



Part # 11339590 - 1963-1972 C10 Delrin Control Arm Bushings



Recommended Tools



1963-1972 C10 Delrin Control Arm Bushings Installation Instructions

Table of contents

Page 2..... Included Components and Hardware List
Page 3&4..... Bushing Installation





Major ComponentsIn the box

Part #	Description	QTY
90002603	Upper Control Arm Cross Shaft	2
90002604	Upper Control Arm Bushing Outer Shell	4
90002605	Upper Bushing Inner Sleeve	4
70012658	Delrin Upper Control Arm Bushing	4
90002430	Lower Control Arm Cross Shaft	2
90002608	Lower Control Arm Bushing Outer Shell	4
90002609	Lower Bushing Inner Sleeve	4
70012661	Delrin Lower Control Arm Bushing	4

HARDWARE

Part #	Description	Usage	QTY
99622003	5/8" -18 Top Locknut	Upper Control Arm Shaft Nuts	4
99623001	5/8" SAE Flat Washer	Upper Control Arm Shaft Washers	4
99752005	3/4" -16 Top Locknut	Lower Control Arm Shaft Nuts	4
99753004	3/4" SAE Flat Washer	Lower Control Arm Shaft Washers	4

Getting Started.....

The Front Control Arms will need to be removed from the truck. Mark the shims, they will be reinstalled in the same location they were removed from. Retain the OEM hardware for reassembly. Refer to the Factory Service Manual for disassembly procedure.

This C-10 Bushing Kit contains: 2 Upper Cross Shafts, 4 Upper Control Arm Bushing Assemblies, 2 Lower Cross Shafts and 4 Lower Control Arm Bushing Assemblies. The Upper Bushings are all the same and the Lower Bushings are the same. Be sure to match the correct Bushings with the correct locations.

The OEM Bushings are removed by threading them out of the Control Arm. It is easier to do with the cross shaft clamped in a vise.

1. Measure the Outside Width of the Control Arms and write it down before starting Bushing Removal. You will use this Dimension to check the Control Arms after the new Delrin Bushings are installed.



Delrin Bushing Installation

The Cross Shaft must be put in place and in the correct orientation before installing the Bushing Shells in the Upper & Lower Control Arms.

There are several ways the Delrin Bushing Assemblies can be installed. No matter the method used, the Control Arm needs to be **SUPPORTED** to keep from distorting the Control Arm. We recommend cutting spacers to go inside the Control Arms when using a Press to install the Bushings. We have used several different methods to install the Bushing Assemblies. We are going to cover the one that worked best for us. When installing the Bushings, the Outer Shell will be installed in the Arm by itself. Next, Press the Inner Sleeve into the Delrin Bushing to install them. Use the OEM Control Arm Washer and Nut to push the Assembly into the Outer Shell. Tighten until both Bushing/Sleeve bottom out against the Outer Shell.

DUE TO VARIATIONS IN THE THREADS OF THE CONTROL ARM, WE RECOMMEND TACK WELDING THE BUSHING SHELLS TO THE CONTROL ARM.

Note: The Delrin is self-lubricating, no lubricant is needed.



2. Disassemble the Bushing being installed. When installing Bushings in the Control Arms, insert the Cross Shaft before installing the 2nd Outer Shell, you can install the 1st Outer Shell before inserting the Cross Shaft. Support the Back Side of the Flange the Bushing (**Figure 2**) is being Installed in. Use a STIFF piece of Metal clamped in a Bench Vise for the Control Arms (**Figure 3**). They can be supported by either the piece of Metal or by the Bench Vise with the Jaws opened wide enough to let the Bushing Shell pass through (**Figure 4**).



3. When installing the 1st Shell, use another Piece of Metal or Strong Wood to Drive the Outer Shell into the Control Arm until the Shell stops against the Control Arm. **Install the Cross Shaft before installing the 2nd Shell.** You will need to use a piece of pipe or a deep socket to install the 2nd Shell due to the shaft sticking through.

