



DON'T FORGET

These instructions can be found in color and expandable at QA1.net

Technical Support Line: (952) 985-5675 Email: sales@QA1.net

INSTALLATION INSTRUCTIONS

QA1 P/N 52031, 52032 '82-'92 F-Body Torque Arm Kit

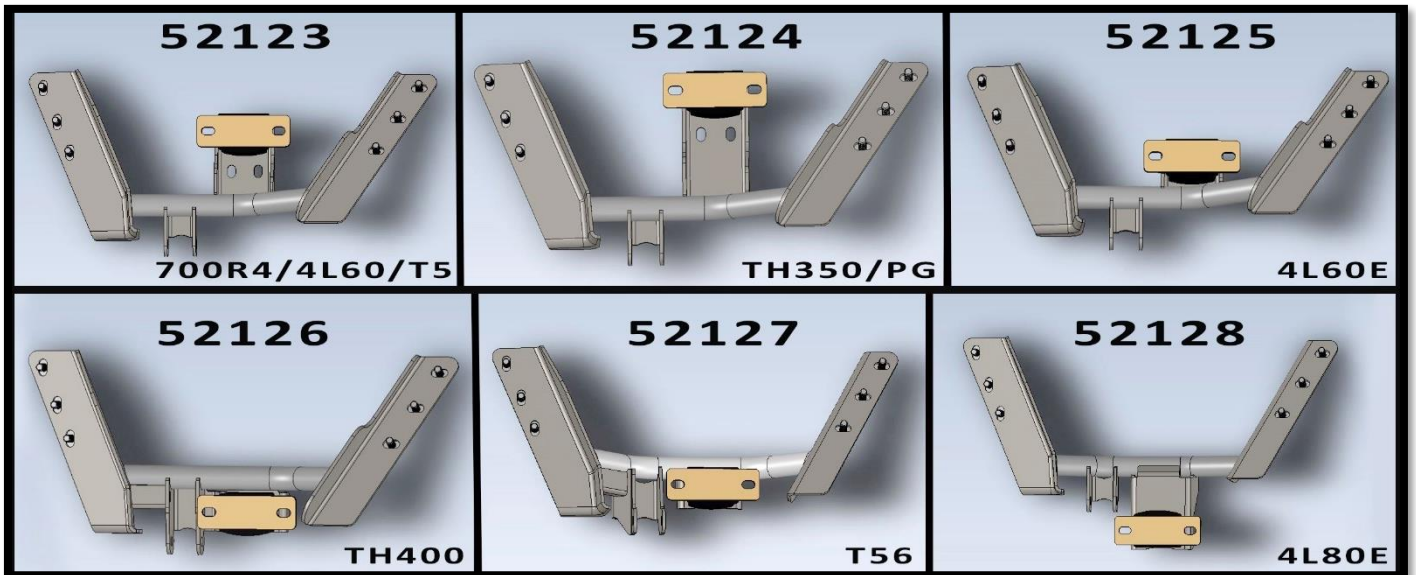
QA1 P/N 52123, 52128 '82-'92 F-Body Transmission Crossmember Kit

TOOLS AND SUPPLIES REQUIRED

- Floor Jack
- Jack Stands
- SAE Sockets and Wrench Set
- Torque Wrench
- M10-1.5 tap
- 3/8" Allen Wrench

PRE-INSTALLATION NOTE:

This QA1 Torque Arm and Transmission Crossmember were designed to work together and will not work with the same factory components.



REMOVAL-

1. Jack the vehicle up and place the frame securely on jack stands.
2. Support the rear axle pinion before unbolting the torque arm from the axle and transmission.
3. Use a floor jack to support the weight of the transmission and remove the transmission cross member. **(Figure 1)**
4. Remove the two bolts holding the soft mount to the transmission. These two bolts will need to be reused to mount the new urethane mount.

