



1. THINK SAFETY, ALWAYS WEAR SAFETY GLASSES WHEN PERFORMING THE OPERATIONS PRESCRIBED IN THESE INSTRUCTIONS

2. READ ALL INSTRUCTIONS CAREFULLY BEFORE ATTEMPTING INSTALLATION

ASSEMBLY TOOLS NEEDED:

Impact Sockets	7/16"—1-3/8"
Metric Sockets	10—19mm
Wrenches	7/16"—1-3/8"
Torque Wrench	
Drills	1/4", 9/16"
Hammer	
Center Punch	
2-6" C-Clamps	

Bolt Size	GR.2 Dry	GR.5 Dry	GR.8 Dry	Metric Size	GR.8.8 Dry
1/4"	66*	9	12	M8	17
5/16"	11	17	25	M10	35
3/8"	20	30	45	M12	60
7/16"	32	50	70	M14	95
1/2"	50	75	110	M16	155
9/16"	70	110	150		
5/8"	100	150	220		
3/4"	175	260	380		
7/8"	170	430	600		
1"	250	640	900		

NOTE: These torque values are to be used for all hardware. Unless otherwise specified, all torque values must meet this specification.
NOTE: All torque values are in Ft.-Lbs unless otherwise stated
*In-Lbs

INSTALLATION NOTES:

1. Mount Sub-Frame assembly completely before tightening any bolts unless otherwise specified.
2. To Install Sub-Frame the vehicle front suspension must be in a normal position such as when the vehicle is parked on level ground.

MOUNTING INSTRUCTIONS:

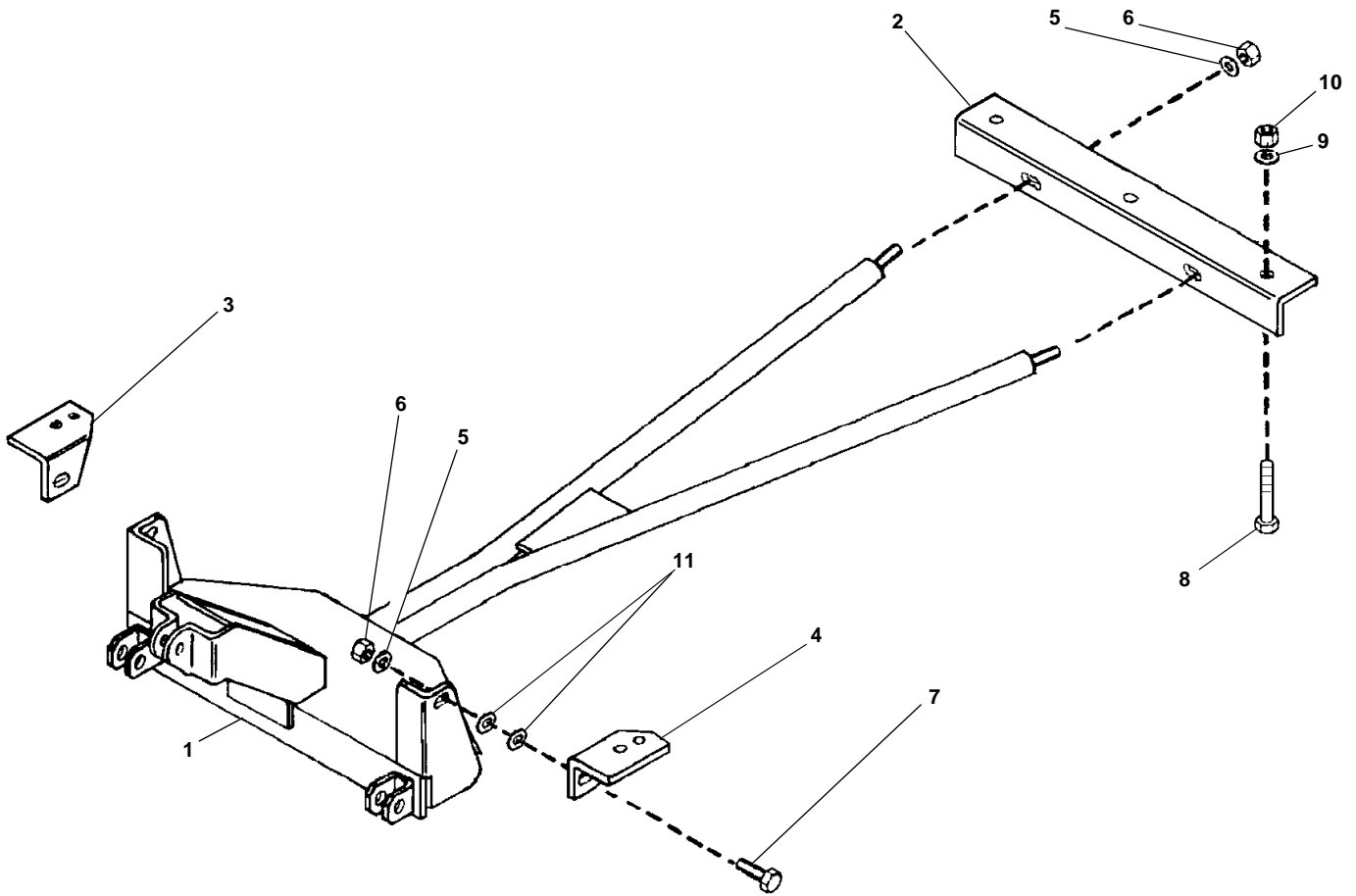
1. Remove existing left and right vehicle tie down brackets and replace with Front Mounting Brackets (#96001279)RH, (#96001278)LH. Secure using existing hardware from vehicle tie down brackets.

