

INSTRUCTIONS

© 2025, Speedway Motors, Inc.



91643238 - 1955-59 Chevy Pickup, Rear Leaf Spring Kit

Kit Contents			
Qty	Part #	Description	Item #
2	54585090.1	Spring Pad, 3" Axle	1
1	91643510	Lower Leaf Spring Plates, Pair	2
4	91043801-1	U-Bolt 8" x 3" I.D.	3
1	91643238.3-L	Front Spring Mount, Left	4
1	91643238.3-R	Front Spring Mount, Right	5
1	91643238.2-L	Rear Spring Mount, Left	6
1	91643238.2-R	Rear Spring Mount, Right	7
2	91033326	Shackles, 2.5" Wide	8
1	91046221	Speedway Short Gas-Filled Tube Shocks	9
2	91643238.1	Shock Mount	10
2	91036096	Stud, Shock Mounting	11
2	91043447	47-1/2" 4-Leaf Spring, 250 lb	19
Hardware			
Qty	Description	Tool Size	Item #
4	Hex Cap Screw, 1/2-20 x 4, GR-8, Zinc	3/4	12
4	Oval Lock Nut, 1/2-20, GR-9, Yellow Zinc	3/4	13
56	Flat Washer, 3/8, SAE, Standard, Zinc Plated	N/A	14
28	Hex Cap Screw, 3/8-24 x 1, GR-8, Zinc	9/16	15
28	Oval Lock Nut, 3/8-24, GR-9, Yellow Zinc	9/16	16
4	Flat Washer, 7/16, USS, Through-Hardened, Zinc Plated	N/A	17
2	Flat Washer, 1/2, SAE, Standard, Zinc Plated	N/A	18

INSTRUCTIONS

© 2025, Speedway Motors, Inc.



NOTE: While it may be possible to install this kit without removing the bed, it is recommended that you do so, as it is much easier. Support the front and rear of the chassis on jack stands. Remove the rear axle, springs, rearend, brake lines, drive shaft, brackets etc.

- 1.** Before removing the stock leaf springs, mark the frame and take measurement as to where the stock axle centerline was. The frame needs to be at the typical 2 degrees rake to mimic actual ride height. Keep the frame at this rake throughout the installation.
- 2.** To remove the rivets holding the mounts, grind the rivet heads flush. Center punch the rivet and drill through using progressively larger drills up to a 5/16" drill. Take care not to drill the original rivet holes larger or off center, as you will be locating your new mounts with these holes.
- 3.** Install the front spring mounts in the same manner as the originals by bolting them onto the outside and bottom of the frame rail. You will be reusing the original spring mount holes. The mounts attach with the leaf spring hole facing toward the rear. It may be necessary to align drill a couple of these holes. Use the mount as a template for drilling any remaining holes on the frame. Fasten the mounts to the original holes on the frame using the provided 3/8-24 x 1-1/4" bolts, lock nuts, and washers. (There are 7 bolts holding each front spring mount.)
- 4.** Install the rear spring mounts in the same manner as the originals by bolting them onto the outside and bottom of the frame rail. You will be reusing the original spring mount holes. It may be necessary to align drill a couple of these holes. Use the mount as a template for drilling any remaining holes on the frame. Fasten the mounts to the original holes on the frame using the provided 3/8-24 x 1-1/4" bolts, lock nuts, and washers. (There are 5 bolts holding each rear spring mount.)
- 5.** The leaf springs center to center measurement is 36.75". Make sure that both spring pads are the same distance from the axle flanges on each side so the housing is centered. The pinion angle should be 5 degrees up.
- 6.** Use the 1/2-20 x 4 bolts and lock nuts to fasten the front of the leaf spring into the front leaf spring mount.
- 7.** Place the shackle bushings into the rear spring eyes. Slide the shackle pins through the bushings. Place the shackles onto the shackle pins and install the lock nuts. Leave loose for now
- 8.** Place the shackle bushings into the rear leaf spring mounts. Raise the rear of the leaf springs up into place and attach them to the rear leaf spring mounts using the shackles and lock nuts. Tighten down the lock nuts on each shackle.
- 9.** Drop the rearend down onto the top of the leaf springs. Align the hole on the leaf pads onto the stud on the top of the leaf springs. Clamp the rearend to the leaf springs using the U-bolts, lower leaf spring plates, and 1/2-20 lock nuts. The lower leaf spring plates are positioned under the spring with the shock tabs pointing down on the inboard side and behind the axle. Tighten down the U-bolts

