

FRONT SUSPENSION CROSS MEMBER INSTALLATION 47-55 CHEVY/GMC

Before starting installation of cross member. You should first remove front sheet metal, engine, transmission, stock steering box and column, and old front suspension.

Make sure the area of frame you are going to be working is clear of any wiring, brake, transmission and FUEL lines. You also want to clean frame at this time.

1. Set truck up on jack stands so frame is as level as possible. Visually inspect the frame for cracks or other damage and repair at this time. Diagonally measure the frame to check straightness.
2. The lower frame rails need to be trimmed back to 2 in. (measured from inside of frame. Use a piece of 2 in. strap to mark frame) Reference FIG. 1
NOTE: Width of frame rail may vary some and may need to be trimmed, check rail top and bottom, The inside dimension should be 2 in. Reference FIG. 1.
3. Using supplied template mark axle centerline and rack and pinion C-Notch. Use a straight edge to mark C-Notch on the bottom side of frame. When both sides of frame are marked lay a straight edge on top of frame over both axle centerlines and transfer marks to top of frame. Reference FIG. 2.
4. Cut out C-Notch both sides. Then grind inside edge of frame to bare metal.
5. Trail fit cross member to frame, boxing plates should fit corner to corner Reference FIG. 3. It may be necessary to fit frame rails to cross member. This is done by bending upper or lower rail up or down with a large adjustable wrench or hammer until proper fit is achieved.
6. Install crossmember in frame so small notches in top of boxing plate line up with axle centerline marks. When everything lines up properly C-Clamp boxing plates snugly to frame. Tack weld boxing plates to frame. Re-check frame dimensionally and weld boxing plates to frame rails.
7. Grind and sand your welds flat to frame and boxing plates.
8. Trail fit spring pockets to frame they should be level at slotted holes and equal distance from ground to shock hole. Reference FIG. 4.
9. V-out joint between cross member and spring pocket for weld. Reference FIG. 5. Sand to bare metal all areas were spring pocket is to be welded to frame.
10. Position spring pockets and tack weld in place. Check as in step 8, If everything checks out weld to frame. Weld tab inside spring pocket to frame, Reference FIG. 4.

With all steps completed finish frame to your taste. When assembling front suspension always use caution when installing springs.

