



Part #109401 & 109401-1

## Installation of your Tin Man Gen I & II Subframe Connectors 1965 – 1973 Mustangs

Thank you for purchasing Tin Man Fabrication's subframe connectors! Our connectors are easy to install by following the steps below. Mustang Convertibles require minor cutting of the floor reinforcement pan. We would be happy to answer any questions you may have. A video of the installation is available on our website at: [www.tinmanfabrication.com](http://www.tinmanfabrication.com).



### **Step 1:**

Make sure the car is sitting level and in its natural state (not twisted).

### **Step 2:**

Cut open the end of the front subframe by grinding off the corners or by using a cut off tool. (See Diagram 1.1)

### **Step 3:**

Drill two ½" holes in each side of both front subframes starting from the back and measuring forward 2" and 4". (See Diagram 1.1)

### **Step 4:**

Locate the spot welds where the back edge of the seat pan is welded to the floor pans. Mark a line through the center of the spot welds from side to side. This is where the center attachment point will be drilled and bolted through the floor.

### **Step 5:**

Slide the subframe connector into the end of the front subframe about 6" so the center attachment point holes line up with the line through the spot welds. Holding the subframe connector into place, use a marker to trace around the subframe connector on the rear subframe to determine areas to be cleaned up for welding.

### **Step 6:**

Remove subframe connector and grind all areas that will be welded (around holes, around end of front sub and around the area that you marked on the rear sub).

### **Step 7:**

Re-install the connector and align. Tack rear of the connector in place. Verify that it is where you want it to be.

### **Step 8:**

Plug weld through the drilled holes to connect the front sub to the connector. Bend end of front subframe to close up the gap between the subframe and the connector and weld.

### **Step 9:**

Weld around the rear of the connector to tie it to the rear sub-frame. Drill and bolt center point. (There may be a small gap that needs to be pulled tight with the bolts.)

### **Step 10:**

Repeat instructions for the other side ensuring that they are in the same location.

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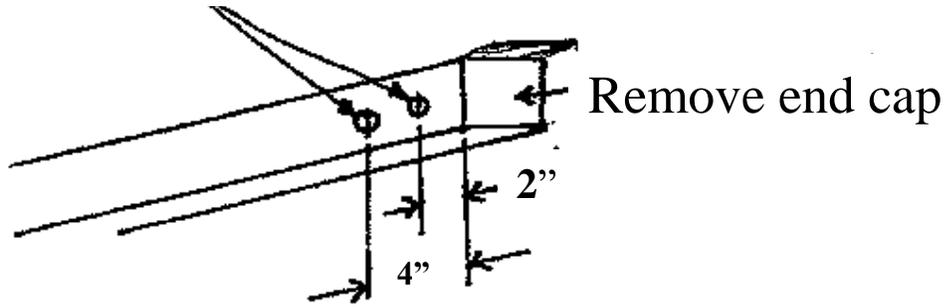
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Diagram 1.1

Drill  $\frac{1}{2}$ " Holes  
Both sides



Rear sub  
frame view



Front sub  
frame view



Pictures of Finished Installation

**Note: For 1970 – 1973** The frame rails are approximately 2" wider so during installation and once the connector is inserted into the front Subframe, clamp the rear of the connector to the side rail prior to welding. There will be some tension until the connector is welded into place.