

# INSTALLATION GUIDE



## 6720 g-Bar Upper Axle Bracket Weld Fixture



**Description:** Bolt-on fixture for welding g-Bar upper axle brackets onto Ford 9" rearend housings. For use with all g-Bar and g-Link rear suspension systems for 1967-69 Camaro and Firebird, and 1968-74 Nova.

### WARRANTY NOTICE:

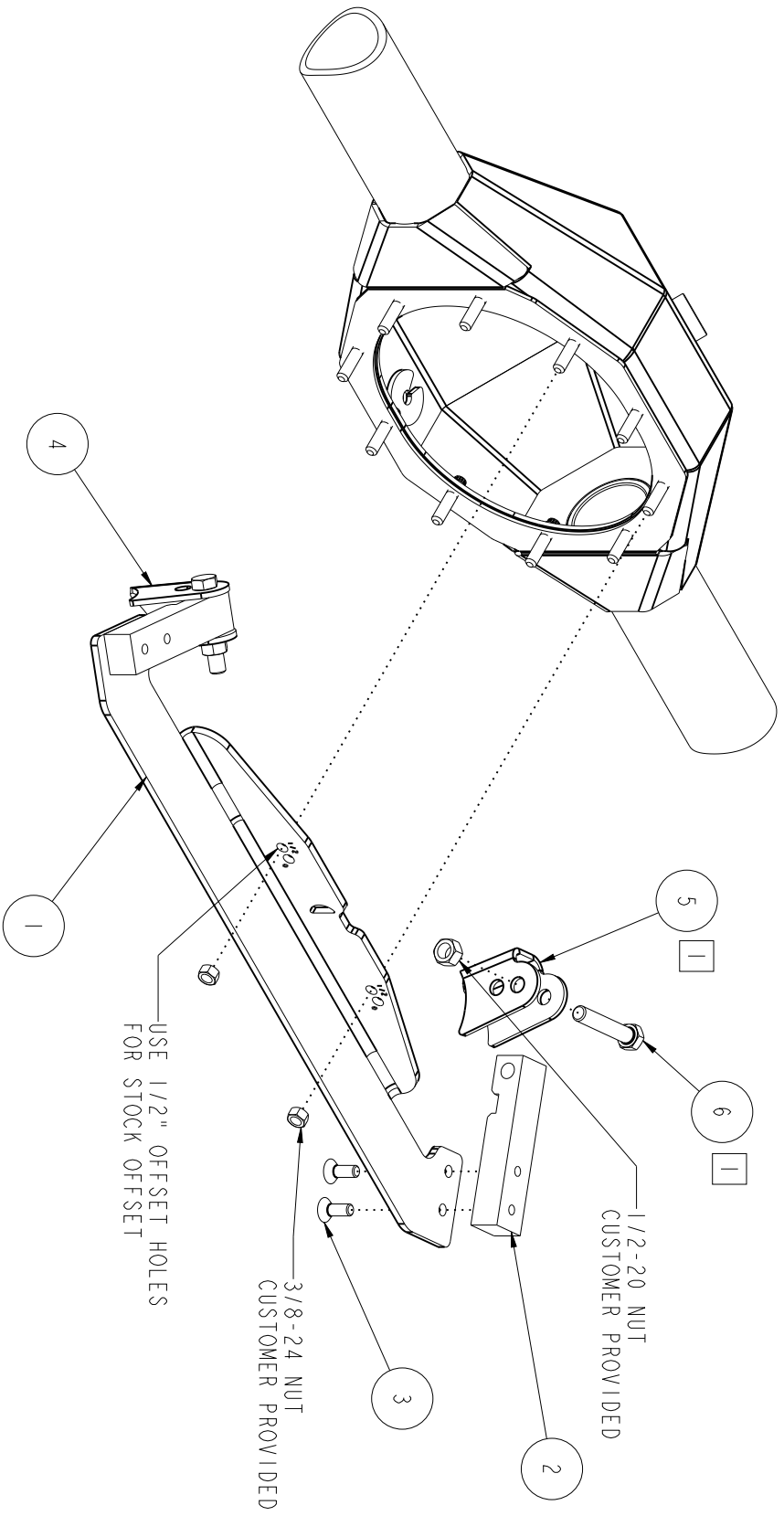
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**Figure 2-1**

ITEM	QTY	PART NO.	DESCRIPTION
1	1	230279	MOUNTING PLATE, UCA AXLE BRACKET WELD FIXTURE, G-BAR, 67-69 CAMARO
2	2	1480	BRACKET LOCATOR, UCA WELD FIXTURE, G-BAR HOUSING
3	4	3105-038C1.00B	FLAT HEAD SOCKET CAP SCREW, 3/8-16 x 1, BLACK OXIDE
4	1	230259	UCA AXLE BRACKET, PSGR, G-BAR, 67-69 CAMARO
5	1	230258	UCA AXLE BRACKET, DRIVER G-BAR, 67-69 CAMARO
6	2	3100-050F2.75Y	HEX BOLT, 1/2-20 x 2 3/4, GRADE 8, YELLOW ZINC



