

## 6220

### INSTRUCTIONS FOR LADDER BAR CROSSMEMBER 5 3/4 HOLES

<u>ITEM</u>	<u>QTY</u>	<u>PART NO.</u>	<u>DESCRIPTION</u>
1	1	4931	Crossmember 3" drop round
2	4	2739	Crossmember front mount 5 3/4" holes
3	1	2005	Gusset material 1/8 x 2-20 makes 2

Crossmember is designed to weld between frame rails. The dropped portion can point up or down to clear driveshaft.

This is the proper crossmember kit for ladder bars with 5/8" bore front rod ends. Use adapter bushings and bolts (#6203) to complete the installation. The use of these adapters will allow you to tighten the front ladder bar bolt and still have the ladder bar pivot freely.

Pro Street ladder bars use Bolt set #6240. It consists of the proper length 3/4" bolts and locknuts.

1. Use the following procedure to position the crossmember correctly. Position the rear end in the car with jack stands so the wheel base and pinion angles are correct. Assemble the ladder bars per their instructions. Cut the crossmember to length to fit between your frame rails. Position the drop so it is centered on the driveshaft. Weld the front mount brackets to the crossmember. The ladder bars should be as wide as possible without hitting the frame, minimum clearance is 3/4" per side. Use the 1/8 x 2 material to gusset the top and front of the brackets. The brackets inner width should be .90 for adjustable ladder bars and 1.68 for pro street bars. Bolt the ladder bars to the front crossmember.

2. Put the ladder bars and crossmember under the car. Position the assembly so the ladder bars are on the housing in the correct location. Position the crossmember between the rails with the bracket rotation so the lower holes are closer to the housing. This will allow you to change the ladder bar setting without affecting the wheelbase length. Tack the ladder bars to the axle housing and tack the crossmember to the frame.

3. Move the rear end up and down through its travel to make sure everything clears. Move the ladder bars to other holes to make sure you have the rotation of the front bracket correct. If everything is okay, weld it up.

4. The final step is to gusset the front crossmember bracket to the frame. This must be done or the torque will twist the front mount. Weld a piece of 1 1/4 tube (not supplied) to the bottom of the crossmember bracket. It must extend forward about 18" and attach to the side of the frame. Do this on each side.

Revision Date: August 16, 2011

