

WELCOME TO QA1!

OUR COMMITMENT

Congratulations on your purchase of this high-quality QA1 64-70 Ford Mustang Subframe Connector kit. 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. With hand tools and essential equipment, you can do the main assembly and setup of your new subframe connectors in your home garage, but if you feel 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 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 64-70 Ford Mustang Subframe Connector installation, 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 Rear Sway Bar assembly procedure.

Check your order as soon as possible upon delivery. QA1 has provided parts list tables and images, as shown on pages 4 and 5. Compare your order's contents against the tables. Call your authorized dealer immediately if you discover anything missing from your order.

This kit requires no welding to assemble and install, but can be welded if preferred. When welding on and around your vehicle, take the necessary precautions. Utilize welding blankets and spark deflection paper to prevent sparks from reaching surrounding painted surfaces, fuel tanks and lines, braking components and lines, rubber hoses, electrical wiring, and other exterior components while welding and grinding.

It is important to wear the appropriate personal protective equipment (PPE). However, the responsibility does not end there. Follow the manufacturer's instructions for safe use when working with power tools, and be cautious and responsible in your work. Make sure to ventilate combustible vapors and remove any nearby flammable materials.

ABOUT THIS MANUAL

PURPOSE

These instructions outline the QA1 64-70 Ford Mustang Subframe Connector kit.

This system is designed to work with only the QA1 Mustang 4-Link Rear Suspension system and cannot be used with a leaf spring suspension.

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

- Floor Jack
- SAE Wrench Set
- SAE Socket Set
- Torque Wrench (lb-ft)
- Cut-Off Wheel
- Angle Grinder or Cut-Off Tool (for 67-70 models)

If welding

- Weld-Through Primer
- Mig Welder (minimum of 1/4" penetration)
- Applicable welding equipment

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, gloves, and a fine particle respirator mask.
- Never use compressed air to clean brake or metal grinding dust from the brake, suspension components, frame, or rear axle housing.
- Grind metal only in a well-ventilated area, and wear a respirator until the dust has settled and the work area air has been cleared.
- Dispose of damaged or old parts in accordance with local laws. Do not throw any hazardous waste in the trash.
- Follow the manufacturer's instructions for safe use when working with power tools, and be cautious and responsible in your work.

