



Installing a Back Half

Please read these instructions completely before starting any work.

- 1) Start by removing the fuel tank, gas lines, rear bumper, interior, and anything flammable or might get in the way during the construction.
- 2) Set your car up on jack stands. Make sure to have the car up high enough to be able to get the back half in the car but down low enough to keep the car stable. Place jack stands under the front and rear of the front clip and under the rear part of the rocker panel. You will also need to support the back part of the body to keep it in place.
- 3) Level the car from side to side and front to back. Check this several times during the construction.
- 4) Mark the centerline of the rear axle on both sides of the car. Do this on the floor and on the side of the car by using a piece of tape on the outside of the fender. Make sure the existing axle is in the car square before marking the centerline. Now you can remove the rear end and all the old suspension.
- 5) Set up the new back half next to the car the way you will be installing it in the car.
- 6) On the new back half measure the distance from the center of the rear end to the front of the front cross member. Transfer this dimension to your car and mark this on the floorboard. This is where you will cut the floorboard to install the new back half. When cutting out the floorboard and trunk floor leave as much structure as possible to support the body until the back half is fully installed.
- 7) Measure between your rocker panels at the point where the cross member will weld to it. (If the rocker panels are thin or rusty you will want to plate this area with steel.) Trim the front cross member on the back to the dimension you measured. When cutting the cross member make sure to keep the rear frame section in the center of the cross member.
- 8) Measure from where you will install the front cross member back to where you want the rear of the back half to connect to the rear valance panel / bumper mounts. Trim the rear part of the frame rails to this dimension.
- 9) You are now ready to put the back half up into the car. Locate the cross member in the rocker panels at the height you are planning on installing. Remember the higher up on the rocker panel you place the back half the lower the car will sit. Support the cross member with jack stands. Move the rear of the back half in to place and support.
- 10) Level the cross member and double check to make sure the rest of the car is still level. Square the back half up in the car using the dimension you measure from the centerline of the rear axle to the front of the cross member.
- 11) You are now ready to tack the back half in and check all your dimensions, and check if everything is square and level.
- 12) When the back half is tack welded in securely install your rear suspension to make sure the center of your brackets align with your centerline marks on the floor and fenders. Look over the body of the car and make sure it has not moved and caused bulges or creases. Look at the door lines to see if they still line up good. Look at the truck lid to make sure it still lines up good.
- 13) If everything checks out you are ready to weld the back half in the car.
- 14) Now you are ready to install your sub frame connectors, roll cage and remove the rest of the floor and trunk pan.