

7033

INSTRUCTIONS FOR SWING-OUT CLEVIS SET FOR ROLL BARS, 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	1	1139	Weld eye 1.480 x .362 wide
3	1	4860	Side bar mounting loop 1 3/4 diameter
4	1	2110	Bracket swingout
5	1	3603	Faspin 1/2 x 1 1/2
6	1	3102	Bolt 1/2 - 20 x 2
7	1	3200	Locknut 1/2

This kit is designed to put a swing-out side bar into a roll bar equipped car. 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 bar 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 side bar mounting loop to the floor plate by the A pillar. Tilt it so the straight length points toward the main hoop at the same angle as the side bar. Tack it in place.
4. Fit the weld eye in place for the lower end of the side bar. Put the side bar with clevis installed on the lower weld eye to make sure it has the correct angle.
5. Fit the upper bracket in place on the main hoop. Cut the side bar so it is approximately 1/8" too long. Install the other clevis into the side bar and the bracket on the main hoop.
6. Tack all the pieces together except the upper side bar clevis. Test the operation of the swing-out side bar to make sure it clears everything. If it functions properly, weld everything up except the upper side bar clevis.
7. 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 to short. Then, weld the upper clevis to the side bar while it is installed.

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