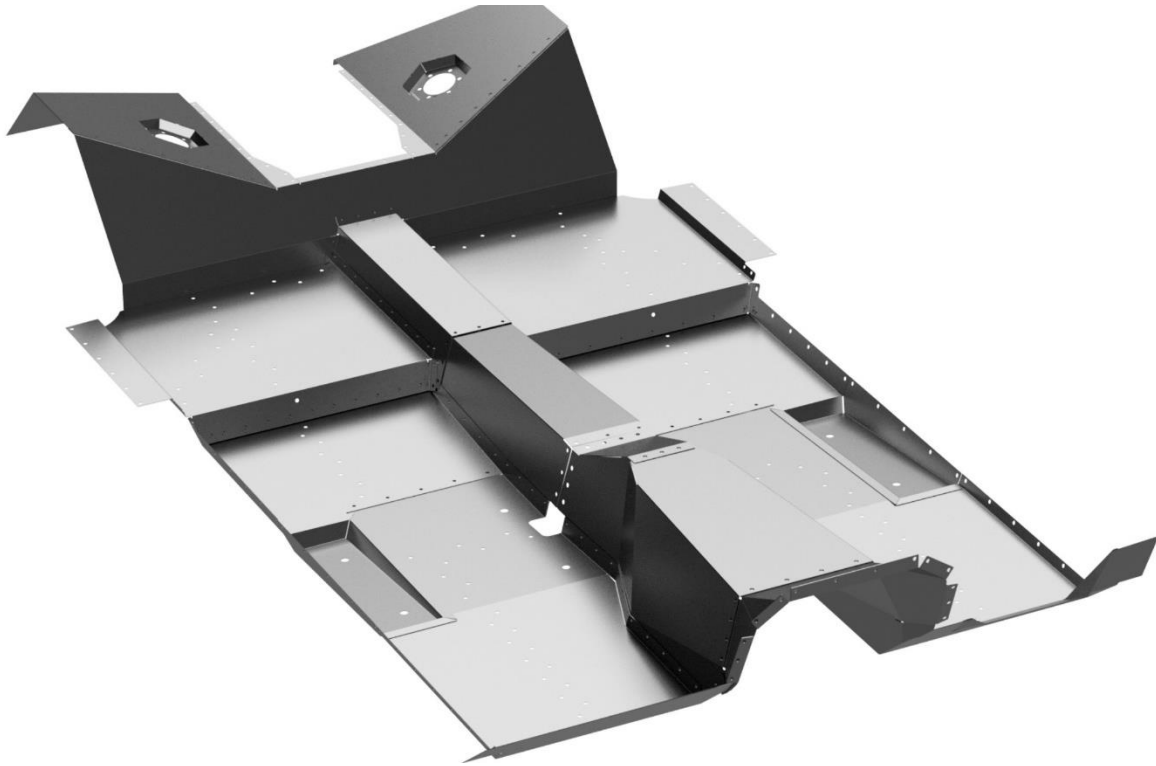


Instructional Guide

68-70 B-Body Mopar – Floor Sheet Metal Kit



Speedtech
PERFORMANCE

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

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Congratulations on the purchase of your new Speedtech Performance 68-70 Mopar B-Body Floor and IRS Sheet Metal Kit. Use only approved and appropriately rated jack and jack stands, be sure to take all safety precautions required to do the job safely and correctly. If you are unsure seek the assistance of a highly qualified workshop to assist you.

Read and understand all instructions thoroughly before you begin. For the most part, assembly and set up of your new 68-70 Mopar B-Body Floor and IRS Sheet Metal Kit can be done in a home garage with hand tools and basic welding equipment.

We enjoy seeing the progress our customers are making as they work through their builds so join the Team Speedtech group on Facebook and share your pictures and your story.

From everyone at Speedtech Performance we send you all best wishes for your project!

Installation Guide

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1.0 GENERAL INFORMATION

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1.1 This Guide

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.

1.2 Overview

These instructions outline the IRS Sheet Metal Kit for all cars that use a cradle IRS where the cradle is welded in to the unibody. Some photos in the install process may vary slightly from your exact application as this document covers Mopar B Body and others. Also, where parts meet each other, may be left long so you can fold over the edge or trim to make professional grade metal finish work for your project.

