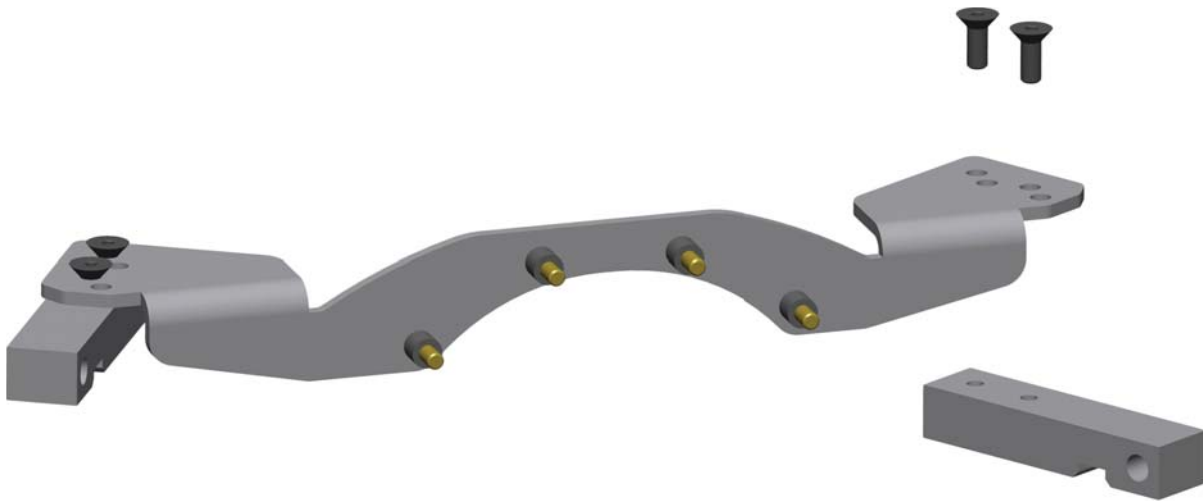


# INSTALLATION GUIDE



## 6724

**g-Bar Upper Axle Bracket Weld Fixture  
for '70-81 Camaro/Firebird with 12-Bolt Housing**



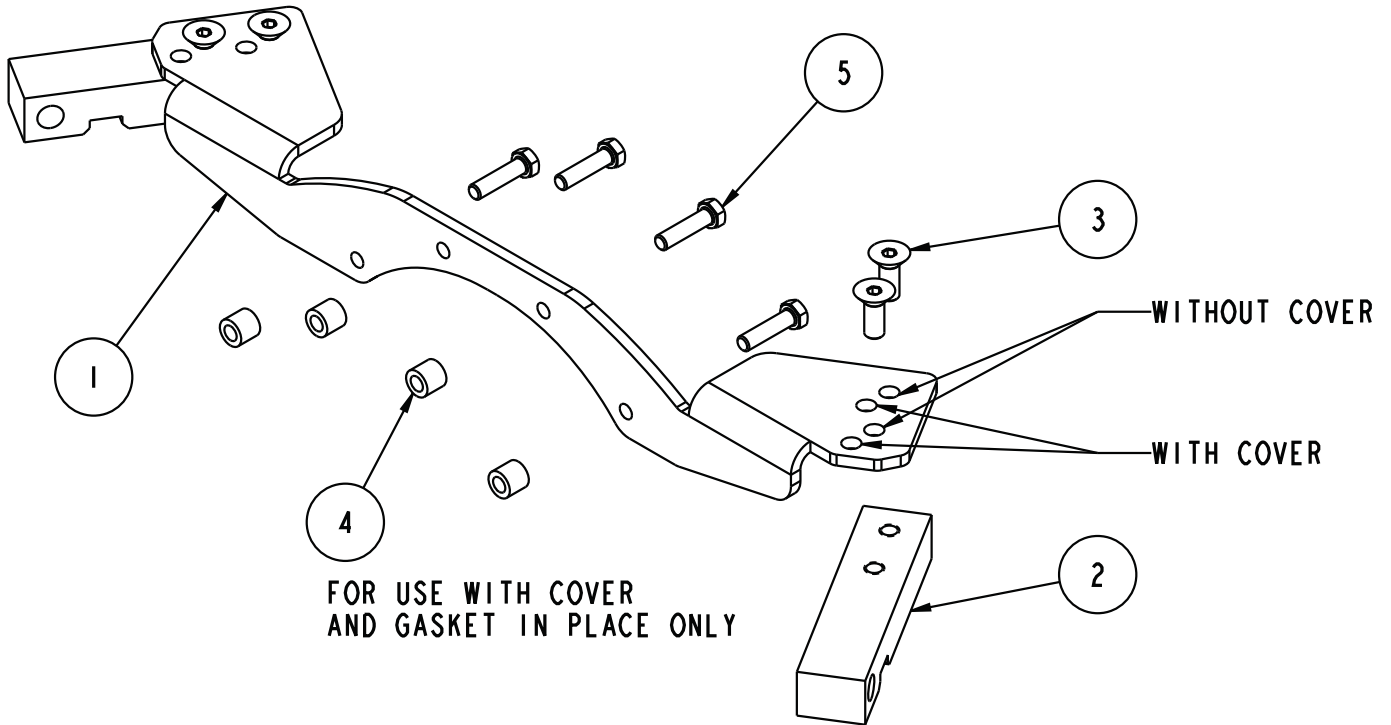
**Description:** Bolt-on fixture for welding g-Bar upper axle brackets onto GM 12-bolt rearend housings. For use with all 1970-81 Camaro and Firebird, g-Bar and g-Link rear suspension systems.

