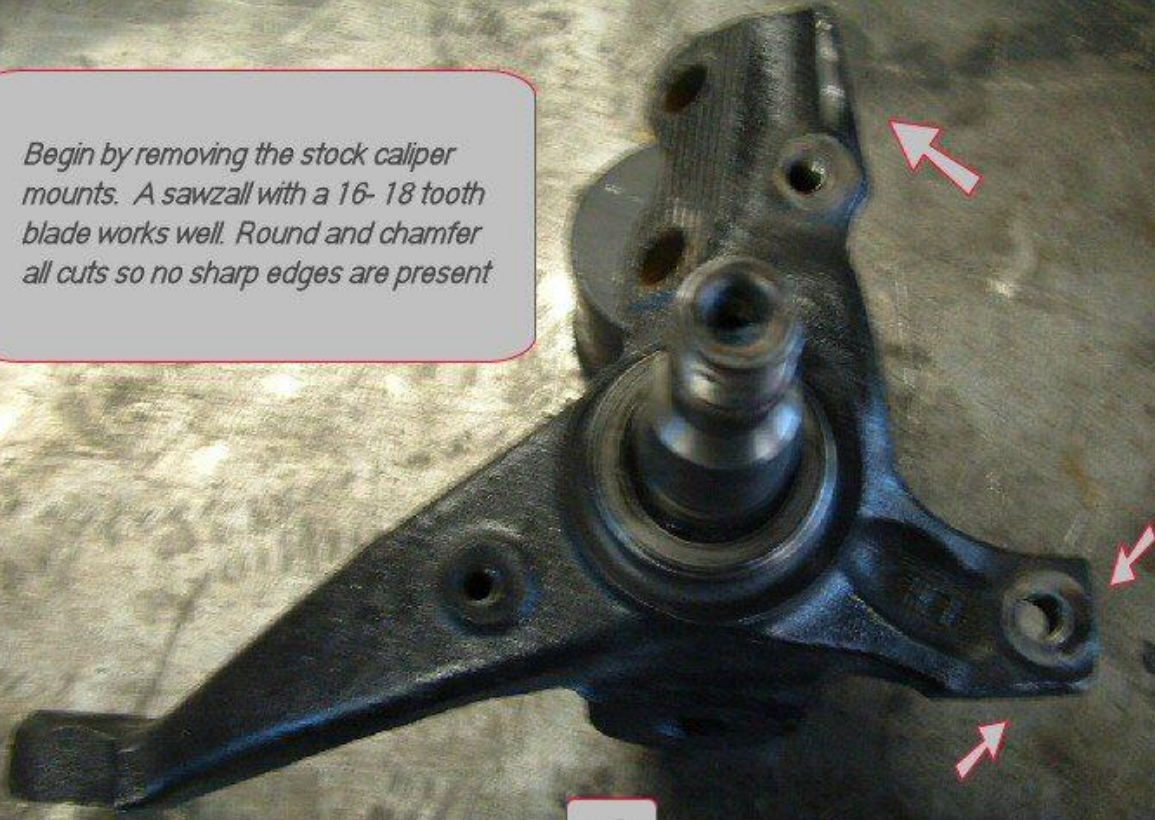
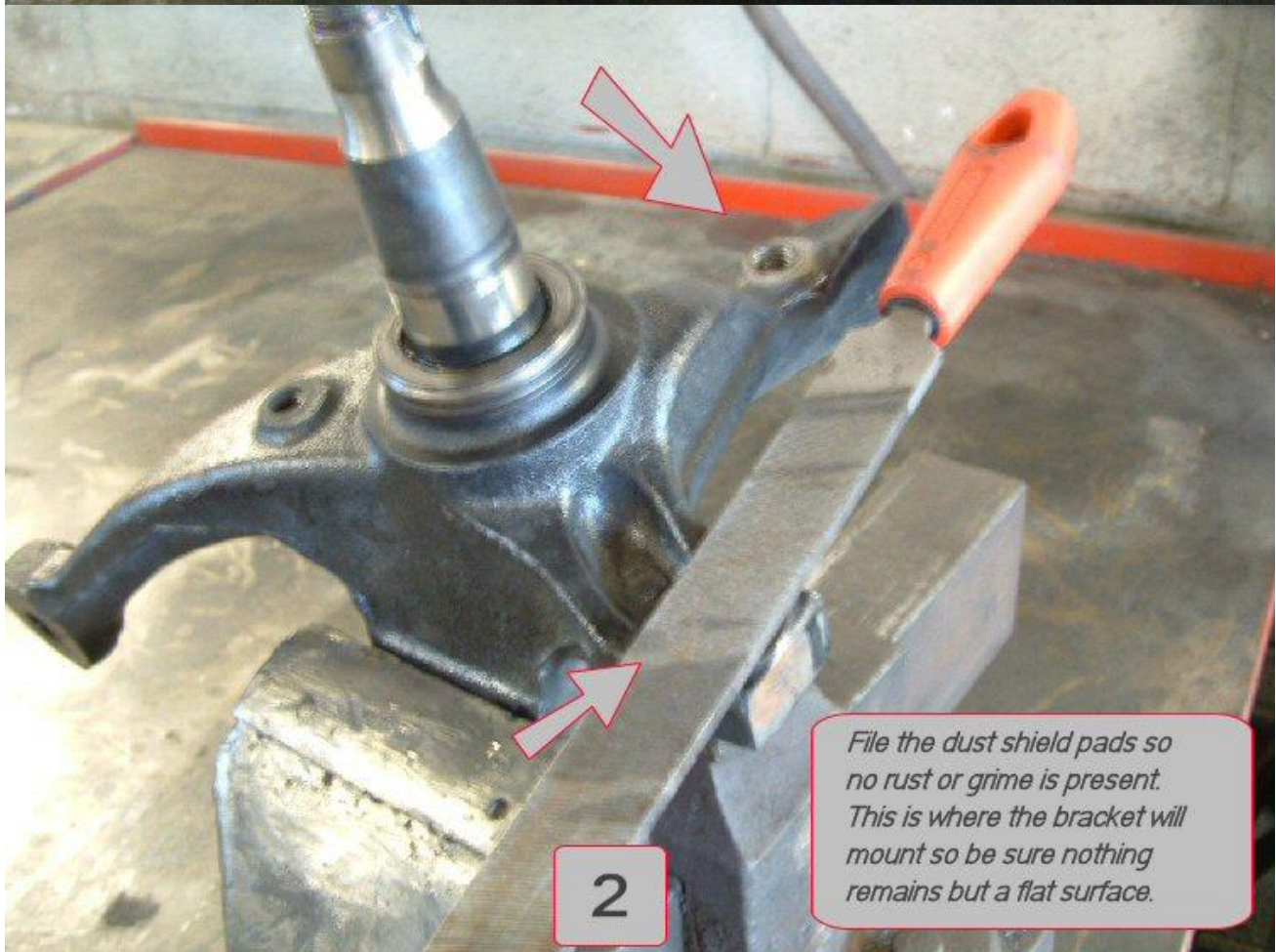


