



CATERHAM

ASSEMBLY GUIDE

EDITION 1.2

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Your feedback and comments are welcome: assemblyguide@caterham.com

For help and build support enquiries contact Derek Howlett: derek.howlett@caterham.com / 01322 625827

WELCOME TO YOUR NEW CATERHAM KIT

Building your own Caterham is immensely rewarding and satisfying. Of course, it should be remembered that you are building a high performance sports car, not a flat-pack wardrobe, so it will be a little challenging from time to time; but we've set out to make it as easy as possible for anyone, whatever their skill level and help is just a phone call away.

But before you do anything else, pop the kettle on or pour yourself a G&T with a slice; and

READ THE NEXT THREE PAGES – THEY ARE REALLY IMPORTANT

No, they will not be very exciting unfortunately, but they are important nonetheless and you will regret it later if you don't.

So there are four important things we need to think about **NOW** before picking up a spanner:

- **This isn't the only guide you'll need**
- **When to apply for an IVA test**
- **Photography (no, really)**
- **Arranging a post build check**

Although we have made this guide as comprehensive as possible, the requirements of IVA change from time to time and even from test centre to test centre. Therefore, it **MUST** be read in conjunction with the 'IVA Checklist Guide', the latest version of which can be downloaded from the Caterham website. You'll find the refer-to-IVA-manual symbol in the bottom of each illustration where attention is required. Reading through it now, will save pain later! Don't assume that because you've found a reference to one item relating to that page, it is the only one..

Once you have completed the assembly of your Seven, you are required by law to present it for an 'Individual Vehicle Approval' test (better known as IVA), which is conducted by the Vehicle and Operator Services Agency (VOSA) at a regional test centre.

We STRONGLY recommend that you apply for your IVA appointment at least a month before you think you will complete your build, to allow for the application form to be processed at the snail's pace of bureaucracy. Once accepted, your IVA application is valid for 6 months and test dates can be changed up to a minimum of 3 working days prior to your appointment with VOSA (any later and you may incur a charge).

The application form and a guide on how to complete it, is contained within an envelope of documents provided with your kit and which is probably acting as a coaster for your g&t at the moment. Take this moment to find it and remove it from the garage and place it somewhere safe (and memorable).



VOSA and the DVLA are a suspicious bunch and in order to register your car, you will need to provide proof that it is amateur built. When you apply for registration, you will need to include photos from various stages of you build, which will demonstrate to them that it is an 'amateur build'.

Recruiting a few extras (your kids, your spouse, the cat, etc.) and some props (last year's Xmas tree, a radio from the 1980's and a rusty bike) will all contribute to a more authentic home-garage feel; proving that no professional help (i.e. commercial workshop/garage) was involved in the build. Of course, feel free to have yourself working away on the kit in the photos if one of your 'extras' can be trusted with the camera (not the cat; they never get the exposure right).

Finally, we know you haven't started yet, but we need to tell you about the Post Build Inspection now, due to availability at our service centres and the time it takes to get you a slot. Plan ahead!

What is the Post Build Inspection? This is a free service offered by all Caterham service centres which we wholeheartedly recommend you take up on prior to your IVA test. It ensures that your car is correctly assembled and is road-worthy. All safety and operational aspects of your Seven will be checked, concluding in a road test. This will enable us to advise you of any corrective work that may be required (which we will be happy to carry out for you*). It is important to note that this is not the same as the IVA test and whilst every effort will be made to ensure your car passes, there is **NO GUARANTEE** of a first time IVA pass.

*Obviously any additional work is not for free, but we will speak to you first so you can decide whether you want to pay us to do the corrections or you want to do them yourself.

REMEMBER: Post Build Inspection slots are in high demand at our service centres and there may be a two-month lead time at busy times, so please check on availability and book ahead!

All our service centres will be able to offer you a Post Build Inspection and IVA service, where they take the car to IVA on your behalf. This tends to increase the likelihood of a first time pass and means you don't need to take a day out to endure the test, which is beyond dull.

As a guide, the Post Build Inspection through to registration can take around 6 weeks to complete.

That's it, we're ready to start assembly

ENJOY

MY BUILD NOTES

Download the IVA Checklist Guide: www.caterhamcars.com

Book IVA Test

Take plenty of photos

Arrange post build check

This was more fun than I ever expected!

HINTS & TIPS

When using a torque wrench, listen/feel the click and then stop. It does not need to be any tighter and you might actually weaken the fixing by 'over-torquing' it. Always wind your torque wrench setting back to free when you've finished with it.

John K

A 'nyloc' nut is one with a nylon insert that gets cut by the bolt thread, making it resistant to unwinding itself. This means that they should not be repeatedly re-used.

Chris B

This guide covers optional equipment your car may not have!

Tiago O

1Nm of torque equals 0.736lbft.

Mick F

Thread lock is used to stop something coming undone, but it only needs a little drop on the thread to be effective.

Jamie A

When using a spanner, always use the ring end wherever possible. The open end is really only for those times that access is too limited for a ring spanner or socket.

Mick A

Generally, metric Nyloc nuts have a blue nylon insert and imperial ones a white nylon insert.

Grant P

Teabag, boiling water, then the milk, in that order.

Simon L

Left and right are as viewed from the driver's seat.

Harrison P

You can tell if you have 'wide track suspension' car by looking at the front dampers. Wide track has a 25mm long hexagonal spacer between the top spring retainer and the mounting bush.

Matt T

A 'caphead bolt' has a circular head with a hexagonal drive inside it. It is tightened with an allen key or hex drive socket. Capheads are useful where there is limited space around the head for a spanner or socket. They look nice too!

Richard T

A bolt size is described by its diameter (e.g. M10=10mm) by the length not including the head (e.g. 65mm).

James A

A 'spring washer' has a split in it and squashes up closed when a fixing is tightened. It is usually used under a bolt head to help resist it coming undone.

John S



Speak to our Expert Derek Howlett
derek.howlett@caterham.com
01322 625827



Video Guides
[https://www.youtube.com/
user/OfficialCaterhamUK](https://www.youtube.com/user/OfficialCaterhamUK)
Playlist coming soon

KEY

SYMBOLS

- Item number
- Fixing item
- S Pack / R Pack specific instructions
- Required torque (where applicable)
- S3 / S5 chassis specific instructions
- Repeat on other side
- Advice from factory professionals
- Now is a good time to take some photos
- Reminder to apply for your IVA test
- Refer to IVA Checklist Guide

FIXINGS

Pack A CATERHAM					44
FRONT SUSPENSION DeDION CARS (METRIC)					PACK NUMBER
This pack may include extra fasteners to cover different options					38F015B
ITEM	QUANTITY	DESCRIPTION	USED ON	ILLUSTRATION	
1	AA	Bolt M12 x 100 Grade 10.9	Lower wishbone rear		
2	AB	Bolt M12 x 45 Grade 10.9	Lower wishbone front		
3	AC	Bolt M12 x 45 Grade 10.9	Upper wishbone rear		
4	AD	Bolt M12 x 45 Grade 10.9	Upper wishbone front		
5	AE	Bolt M8 x 40 Grade 10.9	Anti-roll bar mounting brackets		x4 ← (Indicates number of each fixing required)
6	AF	Plain Nut M14 x 1.5 thread	Temporary use to help lock upper wishbone ball joint		
7	AG	Nylon Nut M12	Lower wishbone rear		
8	AH	Nylon Nut M10	Upper wishbone		
9	AJ	Plain Washer M12 Chamfered	Lower wishbone		
AA					
AB					
AC					
AD					
AE					
AF					
AG					
AH					
AJ					

Illustrations are for illustrative purposes only and are not to scale. Page 1 of 2

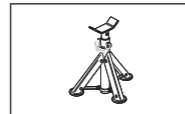
KEY

TOOLS

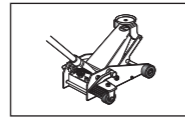
- Allen key
- Flat head screwdriver
- Ruler
- Spray adhesive
- Trolley jack
- Assistance
- Grease
- Scissors
- Spray lube
- WD40
- Axle stand
- Junior hacksaw
- Side cutters
- Stanley knife
- Cable tie
- Latex gloves
- Silicon
- Super glue
- Combination spanner
- Long nose pliers
- Silicon gun
- Tape
- Copper grease
- Muscle
- Socket wrench
- Tape measure
- Drill
- Pop rivet gun
- Socket wrench (allen)
- Thread lock / LocTite
- Drill bit
- Power adhesive
- Spanner
- Torque wrench
- Engine hoist
- Pozidrive screwdriver
- Spirit level
- Torx

LET'S GET READY

PARTS



x3



FIXINGS

TOOLS

TIPS

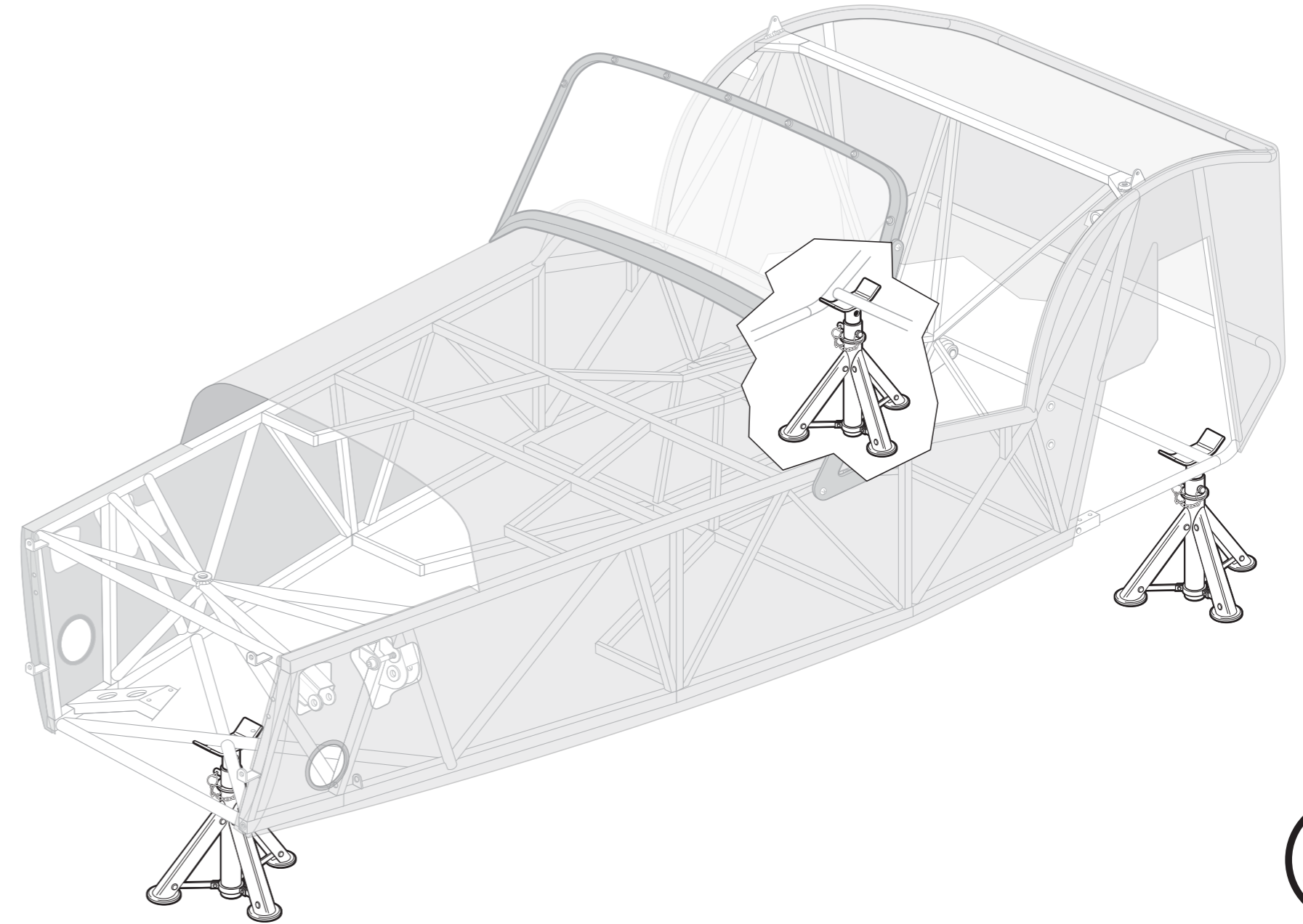
When deciding how high your axle stands should be (the higher the better for working on), don't forget that a complete car will need to come down off them, so make sure your trolley jack can reach and lift the height you set them too!

Mick F

Some tape or foam on the top of the axle stands will stop them scratching the chassis.

Matt T

LET'S GET READY

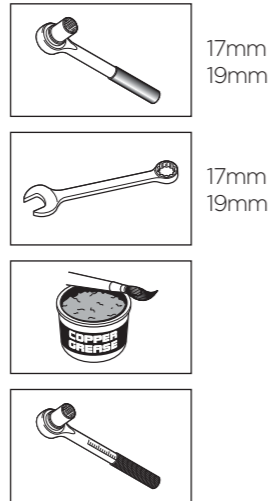


START WITH THE SUSPENSION WISHBONES

PARTS

- 1 Lower wishbone
- 2 Upper wishbone
- 3 Wishbone bush sleeve

TOOLS



FIXINGS

ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	AA Bolt M12 x 100 Grade 10.9	BM12X100	2	Lower wishbone rear	
2	AB Bolt M12 x 65 Grade 10.9	BM12X65	2	Lower wishbone front	
3	AC Bolt M10 x 95 Grade 10.9	BM10X95	2	Upper wishbone rear	
4	AD Bolt M10 x 65 Grade 10.9	BM10X65	2	Upper wishbone front	
5	AA Bolt M12 x 65 Grade 10.9	BM12X65	4	Anti-roll bar mounting brackets	
6	AC Bolt M10 x 100 Grade 10.9	BM10X100	1	Temporary use to hold wishbone upper wishbone ball joint	
7	AG Nylon Nut M10	NM10F12	2	Lower wishbone rear	
8	AH Nylon Nut M10	NM10F10	4	Upper wishbone	
9	AJ Plain Washer M12 Chamfered	W12M12	18	Lower wishbone	
10	AA Bolt M12 x 65 Grade 10.9	BM12X65	4	Anti-roll bar mounting brackets	
11	AL Plain Washer M10 Chamfered	W10M10	2	Steak plate	

x2
x2
x2
x2
x2
x2
x2
x4
x14

Page 1 of 2

ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
12	AA Spring Washer M12	W12M12	2	Lower wishbone front	
13	AA Bolt M12 x 65 Grade 10.9	BM12X65	4	Anti-roll bar mounting brackets & lower wishbone front	
14	AA Bolt M12 x 65 Grade 10.9	BM12X65	2	Steak plate	
15	AA Bolt M12 x 65 Grade 10.9	BM12X65	2	Wing nuts	
16	AA Bolt M12 x 65 Grade 10.9	BM12X65	2	Frame brace, wing nuts, steering rack frame	

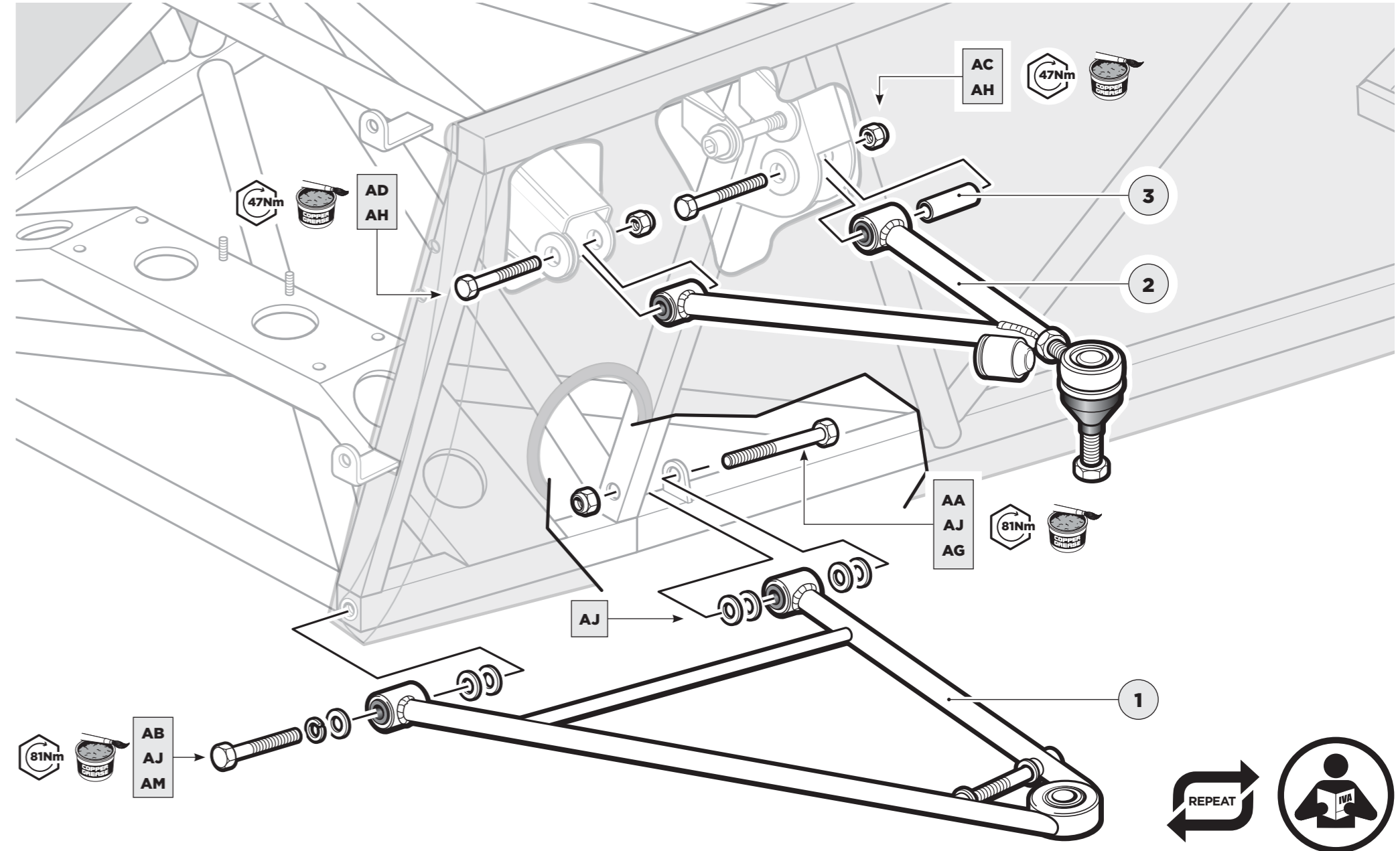
x2

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TIPS

- For now, only tighten the nuts/bolts lightly and then torque them up when the car is finished and on the ground. This sets the bushes correctly and ensures the best handling.
Harrison P
- Leave bolt AD loose for now, as we have to take it back out again to put the headlight bracket on later.
John K
- The big washers are chamfered and the chamfered side should be towards the wishbone.
Alex H

START WITH THE SUSPENSION WISHBONES

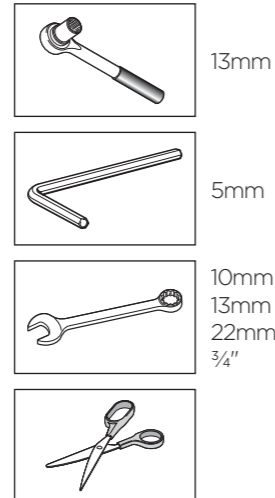


NOW FOR THE STEERING RACK

PARTS

- 1 Steering rack
- 2 Rack clamps
- 3 Column universal joint
- 4 Track rod end
- 5 IVA cover

TOOLS



13mm

5mm

10mm
13mm
22mm
3/4"

TIPS

Finding the right IVA cover isn't obvious because it is effectively a long cap. To use it, you cut the closed end off.