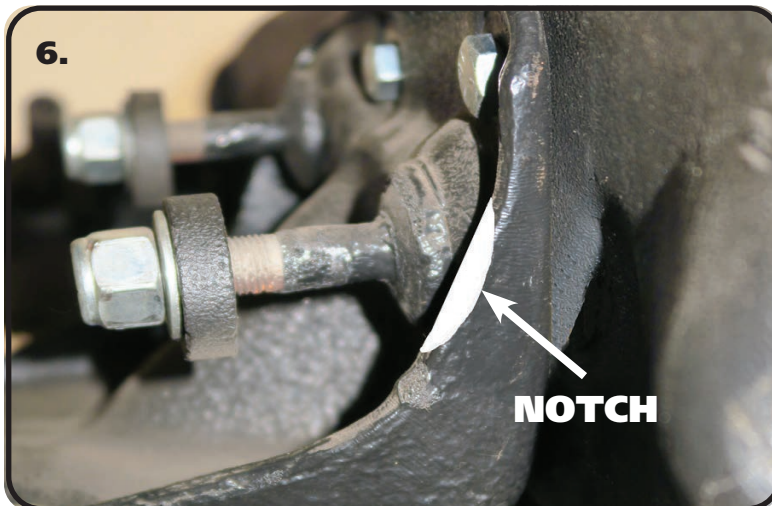


Gusset Clearance

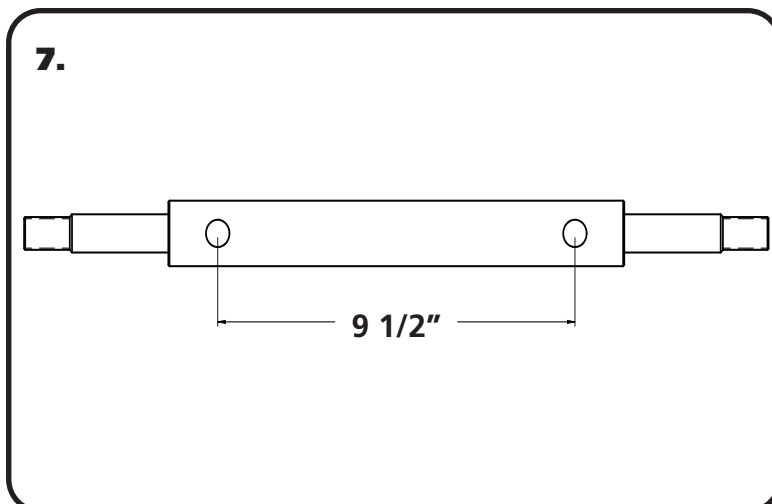


4. Press the Delrin Bushing & Inner Sleeve into the Bushing Shell. **DO NOT DRIVE IN WITH HAMMER.** You may **LIGHTLY** tap them to get them started.

5. Reinstall the Outer Washer & Nylok Nut and finish pushing the Bushings in with the hardware. Tighten Hardware to eliminate any gaps between the Bushings and Cross Shaft.



6. Due to variations in production, it may be necessary to notch the **REAR** gusset of the OEM Upper Control Arm Mount. After the Bushings are installed in the Upper Control arm, slide it on the Upper Control Arm Mounting Bolts to check for clearance. **DO NOT** have any Shims installed on the Mounting Bolts when checking for clearance. Slide the Control Arm on the Bolts until it is tight against the conical washers, check for clearance. Grind a notch in the Gusset to provide clearance if the Bushing is hitting.



7. The Lower Cross Shaft has 2 different locating Hole patterns. This StreetGrip kit uses the 9 1/2" center to center locating holes. The Pin in the Cross Shaft Saddle will locate into these Holes.

8. Reattach Control Arms to Truck. Use the OEM Hardware to attach the Lower making sure the Locating Pin is in the 9 1/2" center to center Holes. Reattach the Upper Control arms using the OEM Hardware and reinstalling the Alignment Shims.