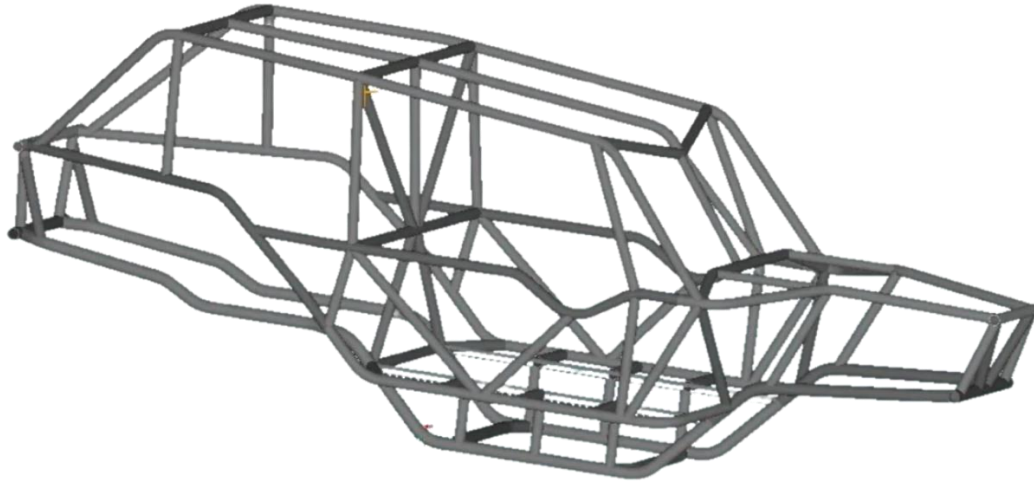




DF Fabrication

4 Seat Chassis Assembly Kit "Stampede"



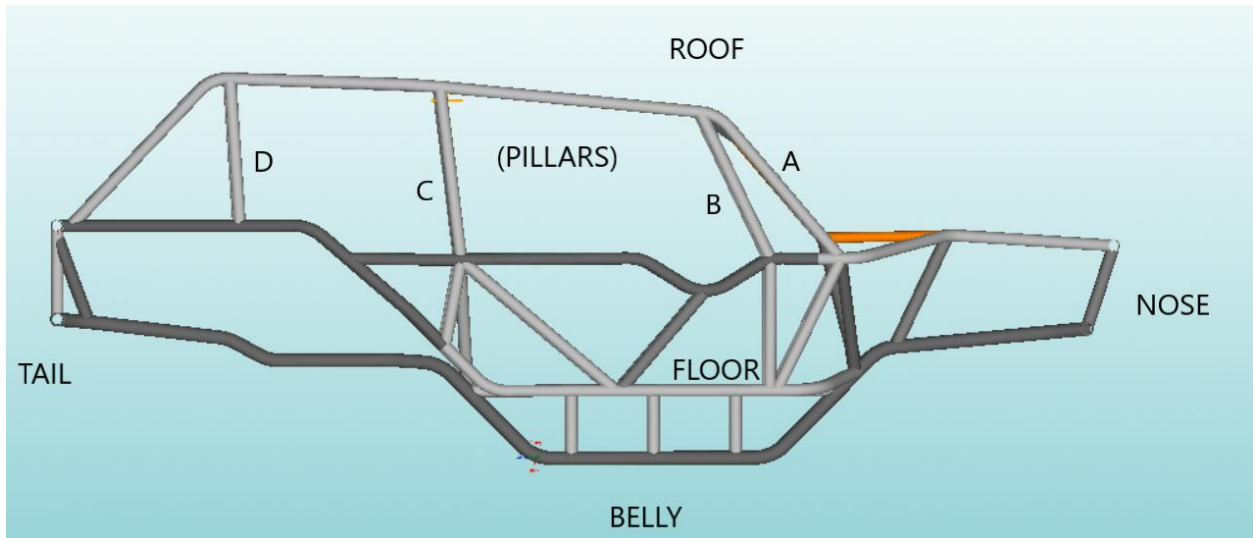
Stampede Chassis Assembly Instructions

All our chassis are CNC cut for precision. Each tube is CNC labeled with a part name and tube locations that may be on an individual part. The tube profile is marked on the tube to provide the exact placement of each tube.

