



Please read the following key points before installing this kit.

1 – Before performing the subframe connector installation, the vehicle must be completely assembled with all body and component parts installed (e.g. fenders, hood, quarterpanels, trunk, full interior, engine, glass, etc.). Basically, the subframe connectors should be one of the last components installed on your vehicle. Reason being is you want the vehicle settled with all of it's own final weight. The car's body is always in constant tension, with forces pushing or pulling within the chassis & body. You want to make sure these forces don't change after you install the subframe connectors. For example, if you installed subframe connectors before installing the engine and body panels this may result in having misaligned fenders, door panels and/or hood later on. The car must be in its final state before the subframe connectors are installed.

2 – The subframe connectors must be installed on an alignment rack or floor ramps (all 4 wheels). The vehicle must be sitting on its wheels at ride height in order to install the subframe connectors. Do not use a two-post lift, as this will load the chassis/body in the wrong points causing the chassis to tweak.

# 4013

## Subframe Connectors 74-81 Camaro / Firebird

### Subframe Connectors:

Your new subframe connectors will increase the overall rigidity of your chassis and improve handling and response. These engineered components connect the rear frame rails with the front subframe to simulate a complete full frame chassis.



*70-74 F-body Connectors Shown*

### Notes:

The subframe connector is essentially a Weld-In component, effectively connecting itself to the front subframe and rear frame rails. However, you may choose to bolt-in the front connection to allow front subframe removal if need be. Hardware for the bolt-in procedure is included.

### Before You Start:

The installation of these subframe connectors will require you to grind and weld. It is recommended that a trained professional install this product. Always wear eye protection when grinding or welding. Please read the entire manual before starting. All images will depict the driver side installation.

## 1. Raise Vehicle

It is best to install the subframe connectors at ride height. To do this properly, please use a 4-Post lift or alignment rack. Disconnect the negative battery cable.

## 2. Prepare Subframe Pieces for Welding

Subframe pieces come fully powder coated so you will want to first prep them for the welding process. Sand the rear mounts of the subframe connector. Make sure you file inside the rosette weld holes also.



## 3. Remove Screws

Remove the screws that hold the brake/fuel lines against the body

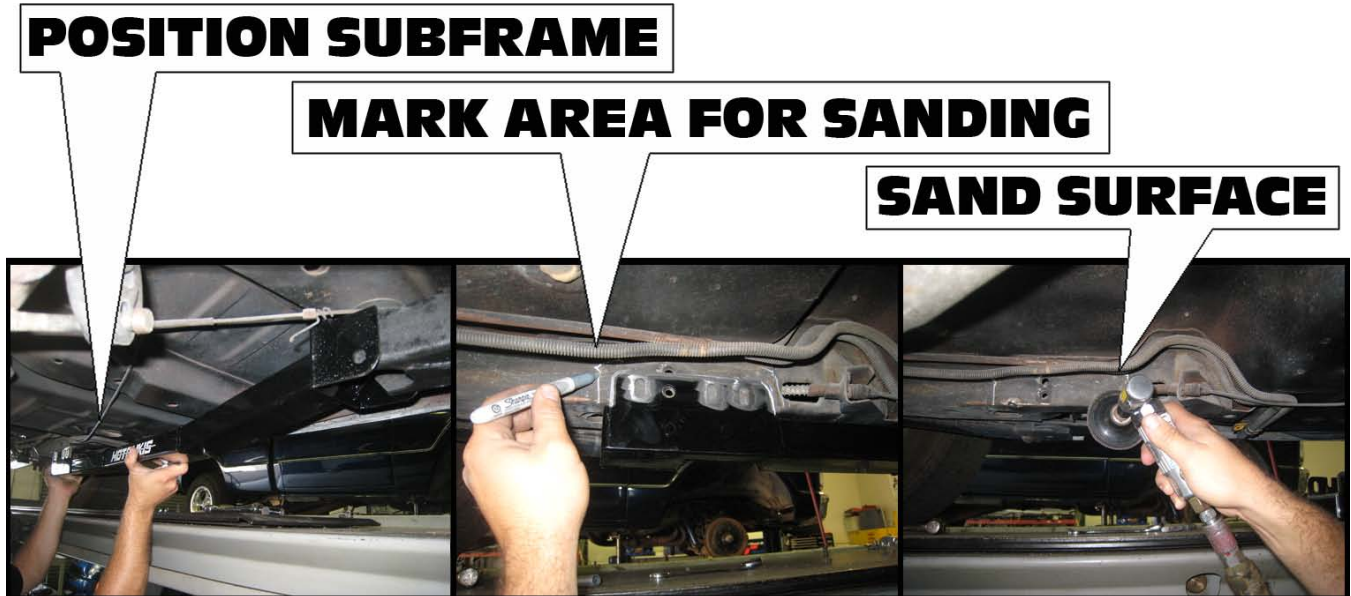
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**REMOVE SCREWS**



