Nov 21, 2017

Torque Arm Rear Sway Bar for '67-81 Camaro & '68-74 Nova

The following instructions are intended for professional installers and are guidelines only. Speedtech Performance assumes NO responsibility for the installation of any of its products. All products are intended for off road use only and must be installed by qualified professionals only.

Thank you for purchasing your new Speedtech Torque Arm rear sway bar kit. Be sure to take all necessary safety precautions required to the job correctly. Use safe and sturdy jack stands to support the vehicle whenever it is off the ground. The installation of the Torque Arm rear sway bar is straightforward, however we recommend you read through all directions prior to starting the installation.
Axle Brackets for ALL Applications

**Note:** The suspension *should be at drive height* when installing the bar. If the car is on a lift and the suspension is in droop when you install the kit it will not line up properly when back on the ground. The sway bar brackets will all need to be test fit into place before final installation to make sure to achieve proper alignment of the bar and no binding is experienced during the suspension’s travel.

Insert sway bar into greased poly bushings, then attach bushing bracket to the axle perches. Do not fully tighten at this point. Position the brackets in the space between the two bends of the bar. Note the back portion of the bar behind the axle housing will point down slightly. *Be sure not to install the bar upside down!*

You will find that the axle perches have one end shorter than the other. Either end can face forward, use the best positioning for proper bar to frame rail bracket alignment. *We have found typically you’ll face the short end forward, the large end towards the back of the car.* Perches can be swapped side to side.

*Also note* one cutout in the perch is larger than the other side. This larger cutout will go over the housing portion of the center section. See diagram.

![Diagram of axle brackets and sway bar](image-url)
Lift the assembly into place and use C clamps, ratchet straps, etc., to hold the sway bar, brackets and perches in position against axle housing. Do not weld at this time. See Photo on page 5.

Position bushing and brackets between these two curves.

Right side bracket will be very close to panhard bracket.

Note: Sway bar will angle down slightly. Photo shows this suspension in free droop.
Torque Arm Sway Bar Hardware Kit Checklist

'67-69 Camaro, '68-74 Nova (Go to page 5 for '70-81 Camaro)

☐ Installation Instructions (1)

☐ A. Axle housing bracket (2)

☐ B. Frame Bracket (2)

☐ C. Interior L Bracket (2)

☐ D. Heim End Link Assemblies, 3 pieces (2)

Bolts

☐ E. 3/8 x 1 1/4 NF (10)

☐ F. 3/8 x 1 1/2 NF (2)

☐ G. 3/8 x 4 1/2 NF (2)

Nylock Nuts

☐ H. 3/8 (14)

Washers

☐ I. 3/8 (20)

Additional Items needed:

☐ You will need basic hand tools and a drill with a 3/8” drill bit.

☐ Brackets and bushings for the sway bar are found in the sway bar packing box.
'67-69 Camaro and '68-74 Nova Frame brackets.

('70-81 Camaro skip to page 10)

1. The frame rail brackets are the same for both sides. Because of this not all bolt holes will be used on either side. Attach the spherical bearing end links to the frame rail brackets using the 3/8x1 ¼” bolts. Typically you'll use the front hole (see photo) for the front or middle sway bar hole, and use the next rearward bracket hole for the sway bar middle or rear hole. Note that the remaining two holes (to the right in the photo) will not be used. See Photo below for proper assembly of the heim joint end link. Note the end link is positioned on the inside of the bracket.

The longer 3/8x1 ½” bolt attaches to the sway bar end of the end link. Shorter 1 1/4" bolt shown installed in place on bracket.
2. Position the bracket on the frame rail so that the heim joint end link hangs down and lines up vertically with the sway bar’s appropriate bolt hole. The tongue of the bracket will cover over the frame rail while the upper lip of the bracket will position near the inside of the frame rail. Mark the two lower holes in the bracket upper lip onto the floor pan. These holes will need to be drilled for the 3/8” bolts. The remaining third hole in the bracket lip will not be used.

The hole for the bracket tongue will also need to be drilled. In most cases, on Camaros and Firebirds this hole will line up with the seat belt bolt hole. It will not line up with the seatbelt hole on Novas. An option for aligning the bracket on Camaros is to use a long punch through the seat belt bolt hole to mark on the frame where the bolt would punch through. The provided 3/8 bolt is a grade 8, however the length is slightly too short and diameter too thin to properly accommodate bolting down the seat belt. If seat belts are to remain in place we recommend using a 7/16” or larger, grade 8 bolt in at least a 5” length.

