



INSTALLATION INSTRUCTIONS

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6623 C-SECTION CHEVY SUBURBAN / GMC YUKON

Thank you for being selective enough to choose our high quality 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 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 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 installation.

RECOMMENDED TOOLS:

- Properly rated floor jack, support stands, and wheel chocks
- Combination wrench set
- Torque wrench: *0-75 lb ft. range*
- Ratcheting socket wrench and socket sets
- Safety Glasses

KIT INSTALLATION

1. Open the hardware kit and remove all of the contents. Refer to the part list (Page 2) to verify that all parts are present.
2. Block the front wheels and raise the rear of the truck using a hydraulic floor jack under the center of the rear axle. Place the frame on jack stands ahead of the front spring hangers, and just behind the rear shackle hangers. Remove the wheels from the truck. **IMPORTANT:** the jack stands **must be** used as shown. **This is mandatory when installing c-sections in the frame.** It must be supported on both sides of the spring hangers to avoid frame damage while installing the c-sections. (Photo 1 & 2)
3. If so equipped, remove the mounting hardware on the brackets holding the sway bar mounts to the frame. These will be reattached later. (Photo 14)
4. Lower the jack and rear end assembly to provide room to work before installing the C-sections. There are nylon clamps holding the steel brake line, fuel lines and electrical wires to the frame. Remove these to free the lines and wires. **CAUTION: Do not let the rear axle drop to the point where the brake lines and/or drive shaft are strained.** You may want to use jack stands to support the rear end housing at this point. (Photo 15)
5. Remove the bolts holding the rubber snubber to the chassis. (Photo 16)

6. You are now ready to install the C-section frame rails. The frame rails should be cleared of all brake lines and electrical wiring. They should be loosened from their attaching hardware and moved away to avoid damage.
7. Using the template supplied, align the guide holes in the template with the corresponding holes in the chassis. (Photo 17)
8. Mark the frame with a punch at the designated locations on the template. Move the template and drill a 1/2" hole in the frame at the four points. (Photo 18)
9. Using a marker or scribe, draw a line between each hole on the frame. Mark the line to the center of the hole. Do this so that there is a round corner at each point. This will prevent the possibility of stress cracks at the end of each cut line. (Photo 19)
10. There are several methods in which the notch can be cut. The method shown is a plasma cutter. A sawz-all, or a die grinder with a cut-off saw blade will work also. **DO NOT** use a cutting torch.
CAUTION: Always wear eye protection when using power tools. (Photo 20)
11. The edges of the notch should now be debarred and the sharp edges ground away. On each side of the chassis just above the notch, you will find a flange protruding from a hole in the frame, just cut.

Grind this area flat. **CAUTION: Always wear eye protection when using power tools.** (Photo 21 & 22)
12. There is a rivet on the bottom of the chassis just behind the C-notch. Remove this rivet. It will be replaced by one of the C-section bolts.
13. Each insert is fastened to the frame by fourteen mounting bolts. Ten on the side, and four underneath the frame. Again using the template supplied, mark the side mounting holes to be drilled using a center punch at the marked locations. (Photo 23)
14. Drill a 1/4" pilot hole then use a 7/16" bit to drill the side mounting holes. The use of c-clamps on the rails will help in the drilling and fitting operation. Install the side mounting hardware. Now the bottom rear two mounting bolts can be attached. Two must be drilled and two go in the holes left by the removal of the rivets in step #22 (Photo 24 & 25)
15. Once the C-sections are in place, the brake lines and electrical wires should be wire tied and tucked into the frame rails securely. Install the urethane bump stops in the holes located in the middle of the C-sections.

PART LIST

PART No.	DESCRIPTION	QTY.
6620-010	C-Section L.H.	1
6620-011	C-Section R.H.	1
6620-887	Template	1
4923-001	Bump Stop	2
112282	Nylon Lock Nut M8x1.25	2
68320069	Hex Socket Screw M8x1.25	2
110650	7/16"-20 x 1-1/4" HHCS	28
110303	7/16"-20 Stover Nut	28
110645	Flat Washer 7/16"	56



