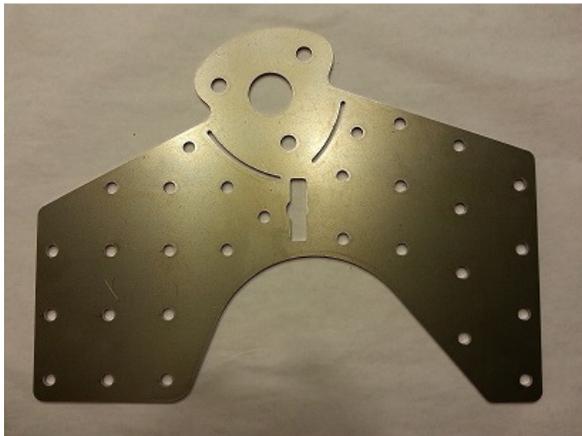


Porsche 911 Front Sway Bar Stiffening Kit Instructions

Do not bypass any safety practices while doing this installation. Use a jack and jack stands, safety glasses, face shields and welding gloves to protect you when drilling, grinding or welding. Be sure you disconnect the car's battery before starting to weld.

The 911 sway bar stiffening kit is composed of two 16-gauge chassis strengthening panels. MIG or TIG welding is the recommended attaching procedure, as this puts less heat into the chassis. Stitch weld along all panel edges and weld each hole, details will follow below. This kit will significantly strengthen the area where the front sway bar attaches and passes through the 911 body. (note: instructions were copied from the 914 version but the process is the same.)



Step 1. Areas to be welded must be cleaned of all undercoating, dirt and grease.



Step 2. Before attaching the panels, check the chassis for cracks, especially around all production welds and where two or more panels come together, and repair any cracks or rust. Below you see how the chassis has been stressed by the sway bar and has cracked by the top bolt hole. This crack and the holes should be welded and ground down as new holes will be drilled for the new stiffening panels.



Step 3. At this point you have to make a decision if you want to remove the brake line bracket and then re-weld it on top of the stiffener panel or use the slot provided so the panel can slip over the bracket. In this installation the bracket was removed and re-welded for a nice flush look. You can get a special tool that cuts around the spot welds or you can simply drill them out and use a cold chisel. Make sure to take some measurements and a couple of pics before you remove.



Step 4. Once any repairs are made and all undercoating has been removed, you need to prep the bare metal with a weld-able primer. A good product is SEM Copperweld 40783.



Step 5. To make your work easier, first drill two holes in the chassis for each panel, and attach the panels with sheet metal screws to check the fit up. Once you are satisfied with the placement, and to ensure that the stiffening panel is held tight to the body, you will want to drive a #10 self tapping sheet metal screw in each hole and use clamps where ever possible. I know it is a lot of work but the reason for driving a screw in each hole is to hold the panel in place while you weld and when you remove the screw it leaves a nice little hole to weld the two panels together.



Step 6. Now start at one end of the panel and remove one screw at a time and fill the hole with weld, after each weld blow some air on the weld to cool it then move to another part of the panel and repeat, this will help spread the heat out and not stress the chassis.





Step 7. Re-weld the brake line bracket back on now. Once you are done welding and depending on how good of a welder you are, you will have to grind all those welds flat!



Step 8. And finally give it a nice coat of primer and paint and depending on where you live maybe some undercoating. Have fun and good luck!



Thank You!
Maddogs Motor Sports

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