DESCRIPTION  
**BRACKET FIXTURE, FORD 9",  
 G-BAR UCA BRACKET, 67-69 CAMARO/68-74 NOVA**

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PART NO.  
**6720**

10/23/08 DWG: 916720

NOTES:  
 1 PART OF CONTROL ARM KIT

# PARTS LIST

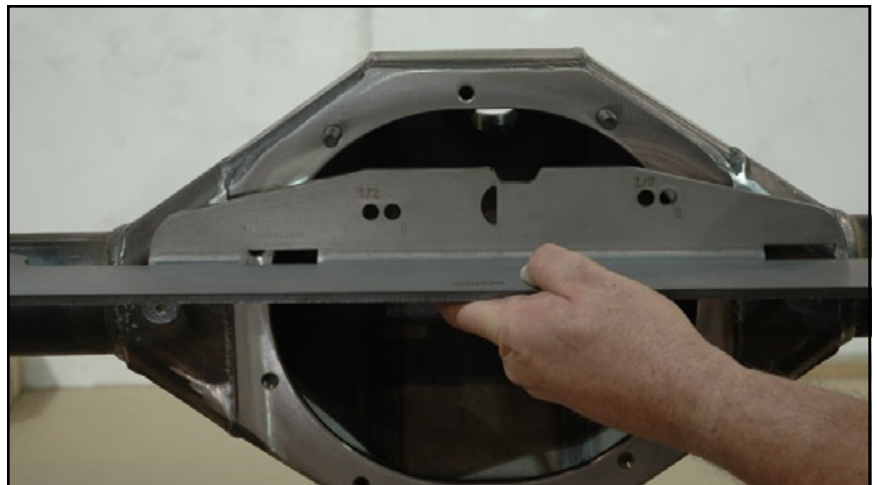
## 6720 - g-Bar Weld Fixture

Qty	Part Number	Description
2	1480	Bracket locator block for g-Bar upper link
1	230279	Mounting plate, upper axle bracket weld fixture
4	3105-038C1.00B	Flat head 3/8-16 x 1" flat head cap screw, black oxide

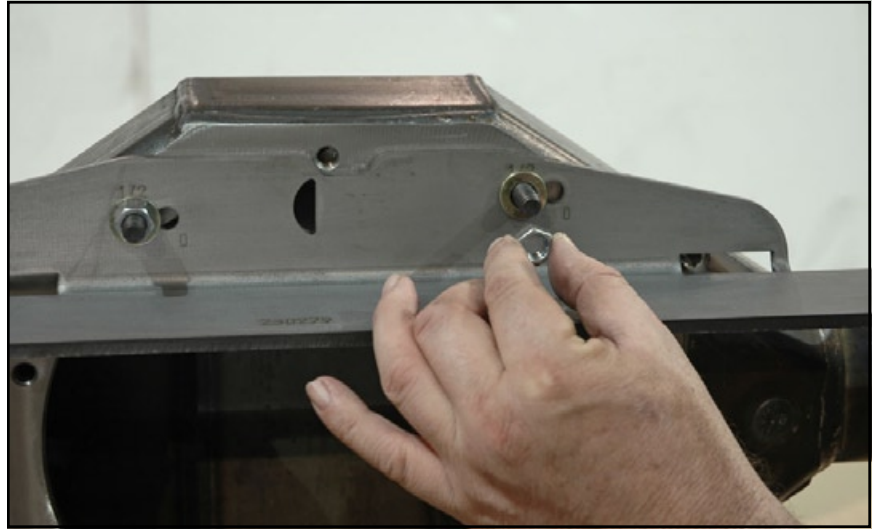
## INSTRUCTIONS

This fixture correctly locates the g-Bar upper axle brackets for welding to the rearend housing. It has been designed for bolt-on use with a standard Ford 9" bolt pattern.

