

## **Porsche 911 Rear Spring Plate Reinforcement Kit Instructions**

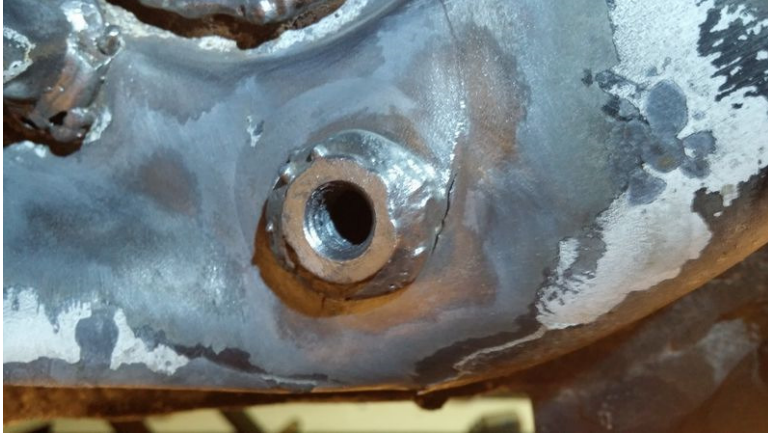
**Do not bypass any safety practices while doing this installation. Use a jack and jack stands, safety glasses, face shields and welding gloves to protect you when drilling, grinding or welding. Be sure you disconnect the car's battery before starting to weld.**

The 911 rear spring plate reinforcement kit is composed of two 11-gauge (.125") steel strengthening panels and one mounting post alignment plate. 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 around each torsion bar mounting post, details will follow below. This kit will significantly strengthen the area around the torsion bar mounting posts and distribute the load from the torsion bar and spring plate to the tube housing and sheet metal beyond the mounting posts locations..



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 repair any cracks or rust. Below you see how the chassis has been stressed by the torsion bar and has cracked by the mounting post. This crack should be welded and ground down before installing the stiffening panels.



Step 3. 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 4. Form the panel as best as you can so it will sit in flush against the metal. There are small perforations in the panel where you will have to make a couple of bends. Depending on your car you might have to remove some material as well to make it fit right.



Step 5. 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 couple of #10 self-tapping sheet metal screw in and use clamps where ever possible. I know it is a lot of work but the reason for driving a screw in 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 stitch weld along the perimeter, 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. 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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