



## 1968-74 Ford ½ and ¾ Ton Van Front Disc Brake Conversion Installation Instructions

1. Break front wheel nuts loose and chock rear wheels to secure vehicle in place.
2. Jack up front end of car and support vehicle with appropriately-rated jackstands.
3. Put a few drops of penetrating oil on brake line nuts where they screw into the rubber lines. Remove front wheels and drum/hub assemblies.
4. Reduce the diameter of the stud bases with a swage cutter, or by another method and then press the studs out of drum/hub assemblies and discard them. Clean off the wheel mounting surfaces of the hubs with a wire wheel or bead-blaster.
5. **For ¾ ton only** - machine outer edges of hub flanges to fit inside rotors with about 0.030" loose fit. Open up center hole of rotor to 3.555" to clear hub.
6. **For ½ ton only** - slide rotor spacer rings onto hubs.
7. Install new studs that are at least ¼" longer than the old studs. Best approach is to use ARP or Moser studs and cut them down to length. NAPA Balkamp 641-1112 studs may work with both applications, but make sure they are threaded far enough.
8. Disconnect flexible brake lines at the frame by loosening and removing the hardline nuts with a flare-nut wrench. Remove the drum retaining bolts. Remove the drum backing plates, hoses and all drum hardware as complete assemblies. Clean off spindle assemblies well.
9. Place the caliper mounting plates over the spindles with caliper bolt retaining nut welds facing inward, and caliper openings oriented to the front. Make sure no dirt is lodged between the spindles and plates.
10. Verify that rotors lay flat against the hubs. Rotors may need stud holes drilled 5/8" to clear stud knurls.
11. Clean and repack wheel bearings. Place the inner bearings inside the hubs and install new grease seals. Assemble hubs onto spindles, tighten outer nuts to spec, then secure with keepers and new cotter pins. Install the dust caps.
12. Place rotors onto hubs and run two or three lug nuts down finger tight to retain them in place. Wipe down rotors with alcohol, lacquer thinner or other cleaner.
13. **Wash hands to prevent grease contamination of rotors and/or brake pads.**
14. Slide caliper assemblies into caliper brackets, with bleed screws facing up. We recommend buying loaded calipers. Tighten caliper bolts to 35 foot-pounds. Check fitment and rotate rotors to check clearances. Install flexible brake lines.

15. 1968-74 drum master cylinders are the same; the only difference is manual vs. power. If they lack a residual pressure valve then they should be sufficient to stop the van. 1975-79 E100 master cylinders are disc only, and may bolt in place of the drum master. Plumb in an adjustable proportion valve in the line going to the rear cylinders, or use a disc proportioning valve if rears suffer from excessive lockup in panic stops.
16. Bench-bleed disc master cylinder. Mount the master cylinder on the car and then **gravity bleed** entire system to eliminate most of the air. Following that, pump-bleed and then test the systems to validate the spool valve in the distribution block piston remains in the centered position and able to pass fluid.
17. Install the wheels and lug nuts and lower car before torquing the lug nuts to spec. Test drive carefully- no hard stops. A series of 30 smooth stops from 30 mph, with a 30 second cooling period between stops will bed-in the pads properly. Let cool for an hour after finished bedding.

#### ½ ton

Part	Application	NAPA	Wagner	Raybestos
Rotor	1995-97 Crown Vic front	86492	BD125476	66492
Caliper, LH	1988-91 GMC 1500 Reg. Cab	N4853	L116290	RC4416SS
Caliper, RH	1988-91 GMC 1500 Reg. Cab	N4852	L116291	RC4415SS
Banjo Bolt	1988-91 GMC 1500 Reg. Cab	82703	DORMAN Part # 13940	
Brake Hose (15")	1979 Seville front	36845	F98912	BH36845

#### ¾ ton

Part	Application	NAPA	Wagner	Raybestos
Rotor	1994-99 Dodge 1/2 ton front	4886447	BD125388	76447
Caliper, LH	1990-02 Astro Van AWD	N4851	TQM25002	RC4418
Caliper, RH	1990-02 Astro Van AWD	N4852	TQM25003	RC4417
Banjo Bolt	1988-91 GMC 1500 Reg. Cab	82703	DORMAN Part # 13940	
Brake Hose (15")	1979 Seville front	36845	F98912	BH36845

Supplied components: caliper mounting brackets, Halfy spacers, cotter pins, hose locks and metric banjo bolts.

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