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C/E3623 - 84" Pro Stock Wheelie Bar Kit

PARTS LIST:

4...Pcs. 1-1/8" x .083" x 76" Tubing	4...3/8" Flat Washer
1...Pcs. 1" x .058" x 24" Tubing	2...3/8" Nylock Nuts (Fine)
2...Pcs. 3/4" x .058" x 72" Tubing	2...3/8" x 2-1/2" Grade 8 Bolts (Fine)
1...Pc. 3/4" x .058" x 36" Tubing	4...1/2" Flat Washer
4...Caster Bracket Sides	4...1/2" Nylock Nuts (Fine)
2...Caster Plate Bottom	4...1/2" x 2" Grade 8 Bolts (Fine)
2...Caster Plate Top	4...1/2" Jam Nuts (Fine)
2...Lower Caster Bracket Gusset	2...3/8" x 1" Quick Release Pin
4...Clevis Tab for Caster Brackets	4...3/16" Chassis Tab 1/2" Holes, Round Notch
2...Caster Mounting Plate	4...3/16" Large Chassis Tab 1/2" Holes
4...Tube Adapter 1/2" x 1-1/8" x .083 RH	2...1/2" x 1/2" Rod Ends (RH)
2...Tube Adapter 1/2" x 1-1/8" x .083 LH	2...1/2" x 1/2" Rod Ends (LH)
4...Wheelie Wheelz Spacers	2...1/2" x 3/8" Rod Ends (RH)

INSTALLATION:

- 1...Determine the width of the wheelie bars for your application. Clean the rear end housing in the area where the brackets will have to be welded.
- 2...Find the center of the rear end housing on the bottom and mark it. Next, measure half the distance of the total width of the wheelie bars from the center mark outward on each side. This will be where the housing brackets/tabs will be welded. Bolt 2 of the 1/2" x 1/2" RH rod ends between the notched brackets for the correct width using the non-locking nuts and tack weld in place. (The cross bar on the bottom of the four link brackets will make the best mounting spot for the brackets when using a four link. If using a ladder bar you must mount the tabs on the back side of the brackets or add a crossbar between the brackets for mounting.)
- 3...Next, build the caster brackets. Using a square tool, start with the caster mounting plate, "B" and place the caster side brackets, "D" in the alignment slots provided. (If using the orange Wheelie Wheels, weld the spacer shims, "D" into place first.) Tack the caster bracket sides into place. Once the sides are tacked into place, take the bottom caster plate (C) and slide it into place using the location slots. Tack it into place. Now, tack the upper caster plate (A) into place. Repeat the procedure for the other bracket assembly. Test fit the wheels, if all fits properly, finish welding the assemblies. (See Figure 1)
- 4...With the car set at ride height, start mocking up the lower bars. Begin by threading the tube adapters (RH) onto the rod ends that are in place on the housing. Thread them up at least half way up the rod ends. Slide 2 pc.s of the 1-1/8" x 76" tubing for the lower bars onto the tube adapters and tack weld them in place. Slip the completed caster brackets onto the tubing. Slide as far as necessary to attain the desired length needed for your application. Mark the tubes, remove the caster brackets and cut the tubing. Replace the caster brackets, making sure they are square and level, tack weld into place. These are now your main lower wheelie bar tubes.
- 5...Remove the lower bars from the car and place on suitable work area. Flip the bars over and tack the

caster bracket gussets (E) into place (See Figure 1). Flip them back over and measure each bar from the center of the wheel up each lower tube 14" - 20" and mark both bars. This will be the mounting point for the cross bar. (See Figure 2)

6...Clamp the main lower bars down to the table at the width you decided at the beginning of the installation when the tabs were installed on the bottom of the rear end housing. Make sure they are straight and square. Cut and notch both ends of the 1" X .058" x 24" piece of tubing to fit between the bars even with the marks made. This makes the cross brace. (See Figure 2) Once you have the bar square and level, tack weld it in place.

7...Cut and notch both ends of one of the 3/4" x .058" x 72" tubes to go from one of the intersections of the cross member and main lower tube to just behind the tube adapter at the upper end of the opposite main lower tube. Cut and notch the other 3/4" x .058" x 72" so that it forms an X from the other end of the cross member (See Figure 2). Next, cut the 3/4" x .058" x 36" piece of tubing in half. Cut and notch each one to fit from the center of the cross member to the bottom of the main lower tubes just behind the caster brackets. Repeat for the remaining piece of tubing to form a V. (See Figure 2). Tack weld all bars in place when correctly fitted and placed.

8...Determine where the upper wheelie bar tabs on the housing will be placed. (The upper tab placement can be narrower than the bottom.) The hole in the upper tabs that mount the top of the wheelie bars must be at least 12" or more, higher than the hole in the lower mounts. The higher the brackets are from the bottom mounts the stronger the bars will be. Bolt the 1/2" x 1/2" LH rod ends between the remaining chassis tabs using the non-locking nuts. Sand the housing clean and mark where the tab assemblies will be placed.