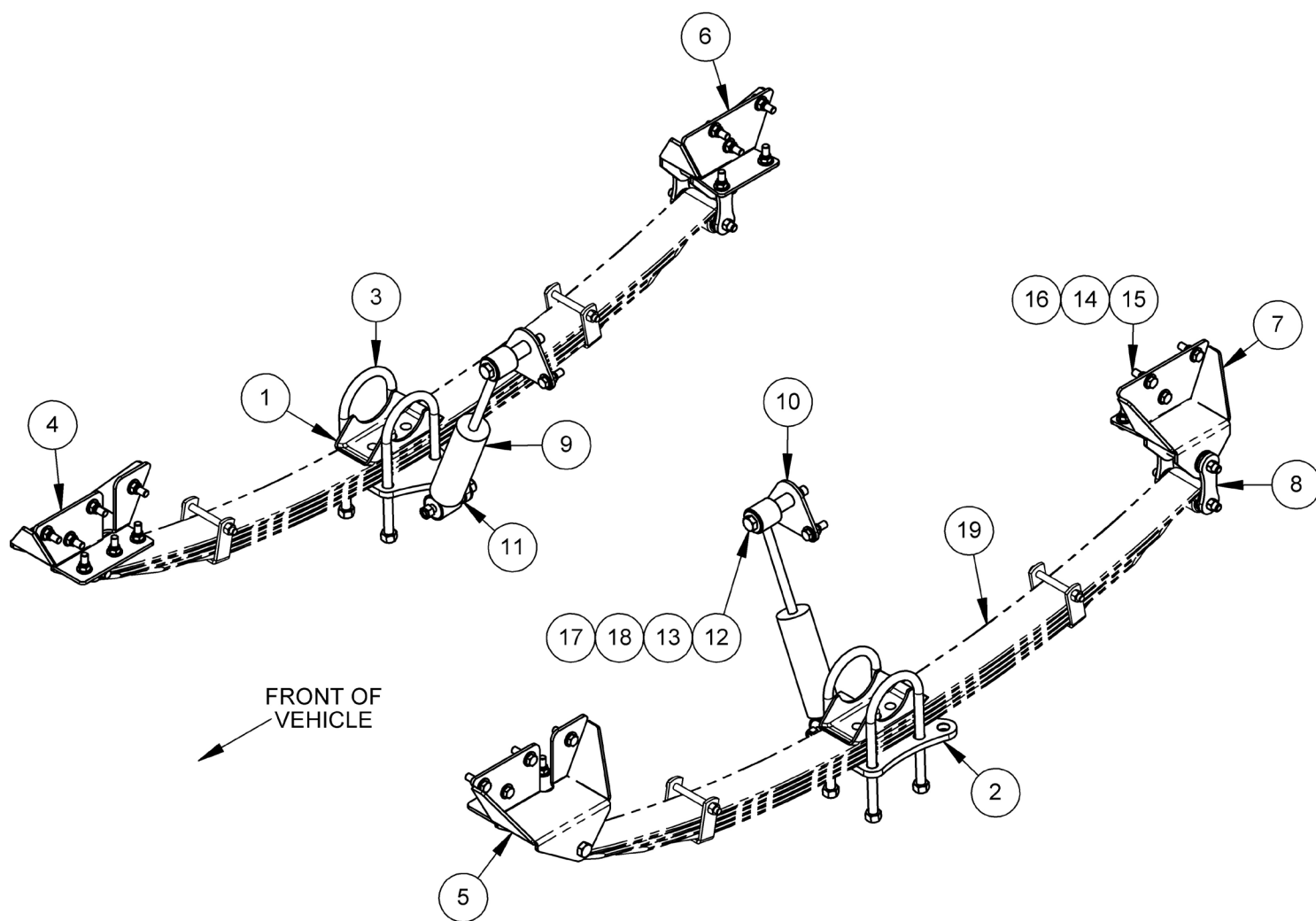
INSTRUCTIONS

© 2025, Speedway Motors, Inc.



10. The new shock mounts attach outboard of the original shock mounts. Drill $7/16$ " holes 3.5 " outboard of the upper rivet of the original shock mount and $1-1/8$ " below the top edge. Bolt the top hole of the mounts and the shocks onto the cross member. Use $1/2$ "-20 x 4 bolts, nylock nuts, and washers under the bolt heads and nuts. Set the bottom edge of the mounts parallel to the cross member and drill the $3/8$ " holes using the bracket as guide. Bolt in place using the remaining $3/8$ "-24 x $1-1/4$ " bolts, lock nuts and washers.

11. Fasten the shock studs to the lower leaf spring plates with $1/2$ -20 nylock and washers. Attach the shocks and fasten with the provided lock nuts, washers.



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