

# Castlemaine ROD SHOP

Chass05Man.doc

## EJ-EH HOLDEN MANUAL BODY 3/4 CHASSIS KIT.



## FITTING EJ-EH MANUAL BODIES WITH 3/4 CHASSIS KITS.

The kit contains all parts required to complete the job. Before starting, thoroughly clean the underneath of the floor and especially the "Y" frames. Due to age and many miles of driving some parts of the floor can be dented or out of shape (Floor members may require some panel beating as the new chassis kit is a tight fit on an undamaged chassis)

Note – This kit needs to be fitted with the Engine and gearbox in position in steps 1 & 2 and can be removed after these steps have been carried out.

The tech screws seen in some of the photos are NOT part of the Chassis kit, these have been used to support the chassis kit on the hoist so photos could be taken to show steps.



1. Fit main rails over floor member and rear spring hangers and hold tight against floor with jacks.
2. Loosely bolt in tail shaft catcher to main rails using four 3-1/2" x 5/16" bolts and Nyloc nuts.(DO NOT TIGHTEN)  
Bolt up gearbox crossmember to the gearbox mount, centralize, measure & mark holes to be drilled on the main rails to mount the gearbox crossmember on to the rails



3. Remove seat bolts that line up with brackets half way along the main rails. Mark with scribe, remove rails and drill holes with 5/16" drill size and drill the thread out of floor where bolts must go through.



4. With Rails already removed, drill out previously marked holes to mount gearbox crossmember using a 7/16" drill.



5. Loosely bolt together gearbox crossmember and tail shaft catcher,



Refit rails into place hold in position with jacks.

Tighten crossmember and tail shaft catcher, Drill through chassis and floor member using 3/8" drill.

Fit two 2-3/4" x 3/8" bolts with large flat washers on inside against floor, but only fit the two bolts closest to seat at this stage. Bolt up with nyloc nuts. Fit two 2-1/2" x 5/16" bolts through seat with original washer and nyloc nuts.



6. Drill rear spring hanger with 7/16" drill and fit four 4 x 7/16" bolt and nyloc nuts.



7. Drill through floor member from front and rear. Install two 4-1/2" x 3/8" bolts from rear and the two 5 x 3/8" bolts, ***but don't fit nuts yet.***



8. Remove front suspension crossmember, centre punch spot welds and drill off brake pipe holders from bottom of "Y" frames, clean rails, there are two different "Y" frame strengthening plates. One has cut out for handbrake mechanism which will bolt back as original. In EJ's an EH handbrake assembly must be used.



9. Line up edges of rails and plates. Hold into position with G clamps and stitch weld plates to frame with approximately 25mm welds approximately 25mm apart. In EJ models for extra strength and to block holes through subframes the original bolts can be replaced which held the original side mounts on but the marking out and drilling for the holes must be done before welding on.



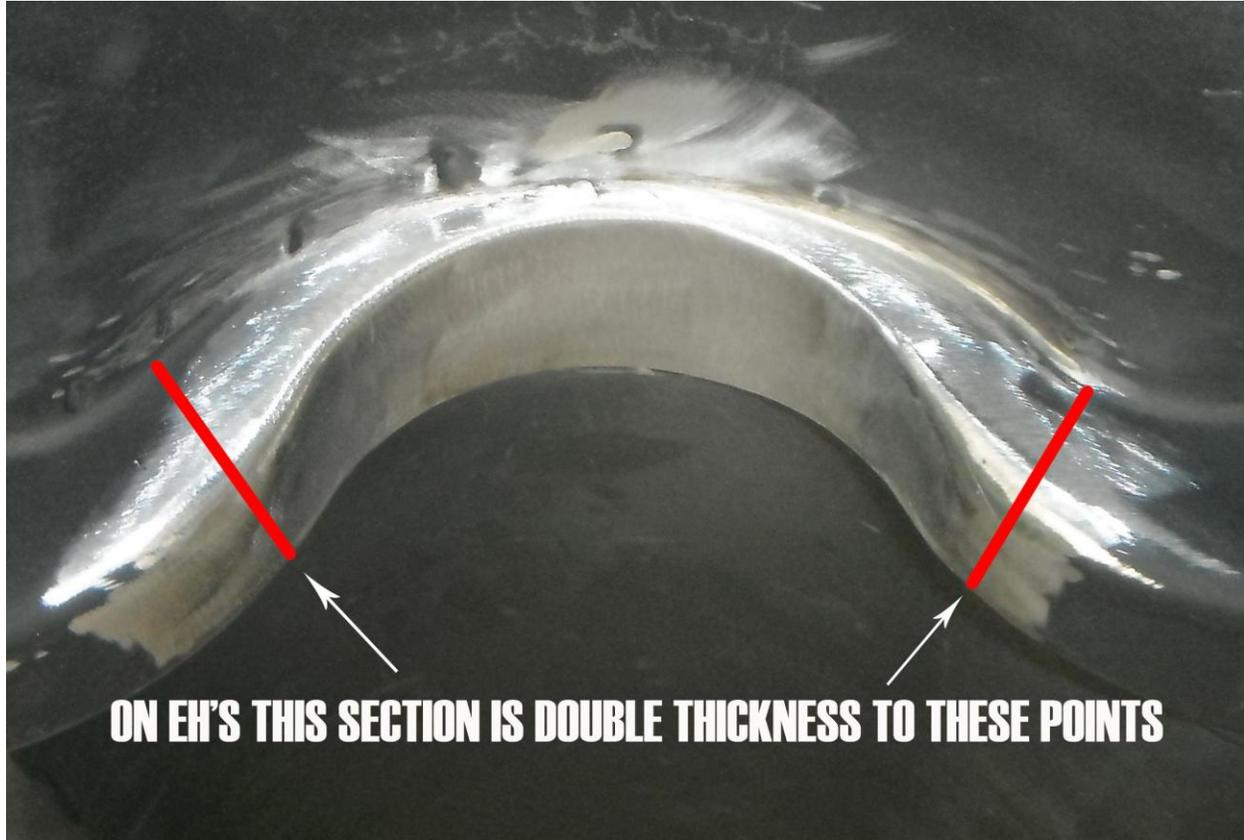
10. Bolt in front support rails using the previously fitted bolts and install the four 3 x 3/8" bolts with body washers in the remaining four holes through floor member.



11. With two jacks or jack stands fitted at the points where chassis fits over floor member and nothing supporting front, drill front support rails using 3/8" drill through the drilled hole in front "Y" frame braces and bolt up using eight 3/8 x 1" bolt and nuts.



With most auto and manual transmissions the floor will need reshaping. This is especially so in the floor member area. The cutting out of the single thickness metal to let the box sit higher will leave the member open. Cut the single thickness metal out until you hit double thickness. Grind edges clean and cut a strip of body steel to the thickness of the floor member, shape and weld in to seal ends of member and across floor. Do this operation after final floor shape is established. See diagram. On EJ models floor member is single thickness metal for the full width.



**ON EJ'S THIS SECTION IS DOUBLE THICKNESS TO THESE POINTS**