

Installation Instructions for 60190 Axle Housing Brace - Ford 9"

Installation

- 1.** We recommend that this installation begin with the rear axle assembly removed from the vehicle.
- 2.** We also recommend the use of an alignment bar. This will prevent distortion during the welding process.
- 3.** Test fit each brace to the housing and axle tube including the area where the two braces meet to form one unit. Trim as necessary with an angle grinder and/or a file.
- 4.** Using a lumber crayon or grease pencil mark the housing and axle tubes where the brace is to be installed.
- 5.** Use an angle grinder to clean and prep the housing surface and axle tubes creating a surface for the weld to penetrate.
- 6. Caution:** Remove all oil and thoroughly clean the entire housing prior to any welding.
- 7.** To minimize the amount of heat distortion, tack weld the brace to the housing and axle tubes in several places before beginning the finish weld. Periodically check the alignment bar for movement or distortion.
- 8.** Weld the remainder of the brackets in increments of one inch while alternating from side to side to further minimize heat distortion. Periodically check the alignment bar for movement or distortion.
- 9.** The braces should be welded on all areas for maximum, structural rigidity.

