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MR1AK

64-70 MUSTANG REAR KIT W/ADJUSTABLE CONTROL ARMS INSTRUCTIONS

Kit Includes:

MR-1000 Rear Cradle

MR-1110 64-70 Mustang Adj. Rear Lower Control Arms

MR-3310 64-70 & 79-04 Mustang Adj. Rear Upper Control Arms

MR-3900 Spherical Bearings Kit

MR-3800 64-70 & 79-04 Mustang Anti Roll Bar

MR-1000 Hardware

- 6 Crush Sleeves- $\frac{3}{4}$ x $\frac{1}{2}$ x $1\frac{3}{4}$
- 8 $\frac{1}{2}$ x 13 x 3" Bolts W/Nylock Nuts
- 2- $\frac{3}{4}$ x $\frac{1}{2}$ x 5/8 Long Spacers
- 14- 7/16 USS Washers
- 2 MR Frame Brackets

Mr-1110 Lower Adj. Rear Control Arms

- 2- Lower Control Arms
- 4- $\frac{3}{4}$ Sleeves 2 15/16" Long (2 of these get Shaved down to fit into Rod End)
- 4- Spacers 1" - .120 Wall x 1.010 Length
- 4 – Urethane Bushings Energy Suspension #10003
- 2- $\frac{1}{2}$ x 13 x 5" Bolts W/ Nylock Nuts
- 2- $\frac{1}{2}$ x 13 x 4 $\frac{1}{2}$ " Bolts w/ Nylock Nuts

MR-3310 64-70 & 79-04 Mustang Adj. Rear Upper Control Arms

- 2 #12 Right Hand Rod End & 2 RH Jam Nuts
- 2 Rear Side Control Arms
- 4- $\frac{1}{2}$ x 13 x 4" Bolts W/Nylock Nuts
- 2- $\frac{3}{4}$ - .120 x 2 7/16 Get Shaved down to fit into Rod Ends
- 4 Spacers 1"- .120 Wall x .780

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- 2- Ladder Bar Adjusters $\frac{3}{4}$ - 16 Threads part # JSI-12
- 2- RH $\frac{3}{4}$ -16 Jam Nuts
- 2- LH $\frac{3}{4}$ -16 Jam Nuts

MR-3900 Spherical Bearing

- 2- #12 COM Bearings
- 2- Snap Rings for Bearings
- 2- Sleeves $\frac{3}{4}$ " X .120 Wall X 2 $\frac{7}{16}$ " Long (Lightly Pressed into the Eye of Bearing)
- 4- Spacers 1" OD X .120 Wall X .870 Long
- 4- $\frac{1}{2}$ SAE Washers
- 2- Spiral Retaining Rings (1 $\frac{3}{4}$ External)

MR-3800 Anti-Roll Kit

- 6- $\frac{7}{16}$ x 14 x 1 $\frac{1}{4}$ " "Bolts W/ Nylock Nuts
- 2- Spherical Bearings W/clips Must Be Installed in Hangers
- 6- $\frac{3}{8}$ x 16 x 2" Bolts W/ Nylock Nuts
- 2- $\frac{5}{8}$ x 11x 2" Bolts W/ #10-12 Mis. Alignment Bushings
- 2- $\frac{3}{8}$ RH/LH Hex 3" w/ $\frac{3}{8}$ x 24 x 2 $\frac{1}{4}$ " Bolts & LH $\frac{3}{8}$ – 24 Rod Ends W/Jam Nuts & Sway Bar Bushings.
- 1- Anti Roll Spacings between Arms 28- $\frac{1}{2}$
- 2- $\frac{1}{2}$ x 13 x 2 $\frac{1}{2}$ " Bolts W/ Nylock Nuts
- 2 sets of L Brackets
- 6 L Bracket Plates

Tools Typically Used:

- Safety Glasses
- Mechanics Wrenches, Sockets and Torque Wrench
- Jack and Jack Stands
- Hammer, Punches and Chisel
- Spray on Rust Penetrant
- Drill, Drill bits, $\frac{1}{8}$, $\frac{1}{2}$ & $\frac{3}{4}$
- Recommend a $\frac{3}{8}$ or $\frac{1}{2}$ Spot Weld Cutter
- Angle Grinder can be used instead of Spot Weld Cutter, (requires more clean-up).

Kit Requires:

87-93 Mustang Style rear-end housing.

A Pair of Coil-over Shocks and Springs with recommended installed (ride) height of 14 inches.

It is recommended to thoroughly clean the installation area prior to beginning. This will make locating the various attaching hardware and spot welds easier.

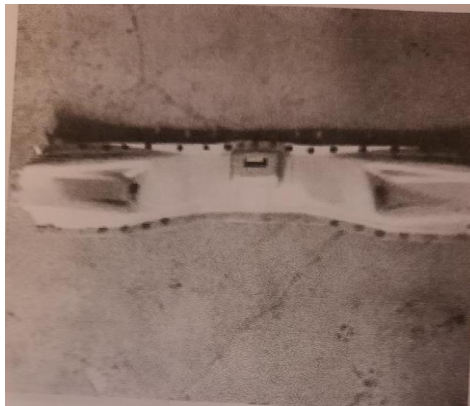
- Position the car on a solid, level and flat surface. Raise the car and SAFELY support it using Jack Stands.
- If the Engine is still installed in the car, disconnect the battery.
- Remove the Rear Wheels.

- Disconnect and plug the brake hoses from the Brake Drum/ Caliper. Use plenty of rags or paper towels to control any spills of Brake Fluid. Dispose of used rags/ paper towel properly after use.