#### 4. Mark Area to Be Sanded

Position the subframe into place and mark the area in the rear that will need to be sanded down to prepare the surface for welding.



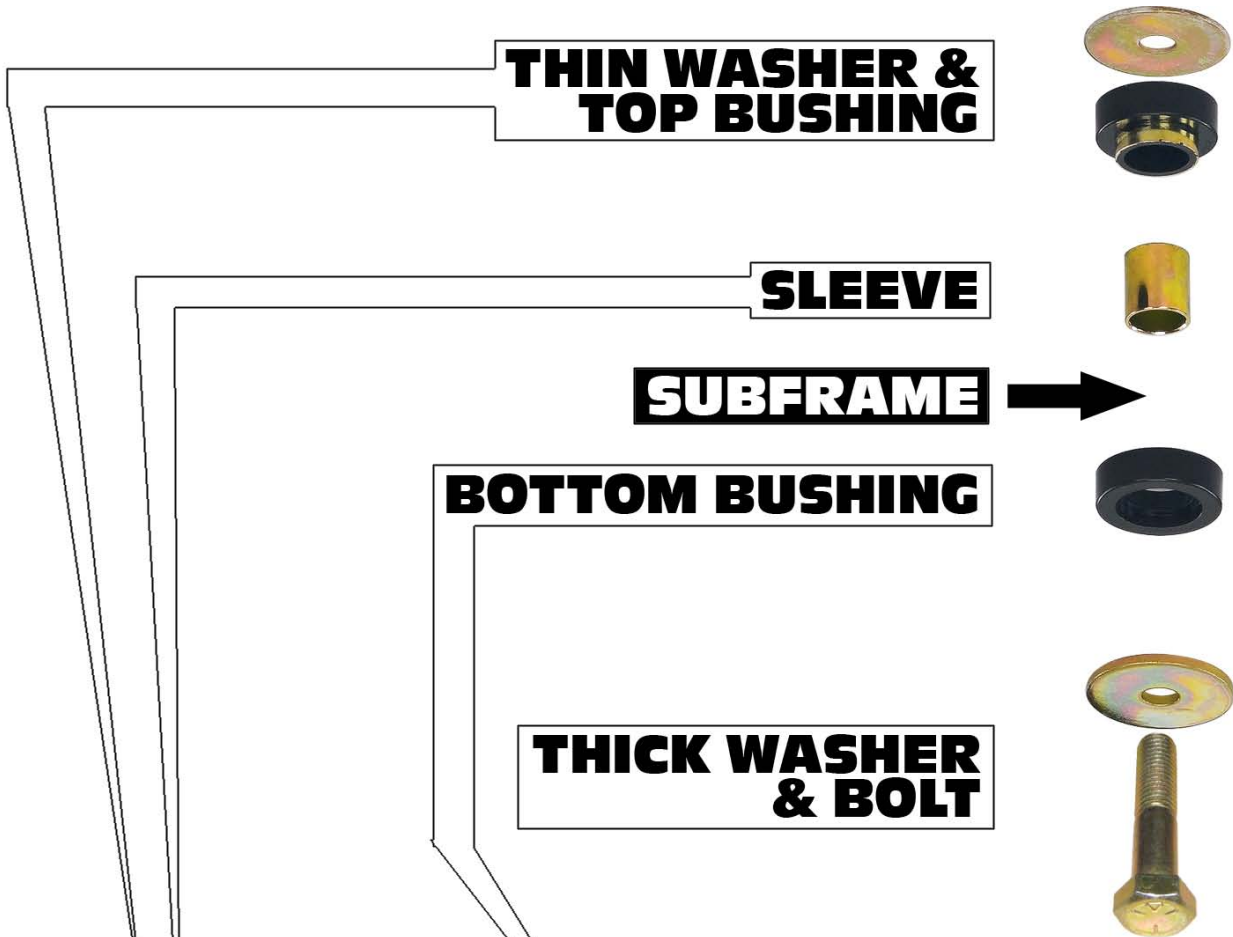
#### 5. Remove Old Bushings

Unscrew and remove all old bushing pieces. You will not need these pieces any longer, so you are free to discard them if you wish.



