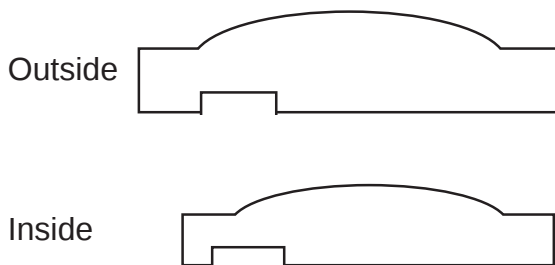




T H E S P E C I A L I S T S I N L A N D R O V E R S • U S A

Rear Frame Kit Instructions For Series II, IIA & III 109"

1. Remove rear frame member bolts and cut off old rear member with torch (or abrasive wheel, hack saw) taking care not to damage the rear wire harness.
2. Clean and smooth frame with wire brush and hand grinder to ease welding of new frame plates.
3. Bolt new rear frame member in place. Use a straight edge and square it up to the rear body.
4. Clamp outside (longer) plates to frame. Trim if necessary so they fit well to both frame and new rear frame member. Weld in place on all seams with 6011 rod at low amperage. Welding old rusty metal is difficult but possible by using short, overlapping passes at low amps (80 with 1/8 rod) on tight, clean seams. D.C. current will make it even easier, but is not necessary.
5. Trim, clamp, and weld inside plates.
6. Bend new upper and lower plates to conform to frame contours. Trim if necessary, clamp and weld.



Top Corner Gusset



Top



Bottom


1 802 879-0032

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Instruction part number (top right corner) or description of what instructions are: _____

Overall, how would you rate the quality of this set of instructions? (please circle one):

Poor		Fair		Good		Very Good		Excellent	
1	2	3	4	5	6	7	8	9	10

Ideas, Comments, or Corrections (please include specifics, such as page number, or step number):

THANK YOU!

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