

QA1
GO DRIVE IT.



**QA1 65-79 FORD F100/F150 ENGINE MOUNTS
INSTALLATION INSTRUCTIONS: 7740-251/252/253/254**

WELCOME TO QA1!

OUR COMMITMENT

Congratulations on your purchase of this high-quality QA1 65-79 Ford F100/F150 Engine Swap Mounts assembly. It is engineered to the highest standards, utilizes the finest materials, and is built with exceptional craftsmanship and attention to detail.

While we understand your eagerness to start your build, please remember that your safety is our utmost priority. Always use an approved and appropriately rated jack, jack stand, or automotive lift, and take all necessary safety precautions to ensure the job is completed safely and correctly.

Before you start, read and understand all instructions thoroughly. If you are unsure of your abilities during the assembly or installation and need some help or have any uncertainties, please seek the assistance of a qualified mechanic or automotive repair shop.

If you have any product questions or need guidance, please don't hesitate to call and speak with QA1 Technical Support & Sales at 952-985-5675.

Remember, we're here to support you every step of the way and are committed to ensuring your assembly and installation process is successful and enjoyable. We wish you all the best!

BEFORE INSTALLATION

Before you begin the QA1 Ford F100/F150 engine swap mount installation, it is crucial to read and understand these instructions carefully. If instructions are not correctly followed, personal injury, equipment, or product damage can result.

Products that have been installed are not eligible for returns. To prevent mistakes, thoroughly read these instructions before you start the engine mount installation procedure. A good automotive repair manual from your local auto parts store can aid with this task.

Wear the appropriate personal protective equipment (PPE) during assembly and installation.

Follow the manufacturer's instructions for safe use when working with power tools, and be cautious and responsible in your work.

ABOUT THIS MANUAL

PURPOSE

These instructions provide guidance for installing the QA1 engine swap mount kit for 1965-1979 Ford pickups when using a QA1 front suspension system.

This document covers standard engine options as well as swap engines, which may require additional components for proper installation. These components can include engine mount isolators, engine mounts, oil pans, and headers or exhaust systems. A list of the additional parts used during the design and testing phases is included in this document.

ITS CONTENTS

The information that follows is described in this instruction set:

- Required tools and supplies.
- Safety, hazard, and warning rules.
- Product overview and included parts.
- Installation and the setup procedures required for use.

Pages with images will have paragraphs and sentences with callout numbers that refer to their respective images, steps, and parts.

Procedures, once described in the text, are generally not repeated. When it is necessary to refer to another procedure, the page and step reference will be given.

REQUIRED TOOLS AND SUPPLIES

- SAE Wrench Set
- SAE Socket Set
- Torque Wrench (lb-ft)
- Red Loctite Threadlocker
- QA1 F100 Front Suspension Conversion system.

SAFETY FIRST

- Work on your vehicle in an appropriate location.
- Park your car on a level surface.
- Use wheel chocks to prevent vehicle roll.
- Check your owner's manual for the correct jack lift points.
- Always support your vehicle with jack stands.
- Wear personal protection like safety glasses and gloves.
- Never use compressed air to clean brake dust from brake and/or suspension components.
- Dispose of damaged or old parts in accordance with local laws. Do not throw any hazardous waste in the trash.

