



# ROOF LOCATING FIXTURE



## ASSEMBLY INSTRUCTIONS

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# Roof Locating Fixture Instructions

## Section I. Fixture Assembly

Identify all of the components of the roof locating fixture as shown in the photo (Photo1) below.

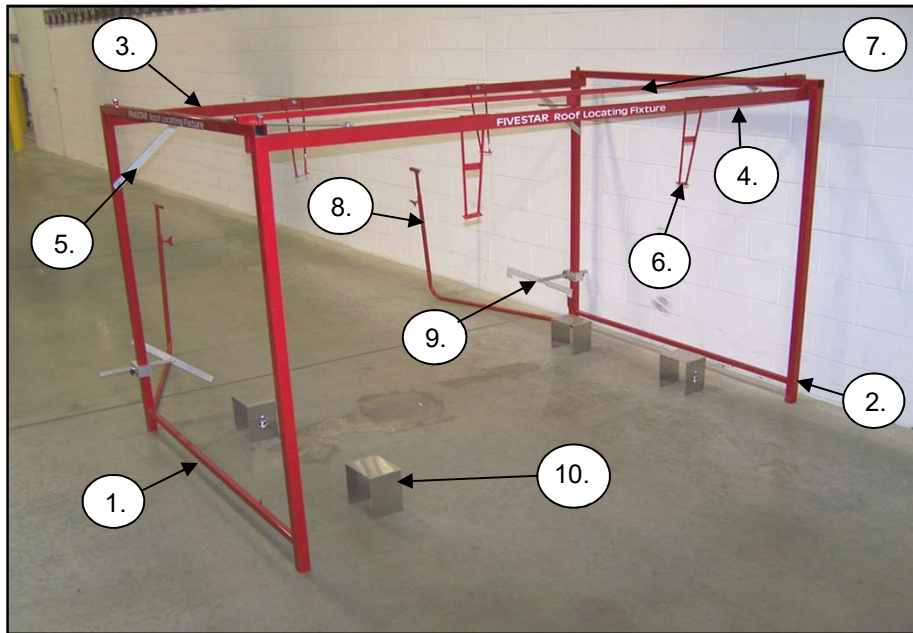


Photo 1

### Roof Locating Fixture Components

1. Right end frame. (1)
2. Left end frame. (1)
3. Rear cross bar. (1)
4. Front cross bar (1)
5. Diagonal braces. (4)
6. Roof mounts (4 per body style).
7. Front overhang measuring bar. (1)
8. Quarter panel support legs including adjustable "T". (2)
9. Locators for the rear axle. (2)
10. Seven inch tall blocks for the bottom of the doors. (4)

### Requirements for Assembly

1. 1/2" Wrench
2. 9/16" Wrench
3. 3/4" Wrench
4. Tape Measure
5. Level floor - this is very important for dimension accuracy!

Just like any other tool that you use, the more accurate that you are the better your results will be. The finished product will be the direct result of the effort that you put forward.

## Assemble the Fixture

1. Place the end frames on the appropriate side with the side labeled toward the center of the chassis.
2. Attach the front cross bar to the end frames using the 1/2" bolts supplied. Do not tighten the bolts at this time.
3. Attach the rear cross bar to the end frames with two 1/2" bolts. Just snug the bolts at this time.
4. Put the bolts in the diagonal braces on the front cross bar to the end frames. Use the 3/8" bolts and just put them in finger tight at this time.
5. Bolt the diagonal braces to the end frames. Do not tighten the bolts at this time.
6. Measure (diagonally) from the left rear cross bar bolt to the right front cross bar bolt as shown in the photo (Photo 2) below. Then measure from the left front cross bar bolt to the right rear cross bar bolt. The dimension should read the same on both measurements. If it does not read the same, move fixture diagonally and repeat the same steps for measuring. When you have the diagonal measurements reading the same you should carefully tighten the braces to the end frames with the 3/8" bolts and then tighten the 1/2" bolts that are used to attach the cross brace on all four corners. Re-check your measurements after the bolts are tight to confirm that the fixture did not move.



Photo 2

7. Next you should bolt the roof mounts in place. You will notice that they are marked to identify where they get located on the cross bars. Note that the roof mounts go toward the inside of the fixture as shown in the photo (Photos 3 & 4). The roof mounts should rest against the top side of the cross bars.