## 6. Install New Bushings

Place the thin washer and top bushing on top of the frame and then slide the sleeve into place. Install the bottom bushing and thick washer next, slide the supplied bolt up and tighten.



## 7. Prepare for Welding

Use a screw jack to hold the subframe connector in place. Make sure you protect any lines that might possibly be in the line of fire of the welding process.



## 8. Weld Frame

Weld the subframe into place using the pre-drilled holes for rosette welds and also along the edges of the subframe that come in contact with the frame.



## 9. Paint and Replace Lines

After welds have cooled down, spray paint any areas exposing raw metal to protect from rusting. Then put all lines back into place and tighten.



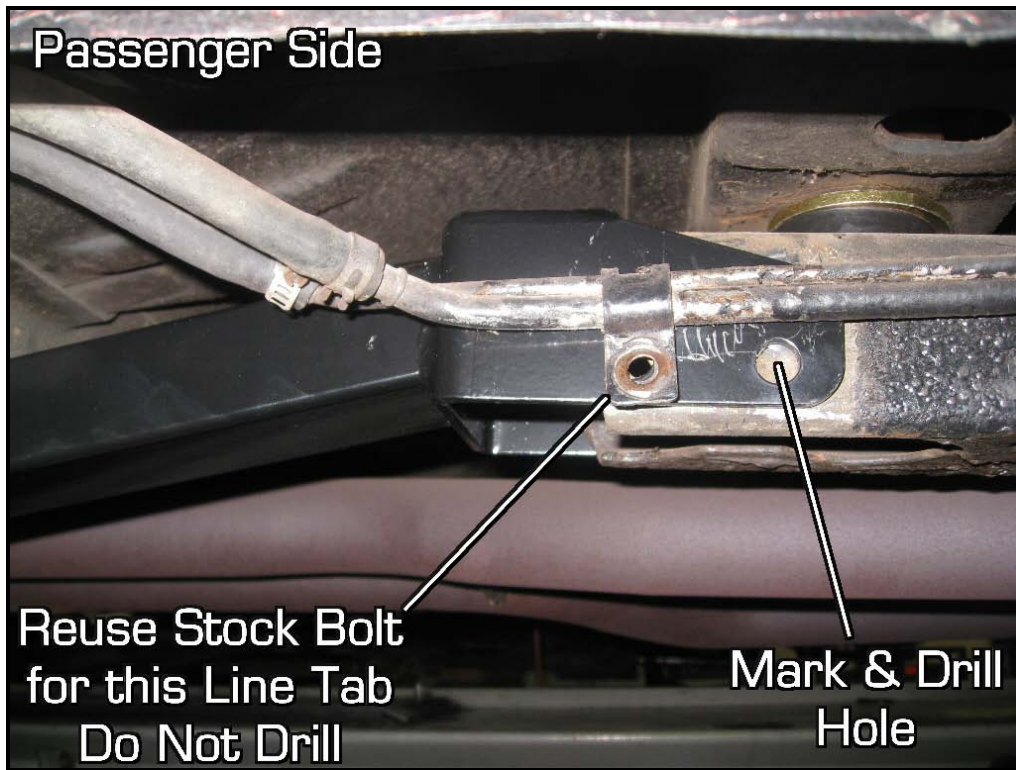
## 10. Drill Holes & Install Bolts

On the front end of the subframe connector, mark the center of each hole and drill a hole through the frame. Use a 1/2" drill bit to get the hole in the frame to the same size as the hole in the connector, big enough for the supplied bolts to fit. Install bolts and fully tighten.

Passenger Side:



**Mark and Drill Out Holes**



Note: The Driver Side does not have this Line Tab. Mark & drill the hole in the same manner as the rest of the holes.







## 11. Double Check

Double check all of the hardware and you are finished.