NOTE: It is recommended that Loctite® or similar thread locking material be used when re-installing the hardware from vehicle tie down brackets.

2. Raise Sub-Frame Assembly (#96101468) to Front Mounting Brackets and secure with two (2) 5/8" x 2" Capscrews (#98009041) Washers, Nylock Nuts and (4) Spacer Washers provided.
3. Install Rear Crossmember (#96001280) to the Sub-Frame Assembly support rail studs using 5/8" Nylock Nuts (#98009038) and Flat Washers provided.
4. Raise rear of Sub-Frame Assembly and secure Rear Crossmember tight to vehicle transfer case and secure using three (3) 3/4" x 3-1/2" Capscrews (#98009056) Washers, and Nylock Nuts provided.
5. Using the Torque Specification Chart above, torque all bolts starting at the rear and working forward.

*NOTE: During the snow- plow season, **Sno-Way** suggests adjusting the vehicle front suspension torsion rods six (6) turns counterclockwise. This will increase the Sub-Frame ground clearance with the snow plow attached. To simplify adjustment raise front of vehicle to reduce load on front suspension.*

1987 & LATER MAZDA 4 X 4 B2600 PICKUP
Sub-Frame Assembly & Installation Instructions
Part No. 99004030 Sub-Frame (Complete) Includes Hardware



ITEM	PART NO.	DESCRIPTION	QTY.
1	96101468	Sub-Frame Assembly	1
2	96001280	Crossmember, Rear	1
3	96001279	Bracket, Mounting, RH.....	1
4	96001278	Bracket, Mounting, LH	1
5	98009039	Washer, Flat, 5/8"	4
6	98009038	Nut, Hex, Nylock, 5/8"-11NC	4
7	98009041	Capscrew, Hex Head, 5/8"-11NC x 2"	2
8	98009056	Capscrew, Hex Head, 3/4"-10NC x 3-1/2"	4
9	98009030	Washer, Flat, 3/4"	3
10	98009003	Nut, Hex, Nylock, 3/4"-10NC	3
11	98009028	Washer, Spacer	4



SNO-WAY INTERNATIONAL, INC.

97100230A