Step 1: Subframe Assembly

The subframe is the lower half of the chassis that is constructed from 2" .120 DOM tubing. The subframe is made up of 10 - 2" tubes: **FR1-3, TAIL, NOSE, AND BELLY**. There are 4 joints in the subframe that will receive a 1.75" sleeve and 4 plug weld per joint.

- 1.) Start with taking **FR1, FLOOR** and 3 **BELLY** tubes and laying them on a flat surface. You will need to identify the markings on the tubes to orient them correctly.
- 2.) Assemble these tubes flat on a table and install each tube at its corresponding location marked on the tube.
- 3.) Observe on each side that the front and rear vertical **BELLY** tubes have a double cope on them where the vertical **BELLY** tube meets the horizontal **BELLY** tube.



Step 2: Subframe + Floor

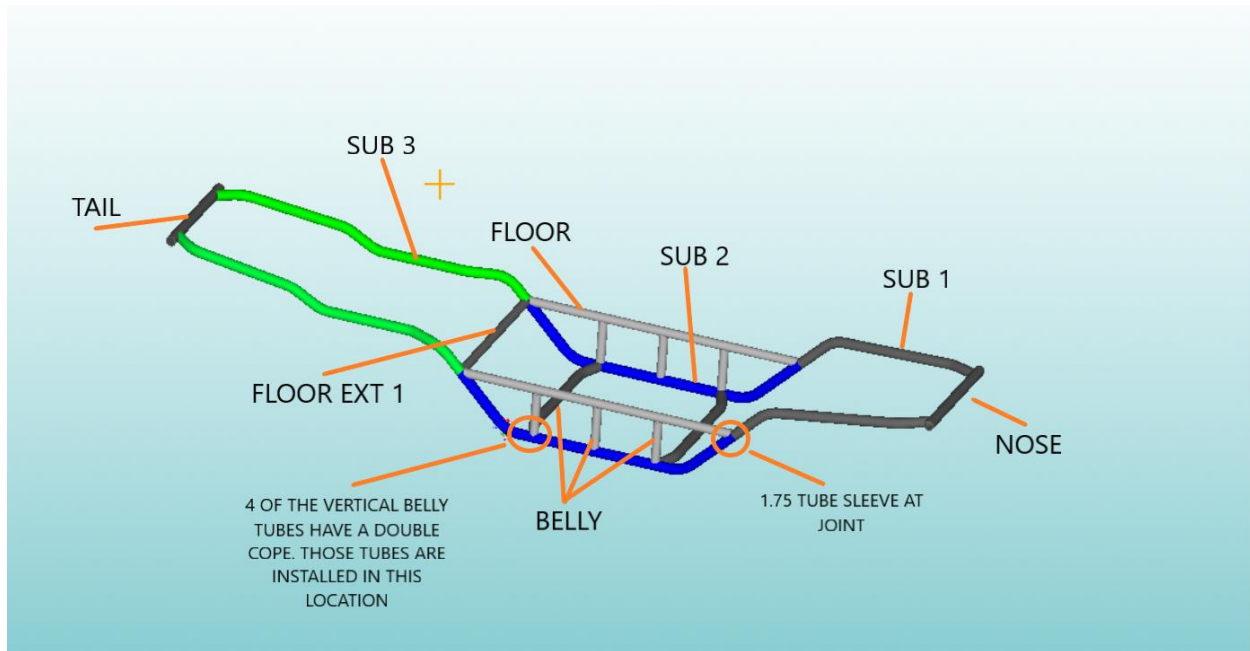
Once both sides have been tacked together, the two sides can be assembled.

Tip: It may be helpful to use a piece of box tubing to aid in holding the two sides together.

- 1.) Install the lower **BELLY 2"** tubes in-between the two assemblies previously installed.
*These two tubes will set the width of the **BELLY**.*

It is critical to maintain a plumb and level surface during assembly to provide consistency throughout the build.