Jamie A

The trackrod end needs to screw on about 12 turns (it will be properly set later when the tracking is done).

Matthew H

Don't fully tighten steering rack for now.

Dan D

FIXINGS

Pack B		CATERHAM		55	
STEERING DeDION CARS (METRIC)					
ITEM	PART DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Rack clamp	BACHEX70	4	Rack clamps	
3	Column universal joint	BMBX30	2	Column to rack universal joint	
5	Track rod lock nut	NFFW12	2	Track rod lock nut	
7	Column to rack universal joint	NMVF9	2	Column to rack universal joint	
8	Steering rack clamp	NMVF6	4	Steering rack clamp	
10	Rack clamps and column clamp	WPHX4	6	Rack clamps and column clamp	

x4

x2

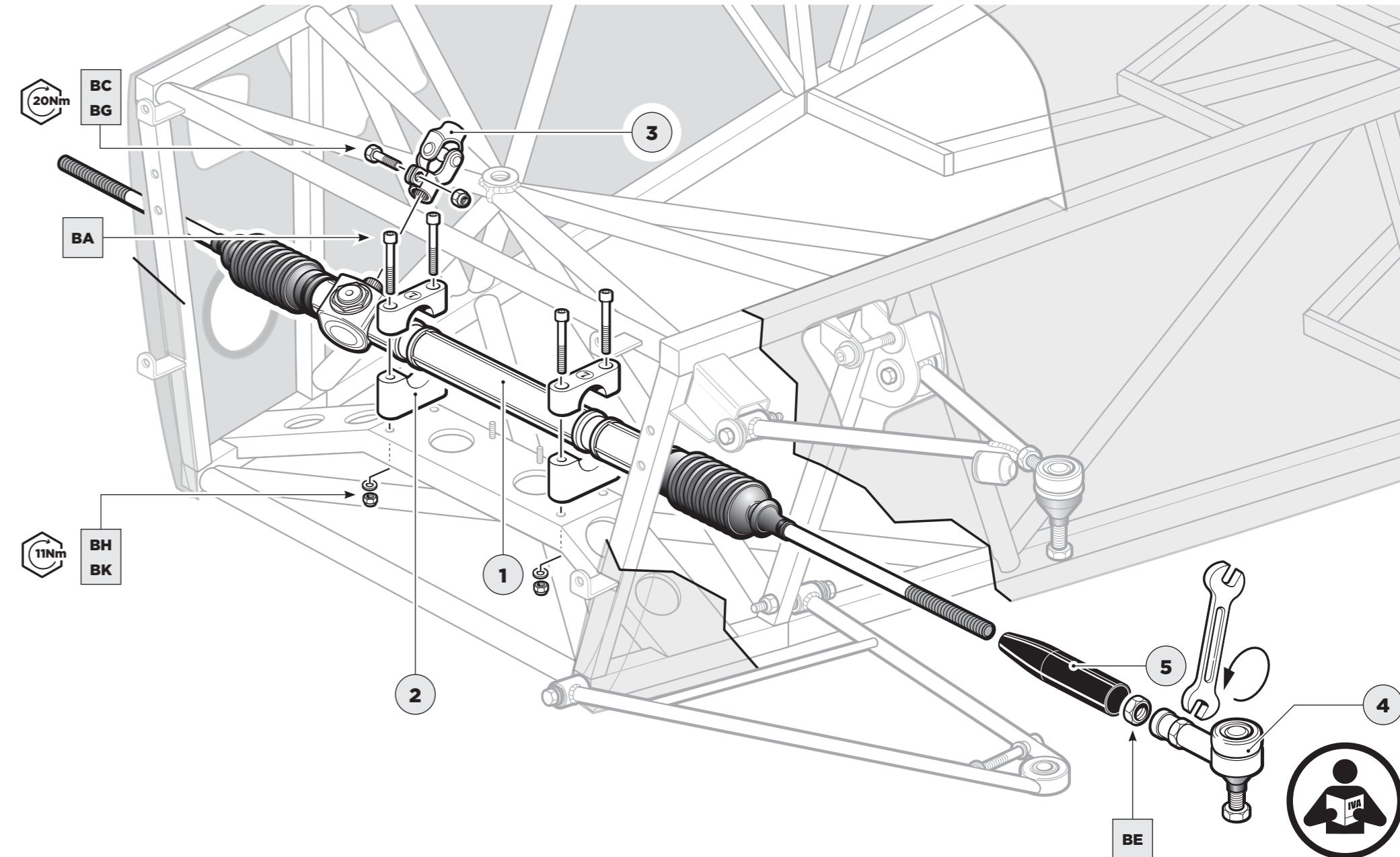
x2

x2

x4

x4

NOW FOR THE STEERING RACK

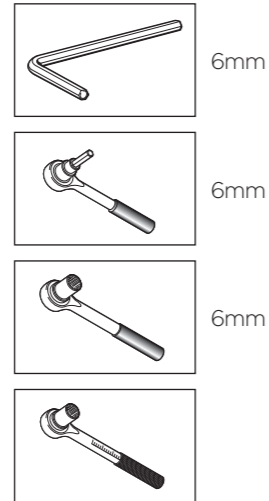


AND THEN THE DAMPERS

PARTS

- 1 Spring / damper
- 2 Lower damper sleeve
- 3 Upper damper sleeve

TOOLS



6mm

6mm

6mm

6mm

FIXINGS

ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
AA	Roller ball 2.5mm	98423702	2	Lower wishbone plate	
AB	Roller ball 2.5mm	98423703	2	Lower wishbone plate	
AC	Roller ball 2.5mm	98423704	2	Upper wishbone plate	
AD	Roller ball 2.5mm	98423705	2	Upper wishbone plate	
AE	Roller ball 2.5mm	98423706	4	Anti-roll bar mounting brackets	
AF	Roller ball 2.5mm	98423707	2	Stake pins	
AG	Roller ball 2.5mm	98423708	2	Wing nuts	
AH	Roller ball 2.5mm	98423709	2	Flare brass, orange mounting and brake	
AI	Roller ball 2.5mm	98423710	2	Flare brass, orange mounting and brake	
AJ	Roller ball 2.5mm	98423711	2	Flare brass, orange mounting and brake	
AK	Roller ball 2.5mm	98423712	4	Upper wishbone	
AL	Roller ball 2.5mm	98423713	2	Lower wishbone	
AM	Roller ball 2.5mm	98423714	10	Lower wishbone	
AN	Roller ball 2.5mm	98423715	4	Anti-roll bar mounting brackets	
AO	Roller ball 2.5mm	98423716	2	Stake pins	

ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
AA	Spring washer	98423717	2	Lower wishbone plate	
AB	Spring washer	98423718	6	Anti-roll bar mounting brackets & upper damper mount	
AC	Spring washer	98423719	2	Stake pins	
AD	Spring washer	98423720	2	Wing nuts	
AE	Spring washer	98423721	2	Flare brass, orange mounting and brake	
AF	Spring washer	98423722	2	Flare brass, orange mounting and brake	

Fixings not contained in the pack will be supplied loosely fitted to the chassis and the wishbone

TIPS

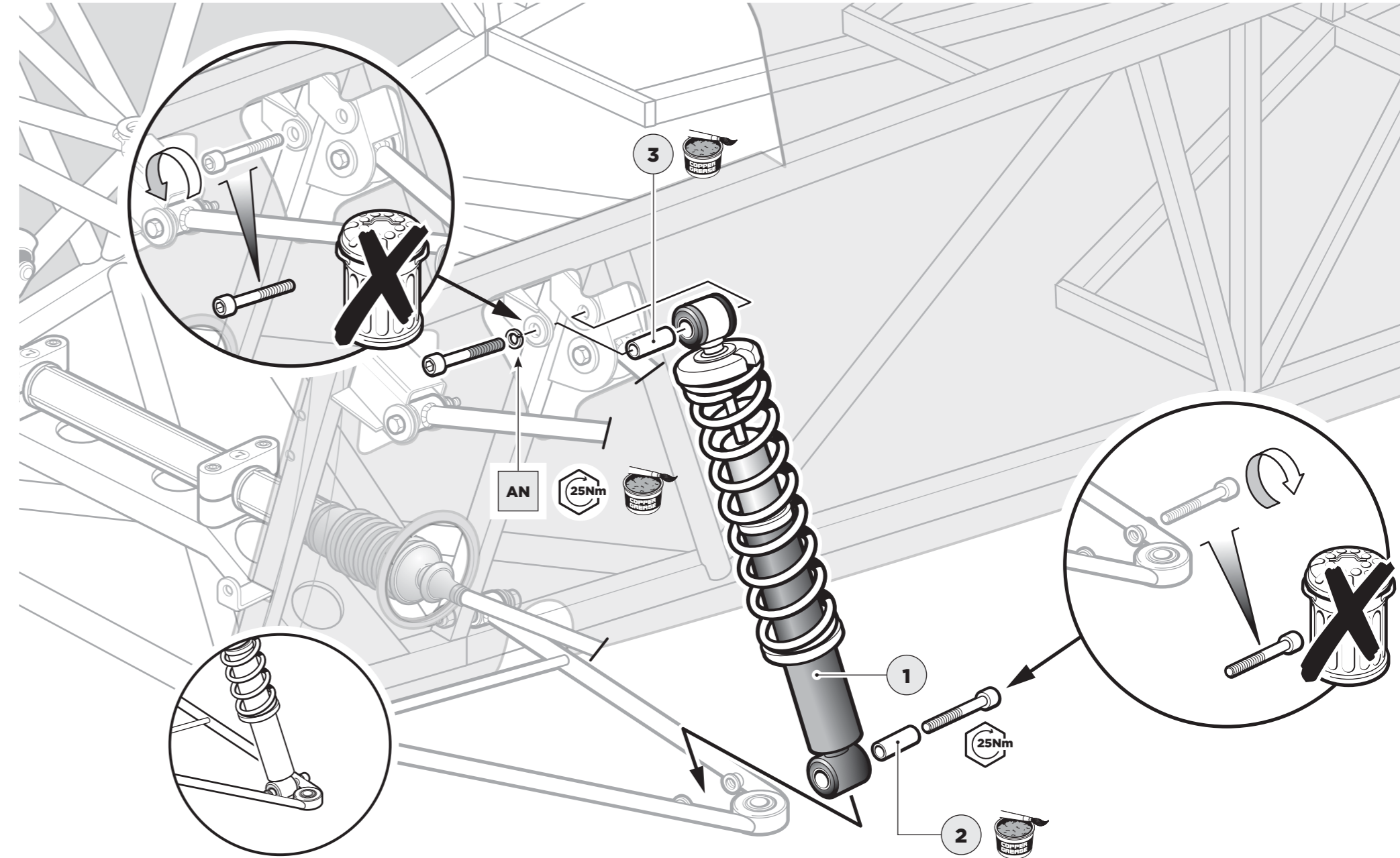
Put the top of the damper on first and be careful not to let it swing into the side of the chassis.

Grant P

The bottom can be a tight fit!

Mick F

AND THEN THE DAMPERS

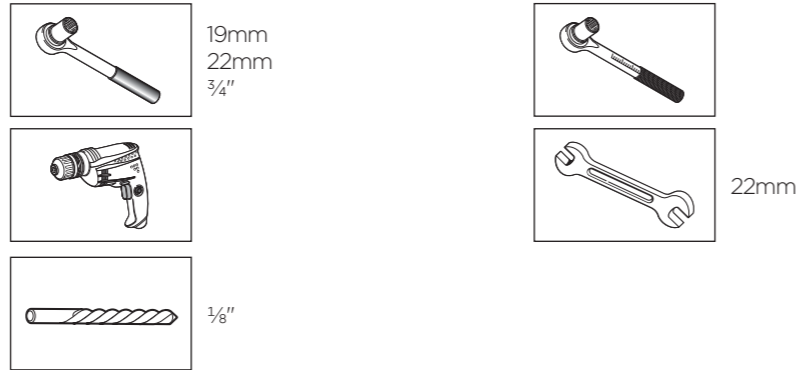


IT'S TIME FOR THE WINGSTAYS

PARTS

- 1 Wingstay
- 2 Front brake & upright assembly

TOOLS



TIPS

The drilled hole is for the side repeater earth that we'll fit later. It's easier to drill from the top and down through both sides of the tube, rather than through one side from the bottom (where the earth will be fixed).

Tiago O

Put the 'upright' into the lower wishbone joint then attach the steering before tightening the bottom nut. This stops it all swinging around hitting the side of the chassis.

John S

Some of the fixings required and shown on the drawings, such as the ball joint nut, are already on the part and not in the fixing pack.

Anthony L

Use the plain nut to pull the top ball joint home before using a nyloc, otherwise the thread will spin.

Chris N

Remove and discard the washer that comes on the back of the assembly before fitting the wingstay; it's not needed.

