

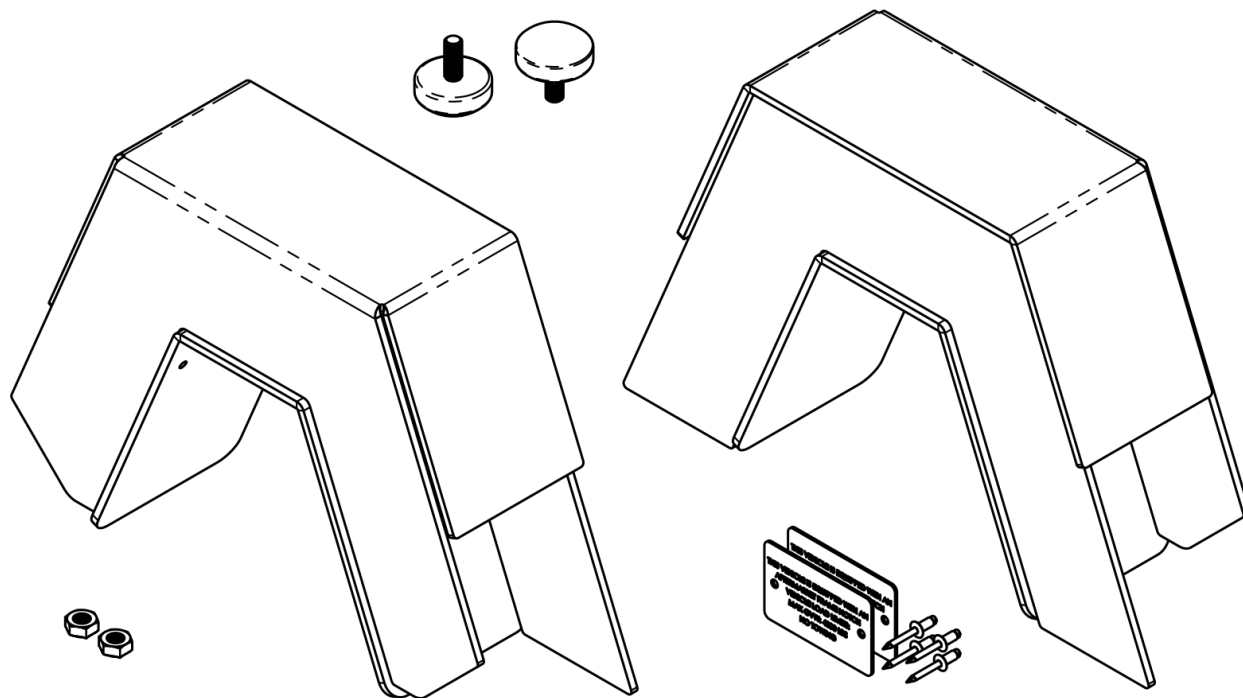
INSTRUCTIONS

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910-27387 - LevelSet™ 1973-87 C10 Frame Weld-In Step-Notch Kit

Kit Contents		
Qty	Part #	Description
2	91027387.1	Step Notch Base
2	91027387.2	Step Notch U-Channel
2	91027387.3	Step Notch Inner Plate
2	91027387.4	3/8-16" Weld Nut
1	91099121	Bump Stop Kit
1	91027386.T	GVW Tag Kit



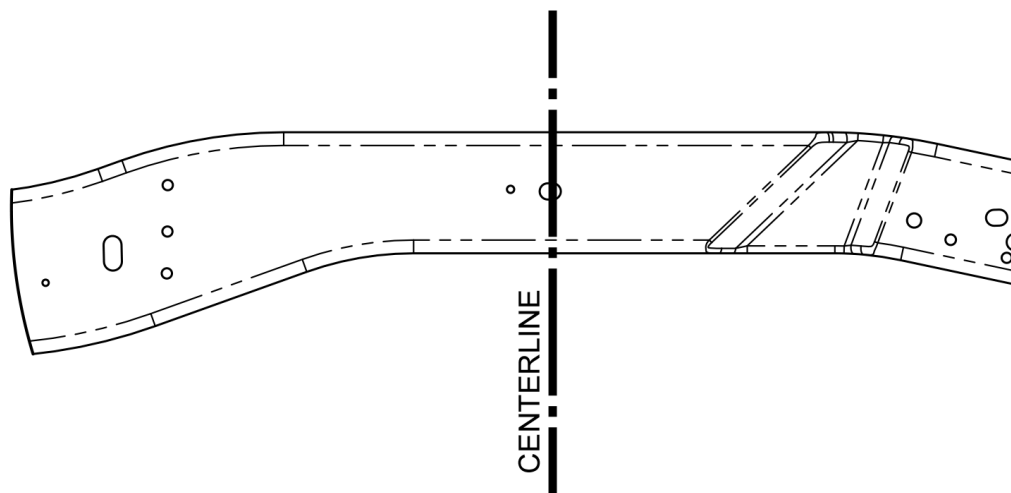
This kit is designed to provide increased suspension clearance and travel. This installation will involve fabrication and welding to notch and clearance the existing frame. As such, this should only be attempted by an experienced fabricator familiar with this type of work. All welds should be completed according to AWS standards. It is recommended that you notch one side at a time to keep the frame as rigid as possible during installation.

