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## **Gripp Bolt or Weld-On Subframe Connectors Part # 2506, 2520, 2542, 2543**

### **I N S T A L L A T I O N I N S T R U C T I O N S**

- Step 1** Support vehicle on drive-on ramps, or by placing jackstands under rear axle and front control arms (this preloads the chassis correctly by putting normal pressure on the suspension).
- Step 2** Place connector over the front and rear subframes, making sure the bar fits flat against the subframe and contours to the floorpan with the slanted end plate towards the front of the vehicle. Be sure bars clear all brake, fuel and vacuum lines.
- Step 3** Tack weld bar (front and rear) to hold in place, then finish welding all seams. Care must be taken when welding heavy-gauge connectors to thin-gauge subframes, too high heat setting can “blow” holes in subframes.
- Step 4** If you wish to bolt the connectors on, the exhaust system at the mufflers may have to be moved out of the way or completely removed for clearance of drill. Repeat steps 1 and 2.
- Step 5** Using a 3/8” bit, drill through both the connectors and the subframe as shown in the diagram below. Place bolt through hole before drilling next hole (this keeps bar in position correctly and ensures an exact tight fit).
- Step 6** After all holes are drilled, install lock washer and nut to each bolt and tighten to 25-35 ft. lbs.
- Step 7** On models equipped with seat support brackets, simply install supplied lock nuts and flat washers to the existing seat studs protruding through the brackets. If a gap is present between the seat brackets and the floorpan, 1/2” flat washers may be used as a spacer to fill the gap.

