

MFK 1000 Frame Kit 1979-2004

Congratulations on your purchase of the Griggs Racing Products MFK 1000 Frame Kit.

Completely read instructions before beginning!

Remove entire interior from car. Rear seat may be left in if covered to protect from welding spatter.

1. Raise car to a comfortable work height and support with jack stands. **Important: Place jack stands evenly under rear axle and front "A" arms. This will place the chassis at its normally loaded state.**
2. Place sub frame connector up against sub-frame rails with the rear of the connector even with the rear lower control arm bolt. Mark its contact area front and rear and remove. Repeat this step for the other side.
3. Using a hand grinder with a soft sanding (not grinding) disc or a wire brush, remove all paint within one inch of area to be welded.
4. Position connectors against car once again and tack weld.
5. If TorqueArm is being installed, bolt brackets to Torque Arm cross member and check for correct fit. L-shaped brackets should fit snugly against sub frame connectors. Adjust position if necessary.
6. If cross member fits properly finish welding connectors to car. Do this in a well-ventilated area, as gases produced during welding can be harmful.
7. Paint exposed metal with a quality rust resistant paint.
8. Using a stiff putty knife, scrape off sound deadener from all areas to be cut or welded as shown in **Figure 1**. Lay parts in car to determine where to scrape. If the sound deadening material is difficult to remove, a little heat applied to the underside with a space heater or a propane torch helps.
9. Lay rear bulkhead plate against rear seat bulkhead and mark contact area. Sand off paint within 2" of areas to be welded.
10. Install bulkhead plates being sure to weld all holes and entire perimeter of plate. Small triangle gussets go in outside lower corners. **CAUTION: 99 and later vehicles have parking brake cables directly behind the bulkhead. Welding may damage them, so remove or shield cables before welding.**
11. It is a good idea to weld the perimeter of the flanges on end of rear sub frame that meet the rear seat bulkhead. If installation is on a T-Bird, look under car at the forward end of the rear sub frame and you will see that the sub frame does not meet the rear seat bulkhead. There is about a 1/2" gap. The 3" angle braces will connect the rear sub frame to the rear seat bulkhead underneath the car. Lay braces vertically on either side of each rear sub frame and mark contact areas. Sand off paint within 2" of marks, and weld securely. Paint.
12. Locate front sub frames inside car. This can be done by finding the spot-weld marks along the floor. Measure forward from the rear bulkhead and mark floor at 45.5" (48.5" T-Birds).
13. Cut across front sub frame channel at the shorter measurement 45.5" (or 47.5" on T-Birds). Cut along sides of sub frame channel starting from the longer measurement of 46.5" (48.5" on T-Birds). This is to leave a 1" flap to cover end of 2x2 tube once installed. Cut channel out all the way to the rear end of front sub frame. Hole should just be 2" wide. Try to maintain a tight fit, as it will make welding it all together much easier. Bend the remaining 1" flap up at the front square to floor. This will then be welded to the 2x2 frame tube after insertion, capping it. **CAUTION: Be careful not to cut fuel or brake lines under floor on passenger side.**
14. Lay 2x2 tube into sub frame channel and slide it back to rear seat bulkhead. Mark and make cuts in areas required as shown in figure 6. Mark raised portion of floor that Torque Arm cross member sits under. Trim humps just until 2x2 tube sits all the way down in channel.
15. Remove 2x2 tube and sand paint off all areas to be welded.
16. Place tube back in channel and check fit at rear bulkhead grind to fit if necessary. Be sure to position end with angle cut towards back. Weld all seams possible; under tube at rear is not necessary. Trim "C" shaped sheet metal pieces to fit top of slot in front seat rail hump, and weld in place.
17. The 2 pieces of 2x3x1/8 flat go between upper and lower connectors in the channel where the Torque Arm cross member goes. Lay them against the sides of the upper and lower connectors and weld in. This will provide a very secure mounting point for the Torque Arm Cross member.
18. Seal up any holes left with silicone. Paint any exposed metal with a quality rust resistant paint and re-install interior. Be creative when it comes to rear carpet. Trim around tube to leave it exposed or just lay on top.

