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Swing out door bar kit

Part # 3214

Parts List:

- 4... Mounting Brackets (2-L 2-R)
- 1... Quick Release Pin
- 1... 3/8" bolt
- 1... 3/8" lock nut
- 2... Mounting Sleeves

NOTE: This kit converts only one side bar

1...Cut the top of the side door bar off at least 4" from the top and 4" from the bottom. These cuts must be square.

2...Clean the bottom piece of tubing of all paint. Tack weld the bottom brackets to this tube with the bracket hanging over the end of the tube 1-1/2". The open side of these brackets when together must be to the outside of the car. (Make sure to have the holes on the top and bottom of the bar in a straight line)

3...Clean each end of the side bar that was cut out. Mark one end of the bar 3/4" from the end. Center punch one side of the tube on the mark made 3/4" from the end. Trim the other end of the bar until it fits in place and the center punch mark line up with the hole in the mounting bracket. With everything lined up go ahead and mark the center of the hole on the other side of the bar. (NOTE: These holes are not in the center of tubing)

4...Center punch the other side of the tubing. Drill each side of the tubing with a 5/8" drill bit. Clean up each hole so the 5/8" mounting sleeve fits. Counter sink the holes in the bar so the weld will be down below the top of the tube. Center the mounting sleeve and weld it in place on the inside and outside of the tube.

5...Grind or sand each side of the mounting sleeve until it fits between the mounting brackets and then bolt the bar in place using the bolt supplied.



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6...Before the bar will swing out the inside of the end of the bar will have to be trimmed to clear the mounting bracket. This can be done with a sander or grinder.

7...Sand all the paint off the 4" piece of tubing on the top. Tack weld the top mounting brackets to this bar leaving 1-1/2" of bracket hanging over the end of the tubing. These brackets should be mounted so the open side faces the outside of the car.

8...Center punch both sides of the tubing. Drill each side of the tubing with a 5/8" drill bit. Clean up each hole so the 5/8" mounting sleeve fits. Counter sink the holes in the bar so the weld will be down below the top of the tube. Center the mounting sleeve and weld it in place on the inside and outside of the tube.

9... Grind or sand each side of the mounting sleeve until it fits between the mounting brackets and then pin the bar in place using the Quick release pin supplied. (NOTE: If for any reason the hole for the pin doesn't line up go ahead and move the mounting brackets.)

10...If everything lines up go ahead and finish welding the mounting brackets.