

7031

INSTRUCTIONS FOR REMOVABLE SIDE BAR CLEVIS SET 1 3/4 TUBE

<u>ITEM</u>	<u>QTY</u>	<u>PART NO.</u>	<u>DESCRIPTION</u>
1	2	1138	Weld clevis 1.48 x 1/2 hole
2	2	2110	Bracket swingout
3	1	3603	Faspin 1/2 x 1 1/2
4	1	3102	Bolt 1/2 - 20 x 2
5	1	3200	Locknut 1/2

The clevis in this kit is designed to slip inside of a piece of tubing that is 1 3/4 OD with a .134 wall thickness.

1. The roll cage must be completely welded in the car before installing the Removable Side Bar kit. Failure to do this will cause binding in the faspins because the welding process will change the length of the side bar.
2. Weld the clevis into one end of the side bar.
3. Fit the swingout bracket in place for the lower end of the side bar. Put the side bar with clevis installed on the lower bracket to make sure it has the correct angle. Weld the bracket in place.
4. Fit the upper bracket in place on the main hoop. Cut the side bar so it is approximately 1/8" too long. Install the clevis into the side bar and the bracket. Weld the upper bracket in place with the side bar installed.
5. Cut the side bar to the exact length and then, drill two 3/16" holes through the side bar to be used for welding rosettes. Weld these holes up first. This will prevent the clevis from pulling in and being too short. Then, weld the upper clevis to the side bar while it is installed.

Revision Date: June 23, 2003