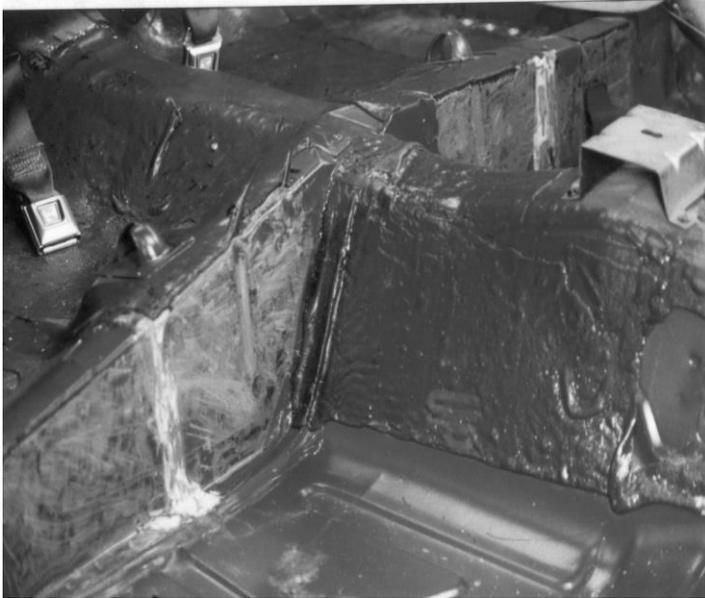


Figure 1



Figure 2



Figure 3



Figure 4

**Cut Floor Up
To Crease**

**This will be the
front end of
Sub-Frame**

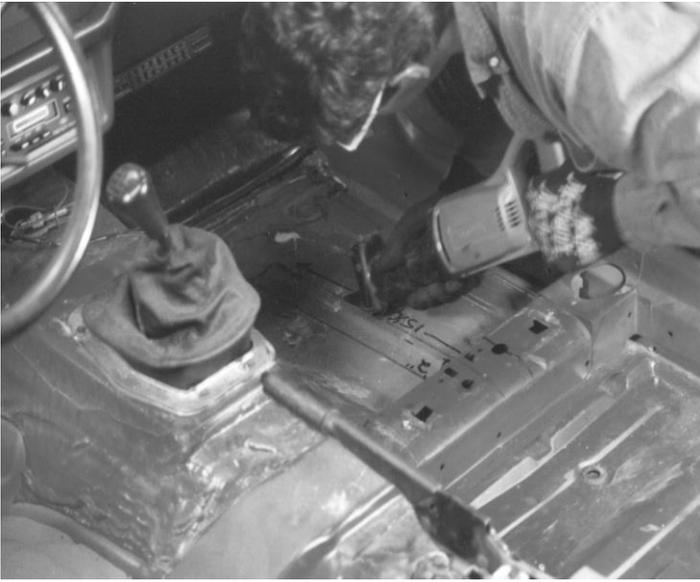


Figure 5



Figure 6



Figure 7

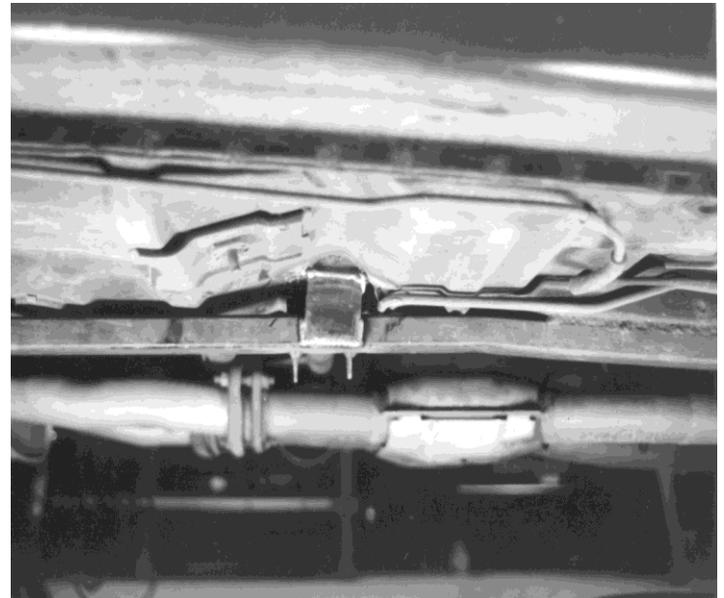


Figure 8