CONTENTS

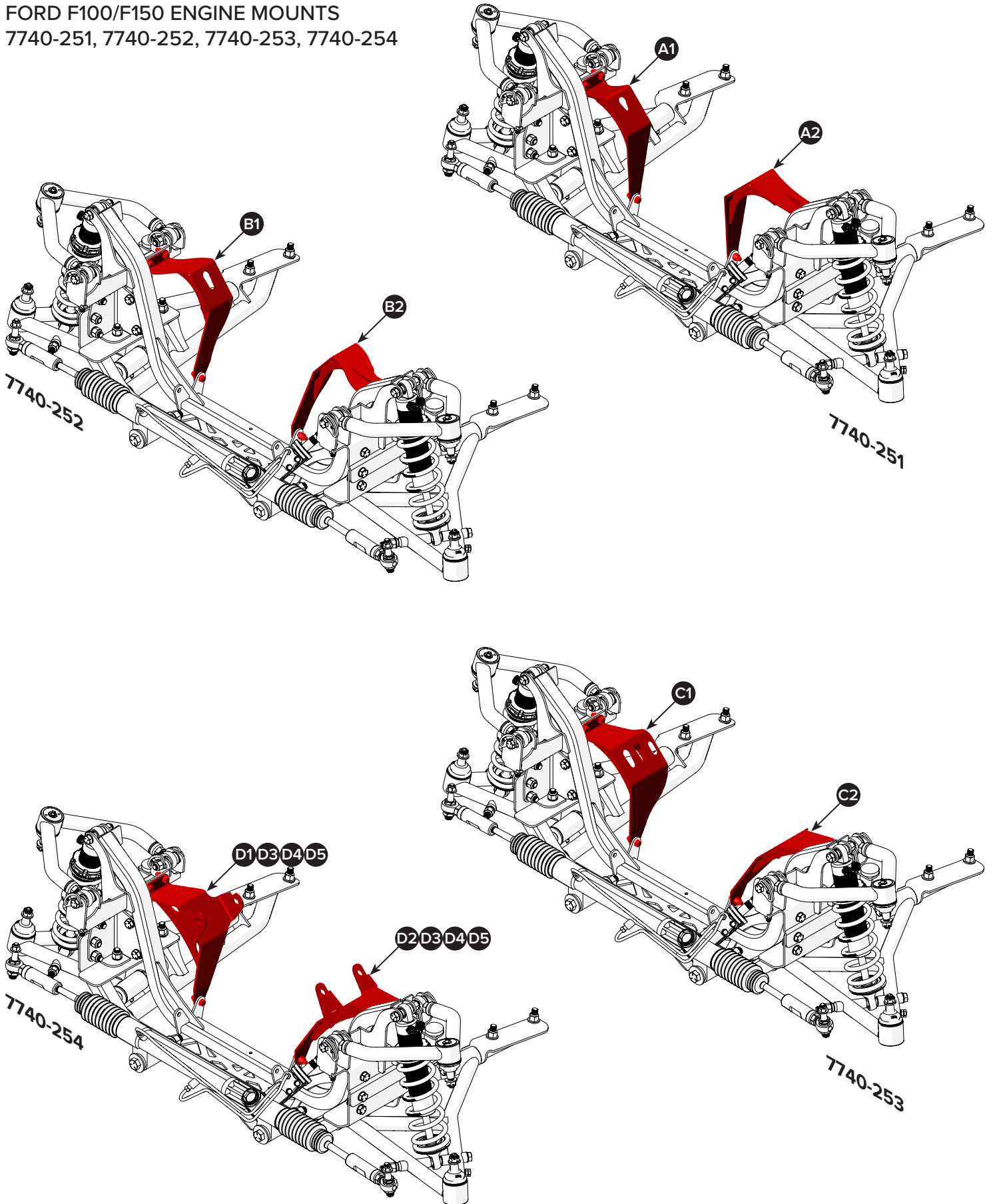
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FORD F100/F150 ENGINE MOUNTS
7740-251, 7740-252, 7740-253, 7740-254



FE ENGINE MOUNTS-7740-251

POSITION	PART NUMBER	DESCRIPTION	QTY
A1	9039-300	FORD FE ENGINE MOUNT, RH <i>(See installer's note)</i>	1
A2	9039-275	FORD FE ENGINE MOUNT, LH <i>(See installer's note)</i>	1

Use OE replacement style engine isolators or mounts for 65-70 360/390 FE Series engines with this kit.