- 2.) Install the **FLOOR EXT 1** tube to set the upper width of the assembly. Use a cross brace clamped up front between the two assemblies to keep the tube plumb.
Tip: If using a steel table for assembly, the lower Main SUB 2 tubes can be tacked to the table so they do not move.
- 3.) Install and tack weld the 4 tube sleeves at each end of the middle **FR1(SUB 1)** tubes.
- 4.) Install the 2 -Rear **FR1(SUB 3)** lower tubes and 2 - Front **FR1 (SUB 2)** tubes on to the other end of the sleeves previously installed. (**DO NOT** tack these tubes yet)
NOTE: A 1/8" gap should be left between the ends of the tubes at every sleeve joint to achieve a good weld



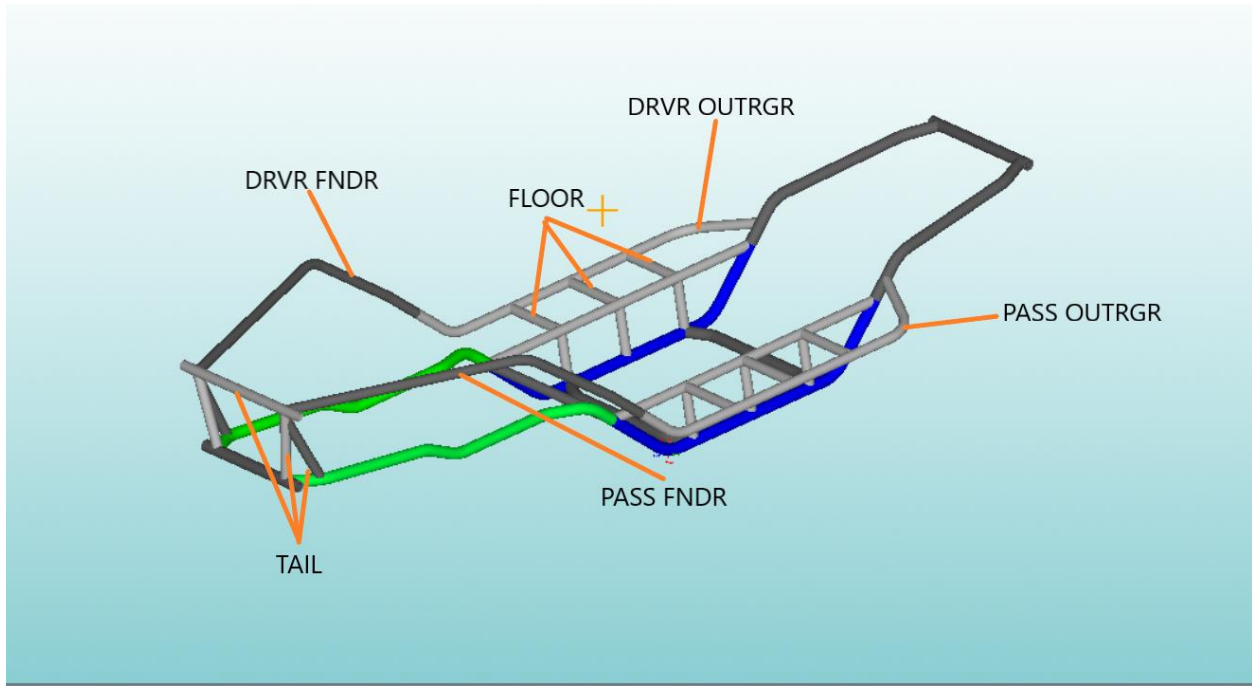
Step 3: Subframe Final Assembly

The last part of the lower assembly will be to install the lower 2" **TAIL** tube and the 2" **NOSE** tube. **Before tack welding these tubes, you must square the chassis.**

- 1.) Cross measure multiple times until you achieve the same measurement.
- 2.) Once chassis is square, plumb, and level, you can tack the **NOSE** and **TAIL** tubes
- 3.) Tack weld each tube at the sleeve joint.

