

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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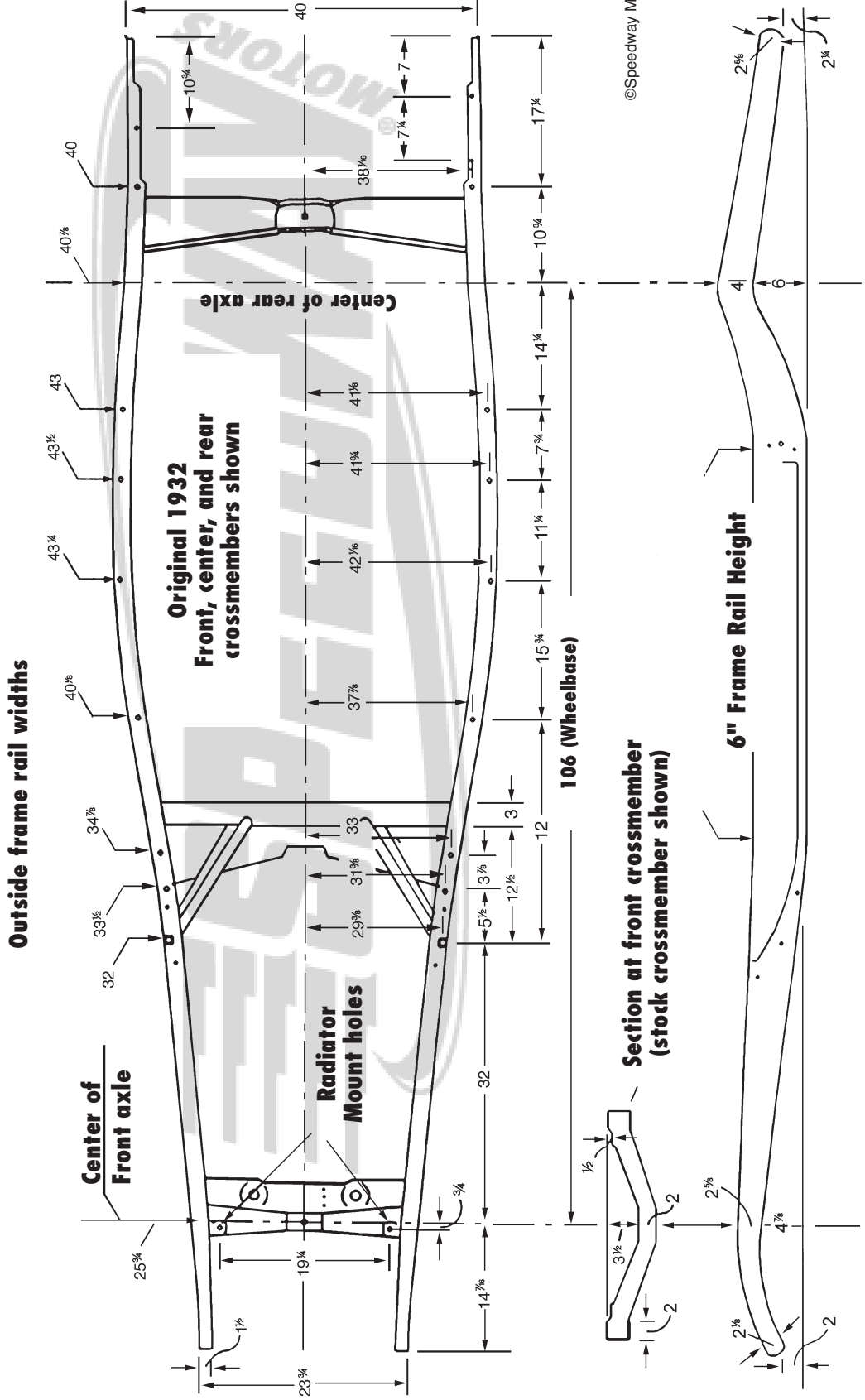


