



November, 2020

**Transmission Mount for Extreme Front Crossmember**  
For 62-67 Chevy II

**Installation Instructions**



**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. All must be installed by qualified professionals only.**

Thank you for purchasing your new Speedtech Torque Arm Rear Suspension System. Installing this product will require the removal of your old transmission crossmember. Take all necessary precautions whenever jacking up your vehicle and use safe and sturdy jack stands to support the vehicle whenever it is off the ground. Be sure to take all other safety precautions required to do the job correctly.

# Transmission Rail Hardware Kit Checklist

All bolts and nuts are NF unless otherwise noted

## Floor Attachment Rails

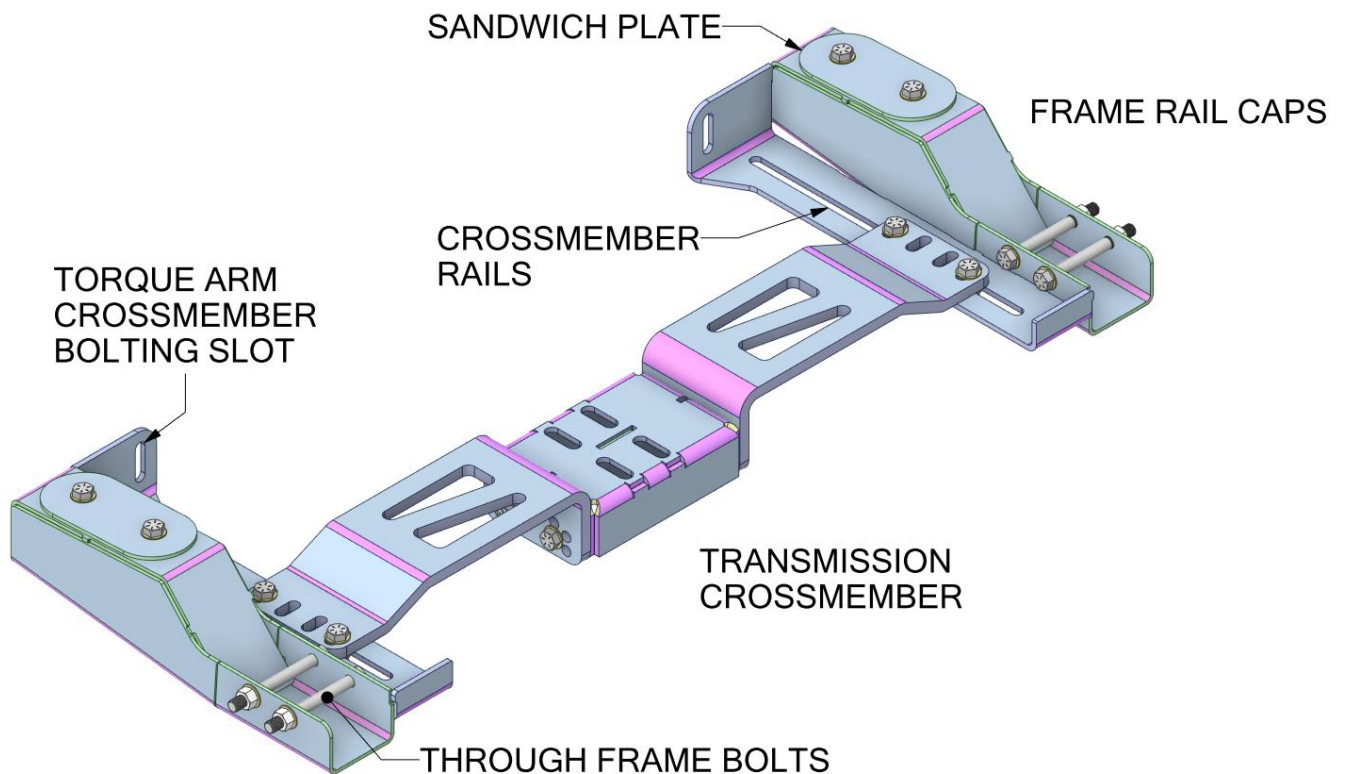
	2	Transmission Crossmember Rails Mirrored	Welded
	2	Sandwich Plates	
	4	Sandwich Plate Bolts	3/8" x 1"
	4	Sandwich Plate Nuts	3/8"
	8	Sandwich Plate Washers	3/8"
	4	Frame Rail Through Bolts	3/8" x 3-1/2"
	4	Frame Rail Through Nuts	3/8"
	8	Frame Rail Through Washers	3/8"

## Transmission Crossmember

	2	Crossmember Arms	Formed Plate
	1	Crossmember Box	Welded
	8	Crossmember Bolts	3/8" x 1"
	16	Crossmember Washers	3/8"
	8	Crossmember Nylock Nuts	3/8"

**Note: This kit requires approximately 10 minutes of welding time to install.** The upper rear cross member, lower arm mounted support brackets, torque arm cross member, and sub frame connector are permanently welded to the unibody. We highly recommend after trimming and fitment of the various components and before welding, that care is taken to protect all non-accessible surfaces. A quality weld through primer strategically places works well. After welding, finish the underside as desired.