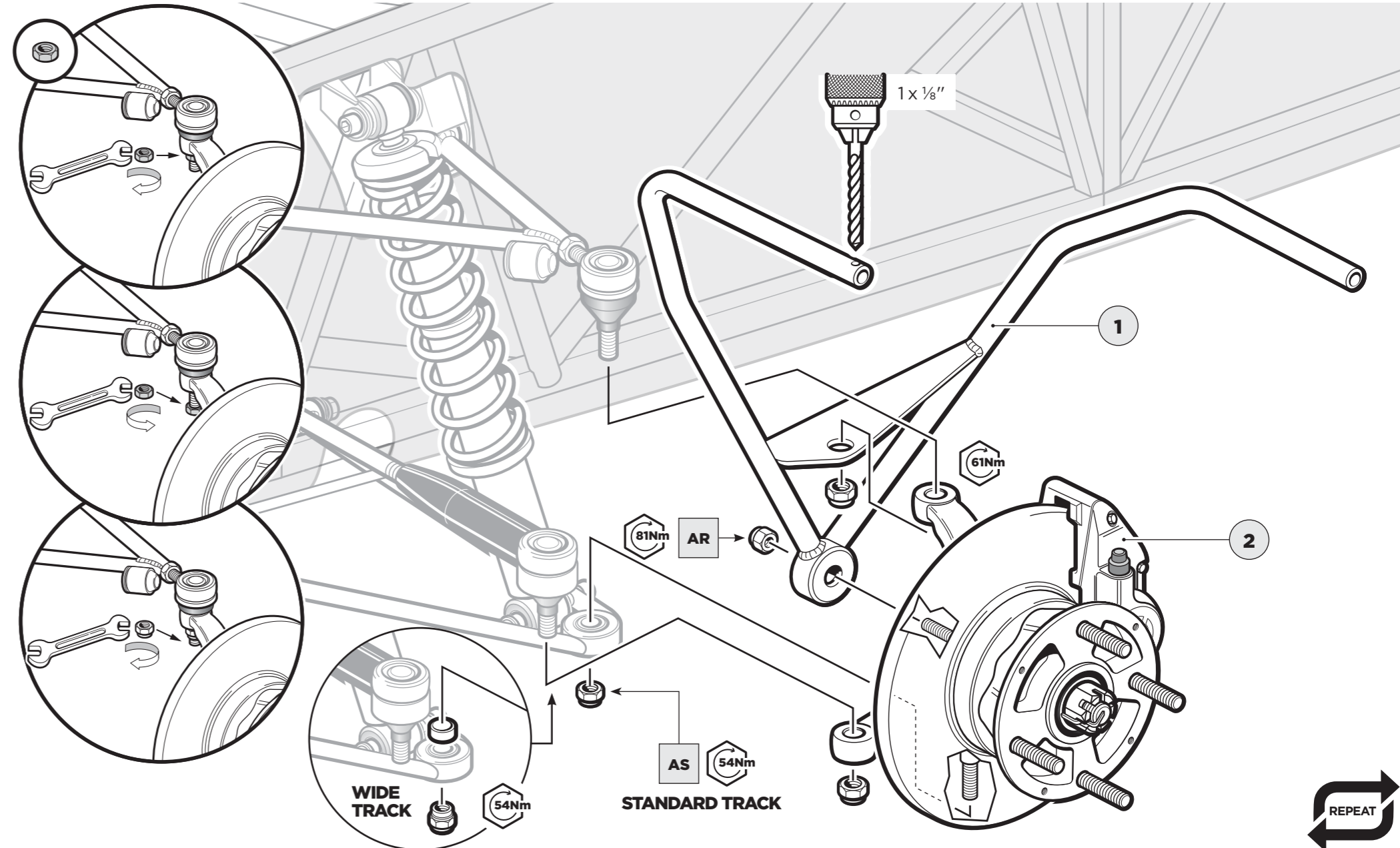
Rich T

FIXINGS

ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
AA	Ball Joint 1.5" (38mm)	BAJ1502	2	Lower wishbone joint	
AB	Ball Joint 2.0" (51mm)	BAJ2002	2	Lower wishbone joint	
AC	Ball Joint 2.5" (64mm)	BAJ2502	2	Lower wishbone joint	
AD	Ball Joint 3.0" (76mm)	BAJ3002	2	Upper wishbone joint	
AE	Ball Joint 3.5" (89mm)	BAJ3502	2	Upper wishbone joint	
AF	Plain Nut M14 x 1.5 (2mm)	BNM14	1	Temporary use to help lock upper wishbone ball joint	
AG	Ball Nut M14	BNM14	2	Lower wishbone joint	
AH	Ball Nut M14	BNM14	4	Upper wishbone joint	
AI	Plain Washer 14mm	PNW14	10	Lower wishbone joint	
AJ	Plain Washer 14mm	PNW14	4	Ball nut for mounting brackets	
AK	Plain Washer 14mm x 1.5"	PNW14	2	Steering plate	

ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
AS	Nyloc Nut 1/2" (14mm)	NFY112	2	Wing stay	
AT	Nyloc Nut 1/2" (14mm)	NFY112	2	Front brake, upright mounting (old track ONLY)	

IT'S TIME FOR THE WINGSTAYS





Now is a good time to take some photos



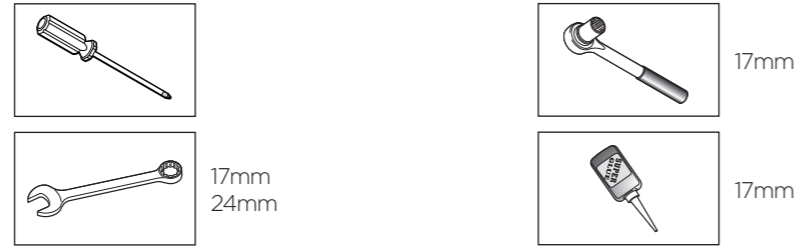
Have you applied for your IVA yet?

LET THERE BE LIGHTS

PARTS

- 1 Headlight assembly
- 2 Indicator pod
- 3 Indicator assembly
- 4 Headlight bracket
- 5 IVA trim

TOOLS



FIXINGS

ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	CA	None 10 x 1/2" hex hardware	6	Indicator assembly to indicator pod	
2	CB	None 2 x 1/2" hex hardware	2	Side regulator with coil spring	
3	CC	None 1/2 x 1/2" hex hardware	4	Rear light shroud rubber flange	
4	CD	None 1/2 x 1/2" hex hardware	4	Rear light shroud lower flange	
5	CE	None 1/2 x 1/2" hex hardware	2	Front bracket to mounting rack	
6	CF	None 1/2 x 1/2" hex hardware	2	Rear bracket to mounting rack	
7	CG	None 1/2 x 1/2" hex hardware	1	Through shroud nut (mounts to indicator pod)	
8	CH	None 1/2 x 1/2" hex hardware	2	Ball headnut	
9	CI	None 1/2 x 1/2" hex hardware	1	Hex nut	

Illustrations are for illustrative purposes only and are not to scale. Page 1 of 1

x6

TIPS

It's very important to read the IVA Guide before starting this job to ensure grommets and sheathing are in the right place. It's very difficult to add them once fitted!

John S

This is the trickiest job on the car, so once done you can breathe a sigh of relief!

Tiago A

The wiring for the headlights is attached to the chassis when you receive your kit. The wires go through the hole in the end of the headlight bracket and out of the other hole in order to go up into the headlight and over to the indicator.

Jamie A

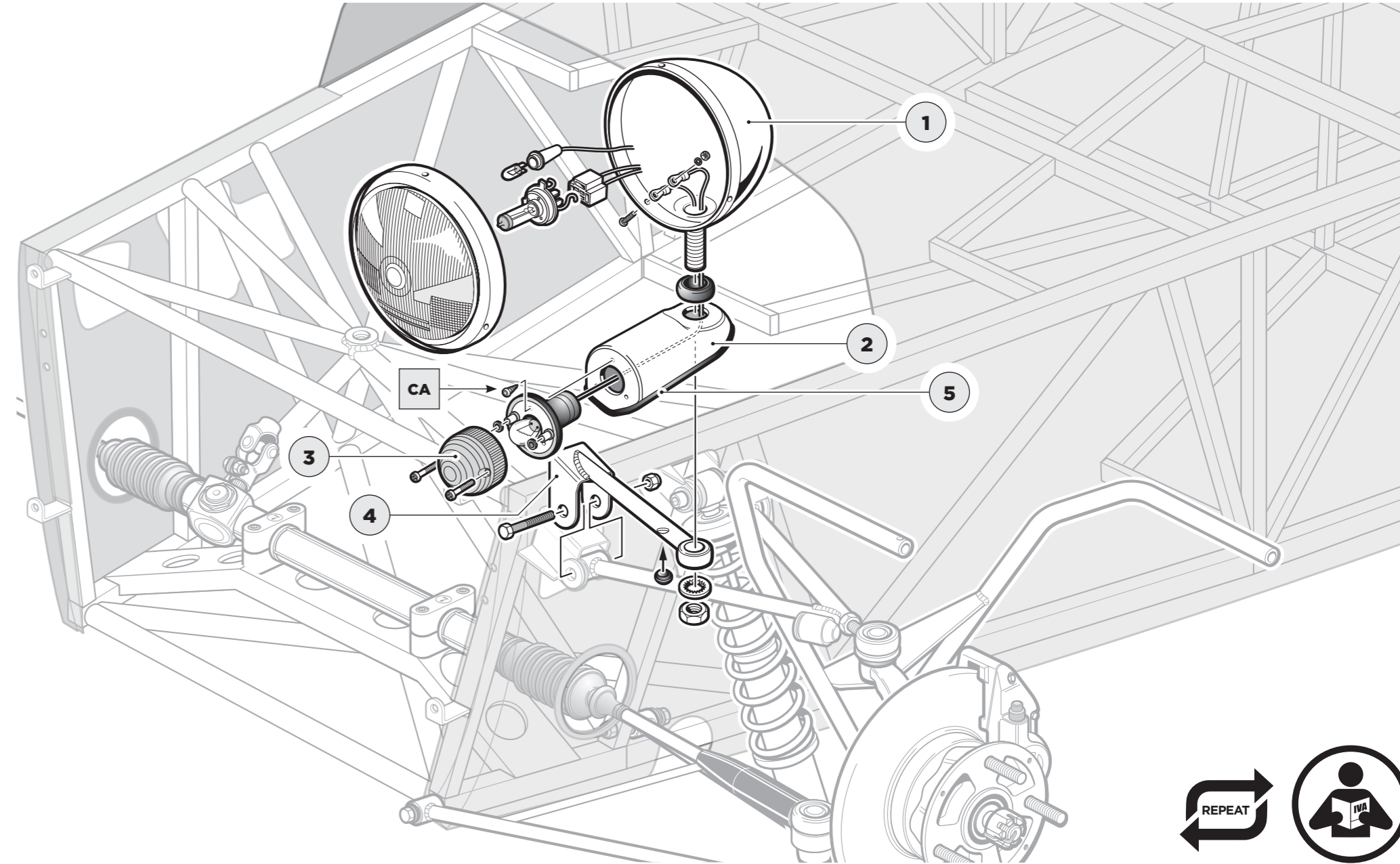
Glue IVA trim all around the edge of the pod before fitting.

Chris B

The tab on the headlight bracket ④ hooks under the wishbone bracket on the chassis.

Harrison P

LET THERE BE LIGHTS

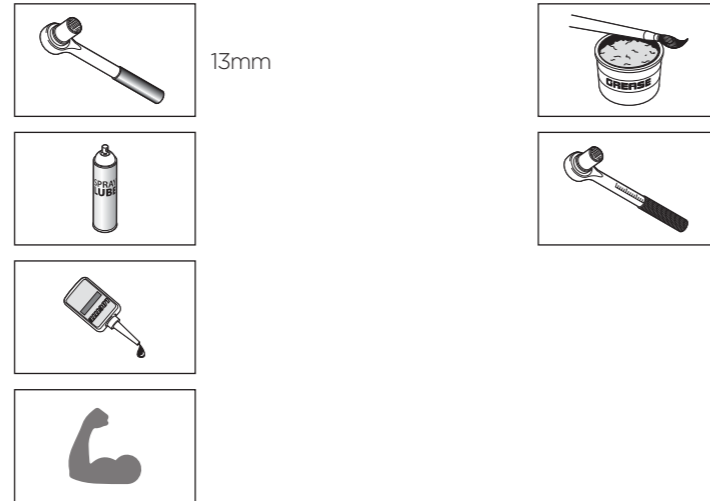


LAST PART OF THE FRONT SUSPENSION: CONNECTING THE TWO SIDES TOGETHER

PARTS

- 1 Anti-roll bar
- 2 Anti-roll bar bracket
- 3 Anti-roll bar rubber
- 4 Anti-roll bar ball
- 5 Anti-roll bar dust cover

TOOLS



FIXINGS

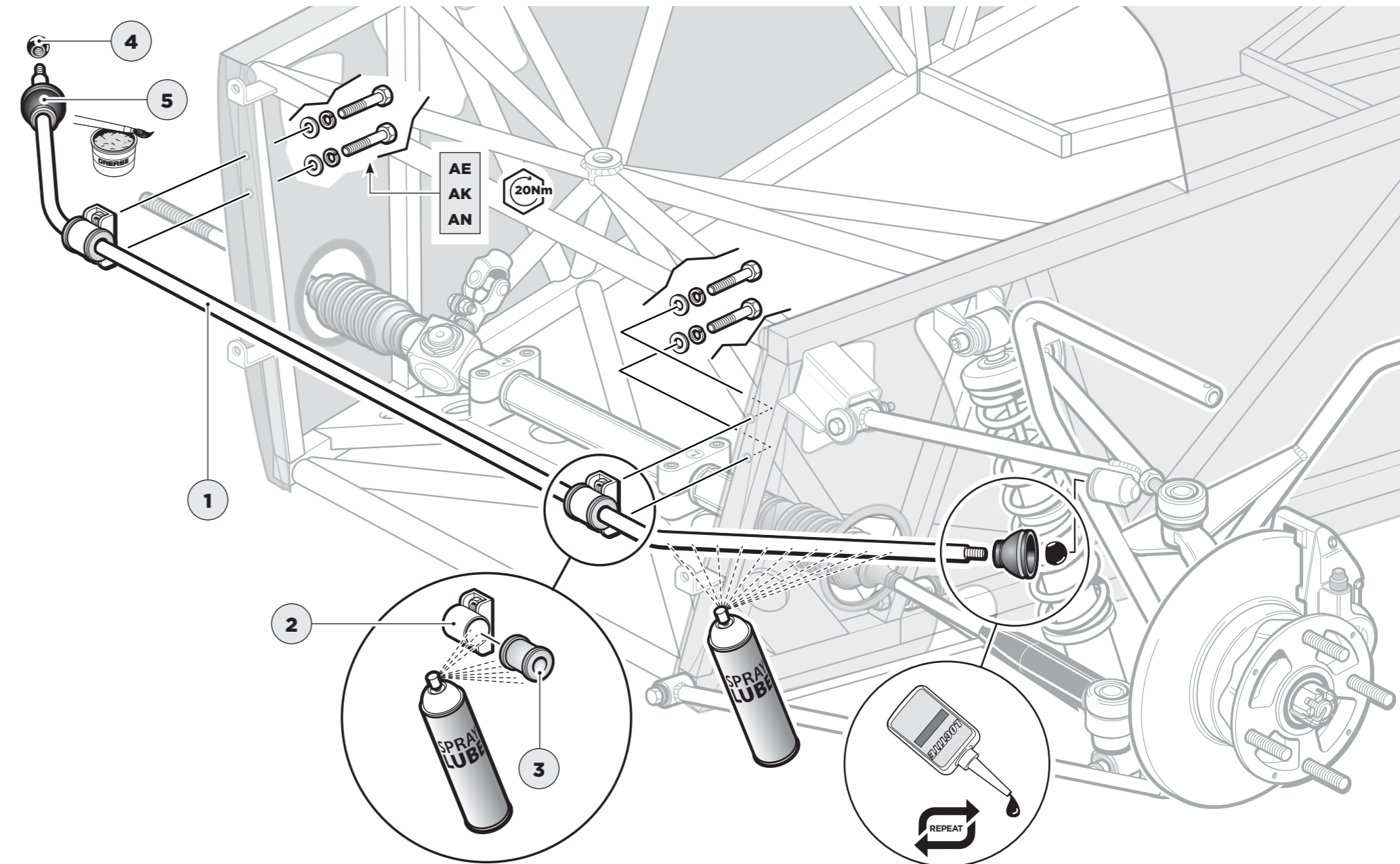
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
AA	Ball Joint 1.500mm x 1.500mm	BA02702	2	Lower wishbone, front	
AB	Ball Joint 1.500mm x 1.500mm	BA02702	2	Lower wishbone, front	
AC	Ball Joint 1.500mm x 1.500mm	BA02702	2	Upper wishbone, front	
AD	Ball Joint 1.500mm x 1.500mm	BA02702	2	Upper wishbone, front	
AE	Ball Joint 1.500mm x 1.500mm	BA02702	4	Anti-roll bar mounting brackets	
AF	Ball Joint 1.500mm x 1.500mm	BA02702	1	Temporary use to hold the upper wishbone ball joint	
AG	Ball Joint 1.500mm x 1.500mm	BA02702	2	Lower wishbone, front	
AH	Ball Joint 1.500mm x 1.500mm	BA02702	4	Upper wishbone, front	
AI	Ball Joint 1.500mm x 1.500mm	BA02702	10	Lower wishbone, front	
AJ	Ball Joint 1.500mm x 1.500mm	BA02702	2	Lower wishbone, front	
AK	Plain Washer 16mm dia	WP048	4	Anti-roll bar mounting brackets	
AL	Shake pin 16mm dia	SP018	2	Shake pin	

ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
AM	Spring Washer 16mm dia	WP048	2	Lower wishbone, front	
AN	Spring Washer 16mm dia	WP048	6	Anti-roll bar mounting brackets & upper damper mount	
AO	Spring Washer 16mm dia	WP048	2	Shake pin	
AP	Spring Washer 16mm dia	WP048	2	Wing stay	
AQ	Spring Washer 16mm dia	WP048	2	Lower wishbone, front	

TIPS

- Use four small cable ties to secure the dust cover. **Mick F**
- Check that the colour of the mounting rubbers matches the colour spot on the bar. **John K**
- Use the thread lock on the thread of the anti-roll bar, not in the thread of the ball. **Dan D**
- Grease the balls and cups generously. **Matt T**
- Getting the assembled anti-roll bar fully into both cups on the upper wishbone can be a bit of a fight. It's made of springy stuff, so don't worry that you are bending it. **Jamie A**

LAST PART OF THE FRONT SUSPENSION: CONNECTING THE TWO SIDES TOGETHER

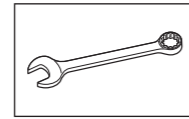


FITTING THE BRAKE HOSES

PARTS

- 1 Brake hose
- 2 Copper washer

TOOLS



13mm (x2)
9/16"

FIXINGS

ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
AA	Ball joint 2.00 (Metric)	BAJ2002	2	Lower wishbone, rear	
AB	Ball joint 2.00 (Metric)	BAJ2004	2	Lower wishbone, front	
AC	Ball joint 2.00 (Metric)	BAJ2006	2	Upper wishbone, rear	
AD	Ball joint 2.00 (Metric)	BAJ2008	2	Upper wishbone, front	
AE	Ball joint 2.00 (Metric)	BAJ2010	4	Anti-roll bar mounting brackets, rear	
AF	Ball joint 2.00 (Metric)	BAJ2012	4	Anti-roll bar mounting brackets, front	
AG	Ball joint 2.00 (Metric)	BAJ2014	1	Temporary use to hold ball joints, substitute ball joint	
AH	Ball joint 2.00 (Metric)	BAJ2016	2	Lower wishbone, rear	
AI	Ball joint 2.00 (Metric)	BAJ2018	4	Upper wishbone, rear	
AJ	Ball joint 2.00 (Metric)	BAJ2020	4	Anti-roll bar mounting brackets, rear	
AK	Ball joint 2.00 (Metric)	BAJ2022	4	Anti-roll bar mounting brackets, front	
AL	Ball joint 2.00 (Metric)	BAJ2024	2	Brake pipe	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

x2

ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
AA	Spring washer, rear	SPR2002	2	Lower wishbone, rear	
AB	Spring washer, front	SPR2004	4	Anti-roll bar mounting brackets & upper wishbone, front	
AC	Washer 1/2" (Shakeproof)	WSD2008	2	Brake pipe	
AD	Ball joint 2.00 (Metric)	BAJ2010	2	Wing nuts	
AE	Ball joint 2.00 (Metric)	BAJ2012	2	Flare discs, wing nuts mounting and brake	

Drawings are for illustrative purposes only and are not to scale. Page 2 of 2

x2

TIPS

The hose will want to curve once fitted. Make sure the curve points towards the front of the car.

