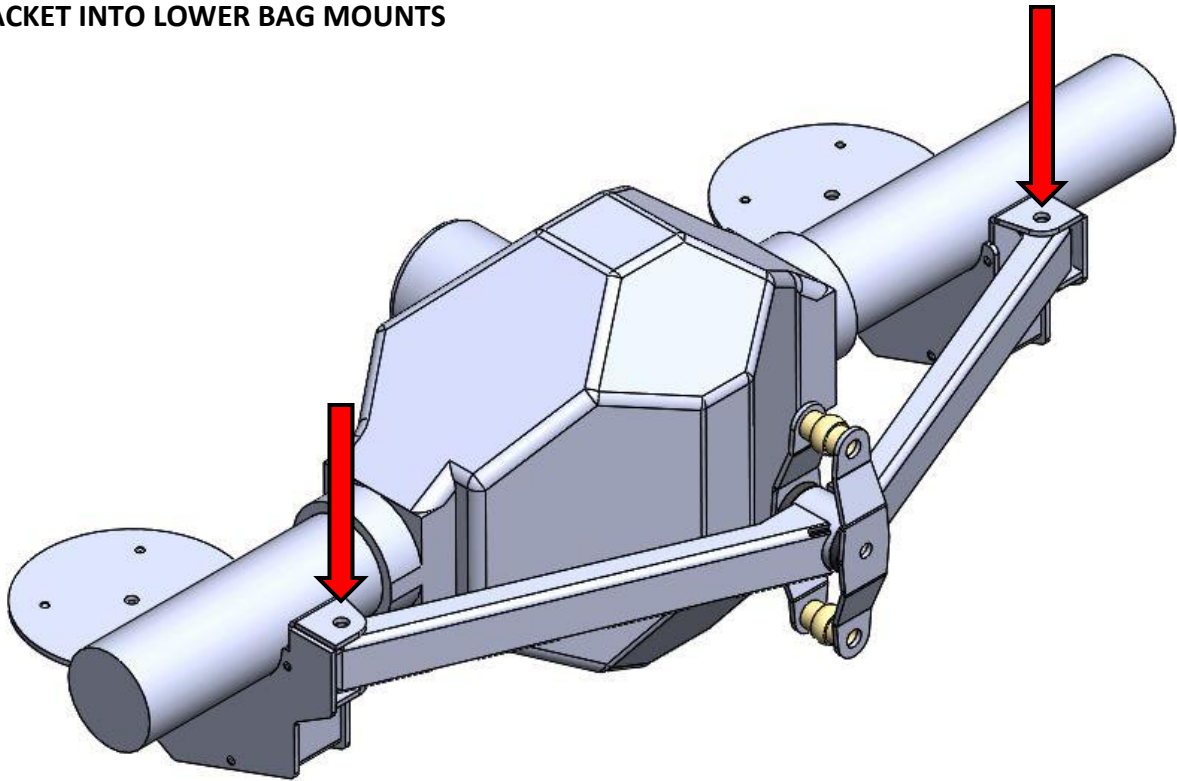
**\*\*\*DO NOT FULLY WELD AT THIS TIME\*\*\***

**NOTE:**

**\*\*\*NONE OF THE BRACKETS ATTACHED TO THE REAR DIFFERENTIAL WILL BE FULLY WELDED UNTIL AFTER MOCK-UP ASSEMBLY OF DRIVETRAIN AND DRIVE-LINE OPERATING ANGLES ARE CONFIRMED\*\*\***