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PARTS LIST 4

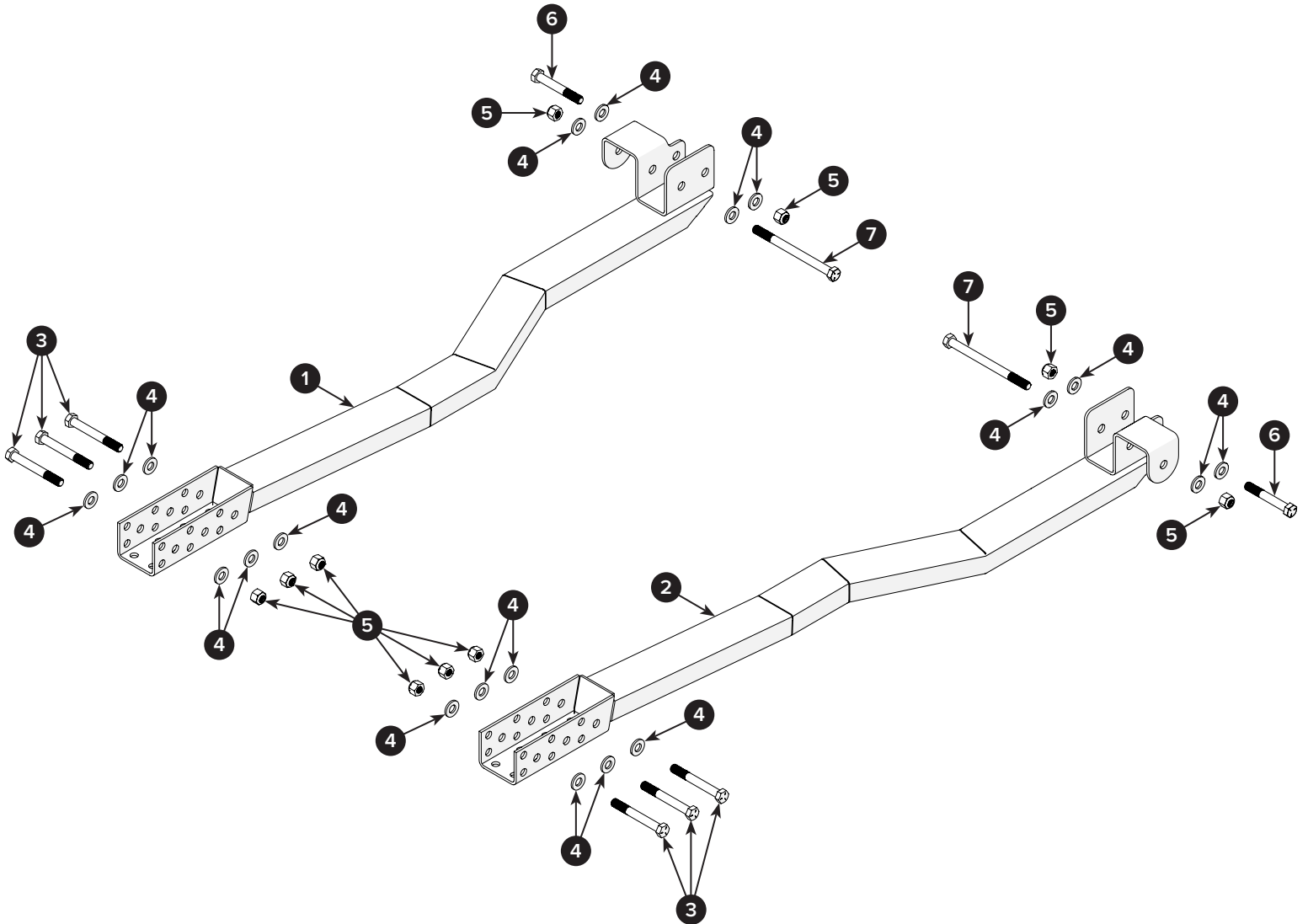
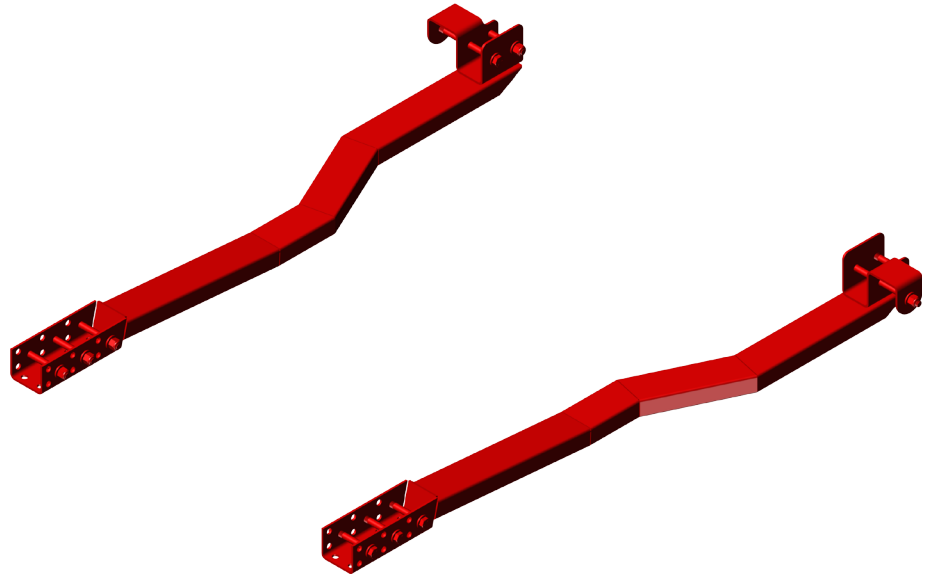
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52097 64-70 FORD MUSTANG
SUBFRAME CONNECTOR KIT



64-70 FORD MUSTANG REAR SWAY BAR (52097)

POSITION	PART #	DESCRIPTION	QTY	TORQUE SPECIFICATION
1	9637-977	SUBFRAME CONNECTOR, RH	1	—
2	9637-978	SUBFRAME CONNECTOR, LH	1	—
3	NA	BOLT, HEX, GRADE 5, 1/2"-13 x 4.0"	6	75 lb-ft
4	NA	FLAT WASHER, 1/2" ID	20	—
5	NA	NUT, NYLOCK, 1/2"-13	10	—
6	NA	BOLT, HEX, GRADE 5, 1/2-13 x 3.5"	2	40 lb-ft
7	NA	BOLT, HEX, GRADE 5, 1/2-13 x 6.5"	2	40 lb-ft

