

# INSTRUCTIONS

**910-63540**

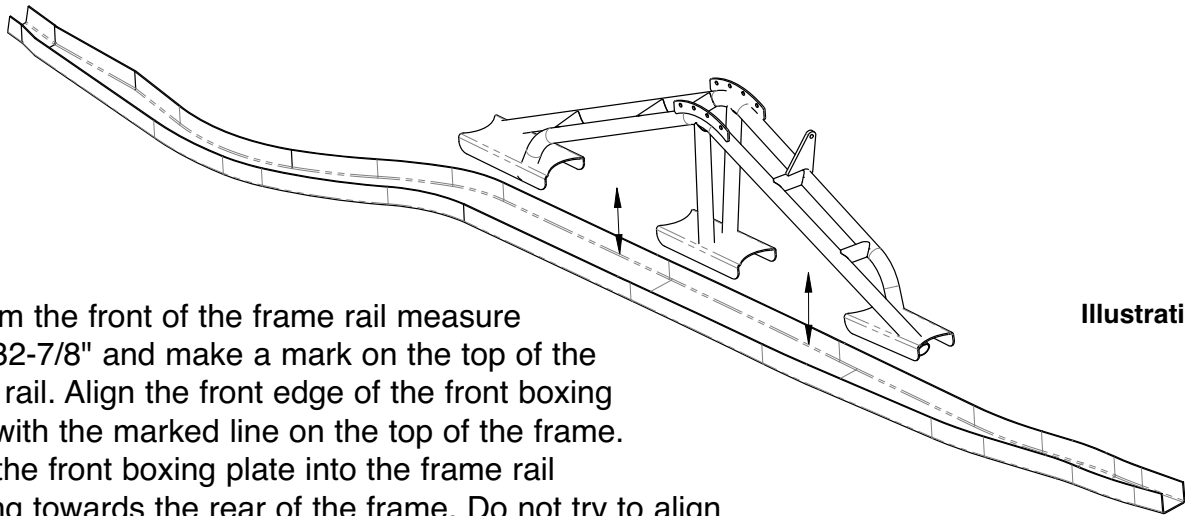
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## Bolt in Center X-Member for Speedway's '35-'40 Frame Rails

