

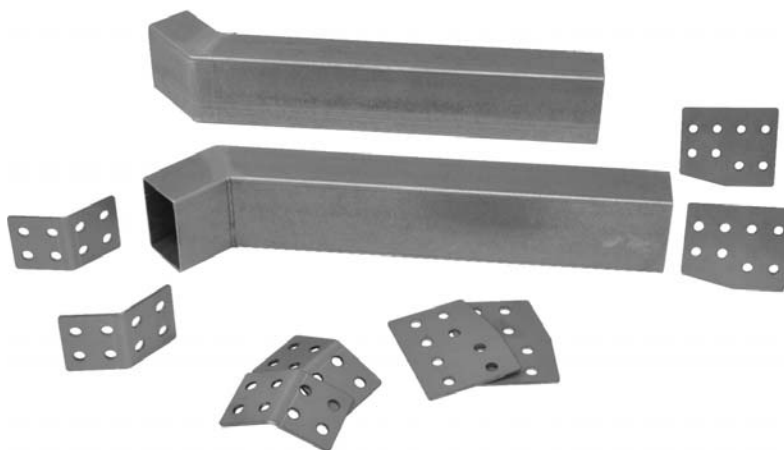
READ ALL INSTRUCTIONS COMPLETELY AND THOROUGHLY UNDERSTAND THEM BEFORE DOING ANYTHING.
CALL CHASSISWORKS TECH SUPPORT (916) 388-0288 IF YOU NEED ASSISTANCE.

INSTALLATION GUIDE



5913-M10-CAP

Frame Rail Insert Set for '64-70 Mustang
with 2" Mini-Tub Inner Wheel Housings



Description: Mini-tub frame rail insert for '64-70 Mustang. Includes rear frame rail insert sections with front and rear doubler gusset plates.

Applications: 1964-70 Mustang

Maximum tire size (with narrowed rear suspension):

1964-66 Mustang - 295 section width on 9.5" wide wheel

1967-70 Mustang - 335 section width on 12" wide wheel

PARTS LIST

5913-M10-CAP - Frame Rail Insert Set for 1964-70 Mustang 2" Mini Wheel Tubs

Qty	Part Number	Description
2	7957-0009	Rear frame rail insert for '64-70 Mustang
4	7957-0010	Rear doubler plate for '64-70 Mustang frame rail insert
4	7957-0011	Front doubler plate for '64-70 Mustang frame rail insert

INSTRUCTIONS

Install frame rail inserts one at a time to avoid chassis distortion.

1. Remove the OEM travel bumpers and brackets from each rear frame rail.
2. Reference measurements will be taken from the forward edge of the rear leaf-spring-shackle bushing.
3. Measure and mark the outside of the frame rail at 12" and again at 29" forward of the shackle bushing.
4. Extend the lines, perpendicular to the trunk floor, to the full height of the frame rail. These are reference marks for cutting and removing the section of frame rail between them.
5. Using a cutoff wheel, cut the frame approximately 1/4" to the inside of each marked line to allow final trimming during installation of the box frame section.
6. Remove the complete frame rail between the cuts, including the flanges welded to the floor.
7. Position the frame rail insert into the cutout area by trimming the OEM frame to fit. The OEM frame will need to be trimmed at an angle to accommodate the new frame rail insert. The frame rail inserts should be parallel to each other and the centerline of the car. They do not run at an angle like the OEM rails.
8. The OEM frame rail, forward of the cutout, is taller than the new frame rail insert. Pie-cut notches must be made in the lower side walls of the OEM rail to allow the bottom of the rail to taper upward.
9. Once the new rail insert is correctly fitted, clean the floor and frame of all rust and paint-and-body filler in the areas you will be welding.
10. Place the frame rail insert into the correct position, parallel to the vehicle centerline, and weld it securely.
11. Grind the welds on the sides of the frame to make the joint flat for the doubler plates.
12. Weld the bent doubler plates over the rear frame rail insert seam; one on the inside, one on the outside.
13. Weld inside the doubler-plate plug holes to strengthen the joint.
14. Position the flat doubler plates over the front seam. You may have to trim the bottom of the plates to fit correctly before welding in place on each side of the frame.
15. Weld inside the doubler-plate plug holes to strengthen the joint.
16. Repeat procedure on the opposite side of the vehicle.

Notes:

WARRANTY NOTICE:

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Chris Alston's Chassisworks
8661 Younger Creek Drive
Sacramento, CA 95828
Phone: 916-388-0288
Technical Support: sales@cachassisworks.com

