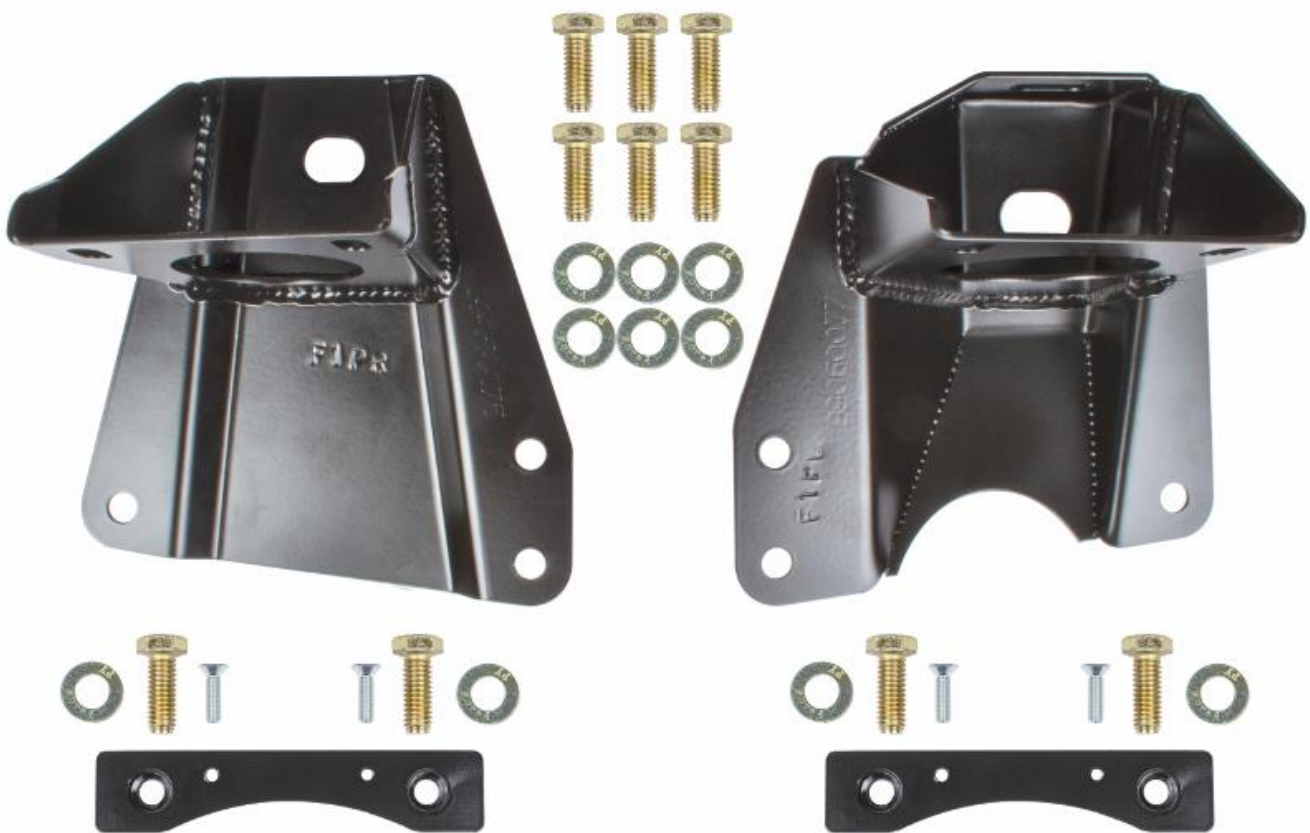




Detroit Speed
1967-69 Firebird Pontiac Engine Mount Kit
DSE Hydroformed Subframe
P/N: 060412DS

The Detroit Speed Pontiac Engine Mount Kit provides an ideal mounting solution for installing a Pontiac engine into the Detroit Speed Hydroformed Subframe for the 1967-69 Firebird. This kit comes complete with powder coated frame side engine mount stands, nut plate assemblies and hardware.



Item	Description	Quantity
1	Frame Stand, LH & RH	2
2	Engine Mount Nut Plate Assembly	2
3	3/8" - 16 x 1" L Hex Head Bolt	10
4	3/8" Flat Washer	10
5	10-32 x 3/4" L Flat Head Cap Screw	4
6	Instructions	1

NOTE: 1967-1969 Pontiac engine mounts are required when installing the Detroit Speed Pontiac Engine Mount Kit in the Detroit Speed Hydroformed Subframe.

