

914 Longitudinal Reinforcement Installation

1. The reinforcement sils are marked Front Left Top / Front Left Bottom and Front Right Top / Front Right Bottom.
2. If heat is retained, cut out the area on each reinforcement along the dashed holes Marked #1 (1x each side)
3. If the parking brake is retained, cut out the areas of the left reinforcement Marked #2 (3x spots) along the dashed holes. Measure and record the location of the parking brake handle rest stop tube. Carefully cut the tube from the chassis and save it to be welded back on after installation of the reinforcements. Grind the welds from the tube flush.
4. Determine which cut out you will need for the passenger side seatbelt bolt and remove it from the reinforcement. Marked #3a / #3b.
5. On each reinforcement there is a tab Marked #4 to be bent out along the two notches at the back near the seat belt bung area.
6. Using self tapping/drilling screws secure the reinforcements into place for fitment. Mark welding surfaces.
7. Remove the reinforcements and prepare the welding surfaces.
8. Screw the reinforcements back into place and begin welding them in. We recommend tacking along the outside every inch or so (excluding the brake handle area till the end) followed by the plug welds. With all of the plug welds complete, finish the outside perimeter. Roll in the edges of the brake handle area by hammering them in, now this area can be welded.

Key notes:

1. It is highly recommended to check door and roof fitment before welding starts.
2. Brace the front of the car to the rear, by either using a frame fixture or temporarily bolt or weld in support struts to the door hinge column and striker mount. This is to prevent the car from folding in on itself while welding in the reinforcements.
3. Be careful of how much heat is put into the reinforcement while welding. We recommend bouncing back and forth between the two and moving to different areas to prevent heat build up. Putting too much heat into the parts will cause the door gaps to close up.