**PLEASE READ INSTRUCTIONS COMPLETELY  
BEFORE STARTING YOUR INSTALLATION**

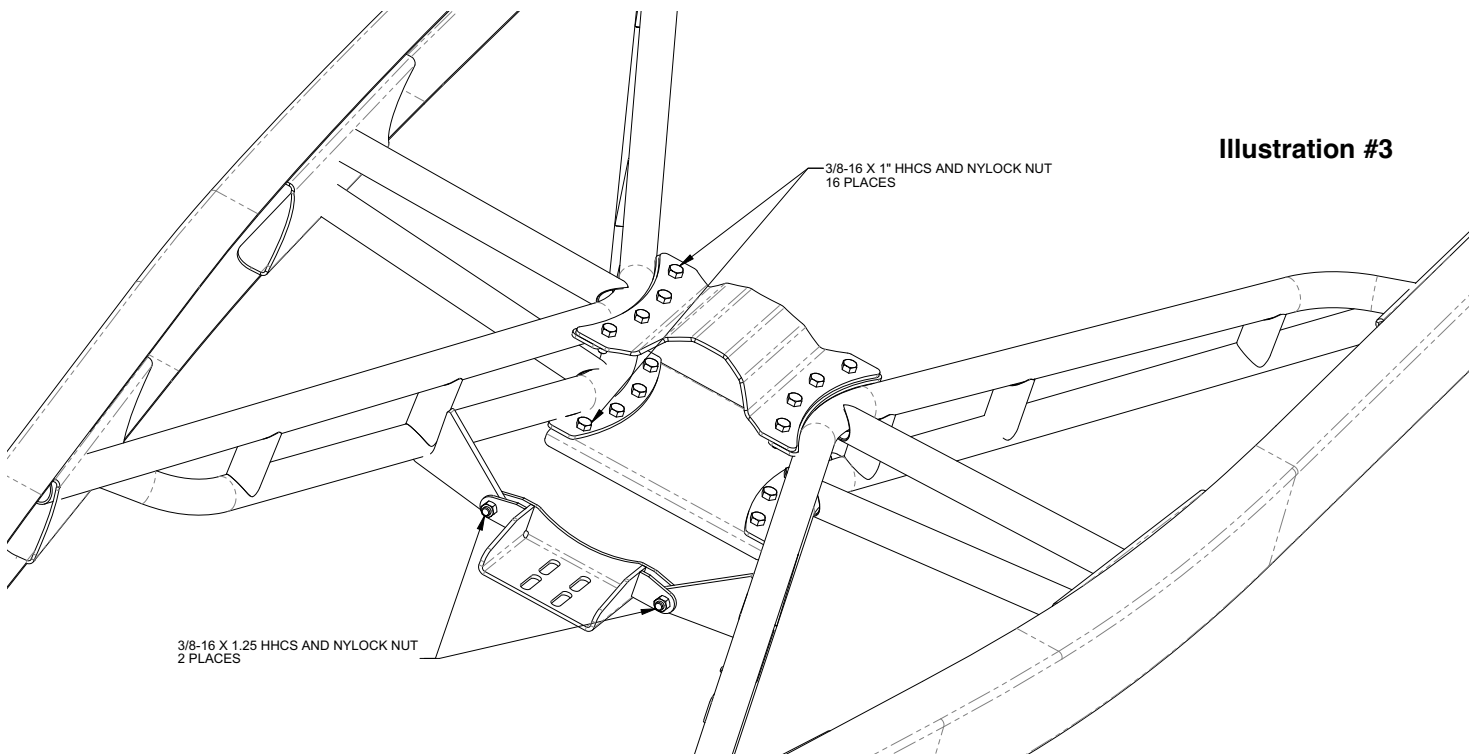
PARTS LIST	
Qty.	Description
1	Left X-member assembly
1	Right X-member assembly
1	Top plate
1	Bottom plate
1	Transmission cross member
1	Hardware kit
40	-HZ5HCSC-.38-1.003/8-16 X 1 USS GR 5
2	-HZ5HCSC-.38-1.253/8-16 X 1 USS GR 5
42	-HZ5NLNC-.38 3/8-16 USS NYLOC NUT

1. The easiest way to assemble the X-member to the frame rails is by laying each frame rail flat on the floor with the channeled side of the frame facing up. Start with the driver side frame rail and X-member. The driver's side X-member assembly has the brake pedal mount welded to it which mounts toward the front along with the transmission mounting bracket.



**Illustration #2**

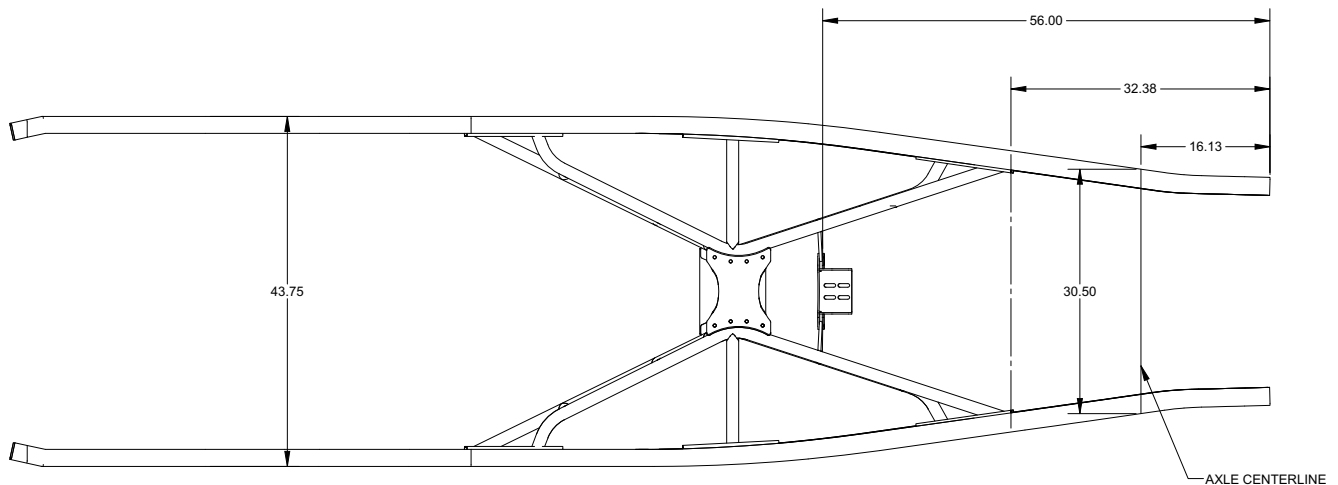
2. From the front of the frame rail measure back 32-7/8" and make a mark on the top of the frame rail. Align the front edge of the front boxing plate with the marked line on the top of the frame. Slide the front boxing plate into the frame rail working towards the rear of the frame. Do not try to align all three boxing plates at the same time its much easier starting at the front and working towards the rear. This will be a snug fit so a little help from a rubber mallet may be necessary. Once all three boxing plates are slid together recheck the 32-7/8" measurement. Use a rubber mallet to adjust if necessary. Install the passenger side X-member into the passenger side frame rail in the same manner. See illustration #2