INSTRUCTIONS

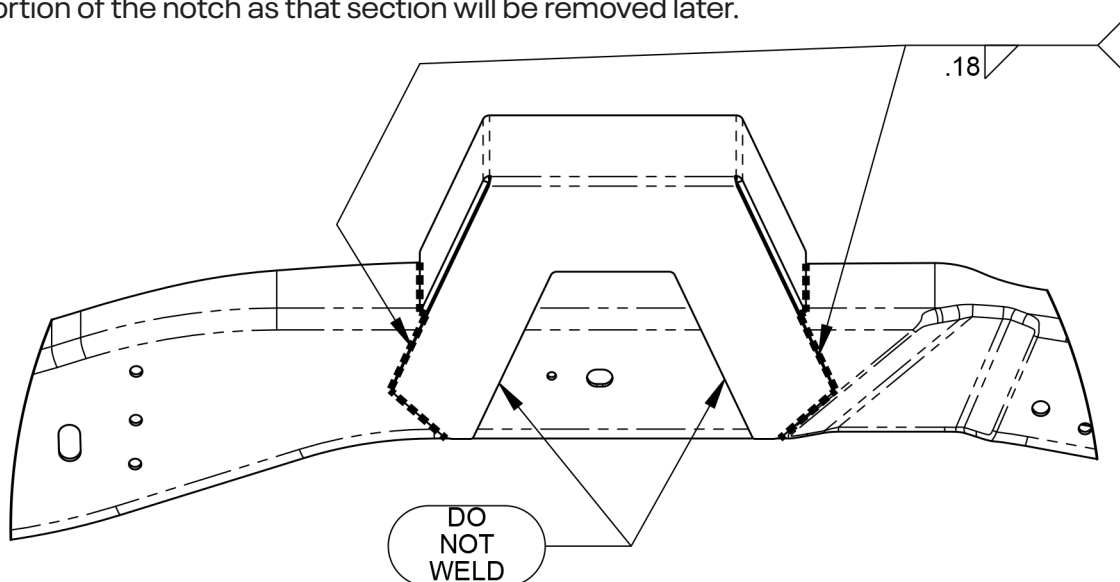
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1. Remove the bed and all electrical wires, brake lines, fuel lines, etc. from the inner frame rail, ensuring that your frame rail is clear of obstructions and hazards before moving on. If equipped, also remove the factory bump stops from the bottom of your frame. The frame rail must be completely relieved of all stress and tension before moving on.
2. Clean and prep your frame rail surface around the area you wish to notch. You will be marking this surface later so doing weld preparations now ensures that you do not remove your necessary markings by accident later. You will need to prepare a surface approximately 18" wide around the center of your notch.
3. With your surface prepped, mark the centerline of your axle on the frame where you would like to locate the notch. On a square body C10 truck, this will be approximately 21-5/8" from the center of the rearmost top rivet on the front leaf spring mount.



4. Using your centerline, center your notch on top of the frame rail as shown. Make sure that the notch sits flush along the side and top of the rail as these portions will be getting seam-welded. Fabricate and trim as necessary to get a good fitment. Once you are happy with the fit and positioning, clamp the notch in place and make multiple tack welds around the top mating edge and outer perimeter of the notch. Once all edges are securely tacked to the frame, go back and fully weld the top and outside perimeter edges to the frame. Be sure not to weld on the inside portion of the notch as that section will be removed later.