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INSTRUCTIONS

32 FORD FRAME/RAILS 916-57007

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

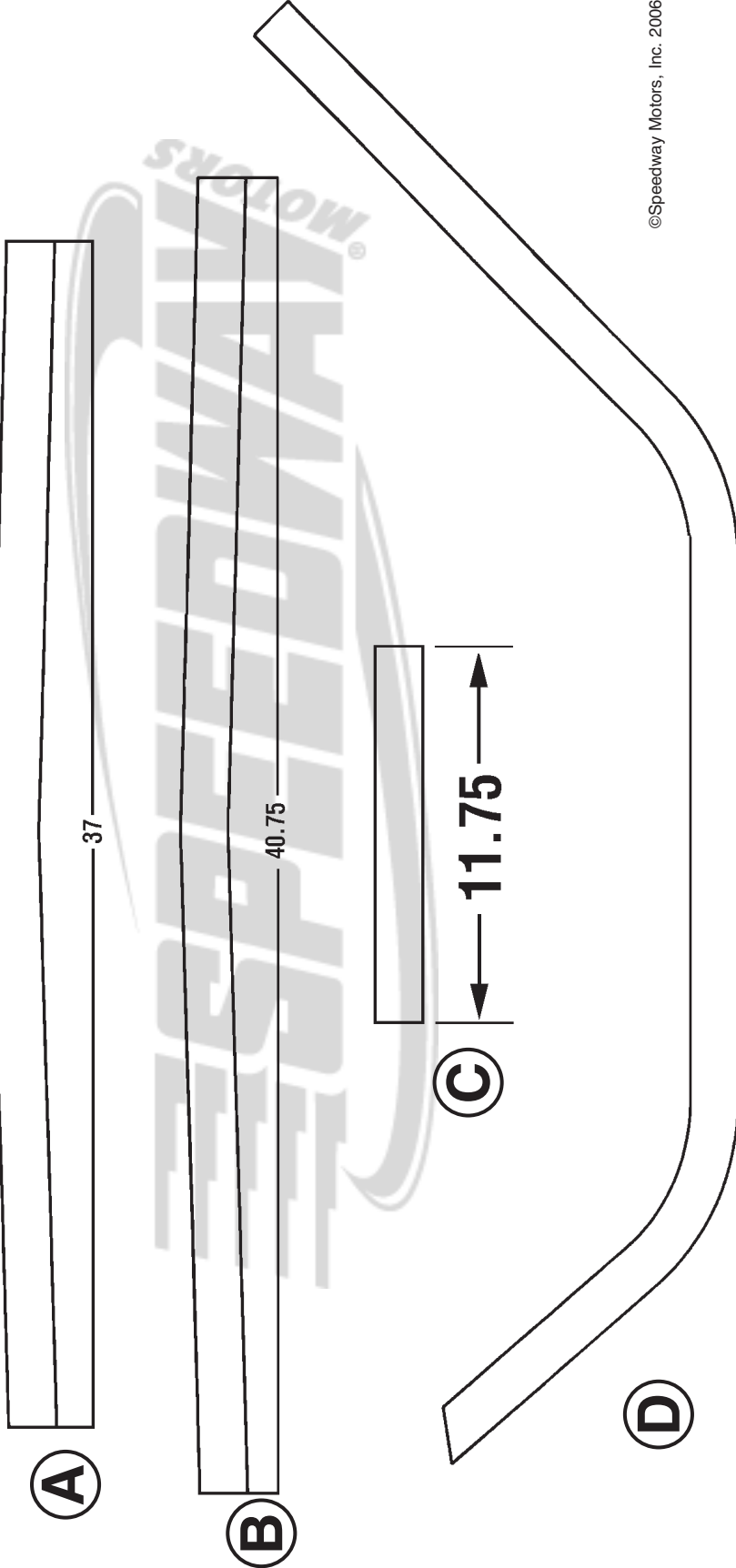


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DWN	MST	DIMENSIONS IN INCHES	TITLE
DATE	2/20/97	TOLERANCE UNLESS OTHERWISE SPECIFIED	32 CENTER CROSSMEMBER
CHKD/APPD		ANGLES -- +	DRAWING NUMBER
DATE		DECIMALS -XX-+ -XXX-+ -XXXX-+	916-57025
			ACAD DRAWING
		SCALE NOT TO SCALE	916-57025
		REV.	SHEET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

