READ ALL INSTRUCTIONS COMPLETELY AND THOROUGHLY UNDERSTAND THEM BEFORE DOING ANYTHING. CALL CHASSISWORKS TECH SUPPORT (916) 388-0288 IF YOU NEED ASSISTANCE.

7044
Back Brace g-Street 1-3/4” Tube Bolt-In Connection

PARTS LIST

7044 - Back Brace gStreet 1-3/4” Tube Bolt-In Connection

Part Number	Qty.	Description
1138	2	Weld clevis 1.480 with 1/2” hole
2838	2	Back brace bracket 3/8” thick
3100-050F2.25Y	2	Bolt 1/2-20 x 2-1/4”, hex head cap screw
3101-050-20C	2	Locknut 1/2-20 nylon insert
Optional		
5918-144	Roll bar spuds .50 x 1.44” for one sidebar or one back brace, made for 1-3/4” tube includes spuds for both ends of one tube	
3226-L-50-150	Quick-lock L-Handle 1/2 x 1-1/2” long, stainless shaft with aluminum handle push-button aircraft style	

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INSTRUCTIONS

1. The complete roll bar or cage assembly must be completely welded in the car before installing any removable side bar or removable back brace kit. Failure to do this will cause binding in the bolts because the welding process will distort the opening enough to change the length of the removable bar.

2. Use one small tack weld on each back brace tab to position them correctly per the following requirements. One small tack will allow for slight adjustment when fitting the back brace tube.

    - Tabs must be same height above rocker sill so back brace bar will sit level.
    - Tabs must point straight back from main hoop. This will prevent injury when climbing past main hoop when the back brace is removed. Additionally it provides additional leg room by positioning the seat farther back.
    - Rotate the position of the clevis tab brackets on the main hoop so the edges that face each other are parallel. If you center the ½" hole on the tube there will not be enough depth in the clevis slot to install the bolt.

3. Insert a clevis into only one end of the back brace bar and fully weld it in place.

4. Use a ½" bolt to hang the unwelded second clevis on one side of the main hoop.

5. Use another bolt to position the back brace tube end with the first clevis already installed on the other side of the main hoop.

6. Hold the back brace tube and the uninstalled clevis beside each other.

7. Mark the back brace tube where it needs to be cut to correctly position the tube just short of the shoulder on the currently unwelded clevis.

8. Remove the back brace tube, saw it to length and drill two 1/4" holes through the back brace bar 180 degrees apart for rosette welds.

9. Reinstall the back brace bar and second clevis with the 1/2-20 x 2-1/4" hex bolts. Use a standard hex nut for this so the nylon in the locknut is not damaged during welding.

10. Verify everything is level and square before proceeding.

11. Do not weld the second clevis to the back brace tube.

12. Completely weld both clevis tabs to the main hoop.

13. Wait for everything to cool down before proceeding. This method will minimize the length changes between the clevis tabs after the second clevis is installed.

14. Plug weld the tube rosette holes first and wait for them to cool down. This will prevent the second clevis from pulling in and the back brace being too short after welding.

15. Weld around the second clevis. Wait for it to cool down.

16. Remove the nuts and see if the bolts will slide out easily.

17. If the bolts are hard to remove, test them both and see which one is worse. Use a small rat tail file to elongate the ½" hole in the tab into a very slight oval, in line with the tube centerline.