



1937-1939 Chevy Truck Rear Air Bag 4 - Link Kit

Installation Instructions

1-866-925-1101

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**CHECK ALL PARTS INCLUDED IN THIS KIT TO THE PARTS LIST BEFORE INSTALLATING OF THE KIT.
IF ANY PIECES ARE MISSING, PLEASE CONTACT: TOTAL COST INVOLVED 800-925-1101**

Note:

These instructions are for TCI Engineering rear air bag 4 - link kit. It requires the removal of the mid frame brace. Read through all of the instructions before beginning the installation.

Place the vehicle on a hard level surface and use an appropriate jack and jack stands to raise the vehicle off the ground.

Remove the bed, rear wheel, rear axle assembly, and the existing rear leaf spring suspension.

Remove the rivets from the front and rear leaf spring hanger brackets on the frame. Use a grinder to grind down the heads of the rivets, then use a hammer and chisel to tap them out.

Figure 1a



Figure 1b

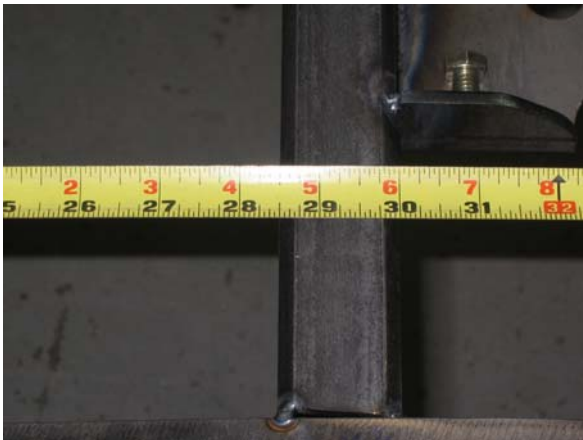


The first thing that needs to be done is to square off the inside frame rail edges. Plasma cutter works a lot faster, but it can also be done with an electric hack saw. (See Figure 1a, 1b)

Figure 2



Once it's squared off, it's time to box the frame rails. Welding it in one pass may distort the frame rails. It is best that you stitch weld the frame a few inches at a time. Alternate your welds between the top, bottom and side to side.

Figure 3a**3b****Figure 5a, b**

Its time to install the air bag crossmember and the shock crossmember. **When installing the crossmembers it is important that it is 0 degrees.** Locate the front bed mounting hole. This will be the reference point to locate the air bag crossmember. Using a long straight edge, place it on the center of the front bed mounting hole. Clamp it down. From the front of the straight edge to the front of the air bag crossmember is **28.5"**. (See **Figure 3a, 3b**).

Figure 4

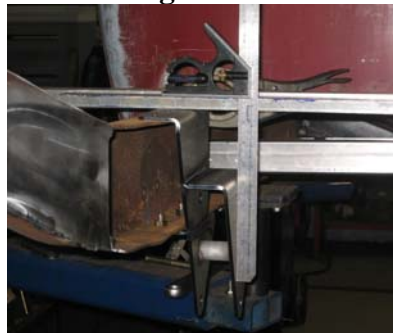
Mount the crossmember to the top of the frame. Then tack it in place. (See **Figure 4**).

Figure 5a**Figure 5b**

Next its time to install the shock crossmember. The measurement from the front of the air bag crossmember to the front of the shock crossmember is 11 5/8". Then Tack it. (See **Figure 5a, 5b**).

Figure 6a**Figure 6b**

Now is the time to remove the mid frame brace. After its remove slide the 4 – link bracket in place. Line up the 2 holes in the bottom of the bracket against the 2 stock rivets hole on the bottom of the frame. Then bolt the two down. (See **Figure 6a, b**).

Figure 7a**Figure 7b**

Next thing to do is to make sure the bracket is 90 degrees with the frame. Using a straight edge put it on top of the brackets and then use a square to make sure its 90 degrees. (See **Figure 7a, 7b**)

Figure 8a**Figure 8b**

Clamp the top of the brackets to the frame, then drill the remaining holes. Once the hole is all drill, bolt it down. (See **Figure 8a, b**)

Welding the axle bracket to the housing is next. The center to center on the bracket is 34". But you can also get the centers by measuring the 4-link bracket on the frame. The angle on the pinion is 3 degree pointing up. Then tack it in place. Next its time to put the air bag housing bracket. The centers are 24.5" at 0 degree.

Now that the cutting and welding are done. The next steps are to bolt on the suspension pieces.

Start by installing the 4 – Link bars. From the frame bracket to the housing. Next we install the shocks to the shock crossmember. You will need a spacer, which is provided with the kit. It goes in between the shocks and the housing bracket. The last part is to install the air bags. Once that is all done connect the air line to the bags.





Parts List

(4)	23" 4-Link Bars 0 degree	(12)	3/8 - 24 x 1 1/4 Bolts
(2)	All -American Shocks	(12)	3/8 - 24 Nyloc Nuts
(2)	Tapered Air Bags & 90 degree fittings	(18)	3/8 Flat Washers
(1)	34" Track Bar	(6)	3/8 - 16 x 3/4 Hex Bolts
(2)	4-Link Housing Brackets	(6)	3/8 Lock Washers
(2)	4-Link Bolt On Brackets	(2)	5/8 - 18 x 3 Hex Bolts
(1)	Air Bag X-Member 24.5" C to C. 39" Long	(6)	5/8 - 18 x 3 1/2 Hex Bolts
(1)	Shock X-Member 28" C to C. 40" Long	(2)	5/8 - 18 x 4 Hex Bolts
(2)	Boxing Plates	(2)	5/8 - 18 x 5 1/2 Hex Bolts

Thank you for purchasing a TCI Product. If you have any questions please call 1-800-984-6259 or visit www.totalcostinvolved.com.