WINDSOR and 429/460 ENGINE MOUNTS-7740-252

POSITION	PART NUMBER	DESCRIPTION	QTY
B1	9039-280	FORD WINDSOR, 429, AND 460 ENGINE MOUNT, RH <i>(See installer's note)</i>	1
B2	9039-274	FORD WINDSOR, 429, AND 460 ENGINE MOUNT, LH <i>(See installer's note)</i>	1

Use OE replacement style engine isolators or mounts for 302/351W engines or Trans Dapt 4226 conversion mounts for 429/460 engines.

MOD/COYOTE ENGINE MOUNTS-7740-253

POSITION	PART NUMBER	DESCRIPTION	QTY
C1	9039-294	FORD MODULAR AND COYOTE ENGINE, RH <i>(See installer's note)</i>	1
C2	9039-295	FORD MODULAR AND COYOTE ENGINE, LH <i>(See installer's note)</i>	1

Use OE replacement style engine isolators or mounts for 96-04 Mustang 4.6L engines with this kit.

LS ENGINE MOUNTS-7740-254

POSITION	PART NUMBER	DESCRIPTION	QTY
D1	9039-292	CHEVROLET LS ENGINE, RH	1
D2	9039-293	CHEVROLET LS ENGINE, LH	1
D3	9012-208	HEX HEAD BOLT, M12-1.75 x 140 mm	6
D4	9005-280	FLAT WASHER, M12	6
D5	9014-457	NUT, HEX FLANGE, M12-1.75	6

Use OE replacement style engine mounts for 98-02 Camaro 5.7 LS1 engines with this kit.

Installer's note: Attach the engine mount to the crossmember with the included fasteners from hardware kit 7039-225 found in the QA1 Front Coilover Suspension System.

Note: The part positions listed above will be called out in this installation manual as a visual reference to their respective positions during the installation procedure. Refer to these pages during the installation.

Note: Count and compare all parts and fasteners to the list above. If parts are missing, contact QA1 at sales@qa1.net.



Print pages 4 and 5 for a quick parts reference guide.



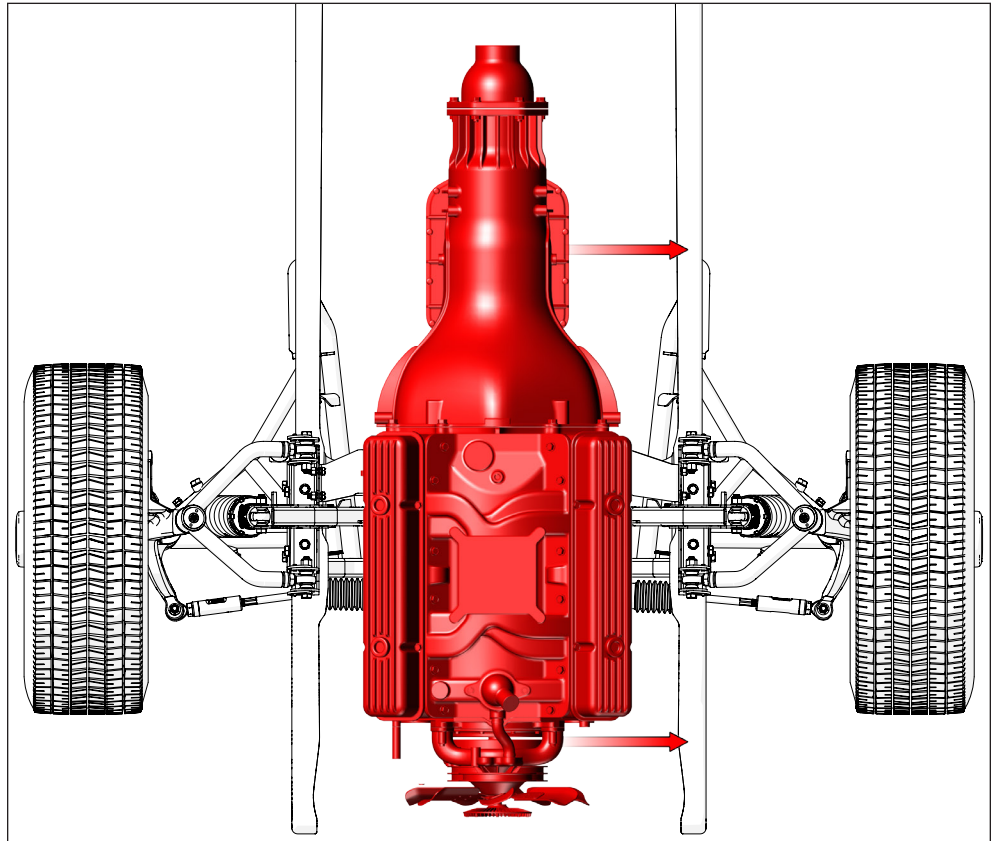
Installer's note: Some engines require additional conversion or relocation kits, and will be noted in these instructions.