Photo 3 (Front)



Photo 4 (Rear)

8. Now put the Quarter panel height legs with the adjustable "T" onto the fixture as shown in the photo (Photo 5) A good place to start is by setting the dimension from the top of the "T" to the ground at  $34\text{-}3/8$ ". You will make the final adjustment when you attach the quarter panel to the roof later.

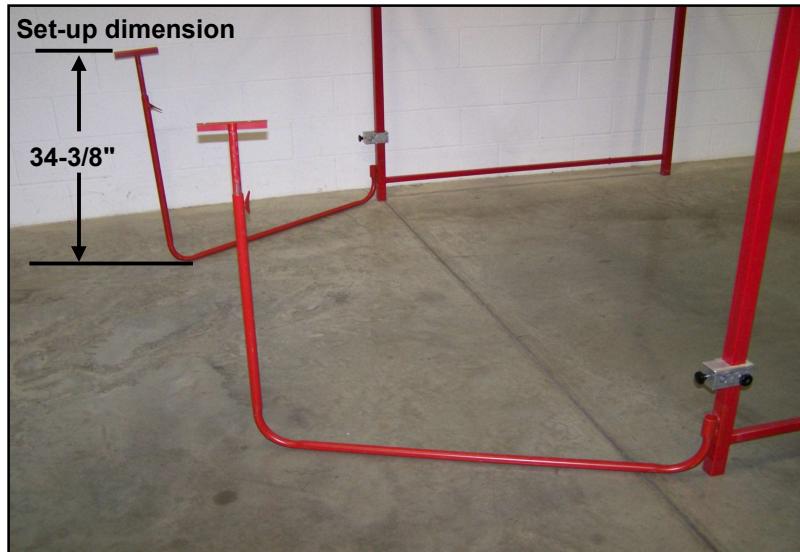


Photo 5

9. The last step in the assembly process will be to put the axle locators into the fixture. Look at the photos (Photo 6 & 7) to determine left and right and slide them into the appropriate block on the end frame.

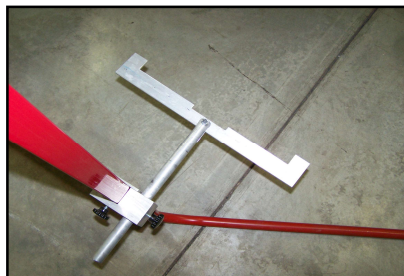


Photo 6 (Left)

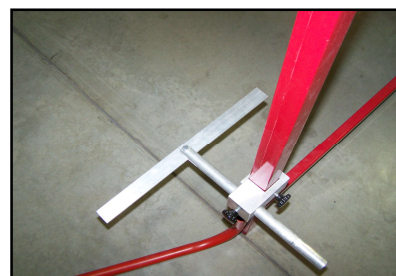


Photo 7 (Right)



## Section II. Assemble Body Components in Fixture

1. You may choose to assemble your body with the fixture located over the chassis or independent from the chassis. To locate the fixture on the chassis, put the rear axle locators into the rear wheels as shown. The blades on the locators go into the wheels and the blocks are lowered on the fixture until both ends of the blade make contact with the lip on the wheel as seen in photos 8 and 9. Use a level to assure that the blades on the locators are level as this will make certain that the fixture is properly located. Adjust left to right to meet body mounting dimensions.

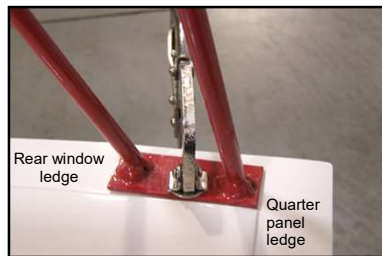


Photo 8

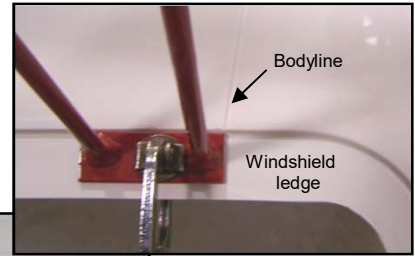


Photo 9

2. Clamp the roof into the fixture, see photo 10 below. Note where the pads on the roof mounts line up on the roof as four corner photos shown in the photos below.