A third option for any of the bracket to frame holes is to plug weld them. If welding the bracket in place be sure to properly prep the frame rail and floor pan for welding. Also note the frame rail is basically thin sheetmetal and does not require as much heat as you may think. Watch your heat and be careful not to blow through the rail. Always remember, measure twice and weld once.

In the right photo you can see the two floor pan bolts in place in the two forward holes above the end link (to the left of the link). These bolts will go through the floor pan behind the seat, so rear seat removal is necessary to attach the nuts.
Note also in the right photo the rearward hole in the bracket and sway bar allow the end link to line up vertically. After holes are drilled and positioning verified, paint or powder coat brackets to protect them from the elements. Attach the bracket to the frame rail using the 3/8x1 ¼ bolts, washers and nuts. On the interior of the car line up the L shaped flat bracket with the holes you drilled. This will sandwich between the floor and the nuts to help spread the load and tie the three bolts together. See photo for approximate positioning.

At this time double check alignment of all brackets, perches, sway bar end link, and sway bar. Adjust as necessary. It is recommended to run the suspension through compression and extension to ensure there is no binding. This may be easiest with the shocks unbolted. If everything is aligned correctly tighten all frame rail bracket bolts.

4. Now mark spring perch locations on the axle housing. Disconnect bushing brackets from the axle perches! Now you can proceed to welding the axle brackets to the axle housing.

**Skip to page 13.**
Torque Arm Sway Bar Hardware Kit Checklist

'70-81 Camaro

- Installation Instructions (1)
- A. Axle housing bracket (2)
- B. Frame Bracket (2)
- C. Heim End Link Assemblies, 3 pieces (2)

Bolts

- D. 3/8 x 1 1/4 (6)
- E. 3/8 x 1 1/2 (2)
- F. 3/8 x 3 (4)
- G. 3/8 x 1 COARSE Socket Head (2)

Nylock Nuts

- H. 3/8 FINE Thread (12)
- I. 3/8 COARSE Thread (2)

Washers

- J. 3/8 (18)

Additional Items needed:

- You will need basic hand tools and a drill with a 3/8” drill bit.
- Brackets and bushings for the sway bar are found in the sway bar packing box.
'70-81 Camaro Frame brackets.

1. The frame rail brackets are the same for both sides. Because the sway bar is adjustable not all bolt holes will be used. Attach the spherical bearing Heim end links to the frame rail brackets using the 3/8x1 ¼” bolts. *Do not fully tighten, you're just mocking it up right now.* Typically you’ll use the front hole for the front or middle sway bar adjusting hole, and use the rear hole for the sway bar middle or rear adjusting hole. Photo shows the heim in the rear hole.

![frame rail bracket with heim end link](image)

2. *With the suspension at ride height* position the bracket on the frame rail so that the heim joint end link hangs down and lines up vertically with the sway bar’s appropriate bolt hole. Use the longer 3/8x1 ½” bolt to position the end link on the sway bar. The top of the bracket should sit up against the floor. Mark the two outer holes in the bracket and drill holes for the 3/8x3" bolts. Remove the bottom half of the rear seat and make sure nothing is in the way of drilling a hole from underneath. Drill the remaining hole at the top of the bracket through the floor using the bracket as a guide. This is the area where you will use the socket head bolt (see page 11).

An option for any of the bracket to frame holes is to plug weld them. If welding the bracket in place be sure to properly prep the frame rail and floor pan for welding. Also note the frame rail is basically thin sheetmetal and does not require as much heat as you may think. Watch your heat and be careful not to blow through the rail. Always remember, measure twice and weld once.
Excessive heat can warp axle tubes. If you do not feel you have the necessary experience to weld on axle housings seek experienced professional help!

With the axle housing prepped for welding and the perches in place weld them to the axle. They do not need to be completely welded around the joint. Stitch welding them (Arrows in the photo) will typically prevent excessive heat and warpage yet provide a strong enough attachment.
On the panhard bracket side you may need to weld inside the perch if there is not an accessible welding area on the outside. Paint the perches to protect them from the elements.

At this time torque all bracket and heim fine thread bolts to 35 ft lbs. Torque course thread socket bolts to 25 ft lbs. That concludes your sway bar installation. If you are unsure or have questions during the installation process, feel free to call us for help. We are open M-F, 8 AM to 5 PM Mountain time.
1. Terms and Conditions of Sale

1. Effective January, 2008, supersedes all previous policy statements. Policies are subject to change without notice. Speed tech performance Ltd. is not responsible for printing errors.