In the stock configuration, the engine is positioned on the truck's passenger side (RH) to ensure enough clearance around the factory steering gearbox.

The transmission tunnel and transition on the firewall are also factory-biased.

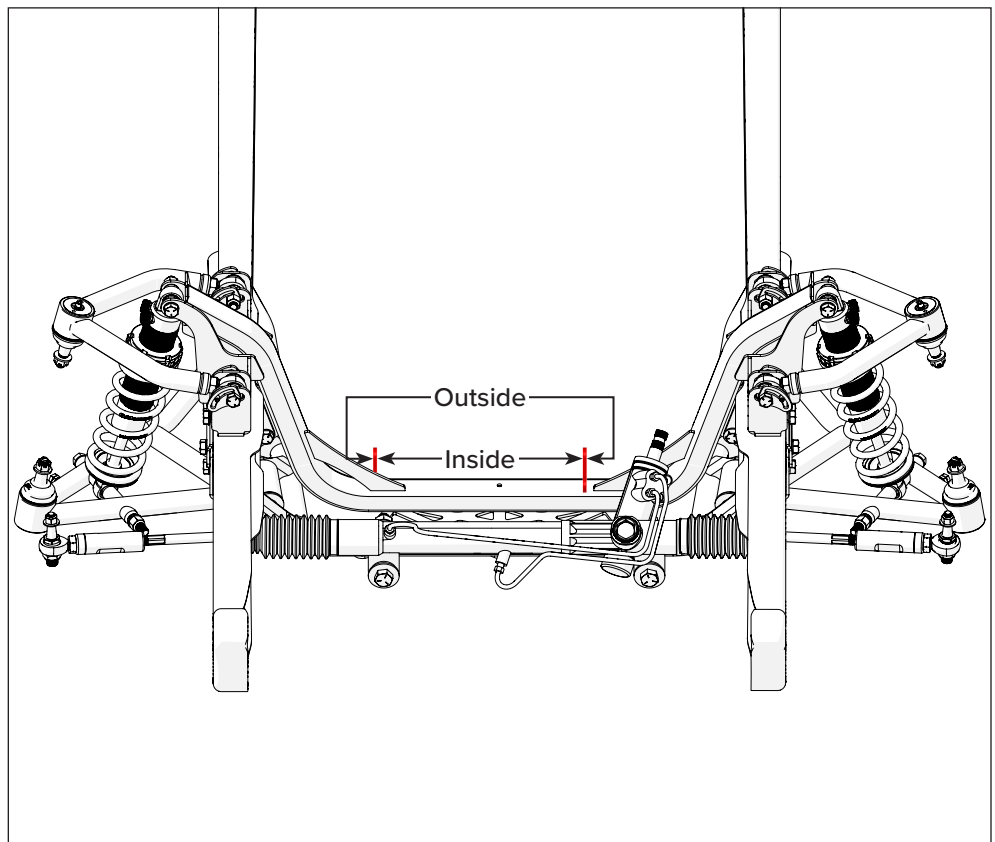
In contrast, the QA1 F100/F150 front suspension system removes the stock steering gearbox and relocates the engine towards the center of the engine bay.

