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INSTALLATION GUIDE



6264

LADDER-BAR X-STYLE TRACK LOCATER

Description: X-style track locator for use with Pro-Adjustable ladder bars

Includes: Billet aluminum mounting clevises, 4130 tube and tube adapters, swivel clevis mount, 4130 rod ends, and mounting hardware



WARRANTY NOTICE:

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PARTS LIST

6264 - Ladder-Bar X-Style Track Locator

Item	Qty	Part Number	Description
1	2	1486-50	Billet track-locator clevis for 1/2" ladder-bar bolt
2	2	1486-63	Billet track-locator clevis for 5/8" ladder-bar bolt
3	2	A16.083-036.000	Tube 1" OD x .083" wall x 36" long, 4130
-	1	906264.12	Hardware Bag 1 of 2
-	1	906264.22	Hardware Bag 2 of 2

906264.12 - Hardware Bag for Ladder-Bar X-Style Track Locator (1 of 2)

Item	Qty	Part Number	Description
4	8	1000	Misalignment bushing 1/2" bore x .250" long
5	4	3101-050-20C	Locknut 1/2-20 nylon insert
6	1	3102-063-18LY	Jam nut 5/8-18 LH, yellow zinc
7	3	3102-063-18RC	Jam nut 5/8-18 RH, clear zinc
8	4	3130-050F2.25B	Bolt 12-point head 1/2-20 x 2.25" long
9	1	3137-063X050-L	Rod end 5/8-18 LH x 1/2" bore
10	3	3137-063X050-R	Rod end 5/8-18 RH x 1/2" bore

906264.22 - Hardware Bag for Ladder-Bar X-Style Track Locator (2 of 2)

Item	Qty	Part Number	Description
11	1	1007	Sleeve 1-1/4" x .120" x 3" long, 4130
12	2	1126-0.830	Weld eye .830" x 3/8" hole x .25" tab
13	3	1136	Tube adapter .830" x 5/8-18 RH
14	1	1506	Tube adapter .830" x 5/8-18 LH
15	4	2732	Tab X-locator center support
16	2	3100-038F1.25Y	Bolt 3/8-24 x 1-1/4" long hex cap screw
17	2	3101-038-24C	Locknut 3/8-24 nylon insert
18	2	3122-050F2.50B	Bolt 12-point head 1/2-20 x 2.50" long
19	2	3122-063F3.00B	Bolt 12-point head 5/8-18 x 3.00" long
20	2	A20.120-000.500	Spacer 1-1/4" x .120" x .50" long, 4130

INSTRUCTIONS

The X-style locator installs onto the Pro-Adjustable ladder-bar or Battle Cruiser ladder-bar suspensions. It attaches where the ladder bar's lower tube bolts to the chassis bracket and rearend-housing bracket. The one piece straight tube runs diagonally front to rear. The locator rod can be attached in either direction.

