



WELD-IN 4-POINT SUBFRAME CONNECTORS

SFC020

REQUIRED TOOLS:

- Jack and Jack stands
- Sockets and wrenches: 13mm, 18mm, 19MM
- Pry bar
- Angle grinder or wire wheel
- Welder

INSTALLATION:

1. Lift vehicle front and rear and safely support on jack stands. To keep the jack stands out of the way, position front stands under the K-member and rear stands under the axle.
2. Using a 13mm socket or wrench, remove the (4) bolts on the driveshaft tunnel brace and temporarily remove the brace.
3. Using an 18mm socket and wrench, remove the driver's side front control arm bolt. **NOTE:** *tension on the rear end may make it difficult to remove and re-install this bolt. Use a pry-bar to move the rear end forward or back to release tension on the bolt while removing/inserting.*
4. A second helper may be useful at this stage. Using the supplied 12mmx100mm bolt, connect the rear of the sub-frame connector to the control arm mount, "capturing" the mount as shown in the **IMAGE 1**.
5. Lift the front of the sub-frame connector up to the frame and hold it in place using a jack or stand.
6. Using the supplied 10mm x 40mm bolts and washers, bolt the sub-frame connector to the tunnel brace area.
7. Trace around the front frame box, the rear control arm saddle, the rear sub-frame mount and the tunnel brace mounting bracket at the weld points on the frame.





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Continued

8. Remove the sub-frame connector and then sand or wire wheel the frame at your previous marks. The surface needs to be sanded down to bare metal and clean for a porosity-free weld.
9. Also remove the powdercoat from the sub-frame connectors at all four weld locations. Re-install the sub-frame connector as before and weld all four locations. It is recommended to weld as much surface area as possible.
10. Duplicate this process for the passenger side.
11. Wire brush all weld points then prime and paint with a rust preventative coating.
12. Tighten the control arm bolts to 100 ft/lbs using a 19mm wrench and socket.
13. Re-install the driveshaft tunnel brace using the supplied 8mm x 40mm bolts and washers. Tighten to 20 ft/lbs.
14. Lower vehicle.

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This product is an aftermarket accessory and not designed by the vehicles manufacturer for use on this vehicle. As such, buyer assumes all risk of any damage caused to vehicle/person during installation or use of this product.