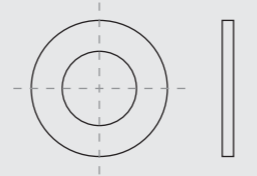
Khalfani D

Brake hoses come in packs of 3: 2 front, 1 back.

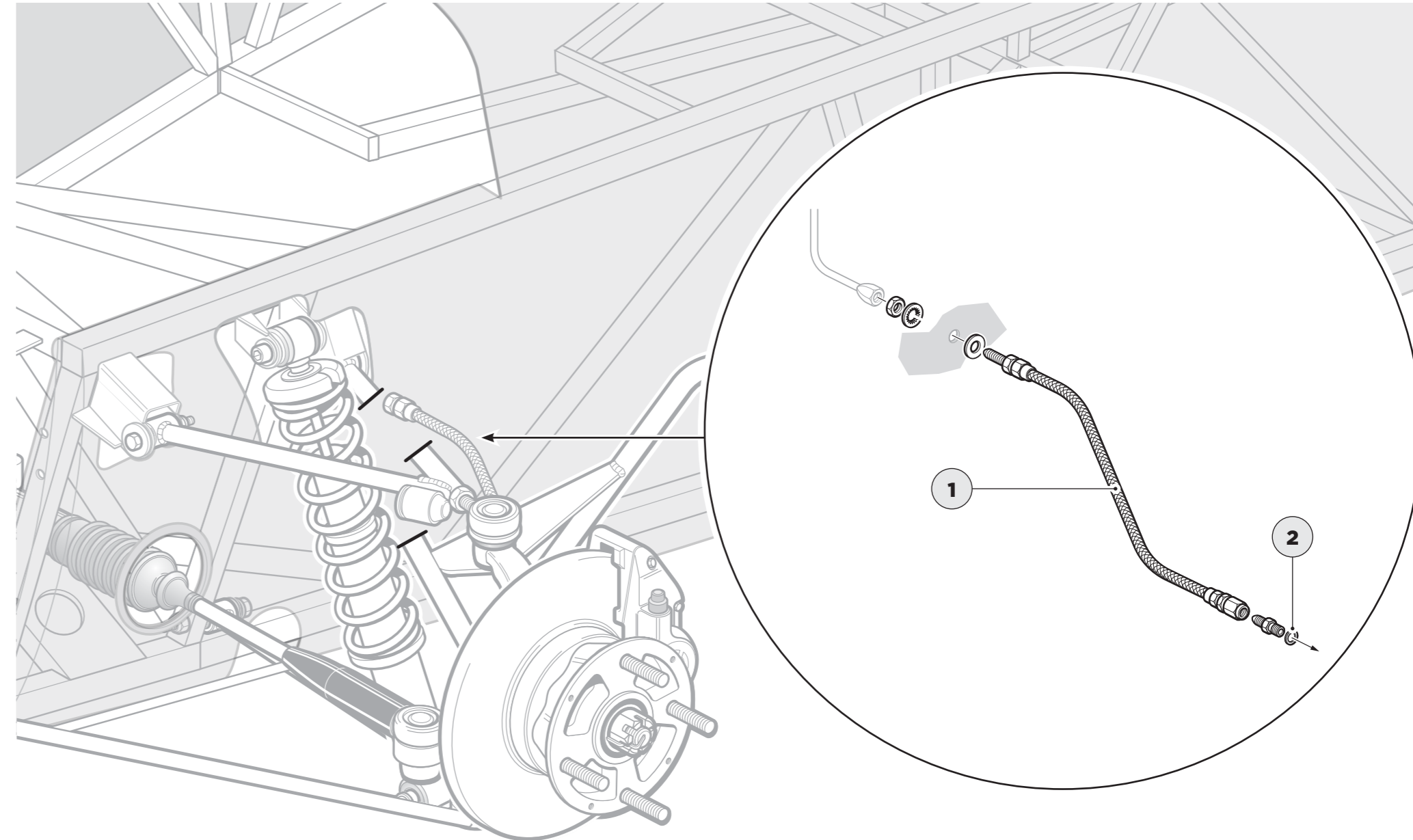
Anthony L

The copper washer should be this size.

James A



FITTING THE BRAKE HOSES



LET'S MAKE SOME NOISE

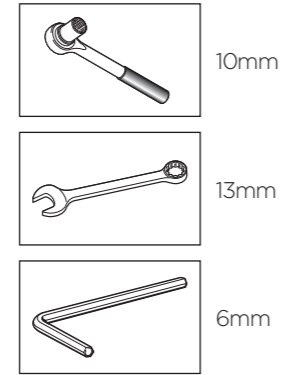
PARTS

- 1** Horn kit (x2)
- 2** Spacer (miscellaneous box)
- 3** Bolt for spacer

FIXINGS

Miscellaneous box

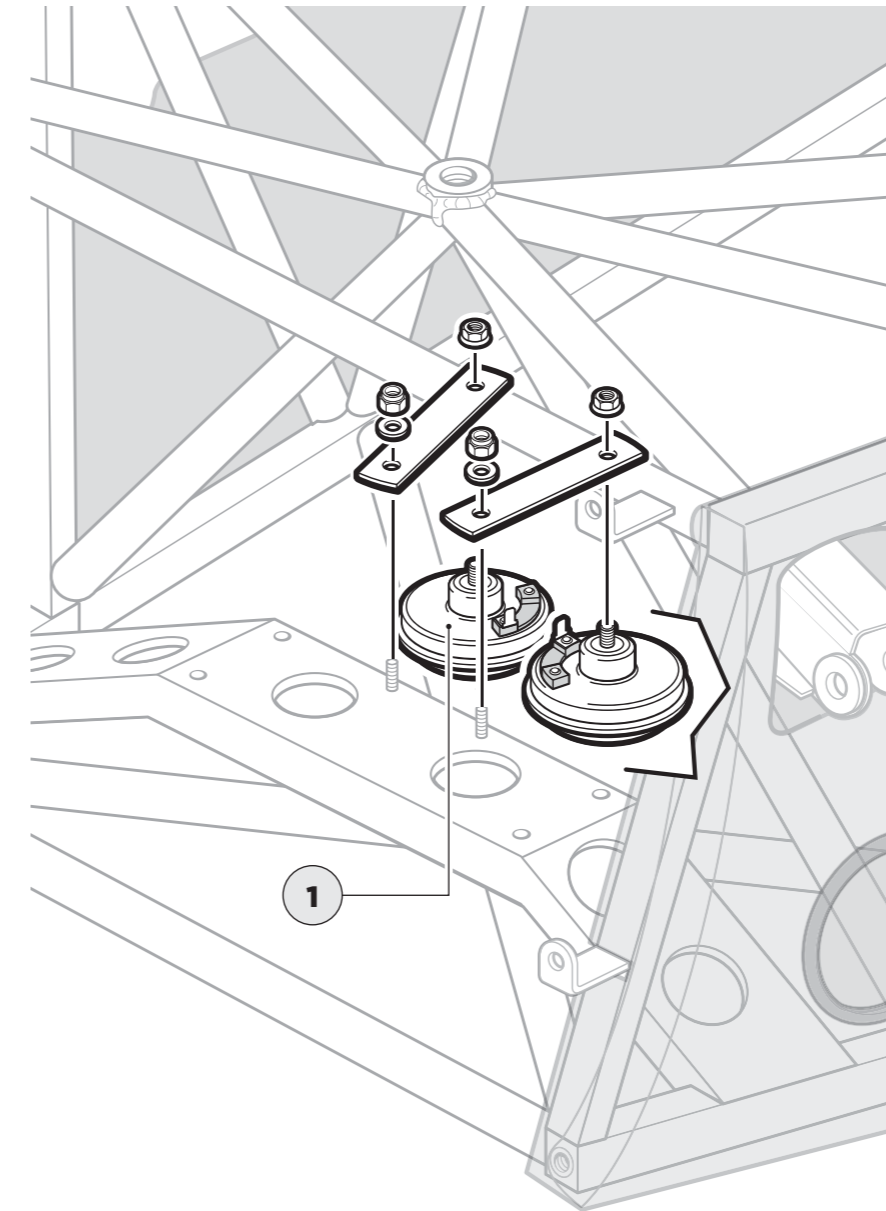
TOOLS



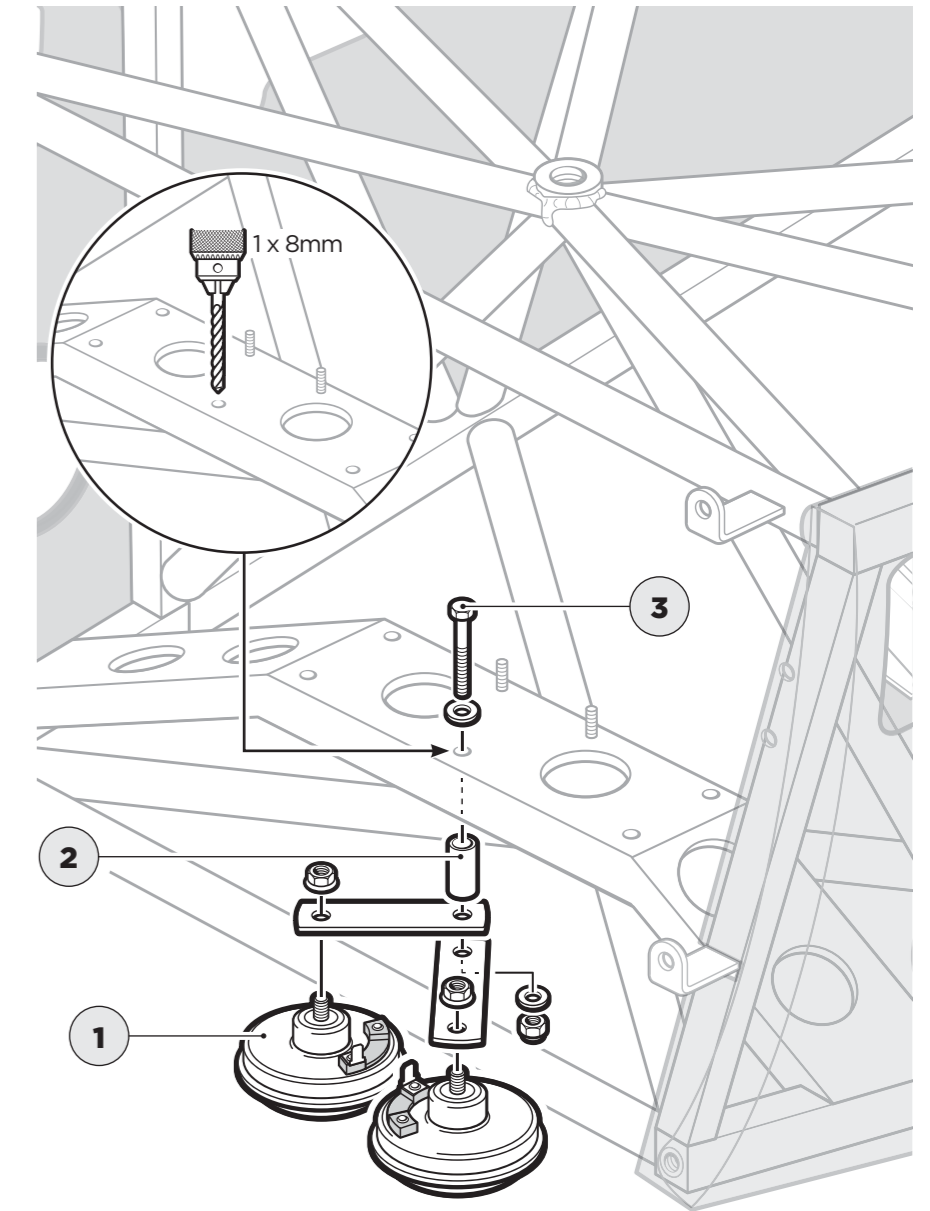
TIPS

LET'S MAKE SOME NOISE

270/310/360



420

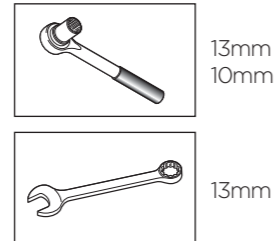


FITTING THE RADIATOR ON THE STANDARD CHASSIS

PARTS

- 1 Radiator
- 2 Fan brackets (x2)
- 3 Fan
- 4 Radiator bobbins (x4)

TOOLS



FIXINGS

ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Radiator	302107A	1	Radiator	
2	Fan brackets (x2)	302107B	2	Fan brackets	
3	Fan	302107C	1	Fan	
4	Radiator bobbins (x4)	302107D	4	Radiator bobbins	

ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
5	Expansion tank	302107E	1	Expansion tank	
6	Spring Washer	302107F	9	8 x Radiator bobbin 1 x Expansion tank	
7	Expansion tank	302107G	1	Expansion tank	
8	Expansion tank	302107H	1	Expansion tank	
9	Expansion tank	302107I	1	Expansion tank	
10	Expansion tank	302107J	1	Expansion tank	
11	Expansion tank	302107K	1	Expansion tank	

x8

x4

x4

x8

x4

x4

TIPS

The fan may have four plastic legs or feet that slot into it.

Vincent M

The fan may have a 'flat' section on the rim. This should be at the top.

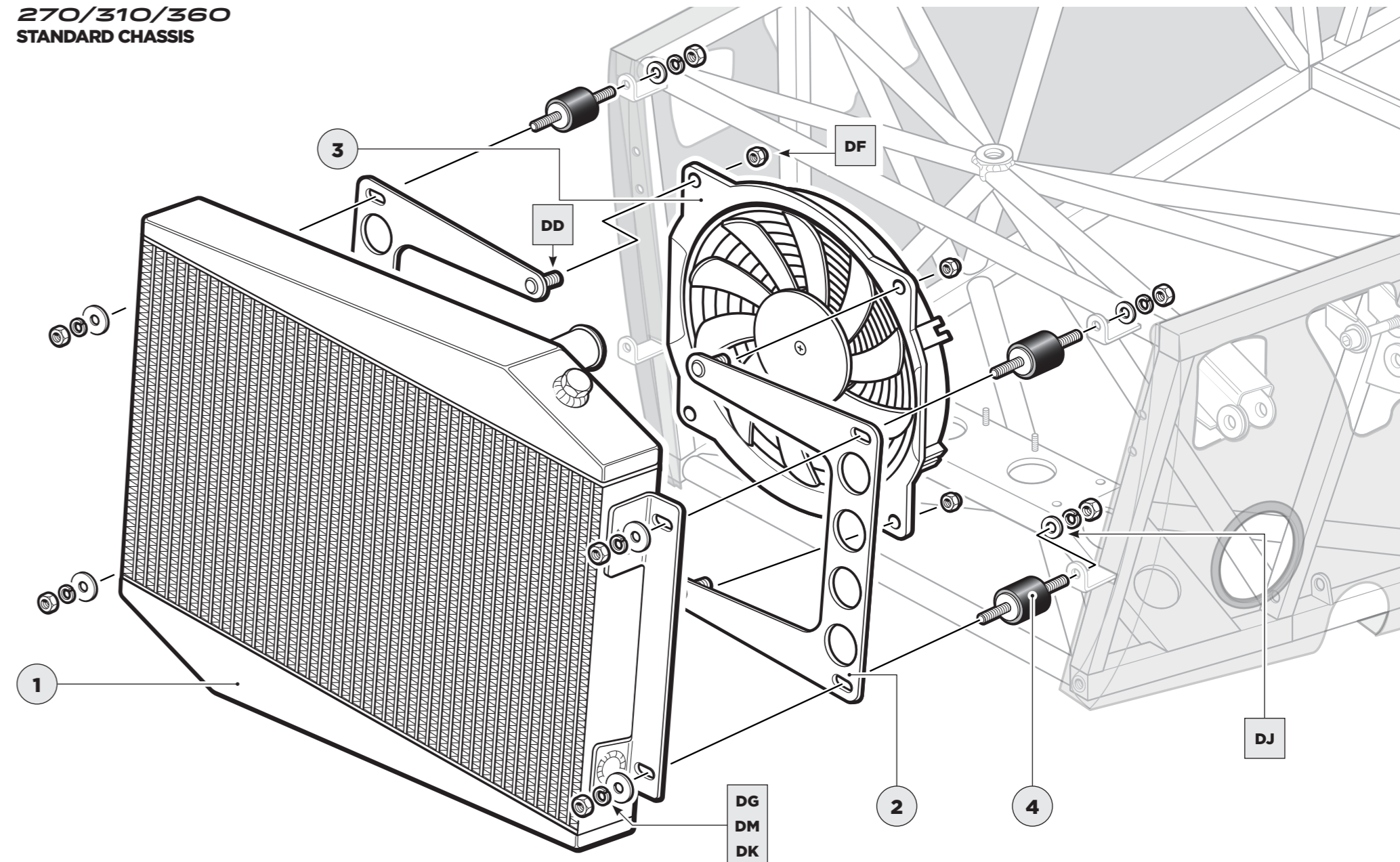
James S

Be careful to tighten the fan on gently and just with a nip.