**Illustration #3**

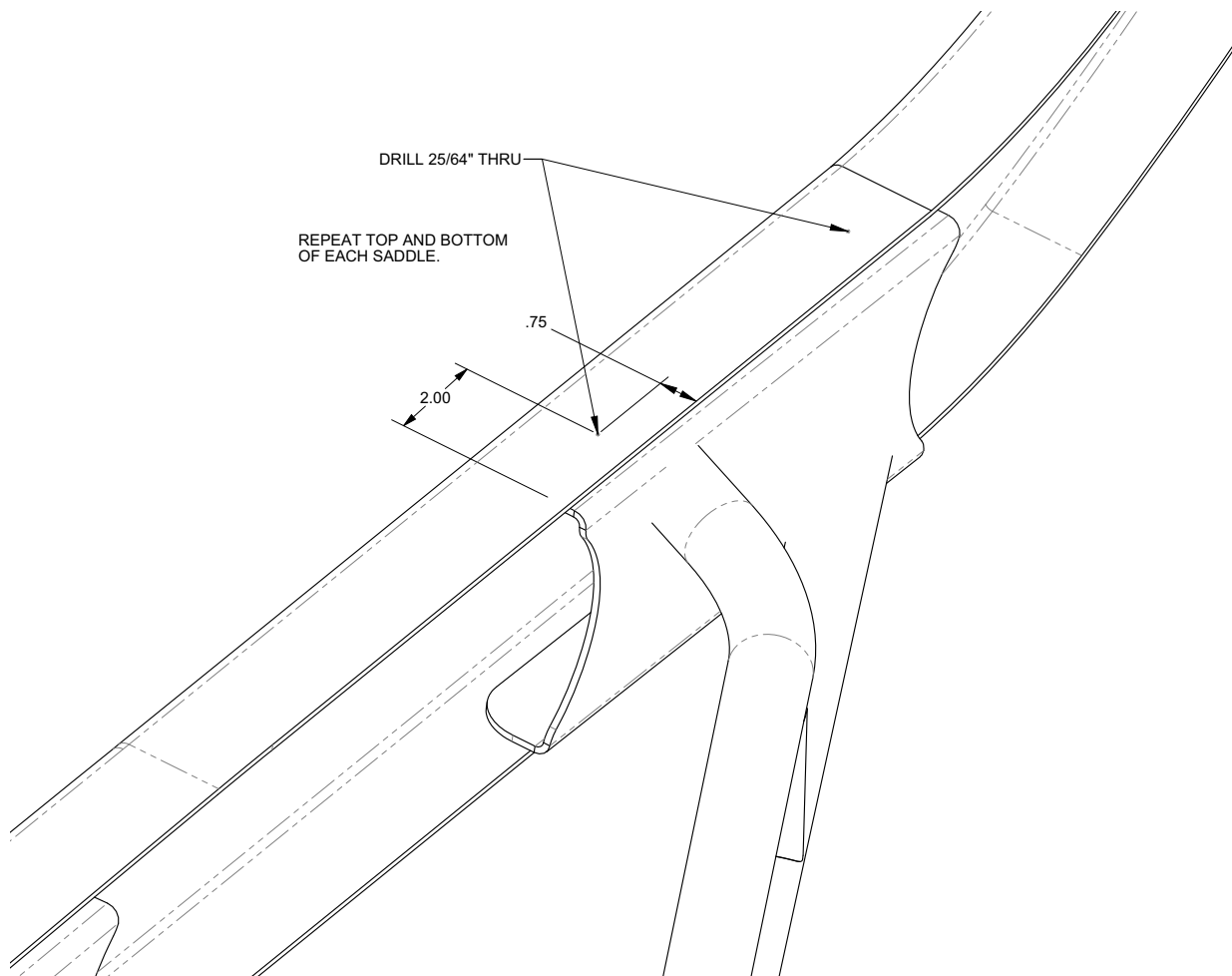
3. Assembling both half's of the X-member together: You will need four jack stands and a couple of small blocks of wood. Set the frame rails up vertically on the jack stands using the blocks of wood under the center of the X-member to square up the frame rails. Slide the frame rails together until you can line up the 16 holes in the x-members with the top and bottom plates. Install the 3/8"-16 x 1" bolts and nylon locking nuts but do not fully tighten. See Illustration #3

