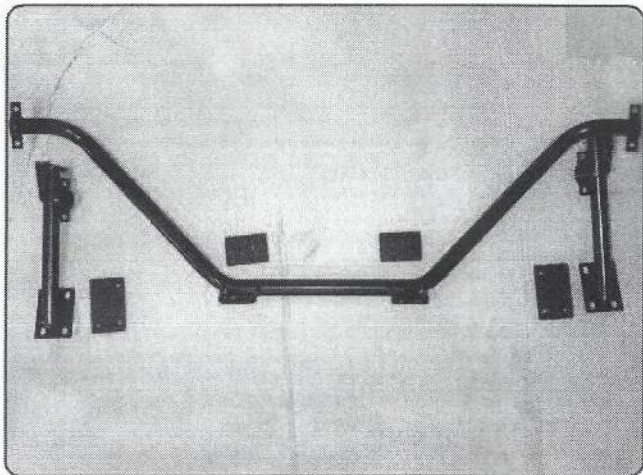


DEFENDER BULKHEAD REMOVAL KIT

FITTING INSTRUCTIONS



This job is for a garage or a skilled DIY person to install. Please read the fitting instructions before starting the installation of this product.

Use suitable safety equipment whilst working - goggles, gloves etc.

For ease of installation it will be necessary to remove the roof and side panels prior to installation.

Remove the seats and seatbelts for ease of access and as not to damage them when cutting and grinding.

Parts List

6 x M10 pan head bolts

10 x M10 x 25mm bolts

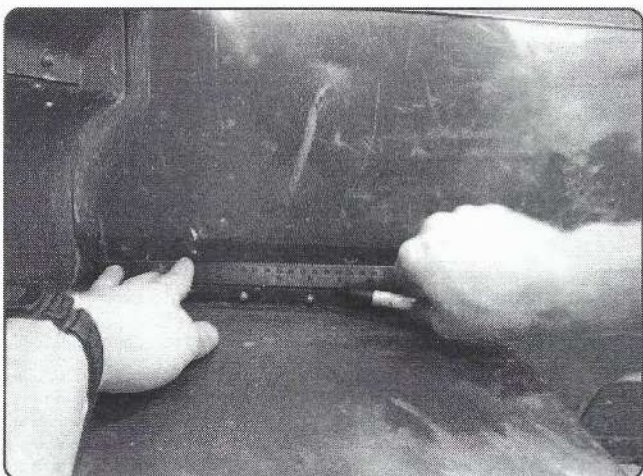
8 x M10 nuts

1 x cross bar

2 x tube uprights

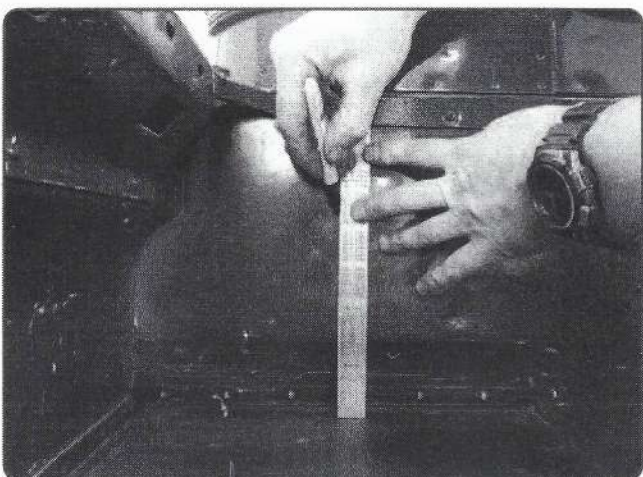
2 x captive nut-plates (handed)

2 x captive bolt plates (handed)



