

# **HOTCHKIS**

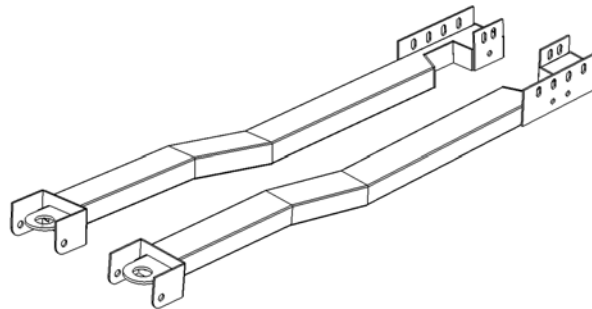
## **4007 (Coupe) / 4008 (Convertible) Subframe Connectors 67-69 Camaro/Firebird**



**Thank you for your purchase from our new line of F-Body parts.  
Please call us at (877) 4NO - ROLL if you have any questions  
regarding the service or installation of your Hotchkis products.**

### Subframe Connectors:

Your new subframe connectors will increase the overall rigidity of your chassis and improve handling and response. These engineered components connect the rear frame rails with the front subframe to simulate a complete full frame chassis.



### Notes:

The subframe connector is essentially a Weld-In component, effectively connecting itself to the front subframe and rear frame rails. However, you may choose to bolt-in the front connection to allow front subframe removal if need be. Hardware for the bolt-in procedure is included.

### Before You Start:

The installation of these subframe connectors will require you to grind and weld. It is recommended that a trained professional install this product. Always wear eye protection when grinding or welding. Please read the entire manual before starting. All images will depict the driver side installation.

## 1. Raise Vehicle

It is best to install the subframe connectors at ride height. To do this properly, please use a 4-Post lift or alignment rack. Disconnect the negative battery cable.



## 2. Replace Subframe Body Mount Bushing

Your kit comes with 2 new polyurethane front subframe body mount bushings. Having proper bushings will ensure correct fitment of the subframe connectors.

Remove stock bushings.



Install Hotchkis bushings.

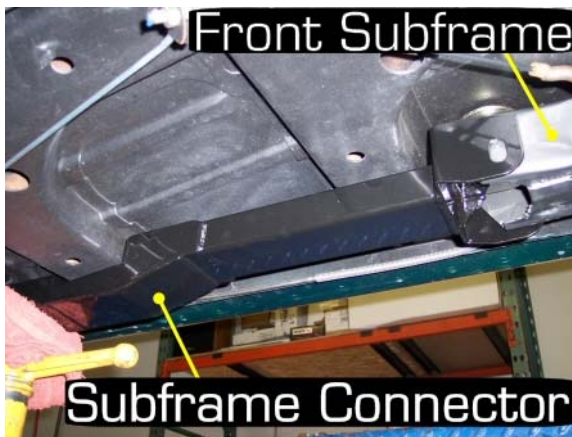




### 3. Mock up Subframe Connector

Preparation is needed before any welding can begin. First, decide whether you will be welding in the connector to the front subframe or bolting it in.

Install the subframe connector using the provided 5/8" bolt and the thick washer. Use a transmission jack to hold the rear end of the connector up. Fully tighten the 5/8" bolt to see where the connector will position itself. Make sure the rear end of the connector is butted up against the rear frame rails. This mock-up should simulate how the connector will be mounted on the vehicle.

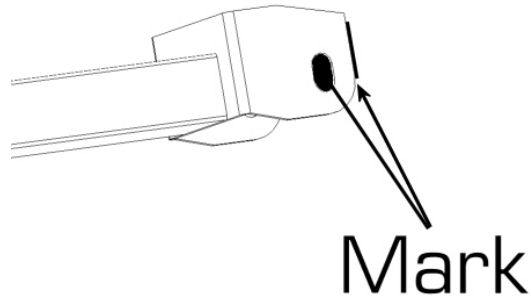


Bolt-In: Mark the front subframe to indicate where your bolt holes will be.