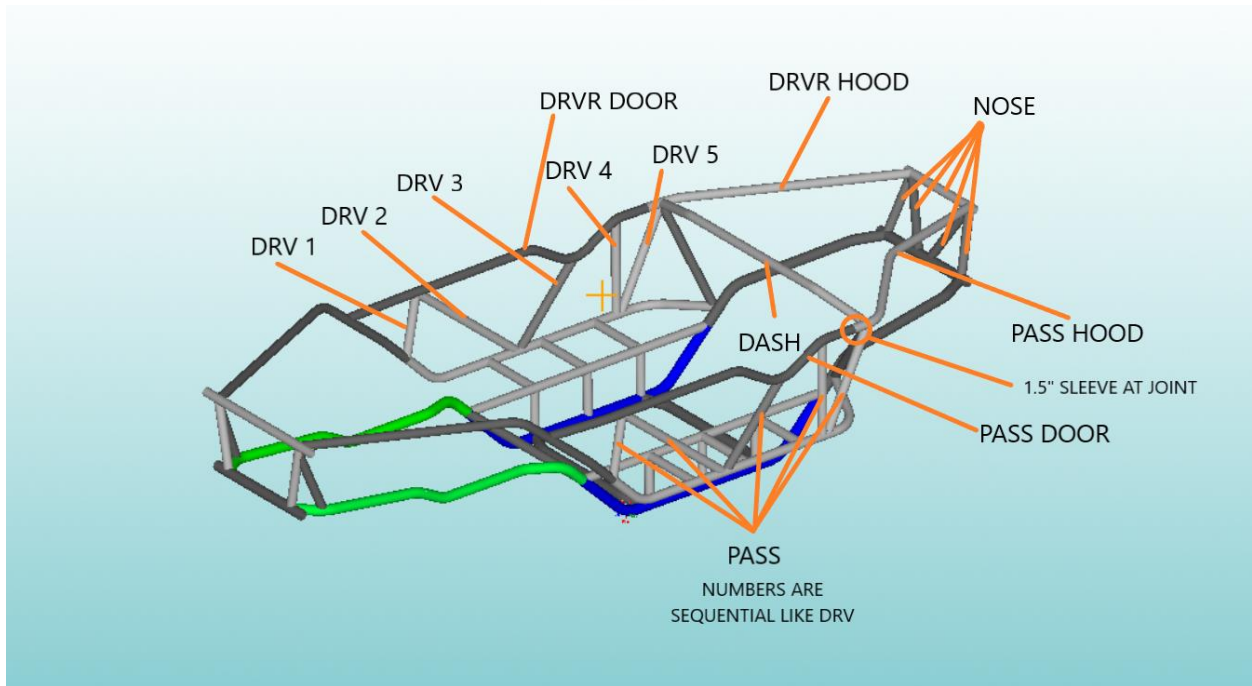
Step 4: Floor

- 1.) Use a long straight edge or box tubing and lay it across the top of **SUB 2** in the front and the back.
- 2.) Install the **PASS OUTRGR** and the **DRVR OUTRGR** at their defined locations up front on the **FR1** tube.
- 3.) Use the straight edge you previously set in place to clamp the back end of the **OUTRGR** tube.
- 4.) Install the 6 **FLOOR** tubes horizontal between the **FLOOR** and **OUTRGR**.
- 5.) Tack weld these tubes once they are installed.



Step 5: Rear Fender

- 1.) Once the **OUTGR** is installed and secured, install a 1.5" sleeve at the end of the **OUTGR** tube and tack weld it in place.
- 2.) Install the **DRVR FENDER** and **PASS FENDER** onto the other end of the sleeve leaving a 1/8" gap.
- 3.) Assemble the 5 - 1.75" TAIL tubes installing them onto the tubes marked location.



Step 6: Driver Door & Hood

For ease of install, it is recommended that the side tubes are assembled with a 90° square or by creating a small fixture to hold the top side rail.

