

FORD 9" FACEPLATE ADAPTER

<u>ITEM</u>	<u>QTY</u>	<u>PART NO</u>	<u>DESCRIPTION</u>
1	1	1519	Ford 9" faceplate adapter
2	2	1520	Ford 9" alignment bar clamp
3	2	3229	Aircraft washer 1/2 .062 thick .88 OD
4	2	3460	Socket head allen 1/2-13 x 3 1/2
5	4	3461	Flat head capscrew 1/2-13 x 1 1/4
6	1	91 CSTM	FAB9 Rear End Narrowing Worksheet and Instruction

This faceplate adapter can be used without #6708 narrowing jig to do the 9" Ford housings. If you purchased the face plate as part number 6714 you will have the #3017 alignment bar and the #1254 Ford housing end adapter. You can easily determine the correct rear axle housing dimensions using Chassisworks' Rear End Narrowing Worksheet.

1. Start by chasing the threads on the bar clamp using a 1/2-13 tap.
2. Insert the 1/2-13 flat head capscrews through the countersunk holes in the faceplate and into the alignment bar clamps. Only tighten them enough to hold the bar clamps in place.
3. Put the 1/2 inch aircraft washer over the 1/2-13 x 3 1/2 socket allen bolts and insert them through the straight hole below the bolts previously installed and into the threads in the bar clamp blocks. Leave the bolts loose at this time.
4. Slide the #3017 alignment bar through the bar clamps. Tighten the 4 flathead capscrews. Next, tighten the socket head allen clamp bolts until they are snug.
5. To verify alignment, slightly loosen the 4 flat head capscrews, tighten the clamp bolts, and then retighten the flat head capscrews. Torque to 55 lb-ft.
6. Loosen the socket head clamp bolts and you should be able to easily slide the alignment bar in the clamp blocks. It is a good idea to put some anti-seize on the socket head clamp bolts because you will be tightening and loosening every time you use the fixture.
7. You can now follow the procedure below to narrow your housing.
8. Most important; the housing must be very clean, especially the inside. A tiny bit of rear end grease will mix with dirt or saw filings and make the center bar very difficult to remove.
9. Clamp the faceplate in a vise, bolt the 9" Ford housing to it. The rear axle should be level right to left. The pinion must be level to the ground. The easiest way to do this is to make sure the front of the faceplate is 90 degrees to the ground.

The top center hole and bottom center slot are both 3/8 diameter. This guarantees that the face plate is properly aligned to the housing. The top and bottom bolt holes must always be used. The other holes are drilled slightly oversized to make the face plate adapter easy to install to the rear end.

10. If you have to weld brackets to a housing, use this sequence:

- a) Cut the housing to proper length
- b) Weld all brackets to housing
- c) Weld axle ends on last.

This procedure will minimize distortion due to welding. Most housings are not straight to start with. Consequently, when you reweld the ends, it looks like the ends are not straight. This may cause customer complaints. You may need to explain to them that the housing is bent but the ends are straight.

11. The pinion centerline slot in the faceplate provides a simple and accurate means to locate the pinion centerline. This will make it much easier to make your measurements. Just slip your tape measure hook in the slot and measure your driver and passenger housing tube lengths directly.

12. Always keep the axle adapters clean and oiled with WD-40™. The alignment bar should be oiled with WD-40™ every time it is used to make installation and removal easier. Failure to do this could seize the bar. If the bar becomes nicked, use 600 grit sandpaper to smooth it out. Weld splatter can be a real problem, especially if you have a gap in the housing end joint. Never hammer on the bar or adapters to remove them; severe damage will result. If a screw on axle adapter becomes seized to the alignment bar (remember to always put anti-seize on the threads), clamp the adapter into a vise with aluminum jaw covers and use a wrench on the hex end of the alignment bar to remove it. With proper care and maintenance, this fixture will last years.

13. Screw the axle adapters onto the alignment bar, one side is labeled BIG FORD, the other SMALL FORD. Put anti-seize on the threads. The adapter is bolted to the housing end. This is because the bolts are not square and there is no flat on the housing end to align the housing end rotation. The flat on the axle adapter is for your protractor level. Put the alignment bar into the clamps pushing the housing end tight against the end of the axle tube. Use a protractor level on the housing adapter flat to get the proper rotation for the housing end. Tighten the socket head allen clamp bolts. Double check your housing length and tack the housing end on in 3 places, 120 degrees apart. If you have a gap, weld it last to minimize distortion. Allow the rear end to cool before removing the alignment bar. Repeat procedure for the other side.

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