1. The ladder-bar suspension must be completely installed with the rearend at ride height and centered in the chassis. Complete installation of only one clevis at a time to ensure the rear end housing is held securely at all times.
2. Remove the 5/8" bolt at the ladder-bar chassis mount and then mount a 5/8"-bore clevis (1486-63) using the supplied 12-point bolt and reusing the original locknut. The clevis must be inline with the ladder bar's lower tube. Torque to 70 lb. ft. Repeat for opposite side of vehicle.
3. Remove the lower 1/2" bolt at the ladder-bar rearend housing bracket and then mount a 1/2"-bore clevis (1486-50) using the supplied 12-point bolt and reusing the original locknut. The clevis must be inline with the ladder bar's lower tube. Torque to 55 lb. ft. Repeat for opposite side of vehicle.
4. The rearend must be centered between the rear frame rails before continuing. Thread one 5/8-18 left-hand jam nut onto one of the left-hand-threaded rod ends 3/4 of an inch, and then thread the left-hand tube adapter, with the hex machined on it, onto the rod end. Using the 1/2-20 x 2-1/4" 12-point bolts, locknuts and two misalignment bushings, install the rod ends between the ears of the billet locator clevis on the driver-side chassis bracket. One misalignment bushing goes on each side of the rod-end ball.
5. Repeat the procedure above using a right-hand rod end, tube adapter, and jam nut. This will go into the passenger side rear end housing bracket billet locator clevis.
6. Slide one end of the 1" x .083 x 36" long tube on to either tube adapter. Hold the 1" tube in place under the other tube adapter and mark its length to reach the shoulder of the tube adapter. Cut the tube to the marker length.
7. Next, slide one of the 2732 X-locator tabs over a 3/8-24 x 1-1/4" bolt followed by one of the weld eyes, and a second tab. Secure with a plain 3/8-24 nut (not included). Do not use the locknuts provided at this time. Repeat this for the second pair of weld eyes, tabs, bolts, and nuts.
8. Position the assembled tabs one on each side of the 1-1/4 x .120 x 3" sleeve so they are centered on the tube. Make sure the long legs of the tabs are opposite of each other. Check to be sure the weld eyes are parallel to each other and the tack weld the tabs to the center tube in three places. Clamping this to a flat plate will keep the weld eyes parallel. Once the weld eyes are checked again you can weld the tabs to the tube the full length of the tab. Use a TIG welder for this since all the parts are 4130 chromemoly. Let this assemble completely cool before proceeding.
9. Slide one of the 1-1/4 x .120" x .50" spacers over the long 1" tube that was cut to length earlier. Next, slide the assembly that was just welded on followed by a second 1/2" long tube.
10. Center the three pieces from step 8 on the long 1" tube. Tack weld one of the 1/2"-wide tubes to the long 1" tube in three places around the circumference. Position the second 1/2" tube against the tube with the tabs welded to it. There should be a very small amount of clearance between the 1/2" tube and the center tube so it can rotate freely, but it should not move between the 1/2" tubes. Tack weld the second 1/2" tube in three places around the circumference. You can now weld the tubes at the three tack welds with 3/8" long welds, do not weld the tube continuously around the OD.
11. Drill two 1/8" rosettes to weld the ends on the 1" tube where the tube adapters will go. Remove the tube adapters from the rod ends in the billet locator clevises. Weld the tube adapters into the tube on the ends around the circumference and the rosettes.

12. After the welded assembly is cool, chase the threads on the tube adapters. Remove the rod ends from the billet locator clevises. Apply a small amount of anti-seize to the rod end threads and install them into the center locator tube. Reinstall this into the 4-link and make sure the rear end housing is centered in the chassis before going to the next step.
13. Thread the remaining jam nuts onto the rod ends and then the tube adapters. Install them into the remaining two billet locator clevises.
14. Slide one end of the 1" x .083 x 36" long tube on to either tube adapter. Hold the 1" tube in place under the weld eye on the center tube assembly and mark its length to reach the shoulder of the weld eye tube adapter. Cut the tube to the marker length. Repeat this for the other side using the remaining piece of 1" tubing you just cut off.
15. Remove the rod ends and tube adapters from the billet locator clevises and the weld eyes from the center link assembly. Again, drill two 1/8" rosettes to weld the ends of the 1" tube where the tube adapters and weld eyes will go. Weld the tube adapters and weld eyes into the end of the tubes around the circumference and the rosettes.
16. After they are cool re-install the short tubes. Use the lock nuts and torque to 35 lb-ft.
17. To adjust the rear end for center, loosen the jam nuts and rotate the center locator tube. You will also need to loosen the 3/8" bolts the ends of the short tubes. Tighten all bolts and move the rear end through its travel to make sure nothing binds.
18. To adjust pinion angle unbolt the locator tubes from the clevises at the rear brackets before attempting to use the ladder-bar adjuster. Once pinion angle has been set, the locator-tube can be adjusted to the correct length then reinstalled.