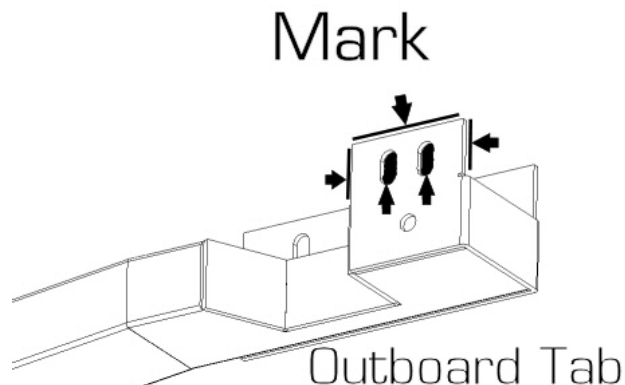
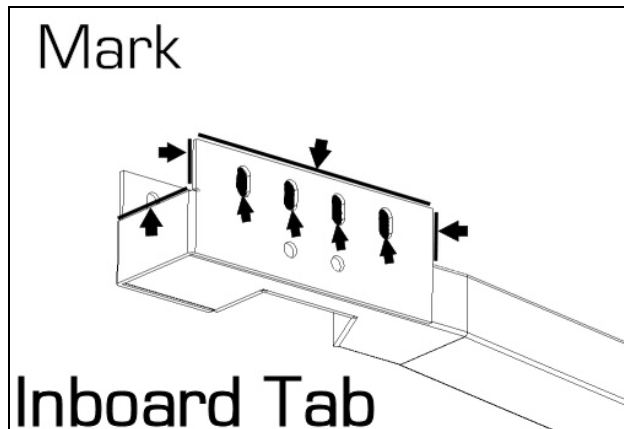




Weld-In: Mark the front subframe to indicate where you should grind/sand the paint for welding. The connector hole will allow you to apply a rosette weld instead of a bolt. You may also want to mark where the leading edge of the connector lies on the subframe so you can run a weld bead there as well.



Mark the rear frame rails along the edge of the connector. This will show you where to grind the paint/grime off the frame. Don't forget the outboard tab. This area will be difficult to access since the leaf spring and bracket are in the way.

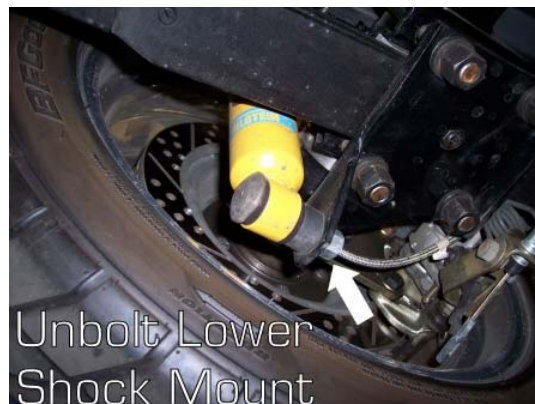


The Outboard Tab will need to be bend inward for a tight fit. Do this by using large channel locks and squeeze the tab in. Leaf Spring Bracket will need to be detached. See next step.



#### 4. Prepare mounting points for welding/bolting

Remove the connector and start grinding/sanding the paint and grime off of the vehicle's frame rail. Unbolt the leaf spring bracket & lower shock mount and raise the vehicle to access the outboard tab area for grinding. You will have to move the brake and fuel line out of the way. Remove any tube clamps necessary to achieve this.



Bolt-in: At this time you can drill a 1/2" hole in the designated mark made earlier on the front subframe. A right angle drill may work the best for this situation.



Weld-in: Grind/sand near the designated area marked earlier on the front subframe.

#### **5. Prepare Subframe Connector for Welding.**

Grind around all rosette holes on the connector. Grind/sand anywhere on the connector that is going to be welded. Use a "rat tail" file to take the paint off the inner surface of the rosette holes. If you are welding the front, make sure to sand near the 1/2" holes and front edges.





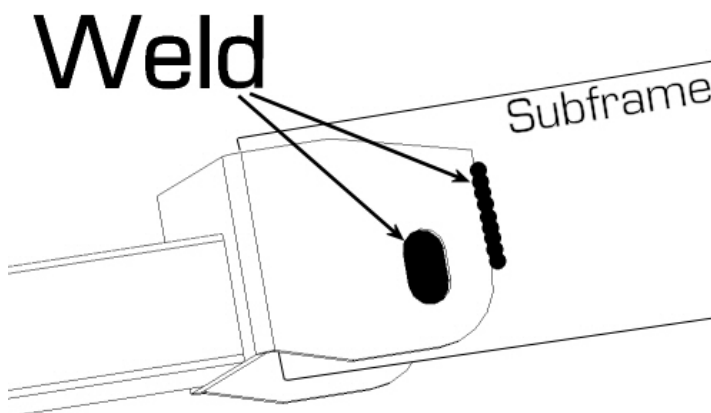
**6. Install the Subframe Connectors onto the Vehicle**

Make sure the vehicle is returned to ride height. Reinstall the connector like before. Fully tighten the 5/8" subframe bolt and use the transmission jack to hold up the rear end of the connector.

