



1949 - 51 Mercury IFS Subframe Assembly Installation Instructions

1. Set frame up on jack stands, leveling it front to rear as well as side to side. Measure and record height of the top of the radiator support mount off of the floor and the distance from the centerline of the spindles (**this is very important**).
2. Remove all front sheet metal, bumper, radiator, engine and transmission.
3. Put a straight edge across the ends of the front frame horns, then measure back **26"** from straight edge to tops of both frame rails and mark frame at that point. Put straight edge across both frame rails and line up with your marks. Now draw lines across both frame rails at that point. Next use a level and extend your lines down both outside and inside of both frame rails.
4. Put a floor jack under the front crossmember to support it. Now cut frame off on your lines using a sawsall or cutoff tool. Remove original front end.
5. Install new subframe, sliding it in with the two overlapping plates going on the inside of the original frame rails. Line the holes on the overlapping plates with the existing holes in the original frame rails. Install bolts in each side. Raise front of subframe until the tops of the frame rails are level.
6. Check radiator support height and distance from spindle centerline (CL of new crossmember) to make sure it is the same as you recorded in step 1. Your radiator support is only tacked in place. Once positioned, tack in place again. Level subframe from side to side.
7. Double check all measurements, then tack weld subframe to existing frame in several places on each side. Weld slowly in place, skipping from side to side to prevent warpage. Also finish weld radiator support crossmember.
8. Install a-arms on crossmember. Install coil springs and shocks on lower a-arms and on upper mounts on crossmember.
9. Install spindles on a-arms.
10. Install rack and pinion on crossmember, install tie rod ends on rack. Bolt tie rod ends to spindles from underneath.



11. Pack wheel bearings with grease, then install caliper mounting brackets and rotors on spindles. Next, install calipers on brackets. There is a right and left caliper, just remember that when mounted the bleeder screw on the calipers must be up.
12. Grease ball joints.
13. Install motor mounts, front suspension, engine / transmission and steering shaft.
14. Reinstall sheet metal, trimming inner fenders to clear a-arms if needed. Install radiator and bumper.

If you have any questions, call before proceeding. Thank you for choosing Street Rod Engineering!