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:

- Welder
- Grinder
- Measuring Tape

2.0 CHECK IN PARTS AND HARDWARE

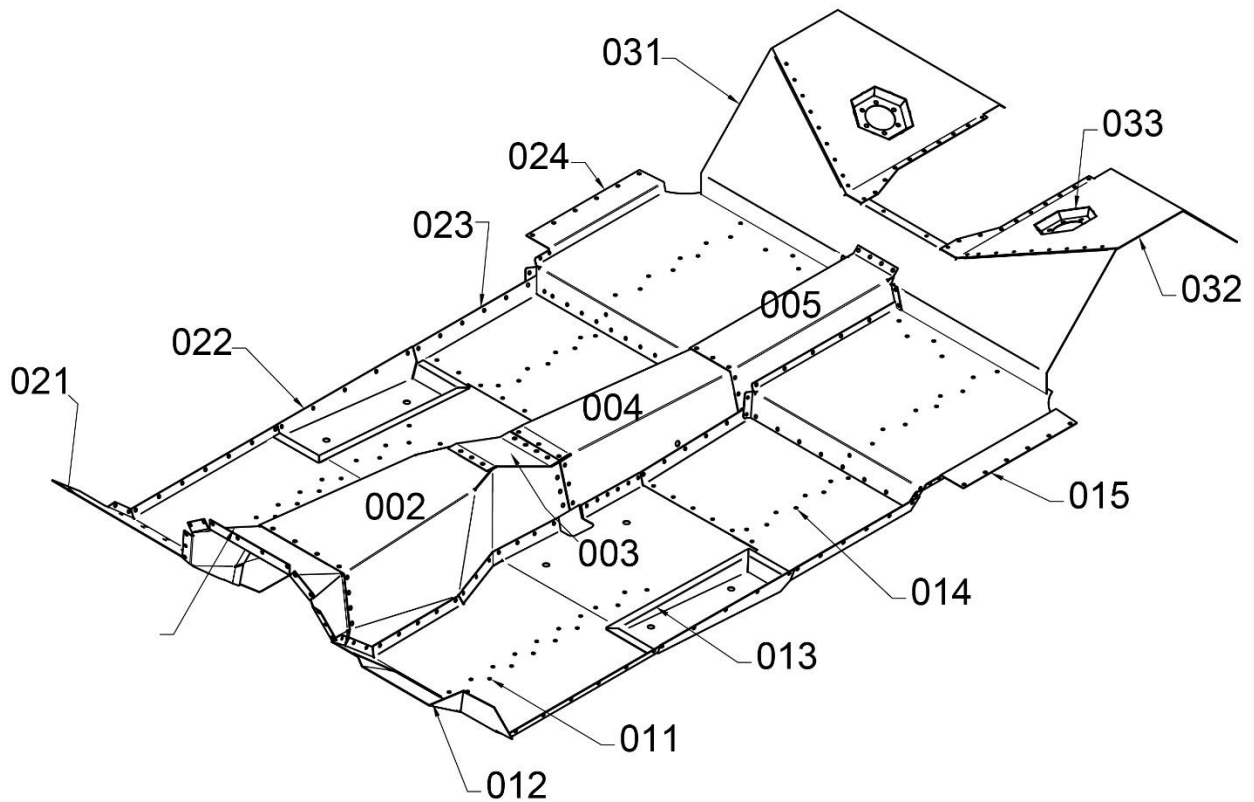
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2.1 Checking in the Order

Best practice will be to check in your order as soon as possible after receiving the order. To check in the order we have provided tables, these can be used as check lists for your order. The number will be etched on the piece and will appear similar to XXXXX – 001 – RO; use the middle number sequence.

2.2 Check in Tables

X	QTY	PART NUMBER	MIRRORED
	1	001	
	1	002	
	1	003	
	1	004	
	1	005	
	1	011	
	1	012	
	1	013	
	1	014	
	1	015	
	1	021	
	1	022	
	1	023	
	1	024	
	1	031	
	2	032	YES
	2	033	



3.0 PREPARATION

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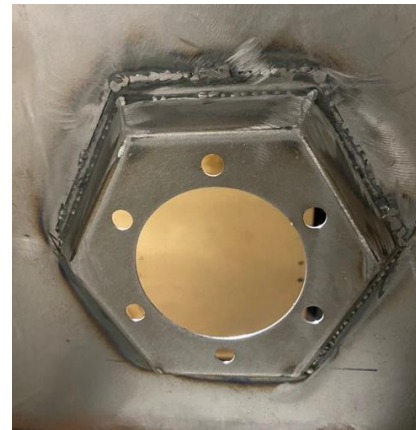
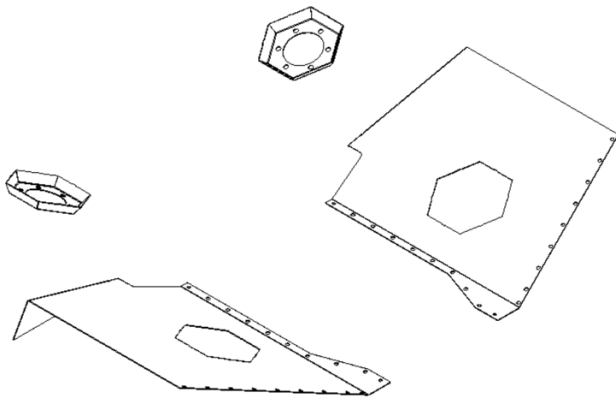
Install your choice of rear wheel tubs before you install the floor and tunnel to ensure proper fitment.