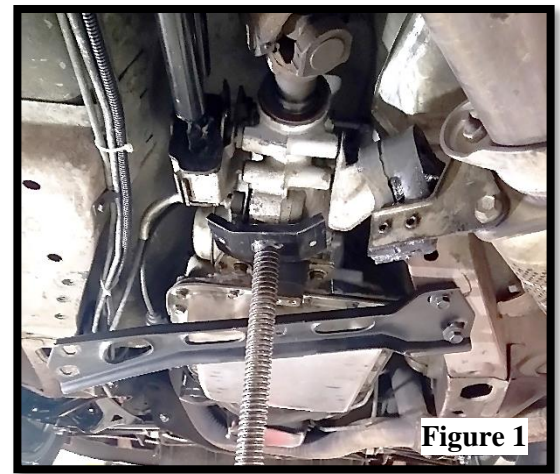


Figure 1

TRANSMISSION CROSSMEMBER INSTALLATION-

1. Thread an M10 x 1.5 tap through the front two holes of the factory transmission crossmember mounts. **(Figure 2)** These holes are threaded from, but not used by the factory so they may be slightly corroded.
2. Install the provided urethane mount to the transmission tail housing using the included Energy Suspension instructions and reusing the factory bolts. **(Figure 3)**
3. Install the transmission crossmember to the frame rails using the included M10 x 25mm bolts with one washer per connection. The bolt holes are slotted to aid in lining up the crossmember with the urethane mount.
4. Bolt the crossmember to the urethane mount using the included Energy Suspension mount hardware.
5. Torque the six crossmember mounting bolts to 38 lb. ft. and the two crossmember to Energy Suspension mount to 49 lb. ft. **(Figure 4)**

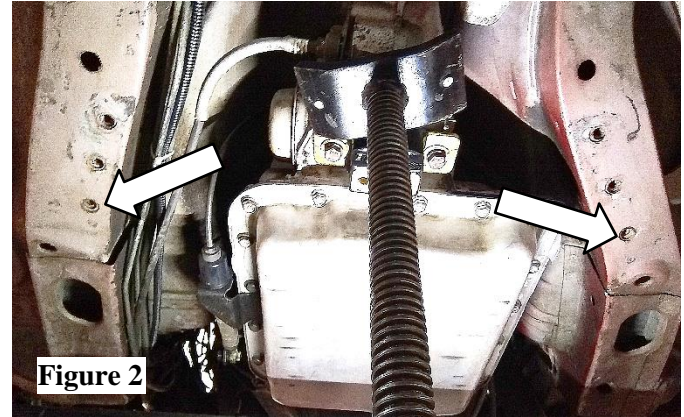


Figure 2

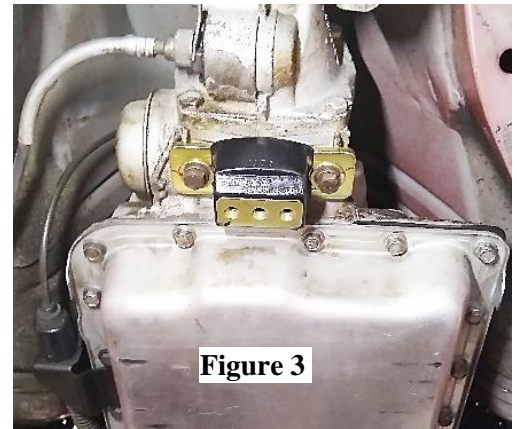


Figure 3

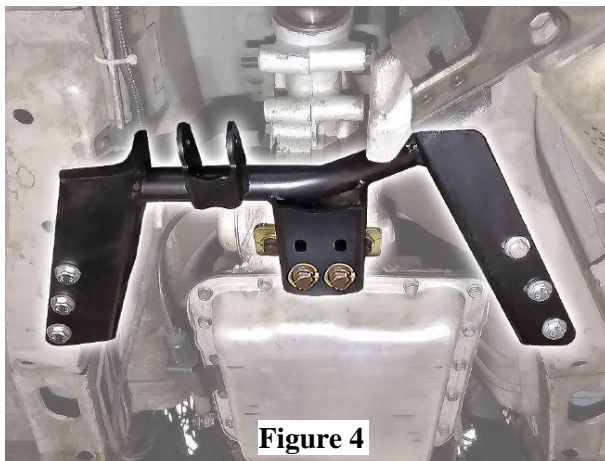


Figure 4

Transmission Crossmember Hardware

QTY/KIT	DESCRIPTION	2ND DESCRIPTION	WHERE USED ON VEHICLE
6	BOLT, HEX, M10-1.5 X 25MM	CLASS 8.8, CLEAR ZINC	CROSSMEMBER TO FRAME
6	WASHER, OVERSIZED, M10, STEEL	10.5MM ID X 25MM OD X 4MM, CLEAR ZINC	