Lloyd D

FITTING THE RADIATOR ON THE STANDARD CHASSIS

270/310/360 STANDARD CHASSIS

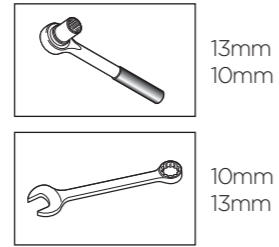


THE RADIATOR MOUNTING FOR THE WIDE-BODIED CHASSIS IS SLIGHTLY DIFFERENT

PARTS

- 1 Radiator
- 2 Fan brackets (x2)
- 3 Fan
- 4 Radiator bobbins (x4)
- 5 Brackets

TOOLS



FIXINGS

ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Radiator	302107A	1	Radiator	
2	Fan brackets (x2)	302107A	2	Fan brackets	
3	Fan	302107A	1	Fan	
4	Radiator bobbins (x4)	302107A	4	Radiator bobbins	
5	Brackets	302107A	2	Brackets	

ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Radiator	302107A	1	Radiator	
2	Fan brackets (x2)	302107A	2	Fan brackets	
3	Fan	302107A	1	Fan	
4	Radiator bobbins (x4)	302107A	4	Radiator bobbins	
5	Brackets	302107A	2	Brackets	

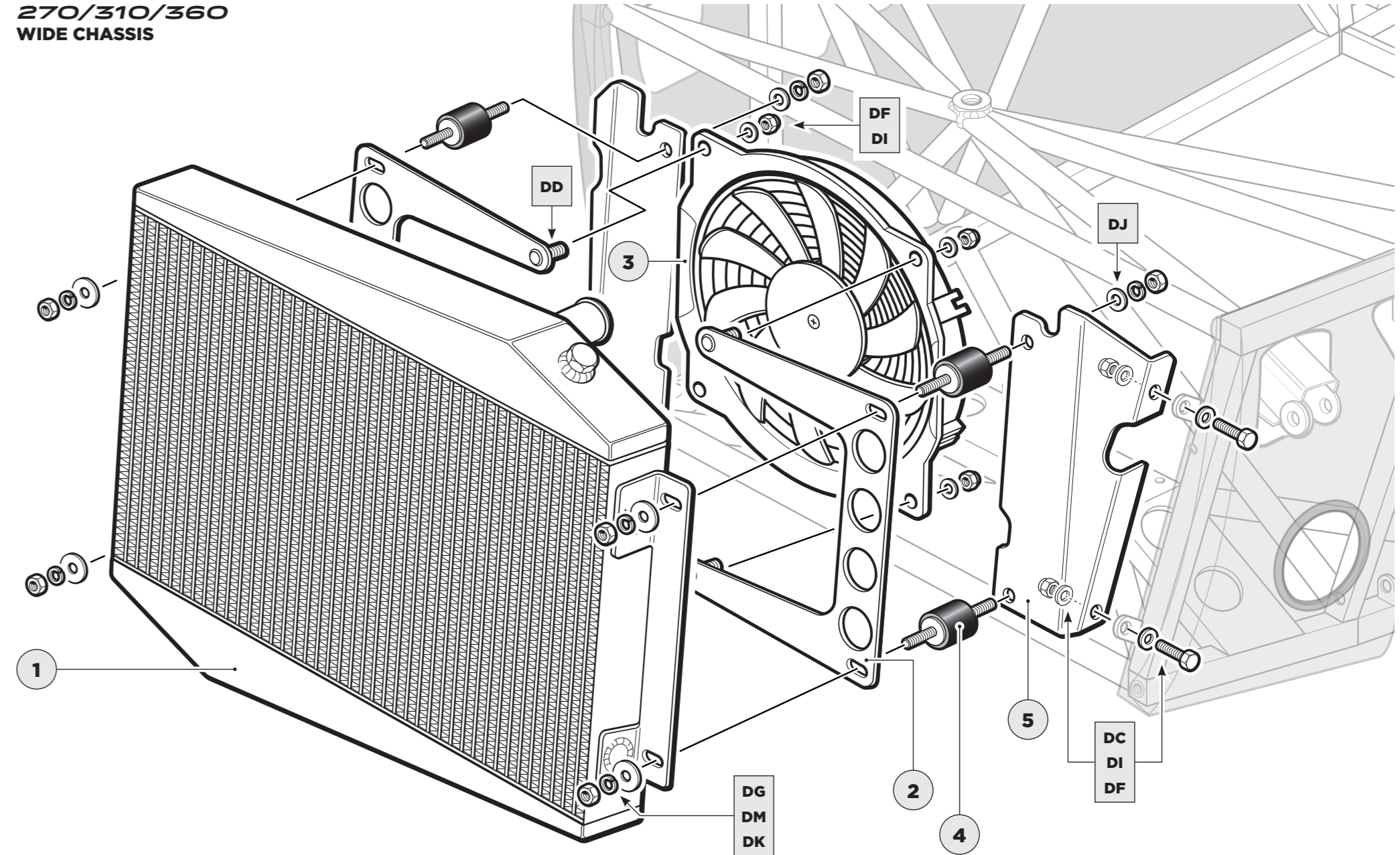
The fan may have four plastic legs or feet that slot into it.
Vincent M

The fan may have a 'flat' section on the rim. This should be at the top.
James S

Be careful to tighten the fan on gently and just with a nip.
Lloyd D

THE RADIATOR MOUNTING FOR THE WIDE-BODIED CHASSIS IS SLIGHTLY DIFFERENT

270/310/360 WIDE CHASSIS

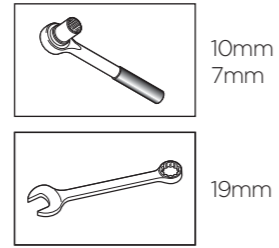


THINGS ARE HEATING UP

PARTS

- 1 Heater
- 2 Valve
- 3 Heater cable
- 4 Lower hose 110mm (cut from long length)
- 5 Upper hose 120mm (cut from long length)
- 6 Grommet

TOOLS



10mm
7mm

19mm

FIXINGS

ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Heater	DE	1	Heater	
2	Valve	DP	1	Valve	
3	Heater cable	DP	1	Heater cable	
4	Lower hose 110mm (cut from long length)	DP	1	Lower hose	
5	Upper hose 120mm (cut from long length)	DP	1	Upper hose	
6	Grommet	DP	1	Grommet	

ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Heater	DE	1	Heater	
2	Valve	DP	1	Valve	
3	Heater cable	DP	1	Heater cable	
4	Lower hose 110mm (cut from long length)	DP	1	Lower hose	
5	Upper hose 120mm (cut from long length)	DP	1	Upper hose	
6	Grommet	DP	1	Grommet	

x2

x4

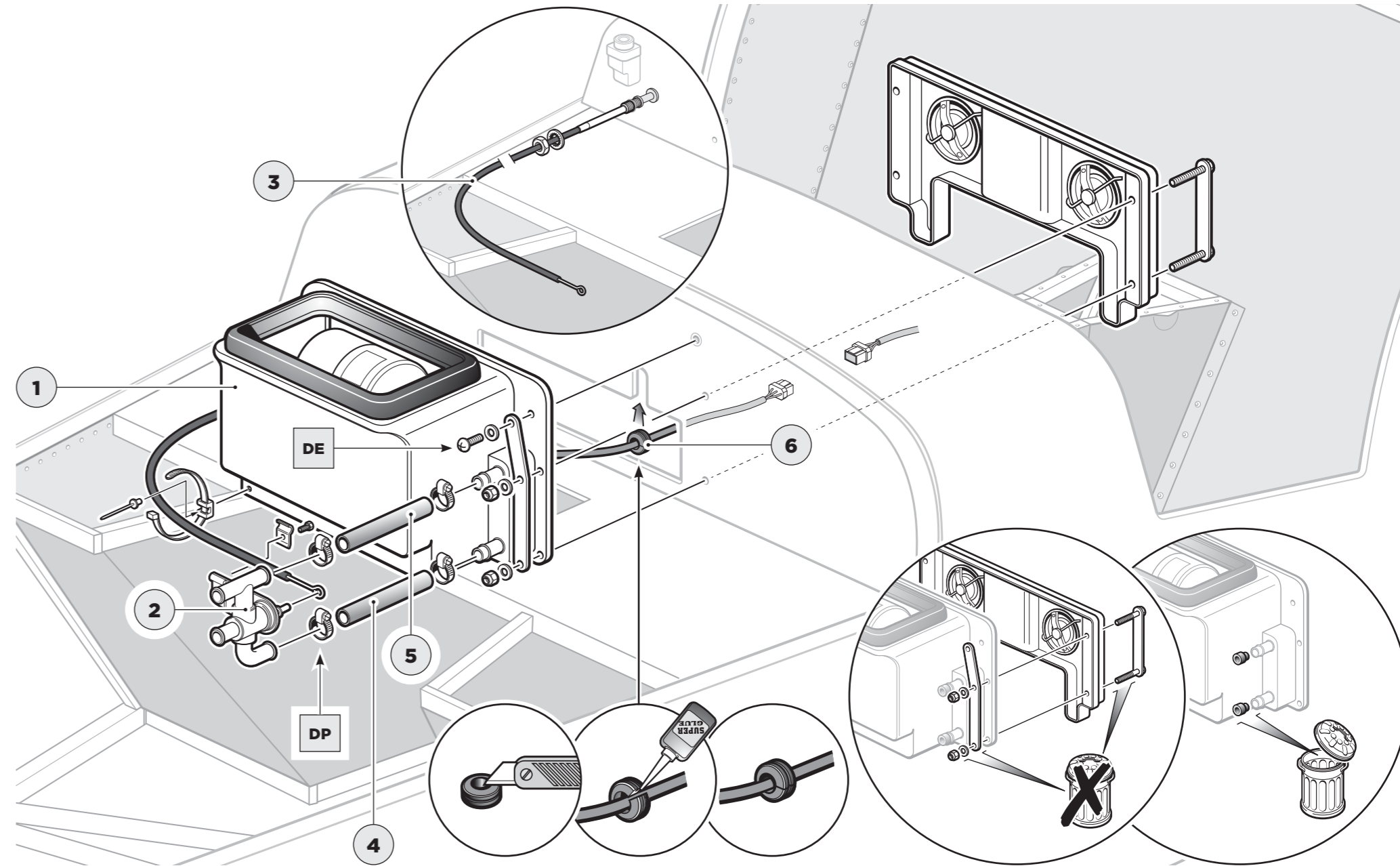
TIPS

Remember to remove bungs from heater.
Jamie A

Use 7mm for jubilee clips but not too tight!
Chris B

It's worth re-tightening the jubilee clips after a couple of uses of car.
John S

THINGS ARE HEATING UP

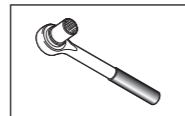
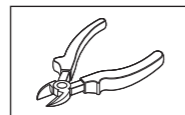
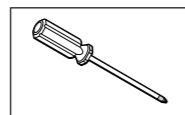


KEEPING THE AIR CLEAN

PARTS

- 1** Air box
- 2** Air filter
- 3** Rubber mounts
- 4** Trim

TOOLS



8mm

FIXINGS

Unmarked bag:

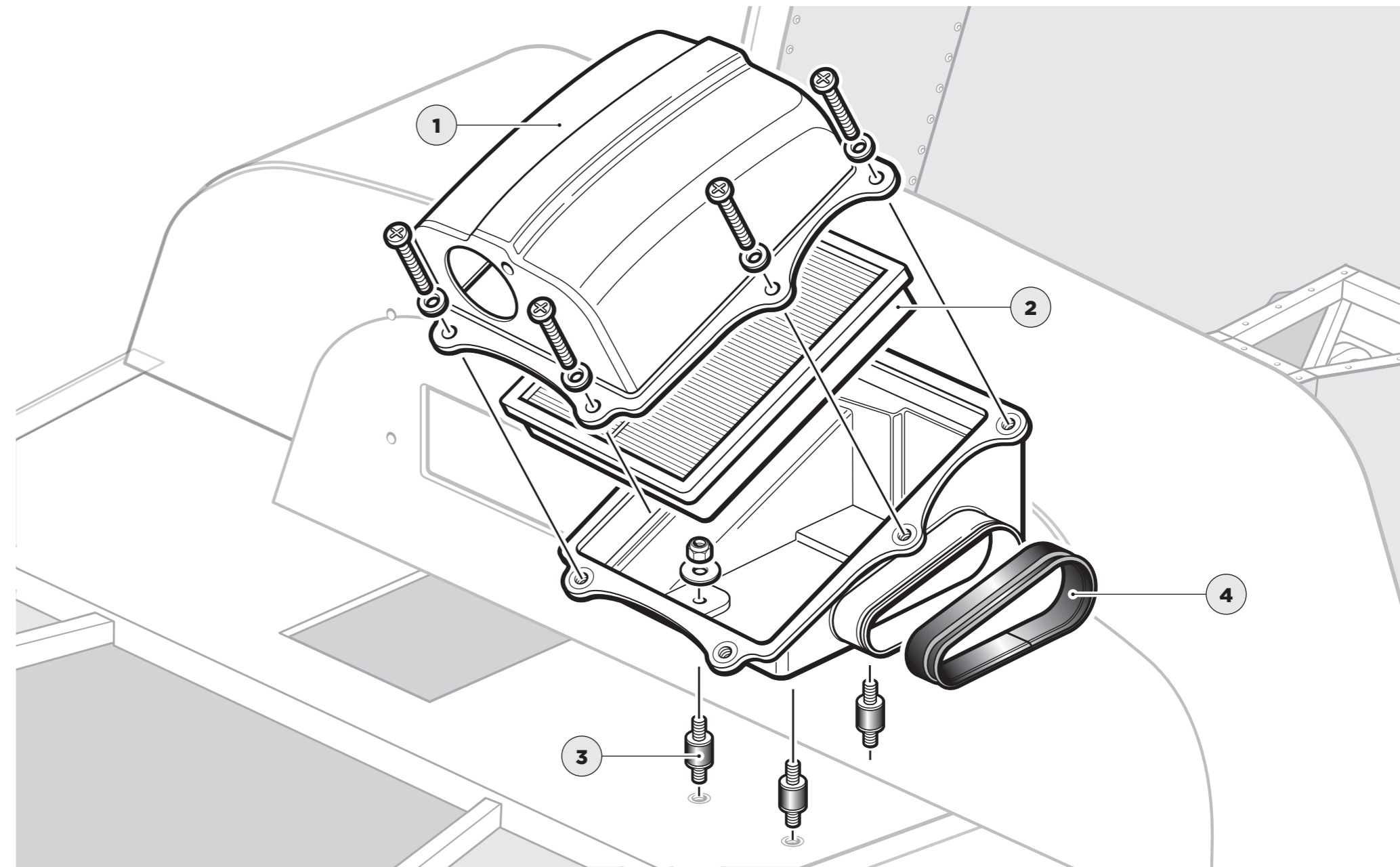
- M5 (x6)
- Spring (x6)
- Flats (x6)
- Nylocs M5 (x3)
- 3/16 washers (x3)
- 3/4 washers (x3)
- Screws (x20)

TIPS

Bobbins are screwed into the car by hand.
John K

The rubber lip of the trim should 'flare out' from the intake hole, not in.
Grant P