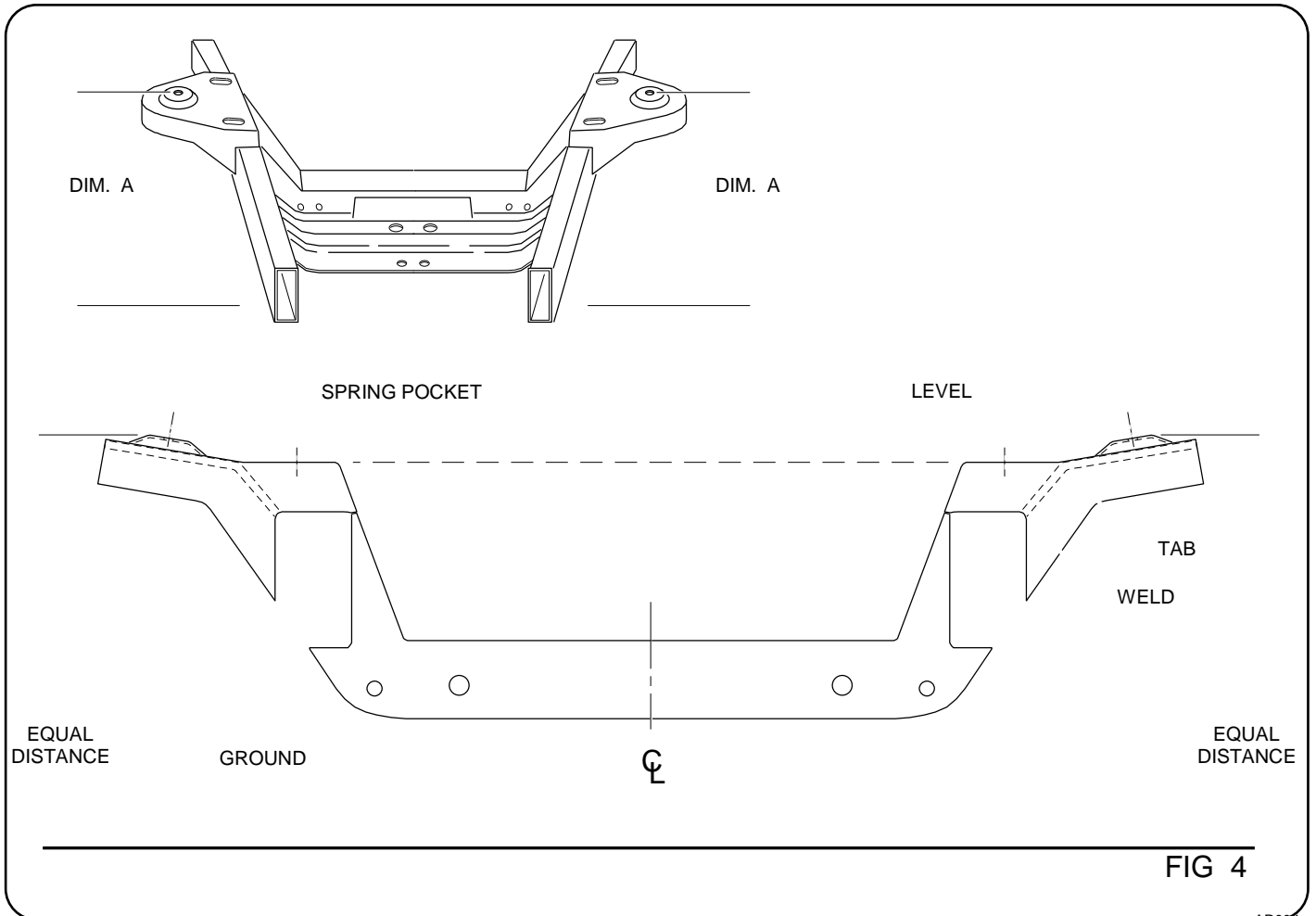
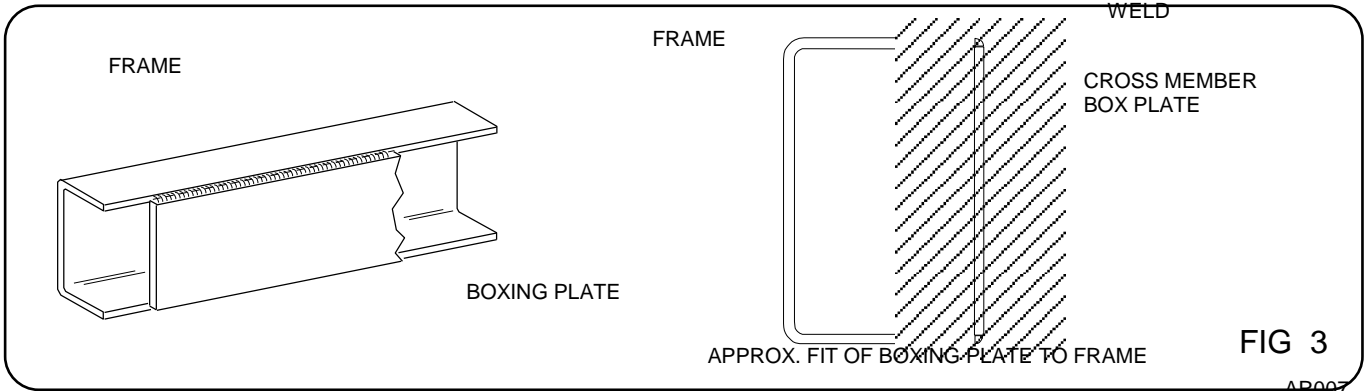
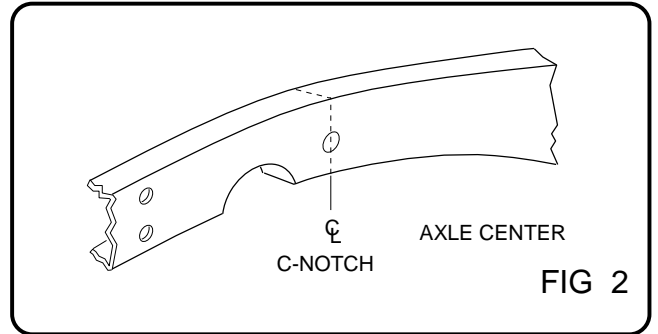
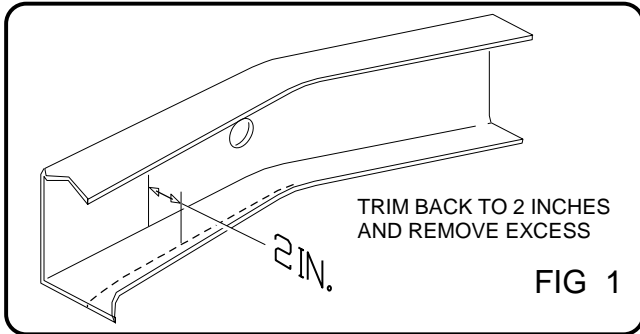


