

INSTALLATION GUIDE



6718

g-Bar Upper Axle Bracket Weld Fixture



Description: Bolt-on fixture for welding g-Bar upper axle brackets onto GM 10-bolt rearend housings. For use with all g-Bar and g-Link rear suspension systems for 1967-69 Camaro and Firebird, and 1968-74 Nova.

Note: Fixture can be configured for welding with the stock-housing cover plate installed or removed. Can be used with 8.2"- and 8.5"-diameter ring gear housings.

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PARTS LIST

6718 - g-Bar Weld Fixture, GM 10-Bolt

Qty	Part Number	Description
2	1480	Bracket locator block for g-Bar upper link
1	230277	Mounting plate, upper axle bracket weld fixture
3	3100-031C1.25Y	Bolt 5/16-18 x 1-1/4 hex head, Grade 8
4	3105-038C1.00B	Flat head 3/8-16 x 1" flat head cap screw, black oxide
6	D09.120-000.250	Spacer 9/16 x .120 DOM x .250

INSTRUCTIONS

This fixture correctly locates the g-Bar upper axle brackets for welding to a standard GM 12-bolt rear end housing. It has been designed for bolt-on use with or without the factory-style, sheet-metal rear cover plate installed on the housing. Aftermarket aluminum cover plates must be removed. Photos illustrate installation with the housing cover plate installed.

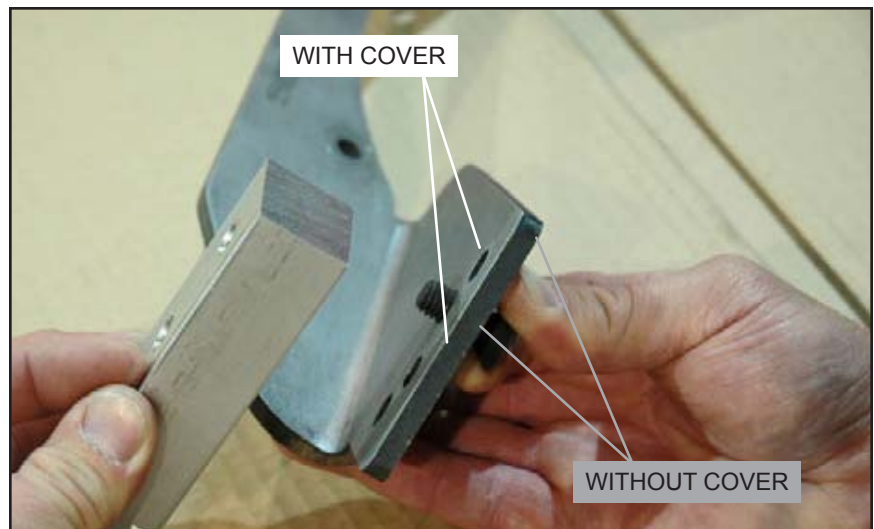
1. Secure the bracket locating blocks to the mount plate using 3/8" flat head cap screws. The tapered body of the flat head cap screw aligns the block as each screw is tightened. The block's notch must face toward the mount plate. There are two sets of holes in the mount plate.

Cover Plate INSTALLED:

Use the forward set of holes.

Cover Plate REMOVED:

Use the rear set of holes.



2. Slide the g-bar driver-side upper axle bracket (230258) over the driver-side block. The rear of the bracket will line up with the notch in the mount block.
3. Use a 1/2" bolt to hold the upper-arm bracket in place. Do not install the nuts on the bolts until the assembly is in place on the rearend housing.



4. Repeat the above for the passenger side using bracket #230259.
5. The fixture is ready to install onto the housing.



6. Bolt the fixture onto the housing.

8.2" Ring-Gear

Cover Plate INSTALLED:

Use the two 1/4" spacers stacked together between the cover plate and the fixture.

8.2" Ring-Gear

Cover Plate REMOVED:

Bolt the fixture directly against the bare housing. **DO NOT USE SPACERS.**

8.5" Ring-Gear - with or without cover plate installed:

Use the three 1/4" spacers stacked together between the cover plate and the fixture.

The cover to the back of the axle tube is 7/8" on 8.5" versions and 5/8" on 8.2" versions.



7. Minor grinding on the edges of the bracket may be necessary fit the bracket tight against the axle tube.



8. Unscrew the locator blocks and clean the weld area on the axle tube and bracket using a scotch-brite drill attachment.
9. Reinstall the locator blocks and brackets. The 1/2" bolt can be tightened to securely hold the bracket.
10. Tack weld the bracket to the housing tube. The tacks need to be strong enough to finish test fitting the rear suspension.
11. Remove the fixture and continue installation of the g-Bar rear suspension.



12. After the suspension has been checked for binding or clearance issues, reinstall the weld fixture and completely weld around each bracket. Let the housing completely cool before removing the fixture.