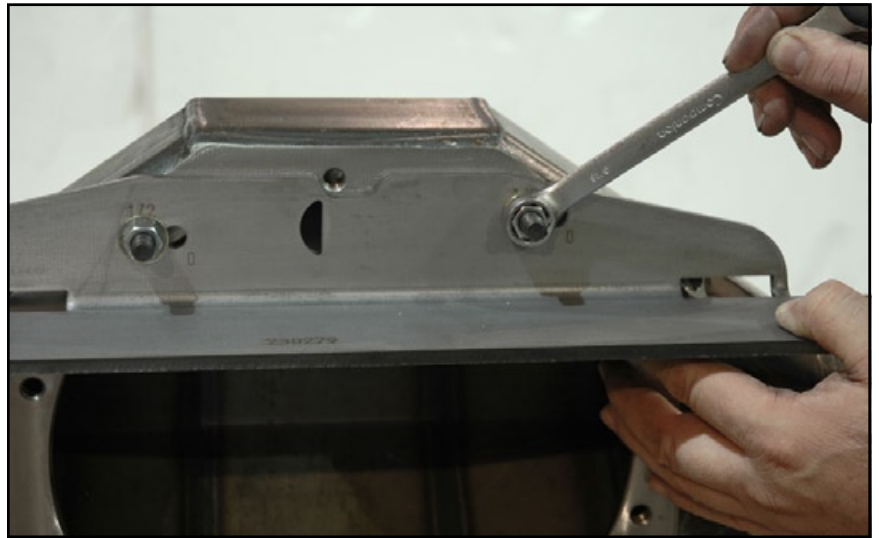
1. Remove axles from the rearend housing. Leave third-member installed for next step.
2. You must determine pinion location in relation to the axle housing ends.
3. Place a carpenter's square or straight edge against the driver-side housing end so it extends forward for easier measurement.
4. Measure from the driver-side housing end (carpenter's square) to the pinion centerline and record this dimension.
5. Repeat measurement steps for the passenger side. If both measurements are equal, the pinion has zero offset. If there is a one-inch difference in measurement, the pinion has a 1/2" offset to the passenger side.
6. Make note of the pinion offset, and then remove the third member from the rearend housing.  
Note: The 1/2" offset pinion will be most commonly found in GM 9" conversion housings.
7. Slide the mounting plate over the two upper studs using the correct set of holes based on the pinion offset calculated in the proceeding steps; zero or 1/2". With the mounting plate in the correct location, the outside end of the plate will be an equal distance from each rear housing end.



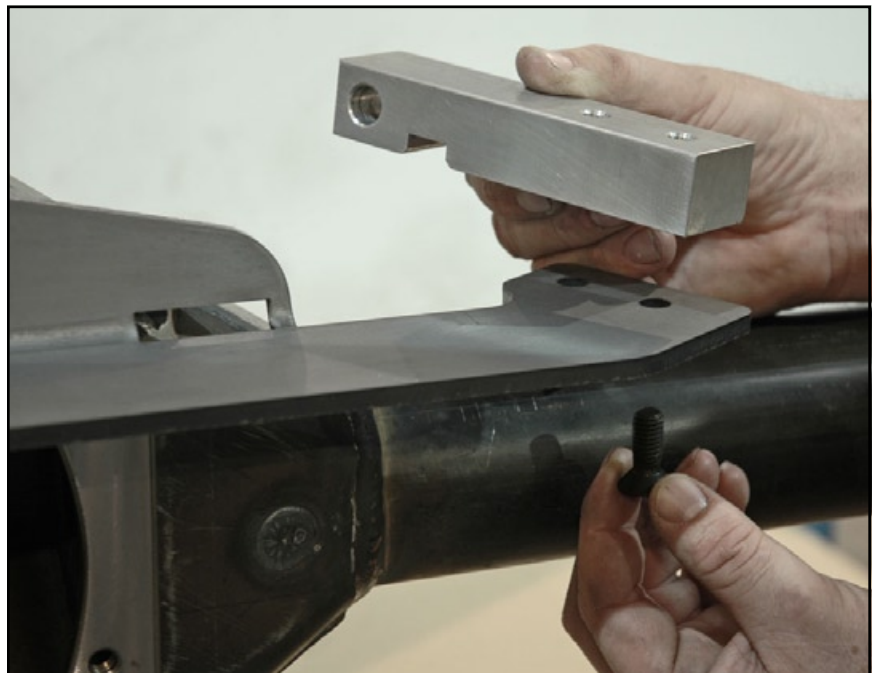
8. Thread a 3/8" nut with flat washer onto each of the two studs.



9. Tighten the nuts to securely hold the mounting plate in place.



10. 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 must point toward the rear of the housing the the notch must face downward.



11. Use a scotch-brite drill attachment to clean the weld area directly below the locater block.



12. Slide g-bar UCA axle bracket, #230258, over the driver-side block and seat against the axle tube.



13. Use one mounting bolt and locknut to secure the bracket's position with the hardware supplied in the g-Bar upper arm kit. If the bracket and locating block do not align correctly, minor grinding on the edges of the bracket may be necessary to fit the bracket tight against the axle tube.



14. Tighten the hardware to prevent the bracket from shifting.
15. Repeat steps for passenger side using axle mount # 230259.



16. Tack weld the bracket to the housing tube. The tacks need to be strong enough to finish test fitting the rear suspension.
17. Remove the fixture and continue installation of the g-Bar rear suspension.
18. 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.

