

## Land Rover Defender 90/110 Truck Cab/Pick-Up (L153) Fitting Instructions

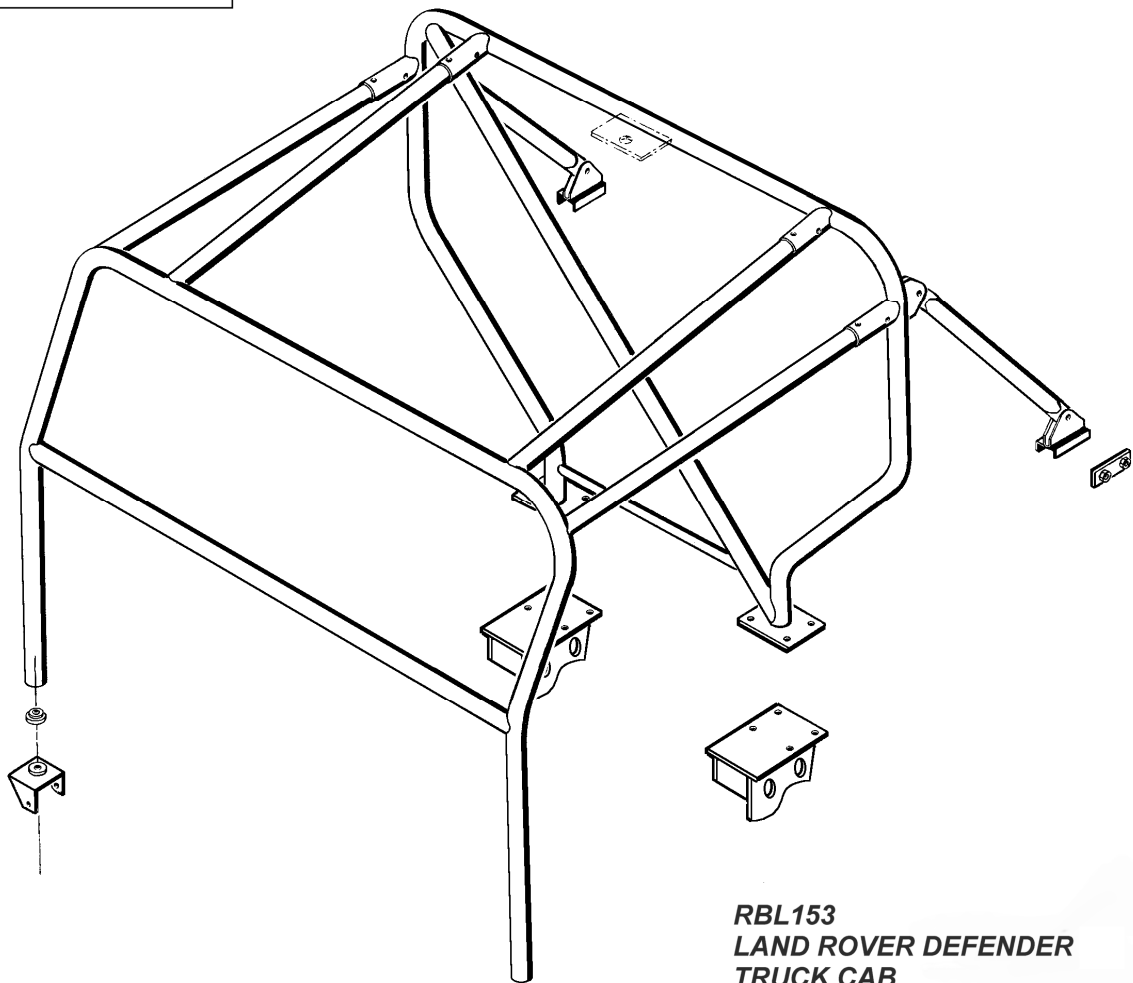
Unwrap the roll cage and unpack the individual fitting kits. At this point it is recommended that all the main components are checked against the assembly drawing provided on page 3 of these instructions. Should any parts or fixings be missing at this stage, or during installation, please contact your stockist.