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



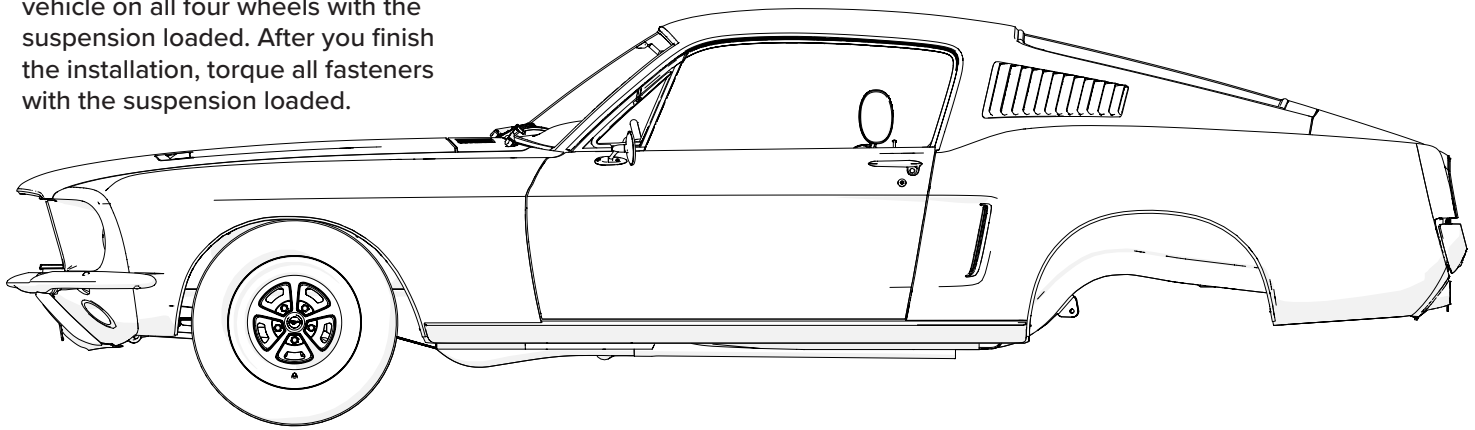
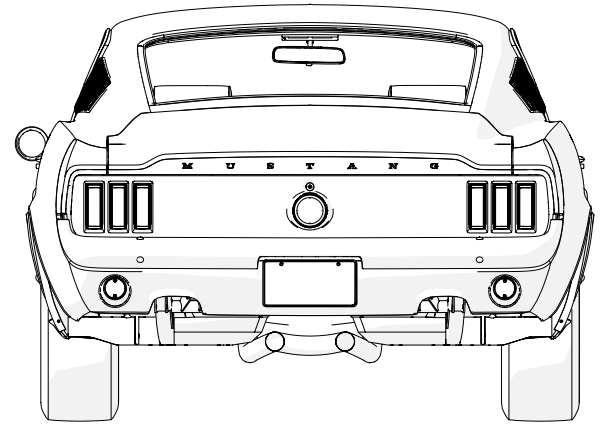
1

The subframe connectors can be used only with the QA1 Mustang Rear Suspension.

These instructions replace steps 12-15 from the QA1 64-70 Ford Mustang 4-Link installation manual (part number 9919-365).

Before you start, make sure the vehicle is supported and level, with the rear wheels and axle removed, as shown in the images.

If this subframe connector kit is added later, lift and support the vehicle on all four wheels with the suspension loaded. After you finish the installation, torque all fasteners with the suspension loaded.



2

Position the left-hand (LH) subframe connector (2) against the vehicle frame as illustrated.

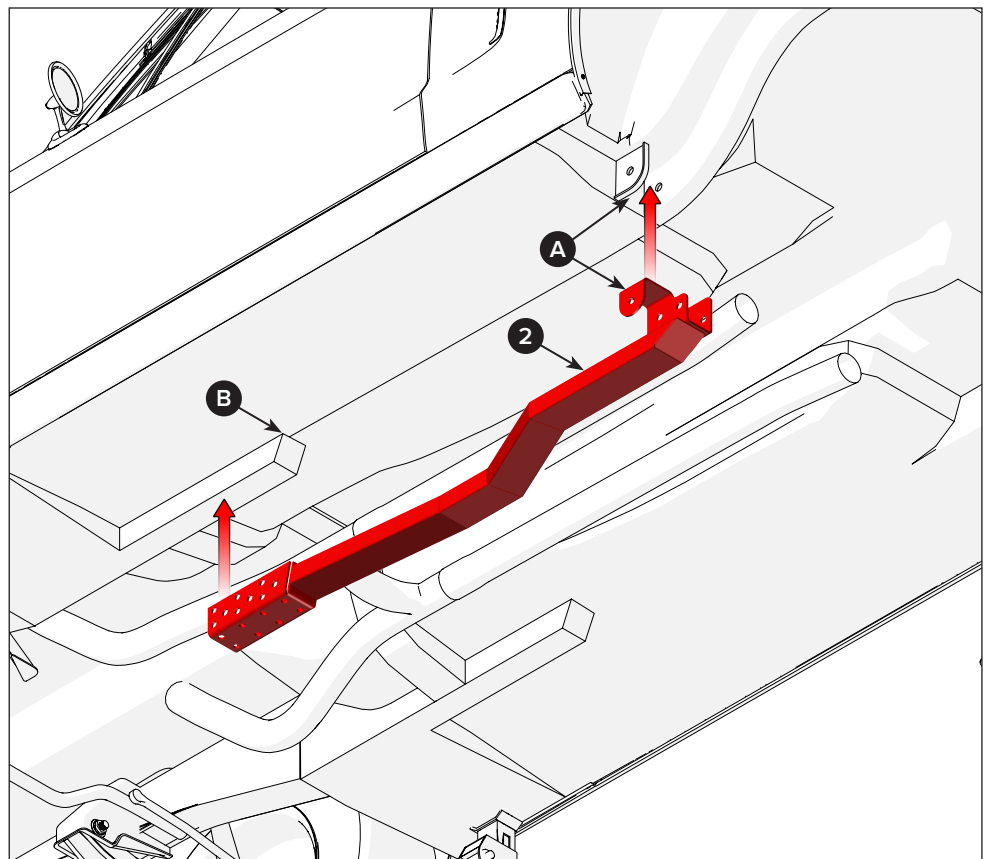
Make sure that the rear bracket (A) tightly fits into the front of the frame's rear axle leaf spring pocket.

