

INSTALLATION - SERVICE INSTRUCTIONS

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Bulletin #9 page 1 of 1 Housing End Alignment Kits

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PART NUMBERS :

DESCRIPTION

- 303F.....Housing end alignment bar kit for Ford applications.
303M.....Housing end alignment bar kit for Mopar and Ford applications.

PARTS INCLUDED :

- 301.....Hard chromed 2" bar with wood transport box
302.....Housing end alignment sleeve (for the 300M kit).
303.....Housing end alignment sleeves (for the 300F kit).
305-309.....Center section alignment rings to suit application (see list below) one pair per kit.

VARIABLE PARTS :

- 304.....Floater spindle alignment sleeve (For M-W floater spindle)
305.....Dana 60 alignment slip rings (3.812" O.D.)
306.....Ford 9" large bore alignment slip rings (3.250" O.D.)
307.....12-Bolt and Ford 9" alignment slip rings (3.062" O.D.)
308.....Mopar 8-3/4" alignment slip rings (3.265" O.D.)
309.....Ford 9" small bore alignment slip rings (2.891 O.D.)

PRIMARY APPLICATION :

Housing end installation.

INSTALLATION INSTRUCTIONS :

- 1) Cut housing tubes to proper length and chamfer for weld penetration. Be sure to allow for the thickness of the housing end before cutting housing tubes.
- 2) Install proper center section alignment rings in the carrier bores and tighten caps. Alignment bar should move freely through alignment rings. If narrowing thirdmember type rears be sure to use a thirdmember gasket of same thickness that will be used to obtain proper position of thirdmember.
- 3) Fit housing end to proper register on alignment sleeve, clamp housing end to flange on alignment sleeve with vice grips or small C clamps in 4 places
- 4) Slide housing end alignment sleeve with housing end onto alignment bar. Housing end should fit squarely against end of the housing tube. If necessary grind face of housing tube until the ends fit against the tube with no gaps. Concentricity of housing end to housing tube is not critical unless there is a gap. If the tube is this far off the tubes should be straightened before installing housing ends. Set the orientation of the housing end for the desired backing plate and or caliper mount being used. Tack weld in at least 6 places, spacing the tack welds evenly around the housing end.
- 5) Remove alignment bar and alignment sleeve. Finish welding.
- 6) Repeat operation for other side.

NOTE: To assure the best results, all welding on housing (4 link brackets, brace, etc.) must be done before the housing ends are installed.

