



Installation Instructions

Frame Brackets (Part # CC100)

1967-1991 GM 4WD Pickups, Blazers, Suburbans equipped with power steering and has front leaf springs suspension system.

CAUTION: Before beginning installation, read entire instructions carefully. This kit should be installed **ONLY** by a certified front end and welding mechanic/specialist. SAFETY GLASSES SHOULD BE WORN AT ALL TIMES DURING INSTALLATION

Step 1: Raise the front of the truck and place it on jack stands. Remove the driver side tire and wheel. Unbolt the drag link assembly and pitman arm bolt and nut. Now, unbolt the steering shaft linkage from the steering box. On power steering vehicles, remove hose at steering box. (Keep hose upright to prevent leaking fluid) It is recommended to cover hose end and steering box fittings with tape to avoid dirt or other particles from entering.

Step 2: Remove the bolts that attach the steering box to the frame and steering box assembly. Check the vehicle frame for cracks. If any cracks exist use a grinder and grind a "V" shaped groove along the entire length of the crack. Weld the groove as necessary. Grind the weld until it is flush with the frame. (Do not over-grind as this will weaken the repaired area).

Step 3: Secure the large (8 hole) plate (Figure 1) to outer frame rail at the steering box location by aligning the four raised holes with bolts facing downward. Check to make sure plate sits flush and level against frame. If necessary, clamp plate to frame to hold it flush and tight against rail and /or apply heat to plate using a torch to flatten plate as needed.

Step 4: After the plate is flush to the frame weld plate to frame. (ONLY IN AREAS SHOWN IN FIG 1.)
Note: Do not weld entire circumference of plate. Now weld the 4 remaining holes in plate for additional bonding.

Step 5: Take the other (2 hole) plate. (Figure 2) Place it on the underside of the frame aligning the two holes on the plate with rivets the bottom of the frame. Clamp plate flush to frame and into position, then tack weld on the inside and outside of plate where clamped. Remove clamps and tack weld at each end of the plate. Now weld in areas show in (Fig 2)

For Technical Support/Warranty Information please call 310-762-9944

Smittybilt, 400 West Artesia Blvd. Compton, CA 90220



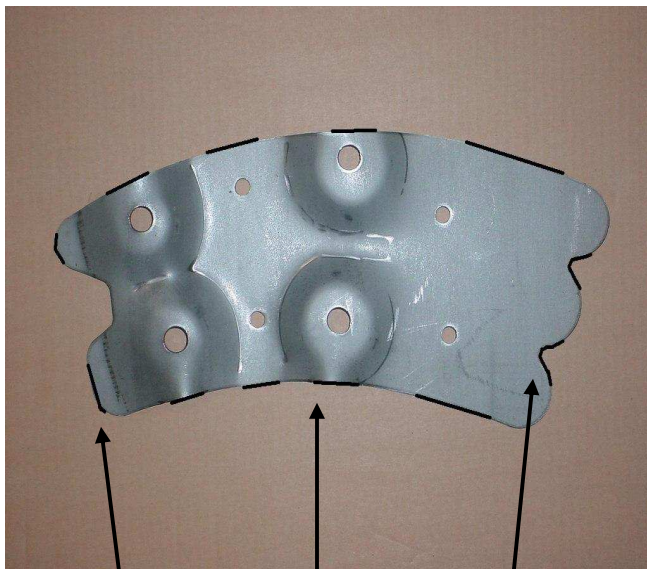
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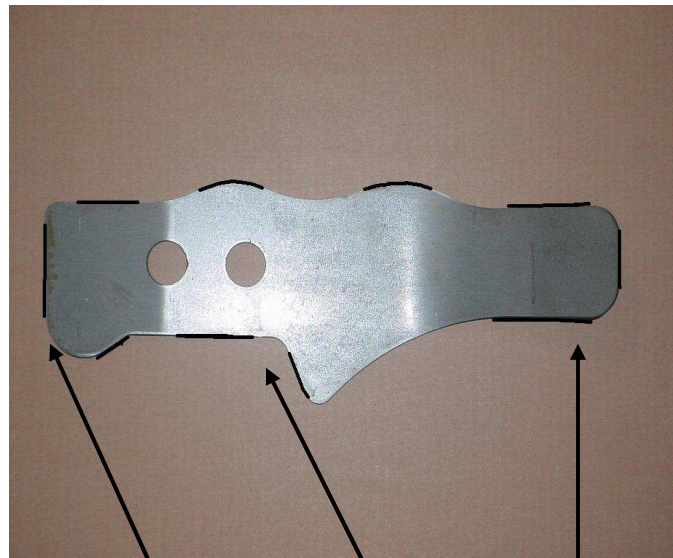
Step 6: Re-install steering box to frame. Tighten the four bolts to 70 ft/lbs. Remove tape from hose ends and fittings that you taped in Step 1 and re-attach hose to box. Re-install steering shaft linkage to steering box. Tighten frame bolt nuts to 25 ft/lbs. Bolt the drag link assembly and pitman arm back into place on the steering box. **Note:** Pitman arm and shaft are notched for proper location and alignment. Tighten Pitman arm bolt to 60 ft/lbs. Re-install the driver side tire and wheel. You may now remove jack stands and lower the vehicle to the ground. (Be sure to check power steering fluid level and add fluid if necessary. Installation is now complete.

(Figure 1)



Weld in all outlined areas
around the plate.

(Figure 2)



Weld in all outlined areas
around the plate.

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