Now, fully push the subframe connectors into their final mounted position.

Use a floor jack, jack stand, or any other suitable means to support the subframe connector firmly against the frame.

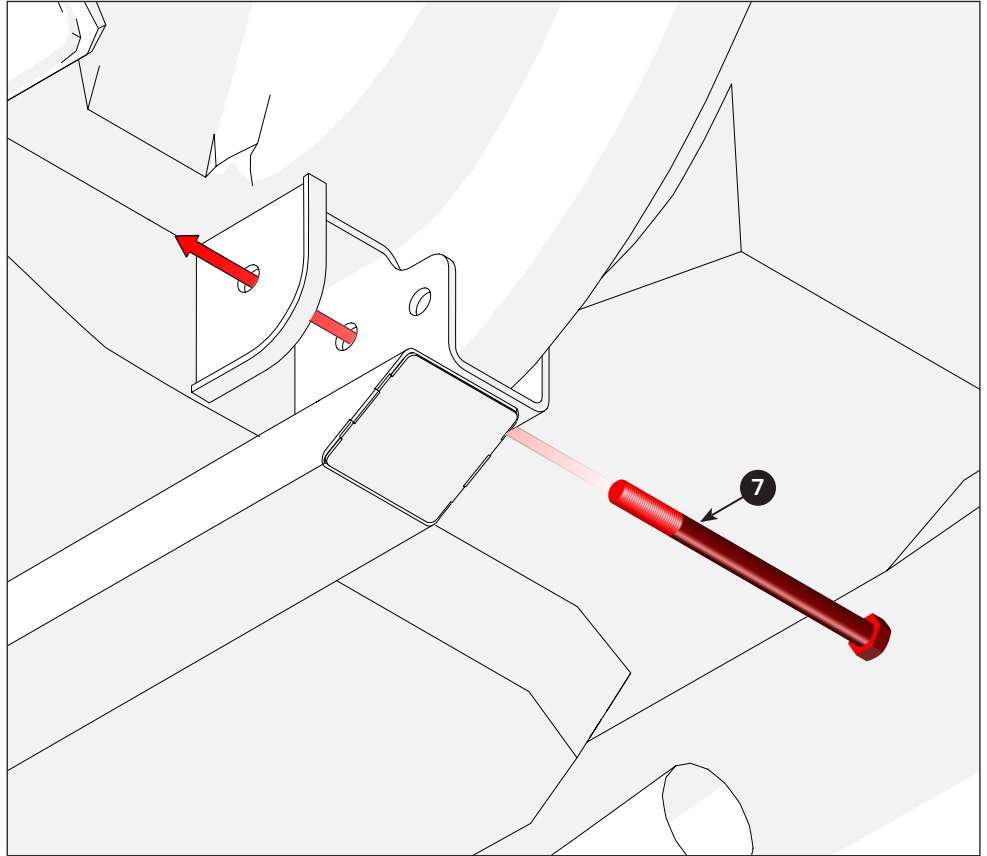
Note: 1967-up Mustang front subframe arms (B) are longer than those of 1964-1966 due to pinch welds.

Cut or grind off the pinch welds where the front subframe connector mounts to the vehicle's frame.



- 3** Align the hole in the subframe connector mount bracket, then insert the long 6.50" bolt (7) through the mount bracket and frame.

Note: This bolt holds the bracket in place for alignment during the next step. A nut is not required at this time.

