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## Weld On Frame Repair Instructions, '67-'87 ('91) Chevy 4WD Fullsize Trucks

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1. Raise front of truck and place on jack stands. Remove driver's side tire/wheel. Unbolt drag link assembly and disconnect draglink from pitman arm, the pitman arm itself can remain attached.
2. Next unbolt steering shaft linkage from steering box. Disconnect the power steering hoses. Remove the steering box from the frame.
3. If the frame is cracked, drill a hole at the end of the crack. Grind a "V" shaped groove down the length of the crack and weld it up, then grind the weld back flush with the frame.
4. Secure large 7-hole plate to outer frame rail at steering box location by aligning four raised holes in plate with bolts. Check to make sure plate sits flush and level against the frame. If necessary, clamp plate to frame rail to hold flush and tight against rail and/or apply heat/hammer plate to flatten as needed.
5. After plate is flush to frame, weld plate **ONLY IN AREAS SHOWN** to frame. See Illustration 1 below. **DO NOT WELD ENTIRE CIRCUMFERENCE OF PLATE.** Now weld remaining three holes in plate for additional bonding.

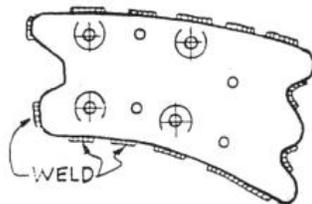


ILLUSTRATION 1

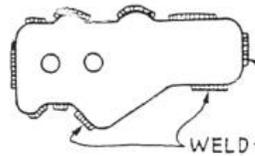


ILLUSTRATION 2

**\*\*Illustration may not exactly match parts, but will give you the general idea to stitch on/off and not weld the whole perimeter\*\***

6. Take remaining plate (two holes) shown in Illustration 2 and place on **underside** of frame; aligning holes in plate with rivets on bottom side of frame. Clamp plate flush to frame and into position and tack weld on inside and outside of plate where clamped. Remove clamps and tack weld at each end of plate. Then weld in areas shown in Illustration 2.
7. Install steering box to frame, torque steering box bolts to 80 ft. lbs. Install power steering hoses and attach steering column rag joint to steering box. Torque flange nuts to 25 ft. lbs.
8. Install draglink onto pitman arm, install driver side wheel/tire, then remove jack stands from beneath truck. Lower truck to ground and check power steering fluid level for proper level; add fluid if necessary. Installation is complete.