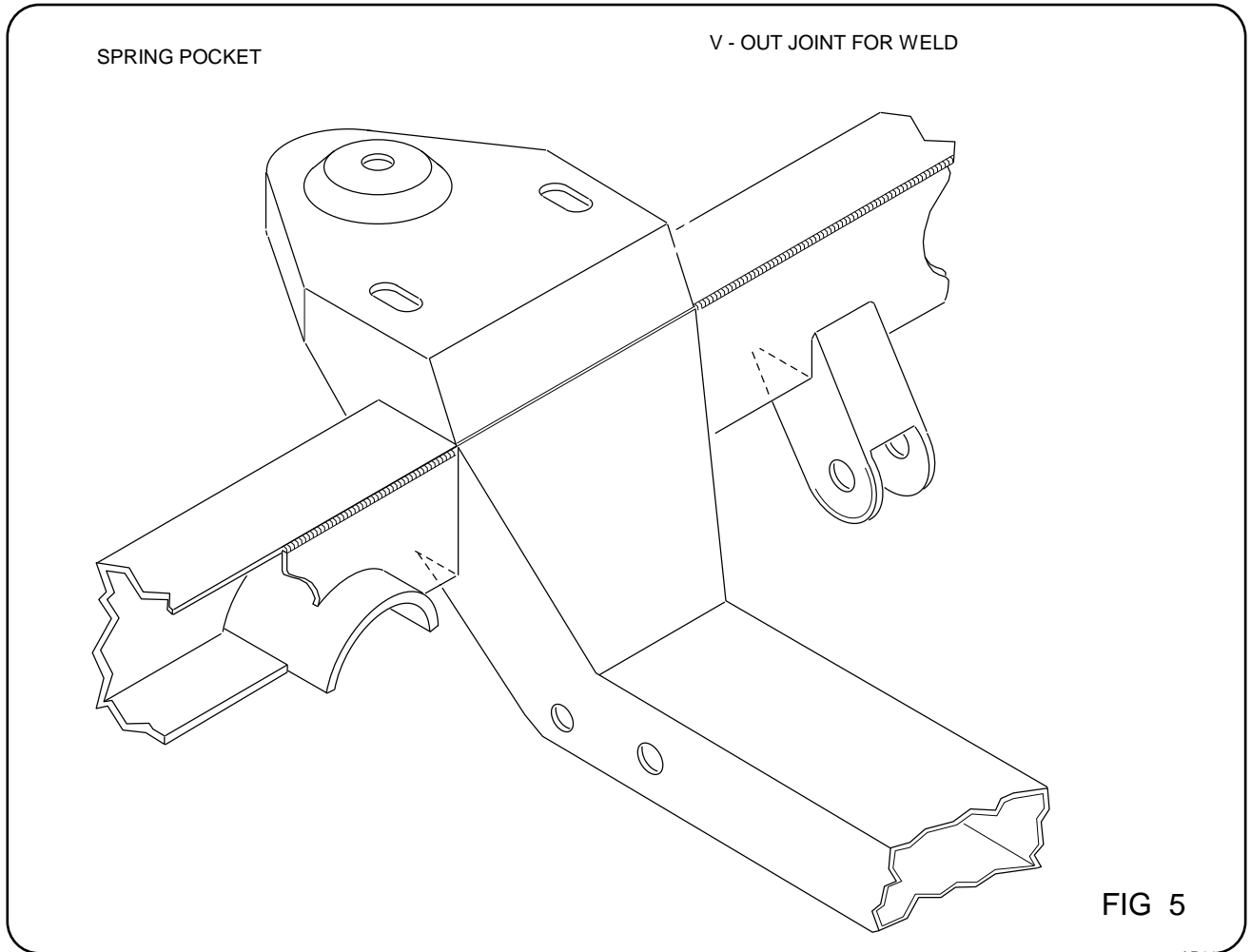
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