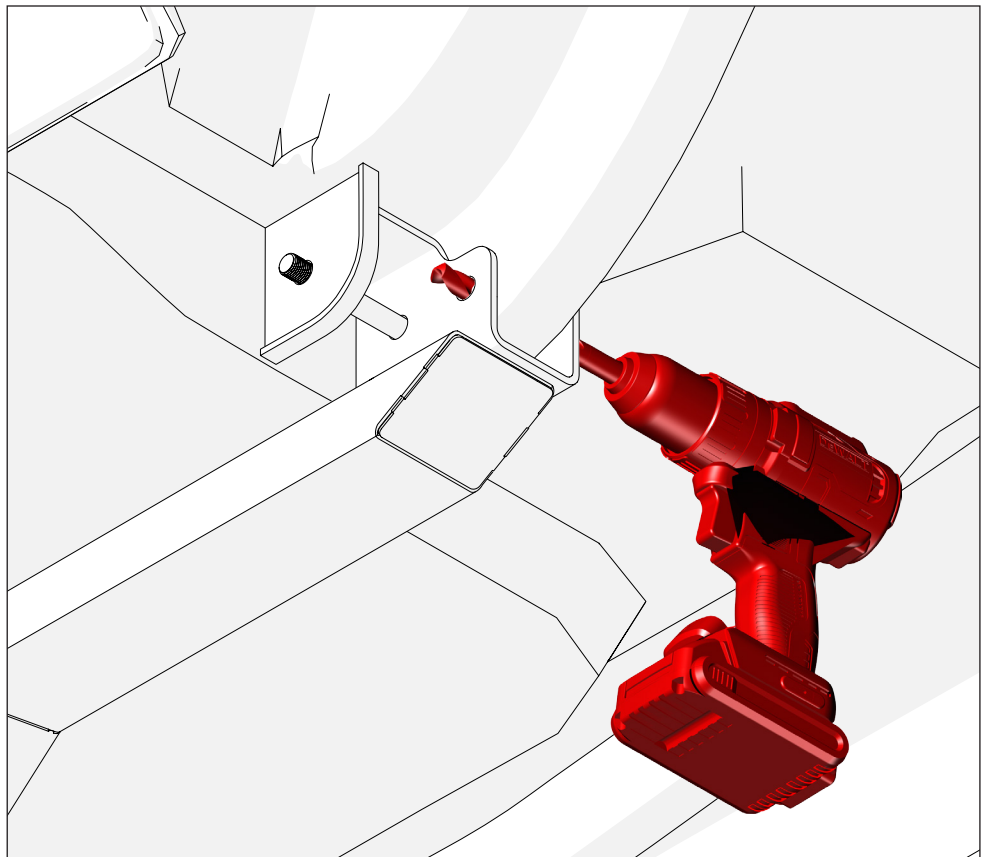


- 4** First, use a 1/8" drill bit to make a pilot hole from the rocker side and through the frame rail. This hole will align the drill bit when you drill from the inside frame rail.

Now, use a 1/2" metal bit and drill through the rear hole in the rear frame mount bracket and both sides of the frame.

Deburr the holes if necessary.

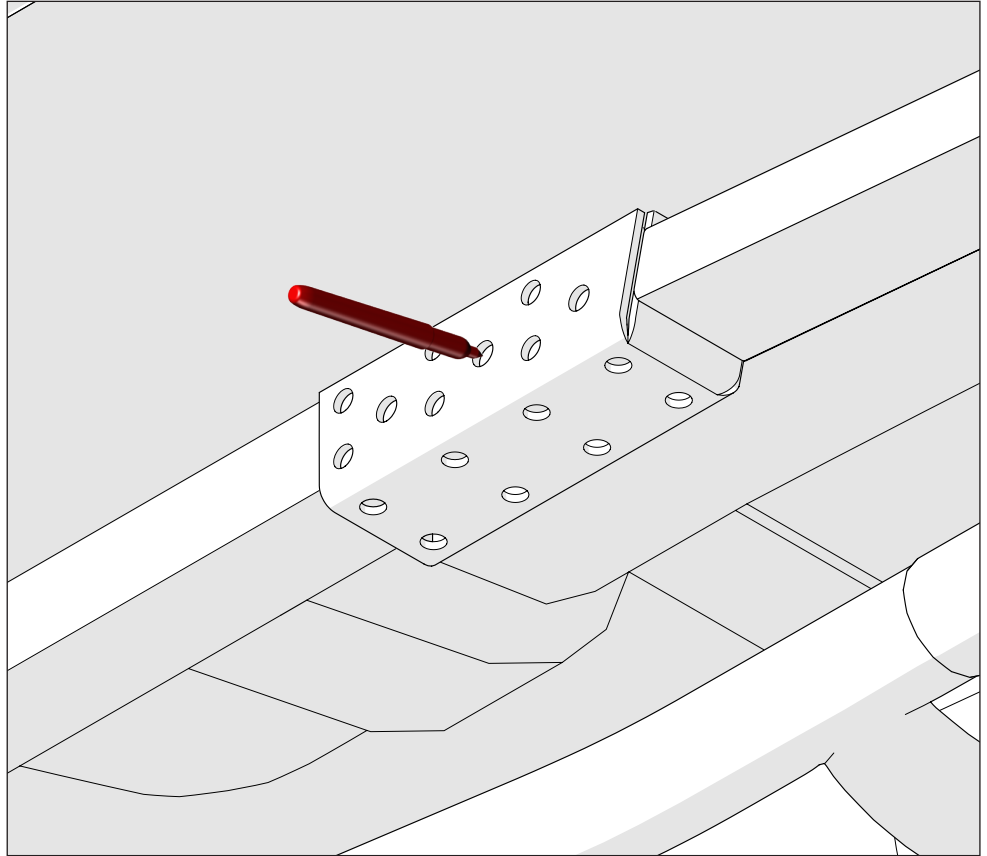
Note: If the new bolt holes are too tight and prevent bolt alignment, lower the subframe connector and use a step drill bit to enlarge the holes.



5

Use a permanent marker inside the center set of machined holes in the front mount bracket.

Make sure to mark both sides of the front bracket on the frame.