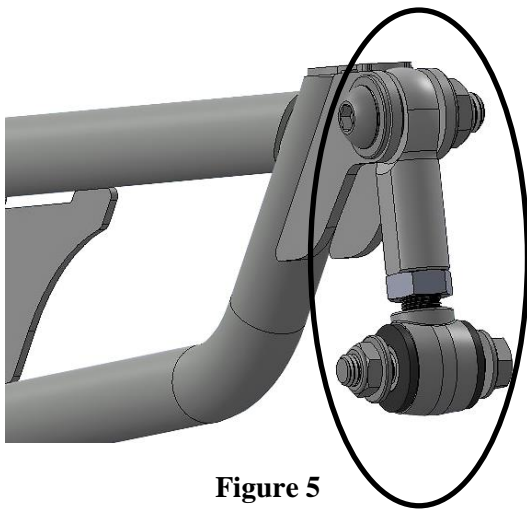
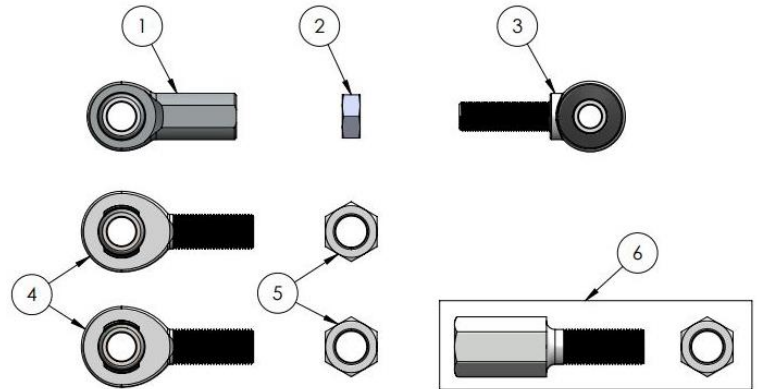


Figure 5

TORQUE ARM INSTALLATION-

1. Thread the 5/8" jam nut (#2) onto the rod end bushing (#3) before threading the rod end bushing into the female rod end (#1). Leave a 3/16" gap between the jam nut and the rod end bushing. (Figure 5)
2. Install the rod end of the assembly into the front torque arm mount with two 5/8" washers. Secure using one button head bolt with nyloc nut. Torque to 135 lb. ft.
3. Install the bushing mount into the transmission crossmember mount using 1/2" x 2.5" bolt with two washers and one nyloc nut. Torque 30 lb. ft.
4. Do not tighten the jam nut on the front assembly until the rear connections are installed.

BALLOON #	ITEM #	DESCRIPTION	QTY.
1	XFR10	ROD END (X) ENDURA ALLOY HT	1
2	JNR10S	JAM NUT, STEEL 5/8-18 RH	1
3	9032-345	ROD END W/BUSHING, .5" ID	1
4	XMR10-12	ROD END (X) ENDURA ALLOY HT	2
5	JNR12S	JAM NUT, STEEL 3/4-16 RH	2
6	AS12-12	LINKAGE ADJUSTER STEEL 3/4-16	1
7	7039-385	HARDWARE KIT, TORQUE ARM	1



5. Thread one 3/4" jam nut (#5) onto one 3/4" male rod end (#4) leaving 1/8" of threads between the jam nut and rod end before threading the rod end into the upper torque arm connection. (Figure 6)
6. Thread one 3/4" left-hand threaded jam nut onto the LH threaded male threads of the linkage adjuster (#6) before threading the adjuster into the left-hand threaded lower rear connection of the torque arm. (Figure 6)
7. Thread one 3/4" (right-hand threaded) jam nut (#5) onto the 3/4" male rod end (#4) before threading the rod end into the linkage adjuster (#6) in the lower connection. The majority of threads of the linkage adjuster and rod end should be evenly and fully engaged with a starting point (end of torque arm to center of rod end) of 4-15/16". (Figure 7) Extension adjustments can be made during installation to the rear axle.