## **WATT'S LINK; LOWER BAG MOUNT INSTALLATION**

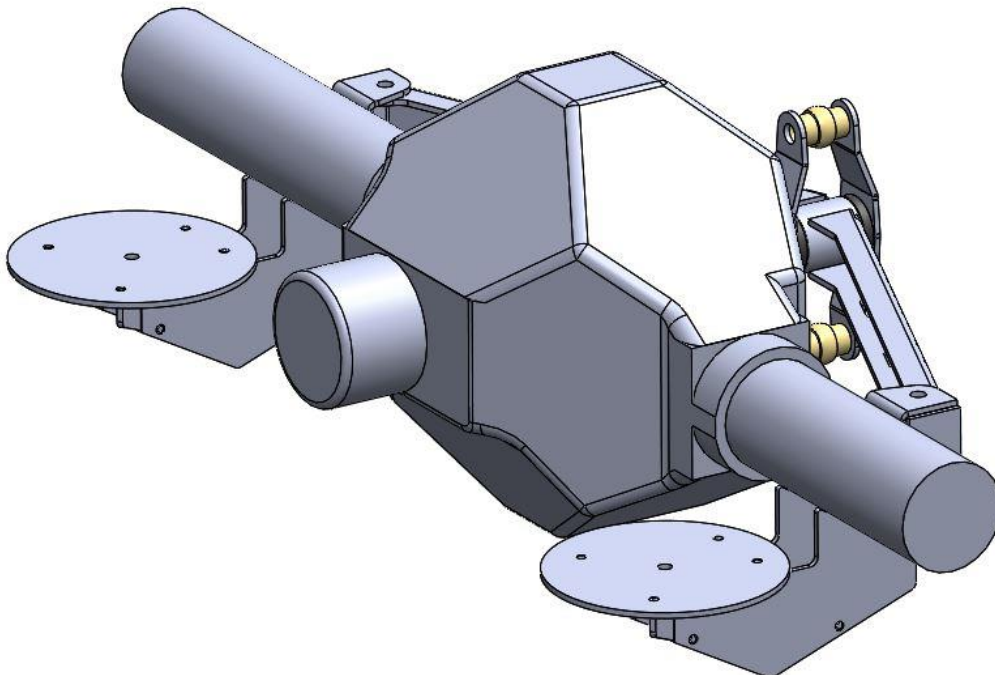
**MOCK-UP LOWER BAG MOUNTS/WATTS LINK ASSEMBLY BY BOLTING WATTS LINK PIVOT BRACKET INTO LOWER BAG MOUNTS**