This relocation modification also adds clearance for the truck's passenger-side headers.



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The engine mounts will connect to the crossmember tabs with a combination of inside and outside attachments, and depends on the engine to be mounted.



Installer's note: Use OE replacement style engine isolators or mounts for 65-70 360/390 FE engines.

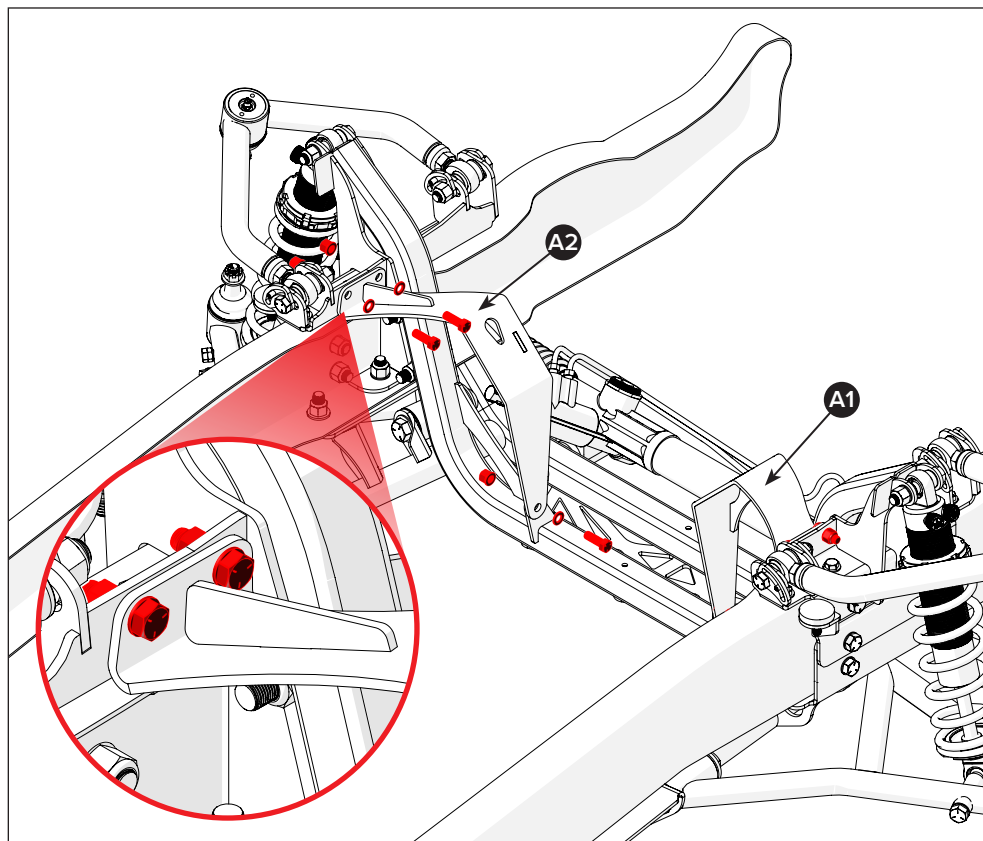
2 For the Ford FE engine, install the 7740-252 engine mount kit.

First, position the driver's side (LH) engine mount (A2) to the inside of the crossmember tab on the driver side. Then, use three bolts, flat washers, and flange nuts to secure the engine mount in the designated holes, as illustrated.

Then, position the passenger's side (RH) engine mount (A1) to the outside of the crossmember tab on the passenger side. Fasten the mount with the rest of the hardware.

Next, torque the fasteners to 24 lb-ft.

Finally, use the factory F100/150 FE mount to connect the engine to the QA1 swap mount.



Installer's note: Use OE replacement style engine isolators or mounts for 302/351W engines or Trans Dapt 4226 conversion mounts for 429/460 engines.

Due to crossmember interference, the 429 and 460 engines require a rear sump oil pan.

