

Tools you'll need to install the Shackle flip

Socket Set
Torque Wrench
½" drill bit
Grinder/drill/plasma cutter or cutting torch to remove frame rivets
Big Hammer and punch
Jack and Jack stands

Getting Started

1. Place truck on level surface. Raise rear of truck and place jack stands under the frame so the rear axle can hang freely. Remove rear tires
2. Remove lower shock nuts and remove shocks from lower mounting position. You can leave them attached up at top. This is for clearance, you will be dripping the axle pretty far so it can help to make it all fit.
3. Drain and remove rear gas tank if so equipped.
4. Loosen the rear most spring eye bolts and shackle bolts and adjust the rear axle height so the bolts can be removed. You need to have a neutral tension on these bolts or the springs can "Pop" when the bolts are taken out.
5. Remove the 4 rivets however you choose to remove them. You can grind the heads off and punch them out with a hammer and punch, drill the heads with a ½" drill bit and once you are flush with the shackle buckets punch them out with a hammer and punch or cut them out with a plasma or cutting torch if you feel you have the skill to do so safely. If flame is used make sure there is no gas around to ignite.
6. With the stock shackle buckets removed drill the 4 holes to a full ½". Then clean the frame and paint if necessary.
7. Drop the rear axle far enough so that the rear of the springs is below the frame a few inches.
8. The shackle flip brackets have 5 holes in them. The 5th hole is optional but recommended. To line up the hole bolt the new bracket in place and use it as a template to drill the 5th hole. Make sure no lines or wires are behind any of the holes you will be drilling.
9. You can now bolt the shackle flip brackets to the frame. Use the ½" grade 8 hardware supplied. Use the smaller washers in front of the brackets and the larger washers on the inside of the frame. Torque to 65 ft-lbs
10. You will have to reverse the shackle on the leaf spring. Just turn it 180 degrees so the open side faces forward. Slide the bolt back into the shackle/spring eye but leave it loose for now. Place the other end of the shackle in the flip bracket and install the new 5/8" bolt with a washer under the head. Do not slide the bolt all the way in, just a little past where it starts sticking out of the inner tab. Now install another washer and the nut, cone towards the center of the truck. Not tighten this down until slightly snug.
11. Reinstall the shocks
12. Place the tires back on the axle and remove the jack stands. With the truck on all fours you can not tighten the spring a shackle bolts. About 15 ft-lbs is all that is required on the springs and slightly more for the upper shackle bolts.

Reinstall the gas tank if removed earlier.

That's it! You're done! You now need to check pinion angle. The pinion WILL BE pointed up further than before but if it's a problem is judged on a case-by-case basis. You want there to be a couple of degrees of down angle from the driveshaft at the pinion. If you have a 115" WB or greater chances are you will be OK. If you have a 106" WB Ramcharger/Trailduster you will need to shim the spring pads to get the proper pinion angle. If you feel any vibration check the pinion angle again.