KEEPING THE AIR CLEAN

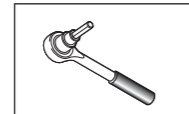


GETTING READY TO PUT THE ENGINE IN

PARTS

- 1 Engine mount
- 2 Starter motor
- 3 Bellhousing

TOOLS



6mm
8mm

FIXINGS

TIPS

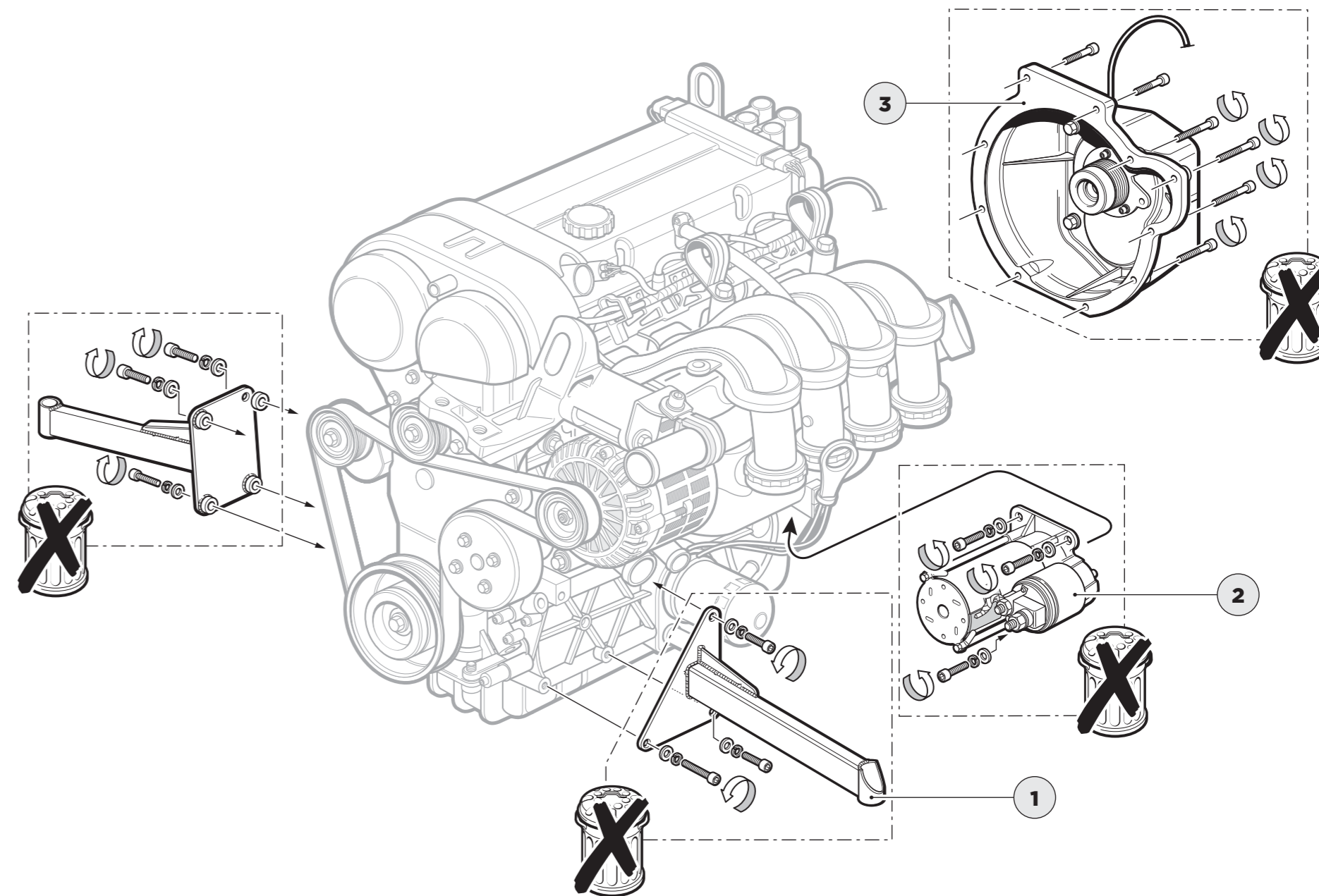
You will need to remove the engine mounts and starter motor but don't throw away the bolts – keep them safe!

Chris N

Remember where the bolts go.

Dan P

GETTING READY TO PUT THE ENGINE IN

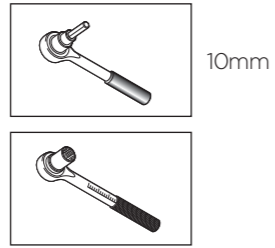


ATTACH THE GEARBOX TO THE BELLHOUSING

PARTS

- 1 Gearbox
- 2 Bell housing

TOOLS



FIXINGS

ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
EA	Engine Mount 2.0L 1.6L 1.8L 2.0L	3821121A	1	All Mount	
EB	Engine Mount 2.0L 1.6L 1.8L 2.0L	3821121A	1	All Mount	
EC	Gearbox Bell Housing 5.0L 5.0L 5.0L 5.0L	3821142A	4	Gearbox	
ED	Engine Mount 2.0L 1.6L 1.8L 2.0L	3821121A	1	All Mount	
EE	Engine Mount 2.0L 1.6L 1.8L 2.0L	3821121A	1	All Mount	
EF	Engine Mount 2.0L 1.6L 1.8L 2.0L	3821121A	1	All Mount	
EG	Engine Mount 2.0L 1.6L 1.8L 2.0L	3821121A	1	All Mount	
EH	Engine Mount 2.0L 1.6L 1.8L 2.0L	3821121A	1	All Mount	
EI	Engine Mount 2.0L 1.6L 1.8L 2.0L	3821121A	1	All Mount	
EJ	Engine Mount 2.0L 1.6L 1.8L 2.0L	3821121A	1	All Mount	
EK	Engine Mount 2.0L 1.6L 1.8L 2.0L	3821121A	1	All Mount	
EL	Engine Mount 2.0L 1.6L 1.8L 2.0L	3821121A	1	All Mount	
EM	Engine Mount 2.0L 1.6L 1.8L 2.0L	3821121A	1	All Mount	

x4

x4

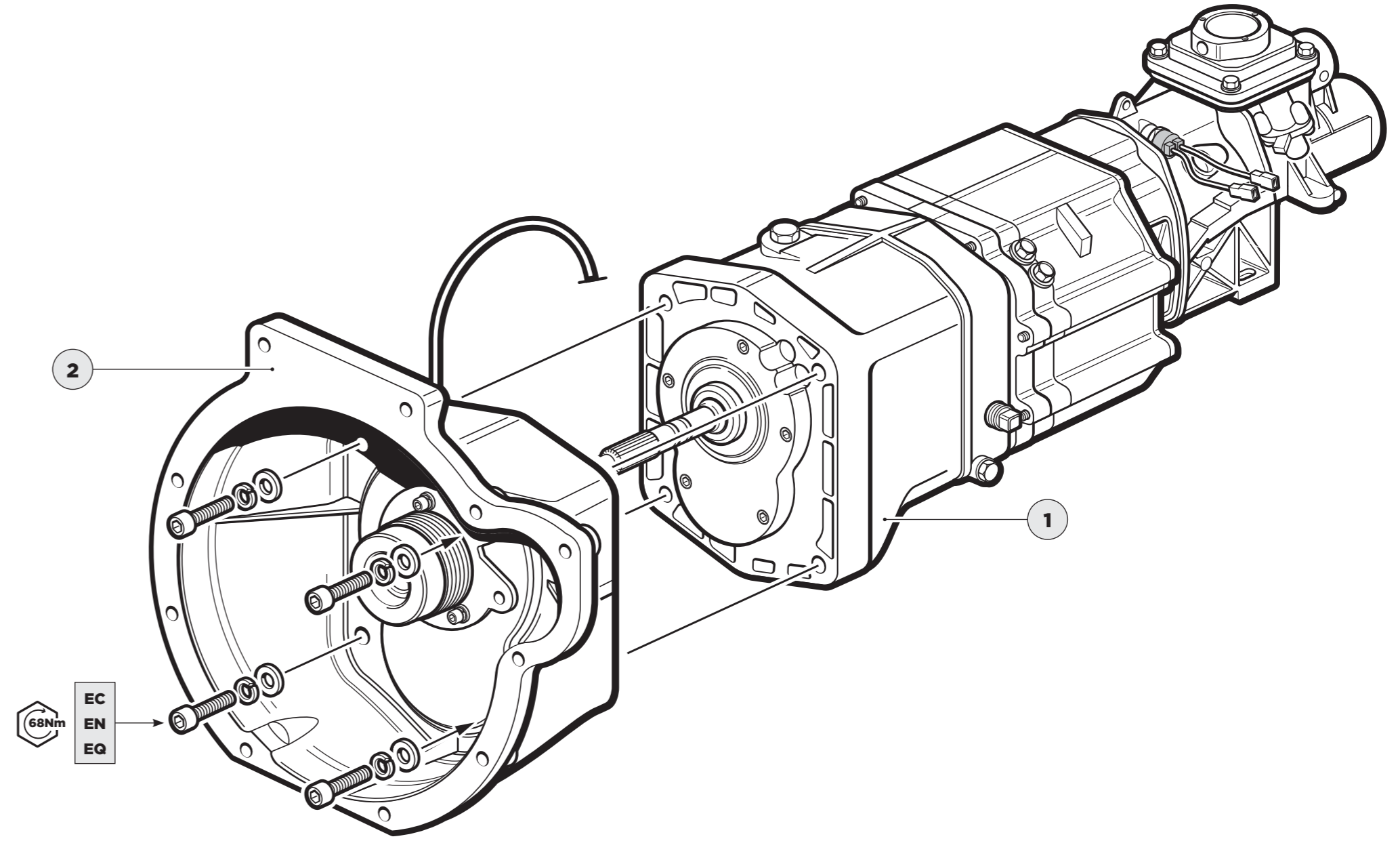
x4

x4

Page 1 of 2

TIPS

ATTACH THE GEARBOX TO THE BELLHOUSING



AND THEN THE GEARBOX TO THE ENGINE

PARTS

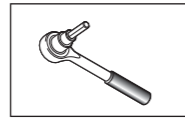
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
EA	Caphead Bolt M10 x 15 Grade 12.9	3E21122A	2	All Mount	
EB	Caphead Bolt M10 x 15 Grade 12.9	3E21122A	4	All Mount	
EC	Caphead Bolt M10 x 15 Grade 12.9	3E21122A	4	Starter	
ED	Caphead Bolt M10 x 15 Grade 12.9	3E21122A	4	1 x Bellhousing 3 x Starter Motor	
EE	Caphead Bolt M10 x 15 Grade 12.9	3E21122A	3	Bellhousing	
EF	Caphead Bolt M10 x 15 Grade 12.9	3E21122A	3	Bellhousing	
EG	Caphead Bolt M10 x 15 Grade 12.9	3E21122A	2	Engine Mount RHS Top	
EH	Caphead Bolt M10 x 15 Grade 12.9	3E21122A	2	Engine Mount LHS Top	
EI	Caphead Bolt M10 x 15 Grade 12.9	3E21122A	1	Engine Mount LHS Bottom	
EJ	Caphead Bolt M10 x 15 Grade 12.9	3E21122A	2	Engine Mount RHS Bottom	
EK	Caphead Bolt M10 x 15 Grade 12.9	3E21122A	3	Clutch Slave Cylinder	

x1
x3
x3

ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
ED	Caphead Bolt M10 x 15 Grade 12.9	3E21122A	4	1 x Bellhousing 3 x Starter Motor	
EE	Caphead Bolt M10 x 15 Grade 12.9	3E21122A	3	Bellhousing	
EF	Caphead Bolt M10 x 15 Grade 12.9	3E21122A	3	Bellhousing	
EG	Caphead Bolt M10 x 15 Grade 12.9	3E21122A	2	Engine Mount RHS Top	
EH	Caphead Bolt M10 x 15 Grade 12.9	3E21122A	2	Engine Mount LHS Top	
EI	Caphead Bolt M10 x 15 Grade 12.9	3E21122A	1	Engine Mount LHS Bottom	
EJ	Caphead Bolt M10 x 15 Grade 12.9	3E21122A	2	Engine Mount RHS Bottom	
EK	Caphead Bolt M10 x 15 Grade 12.9	3E21122A	3	Clutch Slave Cylinder	

x7

TOOLS

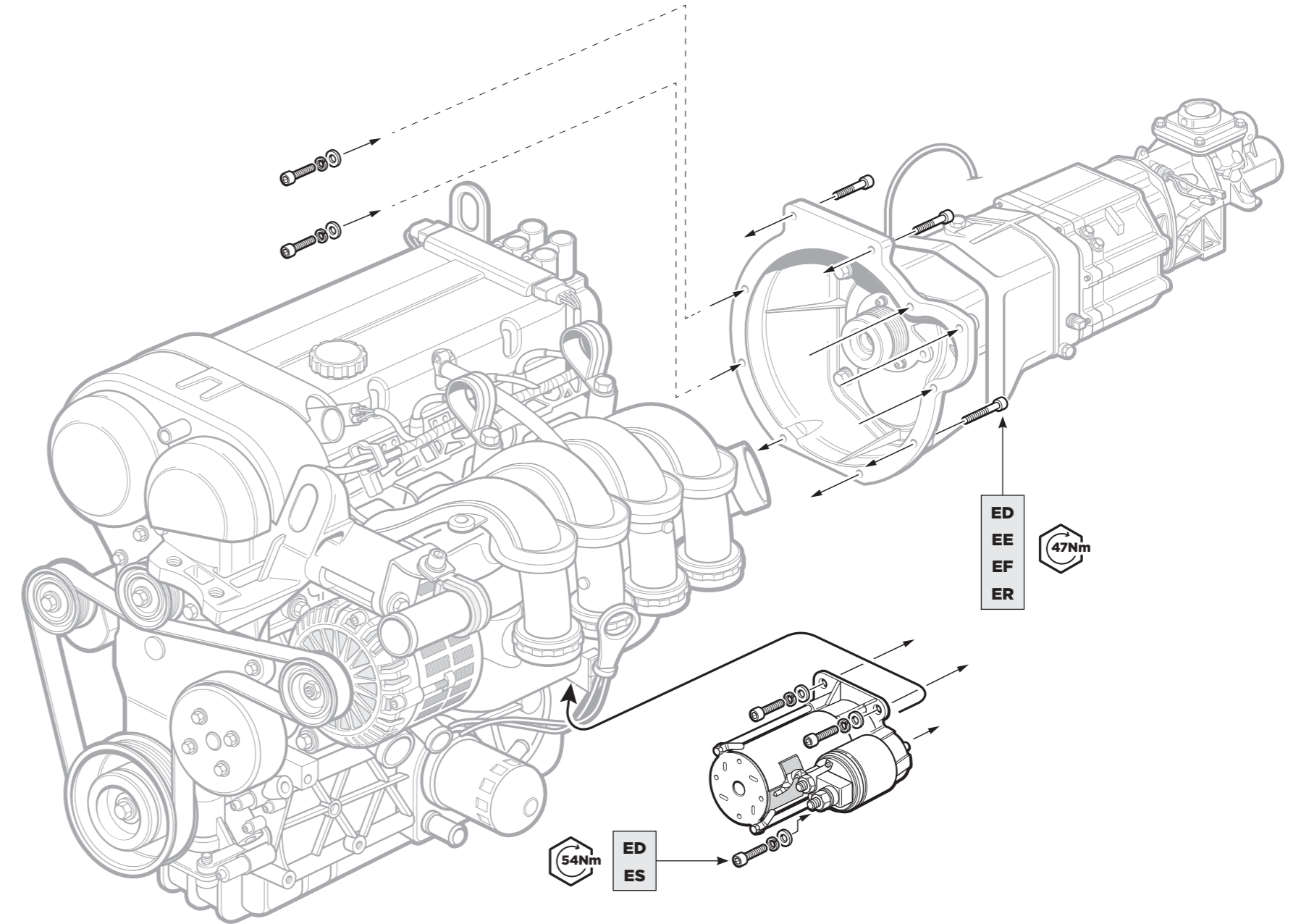


8mm



TIPS

AND THEN THE GEARBOX TO THE ENGINE



AT LAST, THE ENGINE IS GOING IN

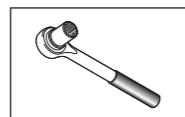
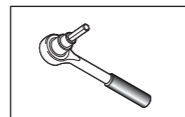
PARTS

- 1 Engine mounts
- 2 Engine rubbers
- 3 Tensioner

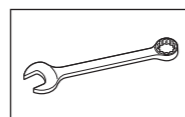
TOOLS



6mm
8mm
3/8"



13mm



13mm
15mm



FIXINGS

Miscellaneous pack

- Bolt 1/2" x 2 1/2" (x1)
- Bolt 1/2" x 1" (x1)
- Bolt M8 x 50 (x1)
- Bolt M8 x 45 (x3)
- Washer M8 (x4)
- Nyloc M8 (x4)

TIPS

When fitting the engine rubbers and mounts, do them as loosely as possible so you can wiggle things to get bolts in. Tighten it all up gradually once all the bolts are in.

Jamie A

Protect the chassis with soft stuff such as cardboard or folded towels/blankets. Just not your fingers.

Tiago O

The shorter 1/2" bolt fits the nearside of the chassis.

Dan P

It will fit – keep at it!

