



## Special Instructions for 1939 – 54 Dodge, Plymouth and Chrysler Mustang II IFS Crossmember Kits Installation

### READ THESE INSTRUCTIONS COMPLETELY BEFORE STARTING!

1. Set up frame on jack stands or frame jig. Level front to rear as well as side to side.
2. VERY IMPORTANT! Measure from floor up to top of existing radiator mount and record this measurement.
3. Next measure existing wheelbase (measurement from center of rear axle to center of front spindles with wheels pointed straight ahead) and record this measurement.
4. Measure from floor up to top of front frame horns and record this measurement.
5. Measure and record outside to outside frame width at front of frame.
6. Remove shaded area of frame shown on drawing, making sure to cut frame off in exactly the same place on both sides.
7. Install new frame sections as in drawing. Use 2 x 4 rectangular 3/16" wall steel. New frame rail sections should extend into existing frame at least 4". Space the new sections **26 1/2"** apart inside to inside, making sure that they are parallel and level with each other and that they are the same distance in on each side from the original frame.

**\*Note 1:** The height that you install the frame rails at up and down will determine the final ride height. With the lower control arms level (normal ride height) the centerline of the spindles will be 1" above the BOTTOM of the new frame rails. After locating the frame rail sections tack weld them in place so that they won't move.

**\*Note 2:** If you are retaining the original bumpers then you will need to re-install the original frame horns to the new frame rails. Do this using all the above measurements.

8. Next install new lower crossmember under the frame rails, centering it front to rear at the wheelbase measurement that you recorded earlier. Level it front to rear as well as side to side. Tack weld it to the new frame rails in several places. Recheck all pieces for the correct measurements as well as for level. Now weld new frame rails to insides of existing frame in as many places as are accessible.



## Special Instructions for 1939 – 54 Dodge, Plymouth and Chrysler Mustang II IFS Crossmember Kits Installation

### **READ THESE INSTRUCTIONS COMPLETELY BEFORE STARTING!**

9. Cut pie shaped notches in the original frame where it meets the new frame rails and squeeze original rails into meet new frame rails.
10. Weld old frame and new rails together. Welding slowly and skipping from side to side to prevent warpage.
11. Drill or burn a  $\frac{3}{4}$ " hole on each side of the original frame 2  $\frac{1}{2}$ " back from the end of the cutoff, centering top to bottom. Plug weld these holes the new inner frame rails to the old outer frame rails filling the holes completely.
12. Next weld the lower crossmember to the new frame rails completely.
13. Now follow the rest of the included standard Mustang II instructions to complete the installation.

Thank you for choosing Street Rod Engineering!