**Assembly Overview:**



## Step 1: Prep

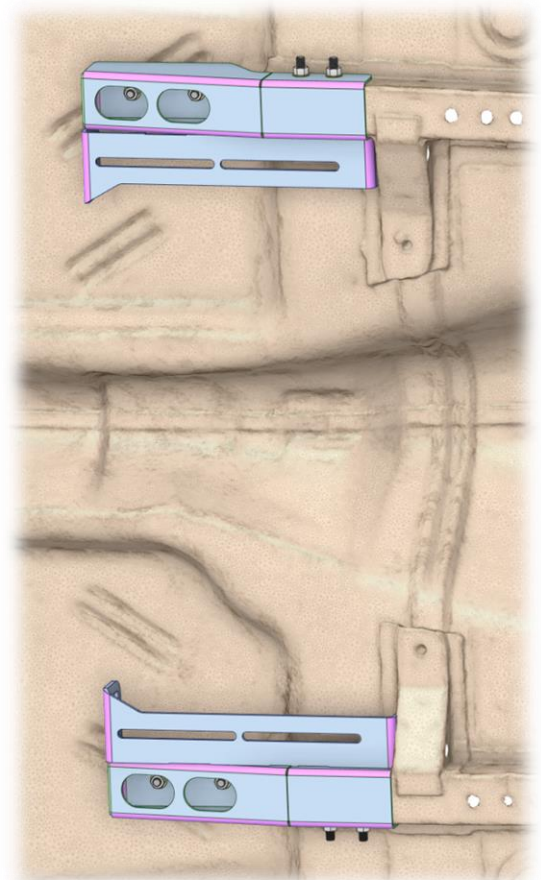
- Disassemble the stock transmission mount.
- Clean the underside floor surfaces, prepping it for cutting and welding.
  - Starting with the stock mount location, clean the frame rail on all sides back to where it ends.
  - Continue to clean the floor back behind the frame rail about 7"
  - Add 1/2" of cleared space on both sides of the frame rail.
  - Protect the exposed metal with a coat of weld through primer.
- Level the car above a level work surface. Measurements will be made off of the work surface and projected onto the car. Take time to avoid alignment problems later in assembly.

Note: There are a number of little stock brackets scattered throughout the underside of the car. These brackets at times will get in the way of any new system underneath the car. They will have to be cut out and removed as needed.