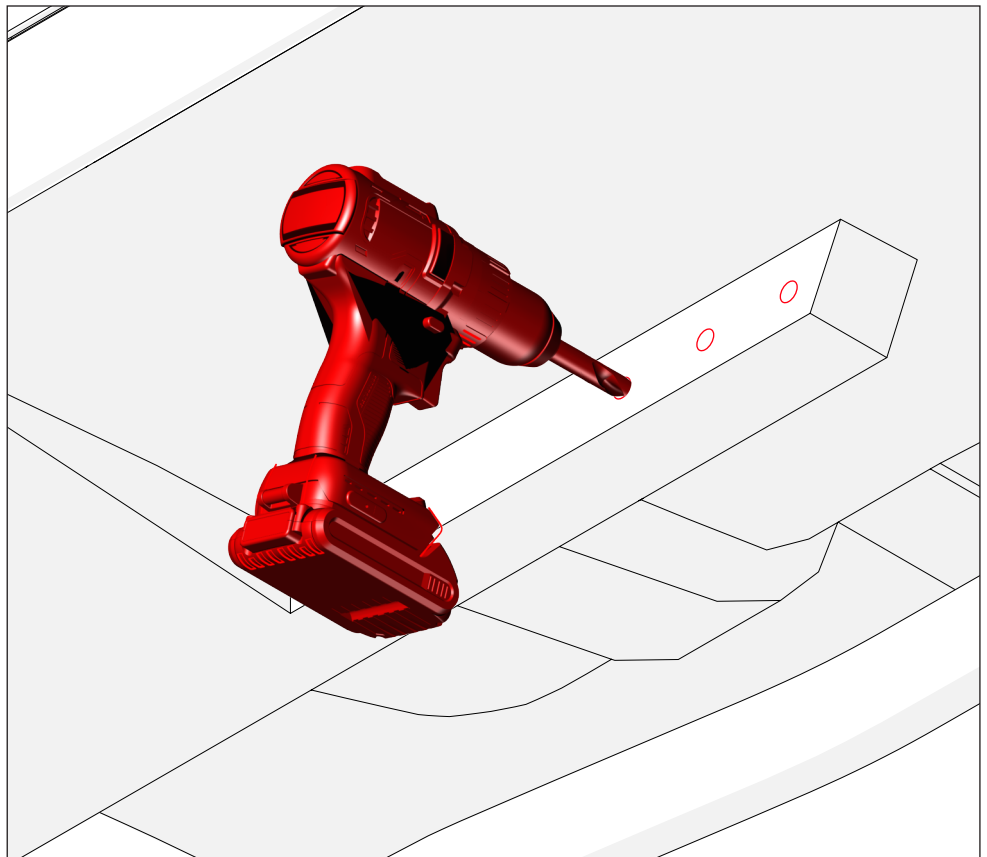
6

Remove the subframe connector from the vehicle.

Use a 1/2" metal bit and drill the frame on both sides marked during step 3.

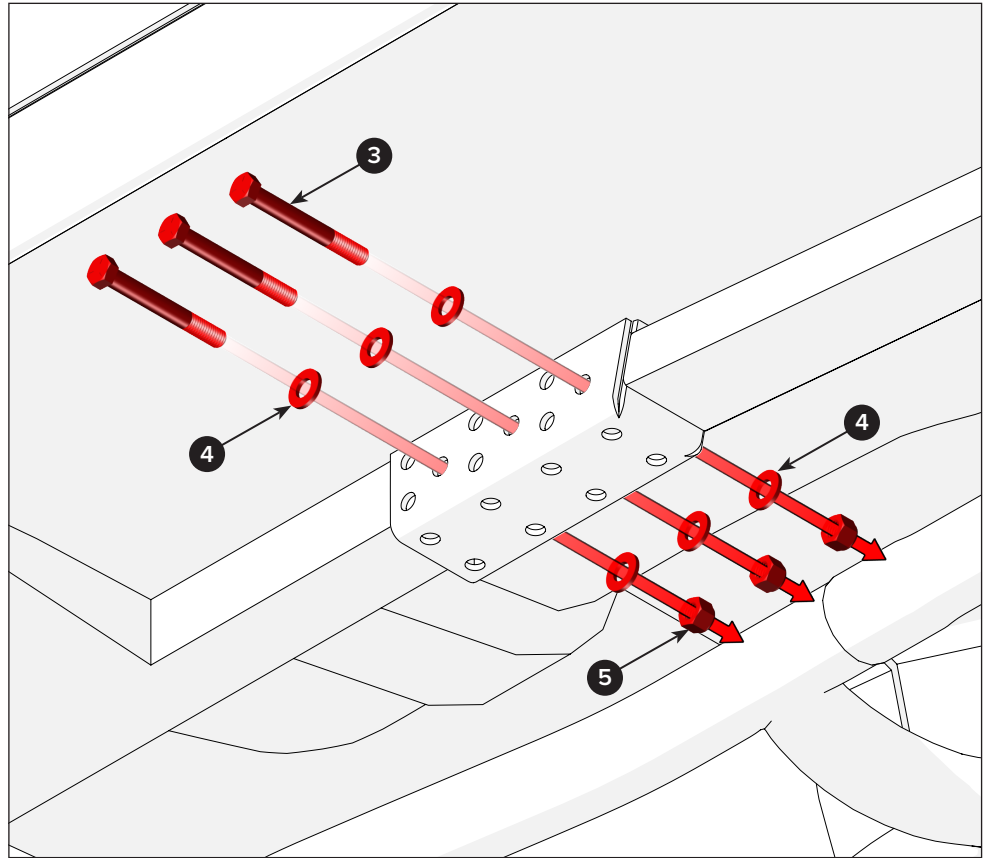
Deburr the holes if necessary.