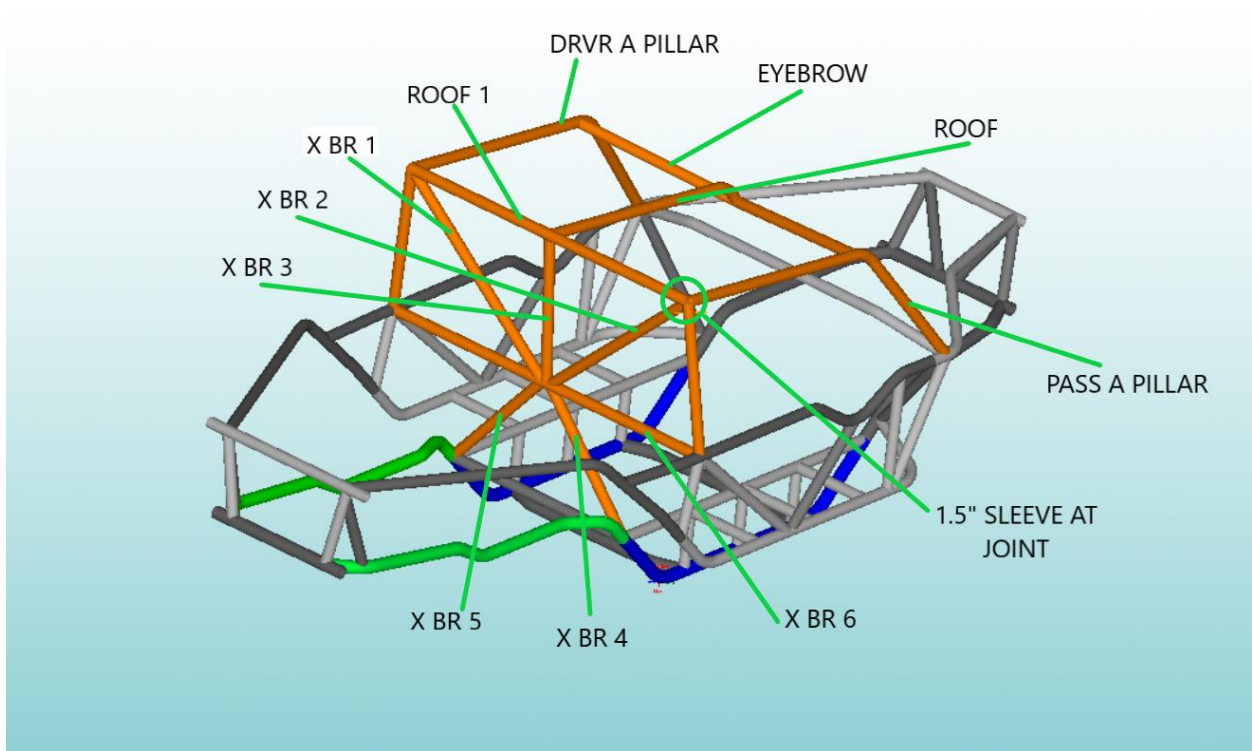
- 1.) Install the **DRVR DOOR** bar placing the rear of the tube on the marked location of the rear fender and using the **DRVR B PILL** tube to support the front of the **DRVR DOOR** tube and tack weld.
- 2.) Install **3 DRVR TUBES** into the side assembly and tack weld them in place.
- 3.) Install the 1.5" sleeve into the front end of the **DRVR DOOR**.
- 4.) Install the **DRVR HOOD**. You can leave the **DRVR HOOD** tube untacked for now.

Step 7: Passenger Door

- 1.) Using the same steps as the **DRVR** (step 6), install the **PASS DOOR** tubes and 1.5" sleeve and the **PASS HOOD** tube.
- 2.) Install the **DASH** and **X BR6** tubes loosely to help set the width. Use a strap from one side to the other to keep tension on the tube.
- 3.) To finish the **HOOD**, take the remaining 5 - **NOSE** tubes and complete the **NOSE** assembly by installing the tubes on to their marked locations.

NOTE: Use cross straps to help maintain the tube works position.