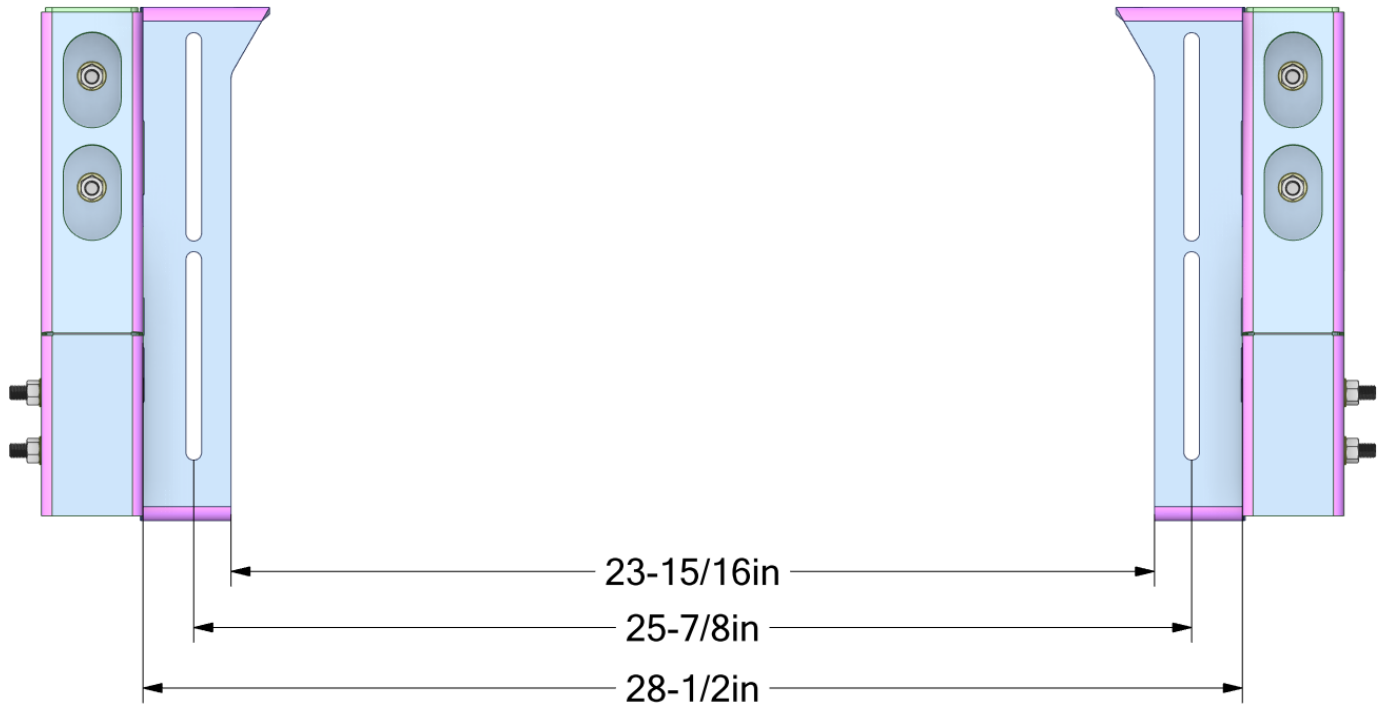
## Step 2: Crossmember Rails

Note: The two rails are installed separately. They are intended to be parallel with each other and hold a gap distance. There is some forgiving wiggle room with the assembly, but these rails need to be as square as possible.

- Dry fit up the rail pieces into the floor. The "C" channel wraps around the stock frame, bumping up to the stock mounting point.
- Mark the centers of the floor holes and the frame rail holes. There are holes on both sides of the frame rail.
- Drill out the holes to an oversized 3/8"
- Do the same to the other side
- Protect the raw metal on the rails that are in contact with the car with weld through primer.
- Loosely bolt the side rails into place.
  - Use the 1" Bolts to bolt through the floor and the sandwich plates.
  - Use the 3-1/2" Bolts through the frame rails.



- Take some time and measure, square, and center the rails to the car and to each other. Refer to the diagram.



- Once all measurements are satisfactory. Lock into place by tightening the bolts down.
- Option: Weld the new rails into place.
  - Stich along the floor where the welder can reach
  - Weld the front “C” channel to the frame rail.
  - Stich the inside sandwich plate to the floor.

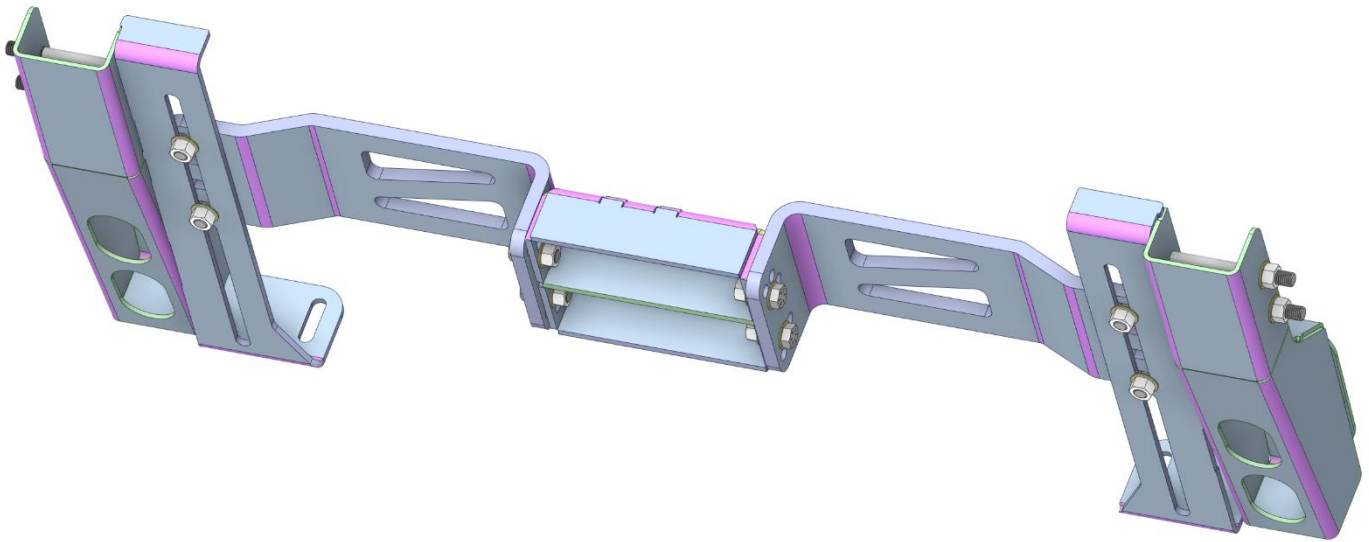


Note: Picture includes Torque Arm Crossmember.

### Step 3: Transmission Crossmember

Note: The transmission crossmember is a direct bolt on into the newly installed crossmember rails. The crossmember has many different adjustments built into it to fit whatever needs the project requires.

- Bolt the box to the crossmember arms using (4) 3/8" nuts and bolts.
- Lift and rotate the arms to land on top of the newly installed rails.
- Bolt into desired locations using (4) 3/8" nuts and bolts.
- Adjust as needed by moving the box up and down the mounting holes on the sides of the box.
- Once all locations have been set Torque bolts to 25 ft.lb.



This concludes the install of the Chevy II transmission rail. This product work as a standalone, or comes as part of Speedtech Performance ExtReme Front Crossmember (#\_\_\_\_\_) and ExtReme Torque Arm (#\_\_\_\_\_).

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