Above two pictures

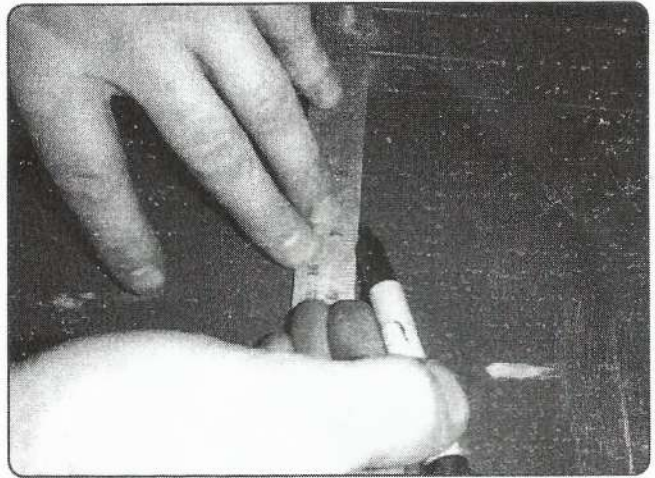
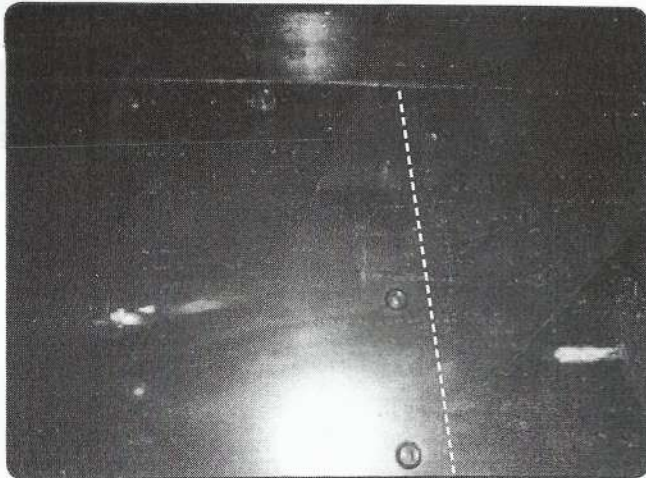
From inside the rear of the tub on the back of the bulkhead there is a seam join around each of the wheel arches, mark a cut line above this seam around the wheel arch.



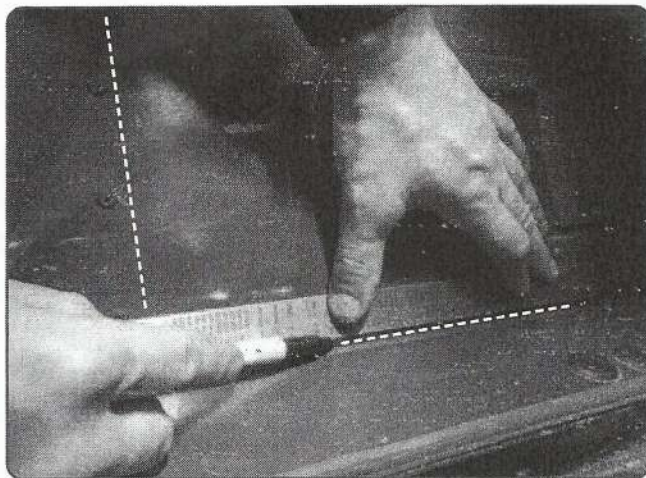
Left picture

Across the top of the bulkhead there is a reinforcing strip riveted on. There is a join either end of this strip, draw a vertical cut line from this to the top of the wheel arch.