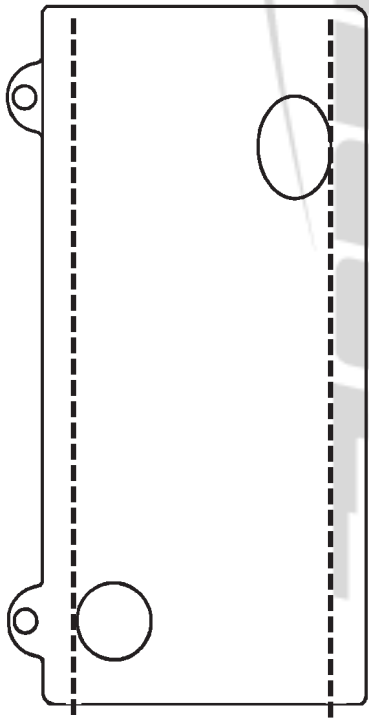


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G	2	916-57025	REAR PLATE	11 GA HRS
H	2	916-57025	FRONT PLATE	11 GA HRS
J	2	916-57025	MOUNT EAR	11 GA HRS
	1	916-57025	TRANS. MOUNT	11 GA HRS

DWN	MST	TITLE
DATE	2/20/97	32 CENTER CROSSMEMBER
CHKD/APPD		DRAWING NUMBER
DATE		916-57025
		ACAD DRAWING
		916-57025
		SCALE
		NOT TO SCALE
REV.	WAS	SHEET 2 OF 2
	BY	DATE



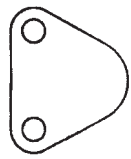
G



J



H



I



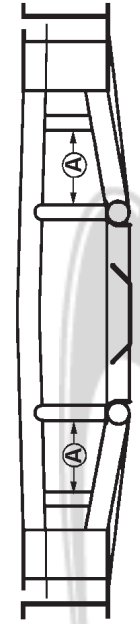
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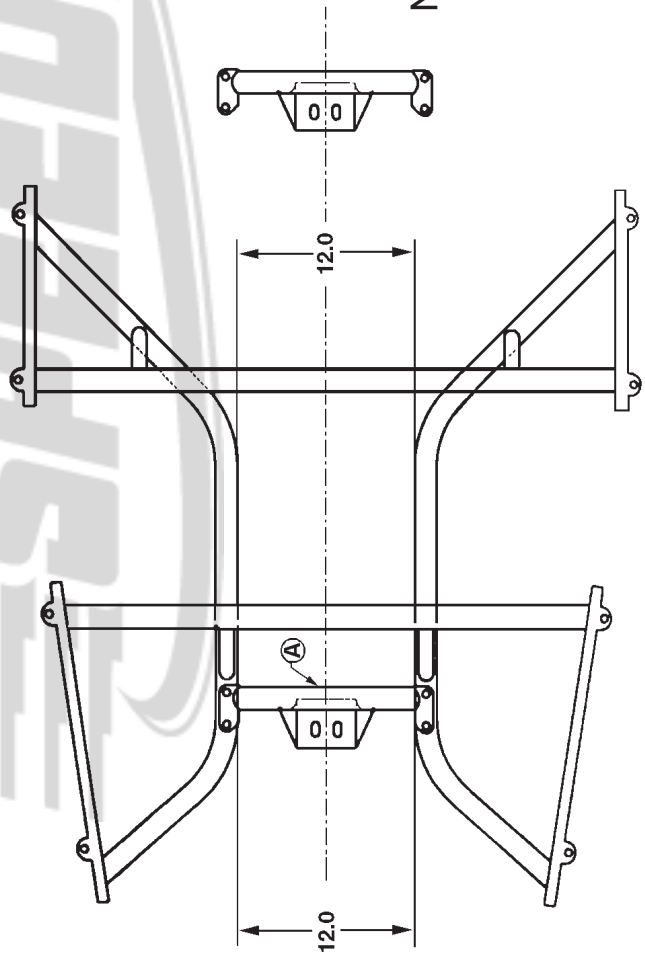
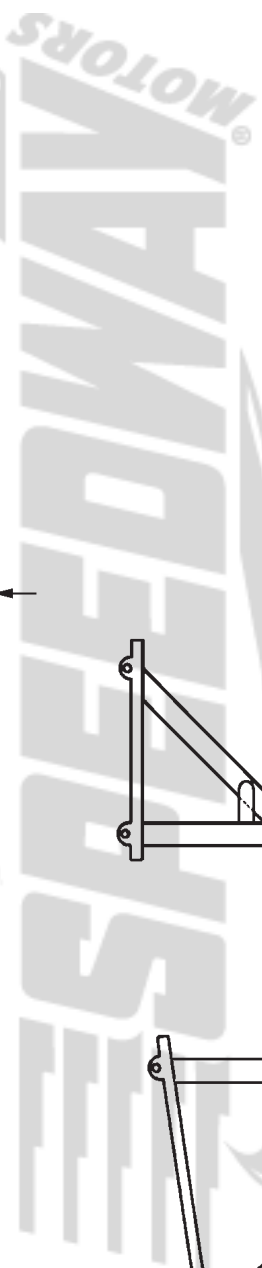
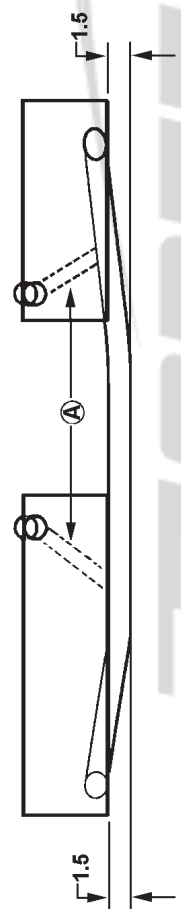
ITEM QTY PART NO. TITLE MATERIAL/VENDOR FINISH
ASSEMBLY DRAWING