NOTE: If you have purchased a powdercoated, assembled Detroit Speed subframe, you will need to unbolt the lower control arms from the subframe as well as the lower shock bolts attached to the lower control arms. At this point, the entire corner assembly will swing away from the crossmember.

Installation:

1. Attach the frame stands (#1) to the subframe. Install three of the provided 3/8 - 16 x 1" L bolts (#3) along with three 3/8" flat washers (#4) per side and tighten (Figure 1). There is a left- and right-hand frame stand.

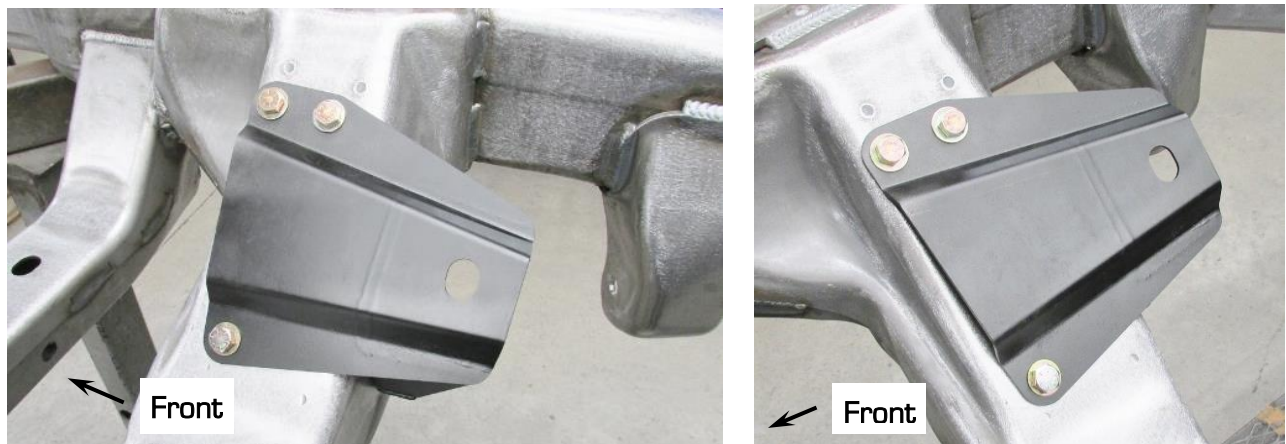


Figure 1 - Bolt Engine Frame Stands to Subframe

2. Using the frame stands as a template, mark the two slotted hole locations to the back side of the primary subframe crossmember on both sides. Remove the frame stands from the crossmember (Figure 2).

