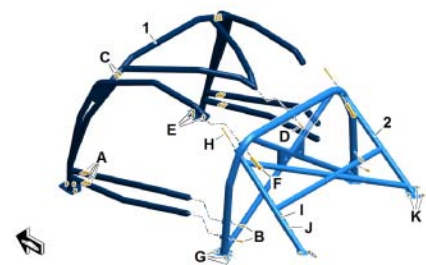


Retrofitting Titanium Roll-Over Cage

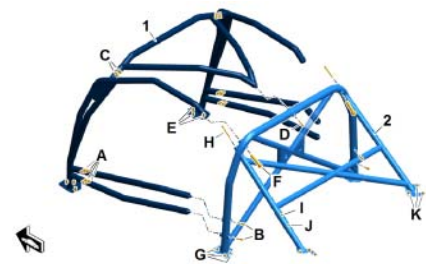
Roll-over bar

Location	Explanation	Type	Basic value	Tolerance 1	Tolerance 2
Roll-over bar - cross strut, base	Item G. M8 x 20 screws (6x)	Tightening torque	25 Nm (19 ftlb.)		



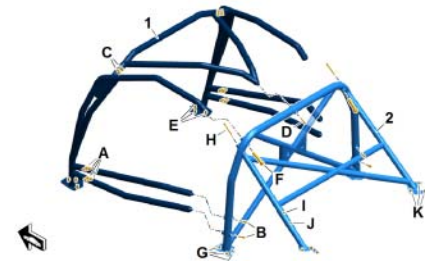
Overview of roll-over bar

Location	Explanation	Type	Basic value	Tolerance 1	Tolerance 2
Roll-over bar - cross strut	Item H. M8 x 75 screws (2x)	Tightening torque	25 Nm (19 ftlb.)		



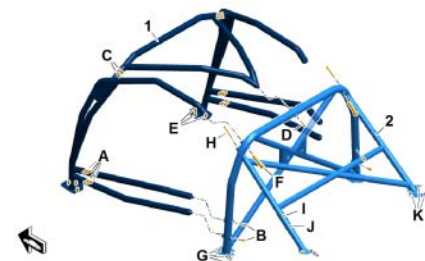
Overview of roll-over bar

Location	Explanation	Type	Basic value	Tolerance 1	Tolerance 2
Roll-over bar - sliding sleeve	Item I. M10 x 60 screws (2x) + nuts (2x)	Tightening torque	33 Nm (24ftlb.)		



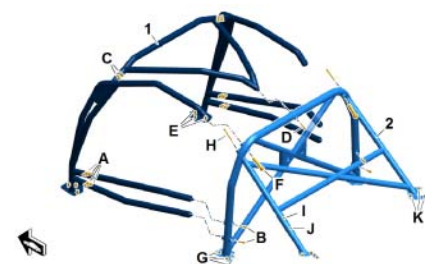
Overview of roll-over bar

Location	Explanation	Type	Basic value	Tolerance 1	Tolerance 2
Roll-over bar - sliding sleeve	Item J. M10 x 60 screws (2x) + nuts (2x)	Tightening torque	33 Nm (24ftlb.)		



Overview of roll-over bar

Location	Explanation	Type	Basic value	Tolerance 1	Tolerance 2
Roll-over bar - support strut	Item K. M8 nuts (6x)	Tightening torque	25 Nm (19 ftlb.)		



Overview of roll-over bar

Preliminary work

- 1 Remove sports bucket seat. ⇒ *Workshop Manual '72011911 Removing and installing folding sports bucket seat - section on "Removing"*

