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Part #918 Thunderbird Subframe Connector

This subframe requires welding. We recommend using TIG or Mig. Your subframe spans the distance from the rear bulkhead where the lower



control arms are mounted, to the front part of the unibody lower pan rail.

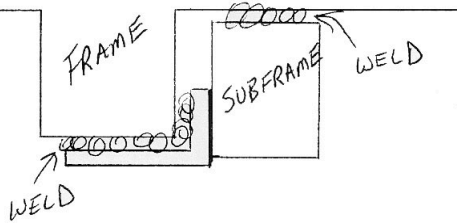
- 2 angle plates
- Driver side subframe
- Passenger side subframe
- 2 plate support gussets

Note: When installing subframes, we recommend the car be on a drive on rack or supported up in the air simulating the load on the suspension and not the frame.

To Install:

1. Driver side: Your subframe installs on the outside of the unibody lower floor pan rail. You will note that the front of the subframe already has an angle plate welded to the tube. This lies up against the outside of the floor rail. The rear of the subframe has an angle plate welded on that butts up against the rear bulkhead. You will note that both subframes look exactly the same except the driver side has a small tab protruding out towards the outside of the car. This tab supports the mounting point of the parking brake cable on the vehicle. You will remove the original parking brake assembly at that location and utilize the tab for reattaching the parking brake cable.
2. The first step is to position the subframe up to the floor. The back of the subframe pushes up against the rear bulkhead approximately where the rear lower arm attaches. Once you pushed the back up against the bulkhead, raise the front of the subframe up along the outside of the floor rail. The subframe should be parallel to the floor rail. Mark the location around the angle plates in the front and rear. Drop the subframe down and buff the powder coat off the edges of the plates. Next buff the dirt and paint off the area on the floor where the welding will take place.

3. Tack weld the subframe: Hold the subframe up tight against the floor and tack weld it at the front and rear. If you have a good fit, complete your welds at the attachment points both front and rear. Note: The diagram below shows the welding location for the subframe to the factory frame rail.



4. Install both subframe connectors before installing the support gussets.
5. There are two center support angle brackets 4 inches long in your kit. The bracket attaches approximately in the middle of the subframe where the factory floor support rail ends. It serves to strengthen the middle of the floor by tying it to the

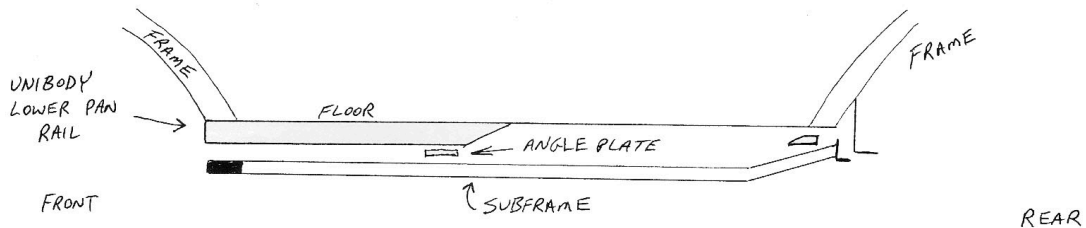


FIGURE 2

round tube subframe. (Figure 2 typical) __ Notice the angle plate in the middle.

The wide portion of the angle plate lays flat along the factory frame rail and the short side of the angle bracket butts up to the new subframe. Mark the area where it butts up to the subframe and around the factory frame rail. Next buff the area for welding. After prepping the area, weld the bracket into position. Do this for both sides.

6. Next install the rear support gussets at the rear of the subframe. The support gussets are flat plates that when installed add additional support to the rear bulkhead area. You will use one gusset preside and it will fit on a slight angle between the new subframe and the square rear frame rail. Figure two does show the small gusset at the back. Simply install the gusset so it contacts the subframe

and floor rail on a slight angle and weld into position. The angle plate will be pretty much all the way back. Prep the area and weld into position.

7. After all welding is completed, prep and paint the areas that were affected by the welding.
8. Finally reinstall the rear brake cable.