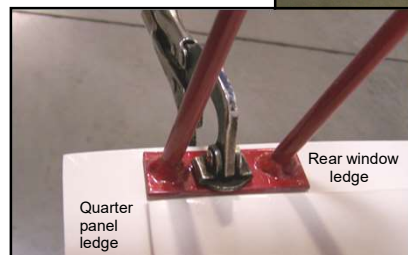
Left Rear



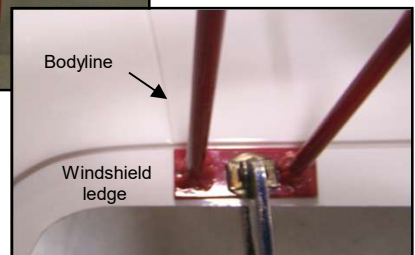
Left Front



Photo 10



Right Rear



Right Front

3. Attach the quarter panels to the roof. Note that the 7" blocks (photo 12) are located under the front of the quarter panel and the quarter panel support legs have been positioned under the back of the quarter panel (photo 11).



Photo 11

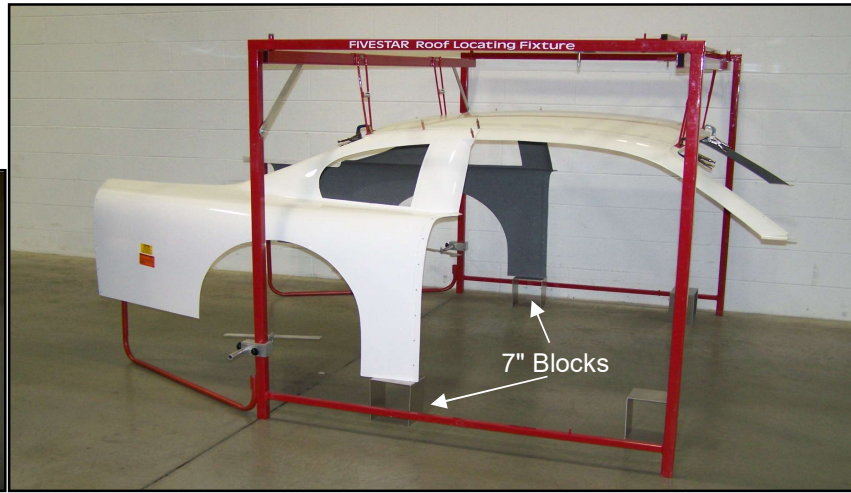


Photo 12

4. The next step is to attach the filler panel to the quarter panels. See photos 13 and 14 below.

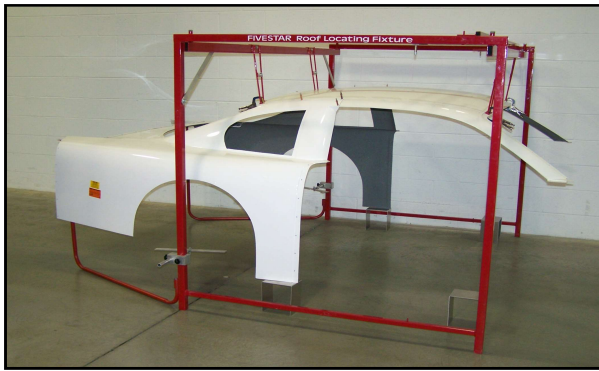


Photo 13



Photo 14

5. Attach the bumper cover to the quarter panels as shown in photo 15 below.

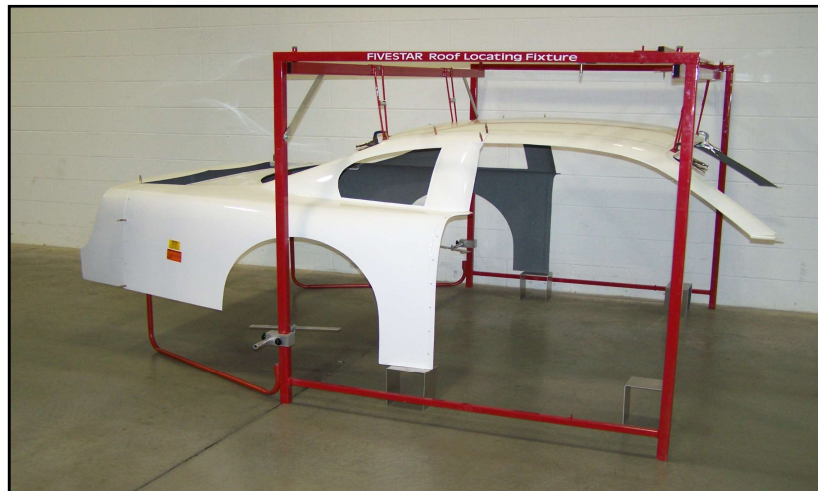


Photo 15



6. Photo 16 below shows the doors attached to the body. Note that the 7" blocks that were under the quarter panel legs have been moved to be under the back of the door and the additional 7" blocks are placed under the front of the doors.

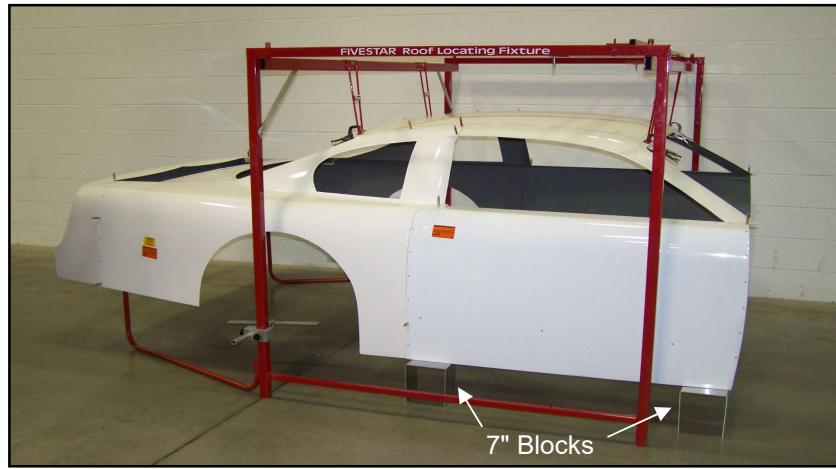


Photo 16