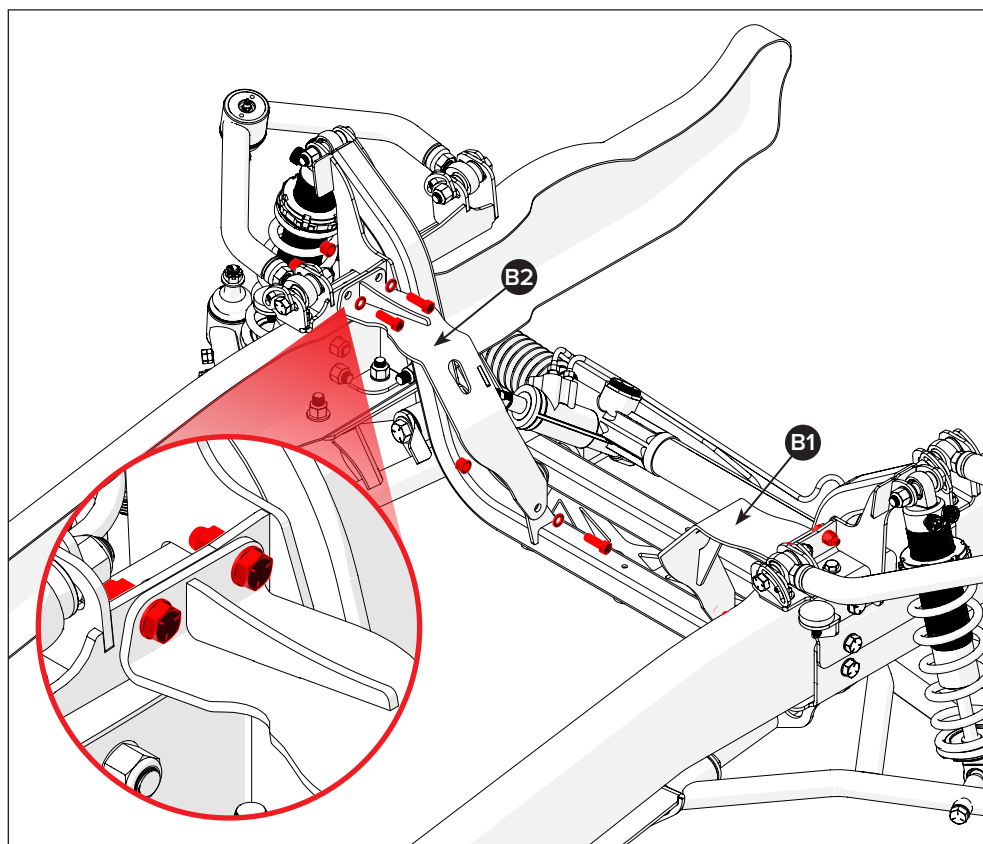
3 For the Ford Windsor, 429, or 460 engines, install the 7740-252 engine mount kit.

First, position the driver's side (LH) engine mount (B2) to the inside of the crossmember tab on the driver side. Then, use three bolts, flat washers, and flange nuts to secure the engine mount in the designated holes, as illustrated.

Then, position the passenger's side (RH) engine mount (B1) to the outside of the crossmember tab on the passenger side. Fasten the mount with the rest of the hardware.

Next, torque the fasteners to 24 lb-ft.

Finally, use the engine mounts to connect the engine to the QA1 swap mount.



Installer's note: Use OE replacement style engine isolators or mounts for 96-04 Mustang 4.6L engines.