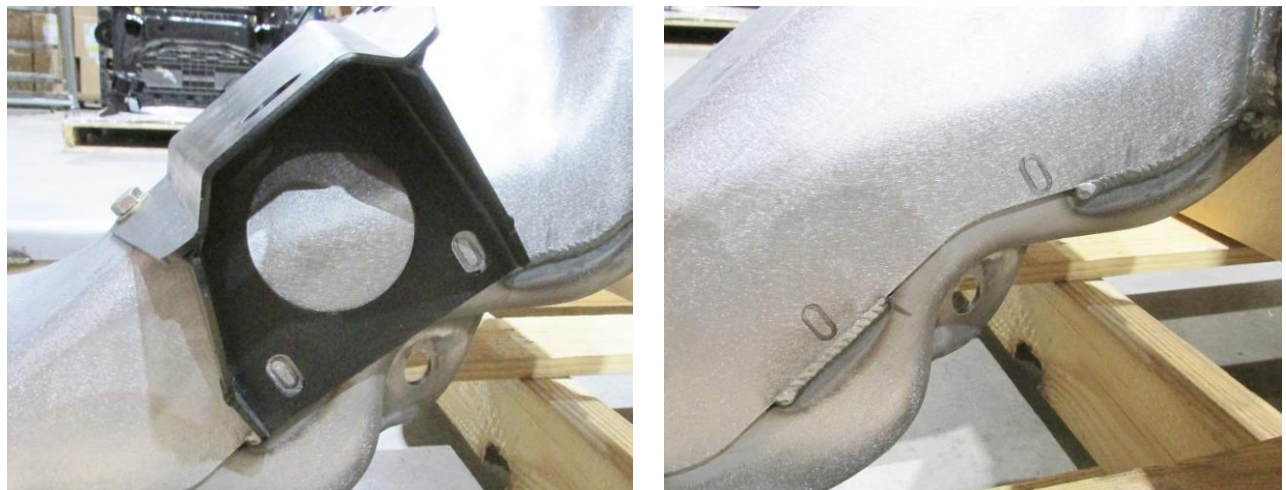


Figure 2 - Mark Drill Locations

3. Create a center mark in all four marked slot locations. Start with a pilot drill and drill four holes on the back of the crossmember. Finish with a 13/32" drill size (Figure 3 on the next page). Chamfer the holes as needed.



Figure 3 - Drill Frame Stand Holes

4. Next install the 3/8"-16 hardware into the provided nut plate assemblies (#2). Make sure the bolts thread into the weld nut side of the assemblies (Figure 4). **NOTE:** The nut plate assemblies are uncoated in the instruction pictures.



Figure 4 - Nut Plate Assembly

5. Install the nut plate assemblies into the holes that were drilled in Step 3. While holding the nut plate assemblies in place, transfer punch the locations of the two smaller holes to the back of the crossmember (Figure 5).



Figure 5 - Transfer Punch Holes

- Remove the nut plate assemblies and center punch the transferred hole locations. Start with a pilot drill and drill four holes on the back of the crossmember. Finish with a 7/32" drill size (Figure 6).

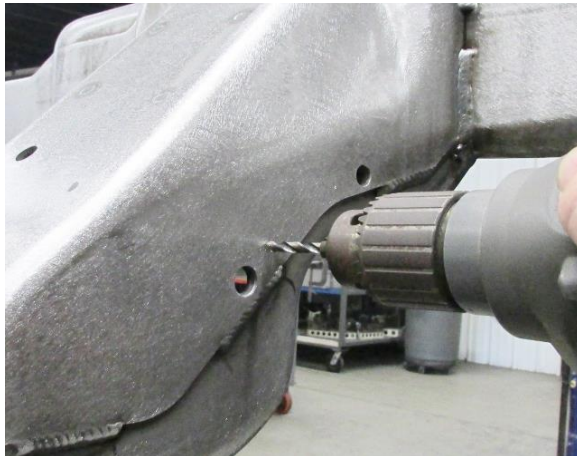


Figure 6 – Drill Nut Plate Holes

- Install the nut plate assemblies on the inside of the crossmember thru the lower control arm mounting holes. Install the provided 3/8"-16 hardware to hold the nut plate assemblies in place. Test fit the four provided 10-32 x 3/4" L flat head cap screws (#5) into the nut plate assemblies (Figure 7). **NOTE:** If the bolts do not install easily, you may need to open up the hole sizes in the crossmember as needed.



Figure 7 – Test Fit Drilled Holes

- Once the bolts install easily, remove the 10-32 hardware. Countersink the 7/32" holes so that the 10-32 flat head screws are flush with the crossmember. (Figure 8).



Figure 8 – Countersink Nut Plate Holes

9. With the 3/8"-16 hardware holding the nut plate assemblies in place, use medium strength blue Loctite 242 on the threads of the 10-32 flat head screws. Install and tighten these screws into the nut plate assemblies.
10. Remove the 3/8"-16 hardware from the crossmember. Place the left- and right-hand frame stands on the crossmember. Install five 3/8"-16 x 1" L hex head bolts and 3/8" washers to hold each frame stand to the crossmember. Torque to 35 lbf-ft. (Figure 9).

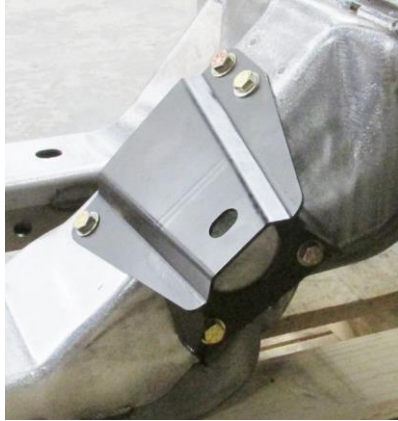


Figure 9 – Finished Installation

11. Installation is now complete.

If you have any questions before or during the installation of this product, please contact Detroit Speed at tech@detroitsspeed.com or 704.662.3272

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