7. The cowl piece can now be attached to the roof as shown in photo 17 below.

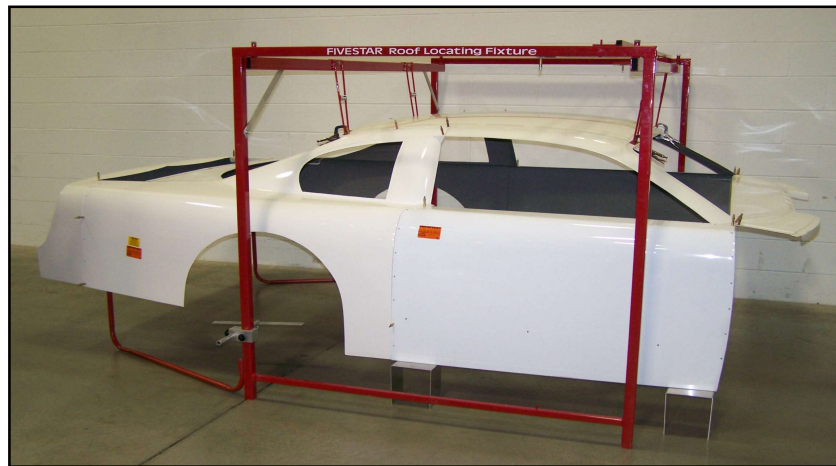


Photo 17

8. Now you can install the mock-up windows into the body (photos 18 and 19). The holes that you drill will be the same as the holes in the blacked out, cut to fit, pre-drilled windows offered for your body.



Photo 18



Photo 19



9. When you have assembled your body to this point, you will want to place the fixture over your chassis if you have not done it previously. Follow the instructions as outlined in step 1 of this section.
10. After you have built all of your body bracing, you can use the fixture for checking the front overhang in the same manner as it is checked with the "Referee". You will position the locators into the wheels as outlined in step 1 of this section. Once you have the blades level, you will place the front overhang bar onto the pegs on the end frames and read the scale to be sure you have the front overhang correct before you build your bumper and bracing.

