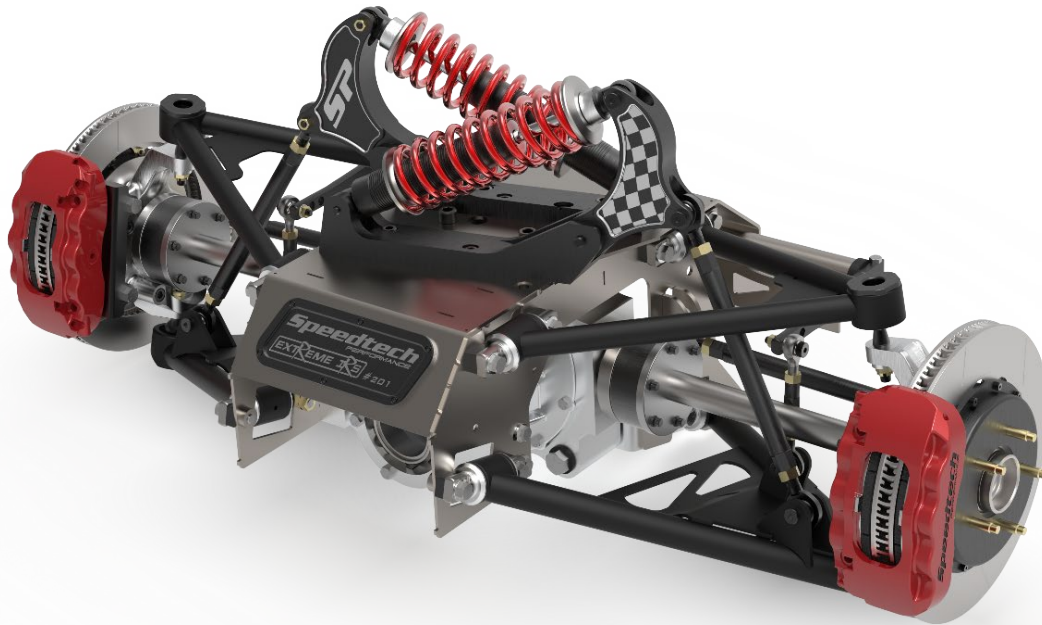


Instruction Guide

Independent Rear Suspension -Sheet Metal Kit
67-69 F-Body



Speedtech

PERFORMANCE

CHASSIS - SUSPENSION - PRO TOURING - AUTOCROSS - DRAG RACING - CUSTOM BUILDS

435.628.4300 SPEEDTECHPERFORMANCE.COM



4160 S. RIVER RD, ST. GEORGE, UT 84790



Figure 1: 1967 Camaro features our IRS [photo by Jeremy Davies]

Congratulations on the purchase of your new Speedtech Performance IRS sheet metal kit. Use only approved and appropriately rated jack and jack stands, and be sure to take all safety precautions required to complete the job safely and correctly. If you have uncertainties, seek the assistance of a highly qualified workshop to assist you.

Read and understand all instructions thoroughly before you begin. Your main assembly and set up of your new IRS sheet metal kit can be done in a home garage with hand tools and basic welding equipment.

Speedtech enjoys seeing the progress our customers are making as they work through their builds. Join the group, [Team Speedtech](#), on Facebook and share your pictures and your story.

Speedtech Performance sends you best wishes for your project!

TABLE OF CONTENTS

1.0	GENERAL INFORMATION.....	4
1.1	THIS GUIDE.....	4
1.2	OVERVIEW.....	4
1.3	TOOLS.....	4
2.0	CHECK IN PARTS AND HARDWARE.....	5
2.1	CHECKING IN THE ORDER.....	5
2.2	CHECK IN TABLE.....	5
3.0	MOCK UP / INSTALLATION.....	5
3.1	MOCK UP.....	5
3.2	WELDING.....	6
3.3	PACKAGE TRAY.....	6
4.0	CONGRATULATIONS.....	7

1.0 GENERAL INFORMATION

[Back to Table of Contents](#)

1.1 THIS GUIDE

Thank you for purchasing your new Speedtech Performance IRS sheet metal kit. Read through all instructions thoroughly before beginning and take all safety precautions required to do the job carefully and correctly.

