



'57-'64 Ford Pickup Rear leaf Spring Kit Installation Instructions

Tech Line: 1-855-693-1259

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CHECK ALL PARTS INCLUDED IN THIS KIT TO THE PARTS LIST BEFORE INSTALLING THE KIT.
IF ANY PIECES ARE MISSING, PLEASE CONTACT: TOTAL COST INVOLVED 1-855-693-1259



Parts

(2) 48 inch leaf springs	(4) U-bolts	(16) 3/8-24 x 1 1/4bolts & nuts	(2) 1/2-20 x 4 bolts
(2) Leaf spring brackets	(2) 5-hole plates	(4) 7/16-20 x 1 1/4 bolts	(14) 1/2-20 nuts
(2) Shackle brackets	(2) Spring pads	(32) 3/8 flat washers	(8) 1/2 flat washers
(4) Shackle plates	(2) Shock absorbers	(16) 7/16-20 nuts	(2) 1/2 x 5 bolts
(4) Shackle pins	(1) Shock cross member	(2) 7/16-20 x 5 1/2 bolts	
(8) Shackle bushings	(2) Shock studs	(12) 7/16 flat washers	

Support the front and rear of the chassis on jack stands. Remove the bed to gain access to the frame. Remove the rear axle assembly, stock springs, and shocks. **Be safe!** Avoid pulling and pushing on the vehicle while it is off the ground.



Remove the front & rear stock spring hanger brackets. To remove the rivets, grind the heads flush. Center punch and drill using progressively larger bits up to a 5/16". The rivet should be easy to punch out. If not, then drill with a 3/8" bit. Take care not to drill the original rivet holes larger or off center, the new parts will use these holes.



Passenger Side Shown

These brackets are the same, left or right (Passenger or Driver) so they can't be installed incorrectly. The brackets will bolt directly to the existing stock spring hanger holes. There are 4 bolts that need to be installed at this stage. Tighten down the bolts making sure the bracket pulls up tight against the frame.



Passenger Side Shown

Using the bracket as a guide drill two 7/16" holes from underneath.



Passenger Side Shown

Install hardware and tighten down.

repeat for Driver's side



There is a right and left (Passenger and Driver) side for the rear brackets.



Driver Side Shown

The TCI Engineering rear spring hanger bracket uses the factory hanger bracket holes. Install the 4 bolts and hardware and tighten down.



Passenger Side Shown

Using the bracket as a guide drill one 7/16" hole from underneath.

Install remaining hardware and tighten down.

repeat process for the other side



Installing rear shock cross member

Measure from the center of the rear bed hole going forward.



Make a mark at 37" on both passenger and driver side frame rails. Draw a line across the top of the frame rail at 37". This is done so that we can find the center of the frame rail from side to side. That way the crossmember is centered in the chassis.



Set the cross member on top of the rails at 37" centers.
Center the cross member for and aft on the line. Take measurements on both passenger and driver side in order to center the cross member from side to side as pictured.

Center punch one side with a 1/2 inch transfer punch as pictured in the lower left corner. Remove the crossmember and drill the hole to 1/2 inch.

Set the cross member back up on top of the frame rails and insert a 1/2 inch bolt through the cross member and through the hole in the frame as pictured in upper right. On the opposite side frame rail, line up the tube to the frame mark and center punch the frame and drill the hole out to 1/2 inch.



Install the cross member between the rails with the shock tubes parallel to the ground and facing forward.

NOTE If the cross member is installed upside down the shock tubes will be pointing up (facing forward).

Install a 1/2" bolt through the frame into the cross member on one side to register it properly. On the opposite side use a 1/2" transfer punch to go through the frame hole and cross member to center punch the hole. Remove the crossmember. Use a small, long drill bit and drill down through the 1/2" top hole into the center punch mark. The final 1/2" hole can be drilled from the bottom to keep the bit from 'walking'. Slide the cross member back up to the hole and install the 1/2" bolt all the way through. The cross member is positioned correctly now so you can drill through the top hole with a 1/2" bit using the cross member as a guide.
Install hardware and tighten down.



Spring Installation

Passenger Side Shown

Install the spring end with the pressed in steel lined bushing in the front hanger using the 4" x 1/2" bolt. Install nut and lightly tighten.

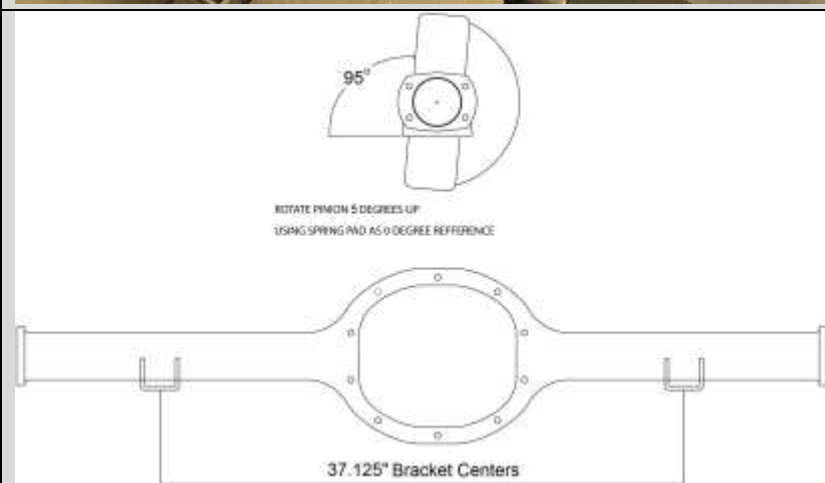


Passenger Side Shown

Install the shackle urethane bushings into the rear of the spring and the rear shackle hanger with the supplied Poly Lube. Use a soft hammer to tap them in. The bushings will stick out just a little but will seat fully when the shackle plates are fully tightened.

Lightly tap the shackle pins through the bushings in the spring and the rear shackle hanger. Install the shackle plates (Dog Bones) over the ends of the pins, install the nuts and tighten.

Finish tightening the front spring hanger bolts.



Installing spring pads.

Measure the center to center measurement of the spring center bolts on the springs that were just installed. This will be the spring pad centers measurement. Center the pads on your housing.

The pinion angle is 5 degrees up from the spring pads with the spring pads being level. Clamp or lightly tack weld the brackets and double check brackets for equal side to side centering and the correct pinion angle. Finish welding the brackets.



Installing the housing

Set the housing on the rear leaf spring center bolts. Drop the u-bolts over the housing. Install the 5-hole plates under the spring with the shock tab facing down on the inboard side and behind the axle. Install the 1/2 x 20 nuts on the u-bolts and tighten evenly.

Installing the shocks

Install the 1/2 x 20 threaded end of the shock stud through the shock tab. Install nut and tighten. Install the rubber bushing end of the shock onto the stud, install 7/16 washer and nut. Using a 7/16 washer on each side of the steel sleeve end of the shock install the 7/16 x 5 inch bolt through the shock and through the tube on the cross member, install nut and tighten.



You are now finished with the installation of the leaf spring kit.

Replacement Parts:

Shocks = Monroe Part# 33121

Shackle Bushings = Energy Suspension Part# 2866.01

No returns or exchanges without a RMA#.

Packages must be inspected upon receipt & be reported within 10 days.

If you are missing parts from your kit, TCI Engineering will send the missing parts via FedEx or U.S. mail ground.

Returned packages are subject to inspection before replacement/refund is given.(Some items will be subject to a 15% restocking fee)

Thank you for your business!