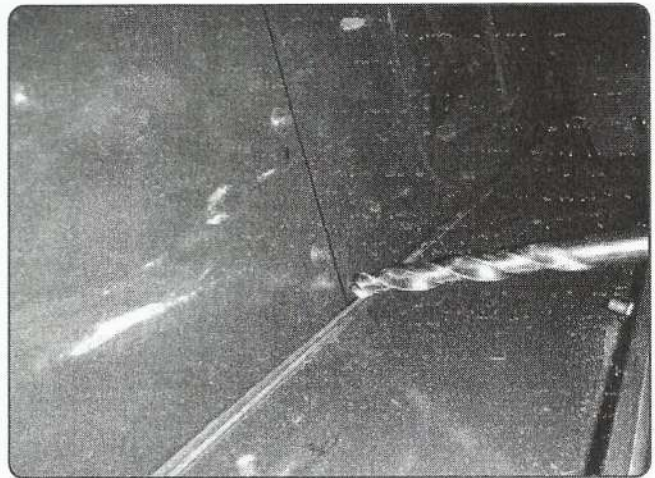
FITTING INSTRUCTIONS - continued



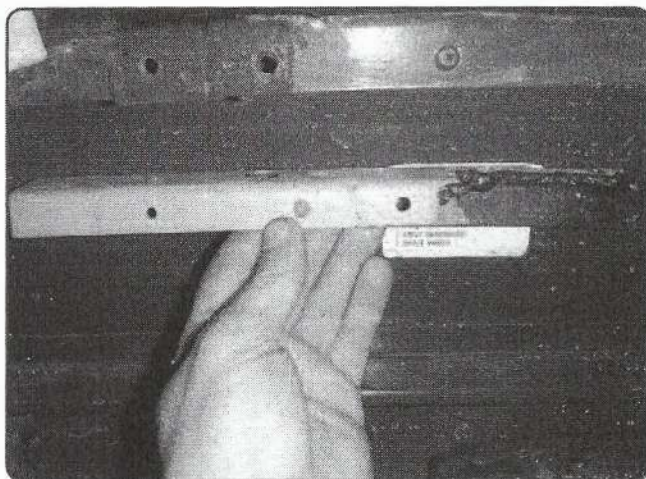
From behind the seats there is a vertical row of rivets which is the join of the wheel arch seam. Depending which side you are, mark a line to match the same position as that on the other side of the bulkhead. Tip - From in the rear tub measure from the centre of the rivet to the cut line you have already drawn and transfer these measurements to the front side of the bulkhead.



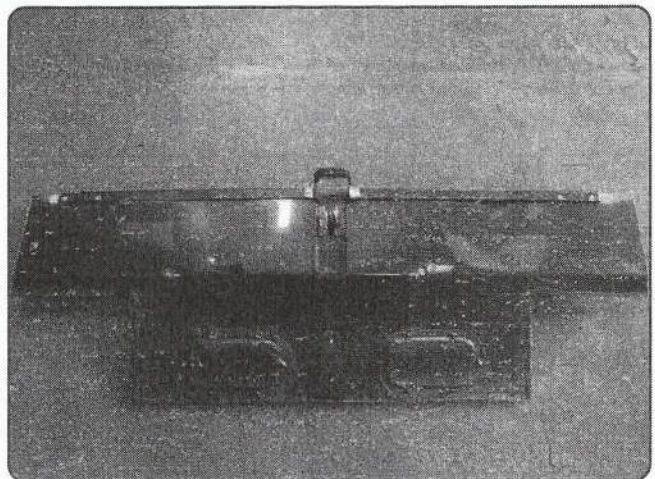
From behind the seats mark a cut line just above the lower part of the bulkhead across between the 2 wheel arches joining up to the 2 vertical lines you have drawn.



Mark a centre point 6mm in from the corner of the 2 lines and drill a 12mm hole. Repeat this both sides.

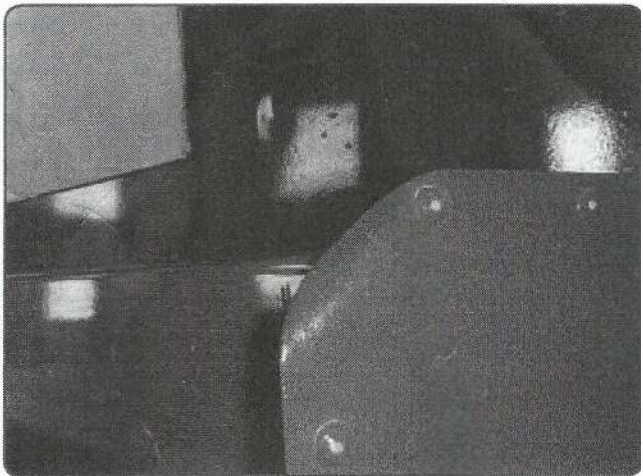


Along the top bar of the bulkhead there are 2 reinforcing pieces riveted in from underneath either side. Using a 5mm drill bit, drill out the rivets and remove these pieces.