*****CHECK CHASSIS TO ENSURE IT IS STILL SQUARE AND PLUMB*****



Step 8: Main X Brace Structure

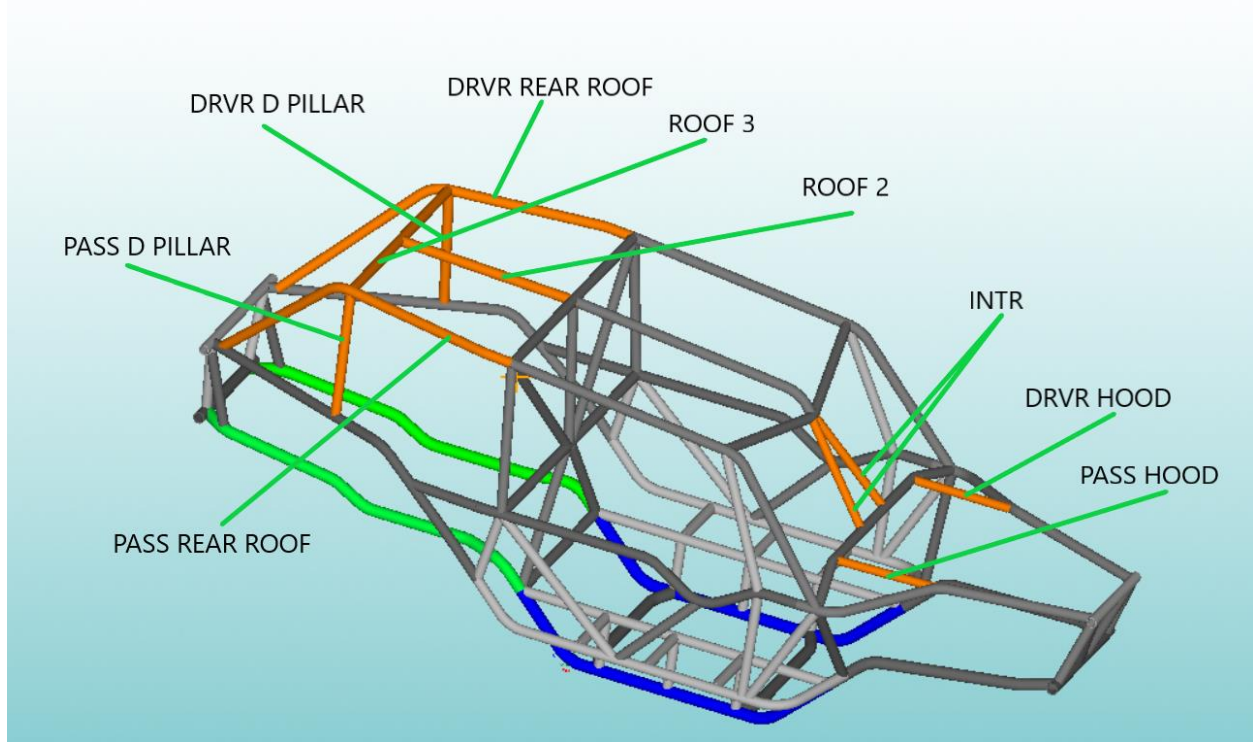
- 1.) With **X BR6** installed in step 7, you can now install **X BR4** and **X BR5**.
These tubes will help maintain the side tubes retain their plumb or vertical 90° position.
Tip: In this next step an extra set of hands is helpful.
- 2.) Install **X BR3** vertical and tack weld.
- 3.) Install **DRVR C PILLAR** and **X BR 1** together using the **ROOF 1** tube to help set the inward angle of the **DRVR C PILLAR**.
- 4.) Repeat above installation process on the **PASS** side and include **ROOF 1** tube.

Step 9: Driver & Passenger A Pillars

- 1.) The **DRVR** and **PASS A PILLAR** tubes will locate the angle at which the previous X brace tubes lean towards the back.
- 2.) The end of both **A PILLAR** tubes will get a 1.5" tube sleeve.
- 3.) The **A PILLAR** should be installed on top of the **C PILLAR** so that the end of the **A PILLAR** tube sits in the middle of the **C PILLAR** cope.

NOTE: The DASH tube will sit on the same plane as the front A PILLAR tubes.

*****CHECK CHASSIS TO ENSURE IT IS STILL SQUARE AND PLUMB*****



Step 10: Roof

At this point the chassis is rigid with the X brace tube work.