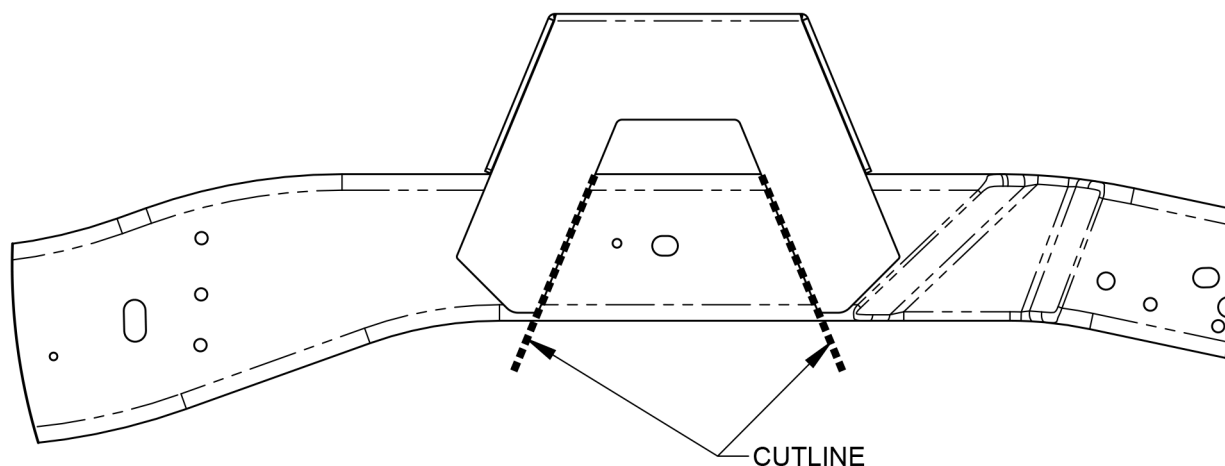


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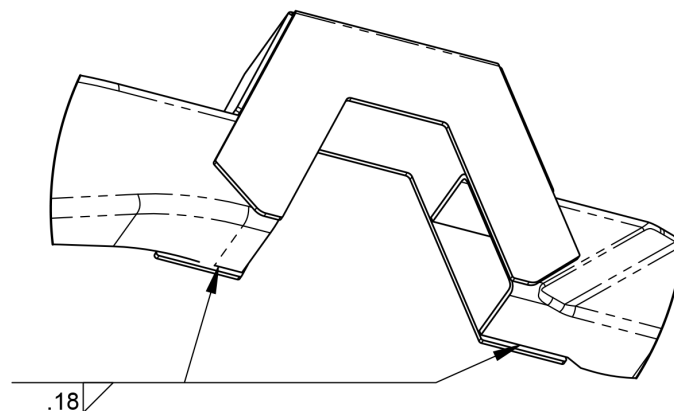
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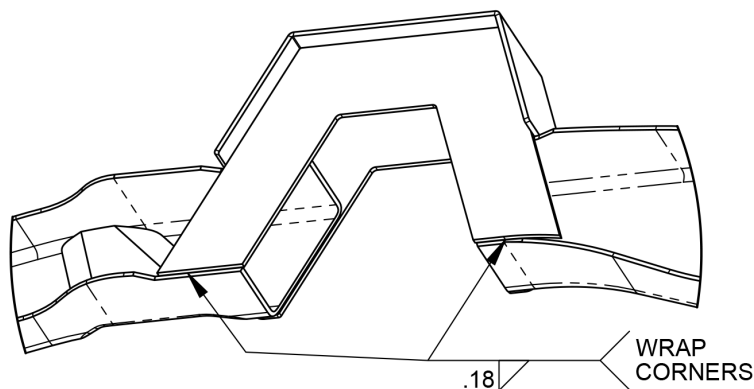
5. Using your notch as a template, use your cutting tool of choice to cut out the middle section of your frame inside your notch. It is very important during this step that the frame be supported on both sides of the notch so that it does not flex and deform during fabrication. On the upper and lower surfaces, be sure to cut straight as you want to remove the excess material but not take so much away that your notch cannot be welded along the bottom edge. Approach the top and bottom cuts conservatively and use a grinder to remove any remaining excess material if necessary, during final fitment.



6. Fit up your backing plate in your frame rail. Trim and grind as necessary for everything to fit together tightly. The backing plate should be trimmed so that it falls just short of the lower face of the frame rail providing an external corner to be fillet welded to the rail or trimmed to go just beyond the frame rail providing an internal corner to be fillet welded. After achieving proper fitment, tack weld the backing plate in place ensuring that it is pulled tight to the top of the notch and fit snug around the sides creating a tight weld gap for later.