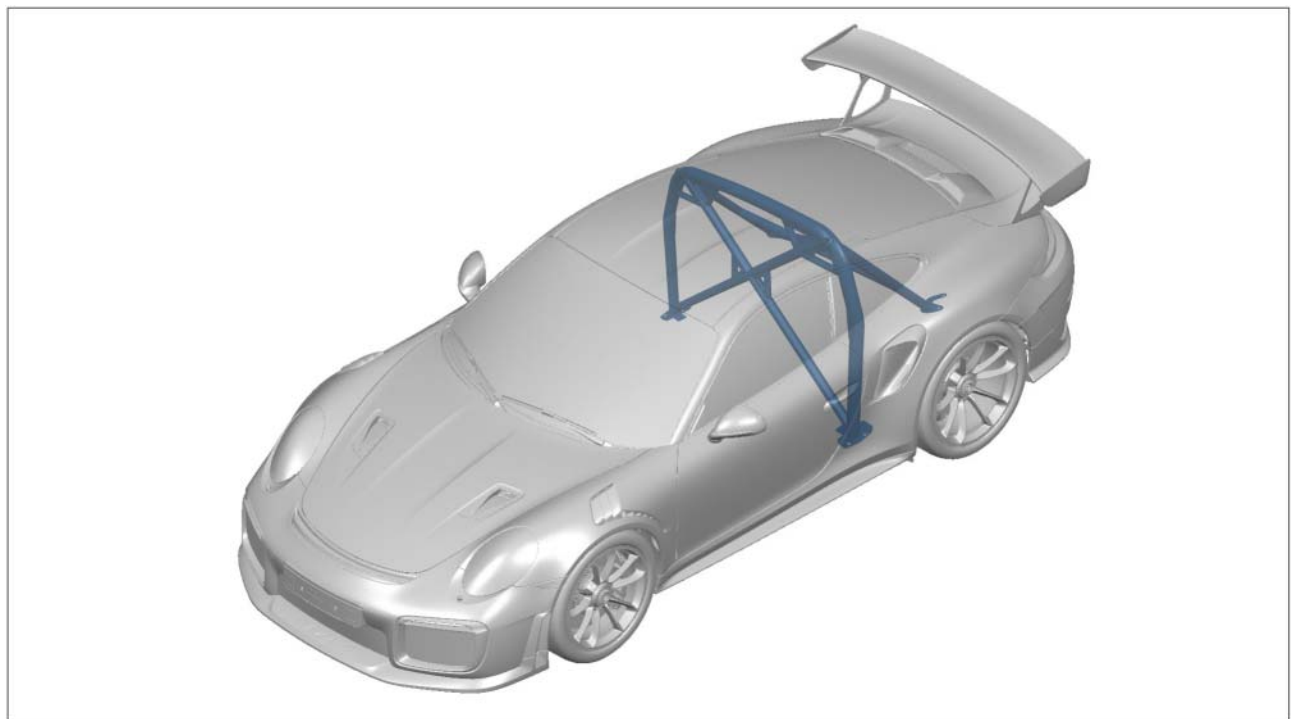
- 2 Remove rear seat cushion. ⇒ *Workshop Manual '745719 Removing and installing rear seat cushion - section on "Removing"*
- 3 Remove rear cover (Coupé). ⇒ *Workshop Manual '705319 Removing and installing rear cover (Coupé) - section on "Removing"*
- 4 Remove and install rear side trim panel. ⇒ *Workshop Manual '705319 Removing and installing rear side trim panel (Coupé)'*