Throughout the assembly we shall use a variety of different fasteners; the torque setting for each different size is listed below:

M10 - 45Nm   M12 - 70Nm   M14 - 95Nm   7/16<sup>th</sup> - 55Nm

- 1) Remove both sills completely.
- 2) Remove M12 bolts and washers from the front outriggers and body mounts at bottom of the bulkhead.
- 3) Fit front leg chassis brackets and relocate M12 bolts and washers. Do not tighten the nuts and bolts at this stage.
- 4) Mark out the holes in the front wings just in front of the 'A' posts. (A template for the hole position can be found at the back of these fitting instructions.)
- 5) Drill out the holes with 55mm hole saw making sure to keep drill vertical as it passes through the wing and down inside the panel.
- 6) Dress the hole with a file to ensure a good fit around the front leg when the rubber trim is fitted.
- 7) Remove the plastic air intake cover panel from the right hand side wing just behind the wheel arch.
- 8) Heat up the end of a length of 2" steel tube and pass it down through 52mm hole in the top of the wing keeping it straight and vertical.
- 9) The hot end of the tube will melt its way through the plastic air intake inside the wing.
- 10) Fit the rubber trim to the 52mm holes.
- 11) Lift the whole front cage assembly into position over the two holes (this procedure will require two people) and lower the front legs down into the holes.
- 12) Feed the legs down the holes until they meet the chassis plate on the outriggers.
- 13) Insert the two 5/8"x 1.5" UNF socket head bolts into the base of the front cage feet and tighten fully.

- 14) Fully tighten the two M12 bolts that pass through the front leg chassis brackets.
- 15) Seal inside the air intake down the edges of the left hand front leg and refit the plastic cover grill.
- 16) Lift the main hoop into the back of the vehicles and manoeuvre into position so that the four roof bars slot into the four short tubes on the front face of the hoop.
- 17) Push the hoop fully home.
- 18) Check that the hoop is sitting square to the vertical and then drill through the holes in the foot plates down through the floor with a 13mm drill bit.
- 19) Offer up the rear chassis brackets underneath the rear of the buck so that the holes in the square plates line up with those drilled through the floor of the buck..
- 20) Bolt the hoop to the rear chassis brackets through the floor with eight M12 x 60 hex head bolts, nuts and washers and tighten down fully.
- 21) Mark off the position of the holes in each of the four short tubes on the front of the hoop, one horizontally and one vertically. Measure 20mm in from the end of the tube for horizontal hole and 35mm from that hole to the vertical hole.
- 22) Drill through the holes completely with 11mm drill bit.
- 23) Fit Eight M10 x 80 hex head bolts, nuts and washers and fully tighten.
- 24) Loosely bolt the backstays onto the brackets on the rear of the main hoop and in turn the backstay capping brackets to the other end of the back stays using four M12 x 35 hex head bolts.
- 25) Locate the capping brackets so that they straddle the top edge of the rear buck, and with a pencil, mark through the two 11mm holes in the side of each bracket onto the capping.
- 26) Drill out the four marked holes with 11mm drill bit.
- 27) Locate the two nut plates inside the cavity of the capping and line them up with the two 11mm holes and bolt the capping brackets into position with four M10 x 25 hex head bolts and washers and tighten fully.

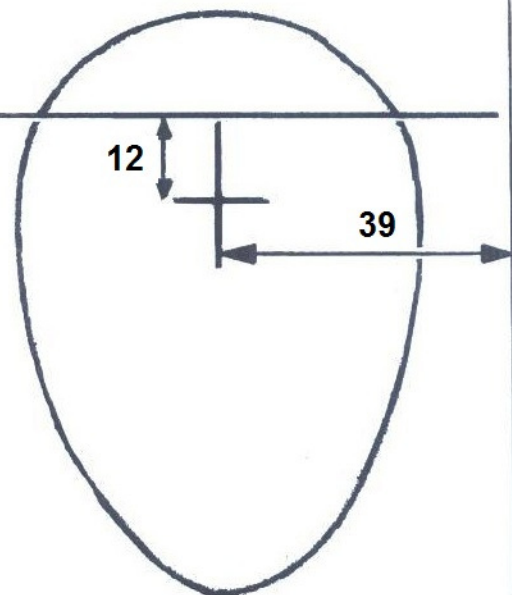


**RBL153  
LAND ROVER DEFENDER  
TRUCK CAB  
FULL EXTERNAL CDS ROLL CAGE**

TOP WING JOINT

LH side shown, RH opposite

Use 55mm Diameter Hole Saw  
Drill in vertical position



REAR OF WING JOINT