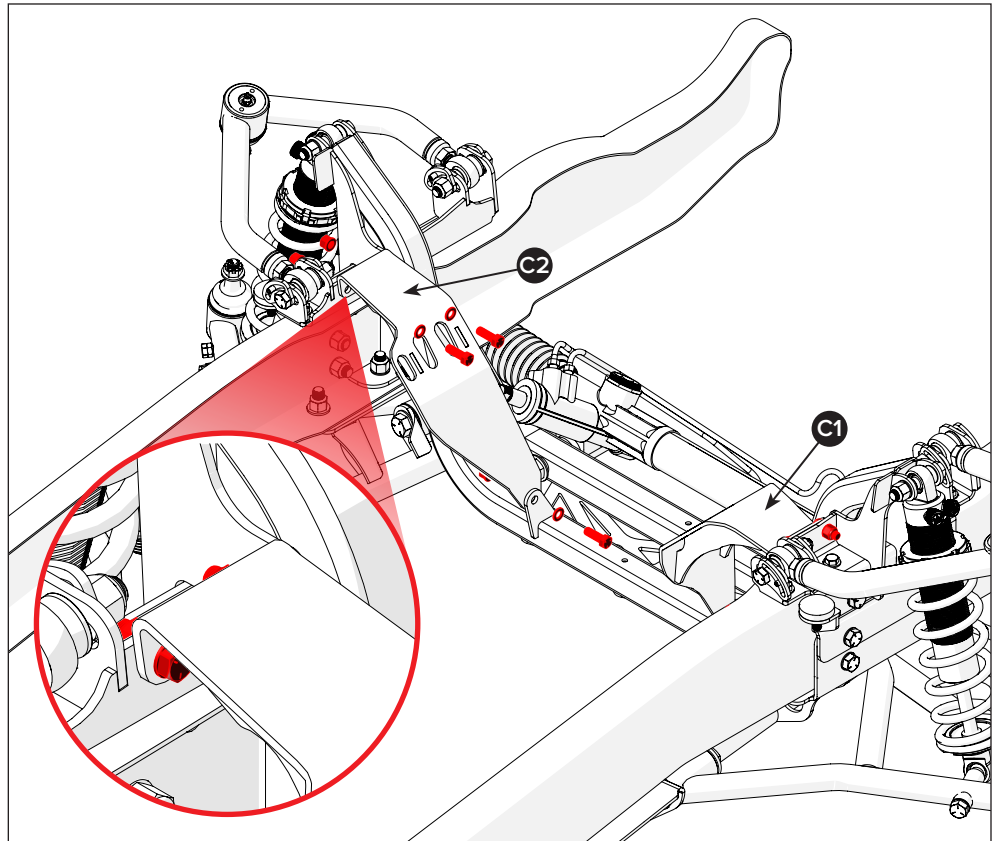
Due to swap mount interference, the 4.6L engine requires an oil filter relocation kit.

4 For the Ford Modular and Coyote engines, install the 7740-253 engine mount kit.

First, position the driver's side (LH) engine mount (C2) to the outside of the crossmember tab on the driver side. Then, use three bolts, flat washers, and flange nuts to secure the engine mount in the designated holes, as illustrated. The top fasteners on the driver's side mount insert under the mount but are shown on top for visual clarity.

Next, position the passenger's side (RH) engine mount (C1) to the inside of the crossmember tab on the passenger side. Fasten the mount with the rest of the hardware. Next, torque the fasteners to 24 lb-ft.

Finally, use the factory Mustang mounts to connect the engine to the QA1 swap mount.



Installer's note: Use OE replacement style engine isolators or mounts for 98-03 Camaro LS1 engines.