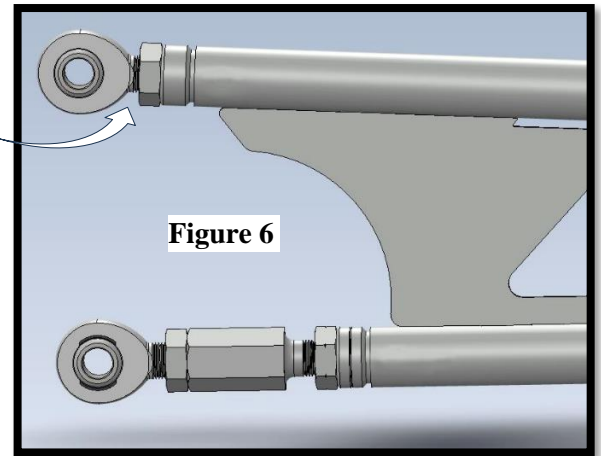


Figure 6

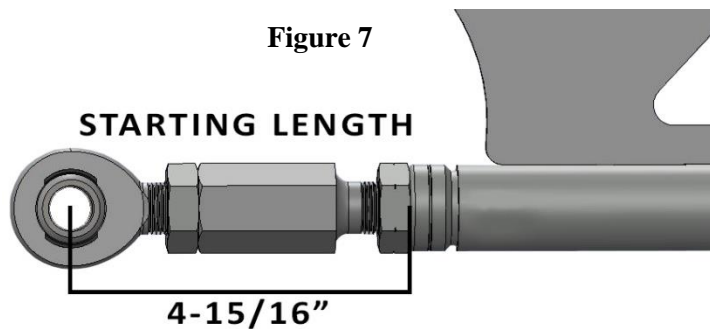


Figure 7

8. Install the rear axle mount to the rod ends using one 5/8" button head bolt with two washers and one nyloc nut per connection. **(Figure 8)** Torque to 135 lb. ft.
9. Install the rear torque arm connection to the axle using M14 x 200mm long bolts with two washers and one nyloc nut per connection. **(Figure 9)** The rod end and adjuster linkage can be adjusted to aid in installing the rear connection and setting pinion angle. Torque to 145 lb. ft.
10. With the vehicle at ride height, adjust the pinion angle using the linkage adjuster before tightening the front and rear jam nuts. For in-depth instant center and tuning information, suspension calculator programs are available such as Performance Trends.

