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

CHRIS ALSTON'S Chassisworks
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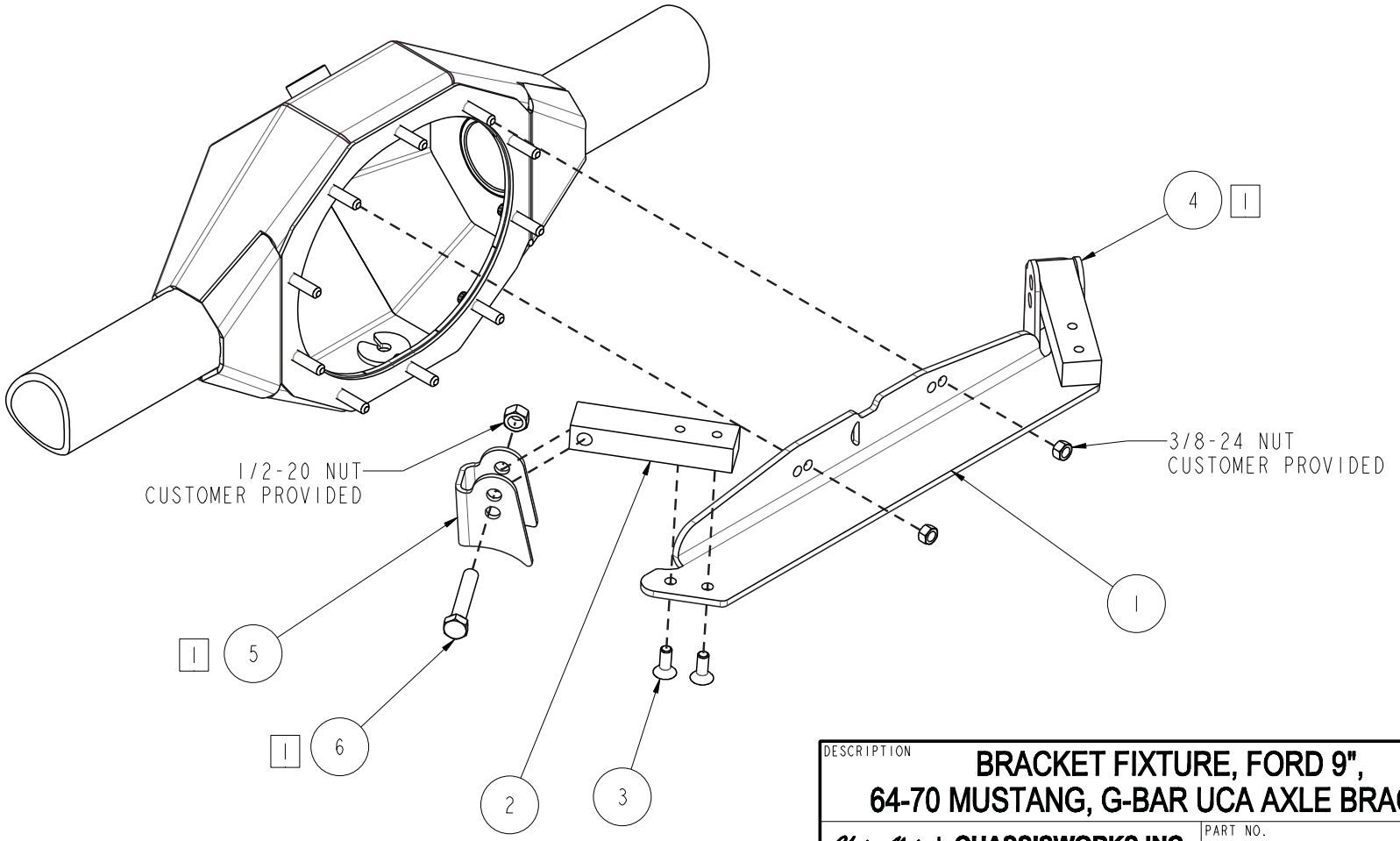
6716
g-Bar Upper Axle Bracket Weld Fixture

Description: Bolt-on fixture for welding g-Bar upper axle brackets onto Ford 9” rearend housings. For use with all g-Bar and g-Link rear suspension systems for 1964-70 Mustang and Cougar.

Note: Fixture can also be clamped into position when used with 8” rearend housing.

Figure 2-1

ITEM	QTY	PART NO.	DESCRIPTION
1	1	230231	MOUNTING PLATE, UCA AXLE BRACKET WELD FIXTURE, G-BAR, 64-70 MUSTANG
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	1	230229	UCA AXLE BRACKET, DRIVER G-BAR, 64-70 MUSTANG
5	1	230230	UCA AXLE BRACKET, PSGR G-BAR, 64-70 MUSTANG
6	1	3107	BOLT, 1/2-20 x 2 3/4 HEX CAP



NOTES:
1 PART OF CONTROL ARM KIT

DESCRIPTION
BRACKET FIXTURE, FORD 9",
64-70 MUSTANG, G-BAR UCA AXLE BRACKET

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PART NO. 6716

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PARTS LIST

6716 - g-Bar Weld Fixture

Qty	Part Number	Description
2	1480	Bracket locator block for g-Bar upper link
1	230231	Mounting plate, upper axle bracket weld fixture
4	3105-038C1.00B	Flat head 3/8-16 x 1” flat head cap screw, black oxide

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.
   Note: Stock 1965-70 Mustang housings will have a centered pinion.

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. Refer to Figure 2-1 for correct orientation.
   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, #230229, 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. Additional bracket fitment modification can be made by replacing the 1/2" through-bolts with smaller 3/8" bolts. This allows a small amount of vertical and fore-aft adjustment while maintaining the correct bracket angle.

11. Repeat steps for passenger side using axle mount # 230230.

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.

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