

Porsche 911 - P010 Weld-in cage fitting instructions and tips

1. Pre-checks and main hoop

- Check all the components of the kit and review the layout drawing as to the position of each, using page 3 of these instructions.
- Trim B-Post pillar as shown in picture (1).
- Locate the 'B' post hoop (main hoop) floor plate 50mm from datum hole, as shown in picture (2)

This plate position must remain flexible until the main structure of the cage is finished. This plate position is the starting point of the original development and the starting point for installation.

- The main hoop will require trimming to length. A black guideline is on each leg but the height of the hoop will have to be made in relation to each individual body shell.
- Position the main hoop on the mounting plate, checking roof clearance etc. To hold the hoop in place, tape around the 'B' post to allow flexibility of movement.

2. Front legs and screen rail

- Loosely position the front leg plates and hold in place with tape
- Check the fit of the legs with the 'B' hoop and profile the legs to fit against the 'B' hoop. Each leg has a guideline marked on it (at both ends). (3)
- The screen rail should now be positioned and the same profiling of tube ends carried out. If there is a roof diagonal in the kit, this must also be profiled and the whole assembly check fitted at the same time. (4)
- The fit and finish of this group of parts is paramount to the appearance of the cage.

Make Sure:

- The legs are close enough to the body to weld later and do not foul any other components.
- The screen rail and roof diagonal are a good fit.
- The link to the front triangulation is good and the welder can get to all joints easily (this only applies if front triangulation is being used)
- Now you are ready to do the final welding of the main structure joints.
 - Weld the joints as much as possible.
 - Remove the fitting plates from the 'B' post hoop and front legs
 - Drop the cage down to the floor level. It may be necessary to pull the legs together with a rope or ratchet strap. (5)
 - Finish off the welding of the main structure on the topside of the joints.
 - Lift the cage back into position and relocate the foot plates
 - Shuffle the whole assembly to get the best fit in relation to the body. Tack the cage to the body to hold it in position. Do NOT finalise the welding at this point.

3. Rear backstays and other straight points.

- These can now be positioned. Many have the ends already profiled but may require that to get a perfect fit are chamfered individually. Use a file or a die grinder to do this. (6).
- Only when you have all the tubes tacked in place and are satisfied with the overall fit, do you finally weld all joints including the floor plates and gussets.
- Use minimum weld lengths of 40mm when stitching to the body. Space them out accordingly and symmetrically – Remember, good quality neat welding is very important.