2. Speedtech Performance USA LLC. does not endorse, nor recommend modification of vehicles for use on public highways, since warranty or government regulations may be violated. As an express condition of sale of any performance part, the buyer acknowledges and agrees to use the performance parts for the modification of vehicles in sanctioned OFF-ROAD competitive events and show purposes only. Customers should exercise their discretion on matters with regards to the purchase and installation of these products.

3. Speedtech Performance USA LLC. does not ensure the legal use of these products. We do not guarantee the fitment of these products for anything other than there intended application nor do we assume any responsibilities what so ever for the misuse or losses incurred by the use of any of these components. While every effort is made to provide technical information and assistance, we have no control over owner installation, modification, and unusual stress that performance parts are subject to.

4. The customer acknowledges that Speedtech Performance USA LLC. and its employees are not responsible for any mechanical failures due to the use of parts sold, supplied or installed not for their intended application. Speedtech Performance USA LLC will not be held liable for any damages which are incurred directly or indirectly on the vehicles or operators or passengers of the vehicle.

5. Please consult your sales agent and/or technician prior to purchase of any of Speedtech Performance USA LLC products to ensure proper fit. The buyer assumes all responsibilities for determining the suitability of the product. All aftermarket products should always be installed by professionals only.

2. How to File a Warranty Claim:

1. Speed tech Performance Ltd. Warrants its products against materials and workmanship failure for the term of 12 months (1 year) from the date of purchase and only up to the amount paid with proof of purchase.

2. Seller’s liability shall be limited to repairing or replacing, at its option, any defective product which is returned, freight prepaid to Seller, according to the Merchandise Return Procedure set forth in Section 3-B below. Buyer shall bear all responsibility for shipping charges and risk of loss or damage during transit to Seller. Products which have been subjected to abuse, misuse, alteration, neglect or unauthorized repair or installation, as determined solely by Seller, are not covered by this warranty. Any alterations, addition, improvements or attachments to the product(s) not authorized in writing by the Seller shall be deemed to be a waiver of this warranty by Buyer and shall render this warranty null and void. Seller shall return repaired or replaced product(s) to Buyer, at its expense via regular ground service in the U.S. Shipping charges by all other methods and to all other destinations shall be borne by Buyer.

3. As per section 3-B below, all shipments MUST be prepaid, include the original invoice and show the RGA on the outside of the package, otherwise it will be refused. Please include a brief explanation letter in order to expedite the warranty analysis process.

This Warranty DOES NOT Cover-
- Removal, installation, shipment and insurance costs
- Improper installation or maintenance
- Alterations on the original design or unauthorized repairs.
- Normal wear and tear
- Misuse or abuse, negligence
- Damage to related components
- Costs incurred due to down time of vehicle

3. Merchandise General Return Procedure:

A. If you purchased your Speedtech Performance USA LLC product from us or from an authorized dealer, you are covered by the terms of our general product return policy. All claims however, must be submitted directly to Speedtech Performance USA LLC. The answer to ALL of the following questions should be YES before contacting our Customer Service Department.

1. Is the part appropriate to your application?
2. Did you carefully and thoroughly read the instructions provided along with the part?
3. Do you have the proof of purchase?
4. Are you the original purchaser?
5. Is the part unmodified and clean?
6. Is the return date within 3 months from the purchase date?
7. Is the reason for return a legitimate product defect?

If all answers are yes, please do the following:

B. Call our customer service representatives at 1-435-628-4300.
- Provide the invoice number, date of purchase and reason for return
- You will be assigned a Returned Goods Authorization Number (RGA) valid for 30 days. The package you return must show the RGA on the outside of the package, include a copy of the original invoice and be shipped prepaid to our facility. The part has to be in its original packaging materials and be in a resellable condition. For parts presenting signs of installation and/or use, only warranty claims will be accepted.
- Ship to seller, freight pre-paid and insured for replacement cost in original packaging.
- Replacement or repair decision will be made when merchandise is received by seller. No advance replacement is available.
- A Restocking fee may be applied.

All warranties implied by law are limited in duration of this warranty. You have specific rights that may vary from state to state or Province to Province. By purchasing any of the products that are manufactured by speed tech performance you agree to any and all of the above terms and conditions.

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