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

FRONT VIEW



SIDE VIEW



(A)

NOTE: THE PIECES INDICATED ARE SHOWN IN THEIR APPROXIMATE POSITION. THEY ARE TO BE FITTED TO YOUR SPECIFIC APPLICATION.

IMPORTANT

DISCLAIMER In an effort to offer our customers the low prices, quick service and great value, Speedway Motors reserves the right to change suppliers, specifications, colors, prices, materials. Each of the previous items is subject to change without notice. Speedway is not responsible for any typographical errors or misinterpretations. Quantities are limited on some items.

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DAMAGE CLAIMS Always inspect your package upon delivery. Inspect all packages in the presence of the delivery driver. The driver must note any damage. Ask the driver the Carrier's procedures for handling damage claims. You must hold the original box, packing material and damaged merchandise for inspection or the carrier will not honor the claim. Notify Speedway Motors customer service department for instructions on returning damaged goods. Speedway is not responsible if no notification is given within 5 days of receipt.

SHORTAGES Always check the contents of your delivery to insure all the parts that you ordered were received. Please read the invoice. Double check all packing materials, small items may be wrapped inside with these products. Shortages may occur from damage to the box, so save all packing materials. Inspect the box for holes that would allow parts to fall out. If you are missing any item(s) be sure to check your invoice for back orders or canceled items before calling the customer service department. If Speedway has to split a shipment into multiple boxes, packages may be delivered on different days. You need to contact the customer service department within 5 days of delivery to assure the prompt replacement. Speedway Motors assumes no liability after this period.

REFUSALS All refused COD customers will be billed a 15% restocking charge plus freight to and from the destination! If you have questions please contact Speedway's customer service department.

WARRANTY CLAIMS If an item has a manufacturer's warranty as being free from defects we will exchange only. If the item has been used and you are requesting warranty work, this may take up to 30 days as warranty work is done by the manufacturer NOT Speedway Motors. If you have any questions please contact customer service.

RETURNS Speedway wants you to be satisfied with your purchase. If within 30 days after you receive your shipment you are not satisfied, you may return the item for refund or exchange. All exchanged or returned merchandise must be in original factory condition with no modifications or alterations. Returned merchandise must include all packaging materials, warranty cards, manuals, and accessories. If the items being returned need to be repackaged there will be a re-packing charge. Re-pack the item in a sturdy box and include a copy of your invoice and complete the form on the back of the invoice. You must ship orders back **PRE-PAID. WE DO NOT ACCEPT COD SHIPMENTS.** All exchanges need to have reshipping charges included. Items that are returned after 30 days are subject to 15% restocking charges. All fiberglass returned will have 15% restocking charge. No returns on electrical parts, video tapes, and books. Absolutely no returns on special order or close out merchandise.

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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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