Rich T

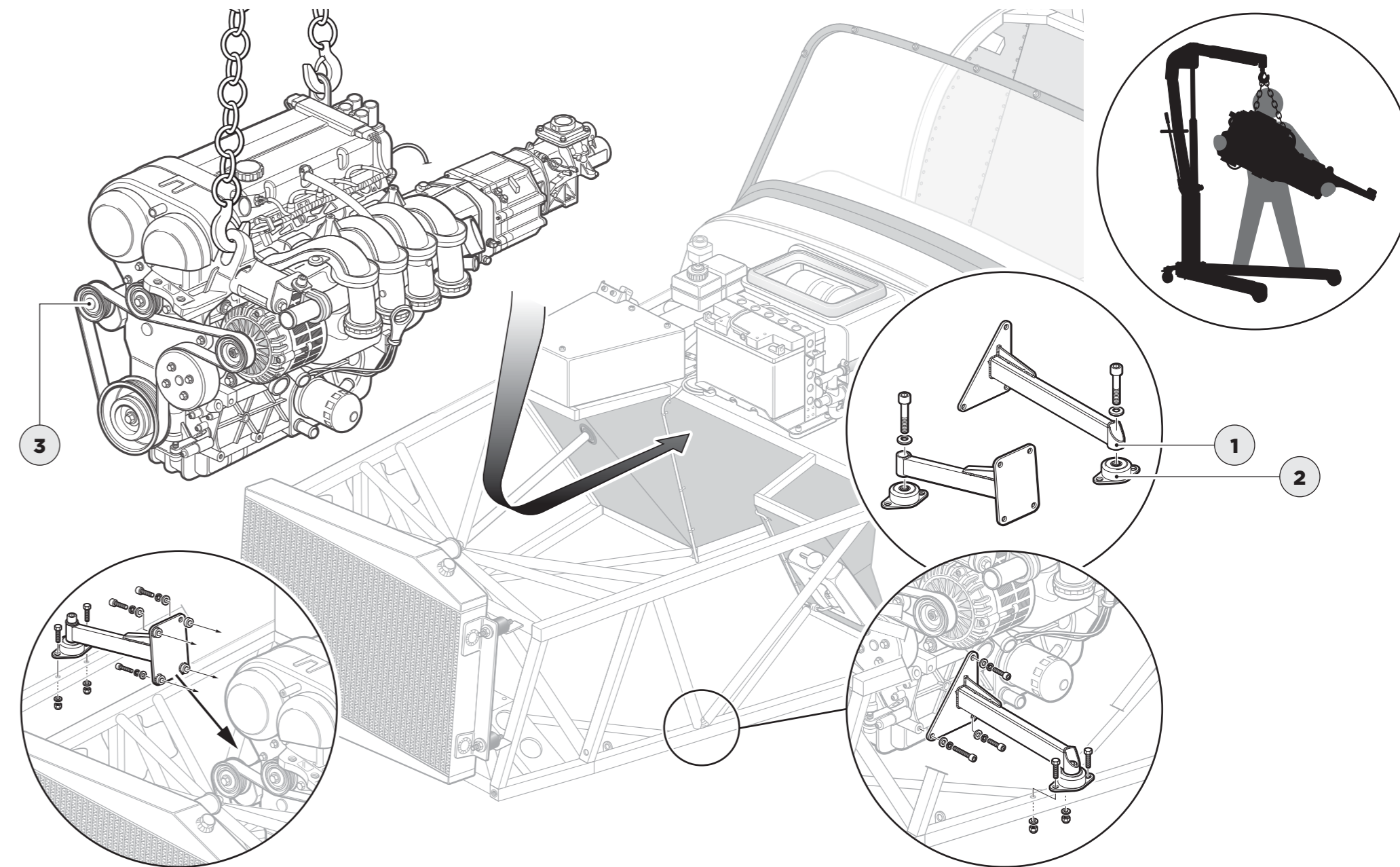
It's 47asNm for the bolts tightened with the 8mm hex socket & 30Nm for the 6mm hex socket.

Grant P

Removing the tensioner will make things much easier.

James A

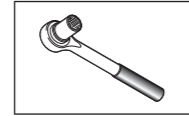
AT LAST, THE ENGINE IS GOING IN



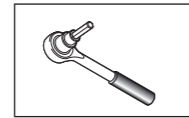
AND THE GEARBOX IS FIXED IN PLACE

PARTS

5 Speed



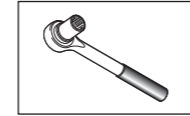
13mm
22mm



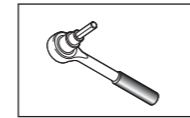
6mm

TOOLS

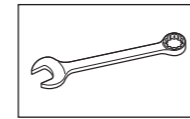
6 Speed



13mm
19mm



6mm



13mm

FIXINGS

Once the engine is in, the wiring can be connected to the car's loom. It should be self explanatory.

Chris B

TIPS

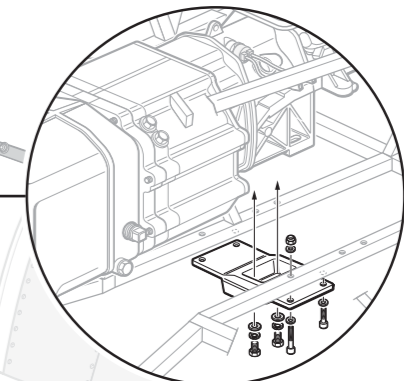
See IVA guide – how to secure a loom.

Grant P

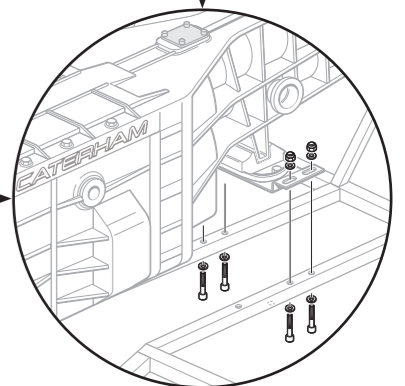
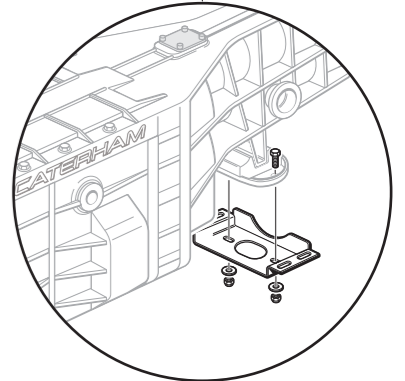
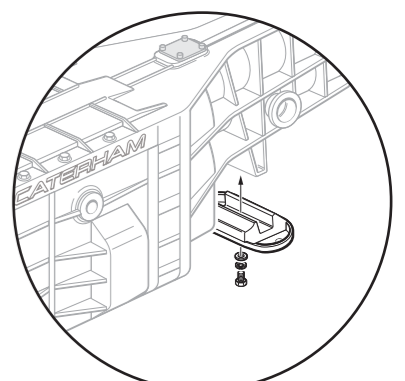
AND THE GEARBOX IS FIXED IN PLACE



5 SPEED



6 SPEED



FILLING THE ENGINE AND GEARBOX WITH OIL

PARTS

Engine oil SW-30

Gear oil GL4

TOOLS

FIXINGS

TIPS

FILLING THE ENGINE AND GEARBOX WITH OIL



Ford 1.6L Engine = 3.8 Litres (Pre-Filled)

5 Speed Gearbox = (Pre-Filled)

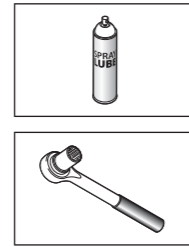
Before Installation. You can double check the oil level by removing the plug on the side. The oil should be to this level.

6 Speed Gearbox = Fill to level of filling point on the side of gearbox

START PLUMBING

PARTS

1 Lower radiator hose



7mm

TOOLS

FIXINGS

Pack D		CATERHAM		44	
		PACK NUMBER		38C047B	
COOLING SIGMA					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Expansion tank	9880002	1	Expansion tank	
2	Expansion tank to bracket	9880003	1	Expansion tank to bracket	
3	Expansion tank to bracket	9880004	1	Expansion tank to bracket	
4	Expansion tank to bracket	9880005	1	Expansion tank to bracket	
5	Expansion tank to bracket	9880006	1	Expansion tank to bracket	
6	Expansion tank to bracket	9880007	1	Expansion tank to bracket	
7	Expansion tank to bracket	9880008	1	Expansion tank to bracket	
8	Expansion tank to bracket	9880009	1	Expansion tank to bracket	
9	Expansion tank to bracket	9880010	1	Expansion tank to bracket	
10	Expansion tank to bracket	9880011	1	Expansion tank to bracket	
11	Expansion tank to bracket	9880012	1	Expansion tank to bracket	

Pack D		CATERHAM		44	
		PACK NUMBER		38C047B	
COOLING SIGMA					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
14	2 x 1/2" shape hose to radiator	98725-05	6	2 x 1/2" shape hose to radiator	
15	2 x 1/2" shape hose to radiator	98725-06	2	2 x 1/2" shape hose to radiator	
16	2 x 1/2" shape hose to radiator	98725-07	18	2 x 1/2" shape hose to radiator	
17	Expansion tank (small) 7.5 liter	98725-08	6	Expansion tank (small) 7.5 liter	
18	Cooling fan	98725-09	12	Cooling fan	

x2

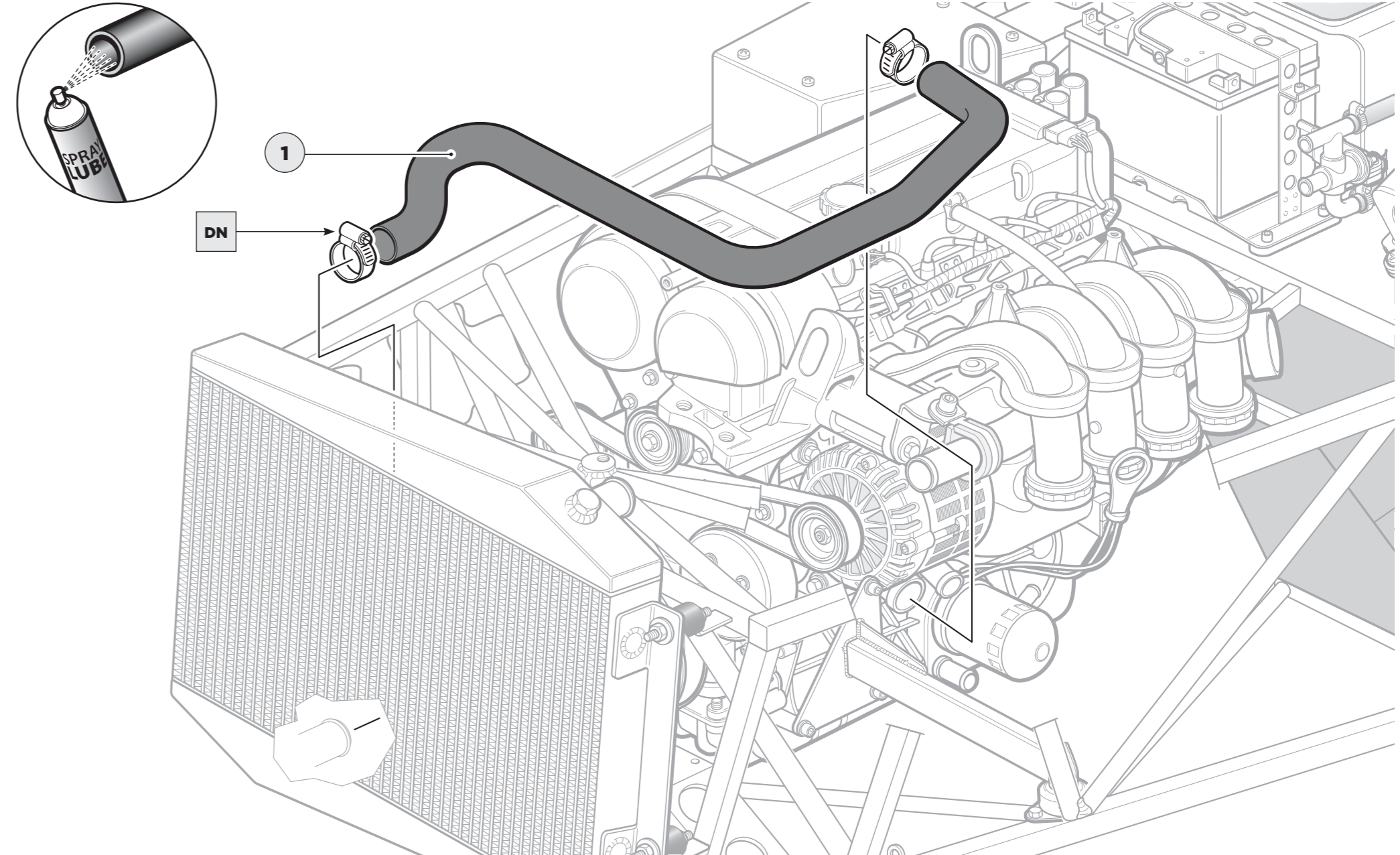
TIPS

Reminder for later on: nip up the clips once the car has been run.
Grant P

Fit the hose to the larger outlet on the engine.
Mick F

Support hose by cable tying to chassis rails – make sure they are clear of the steering rack.
Lee A

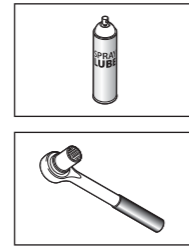
START PLUMBING



AND KEEP PLUMBING

PARTS

1 Upper radiator hose



7mm

TOOLS

FIXINGS

Pack D		CATERHAM		44	
		PACK NUMBER		38C047B	
COOLING SIGMA					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Expansion tank	888002	1	Expansion tank	
2	Expansion tank to bracket	888003	1	Expansion tank to bracket	
3	Expansion tank to bracket	888004	1	Expansion tank to bracket	
4	Expansion tank to bracket	888005	1	Expansion tank to bracket	
5	Expansion tank to bracket	888006	1	Expansion tank to bracket	
6	Expansion tank to bracket	888007	1	Expansion tank to bracket	
7	Expansion tank to bracket	888008	1	Expansion tank to bracket	
8	Expansion tank to bracket	888009	1	Expansion tank to bracket	
9	Expansion tank to bracket	888010	1	Expansion tank to bracket	
10	Expansion tank to bracket	888011	1	Expansion tank to bracket	
11	Expansion tank to bracket	888012	1	Expansion tank to bracket	

Pack D		CATERHAM		44	
		PACK NUMBER		38C047B	
COOLING SIGMA					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Expansion tank	888002	1	Expansion tank	
2	Expansion tank to bracket	888003	1	Expansion tank to bracket	
3	Expansion tank to bracket	888004	1	Expansion tank to bracket	
4	Expansion tank to bracket	888005	1	Expansion tank to bracket	
5	Expansion tank to bracket	888006	1	Expansion tank to bracket	
6	Expansion tank to bracket	888007	1	Expansion tank to bracket	
7	Expansion tank to bracket	888008	1	Expansion tank to bracket	
8	Expansion tank to bracket	888009	1	Expansion tank to bracket	
9	Expansion tank to bracket	888010	1	Expansion tank to bracket	
10	Expansion tank to bracket	888011	1	Expansion tank to bracket	
11	Expansion tank to bracket	888012	1	Expansion tank to bracket	

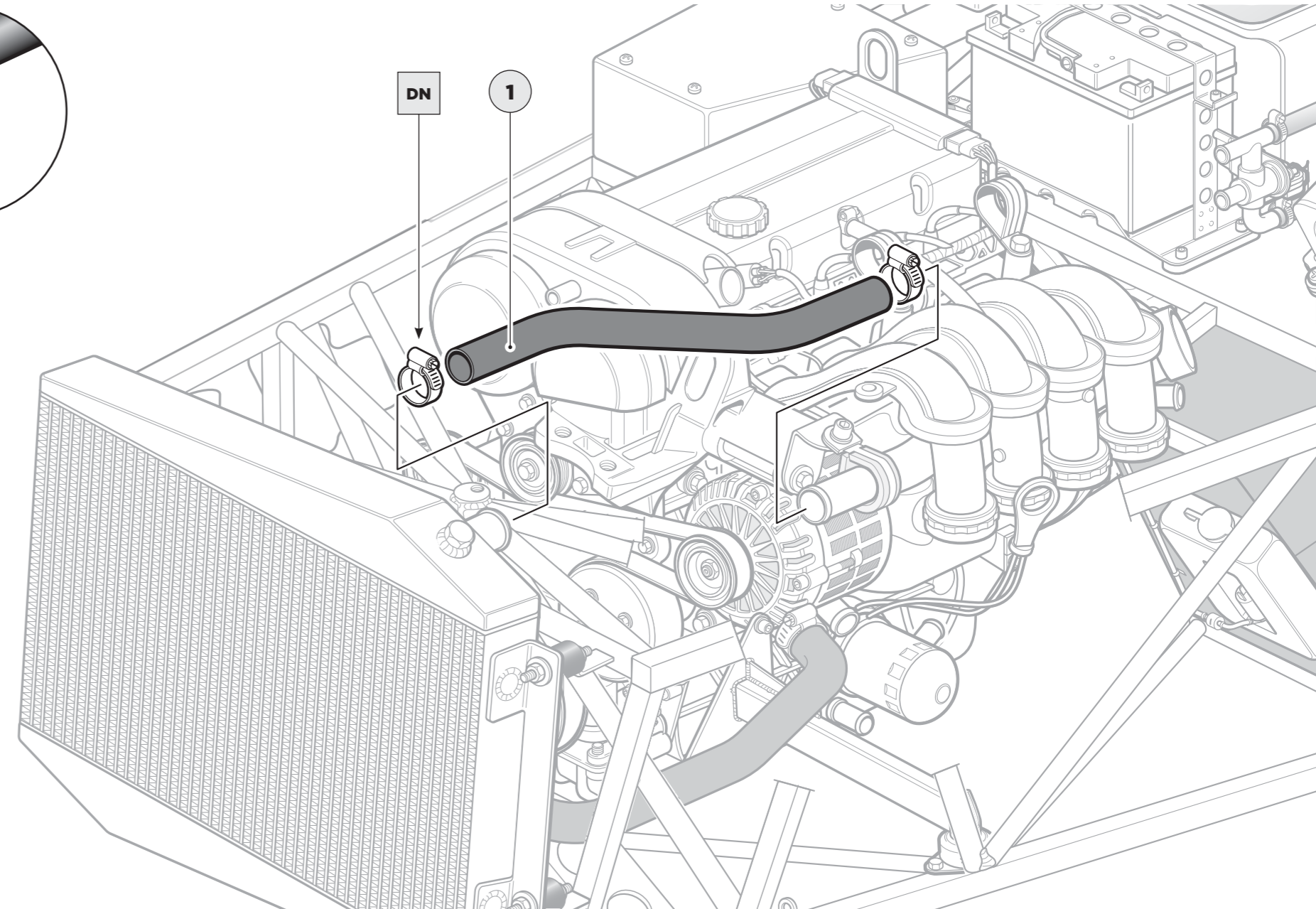
x2

TIPS

Reminder for later on: nip up the clips once the car has been run.