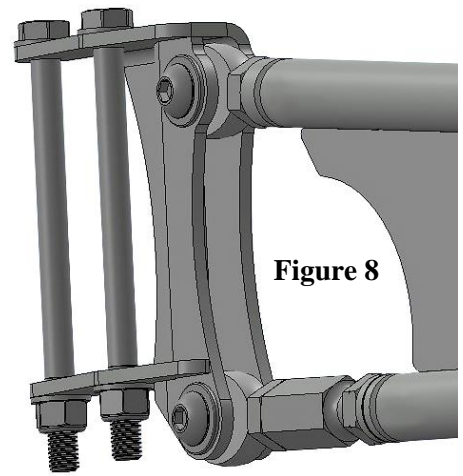


Figure 8

www.performancetrends.com/4link.htm

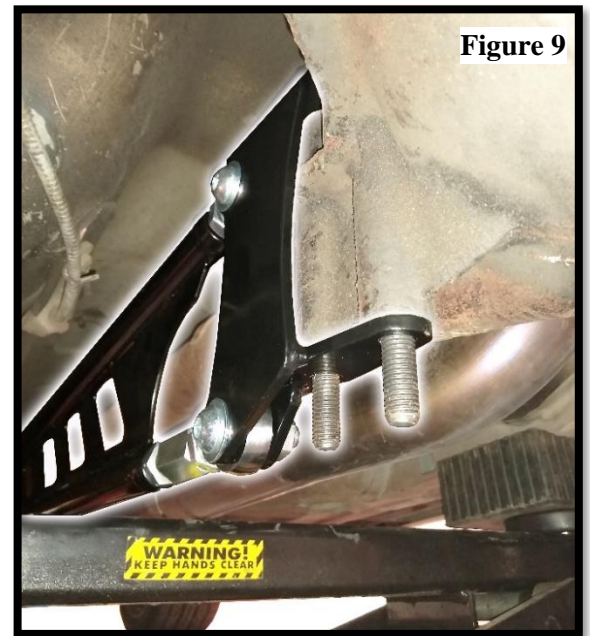
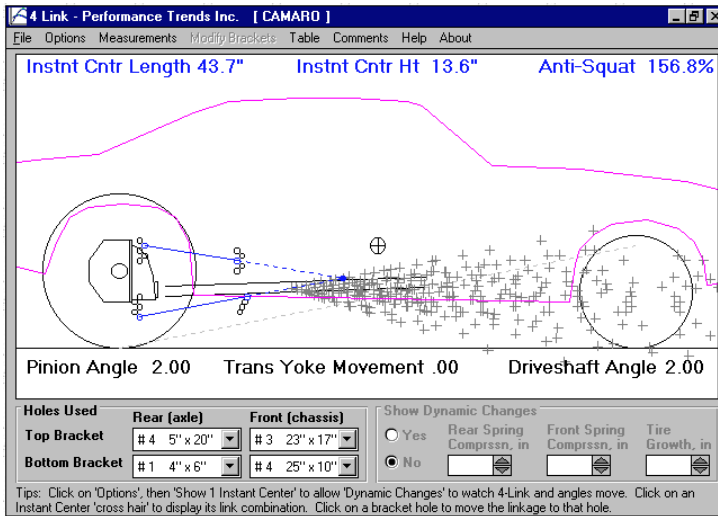


Figure 9



HARDWARE LIST

QTY/KIT	DESCRIPTION	2ND DESCRIPTION	WHERE USED ON VEHICLE
1	BOLT, HEX, 1/2-13 X 2.500"	GRADE 5, CLEAR ZINC, PARTIAL THREAD	TORQUE ARM TO TRANS CROSSMEMBER
1	NUT, NYLOCK JAM, 1/2-13	GRADE 8, YELLOW ZINC	
2	WASHER, FLAT, 1/2" SAE	.531" ID X 1.062" OD X .098", GRADE 8, CLEAR ZINC	
3	BOLT, BHSCS, 5/8-11 X 2.0"	GRADE 5, CLEAR ZINC	TORQUE ARM
3	NUT, NYLOCK JAM, 5/8-11	GRADE 8, YELLOW ZINC	
6	WASHER, FLAT, 5/8" SAE	.656" ID X 1.312" OD X .098", GRADE 8, CLEAR ZINC	
2	BOLT, HEX, M14-2.0 X 200MM	CLASS 10.9, CLEAR ZINC, PARTIAL THREAD	TORQUE ARM TO DIFFERENTIAL
2	NUT, NYLOCK, M14-2.0	CLASS 10, CLEAR ZINC, DIN 985	
4	WASHER, FLAT, M14	15MM ID X 28MM OD X 2.5MM, CLASS 10.9, CLEAR ZINC, DIN 125	



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READ ALL INSTRUCTIONS CAREFULLY AND THOROUGHLY PRIOR TO STARTING INSTALLATION. PRODUCTS THAT HAVE BEEN INSTALLED ARE NOT ELIGIBLE FOR RETURN. USE THE PROPER JACKING LOCATIONS. DEATH OR SERIOUS INJURY CAN RESULT IF INSTRUCTIONS ARE NOT CORRECTLY FOLLOWED. A GOOD CHASSIS MANUAL, AVAILABLE AT YOUR LOCAL PARTS STORE, MAY ALSO AID IN YOUR INSTALLATION.

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DEDICATED TECH SUPPORT

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CHECK US OUT ON YOUTUBE!



- Frequently Asked Questions
- Quick Tips
- Install Information
- Tuning and Repair Guides
- Other Technical Information



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