



## Front Swaybar Mount Reinforcement Panel - Installation Instructions

Part #2270026

### Cars applicable:

'65 – '73 911/912/930 and '74 - '89 cars upgraded with the through body swaybar

### Parts list:

Qty	Description
2	Front Swaybar Mount Reinforcement Panels

### Tools required:

You can use any of the following tools to remove the undercoating:

Needle Scaler, Multifunction Oscillating Tool, Knotted Wire Wheel, Heat Gun, Putty Knives, etc.  
MIG welder with Argon/CO2 shield gas (recommended) with .023 or .030 wire. Flux-wire MIG, AC Arc  
Welding, or Brazing may also be used but is not recommended.

Body hammer  
Grinding wheel  
Degreaser  
Paint

### Introduction –

Congratulations on your selection of Elephant Racing Swaybar Mount Reinforcement Panels. These panels will help prevent or repair the common problem of cracked swaybar mounts resulting from the application of overly stiff, binding, or incorrectly adjusted aftermarket swaybars.

Elephant Racing Swaybar Mount Reinforcement Panels are precision laser-cut 18 gauge panels that distribute the swaybar loads into the bulkhead and double-layer sheet metal just beyond the original single-layer hole location. This would also be a good time to upgrade to Elephant Racing's QuickChange Blade Style Sway Bar which mounts to the chassis using spherical bushings that articulate or "float" ensuring no binding. Spherical bushings allow mounts to automatically re-align themselves when the chassis is flexing under load. We believe this binding plays a significant role in the mount's failure.



Crack at Swaybar Mount

### Step-by-Step Installation -

#### 1 – Disassembly

Securely support the car on jack stands and remove the front wheels and drop the struts from their top mounts. Disconnect the front brake lines from the tab just below the swaybar hole and cap the lines. Gently bend the hard brake line out of the way of the work area.



#### 2 –Prep the area for welding

Remove all undercoating, paint, galvanizing and corrosion within and slightly beyond the work area. Inspect the area for the extent of damage, if any.

**CAUTION: PRIOR TO WELDING, REMOVE FLAMMABLE AND COMBUSTIBLE MATERIALS FROM THE WORK AREA. ASSURE THAT THERE IS ADEQUATE VENTILATION.**



#### 3 – Pre-weld fitting

Weld up all existing cracks. Cracks should be continuous welded and ground flat to ensure a flush fit between the original metal and the reinforcement panel.

Install the reinforcement panel by clamping it between the original sway bar bushing and the body. Draw the bolts down tight to form the reinforcement panel into the mounting recess.

Use a body hammer to remove large gaps that may remain around the bottom edges. The use of clamps or pressing the panels together to remove gaps during welding will help give a cleaner weld.



Weld up cracks

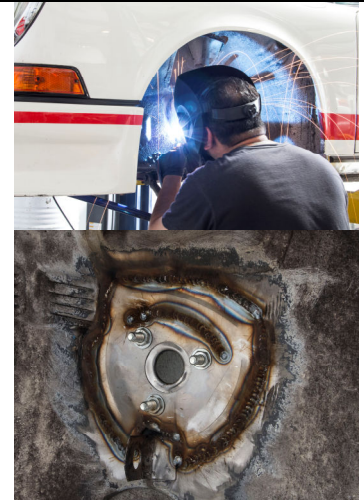


### 3 – Welding

Tack weld the reinforcement panel in place. Then "skip" weld the panel to the body.

Skip welding minimizes warpage by distributing the heat as evenly as possible. Apply a weld bead 1 to 1 1/2 inch long. Leave an unwelded interval of 3/4 to 1 inch before starting the next length of weld. Continue this pattern around the panel until the weld beads are end-to-end. Any gaps will allow dirt and moisture to penetrate, inviting corrosion.

Tack the arched cutout to the body around the swaybar bushing. Remove the bushing and repeat the weld process along this area.



### 4 – Cleaning And Painting

Grind flat the area where the swaybar bushing sits and dress around the center hole to ensure the swaybar can be installed later.

Clean all slag and spatter after welding. Dress grind uneven welds and all sharp and protruding edges. A little effort here can make the reinforcement look like a factory installation.

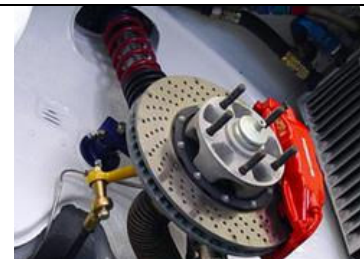
Clean and degrease areas you will be painting. Painting should be done immediately after surface preparation. Use a good, high quality rust inhibiting primer and finish as desired.



### 5 – Reassembly

Reinstall the swaybar, struts and brake lines and bleed the brakes according to the procedures in the shop manual.

Elephant Racing has a fine selection of bushing and swaybar products. This would be a convenient time to upgrade.





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