Using a small angle grinder or power hack-saw, cut out the centre section of the bulkhead being careful not to cut over the ends of the cut lines and remove the centre section.

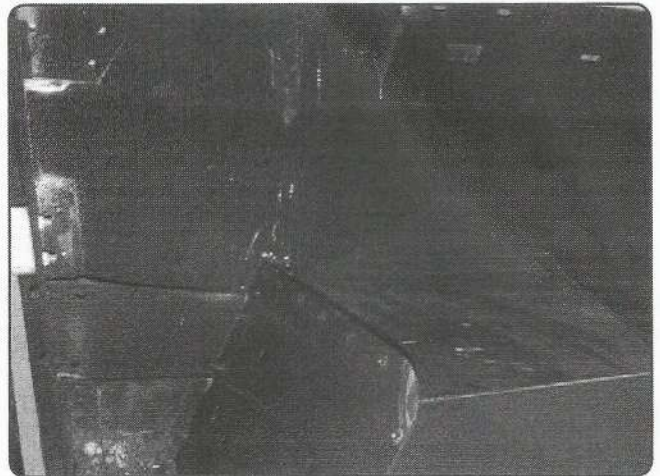
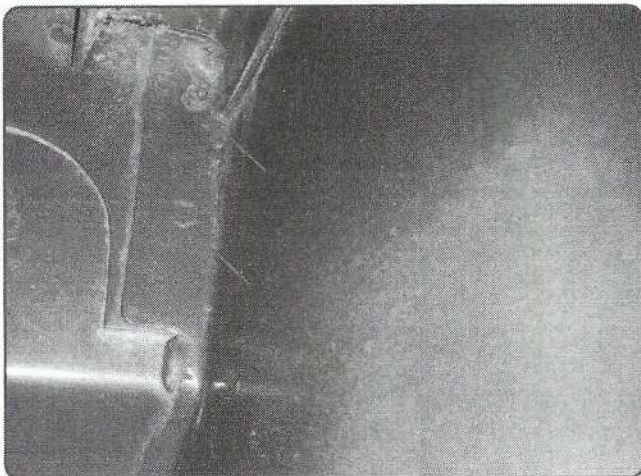
FITTING INSTRUCTIONS - continued



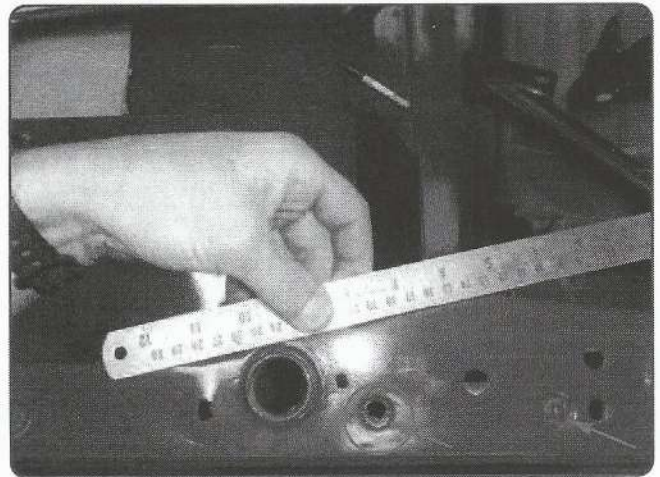
Using a circular object draw a radius of approx 50mm on the top corner of the wheel arch and cut this out.

Remove any burrs and sharp edges.

When fitting the bulkhead bar into position it may be necessary to bend this radius towards the rear of the vehicle to allow room for the centre bar to miss.