**WATTS LINK PIVOT BRACKET WILL SET BAG MOUNTS TO PROPER WIDTH**

**CENTER WATTS LINK AND LOWER BAG MOUNT ASSEMBLY ON REAR DIFFERENTIAL**

**SET LOWER BAG MOUNTS PERPENDICULAR TO GROUND AND TACK WELD TO AXLE TUBES**

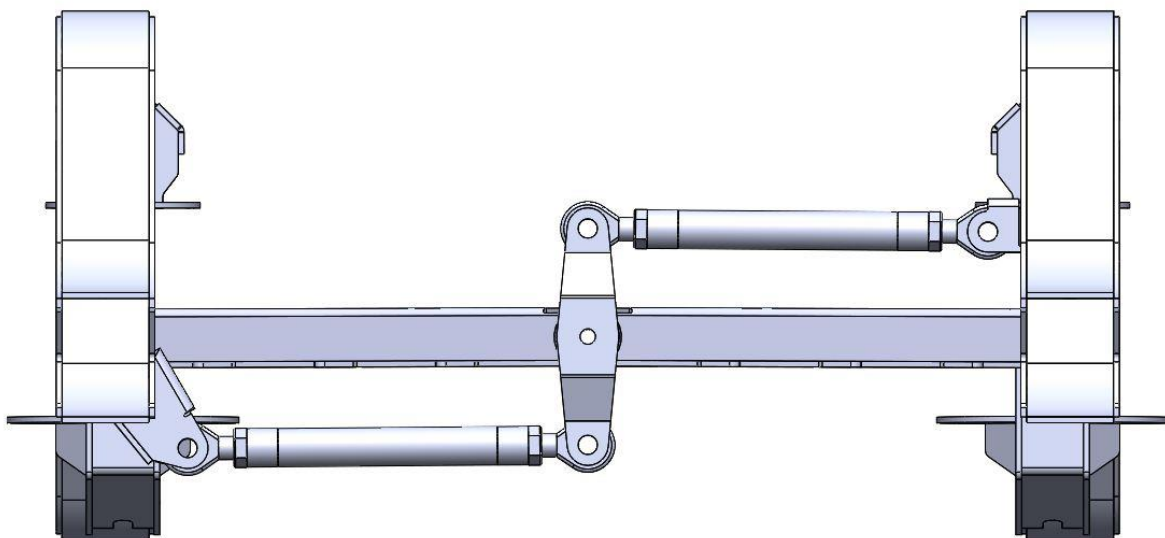
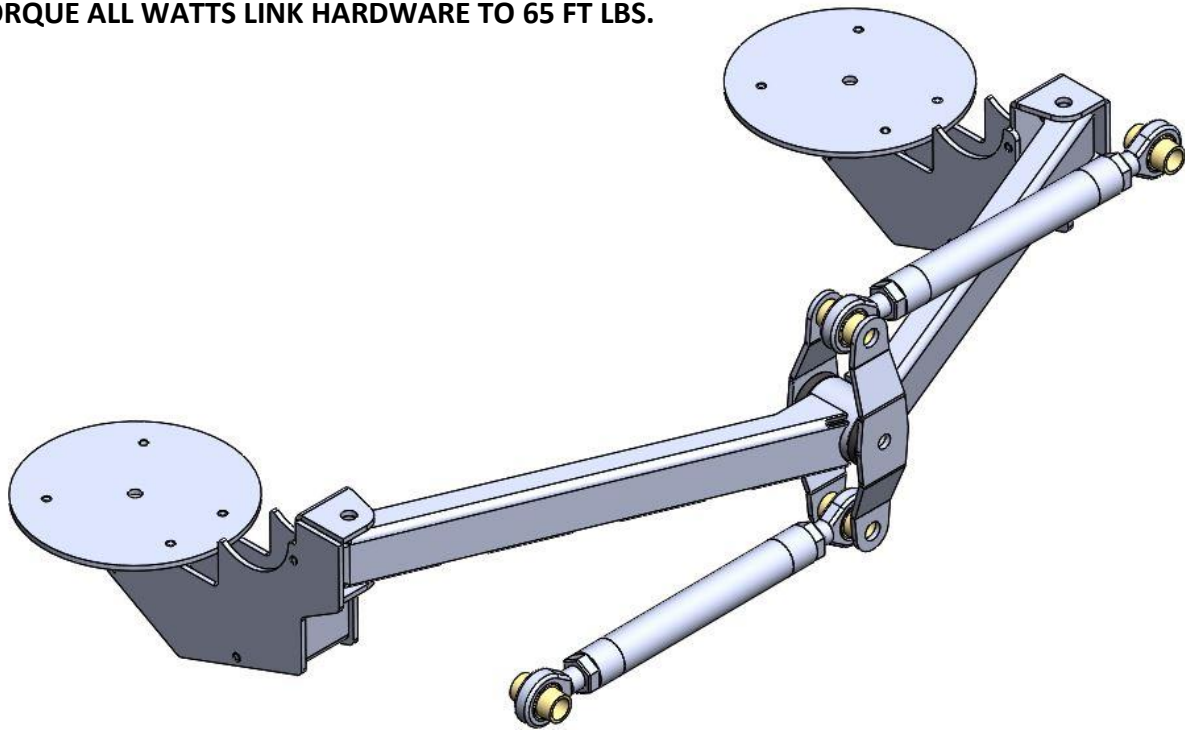


**USE IMAGES AS REFERENCE FOR WATT'S LINK ASSEMBLY**

**MAKE SURE TO USE SOME FORM OF ANTI-SEIZE LUBRICANT ON ROD END THREADS WHEN THREADING INTO WATTS LINK BARS; FAILURE TO DO SO COULD DAMAGE THREADS**

**ONE END OF THE WATTS LINK ADJUSTABLE LINK WILL HAVE A GROOVE, THIS INDICATES A LEFT HAND THREAD; IT WILL CORRESPOND WITH THE LEFT HAND THREAD ROD END WHICH CAN BE IDENTIFIED BY THE GOLD ZINC JAM NUT.**

