



## 914 and 914-6 GT Chassis Kit Installation Guide

The kit you have received is stamped from a mild steel material that is well suited for layered chassis reinforcement. It has received a coating that is rust resistant and safe to weld. We would recommend using a gas, wire-feed, mig. system for welding. From my experience this has produced excellent installation results. Plan enough time to do this job correctly as it is a major addition to the 914s chassis and should be taken seriously. A good welder can have the kit installed in the car in 3 to 5 hours. Plan additional time to do cleanup and to detail the installation area.

**Do not circumvent any welding safety practices while doing this installation. Remember that proper ventilation is very important! Safety glasses, welding gloves and welding blankets should be used. Make sure you disconnect the cars battery before starting to weld.**

**Note:** The pieces provided in this kit will help strengthen the 914s chassis and were originally designed to help keep the Porsche racing 914-6's chassis from excessive flex. They are not intended to restore a rusty chassis' structural integrity. Please call for recommendations if you have serious rust in your lower longitudinal area or the suspension console.

Plan your installation with the car sitting on level ground or verify that it is properly supported by a lift or jack stands before beginning.

### Installation

1. Review the accompanying pictures so you are familiar with the individual piece placement. Elevating the car will help make this job much easier. It will be necessary to remove the rear trailing arms to fit piece # 5.
2. All pieces except piece # 1 will need some bending to fit in their intended locations.
3. If you are working on a 914 racer with removable body pieces or a 914 that is having a quarter-panel replaced, take this rear panel off prior to beginning the installation. It will allow for much easier access to the installation areas.

4. Undercoating and paint should be removed from the area where these pieces are fitted to. Paint these areas with a weld through primer after cleaning them. The installation of pieces # 1 and # 2 will cause paint in the trunk area to lift or burn. Check these areas and touch them up or refinish them as needed.
5. Use a “Stitch” weld to attach these pieces. This method is least likely to cause any metal distortion. **Take special care to avoid overheating the metal in the area you are working in as it could warp the panel.** Alternate from side to side when installing the pieces to help keep things cool.
6. Piece # 4 can be trimmed, as needed, to suite your application. This longitudinal piece has been designed to fit high in this area for those applications where the outer panel can be removed to facilitate welding. If you have a stock bodied car this piece should be trimmed for a fit that covers less overall height. It will then be much easier to weld while still adding an important piece to your cars lower longitudinal. **For installations where a Longitudinal kit is also being installed you may elect to exclude this piece as this area will be covered by the rear section of the Longitudinal kit.**
7. Piece #5 is fitted above the rear trailing arm and will need to be formed to fit the area. I strongly suggest making a cardboard or stiff paper template to identify the proper placement and shape of this piece before beginning to weld it into place. Begin welding at the forward most edge and shape the piece as you weld it to the chassis. When this piece is correctly positioned the rear edge overlaps the end of the sub-frame by an inch.
8. After all the pieces have been installed they should be prepped, undercoated and seam sealed. If you are interested in a very nice, clean look you can grind the welds smooth and seam seal all the exposed edges and any open welds. This will make sure no moisture will get behind the panel. Lastly top coat this area with a corrosion resistant finish and undercoat or paint the area as desired. Failure to finish the job may result in light rusting of the welded area if its left unpainted.

Please call if you have any questions with the installation of this kit. We know you are a very dedicated 914 owner by making the commitment to install this kit on your 914 and want the installation to be perfect.

**THANKS FOR YOUR PURCHASE!**

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