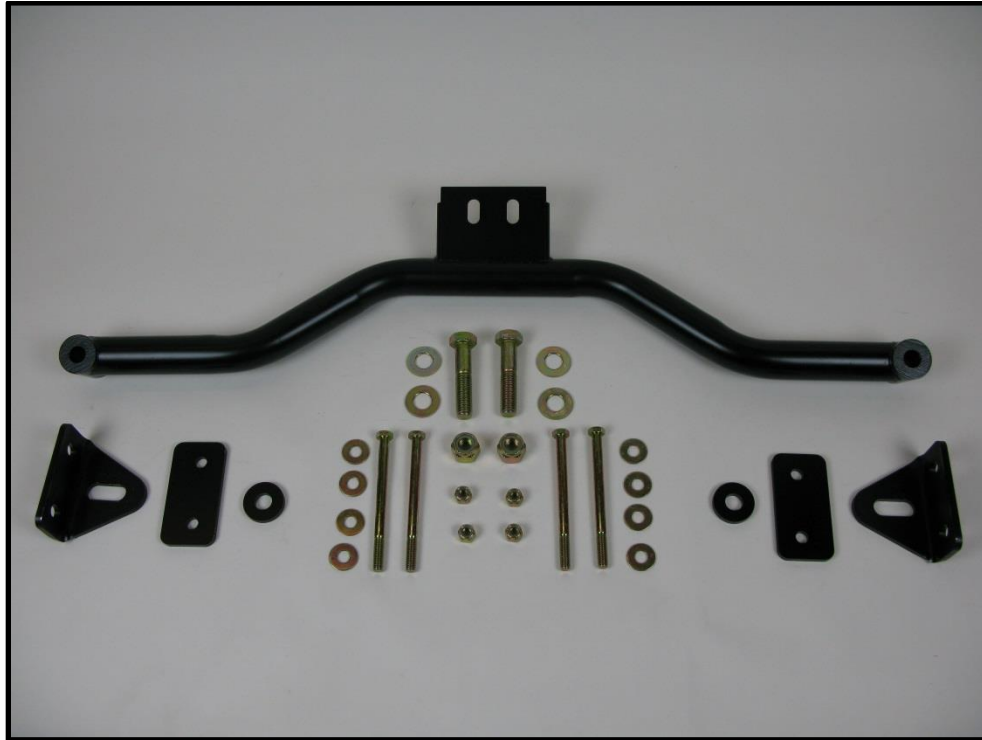




TRANSMISSION CROSSMEMBER KIT



How to install your SCR Transmission Cross member to the chassis.

This cross member is used when converting to a newer style manual or automatic transmission with rear mounts. It can be used with front or side engine mounts.

You have a choice of bolting the L brackets onto your chassis (with the 3/8" bolts that are provided) or they can be welded in place. If you are welding them in place, **be sure that the welds cover all the sides. Don't just tack weld the plates! They need to be securely welded to the frame.**



First hold up the back of the transmission with a jack. (Make sure the jack is not in the way of the mount location you will be working on.)

Disconnect the existing frame horn brackets. Lift the transmission just enough to clear your work area.

Bolt the tubular center section to your rear transmission mount on the tail shaft using the existing bolts. (These need to be tight but not torqued yet.) (See picture # 3 for the direction the tube should attach)

Then attach the two L brackets to each side of the crossmember tube with the L tabs facing up. Use the 2 x 5/8" bolts, 2 x thin washers, 2 x 1/4" washers and nuts provided. Be sure to use the 1/4" thick washer on top. (The bolts should be tight but they do not need to be torqued at this point.) (See picture # 1) for the direction the L bracket should sit)

PICTURE # 1



Jack the transmission up or down so that the top of the L brackets are flush with the top of the frame. (See Pic# 1) **Make sure the brackets are as high as they can go on the frame but not past the top edge.** (The higher up you put the crossmember the better. This will give you the most clearance below the crossmember needed for your exhaust.)

Measure from a fixed point on each side of the frame to even up the L brackets front to back so it is not crooked. (See Pic# 2)



PICTURE # 2



Mark the points where you will drill two 3/8" holes on each side. Remove the bar and brackets and drill the holes all the way through the frame. **(Be careful not to drill into your fuel or brake lines).**

Once the holes are drilled. Bolt the L bracket to the frame using the 2 x 3/8" bolts, washers, nuts and supports on each side. (See Pic# 1) (The support plate goes on the outside of the frame and the bolts should run from the outside in.)

Insert the crossmember on top of the newly installed L brackets using the same nuts, bolts and washers from the top down. (See Pic# 1) (Don't forget to put the 1/4" thick washer on top.)

Slowly drop the transmission down onto the newly installed tubular crossmember and install the existing bolts into the transmission.

At this point you can torque all the nuts and bolts to desired amount. (See Pic # 3)

PICTURE # 3

