



## *Squaremax Transmission Xmember Installation*

*'73-'87 C / K Series & '88-'91 R / V Series*

*Revision 00 ( 08/06/18 )*

### *Package Contents*

- *(1) Transmission Xmember*
- *(1) HD Polyurethane Transmission Mount*
- *(4) M10x1.5x35mm Flange Head Bolts*
- *(4) M10x1.5mm Flange Head Lock Nuts*

### *Tools Required*

- 1. Framing square*
- 2. Tape measure*
- 3. 3/8" or 1/2" corded or cordless drill*
- 4. 13/32" center punch*
- 5. 13/32" drill bit*
- 6. 5/8" countersink or burrwhip*
- 7. 15mm box end wrench / 15mm socket x 3/8" drive*
- 8. 3/8" ratchet*
- 9. Torque wrench*

## *Notice*

*First of all we would like to take a moment and thank you for your recent purchase and support! Thanks to you kind folks we have been successful following our dreams of creating this amazing powertrain conversion.*

### *Transmission Xmember Installation*

- 1. Remove OEM transmission crossmember and discard.*



- 2. Please note our Transmission Xmember has been designed to rest on the inside of the "C" channel of the frame rails with the flanges pointing upward just like the '81-'91 OEM transmission crossmembers did. This does not only provide maximum ground clearance but also is a full-proof mechanical connection for the Transmission. Lastly it positions the frame rails to the proper location so they are parallel to each other and perpendicular to the ground.*
- 3. If your vehicle is a K or V Series, please note that the Transmission Xmember will work with either driver side or passenger side drop transfer cases.*
- 4. We will be designing a drill template to place on the lower side of the frame rail and bolt into position using the OEM fasteners. The template will have multiple hole patterns so please read carefully and double check before drilling. Until this template is completed use a framing square to make sure the Transmission Xmember is square prior to center punching the holes and drilling. You can double check your work by taking a few measurements with a tape measure. Center punch and drill the (4) four holes that correspond with the transmission*

*being used. Drill the (4) four 13/32" (.406" diameter) holes in the lower flange of the frame rails.*

- 5. Install transmission and support with floor jack.*
- 6. Spread the frame rails apart using a Porta Power hydraulic jack or suitable device. Remember to wear safety glasses or goggles when performing this task and spread the frame rails SLOWLY.*
- 7. Insert the Transmission Xmember and Polyurethane Transmission Mount at a 45 degree angle between the frame rails with the driveshaft tunnel pointing down. Twist the Transmission Xmember into position and release the pressure of the Porta Power hydraulic jack or suitable device.*
- 8. Lower transmission onto HD Polyurethane Transmission Mount and fasten using the (2) two OEM transmission mount bolts. Torque using the provided Torque-Tension chart to determine proper bolt torque.*
- 9. Install the (4) four M10 x 1.5mm x 35mm Flange Head Bolts and fasten with the M10 x 1.5 Flange Head Lock Nuts. Torque using the provided Torque-Tension chart to determine proper bolt torque.*