9...With the car at ride height, install the lower wheelie bar assembly. Place wood under the wheels so you have about 6" from the ground to the center of the pin on each wheel. Once on the wood, make sure the bars are straight and in the center of the car. If not the rod ends can be adjusted or the tabs can be moved.

10...Tack weld the 2 (LH) tube adapters into one end of each of the remaining 76" long pieces. Thread the tube adapters onto the 2 upper tab assemblies (at least half way up the threads) and place the assemblies on the marks previously made in step 8. Move the opposite end of the assemblies to align with the center of the caster brackets. Tack weld the tab assemblies into place on the housing.

11...Assemble the 4 caster clevis tabs (F) with the 2 remaining rod ends (1/2" x 3/8"). Thread the tube adapters onto the rod ends approximately half way. Slip the assemblies into the end of the 2 top bars, do not tack them in. The caster brackets and upper tubes will have to be trimmed to fit so that the brackets will be in line with the direction of the upper bars (See Figure 4). Once the brackets and tubes have been trimmed to fit, tack the tubes and tube adapters plus the caster brackets into place.

12...With everything tacked and mounted into place, make sure that wheelie bars are placed in the proper position and that they adjust properly. If everything is correct, remove all rod ends and final weld the entire assembly. Before re-installing the rod ends, lubricate them with a never-seize compound.

Before re-installing the rod ends make sure that you use anti-seize on all the threads.

