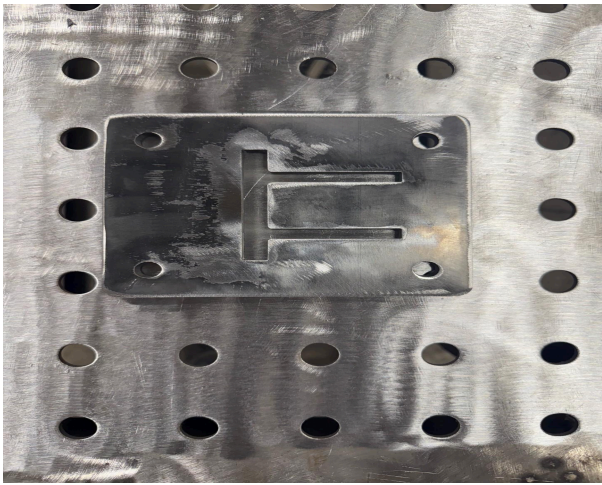


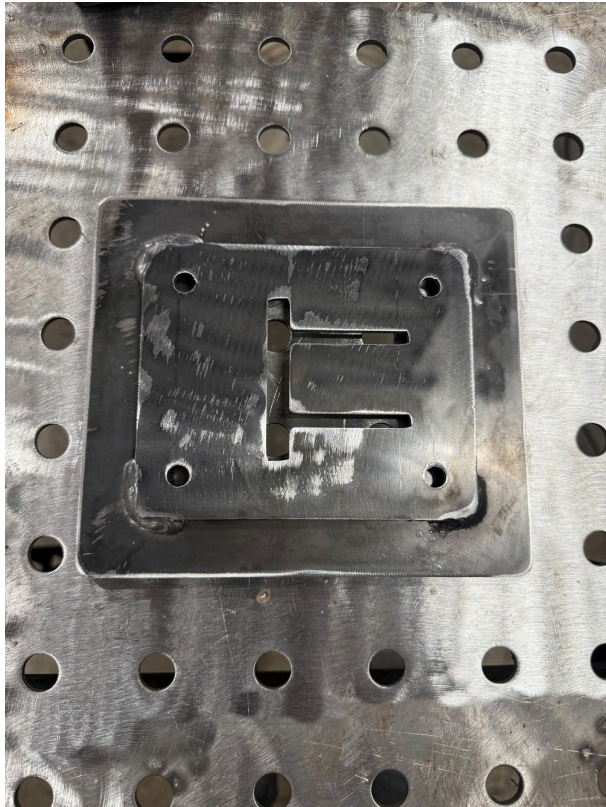
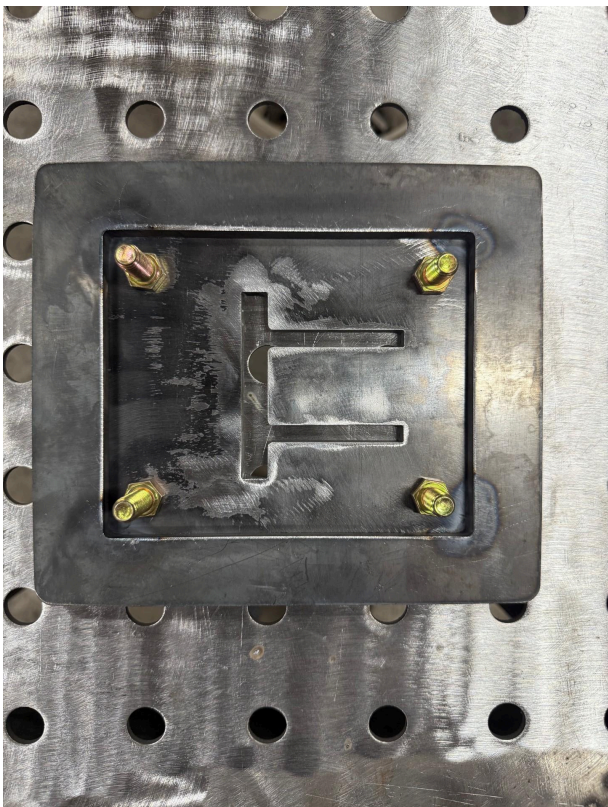
Step) 1

Prepare steel for welding by cleaning corners and removing mill scale around welded areas.