4. Bolt the transmission cross member in place between both half's of the X-member using the 3/8"-16 x 1-1/4" bolts and nylock locking nuts. Torque the two transmission mounting bolts and the sixteen top and bottom plate bolts to 30 ft. lbs. See Illustration #3



**Illustration #5**

5. Check the transmission cross member mounting bracket location. Measure from the front of the mounting bracket on the x-member to the front of the frame rails. This measurement should be 56" + or - 1/8". Adjust as necessary. See Illustration #5
6. If you purchased our bolt in IFS cross member clamp it into position using the supplied instructions. Or you can temporary clamp a brace across the frame rails at the axle center line. The axle center line is 16-1/8" back from the front of the frame rails. The outside frame measurement at the axle centerline should be 30-1/2". See Illustration #5
7. Measure the outside width of the frame rails at the rear boxing plates. If this measurement is greater than 43-3/4" use a bar clamp to pull them into position. Make sure the boxing plates on the x-member are centered between the frame rails at both the front and rear. Once in position clamp the boxing plates to the top of the frame rails.
8. You will now need to check your frame for squareness. Measure across diagonally from one frame rail to the other using the existing mounting holes on the top of the frame as a reference. Repeat this measurement on the opposite frame rail. If the difference between these measurements are greater than 1/8" use a rubber mallet to move the frame rails into position and double check your measurements, also double check the 56" measurement from the transmission cross member mounting bracket to the front of the frame rails.
9. If you purchased our rear cross brace you can clamp that into position using the instructions supplied. Or you can temporary clamp a brace at the rear of the frame rails. The outside frame measurement should be 43-3/4". See Illustration #5
10. Double check all your frame widths and diagonal measurements.



**Illustration #11**

11. Using a 25/64" drill mark and drill the twelve upper mounting holes. Locate the holes 3/4" in from the inside edge of the frame rail and 2" in from the end of the boxing plates. See illustration #11

12. Bolt the upper flange of the boxing plates to the frame rails using the 3/8"-16 x 1" bolts and nylon locking nuts. Torque them to 30 ft. lbs. You can now remove the clamps.

13. Flip the frame over and check that the frame rails are plumb. Use bar clamps to square the rails up if necessary. Clamp the boxing plates to lower frame rail.

14. Using a 25/64" drill, mark and drill the twelve lower mounting holes. Locate the holes 3/4" in from the inside edge of the frame rail and 2" in from the end of the boxing plates. See Illustration #11.

16. Bolt the lower flange of the boxing plates to the frame rails using the 3/8"-16 x 1" bolts and nylon locking nuts. Torque them to 30 ft. lbs.

# IMPORTANT

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