

GT86-RCKR

1. REMOVE THE FRONT CROSSMEMBER FROM THE VEHICLE.
2. IF PRINTING TEMPLATES, CONFIRM BY MEASUREMENT THAT THE SCALE IS CORRECT. IF NOT, REPRINT AND ADJUST THE SHEET SCALE.

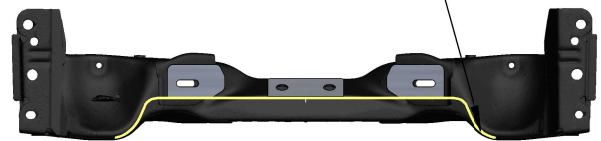
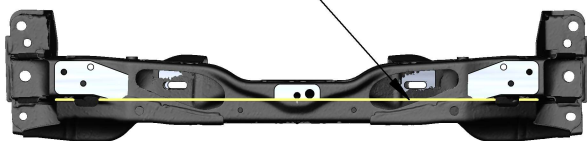
CUTOUT ALL OF THE SUPPLIED TEMPLATE PIECES.

3. ALIGN THE TEMPLATE PIECES ON TO THE CROSSMEMBER AS SHOWN BELOW AND MARK THE EDGES TO BE CUT.



TEMPLATES MUST
BE ALIGNED

FOLLOW CONTOUR



BOTTOM

TOP

MARK AND CUT LOWER
1/2 OF TUBE TO FREE IT

FOLLOW CONTOUR



FRONT

BACK

4. USE A GRINDER TO CAREFULLY CUT ALONG THE MARKED LINES AND REMOVE THAT SECTION OF THE CROSSMEMBER.
5. ONCE REMOVED TEST FIT THE RACK RELOCATION FRAME ON TO THE CROSSMEMBER. FRAME MUST SIT FLAT ON CUT SURFACE AND BE LEVEL AND EVEN.

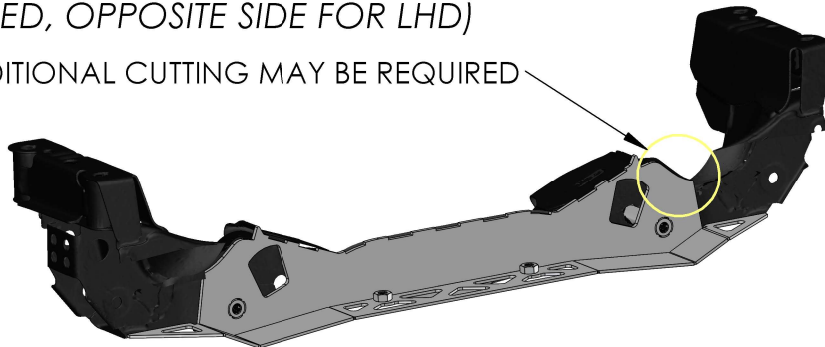
USE A GRINDER TO REMOVE HIGH SPOTS FROM THE CROSSMEMBER TO IMPROVE FITMENT.

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6. WHILE TEST FITTING THE RELOCATION FRAME, ALSO TEST FIT THE STEERING RACK ON TO THE FRAME. IN MOST CASES, YOU WILL NEED TO DO SOME ADDITIONAL TRIMMING AROUND THE PINION HOUSING.

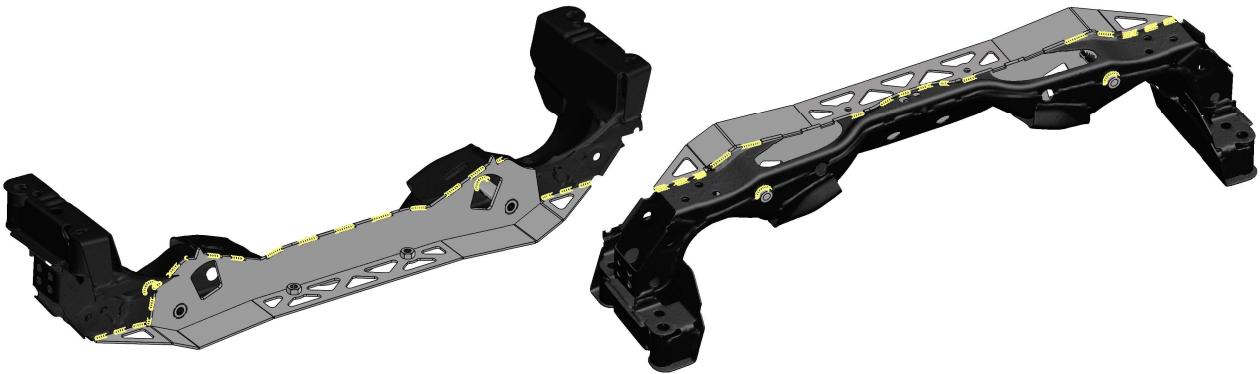
(RHD PICTURED, OPPOSITE SIDE FOR LHD)

ADDITIONAL CUTTING MAY BE REQUIRED



7. ONCE CLEARANCE AND FITMENT IS OPTIMAL AND YOU ARE READY FOR WELDING, RE-INSTALL THE CROSSMEMBER INTO THE VEHICLE USING THE 4 MAIN CROSSMEMBER BOLTS AND TORQUE TO 95Nm (70ft-lb).
8. TACK WELD THE RACK RELOCATION FRAME TO THE CUT AWAY CROSSMEMBER.
9. ALLOW THE TACKS TO COOL, THEN ONCE AGAIN CONFIRM RACK FITMENT IS OPTIMAL.
10. STITCH WELD THE CROSSMEMBER IN THE LOCATIONS HIGHLIGHTED BELOW.

NOTE: WELDING WHEN INSTALLED IN THE VEHICLE IS OPTIMAL AS CUT AWAY CROSSMEMBER IS FLEXIBLE AND LIKELY TO BE WELDED OUT OF POSITION AND TO WARP. ALTERNATIVELY, GOOD RESULTS COULD BE ACHIEVED OUTSIDE OF THE VEHICLE BY USING CAREFUL MEASUREMENTS AND BRACING. DO NOT UNDERESTIMATE HOW FLEXIBLE THE CUT AWAY CROSSMEMBER IS!



11. ALLOW TO CROSSMEMBER TO COOL IN THE VEHICLE AS THIS WILL PREVENT WARPING.
12. REMOVE FROM THE VEHICLE AND PAINT THE CROSSMEMBER TO PREVENT RUST AND CORROSION.
13. INSTALL THE FINISHED CROSSMEMBER USING THE FOLLOWING TORQUE SPECS:
 - CROSSMEMBER MOUNTING BOLTS: 95Nm (70ft-lb)
 - ENGINE MOUNTS: 60Nm (44ft-lb)
 - STEERING RACK MOUNTS: 120Nm (88.5ft-lb)
 - STEERING COLUMN UNI JOINT: 35Nm (26ft-lb)
 - TIE ROD TO STEERING RACK: 103Nm (76ft-lb)