



MRC S197 8.50 Cage Kit

Thank you for choosing MRC for your cage kit!

We hope we made this as painless as possible.

If there are any questions this sheet doesn't cover, Please contact us by phone, Email or Facebook Messenger.

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This guide is to be a supplement to common roll cage installation techniques. Some portions are not covered in this guide. We have supplied you with some pictures to guide you. More pictures are available on our facebook and website.

Commonly used tools

1. Tig or Mig welder (If chromoly, the process has to be Tig welded)
2. Grinder to fit tubes, finish tube notches, clean floors
3. We recommend a tube notcher to make notches, but a grinder will work also.
4. Digital protractor
5. Tape measure
6. Sandpaper or sander to clean tubing of mill scale to weld
7. Wire wheel and flap disk to remove paint and seam sealer.
8. Ratchet strap

Before we begin, Make sure the car is level, front to back and side to side.

Part Name	Die	Material		Length
Main Hoop	1.625 6.5	1.625		130.0625
12A	1.625 6.5	1.625		84.4375
12B	1.625 6.5	1.625		84.4375
Part 113	1.625 6.5	1.625		45.25
Driver Rocker		1.625		49
11		1.625		53.375
15		1.625		56.1875
51B		1.625		36.8125
51B		1.625		36.8125
D Bar		1.625		35.3125
D Bar		1.625		35.3125
17A		1.625		57.125
16A		1.625		57.125
Pass Rocker		1.625		49

***All bars have 2 extra inches added to each end.**

If notched, none will be added.

This kit allows you to install a 8.50 Cage kit with relative ease. Without spending a lot of money on a notcher and required tools.

Due to the nature of each individual car some adjustment is required to fit perfectly for your vehicle.

To do this, we recommend a sanding drum/roll. Pictured below.

We have these on our website if you do not have one of your own.



This guide is to be a supplement to common roll cage installation techniques.

We are providing you with some measurements to help you set the bars where they need to go to fit other bars. All measurements are not provided.

Make sure the car is level, front to back and side to side.

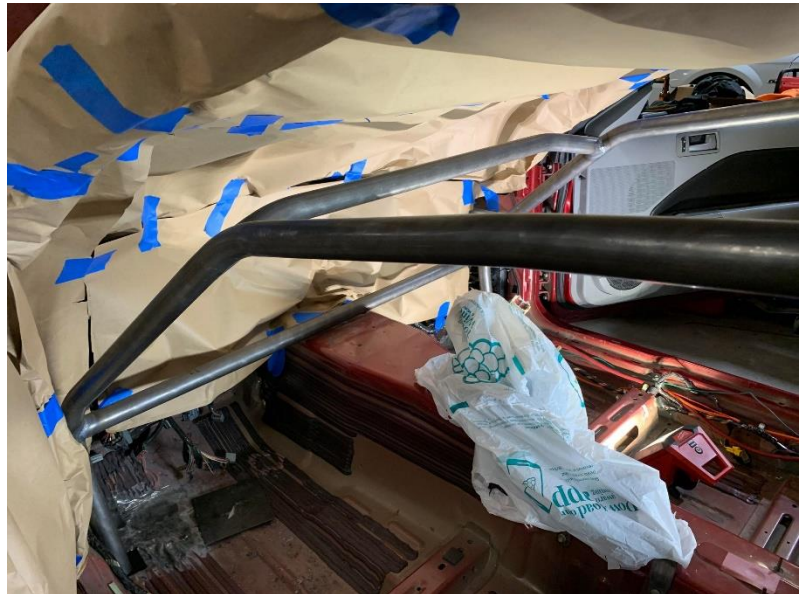
Step 1

Level car to floor. **This is critical!**

Make sure the car is level side to side and front to back.

Step 2

Clean Seam Sealer and get floor to bare metal where the 6x6 plates will land on the floor. Also shown here is what can be done to assist welding the tops of the cage. Cut small holes to allow the cage to drop through the floor. This allows you to reach those tough places on top of the cage. Then when finished welding, slide the plates under the cage structure and weld the plates to the floor.



Step 4

Once the plates are on the floor, Set the main hoop and tack lightly

On the bottom of the main hoop that wraps around the rear seat area, This needs to be 0 degrees. If measuring above that, it is leaned back 14 degrees.



Step 5

Once the main hoop is set and tacked. Fit the 12A, 12B, 13 bars

Step 6

Now, the #11 bar can now be set.

Step 7

The rest of the bars can now be set in any order. Keeping the above order helps keep the cage square and even as you assemble and tack into place.

Step 8

The rear down will be placed on the plates provided.

**If there's something this didn't cover, Please contact us and
we can point you in the right direction.**

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