Note: If the new bolt holes are too tight and prevent bolt alignment, lower the subframe connector and use a step drill bit to enlarge the holes.



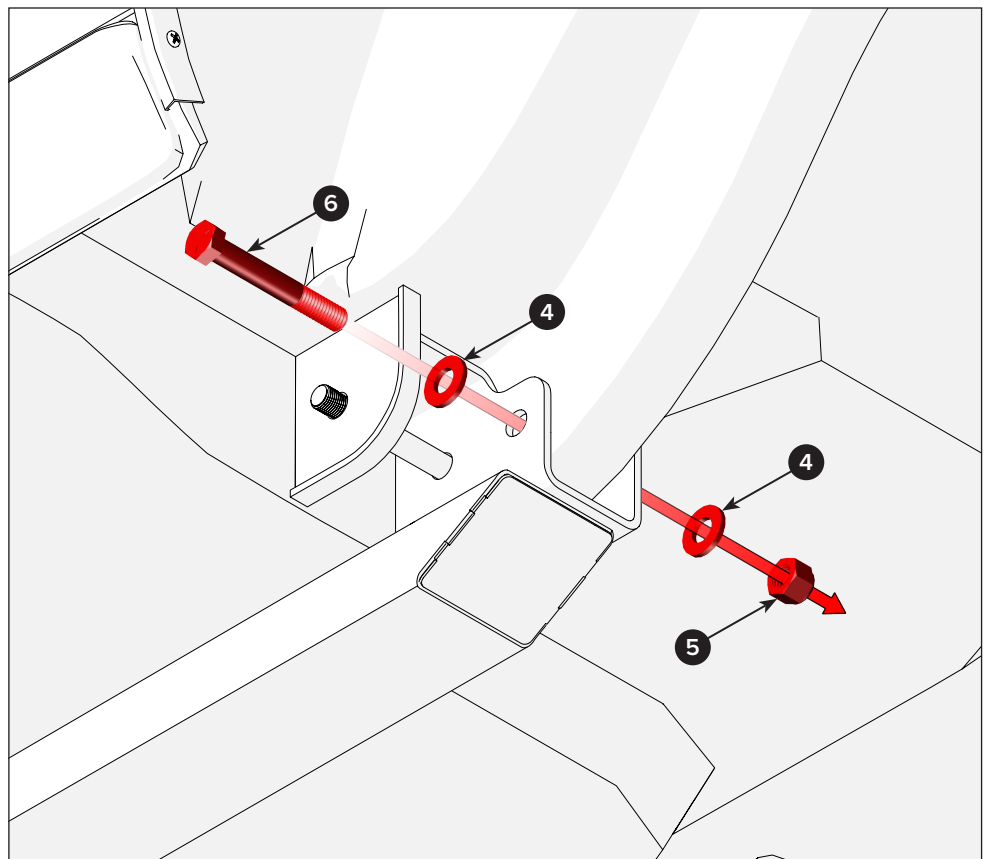
7

Attach the front of the subframe connector to the frame with three 4.00" long bolts (3), six flat washers (4), and three Nylock nuts (5).
Do not torque the bolts at this time.