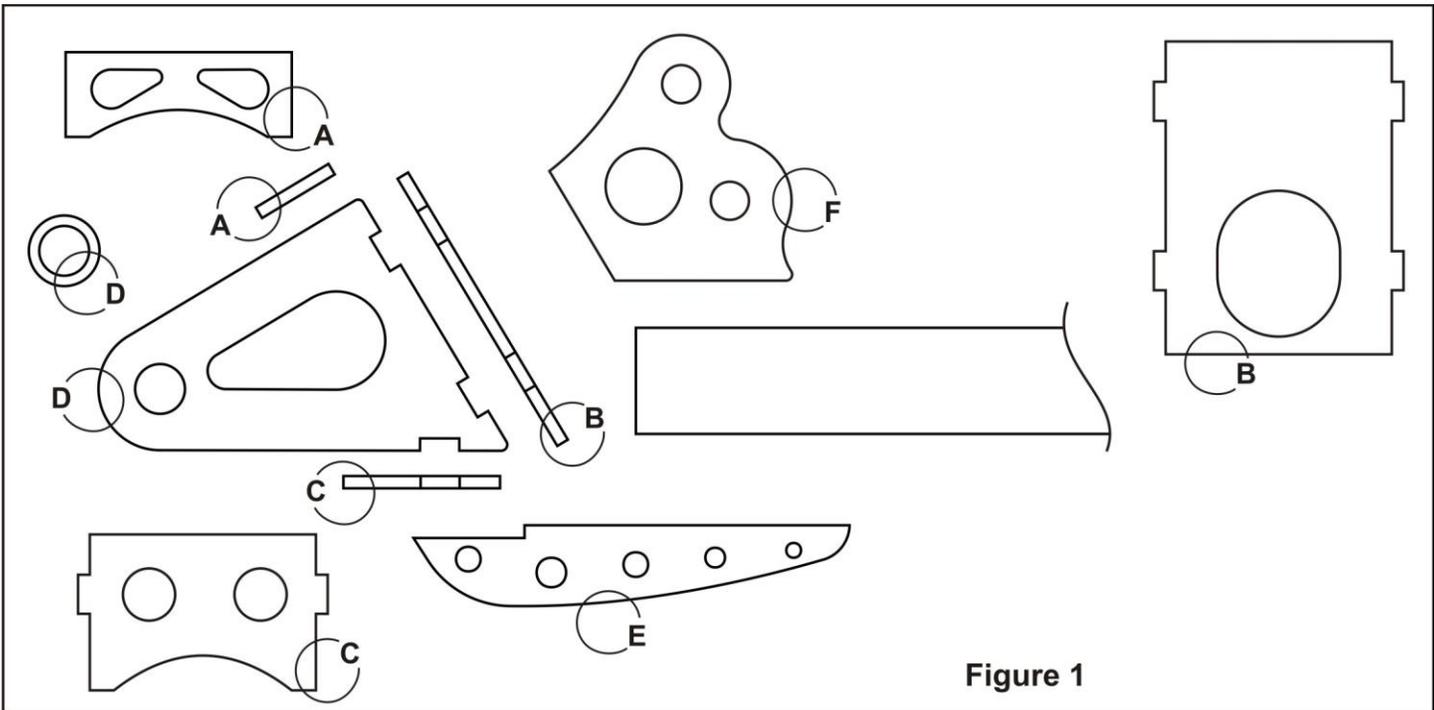


Figure 1

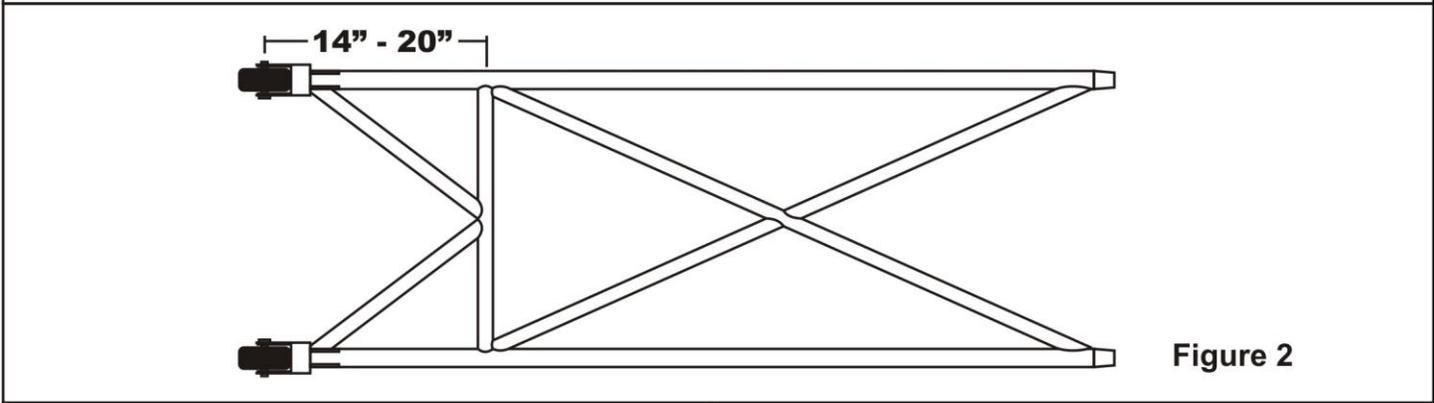


Figure 2

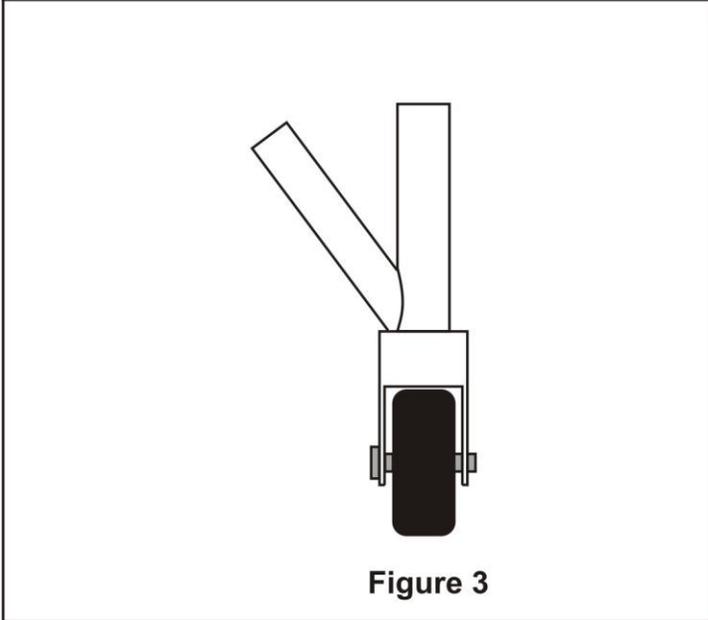


Figure 3

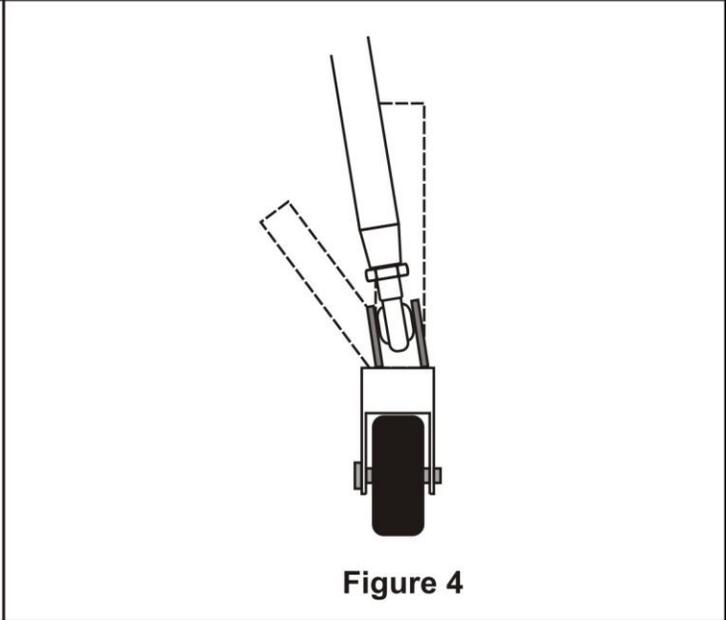


Figure 4