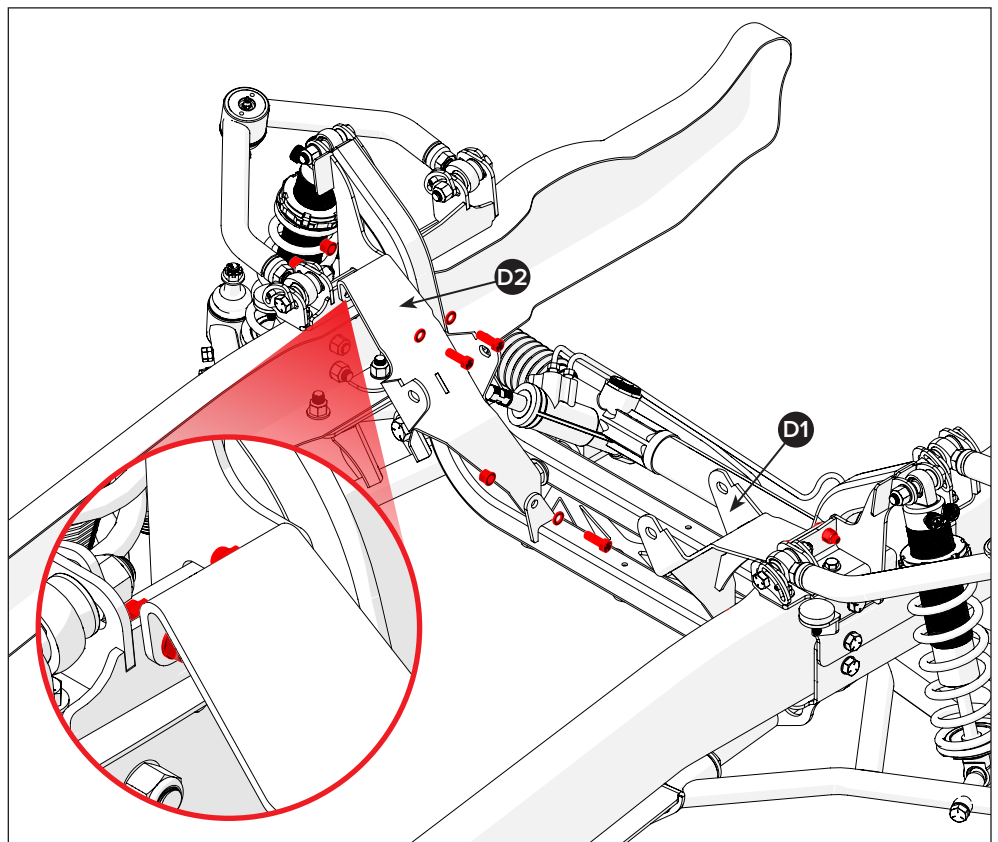
5 For the Chevrolet LS engines, install the 7740-254 engine mounts.

First, position the driver's side (LH) engine mount (D2) to the outside of the crossmember tab on the driver side. Then, use three bolts, flat washers, and flange nuts to secure the engine mount in the designated holes, as illustrated. The top fasteners for the driver's side mount (D2) insert under the mount but are shown on top for visual clarity.

Then, position the passenger's side (RH) engine mount (D1) to the inside of the crossmember tab on the passenger side. Fasten the mount with the rest of the hardware.

Next, torque the fasteners to 24 lb-ft.

Finally, use the factory 98-02 Camaro LS1 mounts to connect the engine to the QA1 swap mount.



DISCLAIMER / WARRANTY

QA1 warrants the products to be free from defects in material and workmanship for one year from the date of sale to the original purchaser. QA1 makes no other warranty of any kind, expressed or implied.

QA1 shall have no obligation under the preceding warranty where the defect results from improper or abnormal use, your negligence, vehicle accident, inappropriate or incorrect installation or maintenance, nor when the product has been repaired or altered in any way. QA1's liability in the case of defective products subject to the preceding warranty shall be limited to the repair or replacement of the defective products at QA1's option.

The user understands and recognizes that racing parts, specialized street rod equipment, and all parts and services sold by QA1 are exposed to many varied conditions due to the manner in which they are installed and used. It is the user's responsibility to determine the proper use or application of QA1 products.

QA1 shall bear no liability for any loss, damage, or injury, either to a person or to property, resulting from the installation, direct or indirect use of any QA1 products, or inability by the buyer to determine proper use or application of QA1 products. With the exception of the limited liability warranty set forth above, QA1 shall not be liable for any claims, demands, injuries, damages, actions, or causes of action to the buyer arising out of or connected with using any QA1 products.

Motorsports are inherently risky; therefore, no warranty or representation is made as to the product's ability to protect the user from injury or death. The user is fully aware and assumes that risk.



