



INSTALLATION INSTRUCTIONS

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6602 1994- CHEVROLET S10-S15 / GMC SONOMA C-SECTION INSTALLATION

CONGRATULATIONS!

You were selective enough to choose a **BELLTECH PRODUCT**. We have spent many hours developing our line of products so that you will receive maximum performance with minimum difficulty during installation

Note: Confirm that all of the hardware listed in the parts list is in the kit. **DO NOT** begin this installation if any part is missing. Read the instructions thoroughly before beginning this installation.

Warning: **DO NOT** work under a vehicle supported by only a jack. Place support stands securely under the vehicle in the manufacturer's specified locations unless otherwise instructed.

Warning: **DO NOT** drive the vehicle until all work has been completed and checked. Torque all hardware to values specified.

Reminder: Proper use of safety equipment and eye/face/hand protection is absolutely necessary when using these tools to perform procedures!

Note: It is very helpful to have an assistant available during the installation process.

Note: We **DO NOT RECOMMEND** using wheel ramps while performing this installation.

Note: The following installation pictures shown, were done at a professional installation facility.

RECOMMENDED TOOLS:

- Properly rated floor jacks and support stands
- Ratcheting Socket Wrench
- SAWZALL Cutting tool
- Safety Glasses
- Torque Wrench 10-75 lb ft. range
- Combination Wrench
- Abrasive Cutting Wheel

1 KIT INSTALLATION

- 1a. Open the hardware kit and remove all of the contents. Refer to the parts list (Page 4) to verify that all parts are present.
- 1b. Park the vehicle on a smooth, level concrete or seasoned asphalt surface and activate the parking brake.
- 1c. Using a properly rated floor jack, lift the REAR wheels of the vehicle off the ground. Place support stands, rated for the vehicle's weight and in the factory specified locations. Refer to the vehicle Owner's Manual. Prior to lowering the vehicle onto the stands, make sure the supports will securely contact the chassis.
- 1d. It is very important that the vehicle is properly supported during this installation to prevent personal injury and chassis damage. Make sure that the support stands are properly placed prior to performing the following procedures. We **DO NOT RECOMMEND** using wheel ramps while performing this installation.

NOTE: THE INSTALLATION PHOTOS FOR THIS KIT WERE TAKEN ON A BARE CHASSIS.

2. VEHICLE BED REMOVAL

- 2a. For the ease of installation of this kit, the vehicle bed will need to be removed from the chassis.
- 2b. Block the front wheels with the wheel chocks.
- 2c. Using a floor jack, raise the back end of the vehicle upward, so the rear wheels come off the ground. Remove the rear wheels only.
- 2d. Un-bolt the gas filler neck from the vehicle bed and any electrical lines (license plate lamp, tail-light lamp connectors that are connected to the vehicle bed). Tie-strap them aside out of the way.
- 2e. Remove the mounting bolts that mount the bed to the chassis.
- 2f. Lift the bed off the chassis and put aside.
- 2g. Place at each rear corner of the frame chassis, jack stands to support the chassis throughout the modification process. This will prevent any damage that may occur during the modification process.
- 2h. Prior to beginning modification on the drivers side, **it is important to note**, that for safety reasons, that the gas tank be completely wrapped with fire retardant blankets, to avoid coming into contact with any heat caused by cutting out the bracket.

3. LOCATING THE BRACKETS AND MARKING FOR MODIFICATION

- 3a. There are actually two areas that will need to be cut away in order for the new C-Section bracket to slide down over. We will start on the passenger side first. (photo 1) Remove plastic spacer (photo 2)

3 CONTINUED:

- 3b. Use the hole that the plastic spacer was in to locate the c-section, (photo 3,4,5,6)
- 3c. For the outside wall, as shown in (photo 7). Follow the radius of the c-section and mark lower on the frame side of the bump stop mount. Mark below the frame (photo 8)(photo 9) shows the in side wall cut line.
- 3d. Using a sawzall®, begin cutting the marked areas, cutting along the lines. (photo 10)
- 3e. Using a cutting wheel, cut-line, (photo 11), separating the bracket from the chassis.
- 3f. Once you have completed the cut, grind any excess off, making it smooth. This will allow the new C-section to fit flush to the frame walls.

4. ALIGNING THE NEW C-SECTION BRACKET TO THE FRAME/CHASSIS AND MOUNTING HOLE TRANSFER

- 4a. Place the new c-section bracket where it is suppose to be located (photo 12). Using a c-clamp to keep it in place, the mounting holes need to be transferred from the new c-section bracket to the chassis/frame.
- 4b. Using a hole punch, transfer all, eight (8), mounting holes from the new c-section to the chassis/frame.

5. DRILLING THE NEW MOUNTING HOLES FOR THE C-SECTION BRACKET

NOTE: THIS CAN BE DONE TWO WAYS: ONE, YOU CAN LEAVE THE NEW C-SECTION BRACKET IN PLACE USING IT AS A GUIDE, OR REMOVING THE NEW C-SECTION BRACKET AND UTILIZE THE PUNCHED MARKS AS A GUIDE.