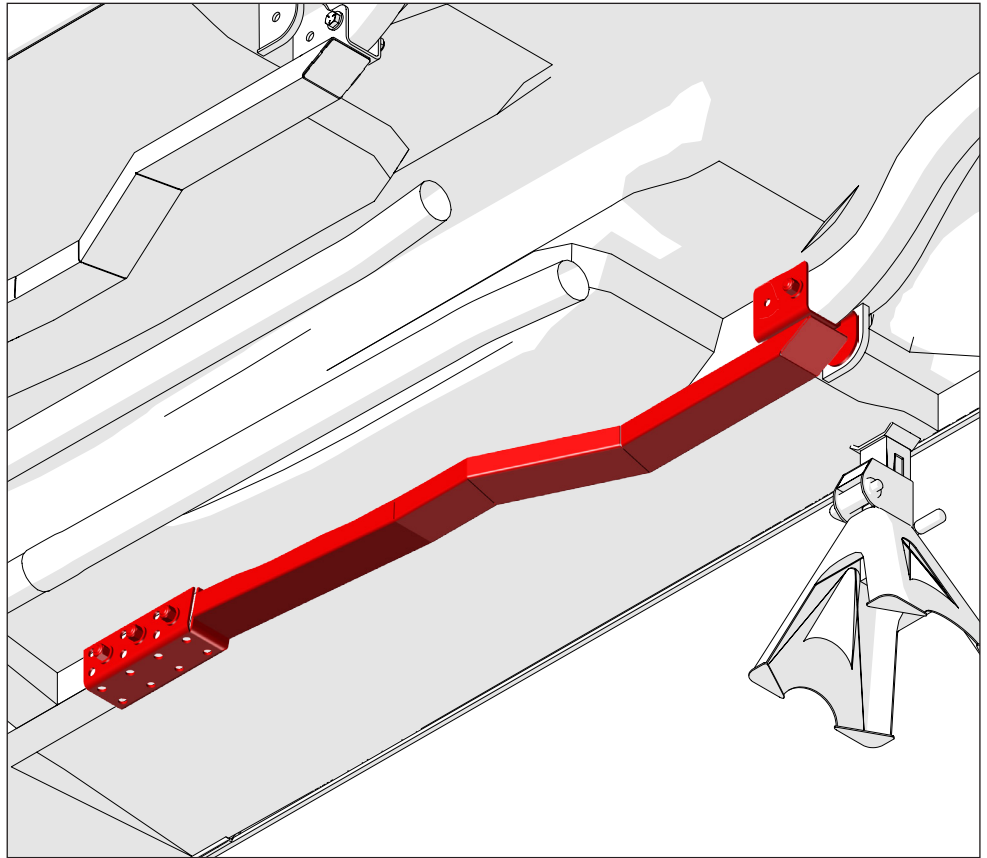
8

Fasten the mount bracket to the frame with one bolt (6), two flat washers (4), and one Nylock nut (5).
Torque the bolt to 40 lb-ft.
Remove the long frame mount bolt.



9

Repeat steps 2-8 to attach the RH subframe connector (1) to the frame.



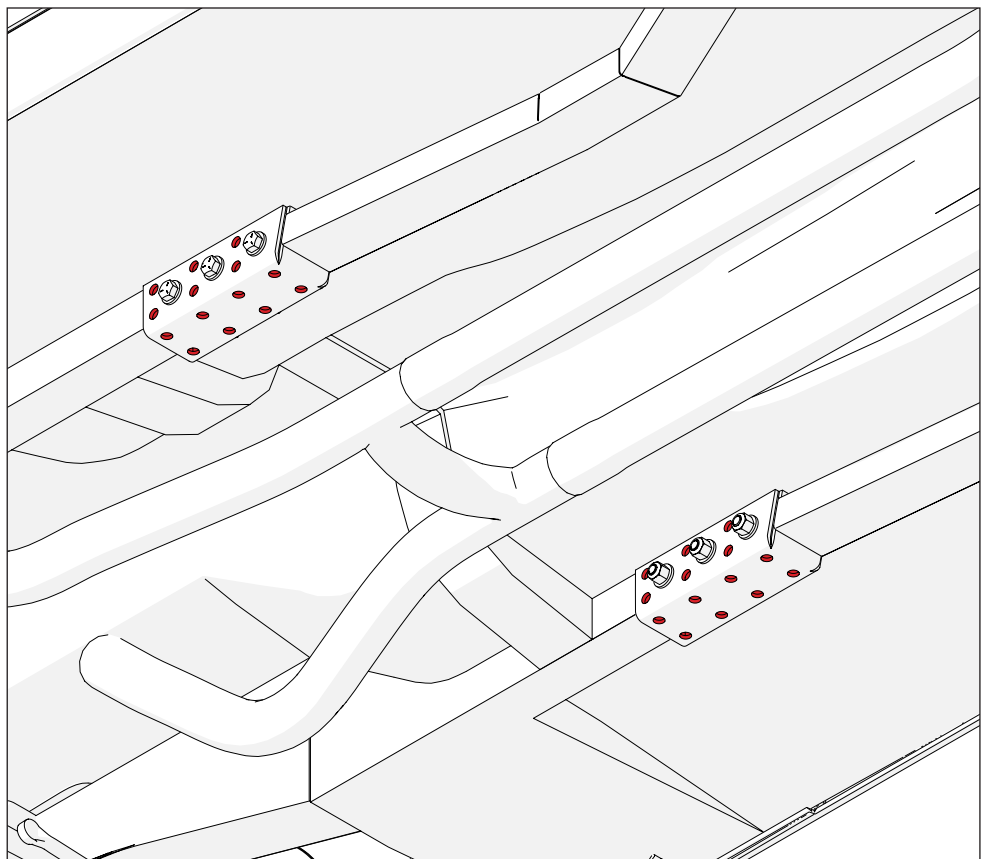
10

The front subframe mount brackets can be attached to the frame with hardware, plug welds, or a combination of both methods.

If you opt for the all-hardware attachment method, simply install the fasteners and torque the bolts to 75 lb-ft.

If you opt to use the plug weld only method, remove all fasteners and the powder coating from the surfaces to be welded. Clean the area with a prep wipe, and once dry, apply a weld-through primer. Then, position the subframe connector and plug-weld it at the locations indicated in red.

For a combination plug weld & fastener attachment method, repeat the plug weld only steps, then grind down any high spots from the plug welds where flat washers will be placed. Next, prime and paint all exposed metal surfaces and welds. After that, install the fasteners and torque the bolts to 75 lb-ft.



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.



