



Rev. # 10-02

PART #FK2599-6,FK2599-6X,FK2599-7&FK2599-7X

1999-2005 CHEVY 1500 REAR FLIP KIT

INSTALLATION INSTRUCTIONS

Please take the time to read these INSTALLATION INSTRUCTIONS and check the Hardware Parts List to be sure you have all the listed parts.

These installation instructions are prepared for the professional installer with the proper equipment, tools and experience in suspension systems and safety. This vehicle and its components are extremely heavy and can be dangerous without the proper equipment and experience.

Please read the warranty information (blue page enclosed). Complete your Product Warranty Card and mail it to DJM Suspension.

Please take a few minutes to fill out your installation helper (back side of warranty). Accurate measurements BEFORE BEGINNING INSTALLATION will show any irregularities in your vehicle.

NEVER WORK UNDER TRUCK SUPPORTED BY A JACK ONLY !!!
USE QUALITY JACK STANDS WHICH HAVE A RATING ADEQUATE FOR YOUR TRUCKS WEIGHT!!!

New shocks are required.
 Use DJM #1800 Driver side & 1900 Passenger side.

Hardware Parts List:

Axle Flip Kit

- 2- Universal Axle Locators (1010A)
- 2- Upper Axle Plates (1010P)
- 4- 5/8" U-Bolts (1025)
- 8- 5/8"x18 Nylock Nuts
- 8- 5/8" Flat Washers
- 2- Leaf Spring Plates (1025)
- 2- Urethane Bump Stops (10S)
- 2- 5/8" x 11 x 3-1/2" Tap Bolts
- 2- 5/8" x 11 x 4" Tap Bolts
- 8- 5/8" Flat Washers
- 4- 5/8 X11 Nylock Nuts

- 2- Rear 1012 Shackles (FK2599-7 only)

- 1-CB99 Carrier Bearing Bracket Kit. (included with FK2599-6X & FK2599-7X)

Frame Support Kit

- 1- Frame Support (Left)
- 1- Frame Support (Right)
- 16- 1/2" x 13 x 1.75" Bolts
- 16- 1/2" Flat Washers
- 16- 1/2" x 13 Nuts

Shock Extender Kit

- 1- Shock Extender (2599).
- 2- 1/2" x 20 x 1" Bolts.
- 2- 1/2 x 20 Nuts.
- 2- 1/2" x 13 x 2-3/4" Bolts.
- 1- 1/2 x 13 Nuts.
- 1- 3/8" x 16 x 1" Bolts.
- 1- 3/8" x 16 Nuts.

Install new U-bolts and spring plates (5 hole) on the bottom of the springs. Cross-torque u-bolts. Over tightening may bend spring plates. Place the new upper axle plates, with the pin down, on top of the axle. Install and tighten the 5/8" bolts provided with one flat washers on top of the upper plate and one on the bottom of the axle locator.



For FK2599-7 & FK2599-7X, replace factory shackles with DJM shackles.

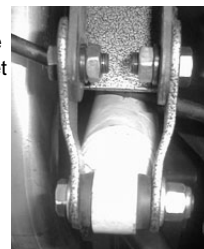


Installing Frame Supports

Frame supports are installed after axle is relocated. Raise the axle, and mark the center on the frame. Use this mark to center the frame support. Make a template or use one of the brackets and mark the frame. Use a sawzall, cutting wheel or plasma cutter to notch frame. **Do not use a torch!!** Move any wires or brake lines out of the way before cutting. Drill and bolt frame support to frame. Install bump stop on the frame support.



Before installing rear shocks, install the shock extender to the right side axle mount. This will make the shock work at a much better angle. Slide bracket over the factory mount and install the two 1/2" x 1" bolts from the outside and tighten. Line drill a 3/8" hole through the factory mount using the shock extender as a guide and install on 3/8" x 1" bolt and tighten. Now install the DJM # TS1800C driver side rear shock and the DJM #TS1900C on the passenger side.

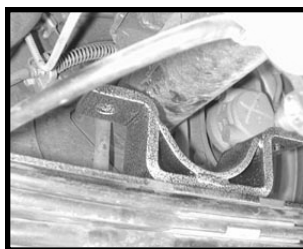


Install rear wheels and torque lug nuts. Remove jack stand and floor jack. Test drive and adjust pinion angle as necessary. Measure and record the height of the rear on the installation helper.

If drive line vibration occurs, with 2 piece drive shafts, install the Carrier bearing bracket #CB99 (included with FK25996-X and FK2599-7X) to correct drive line angle.

RELOCATING (FLIPPING) REAR AXLE

Reinstall the leaf spring under the axle. Place the new axle locator bracket on top of the spring, with the off center hole toward front of vehicle. This will center the rear axle and pull the drive shaft back from the transmission slightly. Lower the rear axle into the new axle supports. Rotate axle to desired pinion angle.



Remove factory bracket from cross member.



Position new bracket and drill two holes to attach bracket.

Check out all the DJM products on the web www.DJMSuspension.com

Tech Line (310) 538-1583