



INSTALLATION INSTRUCTIONS

Part #6410

Rear Axle Flip Kit

1973-1987 GM 2wd Trucks C10

UMI Performance Inc,
509 Hemlock Street
Philipsburg, PA 16866
814-343-6315
support@umiperformance.com



Applications

1973-1987 GM 2wd trucks, Suburban, Blazer
1988-1991 GM Suburban/Blazer 2wd

Notes

For trucks equipped with GM 8.5" 10 bolt axle

Cutting/Drilling Required

Ride height is dependent upon spring pack. Designed for use with factory 3/1 leaf springs packs.

Included Parts

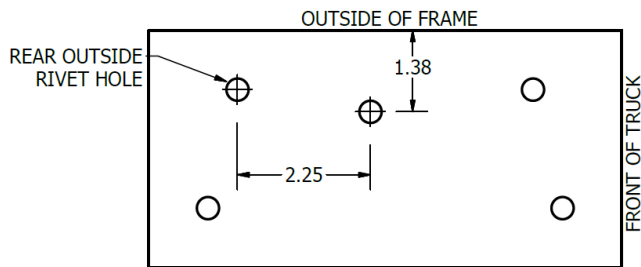
Part #	Quantity	Description
6410AB	2	Axle Flip Bracket - Black Powdercoat
6412AB	2	Lower Leaf Mounting Plate – Black Powdercoat
8U-356R	4	5/8 U bolt - Zinc
1000128	8	5/8 Hardened Washer
1000129	8	5/8-18 Tall hex Nut
6052G	2	Pancake Bump Stop
1000004	2	3/8-16 Hex Nut
1000005	2	3/8 lock washer

Optional Items

UMI6411 Rear Shock Relocation

Installation

1. Lift rear of vehicle using your preferred method. Use a vehicle lift or jack and jack stands. Support the weight of the truck under the Chassis, allowing the rear suspension to fully “droop”.
2. Remove wheels from vehicle to gain working access.
3. Support the axle with a jack or separate jack stands
4. Remove Ubolts from Rear Axle.
**Cutting may be necessary if Ubolts are rusted.*
5. Remove Front and Rear Bolts from Leaf Spring.
6. Remove Leaf Spring
7. Remove Factory Bumpstop bracket from Frame. It is attached using (4) rivets per side. Grind head of rivet until flush with bracket, then use punch or air hammer to drive rivet thru frame.
8. Drill a new hole for supplied bumpstop. Refer to dimensions below for location to drill hole.
It is recommended to paint any exposed bare metal before installing bumpstop.



9. Install Bumpstop in drilled hole. Place lock washer under hex nut.

Hardware Required:

- (2) Bumpstop
- (2) 3/8" lock washer
- (2) 3/8-16 Hex Nut

Torque: tight with hand tools

10. Repeat Steps 4 thru 9 on the opposite side of the truck.

11. Reinstall Leaf springs on the bottom Side of the axle. Reuse factory hardware for the Front and Rear Pivots. Torque factory mounting bolts to 100 ft lb.

12. Install the U shaped bracket on top of the leaf spring. Align the alignment pin in the hole of the bracket. The hole is offset toward the front of the truck, this ensures the axle is centered in the wheel well.

13. Lower the axle into the U shaped bracket.

14. Install U bolts and lower leaf plate. The flat gusset on the lower plates faces the outside of the rear axle. The forward most hole aligns with the center pin on the leaf spring.

A small amount of Anti-seize is recommended on each u bolt thread.

Hardware Required:

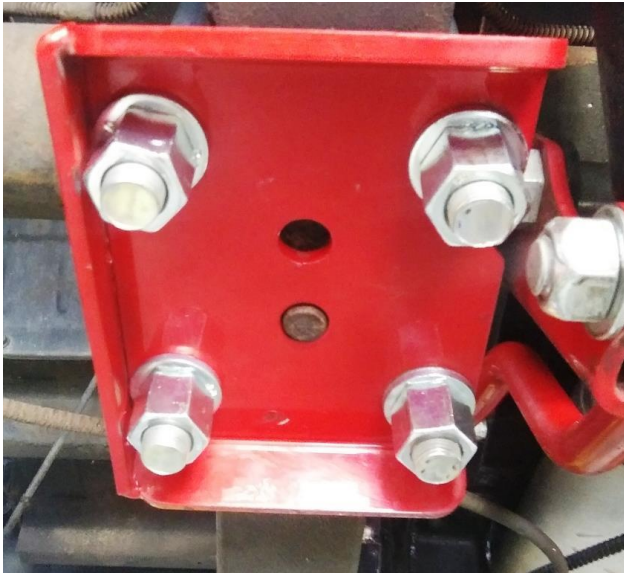
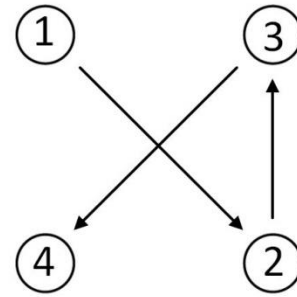
- (2) 5/8-18 x 6" U Bolt
- (4) 5/8 Hardened Washer
- (4) 5/8-18 Tall Hex Nut

Torque: 110 ft lb

Driver Side only: The shock bolt must be installed through the bracket from the outside. The nut must be toward the inside of the truck. The lower leaf plate has a notch to clear the bolt head.

Installation Continued

15. Tighten Nuts evenly in an "X" pattern. Torque to 110 Ft. lb



16. Repeat steps 12 thru 15 on opposite side of the truck

17. Reinstall Wheels and lower vehicle onto ground.

It is recommended to re check Ubolt torque after driving a short distance. Leaf springs "settle" into place and sometimes require multiple tightening/torque.

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This warranty is valid against defects in materials and workmanship for the two (2) year warranty period. It is not valid against defect resulting from, but not limited to: Misuse and/or abuse, neglect or accident, Exceeding the item's design limits, Improper installation. Acts of God, including lightning, floods, earthquakes, fire or high winds. Damage in handling, including damage encountered during shipment.

This warranty is valid for the original purchaser of the UMI Product. Warranty is not transferable or valid for second ownership.

This warranty shall be considered void if the warranted product is in any way altered, adjusted, tampered with or defaced.

The two (2) year warranty does not apply to normal wear and tear (the gradual deterioration of an asset which results naturally from use and/or age, i.e. bearings, bushings, etc.).

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UMI Performance cannot assume responsibility for any damages to UMI Products nor for claims for personal injury or property damage resulting from the use of UMI Performance products or the improper operation thereof or consequential damages arising from the products or use of the products.

UMI Performance two (2) year warranty excludes incidental charges incurred by the end user in the event of breakage (towing, labor, installation, etc.). By their very nature, competition suspension parts are continuously expected to exceed to their limits (either by race or road use). UMI suspension components are designed to withstand intense race conditions, although it is impossible to control the quality of installation or the varying conditions in which they are used.

This warranty supersedes all other warranties and may only be modified by statement in writing, signed by UMI Performance owners/principals.

All Warranties implied by law, including the warranties of merchantability and fitness for a particular purpose, are hereby limited to the warranty period herein and shall expire at the end of such period.