**Note:** Fixture can be configured for welding with the stock-housing cover plate installed or removed.

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REVISIONS

ZONE	REV	DESCRIPTION	DATE	APPROVED
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ITEM	QTY	PART NO.	DESCRIPTION
1	1	7959-0051	WELD FIXTURE BRACKET, UCA AXLE BRKT, G-BAR, GM 12-BOLT, 70-81 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	4	D09.120-000.500	SLEEVE, Ø 9/16 x .120 WALL x .500
5	4	3100-031C1.25Y	HEX BOLT, 5/16-18 x 1 1/4, GRADE 8, YELLOW ZINC

UNLESS OTHERWISE SPECIFIED		APPROVALS	DATE	<b>BRACKET FIXTURE, G-BAR UCA AXLE BRKT, GM 12-BOLT, 70-81 CAMARO/FIREBIRD</b>  Chris Alston's CHASSISWORKS INC. 8661 YOUNGER CREEK DRIVE SACRAMENTO, CA 95828 (916) 388-0288 FAX 388-0295
DIMENSIONS ARE IN INCHES TOLERANCES FRACTIONS ±1/16 ANGLES ±.5 DECIMAL ±.01 ±.005 ±.0010		DRAWN BY: D. HOESCHEN	1/10/11	
		CHECKED BY: S. RIEGER	1/10/11	
		DWG RELEASE LEVEL: In Work		
FINISH NONE		SIZE A	PART NO. <b>6724</b>	PART REV. 0
MATERIAL ASSEMBLY		SCALE: 1:4		DWG: 6724 REV: 0.1
SHEET 1 OF 1				

# PARTS LIST

## 6724 - g-Bar Weld Fixture, GM 12-Bolt, '70-81 Camaro/Firebird

Qty	Part Number	Description
2	1480	Bracket locator block for g-Bar upper link
4	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
1	7959-0051	Arm mount fixture plate for GM 12-bolt, '70-81 Camaro/Firebird
4	D09.120-000.500	Spacer 9/16 x .120 DOM x .500

## INSTRUCTIONS

This fixture correctly locates the g-Bar upper axle brackets for welding to a standard GM 12-bolt rearend 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.

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 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.
5. The fixture is ready to install onto the housing.
6. Bolt the fixture onto the housing.

**Cover Plate INSTALLED:**

Use the four 1/2" spacers between the cover plate and the fixture.

**Cover Plate REMOVED:**

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

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.

**WARRANTY NOTICE:**

There are **NO WARRANTIES**, either expressed or implied. Neither the seller nor manufacturer will be liable for any loss, damage or injury, direct or indirect, arising from the use or inability to determine the appropriate use of any products. Before any attempt at installation, all drawings and/or instruction sheets should be completely reviewed to determine the suitability of the product for its intended use. In this connection, the user assumes all responsibility and risk. We reserve the right to change specification without notice. Further, Chris Alston's Chassisworks, Inc., makes **NO GUARANTEE** in reference to any specific class legality of any component. **ALL PRODUCTS ARE INTENDED FOR RACING AND OFF-ROAD USE AND MAY NOT BE LEGALLY USED ON THE HIGHWAY.** The products offered for sale are true race-car components and, in all cases, require some fabrication skill. **NO PRODUCT OR SERVICE IS DESIGNED OR INTENDED TO PREVENT INJURY OR DEATH.**

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