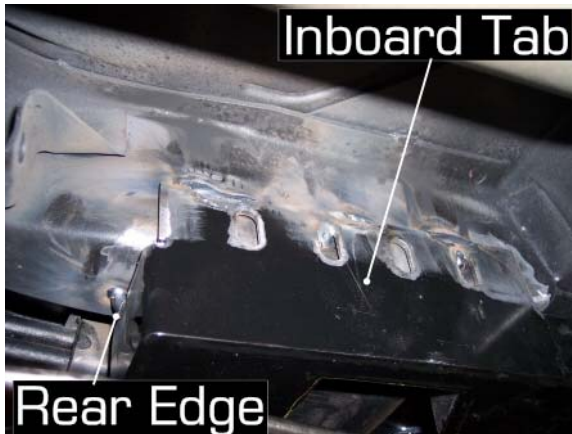
Bolt-in: Install the 1/2" bolts in subframe holes as shown in the picture. Fully tighten these bolts at this time.



Weld-in: Rosette weld the front hole on each side. Weld a bead along the leading edges of the connector.



Tack weld 2-3 of the rosette holes on the inboard tab to the frame rails. Tack weld the rear edge of the connector. Once you have these minimum welds complete, you may raise the vehicle again to access the outboard tab. Completely weld both rosettes and any edges. Lower the vehicle back on it's wheels and finish the inboard rosette welds and remaining edges to be welded. To protect the brake line (driver side) and the fuel line (passenger side) from the welding radiation and sparks, cover them with aluminum foil.



Outboard Tab







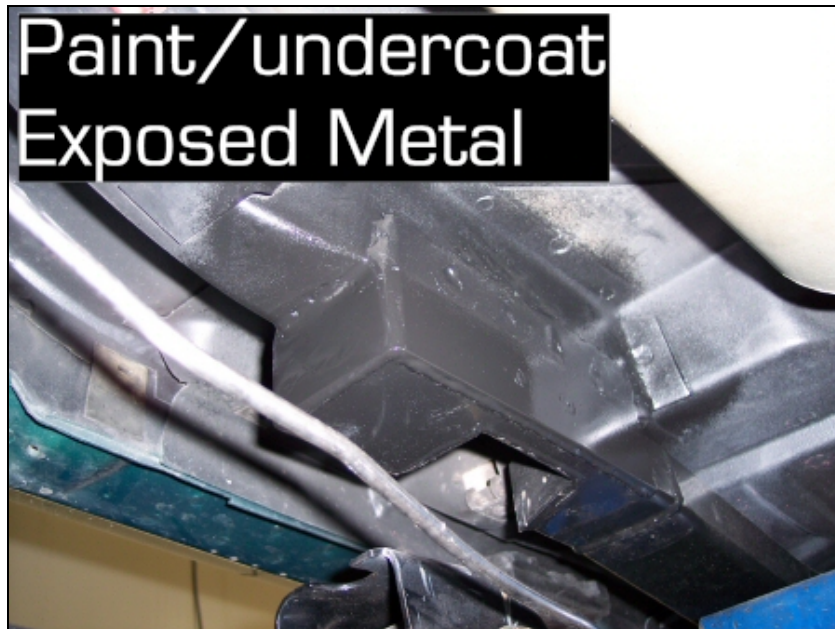
## Finish The Rest of the Welding

### 7. Optional Metal Finishing

Depending on how pretty your welds turn out, you might want to grind down any “high” welds or weld mistakes before proceeding any further.

