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Part # 4110 – Sportsman Front End Mount Kit

Parts List:

- | | |
|-----------------------------------------------------------|----------------------------------------|
| 1...Main Cross Brace 3/4" x .083" x 6' | 6...4" x 4" x .062" Steel Plates |
| 2...Quick Pins | 2...Upright Supports 5/8" x .065" x 2' |
| 2...Male Slip Tubes 1" x .065" x 12" w/ 3/4" hole | 2...Forward Supports 5/8" x .065" x 3' |
| 2...Female Receiver Tubes 1-1/4" x .065" x 5" w/ step cut | |

These instructions are just one way of properly installing the Sportsman Front End Mount Kit. Depending on your fabrication experience, you may find it easier or more convenient using other methods that accomplish the same results. Every installation is slightly different and we have attempted to structure these instructions to make your installation as easy as possible.

1. You will need to install the Female Receiver Tubes into/onto the end of the front frame rails. You may want to drill a couple holes in the frame rail to give you a couple of locations to plug weld the receiver into the frame rail. Allow approximately 2" of the receiver tube exposed. Weld the tubes in place. For 2" x 3" frame rail cars, take a piece of scrap material and make a cover for the end of the frame rail (This extra piece of material is not included in this kit).
 2. Next align the front end to the main body shell and support in such a way that it cannot move while installing the mount kit.
 3. Now measure 6" ahead of the Female Receiver Tubes. At that point, measure the inside width of the front end and cut the Main Cross Brace to size and slip the Main Cross Brace through the holes drilled in the Male Slip Tubes. Slide the assembly into the Female Receiver Tubes making sure everything is square and equal from the chassis centerline.
 4. Form the 4" x 4" plates to match the contour of your body. Form both plates for each end of the Main Cross Brace and tack weld in place. Pop rivet the plates to the front end, this will hold everything in place.
 5. Install the Upright Support Bars from the Main Support Bar up to the front end of the body. Form two plates to the contour of the body where the support bars meet the body. Pop rivet the plates in place and tack weld the Upright Support Bars from the main cross brace to the plate.
 6. To install the forward support bars follow step 5.
- NOTE: Body styles with long front ends (i.e. Firebirds & Corvette's) offer special problems. These longer front ends will need the forward support to angle up more since they lack the body contours that strengthens the front end. Extra plates and tubing is available.
7. With any leftover material, gusset and triangulate the larger span areas to give the frame work more strength. For larger cars you may need extra tubing. Finish welding the entire assembly.

