

## 55 - 57 FORD THUNDERBIRD & 54 – 56 FORD AND MERCURY FRONT DISC BRAKE KIT INSTALLATION

Support the front of the vehicle on jack stands. Remove front brake drums, backing plates and flexible brake lines from both sides. Clean the spindles, including the spotfaces in back and the mounting surfaces on the spindle arms. Install the front spindle bracket and steering arm using the 3/8 x 1 1/2" and 1/2 x 2 1/2" bolts with the lockwashers and nuts on the back side, do not tighten. Install the 1/2 x 2 1/4" grade 8 bolt in the lower front hole through the steering arm with the nut and lock washer on the back side. Attach the caliper bracket to the spindle bracket with the 3/8 x 2 bolts and lockwashers. Apply Loctite to the 3/8" grade 8 bolts and tighten to 45 - 50 FT. LBS., make sure to install the lock washers. Apply Loctite to the 1/2" bolts and tighten to 75 - 80 FT. LBS.

Now you will have to heat the bearing spacers with a torch to a dull red. DO NOT OVERHEAT! Slide the heated spacer over the spindle with a pair of pliers and push the spacer with a piece of pipe large enough to fit over the bearing journal until firmly seated. You might have to tap the pipe with a hammer. Make sure the pipe seats against the larger flat face. Do not try to install the spacer without heating. After it cools slide the inner bearing over the spacer, it should slide on easily. If not, polish the bearing journal with emery cloth until it slides on and off easily.

If you are installing the Budget Kit you will have to make some modifications to the GM calipers. There is a knob on lower center part of the casting that will have to be removed with a grinder or saw and sanded smooth. There is also a raised lip around the area that the brake line bolts to. This will have to be removed with a grinder or saw. Make sure the plastic plug is in the hole so you don't get any filings inside. These modifications have already been made to the supplied calipers in the Super Kit. Make sure the bleeder is at the top when installing the calipers. Finish assembling the remaining parts. DO NOT Loctite the caliper slide bolts. Install the new flexible brake line and turn the wheels all the way right and left and check for interference, adjust accordingly and tighten.

It is recommended that you install a dual master cylinder and a proportioning valve. A power booster can be used to reduce pedal pressure. These parts are not included but you can buy them from most parts stores or Speedway Motors. You must bleed the brakes before attempting to drive the vehicle. Some wheels will require turning the rotor hub or enlarging the center hole.