Step) 2

Following the orientation of attached pictures add the beauty ring to the base plate and tack in two corners, this will be the bottom. (hint: perimeter of beauty ring is about perfect to a 1" ruler and can make quick work of finding center) Then weld in four corners or area of your choosing. Ensure you verify bolt spacing for tools used to tighten down into the base, on the side that faces up. Example: using a ratchet and socket to tighten bolts.



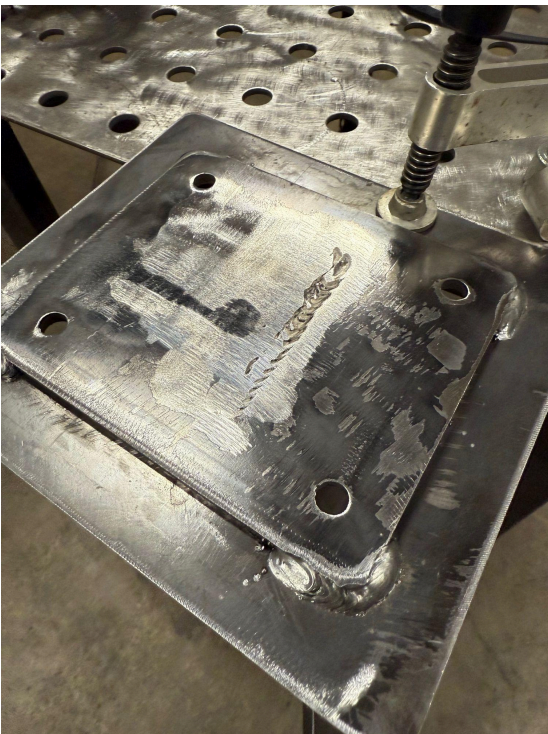
Step) 3

Place the vertical riser and gussets down into the slotted base (note that the unit will “lean” towards the driver, and back as if you were sitting in the driver's seat). Once that angle is satisfied, tack in slots.



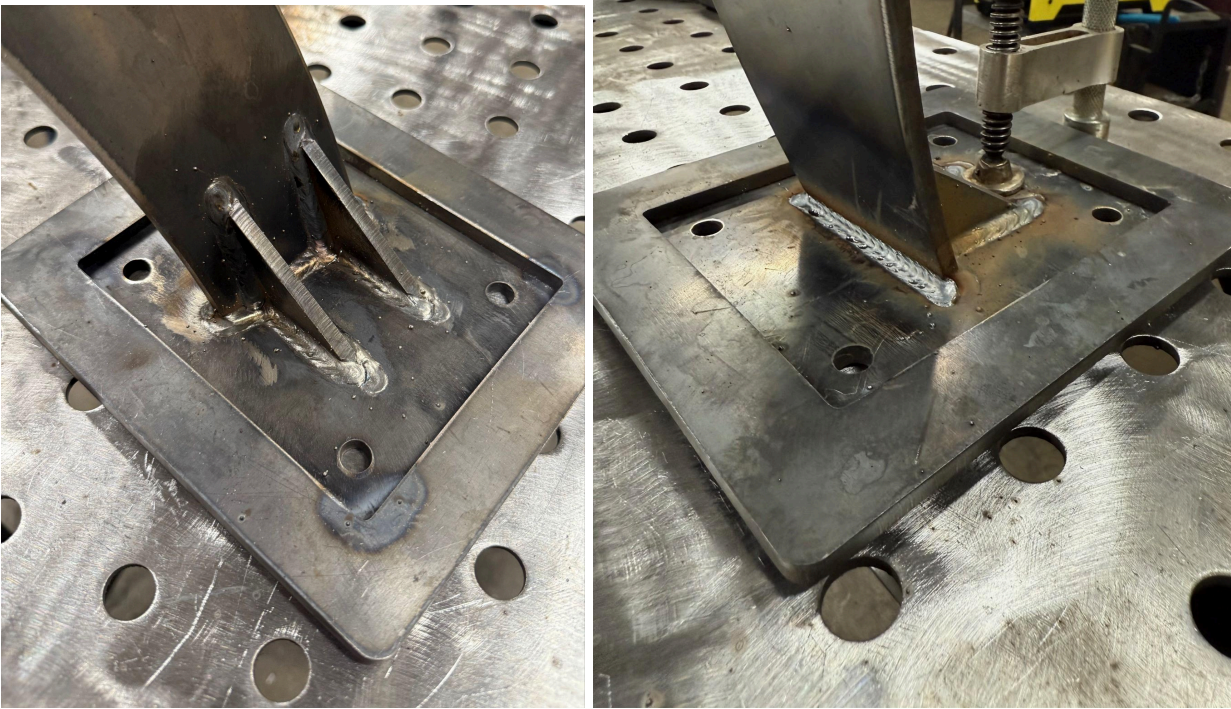
Step) 4 (optional but aids in unit staying stationary while welding later)

