

INSTRUCTIONS

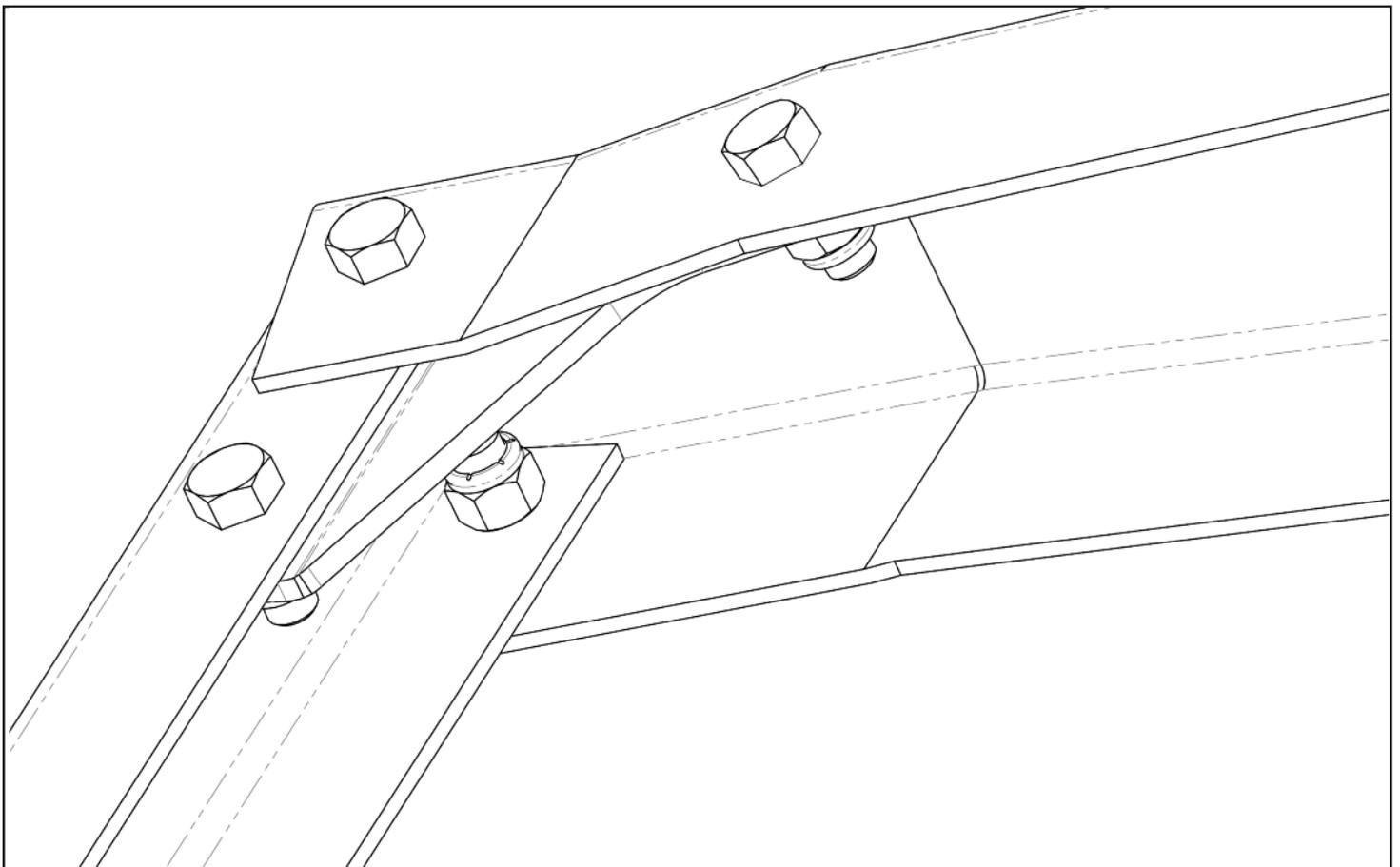
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Rear Cross Brace for '35-'40 Ford Chassis

O.E.M Frame Rails

1. You will need to check your frame for squareness before starting this installation. You can measure your frame diagonally to verify this. Measurements should be within 1/8".
2. Remove the old rear cross brace by removing the six rivets that attach it to the frame rails. This can be accomplished by grinding the heads of the rivets flush with the frame rail then center punching the center of the rivets and drilling a 5/16" diameter hole about 1/4" deep. Using a hammer and punch you can drive out the rivets. The cross brace can now be removed.
3. Drill out the upper and lower mounting holes to 25/64".
4. Slide the cross brace into position lining up the holes in the cross brace with the holes in the frame.
5. Slide the gussets into position mounting them to the inside of frame rail and cross brace. Bolt in place using the 3/8"-16 x 1" bolts and nylon lock nuts. Torque them to 35 ft. lbs.



Speedway Frame Rails

1. You will need to check your frame for squareness before starting this installation. You can measure your frame diagonally to verify this. Measurements should be 1/8" or less.
2. Slide the cross brace into position flush with the back edges of the frame rails. Clamp the cross brace into position clamping the lower portion of the frame rail to the lower portion of the cross brace. The outside width of your frame rails should measure 43³/₄" measuring it about 5" from the back edge of your frame. Set the gussets onto the top of frame rail aligning the holes in the gussets with the holes in the cross brace. Mark and drill the four upper mounting holes using a 25/64" drill.
3. Slide the gussets into position mounting them to the inside of frame rail and cross brace. Bolt them in using the 3/8"-16 x 1" bolts and nylock nuts. Temporally leave the bolts in both corners out. You can now remove the clamps on the lower portion of the frame rails.
4. Using the 25/64" drill, align the drill through the corner holes and the lower portion of the cross brace drilling through the lower frame rail. Bolt in place using the 3/8" bolts and nylon lock nuts; torque them to 35 ft. lbs.

IMPORTANT

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