



## 79-04 Mustang Upper Torque Box Doubler Kit

#327401

**\*\*\* FULLY READ INSTRUCTIONS BEFORE INSTALLATION \*\*\***

1. Drill existing holes in upper torque box to 5/8".
2. Notch frame rail as shown below, using red lines as a guide (Pic 1). Grind marked area as needed for drill fixture clearance (Pic 2).

Pic 1



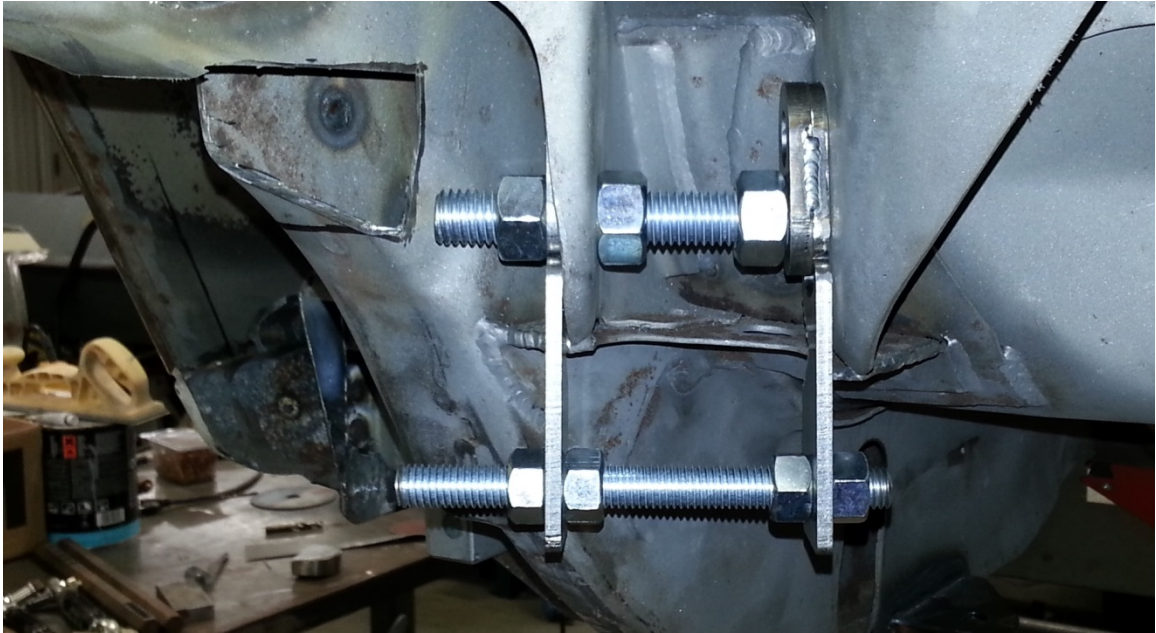
Pic 2



3. Assemble drill fixtures as shown below using nuts and threaded rod. The  $\frac{1}{4}$ " spacers face each other with the notches forward. One fixture is attached on the outside of the torque box while the other is on the inside (Pic 3).

NOTE: The fixtures must be parallel! Adjust nuts on threaded rods as needed, then snug inner nuts.

Pic 3



4. Swing top of fixture forward to a vertical angle of  $80^\circ$ , relative to the rocker panel. (The new hole should be  $10^\circ$  further forward than the existing stock hole.) Measure angle as shown below (Pic 4).

\*\*\* Picture below is only to be used as reference for how to measure, it does not show correct value!!! \*\*\*

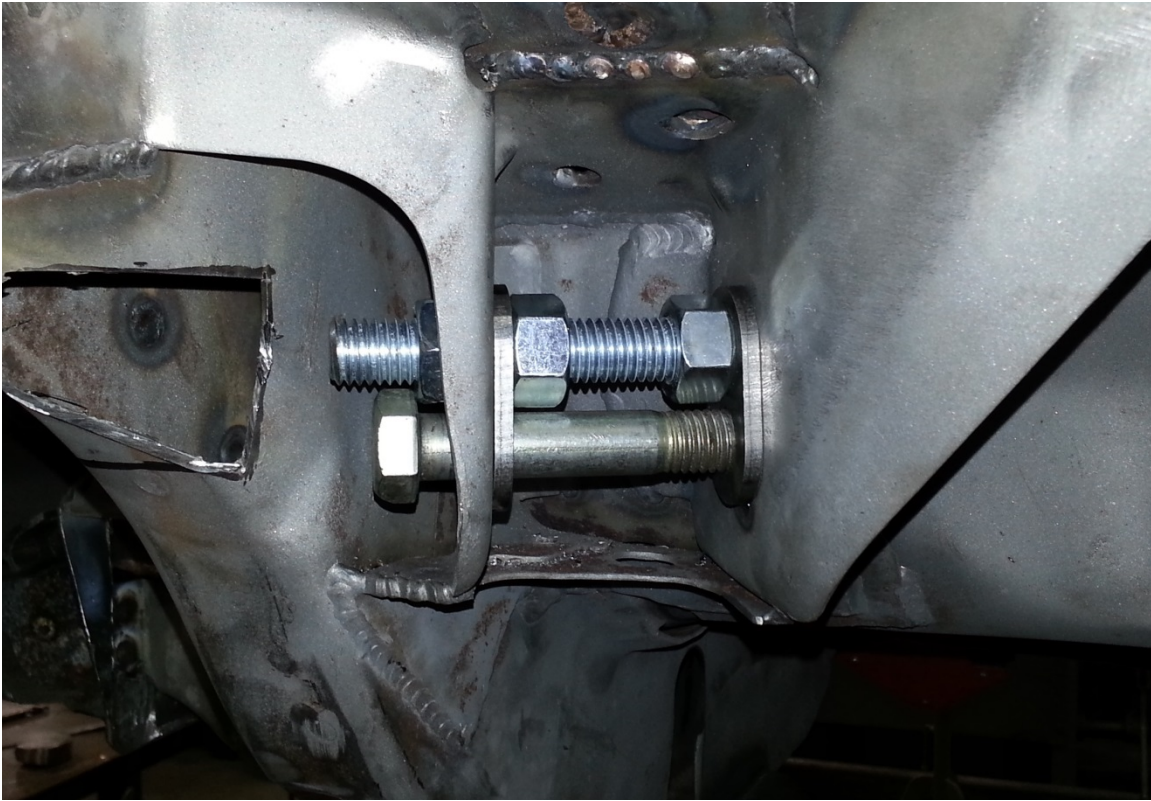
Pic 4





5. Drill upper holes.
6. Remove fixture and use 5/8" threaded rod and a 5/8" bolt to locate doublers on inside of torque box as shown below (Pic 5).

Pic 5



7. Tack doublers into position and fully weld after removing threaded rod and bolt. You will also want to weld the notch back in as shown on the left side of the picture below (Pic 6).

Pic 6



8. Bushings need to be installed as shown below (Pic 7) Short bushing to the outside, long bushing to the inside.

Pic 7