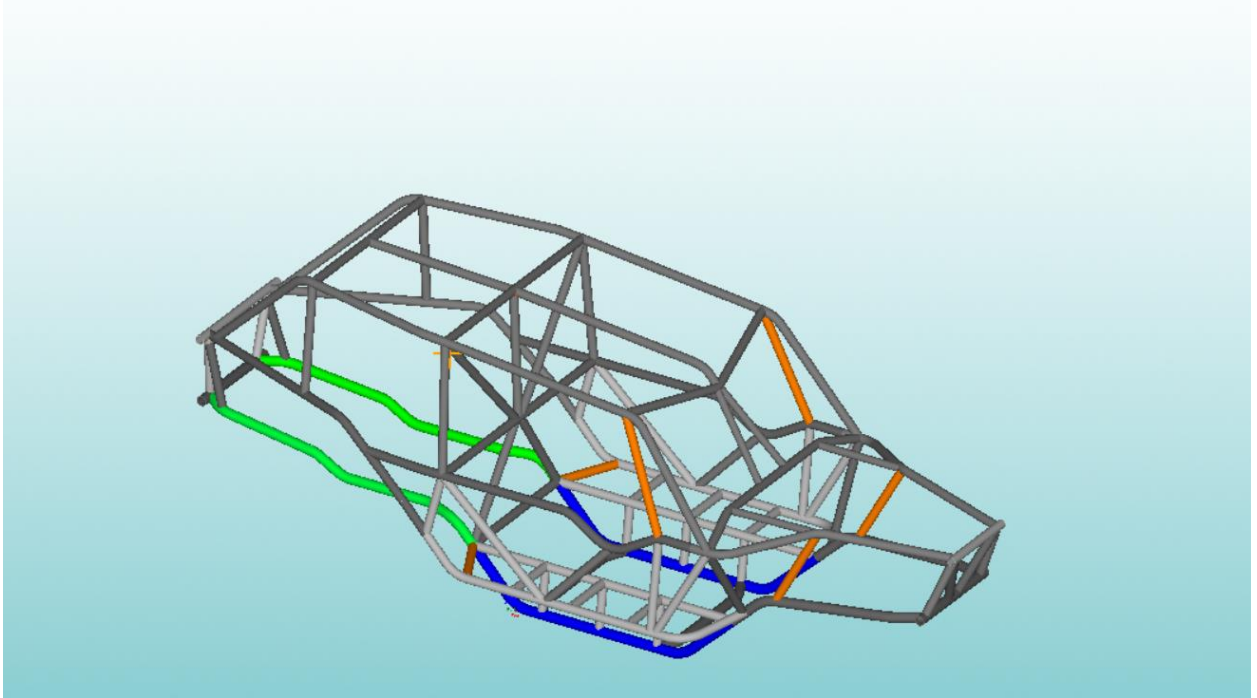
*****CHECK CHASSIS TO ENSURE IT IS STILL SQUARE AND PLUMB*****

- 1.) Install the **EYEBROW** bar.
*This will set the width of the **DRVR** and **PASS A PILLAR**.*
- 2.) Use a strap to help hold the **EYEBROW** in place.
- 3.) Use a point of reference on the **FLOOR** tube on both sides and measure down from the **A PILLAR** on both sides until they are the same.
Tip: It will help to strap diagonally from the A PILLAR to the FLOOR and make small adjustments until both dimensions are the same.
- 4.) Install the **DRVR** and **PASS HOOD** support tubes.
*These tubes will aid in setting the angle at which the **DASH** tube sits.*
*NOTE: The **DASH** and the **A PILLAR** angle/plane is the same.*
- 5.) Install the **SHK SUPPORT** tubes on both **PASS** and **DRVR** to ensure that the fitment of the **DRVR HOOD** support and **SHK SUPPORT** are tight.
- 6.) Install remaining **ROOF** center tube and the 2 - **INTR** tubes.
*These tubes help locate the angle at which the **EYEBROW** tube is installed.*



Step 11: Rear Roof

- 1.) Install the tube sleeves into the end of the **A PILLAR** tube.
- 2.) Install the **DRVR** and **PASS REAR ROOF** on the end of the 1.5" sleeve.
NOTE: Leave 1/8" gap for welding.
- 3.) Install **ROOF 3** tube to set the width between the **DRVR** and **PASS REAR ROOF** tubes.
- 4.) Install the **ROOF 2** and both **PASS** and **DRVR D PILLAR** tubes as marked on the tube.
This will complete the rear section.



Step 12: Final Completion

- 1.) Install the final 4 tubes **PASS** and **DRVR B PILLAR**, **FLOOR EXT 1** and **FLOOR EXT 2** as marked on the tube.

If tube gusset kit or other tube assemblies have been purchased, additional installation instructions will be provided separately.