INTERNAL CORNER
FILLET WELD



EXTERNAL CORNER
FILLET WELD

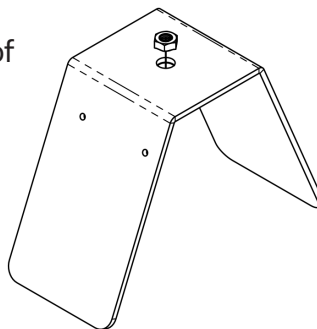
WRAP
CORNERS

INSTRUCTIONS

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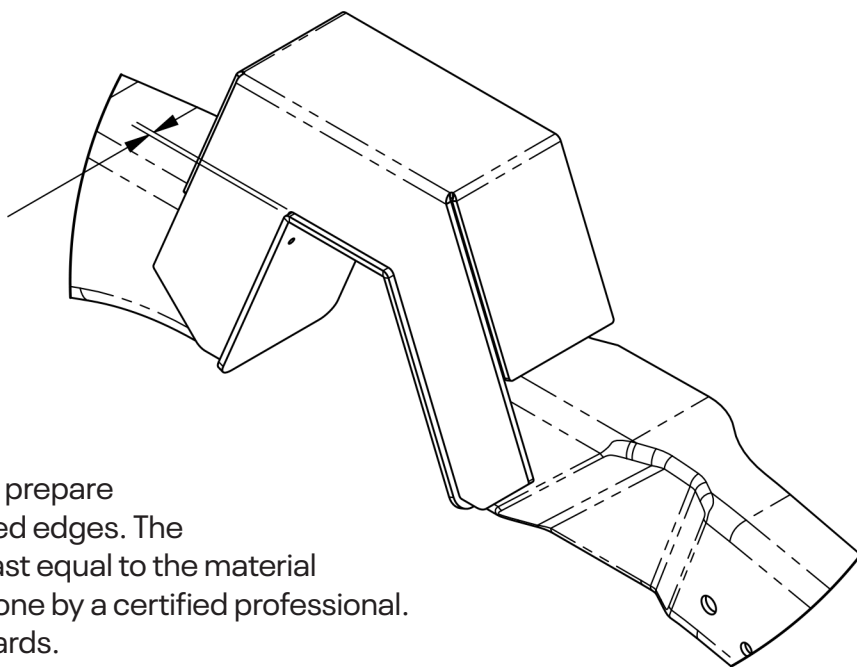
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7. Tack weld the supplied 3/8-16 weld nuts in place on each of your C-channels. Two tack welds per nut are recommended.



8. Now it is time to insert your C-channel. Place the C-channel in the frame with 3/16" to 1/4" protruding beyond the outer edge of the notch. This will create the inner corner on the outside of the notch for you to weld. Clamp the C-channel tightly in place and tack weld around the C-channel on all sides to secure it.

.24
.18
[1/4]
[3/16]



9. Give your notch one final inspection, ensuring that everything has tight weld gaps and is properly aligned. Clean and prep the notch and its mating surfaces where necessary to prepare them for welding. Fully weld all corners and exposed edges. The welds should be fillet welds with a throat size at least equal to the material thickness. It is highly recommended that this be done by a certified professional. All welds should be done according to AWS standards.

THE CUSTOMER IS RESPONSIBLE FOR CERTIFYING THE INTEGRITY OF ALL FABRICATION AND WELDING.

10. Repeat steps 1-9 for the other side.

11. With your notches now fully welded, clean and paint them as desired.

12. Install the supplied bump stops by threading them into your previously installed weld nuts.

13. Install the GVW tag kit using the supplied 3/16" rivets.

Installation Note: Following this installation, the vehicle's **Maximum GVW (Gross Vehicle Weight) is 4,200 lbs.** GVW includes the vehicle, fuel, occupants, cargo, accessories, and any installed equipment. The total vehicle weight must not exceed 4,200 lbs., and **Towing is NOT Permitted.** Failure to follow these restrictions may compromise vehicle safety.

Congratulations, your new step notches are now installed, giving your truck increased suspension travel.

Need Help with This Product?
Talk to one of our Tech Support Agents:
Mon-Fri, 8am – 5pm (CST)

U.S.: 800.979.0122
Canada: 855.313.9180
International: 1.402.323.3200