*Begin by removing the stock caliper mounts. A sawzall with a 16- 18 tooth blade works well. Round and chamfer all cuts so no sharp edges are present*



1



*File the dust shield pads so no rust or grime is present. This is where the bracket will mount so be sure nothing remains but a flat surface.*

2





*Drill the shield holes out using a 13/32 drill bit. Be sure to drill straight down the original holes. Drill deep enough to allow for enough thread engagement in the upper hole.*



*Tap drilled holes to 12mm x 1.75, tap slowly with a light oil, backing the tap out occasionally to clear the flutes of the tap.*



Some spindles will require a few areas to be relieved of a small amount of material. Trial fit your bracket to determine if it is required. Grind these areas to allow the bracket to sit flat on the pads without touching any other part of the spindle.




Trial fit the bracket, be sure the lower hole (arrow) lines up with the bracket, lightly torque the upper bolt with a ratchet.

Be sure to check all angles of the bracket to assure there is no interference with any portion of the spindle aside from the dust shield pads.








Tap the spindle and bracket together clamped in a vise to hold them secure. Tap slowly with light oil, take care not to burden the tap when entering the steel bracket, it can snap off if care is not taken. Any irregular spots near the hole should be filed flat so the head of the bolt will seat properly against the spindle.

7



Spindle and bracket that has been tapped together. This is ready for loctite 271 and a 10.9 hardened bolt.

8



Have your torque wrench set to 85 ftlbs. apply a few drops of non-removable thread locking compound. In most cases the correct color of the compound will be red. 271 is the name of the locite brand compound.




9

Some 12mm x 1.75 x 30mm length will have a small shoulder under the head of the bolt, if so the first 1 or 2 threads of the spindle must be opened up to accept the bolt. use a drill bit two sizes bigger to open it.



10



With both bolts treated with loctite and threaded into the spindle and bracket, torque both bolts to 85ftlbs.

11



With the bolts torqued the spindle is complete. The arrow shows a point that can contact the bore or the LS1 caliper, this area should be flush with the bracket to be assured that no contact can occur.

