

# INSTRUCTIONS

**916-57025**

## '32 CENTER CROSSMEMBER KIT

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### INTRODUCTION

This manual is written to assist you in installing the '32 center crossmember in your frame. It assumes that you have some fabricating experience and have access to fabrication tools, a cutting torch, wire welder and grinder. If you don't have access to these tools, you may find it cheaper and easier to have a professional welder or shop perform the installation for you.

### SAFETY

Always wear safety glasses as well as any other appropriate protective equipment. Do not weld around flammable materials, and always work in a well ventilated area.

### HERE WE GO!!!

1.) The first thing you will need to do is notch boxing plate "H" to fit your rails. To do this, place the plate, with the hole in the upper rear corner, flat against the rail with the bolt holes in the plate directly across from the corresponding frame holes. Make the plate where it extends beyond the taper in the front of the rail. Trim the plate to match this taper.

2.) Next, using the factory frame holes, bolt the boxing plates to the rails. With 3 or 4 heavy tacks, weld the lower edge of the plates flush with the inside of the frame.

3.) If they are not already, the frame rails need to be assembled with the front and rear crossmembers or spreader bars and shimmed to at least 1 1/2" above the ground now. It is very important that the frame is held flat and square during the assembly of the crossmember, and that the frame width is correct. If it is not, the frame will not fit the body, and may cause alignment problems.

### SETTING THE FRAME WIDTH

Measure across the frame and compare this with the numbers on the print. If they are more than 1/8" off, cut a 2x4 shim to the proper length and clamp or wedge it between the rails.

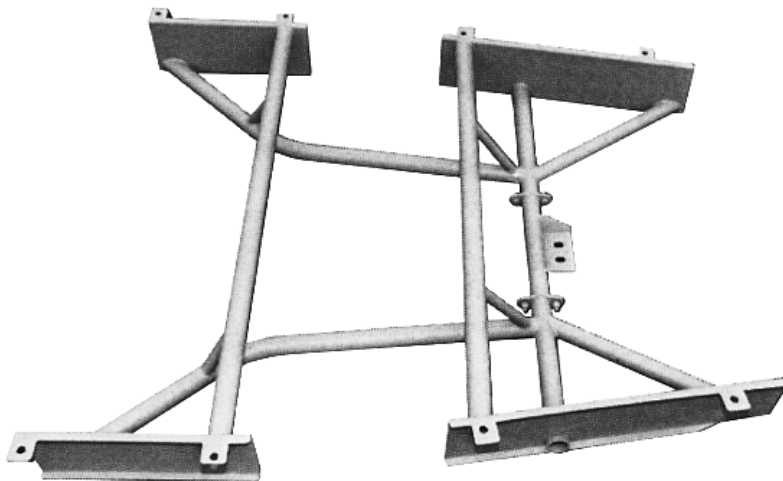
### TO SQUARE YOUR FRAME YOU WILL NEED TO.....

With a tape measure, measure from the rear hole in the rail in front of the rear crossmember the frame to the front hole in the opposite rail. Do this for both sides, and if the measurements are different by more than 1/8", the frame will need to be squared. To square our frame, use a ratchet type come along or tie down to pull in the direction that is too long. Relax the tie down and measure again. Repeat until both sides are the same.

## TO LEVEL THE FRAME

Place a 4 foot level on the flat section of the rail, and shim until it is level. Do this for both sides. Now, place the level across the frame rails and shim until they are level with each other.

- 4.) Install parts A and B, with A in the front, into the upper holes in the boxing plates. Position them so that they point straight up, with the peak in the center. Use 2 or 3 heavy tacks to hold them in place.
- 5.) Place the 2 part "D" tubes in the frame, with the rear (long) leg in the lower, oval hole in the rear plate. Using the same instructions as for the frame, set the width and level of the center leg of the part "D" tubes. Tack weld both ends with 2 or three heavy tacks.
- 6.) Cut and notch 2 pieces of 1" tube (provided) to form the rear diagonal braces (labeled "A" in the assembly drawing) and fit them to clear your intended exhaust system. Tack weld them in place.
- 7.) Before continuing you will need to recheck all tack welds to ensure that they will not break when the engine and transmission are trial fitted.
- 8.) Install the engine and transmission, with the engine and transmission mounts, in the frame letting the ears of the transmission mount rest on the top of the part "D" tubes. With a transfer punch, make the bolt holes in the tubes. Remove the engine and transmission.
- 9.) Clamp the transmission mount in place and drill the bolt holes, Bolt the transmission mount in place.
- 10.) Fit the 2 forward diagonal braces, so that they are at least 1" behind the transmission mount. Tack weld them in place.
- 11.) Remove the transmission mount, and fully weld all seams.