### 8. Paint the Exposed Metal

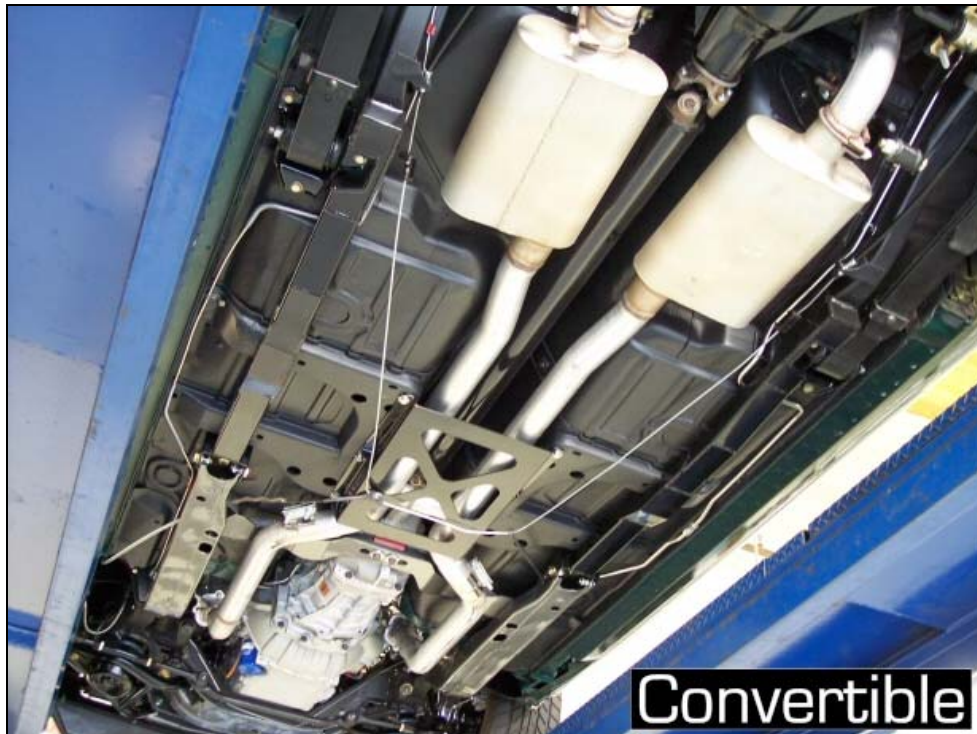
You may use any paint or undercoat you wish to coat the exposed welded/grinded areas. We recommend Duplicolor’s Truck Bed Coating. This coating has the perfect texture and color for this project. It is up to you on how and where you want to mask off for the coating.



## Paint/undercoat Exposed Metal

### 9. Reattach Everything

Reattach your brake line and fuel lines. Fasten the 3 bolts on each leaf spring bracket. Reattach the lower Shock mount. Double-check to make sure all hardware is fully tightened.





## HOTCHKIS PERFORMANCE WARRANTY POLICY

**Effective January 1, 2000. Supersedes all previous policy statements. Policies are subject to change without notice. Hotchkis Performance is not responsible for printing errors.**

If you purchased your Hotchkis Performance product from an authorized dealer, you are covered by the terms of this policy. All claims however, must be submitted **THROUGH YOUR DEALER** not to Hotchkis Performance directly.

### Return Policy:

We want you to be completely satisfied with your Hotchkis Performance product. In case you're not, you can exchange or return it within 30 days of the purchase date. To obtain a full refund, excluding freight, please contact our Customer Service Department at (562) 907-7757. You will be assigned a Returned Goods Authorization Number (RGA). The package you return must show the RGA on the outside of the package, include the original invoice and be shipped prepaid to our facility. The part has to be in its original packaging materials and be in a sellable condition. For parts presenting signs of use, only warranty claims will be accepted. Exchanges or refunds can be made after 30 days with a 20% restocking charge.

### Warranty Claim:

Hotchkis Performance warrants its products against materials and workmanship failure for the term of 36 months (3 year) from the date of purchase and only up to the amount paid. If the product is determined to be defective, Hotchkis Performance will repair, replace or refund its value at Hotchkis Performance's discretion. Any repaired or replaced product will be returned to the sender freight prepaid.

### How to File a Warranty Claim:

The answer to ALL the following questions should be **YES** before contacting our Customer Service Department.

- Is the part appropriate to your application?
- Did you carefully and thoroughly read the instructions provided along with the part?
- Do you have the proof of purchase?
- Are you the original purchaser?
- Is the part unmodified and clean?
- Is the return date within 36 months from the purchase date?
- Is the reason for return a legitimate product defect?

**If the answer to all these questions is YES, please contact our Customer Service Department at (562) 907-7757. You will be given a Returned Goods Authorization Number (RGA) valid for 60 days. You will also be asked to ship the part prepaid to our facility. All shipments MUST be prepaid, include the original invoice and show the RGA on the outside of the package, otherwise it will be refused. Please include a brief explanation letter in order to expedite the warranty analysis process.**

### What doesn't this Warranty Cover?

The costs not covered by this warranty include but are not limited to:

- Removal, installation, shipment and insurance costs.
- Improper installation or maintenance.
- Misuse or abuse, negligence, off-road and/or racing applications.
- Damage to related components.
- Normal wear and tear.
- Costs incurred due to down time of vehicle.
- Alterations on the original design or unauthorized repairs.

**Items offered but not manufactured by Hotchkis Performance are warranted according to the manufacturers terms and are not the responsibility of Hotchkis Performance.**

**All warranties implied by law are limited in duration of this warranty. You have specific rights that may vary from state to state.**

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