Removing roll-over bar



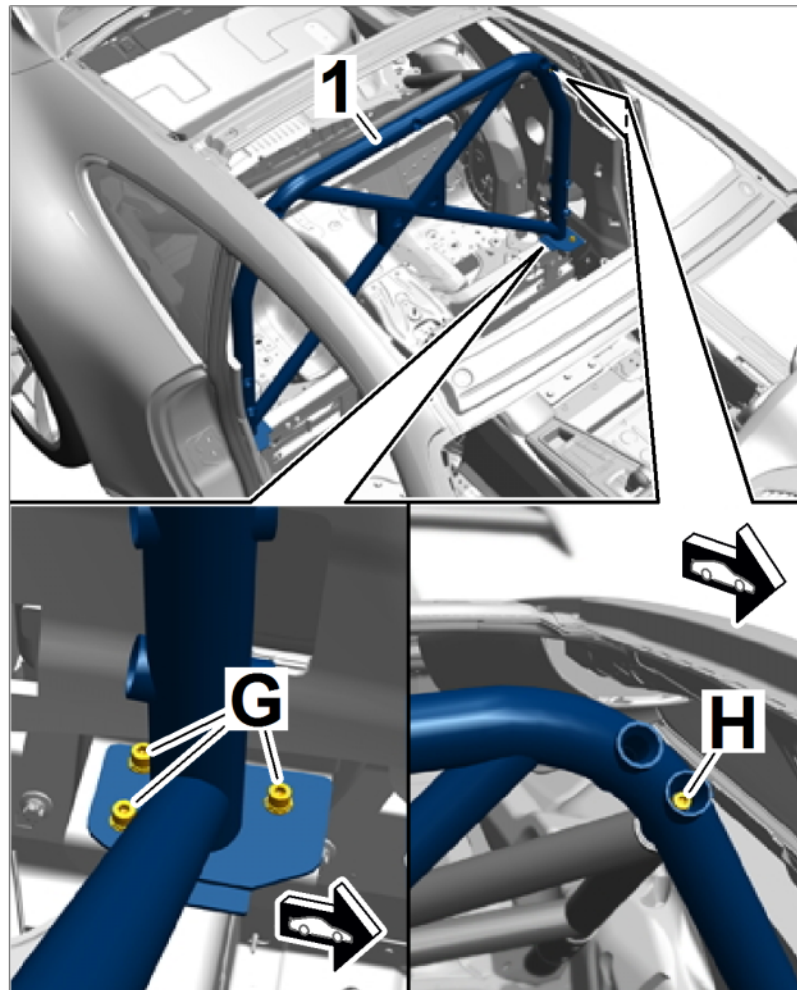
Information

Some of the repair illustrations show only one side of the vehicle. Naturally, some steps also have to be performed on the opposite side of the vehicle as well. These must be carried out as a mirror image of the steps shown.



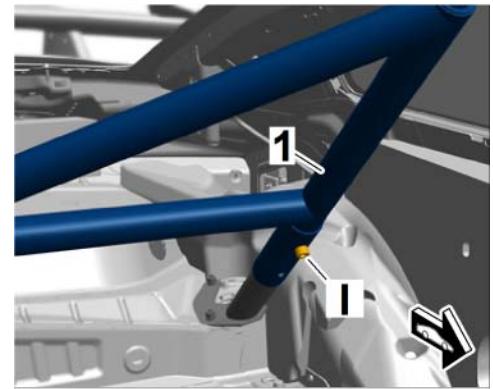
Installation position of roll-over bar

- 5 Unscrew screws ⇒ *Roll-over bar - front cross strut -G & H-* on the front cross strut ⇒ *Roll-over bar - front cross strut -1-*.
 - 5.1 Carefully remove front cross strut ⇒ *Roll-over bar - front cross strut -1-*.



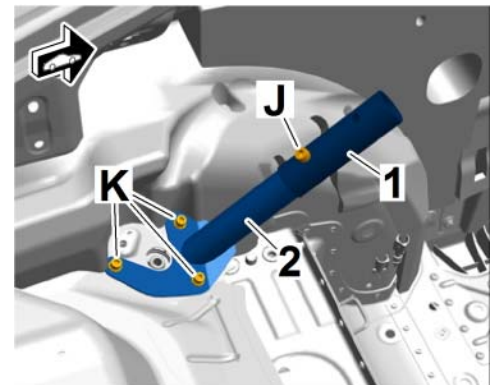
Roll-over bar - front cross strut

- 6 Unscrew nuts ⇒ *Roll-over bar - rear cross strut-1* - on rear cross strut ⇒ *Roll-over bar - rear cross strut-1* -.
- 6.1 Pull out screws and remove rear cross strut ⇒ *Roll-over bar - rear cross strut-1* -.



Roll-over bar - rear cross strut

- 7 Unscrew nut ⇒ *Roll-over bar - rear support strut mounting -J-* and pull out screw.
 - 7.1 Remove sliding sleeve ⇒ *Roll-over bar - rear support strut mounting -1-*.
 - 7.2 Unscrew screws ⇒ *Roll-over bar - rear support strut mounting -K-* and remove rear support strut mounting ⇒ *Roll-over bar - rear support strut mounting -2-*.



Roll-over bar - rear support strut mounting

Installing roll-over bar

- 8 Installation is performed in reverse order.
- 9 Tighten nuts to ⇒ Tightening torque 25 Nm (19 ftlb.) .
- 10 Tighten screws to ⇒ Tightening torque 33 Nm (24ftlb.) .
- 11 Tighten screws to ⇒ Tightening torque 33 Nm (24ftlb.) .
- 12 Tighten screws to ⇒ Tightening torque 25 Nm (19 ftlb.) .
- 13 Tighten screws to ⇒ Tightening torque 25 Nm (19 ftlb.) .

Subsequent work

- 14 Install rear cover (Coupé). ⇒ *Workshop Manual '705319 Removing and installing rear cover (Coupé) - section on "Installing"*
- 15 Install rear seat cushion. ⇒ *Workshop Manual '745719 Removing and installing rear seat cushion - section on "Installing"*
- 16 Install sports bucket seat. ⇒ *Workshop Manual '72011911 Removing and installing folding sports bucket seat - section on "Installing"*
- 17 Remove and install rear side trim panel. ⇒ *Workshop Manual '72011911 Removing and installing rear side trim panel (Coupé)'*

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