Flip assembly over to the bottom and fully weld the base slots from the underside as the tacks hold everything together from the top, then grind flat as this sits against the floor.



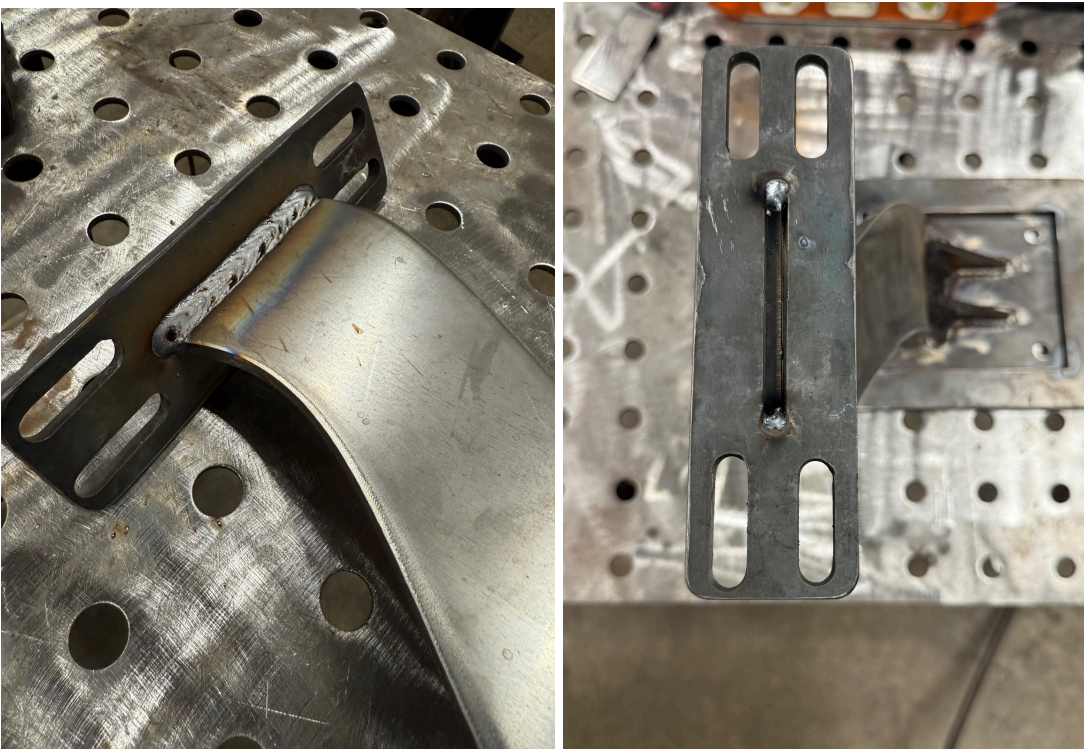
Step) 5

Proceed to fully weld the gussets and vertical riser.



Step) 6

Assuming you are welding these on a leveled table (or not) zero out your level, (or check your bubble) to that surface in the X and Y plane and tack the shifter mounting plate to match. Once you have that out of the way fully weld the top side and check your level once again. If you find yourself needing to go one way or the other flip bracket and weld the underside corner in the direction you need it to pull to. (in some cases you can use shop compressed air to then cool your weld down faster and get it to “pull” straight) Proceed to let it cool some, then weld the remaining side.



Step) 7

Then finally grind down the mating surface of the shifter mounting plate.

