

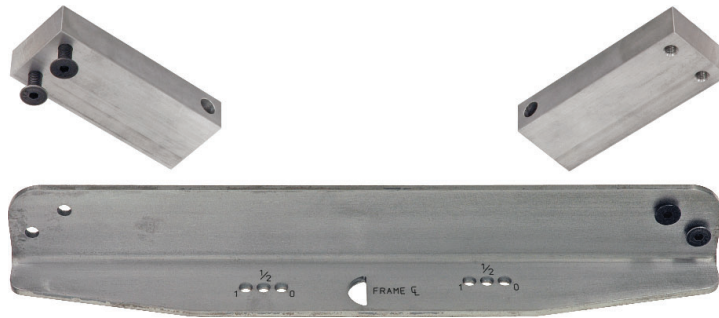
READ ALL INSTRUCTIONS COMPLETELY AND THOROUGHLY UNDERSTAND THEM BEFORE DOING ANYTHING.  
CALL CHASSISWORKS TECH SUPPORT (916) 388-0288 IF YOU NEED ASSISTANCE.

# INSTALLATION GUIDE



## 6715

### Canted 4-Link Upper Axle Bracket Weld Fixture



**Description:** Bolt-on fixture for welding Canted 4-Link upper axle brackets onto Ford 9" rear end housings. For use with custom-fit and vehicle-specific Canted 4-Link rear suspension systems.

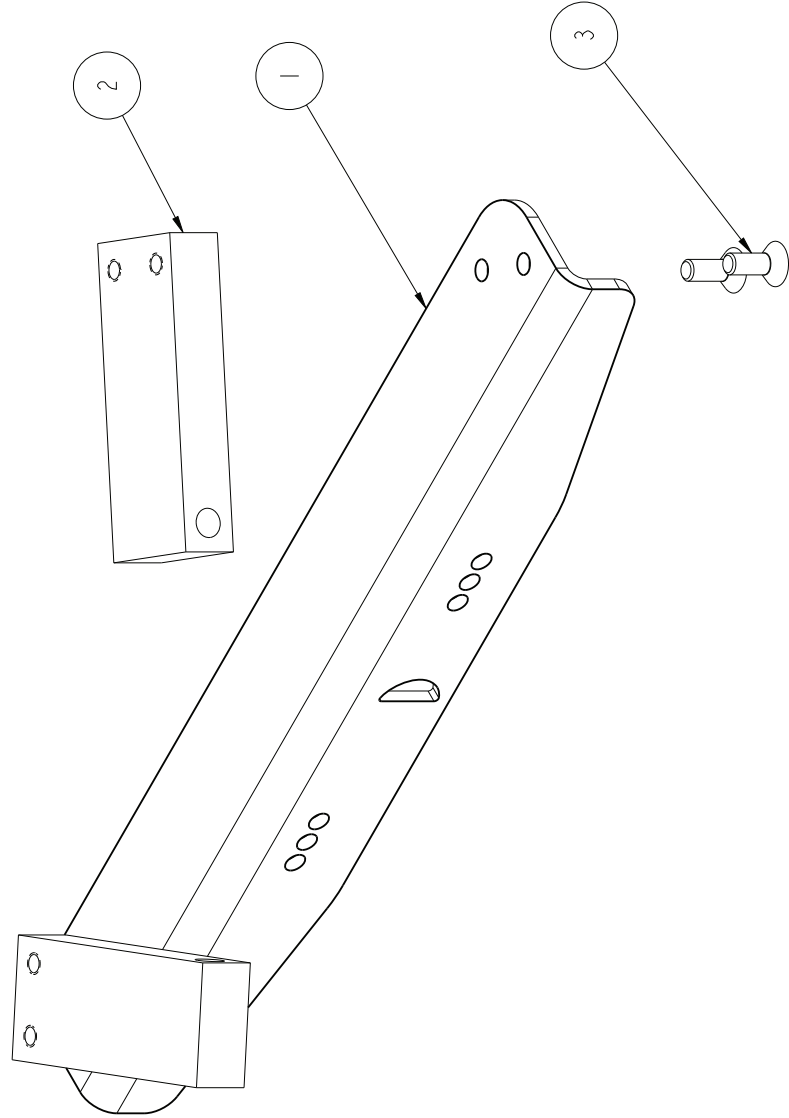
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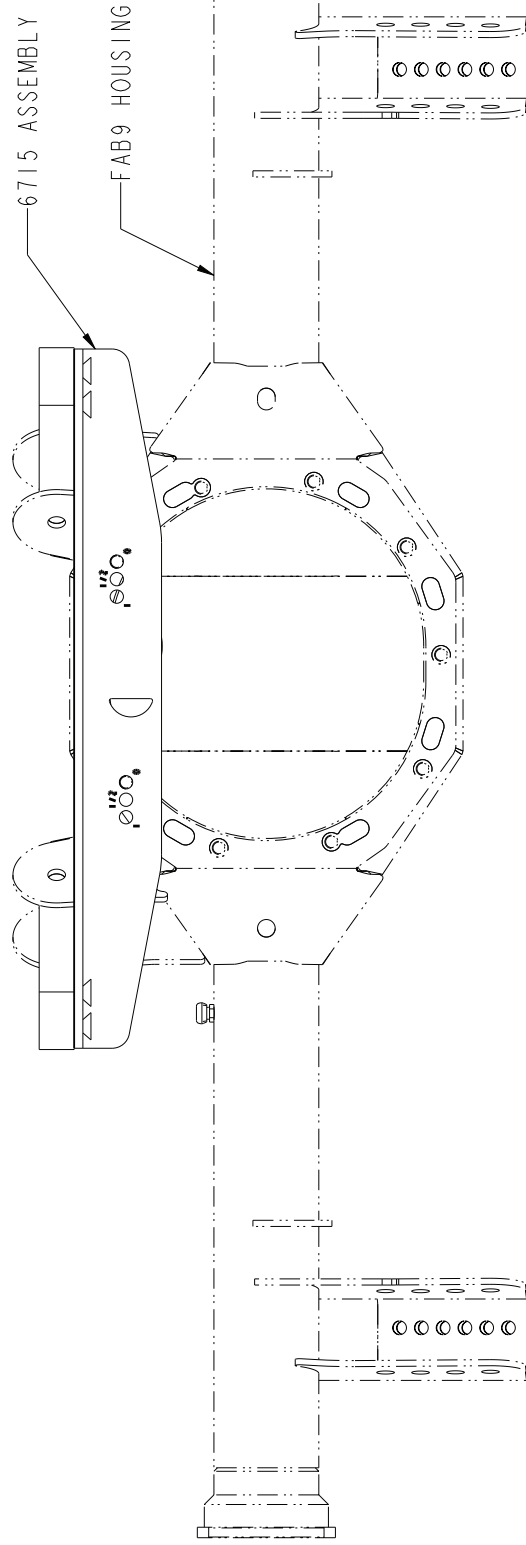
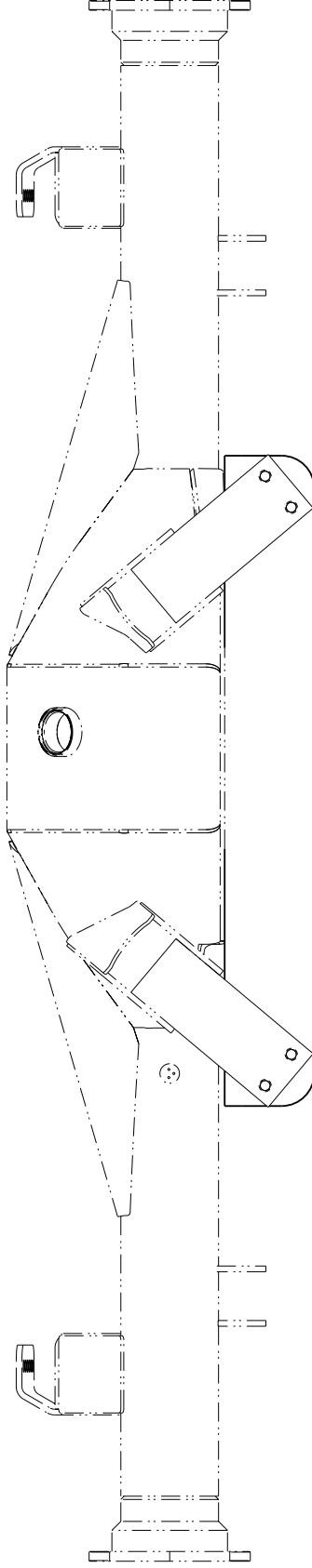
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ITEM	QTY	PART NO.	DESCRIPTION
1	1	230180	MOUNTING PLATE, UCA BRACKET WELD FIXTURE, BILLET 4-BAR HOUSING
2	2	1472	BRACKET LOCATOR, UCA WELD FIXTURE, BILLET 4-BAR HOUSING
3	4	3105-038C1.00B	FLAT HEAD SOCKET CAP SCREW, 3/8-16 x 1, BLACK OXIDE