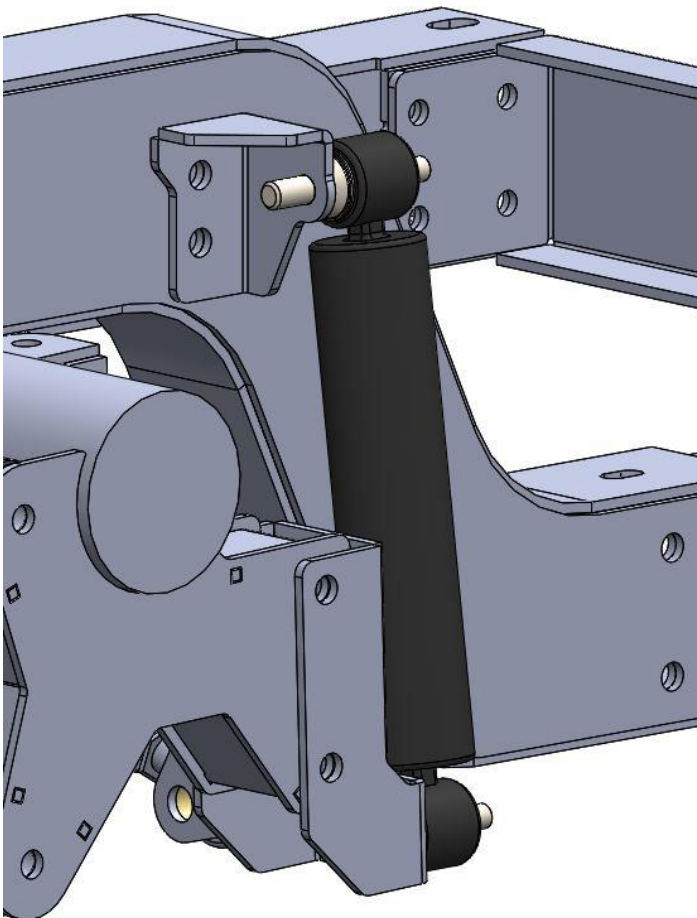
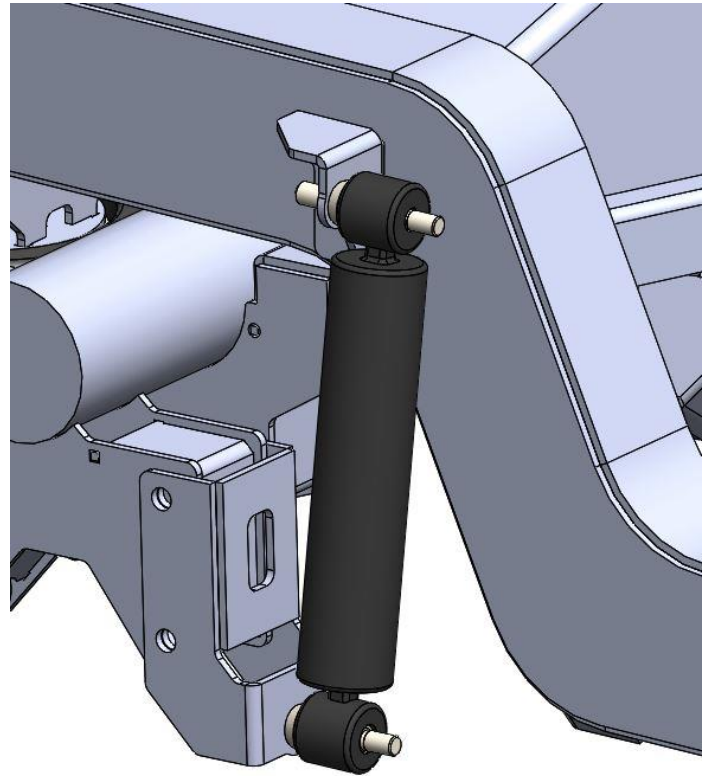
**TORQUE ALL WATTS LINK HARDWARE TO 65 FT LBS.**