- 5a. Using a 1/8" drill bit, create, eight (8), pilot holes on center of earlier created punch marks. (photo 13)
- 5b. Using a 17/32" drill bit, drill through all, eight (8), pilot holes. Debur all holes, this will allow washers and the c-section bracket to sit flush to the frame/chassis. (photo 14,15)

6. INSTALLING THE NEW C-SECTION BRACKET

- 6a. Prior to mounting the inside section of the new c-section. The kit supplied bump stop needs to be mounted. (photo 16)
- 6b. Once mounted, install the C-section to the inner C-section, mounting it with the kit supplied hardware. (photo 17,18,19,20)

7. FINALIZING THE INSTALLATION

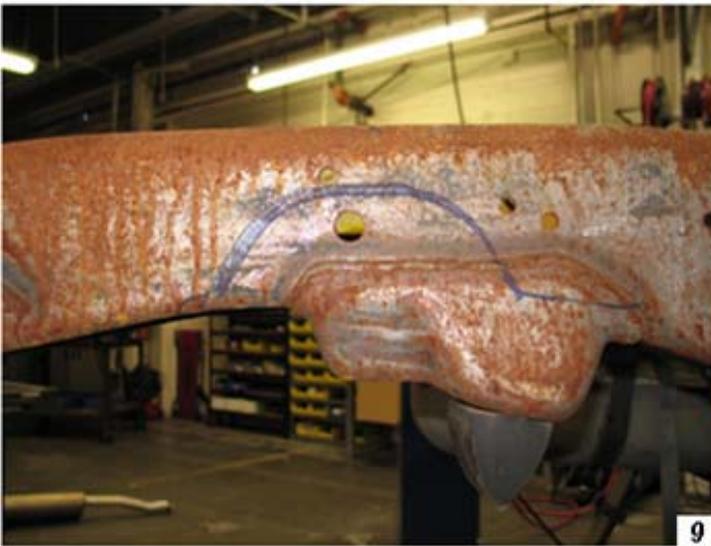
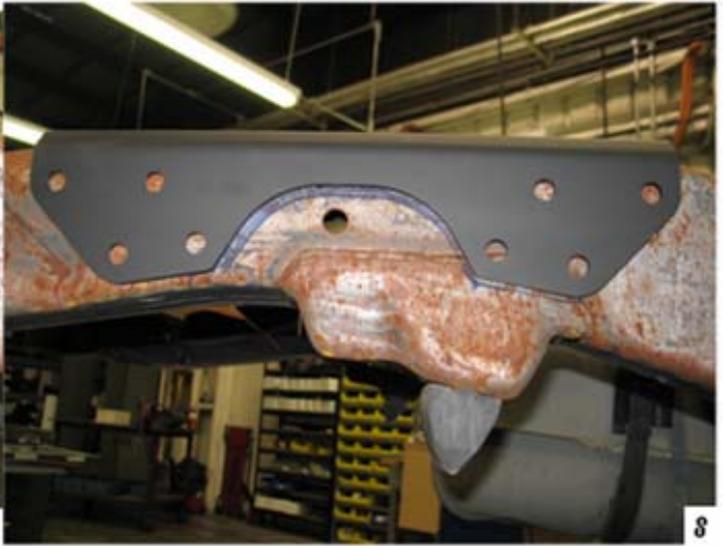
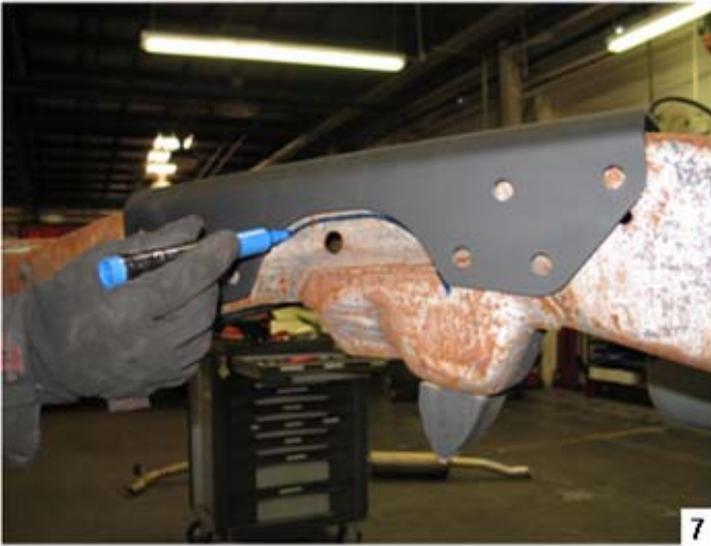
- 7a. All hardware being fastened to the vehicle's original fastening points should be torqued to the proper specifications. To prevent chassis damage, never over torque the hardware.
- 7b. Check that all components and fasteners have been properly installed, tightened and torqued to 75lb.
- 7c. Check brake hoses and other components for any possible interference.

7. CONTINUED:

- 7d.** Install the vehicle's bed. Torque hardware to manufacturers specifications.
- 7e.** Lift the vehicle and remove the support stands. Carefully lower the vehicle to the ground.
- 7f.** Immediately test-drive the vehicle in a remote location so that you can become accustomed to the revised driving characteristics and handling. Be aware that the vehicle will handle substantially different now that it has been modified.
- 7g.** Installation is complete. Check all of the hardware and re-torque at intervals for the first 10, 100, 1000 miles.

<u>PART NO</u>	<u>DESCRIPTION</u>	<u>QTY</u>
6602-020	INNER FRAME SUPPORT	2
6602-001	OUTER FRAME SUPPORT	2
4920-001	BUMP STOP	2
110660	1/2" FLAT WASHER	28
110402	1/2" - 20 LOCK NUT	14
110408	1/2" - 20 X 1 1/4" SCREW ZP	14









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