The following instructions are intended for professional installers and are guidelines only. Speedtech Performance assumes no responsibility for the installation of any of its products installed by others. All products are intended to be installed by qualified professionals. If you have uncertainty, seek the assistance of a highly qualified workshop.

WARNING: Once assembled you will need a professional wheel alignment performed. Driving a vehicle without a proper alignment can be dangerous. Towing is recommended to transport the car prior to the alignment being performed. For basic rough alignment settings refer to the ExtReme IFS instruction guide.

1.2 OVERVIEW

These instructions outline the IRS sheet metal kit. Photos in the instruction process may vary slightly from your exact operation.

1.3 TOOLS

Installation of the Speedtech Performance IRS sheet metal kit can be done on the floor with simple hand tools and basic welder.

Tools to have before you start:

- Floor Stands
- Floor Jack
- Welder
- Grinder
- Measuring Tape

2.0 CHECK IN PARTS AND HARDWARE

[Back to Table of Contents](#)

2.1 CHECKING IN THE ORDER

Check in your order as soon as possible. To check in the order, Speedtech has provided a table which can be used as check list, as displayed in figure 2. All bolts and nuts are NF unless otherwise noted. Hardware comes in several boxes. If you discover anything missing from your order, call your authorized dealer as soon as possible.

2.2 CHECK IN TABLE

All bolts and nuts are NF unless otherwise noted.

Upper Control Arm

X	#	Description	Size
	1	Cabin Plate	
	1	Passenger Side Plate	
	1	Driver Side Plate	
	1	Trunk Plate	
	2	Seal Boots	

Figure 2: Check in table with amounts and descriptions

3.0 MOCK UP / INSTALLATION

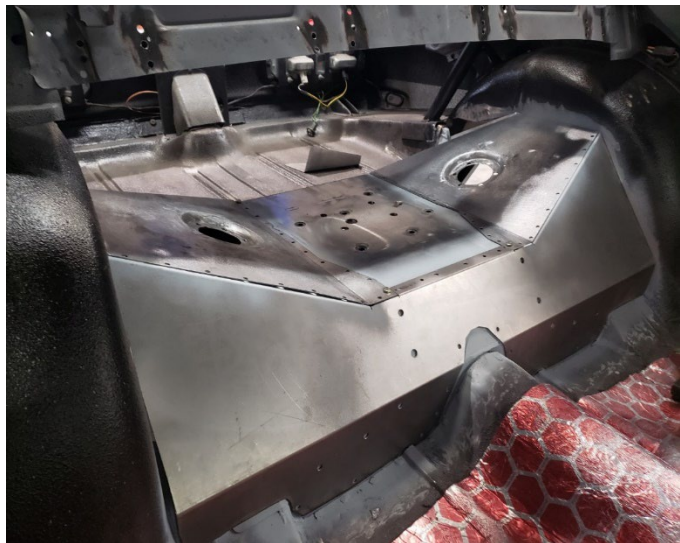
[Back to Table of Contents](#)

3.1 MOCK UP

Lay out the sheets with the cabin and trunk plates first.

Next, place each side plate. Hold in place with sheet metal screws or clecos.

Figure 3: Mock up



3.2 WELDING

You will want to do the plug welds and weld along sections of the floor, including where the plates meet up to the wheel tubs.

You will repeat this process for the top and back plates as well.

Figure 4: Welding



3.3 PACKAGE TRAY

Reattach the package tray brackets using the original drilled out plug weld holes.

NOTE: Your rear seat frame will require modification to install. Each application may vary depending on what interior you have as well as which enclosure option you choose.

Figure 5: Package tray



4.0 CONGRATULATIONS

[Back to Table of Contents](#)

Congratulations on completing your project! We know you will get many years of enjoyment from your project. Please join the group, [Team Speedtech](#), on Facebook. Team Speedtech is a community of customers, dealers, and factory employers that have a passion for pro touring muscle cars and are using Speedtech Performance products. You can ask questions and get advice from the group members and share your experience. Everyone enjoys seeing the videos and pictures during the progress of your project and Speedtech encourages you to share them!

Thank you for choosing Speedtech Performance and entrusting us with your IRS sheet metal for your custom muscle car.

Speedtech Performance, LLC
4160 S. River Rd.
St George UT, 84770
(435) 628-4300