4.0 MOCK UP / INSTALLATION

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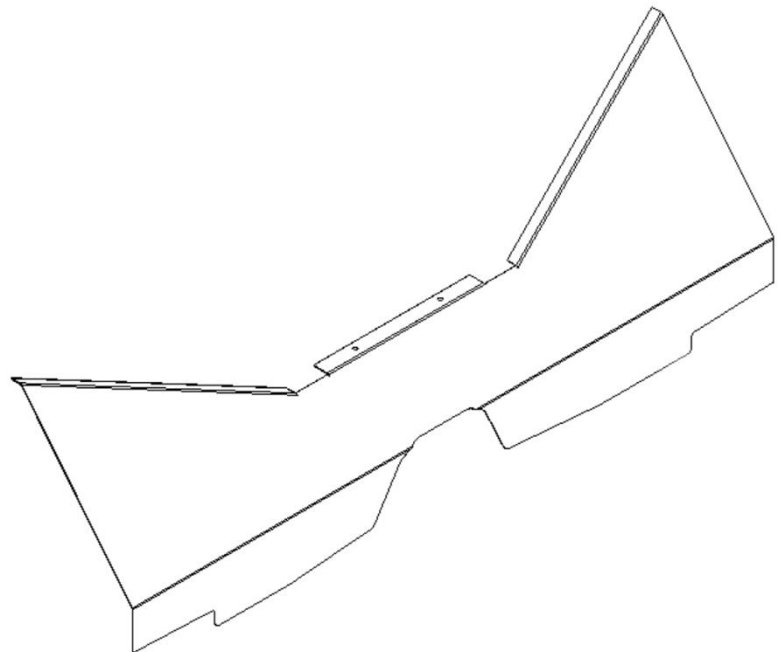
4.1 BOOT POCKETS

If you use our method for sealing the push rod to the side panel you will need to weld in the pockets to the right and left side panels.



NOTE: We learned this order was easier due to being able to access the IRS area easier.

Start by laying in the Front IRS Panel, it should lay in against the front of the IRS cradle and but up against it nicely. There are two ¼ inch holes in the IRS Cradle that will line up with holes in the Front Panel, you can drop a bolt or dowel in temporarily to help hold the part in position. You will need to trim the sides of the panel around your mini-tubs, the top and bottom should fit to the IRS Cradle perfectly. Additionally, some welds on the **CHASSIS** may need to be ground down for best fitment.



4.2 IRS MOCK UP

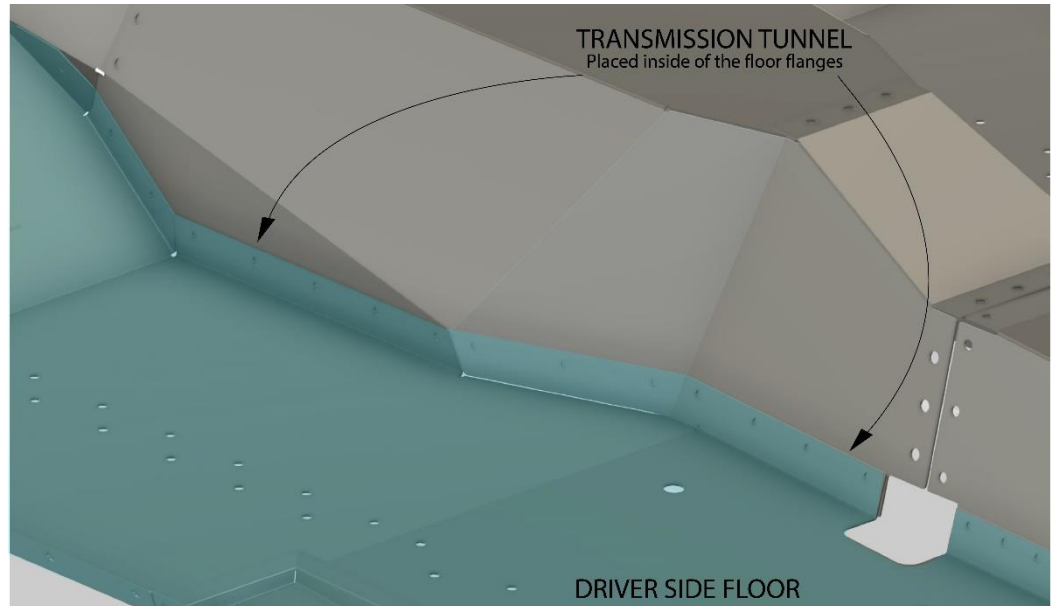
The Left and Right-side pieces have been left long and will need to be trimmed around your mini tubs. There is a 1/4" hole in the corner at the front and rear that will meet up with the 1/4" holes in the IRS top plate. You can install a 1/4" bolt as a pin to hold in the part place once trimmed to your satisfaction. You will also want to add some holes in the Front Plate to weld the Front Plate to the IRS Cradle.



