



Instructions for #3021

32 FORD

VIPER HAIRPIN

SPECIAL NOTE: FRAME SHOULD BE BOXED THE FULL LENGTH TO PREVENT RAILS FROM FLEXING. IF THIS IS NOT POSSIBLE, FRAME MUST BE BOXED AT LEAST 5" BEYOND EITHER SIDE OF THE POINT AT WHICH HOLE IS TO BE DRILLED IN FRAME RAILS.

MEASURE FROM CENTER OF CROSSMEMBER BACK $36\frac{5}{8}$ " TO LOCATE VERTICAL CENTER OF HOLE TO BE DRILLED. FROM THIS POINT, MEASURE DOWN THROUGH RAIL, THEN MEASURE DOWN $4\frac{5}{8}$ " TO LOCATE HORIZONTAL CENTER. START HOLE WITH $\frac{1}{8}$ " DRILL BIT. BEING CAREFUL TO KEEP PILOT HOLE SQUARE WITH FRAME RAIL. THEN, WITH $\frac{7}{8}$ " HOLE SAW, BORE COMPLETELY THROUGH RAIL.