DESCRIPTION		BRACKET FIXTURE, FORD 9" BILLET 4-BAR UPPER CONTROL ARM BRACKET	
PART NO.		6715	
Chris Alston's CHASSISWORKS INC.		12/7/05	
8661 YOUNGER CREEK DRIVE		DWG: 916715	
SACRAMENTO, CA 95828			
(916) 388-0288 FAX 388-0295			



DESCRIPTION

**BRACKET FIXTURE, FORD 9" BILLET  
4-BAR UPPER CONTROL ARM BRACKET**

*Chris Alston's CHASSISWORKS INC.*

8661 YOUNGER CREEK DRIVE  
SACRAMENTO, CA 95828  
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PART NO.

**6715**

4/9/21

DWG: 916715

# PARTS LIST

## 6716 - g-Bar Weld Fixture

Qty	Part Number	Description
2	1472	Bracket locator block
1	230180	Mounting plate, upper axle bracket weld fixture
4	3105-038C1.00B	Flat head 3/8-16 x 1" flat head cap screw, black oxide

This fixture correctly locates the upper axle brackets for welding to the rearend housing. It has been designed for bolt-on use with a standard Ford 9" bolt pattern, but can also be used on 8" Ford housings by measuring from each housing end to the closest bracket to ensure the brackets are centered, and then clamping it to the housing face.

## INSTRUCTIONS

- This fixture will align the upper control arm brackets for the Canted 4-Link with any FAB9™ or Ford 9" housing.
- The straight side of the 'D' shaped cutout is the location of the frame centerline.
- When installing the mounting plate, you must be careful to use the correct holes for the pinion offset. The mounting plate allows you to...
  - Center the pinion, zero offset (0)
  - 1/2" offset to passenger side (1/2)
  - 1" offset to passenger side (1)
- Slide the mounting plate over the two upper studs on the housing face. The center stud in the top of the housing face will need to be removed to allow the plate to be bolted tight to the housing face.
- Use the 3/8-16 x 1" flat head cap screws to bolt the bracket locator blocks to the mounting plate. The blocks go toward the back of the housing over the case.
- Follow the instructions provided with the 4-bar kit for the procedure to fit the brackets to the housing. Once they are fit, secure them to the bracket locator block and weld them to the housing.