CAUTION: BRAKE FLUID IS TOXIC. IT WILL ALSO REMOVE PAINT. IF BRAKE FLUID IS SPILLED, CLEAN UP IMMEDIATELY.

- Place a Jack under Rear-End Housing and raise it to compress the spring slightly.
- Remove all Mounting Hardware for Springs and Shocks so Rear-End can be removed.
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Remove Spot Welds that secure Shock Cross Member to Floor and Frame Rails. Hidden Spot Welds on both ends of Cross Member will not be accessible. The ends of Cross Member will need to be cut ,in order to, remove it.



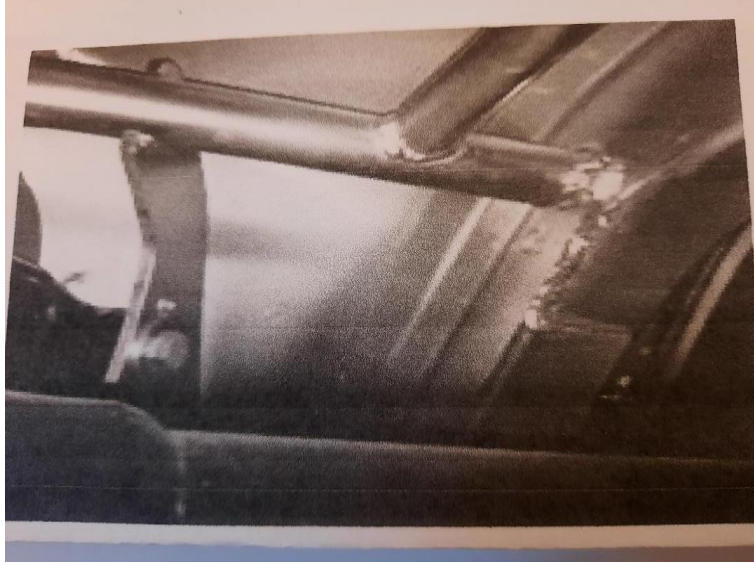
Once Cross Member is removed use Grinder to clean excess tab materials off inside and under Frame Rails.

Prep area for finish or welding before cross member is test fitted.

Start Installation:

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Place cradle up into frame rails and position lower tabs to bottom side of frame rails. This will generally give you a base location.



If bolting Cradle into your car mark holes from Cradle onto Frame Rails. These holes will be drilled to $\frac{1}{2}$ inch through the Frame Rail. Outside or Wheel well side need opened to a $\frac{3}{4}$ inch hole. This will allow Crush Sleeve to be installed.

Use Supplied Hardware and Sleeves.

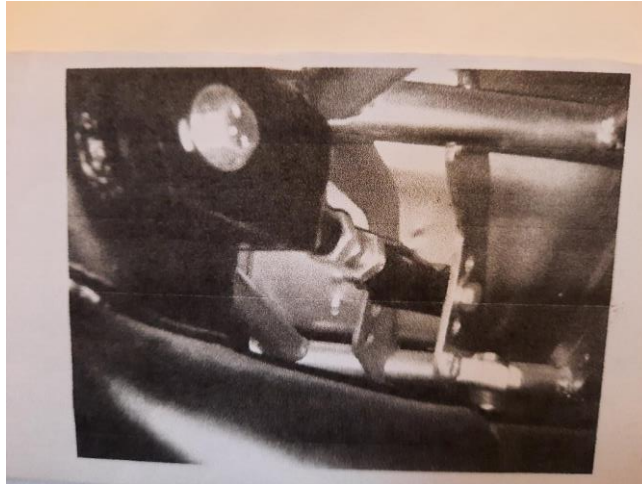
If welding frame into car once located clamp in place before starting to weld.



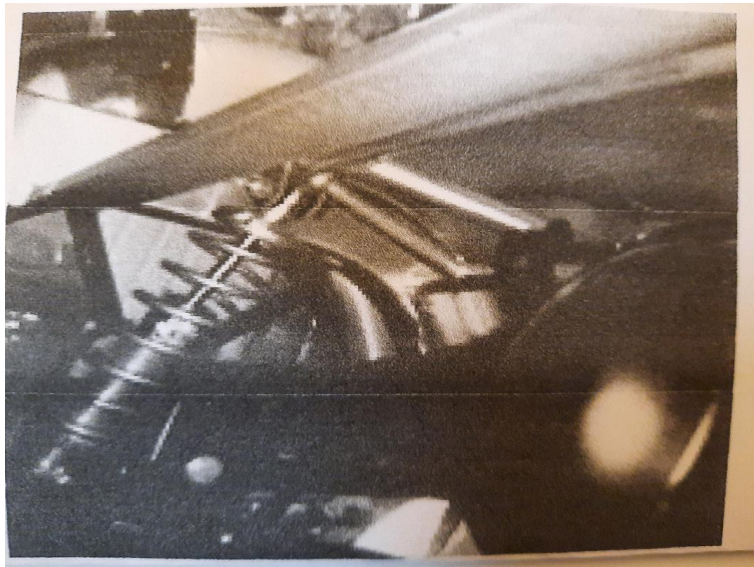
Installing Control Arms

Lower Arms Mount into original spring locations with supplied hardware.

Upper Control Arms mount into one of four provisions on Rear Cradle.



Position Rear End under car to attach control arms to Provisions on Housing. After positioning Rear End, the lower control arms will attach in factory bracket locations of in the added anti-roll hanger.



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