4.3 FLOOR/TUNNEL MOCK UP

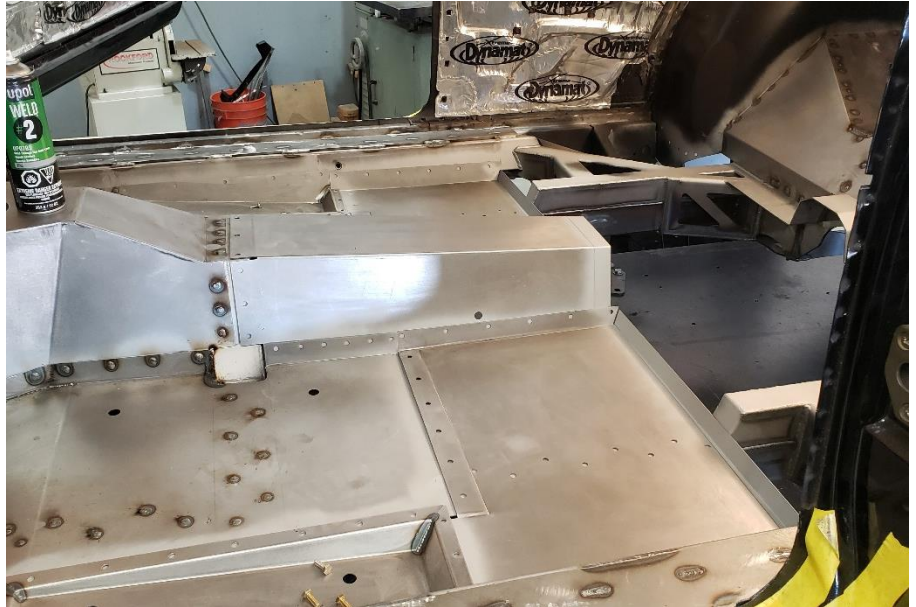
Lay the floor in place to ensure proper fitment, starting at the firewall and working towards the IRS.

When mocking up the tunnel, note that the tunnel will fit **INSIDE** of the pre-bent flange to prevent moisture pooling. You will need to mock-up the location of the transmission and cut to fit.



4.4 Weld in the Sheet Metal

With everything laid out and once you are satisfied with the fit, weld in the kit. When welding, do one rosette and move to a cool location for the next weld. Similarly on the edges, stitch an inch and move to another area that is cool. This will help minimize warping of the panels. We recommend smoothing the welds out before priming and finishing.



4.5 Finish

When installing the floor in complete and the welds are smoothed out, finish to your preference. This kit will most likely require a custom cut carpet kit due to the side of the transmission and heightened driveline tunnel.

NOTE:

Your rear seat frame may require modification to install around the new mini tubs. Each application may vary depending on what interior you have as well as which enclosure option you choose.



5.0 CONGRATULATIONS

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Congratulations on completing this part of your project, we know you will get many years of enjoyment from your car with this modification. Please join the group [Team Speedtech](#) on Facebook. Team Speedtech is a community of like-minded individuals using Speedtech Performance products. The Group's members include customers, our dealers and factory employees - each with a passion for Pro Touring muscle cars. You can ask questions and get advice from the group members as well as share your experience. Within the group we enjoy seeing the videos and pictures during the progress of your projects so post up. We also encourage you to share pictures and videos of your finished projects out on the road, at the show & shine, on track or however you get enjoyment from your ride, we want to see it!

Thank you for choosing Speedtech Performance! We know you have a choice, and we appreciate that you entrust us with your chassis and suspension needs for you custom muscle cars.

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