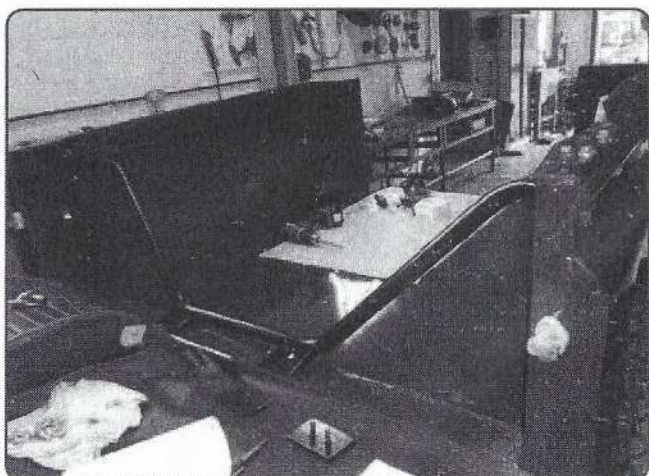


Extend the cut line across the top of the wheel arch towards the outer wing being careful not to catch the outer wing. If necessary use a hacksaw blade by hand to do the last bit. Using a spotweld drill, drill the first layer only of the 2 spotwelds in the corner underneath the top reinforcing bar. The only thing now holding this piece in place is some seam sealer; using a knife cut the sealant remove the last piece of the bulkhead either side. Using a file remove any burrs and sharp edges and clean off any excess sealant from the inner wing.

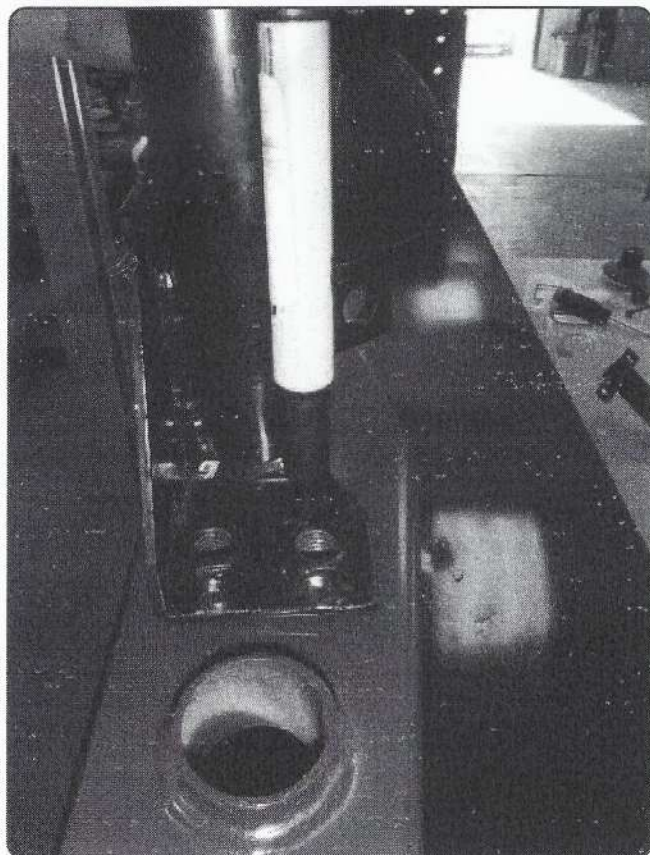


Using a straight edge draw a line across the remainder of the bulkhead capping and cut off using a grinder. Remove any burrs and sharp edges using a file. Drill out the 2 pop rivets shown then drill out the hole circled to 10.5mm.

FITTING INSTRUCTIONS - continued



Place the tubular pieces inside the vehicle to work out which way around the bars fit into place.