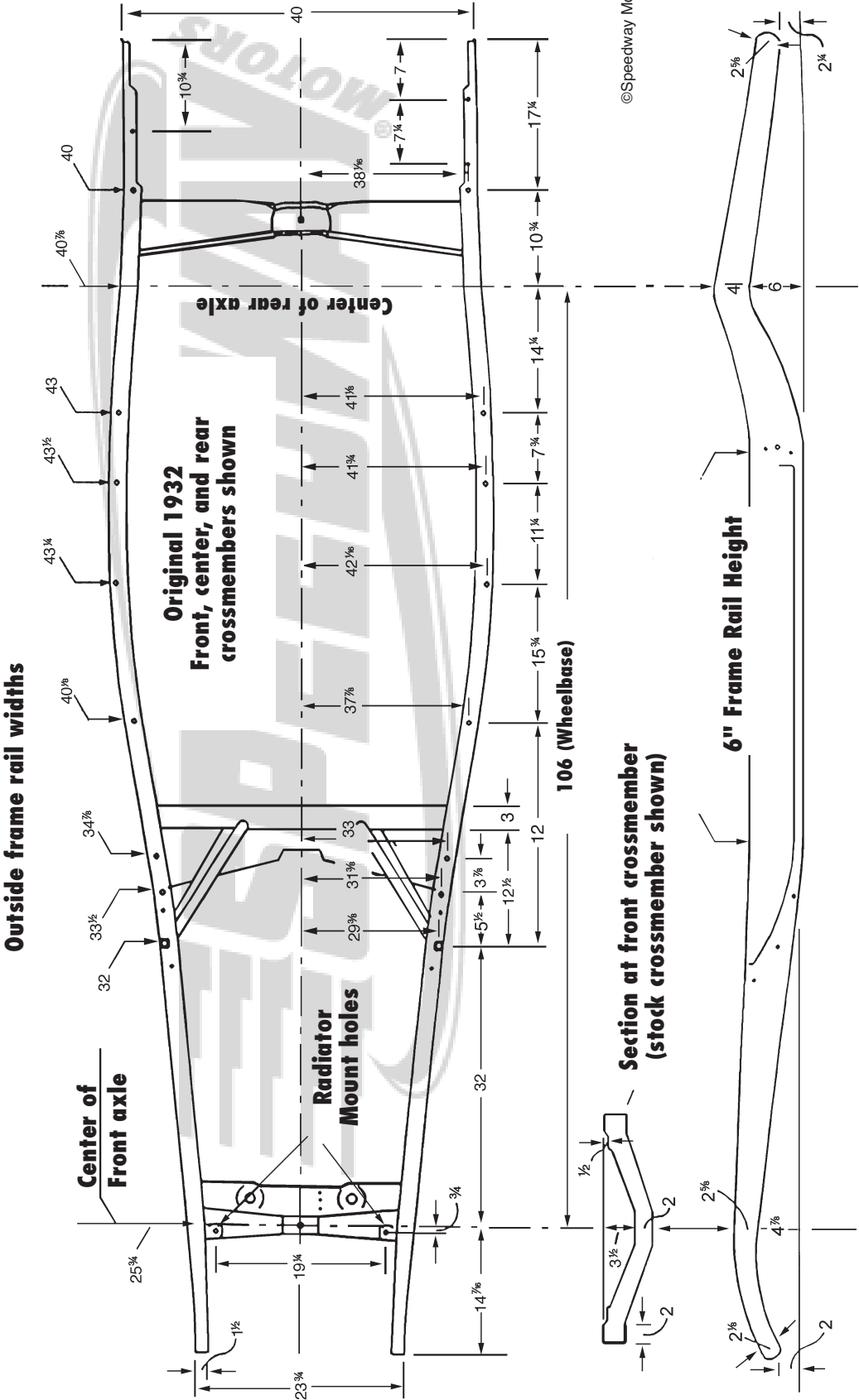
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# INSTRUCTIONS

