

Global MX-5 Cup ND Fascia Support Weld Bung Installation Instructions

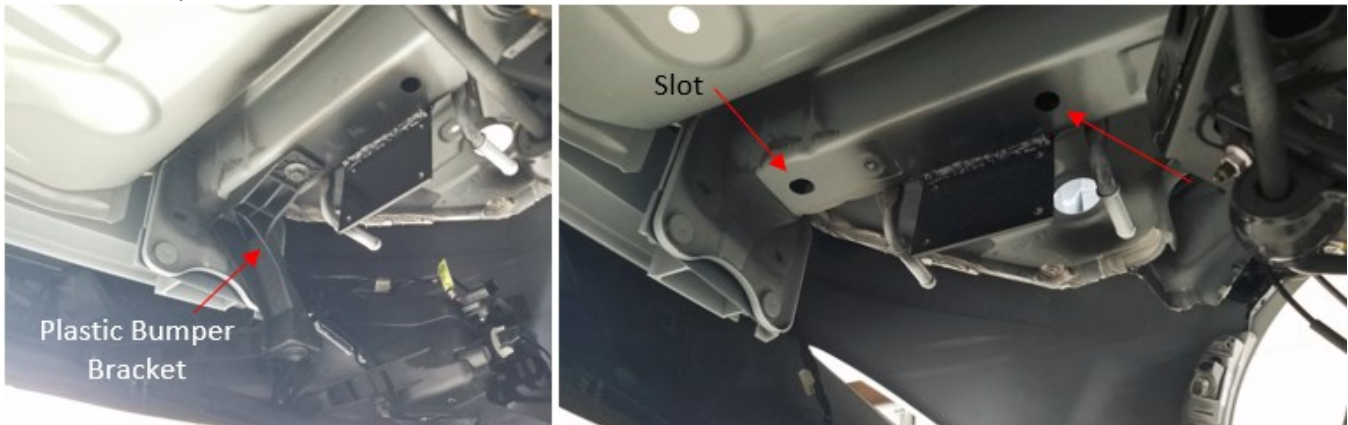


1.0 General:

- 1.1 Safety: Follow all industry standard safety procedures.
- 1.2 Intended Use:
 - 1.2.1 This Guide is intended to be used for installation of the weld bungs in the rear frame rail required to install Long Road Racing's Fascia Support Braces in a Global MX-5 Cup Race car as built by Long Road Racing from the Mazda MX-5 ND Chassis.
- 1.3 Basic Installation Overview and Notes:
 - 1.3.1 Eight threaded bungs (Included) must be welded into the rear frame rails. These install in existing factory holes, no drilling is required. Disconnect the battery and ECU prior to welding on the vehicle.
 - 1.3.2 The 5mm screws in the plastic bumper brackets are re-used in Fascia Support installation.
- 1.4 Tools Required: Ratchet, extension, 10mm socket, Phillips Screw Driver, Slotted Screw Driver and a Welder.

2.0 Rear Subframe Modification: Installation of Weld Bungs in Rear Frame Rails.

- 2.1 Left Rear and Right Rear are symmetrical. Pictures of Left Rear are shown.
- 2.2 Remove the plastic bumper bracket from each frame rail to expose factory slot at the rear end of the frame rails.
 - 2.2.1 Keep the #12 screws used to attach the bumper bracket to the fascia for later use.
- 2.3 Prepare the rear slot and forward hole shown below for weld.



- 2.4 Remove tape covering factory holes on the outer side of the Rear Frame Rail, and prepare the two holes shown for weld.



- 2.5 Disconnect the battery and ECU.

- 2.6 Weld the “Smaller” Upper Weld Bungs (3/4” dia) into the factory holes on the side of the frame rails.
- 2.6.1 All of the weld bungs are M10x1.5, however the lower bungs will not fit in the upper holes.
- 2.6.2 Full weld around the bungs, keep the bungs flat and parallel to the face of the frame rail, and grind flat as needed.
- 2.6.3 Take care to make sure the weld bead is less than 5/16” wide to avoid interference with the spacer plate on the Fascia Supports.
- 2.6.4 Protect threads and paint to prevent corrosion.



- 2.7 Weld the “Larger” Lower Weld Bungs (7/8” dia) into the factory slot and hole on the bottom surface of the frame rail. Note that the bung must be slid all the way forward in the slot. Spacing between the lower bungs after installation should be 7.75” from center to center.
- 2.7.1 Full weld around the bungs, keep the bungs flat and parallel to the face of the frame rail, and grind flat as needed.
- 2.7.2 Protect threads and paint to prevent corrosion.