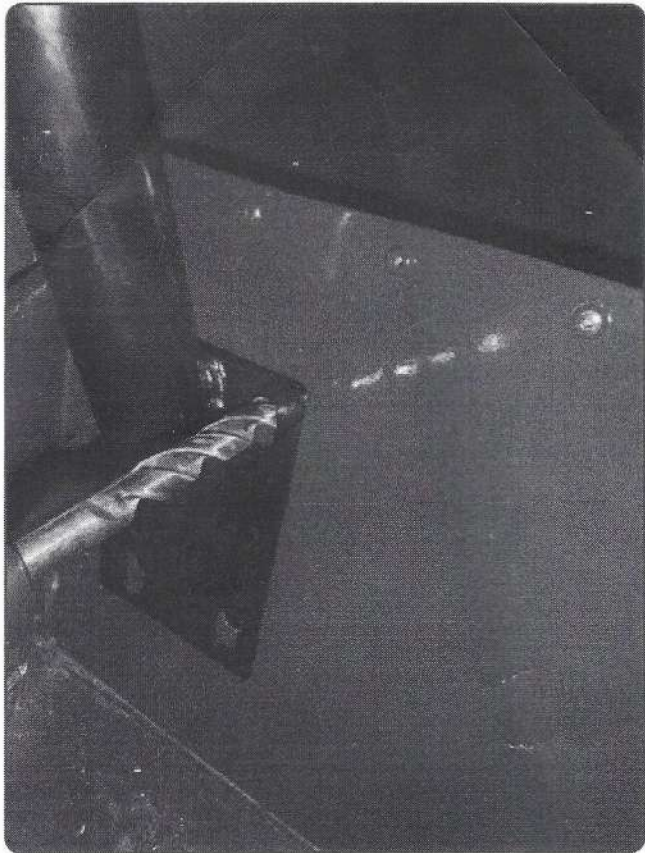


Once you have worked out which side bar is which, take the side bar from the opposite side and place it upside down on top of the side you are working on and align with the 10.5 mm hole you have already drilled and align the outside of the capping on the rear tub with the bracket.

Mark the 2 other centres of the bolt holes. Remove the bracket and repeat the process on the other side of the vehicle.

Centre punch the marks and drill out the holes to 10.5mm

FITTING INSTRUCTIONS - continued



Fit the tube side brackets into position and secure at the top using the pan head bolts provided.

Fit the centre bar into place and locate the 4 top fixing bolts into position loosely.

Mark and drill the 3 bottom holes in the wheel arch and fix the bolts into place using the nut retaining plate on the other side of the wheel arch.

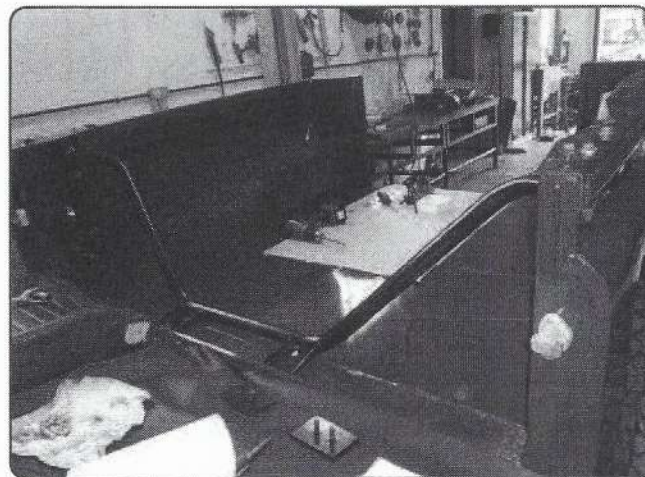
Do not tighten.

At this point in time you should have done all the drilling and cutting needed so remove all sharp edges and prime and paint all bare metal surfaces where you have been cutting or drilling before carrying on any further.



In the middle of the centre bar there are 2 mounting points, these should align with 4 pre-drilled holes in the seat base.

Remove the centre seat base cover to place the bottom retaining plate into position from underneath and secure loosely with the nuts provided.



Once all the nuts/bolts and brackets are in position tighten up the nuts and bolts from the centre bar fixing points outwards to a torque of 40 newton metres.

If the roof and side panels were removed as one part refit and tighten up.

If the roof and side panels were removed individually refit them all loosely with all fixings in place first.

Then tighten them starting from the roof panel and working your way downwards.

Refit the seat belts and seats into position.