## 32 FORD FRAME/RAILS 916-57007

1932 Ford Frame  
Diagram only    Measurements in Inches  
Passenger cars and Pickups use same frame

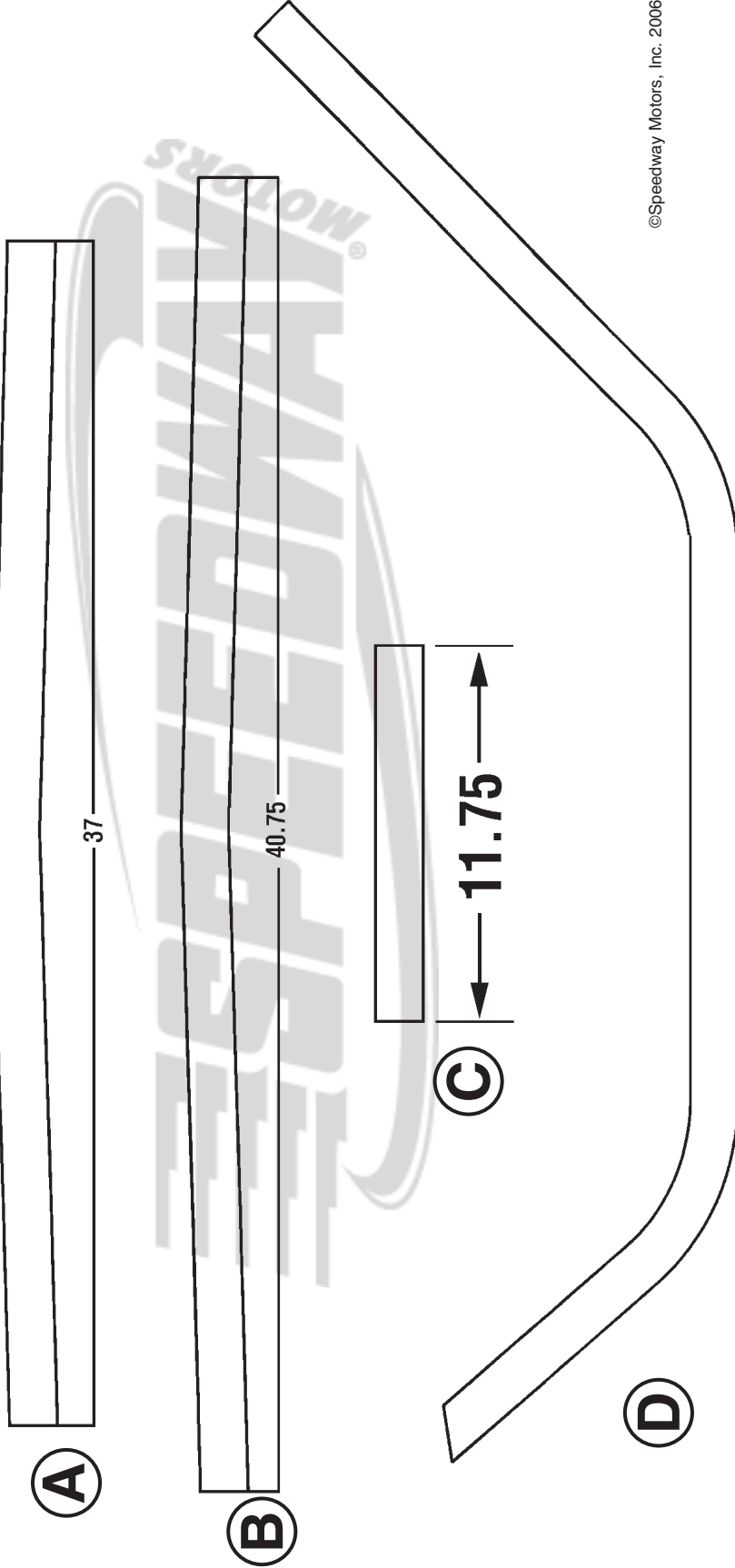


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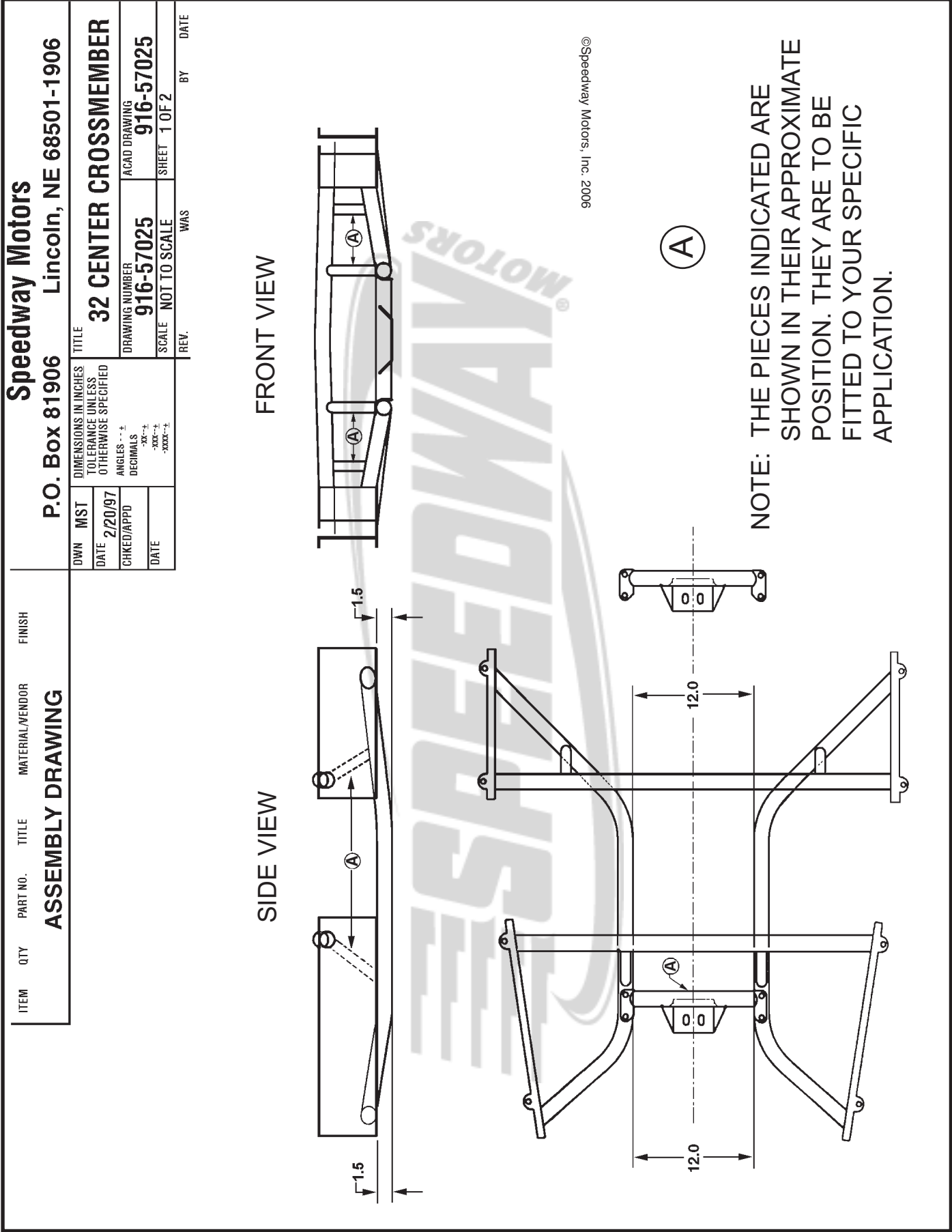
P.O. Box 81906 Lincoln, NE 68501-1906

|           |         |                                                                                                                              |                |                       |              |           |
|-----------|---------|------------------------------------------------------------------------------------------------------------------------------|----------------|-----------------------|--------------|-----------|
| DWN       | MST     | DIMENSIONS IN INCHES<br>TOLERANCE UNLESS<br>OTHERWISE SPECIFIED<br><br>ANGLES -- ±<br>DECIMALS<br>.XX ±<br>.XXX ±<br>.XXXX ± | TITLE          | 32 CENTER CROSSMEMBER |              |           |
| DATE      | 2/20/97 |                                                                                                                              | DRAWING NUMBER | 916-57025             | ACAD DRAWING | 916-57025 |
| CHKD/APPD |         |                                                                                                                              | SCALE          | NOT TO SCALE          | SHEET        | 1 OF 2    |
| DATE      |         |                                                                                                                              |                |                       |              |           |
|           |         |                                                                                                                              | REV.           | WAS                   | BY           | DATE      |

NOTE: TUBING IS 1.5"Ø x .120 WALL ROUND  
 BENDS ARE 6" INSIDE RADIUS  
 NOTCHES ARE FOR 1.5" TUBE  
 UNLESS SPECIFIED







# IMPORTANT

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\*\*Some items are not legal for sale or use in California on pollution controlled motor vehicles. These items are legal in California for racing vehicles only which may never be used upon a highway.

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