

READ ALL INSTRUCTIONS COMPLETELY AND THOROUGHLY UNDERSTAND THEM BEFORE DOING ANYTHING.
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INSTALLATION GUIDE



6729

**g-Bar Upper Axle Bracket Weld Fixture
for '62-67 Chevy II with Ford 9" Housing**



Description: Bolt-on fixture for welding g-Bar upper axle brackets onto Ford 9" rearend housings. For use with all 1962-67 Chevy II, g-Bar and g-Link rear suspension systems.

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

Return Note: Can be returned for partial refund if within 60 days of invoice and all parts are in good condition. Cannot be returned if any part is missing. An RA number is required

PARTS LIST

6729 - g-Bar Weld Fixture, Ford 9", '62-67 Chevy II

| Qty | Part Number | Description |
|-----|----------------|--|
| 2 | 1480 | Bracket locator block for g-Bar upper link |
| 4 | 3105-038C1.00B | Flat head 3/8-16 x 1" flat head cap screw, black oxide |
| 1 | 7959-0277 | Arm mount fixture plate for Ford 9", '62-67 Chevy II |

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, but can also be used on 8" Ford housings by measuring from each housing end to the closest bracket to ensure the brackets are centered, and then clamping it to the housing face.

INSTRUCTIONS

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.
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". (Figure 2-1 shows assembly using centered pinion position.) 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. Secure the bracket locating blocks to the mount plate using 3/8" flat head cap screws.
Note: The tapered body of the flat head cap screw aligns the block as each screw is tightened.
9. Slide g-bar UCA axle bracket over the driver-side block and seat against the axle tube. The bracket's edge should fit tightly along the axle tube, with the bend corners extending vertically.
10. Use one mounting bolt and locknut to secure the bracket's orientation with the hardware supplied in the g-Bar kit. If the bracket and locating block do not align correctly, you may need to grind the bracket to better fit the axle tube.
11. Repeat steps for passenger side using axle mount.
12. Measure from the housing end to the UCA axle bracket on both sides. They must be the same distance from each housing end.
13. The brackets can now be tack-welded then measured again to verify correct positioning.

14. Weld completely around each bracket where it meets the axle tube. Leave the fixture in place until the housing is completely cooled to minimize axle tube warping from welding.
15. You can now reinstall the third-member, axles, and brakes on the rear end housing, and continue with installation of the g-Bar rear suspension system.

WARRANTY NOTICE:

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