## SHOCK MOUNT INSTALLATION

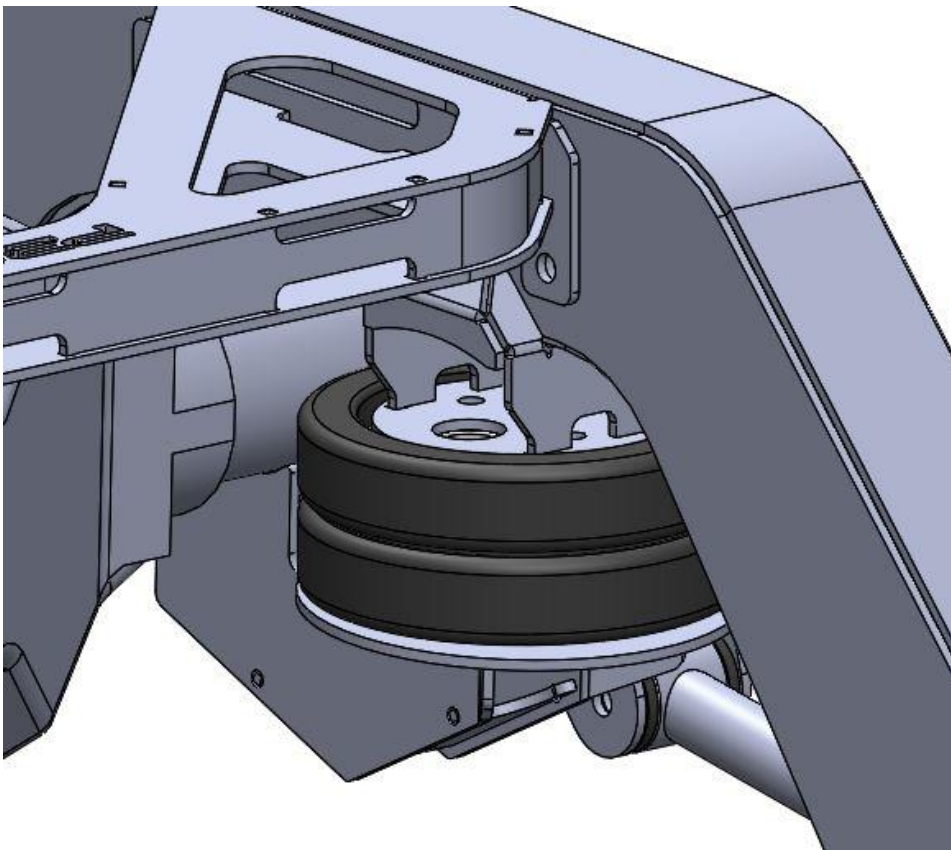
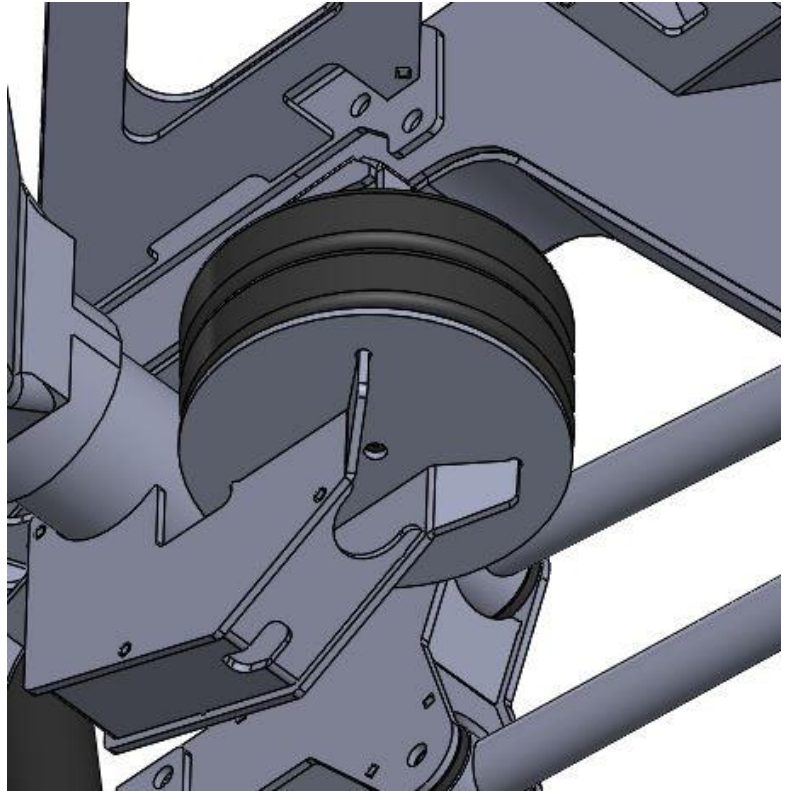
USE IMAGES BELOW TO REFERENCE UPPER AND LOWER SHOCK MOUNTING BRACKET AND SHOCK INSTALLATION

\*\*\*TORQUE MOUNTING HARDWARE TO  
65 FT LBS\*\*\*



## AIR BAG INSTALLATION

USE SUPPLIED GRADE 8 HARDWARE TO INSTALL DOM2600 AIRBAGS (SEE BELOW IMAGES FOR REFERENCE)



## **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

EMAIL: [NATE@PBFAB.COM](mailto:NATE@PBFAB.COM)

TEXT: 480-310-9847