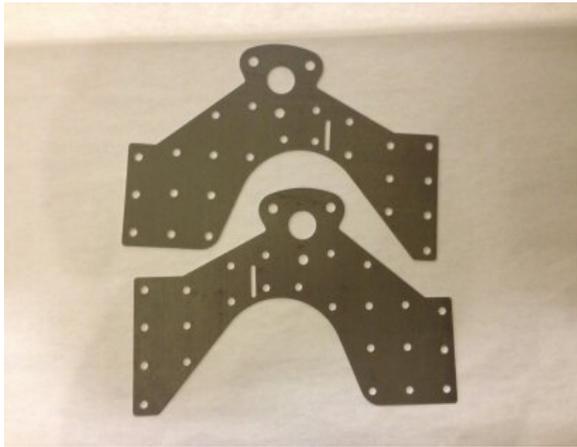


Porsche 914 Front Sway Bar Stiffening Kit Instructions

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

The 914 sway bar stiffening kit is composed of two 16-gauge chassis strengthening panels. MIG or TIG welding is recommended as this applies less heat to the chassis. Stitch weld along all panel edges and weld each hole; details follow below. This kit will significantly strengthen the area where the front sway bar attaches and passes through the 914 body.



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



Step 2. Before attaching the panels, check the chassis and repair all rust or cracks, especially around all production welds and where two or more panels come together. 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 need to be drilled for the new stiffening panels.



At this point you need to decide whether or not 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. Be sure to take some measurements and a couple of pics before you remove.



Step 4. Once repairs are made and all undercoating has been removed, you'll 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. 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 into each hole and use clamps wherever 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, remove one screw at a time and fill each hole with a 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 as to not put too much stress on the chassis.





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



Step 8. When you're done grinding down your welds, drill out the holes for the mounting bolts and sway bar. Finally, give it a nice coat of primer and paint, depending on where you live you may also want to apply some undercoating. Have fun and good luck!



Thank You!
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