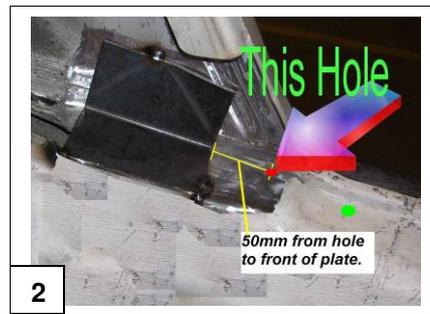
4. Front triangulation

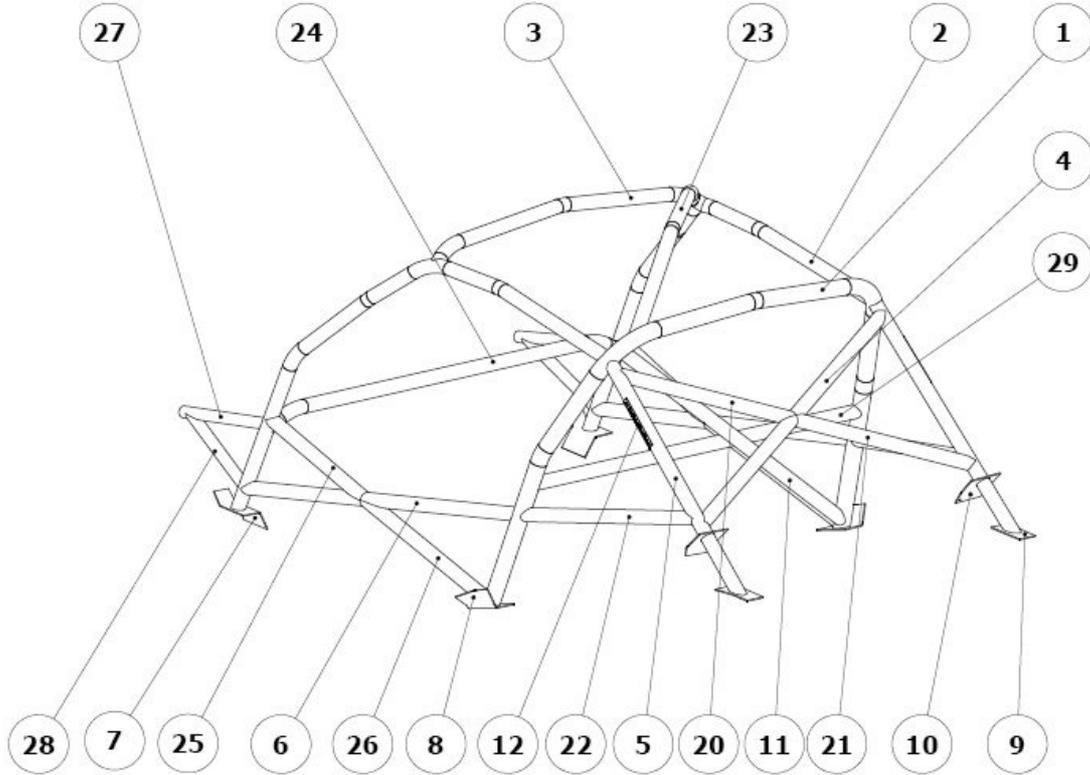
- This usually requires a degree of skill in getting the fit to the cage accurate. The triangulation will require to be in place prior to the front legs being finally positioned. (7) (8). Some of the illustrations are of a Rover 25 with the outer panel removed. Most cars triangulation is installed inside the engine compartment.

Remember:

- Always check the clearance to other components as you progress with the assembly. It is too late if for example you have finished the job and the seats foul!!

Remember to send your certification to the M.S.A !!





Item	Catalogue No	Description	Plasma	Type	Material	Qty	✓
PRIME CAGE (1-12)							
1	RBP0106BH	B' POST HOOP	-	BENT - UNPROFILED	CDS44 12T	1	
2	RBP0106FL	FRONT LEGS	-	BENT - UNPROFILED	CDS38 14T	2	
3	RBP0106TR	TOP RAIL	-	BENT - UNPROFILED	CDS38 14T	1	
4	RBP0106BD	BACKSTAY DIAGONAL	3580	PROFILED	CDS38 14T	1	
5	RBP0106BS	BACKSTAYS	2879	PROFILED	CDS38 14T	2	
6	RBP0106DB	DOORBAR (SINGLE RH & LH)	3583 & 3584	PROFILED	CDS38 14T	2	
7	20-2400-117	RH/LH - F/LEG PLATES	-	PLATE	-	2	
8	20-2400-116	RH/LH - B/HOOP PLATES	-	PLATE	-	2	
9	20-2000-67	BACKSTAY PLATE	-	PLATE	-	2	
10	20-2340-201	BULKHEAD PLATE	-	PLATE	-	2	
11	RBP0106BD1	MAIN HOOP DIAGONAL	2880	PROFILED	CDS38 16T	1	
12	20-2300-420	SD IDENTITY PLATE	-	PLATE	-	2	
13	HOMSTP010	HOMOLOGATION STICKER	-	-	-	1	
14	-	SDI LOGO STICKER	-	-	-	2	
15	-	FITTING INSTRUCTIONS	-	-	-	1	
FULL CAGE (1-29)							
20	RBP0106XDU	Upper 'X' Diagonal	3581	PROFILED	CDS38 16T	1	
21	RBP0106XDL	Lower 'X' Diagonal	3582	PROFILED	CDS38 16T	1	
22	RBP0106LBS	Lower Backstays	2877	PROFILED	CDS38 16T	2	
23	RBP0106RD	Roof Diagonal	-	BENT - UNPROFILED	CDS38 14T	1	
24	RBP0106DAB	Front Dash Bar	-	BENT - UNPROFILED	CDS38 16T	1	
25	RBP0106XDBU	Upper 'X' Doorbar	2887	PROFILED	CDS38 16T	2	
26	RBP0106XDBL	Lower 'X' Doorbar	2886	PROFILED	CDS38 16T	2	
27	RBP0106FTR	Top Triangulation	2885	PROFILED	CDS38 16T	2	
28	RBP0106FTB	Lower Triangulation	2883	PROFILED	CDS38 16T	2	
29	RBP0106XB	Rear Hoop Brace	2881	PROFILED	CDS38 16T	1	