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ASSEMBLY INSTRUCTIONS

QA1 Sub-Frame Connectors for 1970-1981 Camaro/Firebird P/N 5281

READ ALL INSTRUCTIONS CAREFULLY AND THOROUGHLY PRIOR TO STARTING INSTALLATION. PRODUCTS THAT HAVE BEEN INSTALLED ARE NOT ELIGIBLE FOR RETURN. USE THE PROPER JACKING LOCATIONS. DEATH OR SERIOUS INJURY CAN RESULT IF INSTRUCTIONS ARE NOT CORRECTLY FOLLOWED. A GOOD CHASSIS MANUAL, AVAILABLE AT YOUR LOCAL PARTS STORE, MAY ALSO AID IN YOUR INSTALLATION.

• DISCLAIMER / WARRANTY •

QA1 WARRANTS THAT THE PRODUCTS WILL BE FREE FROM DEFECTS IN MATERIAL AND WORKMANSHIP FOR ONE YEAR FROM DATE OF SALE TO THE ORIGINAL PURCHASER. QA1 MAKES NO OTHER WARRANTY OF ANY KIND, EXPRESS OR IMPLIED. QA1 SHALL HAVE NO OBLIGATION UNDER THE FOREGOING WARRANTY WHERE THE DEFECT IS THE RESULT OF IMPROPER OR ABNORMAL USE, YOUR NEGLIGENCE, VEHICLE ACCIDENT, IMPROPER OR INCORRECT INSTALLATION OR MAINTENANCE, NOR WHEN THE PRODUCT HAS BEEN REPAIRED OR ALTERED IN ANY WAY. QA1'S LIABILITY IN THE CASE OF DEFECTIVE PRODUCTS SUBJECT TO THE FOREGOING WARRANTY SHALL BE LIMITED TO THE REPAIR OR REPLACEMENT, AT QA1'S OPTION, OF THE DEFECTIVE PRODUCTS.

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TOOLS AND SUPPLIES REQUIRED

- Common hand tools
- Drive-on Lift
- Soft-backed angle grinder / sander
- C-clamps or vice grips
- Mig welder

Notes:

Weld-on subframe connectors should be installed by a professional welder with a proper wire feed or MIG welder. The installer should have an understanding of welding dissimilar metals. The subframe is formed from thin gauge sheet metal. The bracket of the QA1 subframe connectors are made from 1/8 thick hot rolled steel that has been laser cut and formed to the required shape allowing for minimum of gap.

Subframe connectors should not be installed on a vehicle with subframe damage due to accident or vehicles that have weak, unequal rate, or improper springs.

Due to high production tolerances and wear from age, some vehicles may require fitting of the subframe connectors. This may require reshaping of the vehicles floor pan or subframe, or minor grinding of the subframe connectors.

A drive-on lift is strongly recommended.

INSTALLATION INSTRUCTIONS

1. Remove the rear bolt from the front sub-frame. Pry the sub-frame down and remove the rear factory bushing and replace it with a solid bushing.
2. Remove bolts that retain the fluid lines to the chassis at the rear sub-frame in the area of the front eye of the leaf springs.

3. Place sub-frame connector in place (#25-4118 on the left side of the vehicle, #25-4119 on the right side). Install the front bolt with the solid bushing in place. Install the nut plate at the rear of the vehicle into the frame opening just in front of the brake cable retaining bracket. Install the supplied 3/8" bolt with the corresponding washer and lock washer through the hole in the rear bracket into the nut plate.
4. Align the sub-frame connector for the best fit to your car's chassis and tighten the bolts. Install the 5/16" bolt with the corresponding washer and lock washer through the line retainer clip and sub-frame connector end bracket, then into frame.

Note: After you are done bolting the sub-frame connectors in place, they need to be welded and the reinforcing brackets need to be installed. Grind clean any area that will be welded. An experienced welder will understand the proper way to clamp and weld the subframe connectors to the front and rear sub-frames. Welding should be done any place the sub-frame connectors contact the sub-frame of the vehicle. The reinforcing (U-shaped) brackets are supplied to strengthen the front attachment point by wrapping around and welding to the ends of the front sub-frame.

Note: Be sure to use vise grips to clamp the sub-frame connector end brackets and reinforcing brackets tightly to the sub-frames of the vehicle while welding to ensure a solid and clean looking installation.

5. After welding has been completed you should apply some paint to the welded areas to reduce the chance of corrosion.

Note: To further upgrade your suspension, use other QA1 suspension products such as coil overs, shocks, struts, springs, torque arms, panhard rods, subframe connectors, strut tower braces, rod ends, spherical bearings, etc. For more information, go to our website at WWW.QA1.NET