James A

AND KEEP PLUMBING





Now is a good time to take some photos



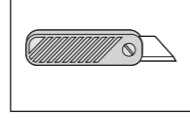
Have you applied for your IVA yet?

A BIT OF SUB-ASSEMBLY - SOME HOSES NEED MODIFYING

PARTS

1 Silicone hoses

TOOLS



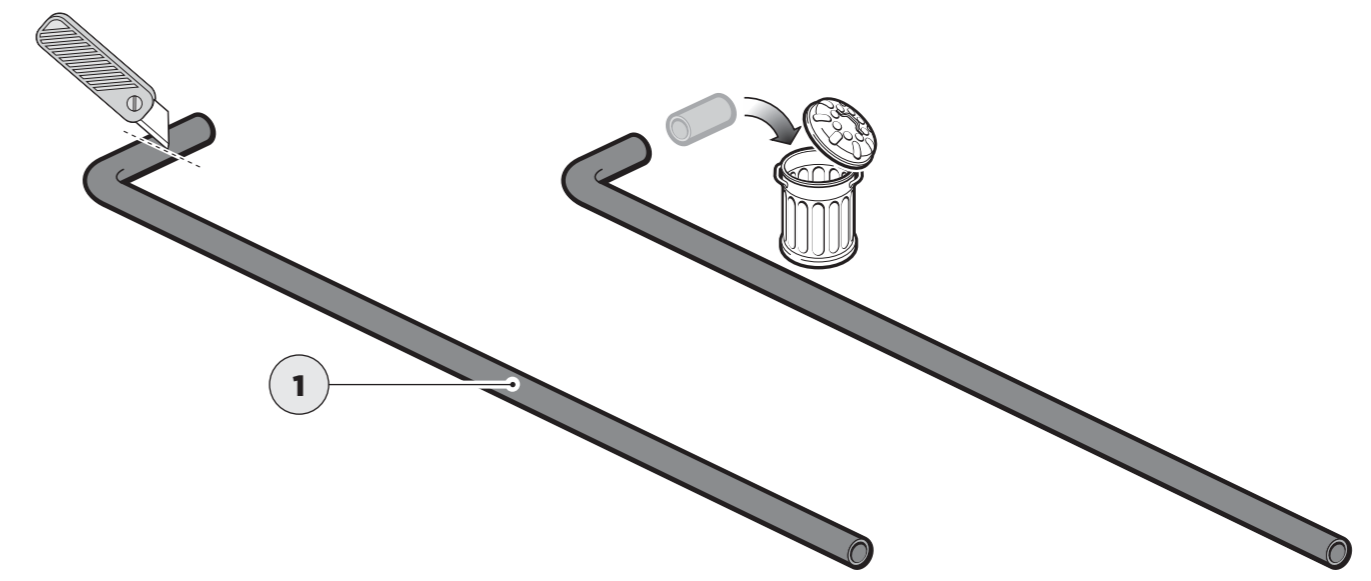
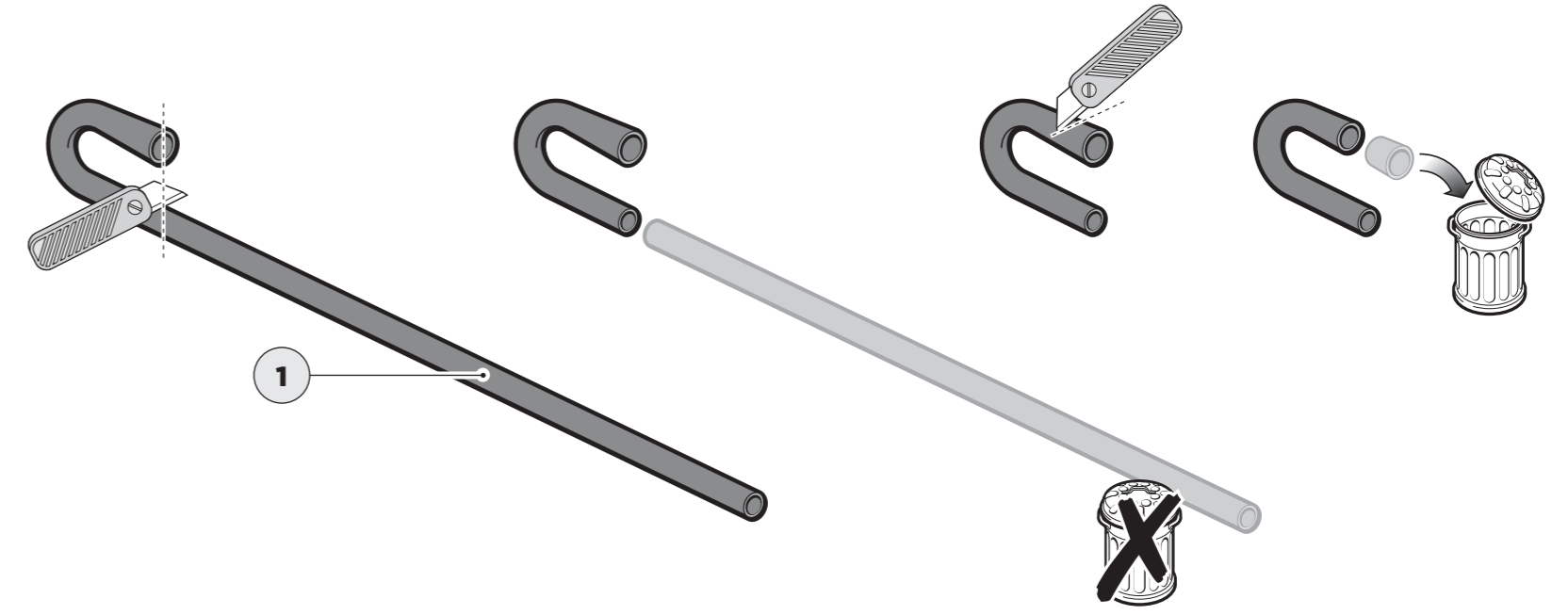
FIXINGS

TIPS

Don't throw away the long piece of hose after cutting.

Rich T

A BIT OF SUB-ASSEMBLY - SOME HOSES NEED MODIFYING

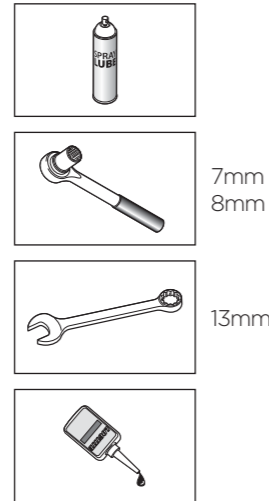


SUB-ASSEMBLY - TEMPERATURE SENSOR

PARTS

- 1** Temperature sender
- 2** Earth tag
- 3** Cooling submarine

TOOLS



7mm
8mm

13mm

FIXINGS

Pack D		CATERHAM		44	
		PACK NUMBER		38C047B	
COOLING SIGMA					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Expansion tank	38C002	1	Expansion tank	
2	Expansion tank to bracket	38C003	1	Expansion tank to bracket	
3	EV radiator bracket	38C004	1	EV radiator bracket	
4	Fan bracket for fan	38C005	1	Fan bracket for fan	
5	Pair of radiator mounting - 20" long	38C006	2	Pair of radiator mounting - 20" long	
6	Pair of radiator and EV radiator bracket	38C007	1	Pair of radiator and EV radiator bracket	
7	Radiator bracket	38C008	1	Radiator bracket	
8	Expansion tank bracket	38C009	1	Expansion tank bracket	
9	Pair of radiator and EV radiator bracket	38C010	1	Pair of radiator and EV radiator bracket	
10	Radiator bracket	38C011	1	Radiator bracket	
11	Radiator bracket	38C012	1	Radiator bracket	

Pack D		CATERHAM		44	
		PACK NUMBER		38C047B	
COOLING SIGMA					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Expansion tank	38C002	1	Expansion tank	
2	Expansion tank to bracket	38C003	1	Expansion tank to bracket	
3	EV radiator bracket	38C004	1	EV radiator bracket	
4	Fan bracket for fan	38C005	1	Fan bracket for fan	
5	Pair of radiator mounting - 20" long	38C006	2	Pair of radiator mounting - 20" long	
6	Pair of radiator and EV radiator bracket	38C007	1	Pair of radiator and EV radiator bracket	
7	Radiator bracket	38C008	1	Radiator bracket	
8	Expansion tank bracket	38C009	1	Expansion tank bracket	
9	Pair of radiator and EV radiator bracket	38C010	1	Pair of radiator and EV radiator bracket	
10	Radiator bracket	38C011	1	Radiator bracket	
11	Radiator bracket	38C012	1	Radiator bracket	

x2

TIPS

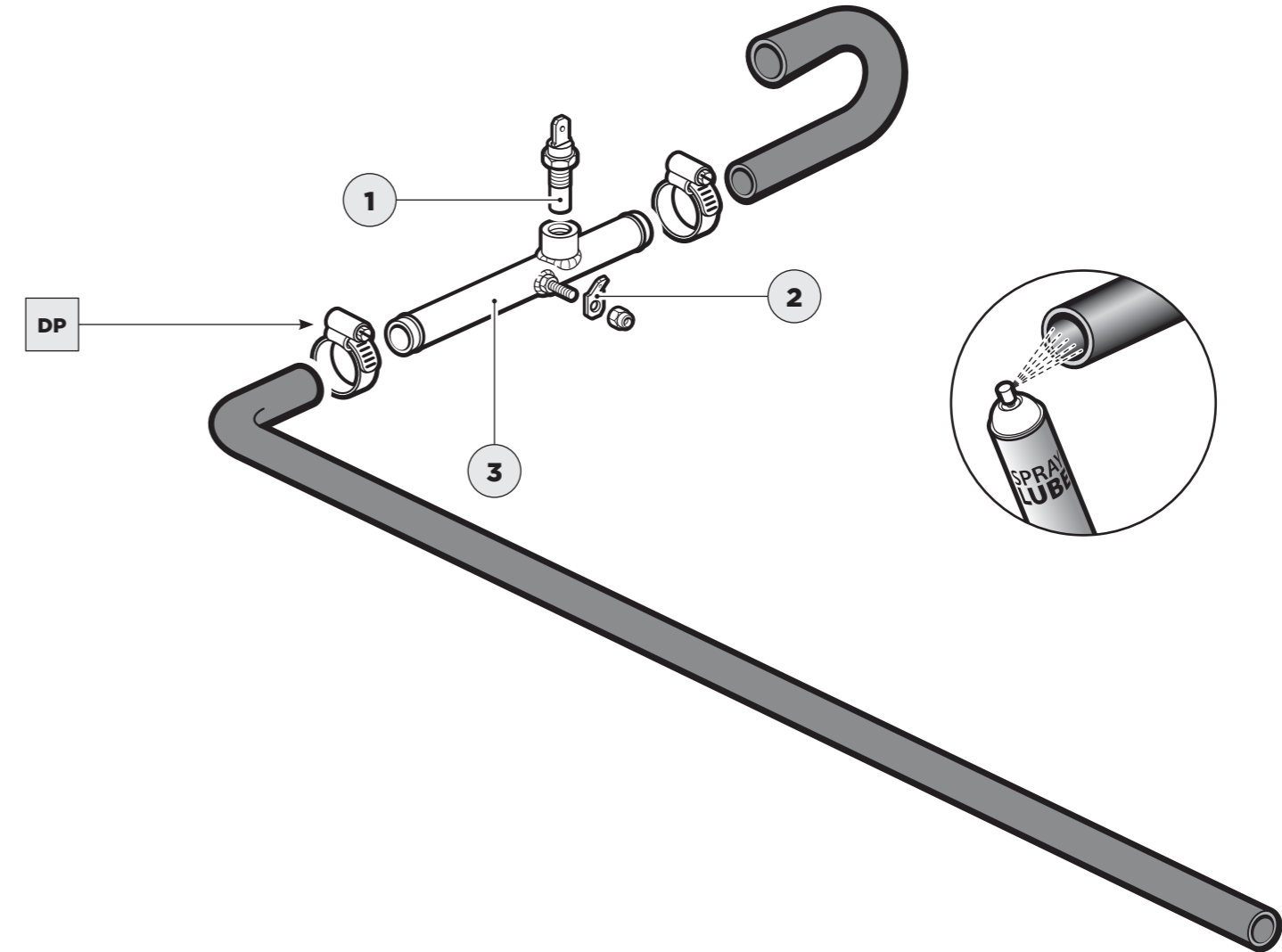
Use a drop of Loctite on the sender.

Tiago O

Be careful not to over-tighten the sender.

Jamie A

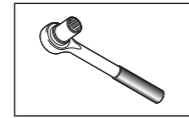
SUB-ASSEMBLY - TEMPERATURE SENSOR



BACK TO THE PLUMBING

PARTS

1 Submarine assembly



7mm

TOOLS

FIXINGS

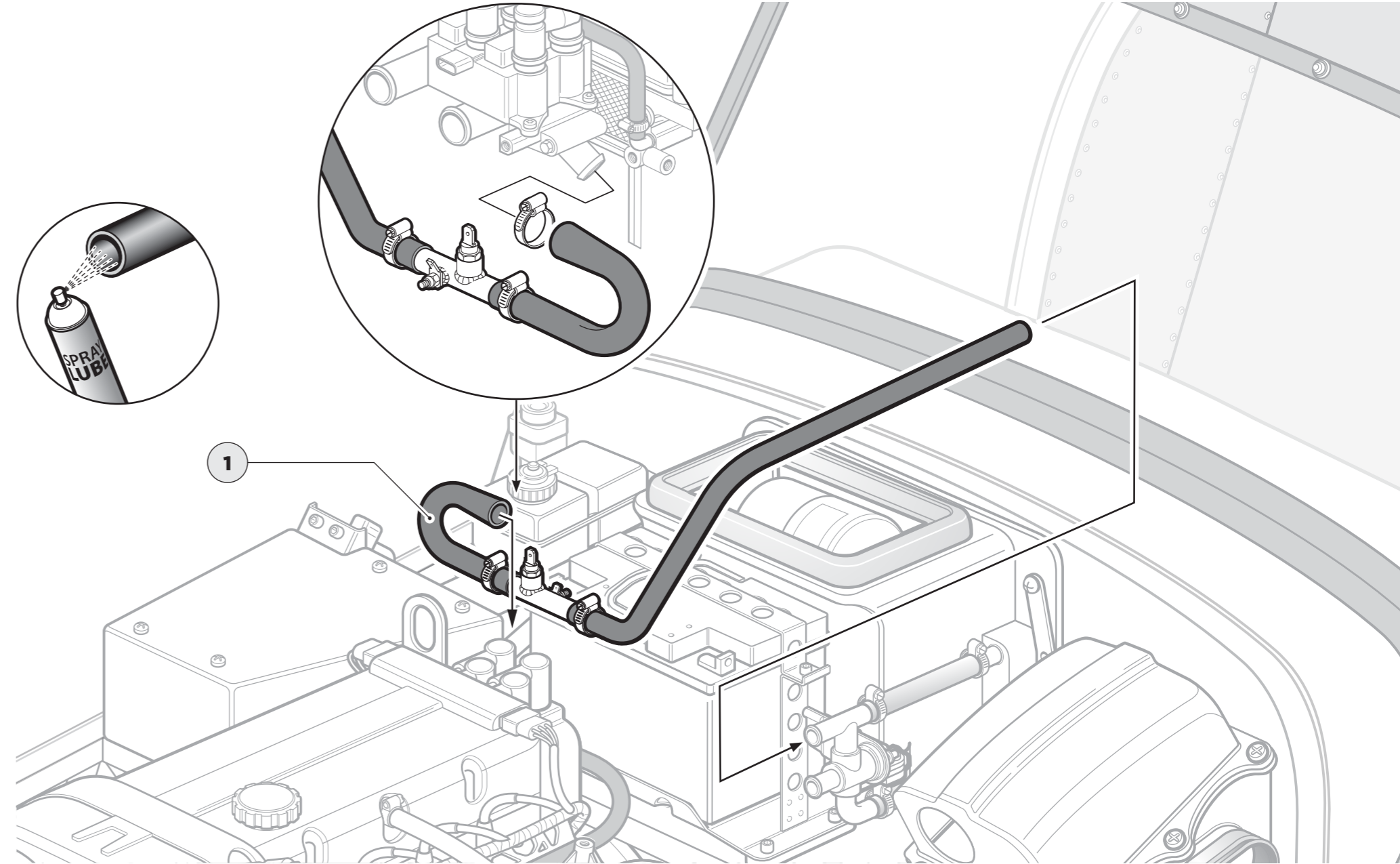
Pack D		CATERHAM		44	
		PACK NUMBER		38C047B	
COOLING SIGMA					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Expansion tank	80120-01	1	Expansion tank	
2	Expansion tank to bracket	80120-02	1	Expansion tank to bracket	
3	Expansion tank to bracket	80120-03	1	Expansion tank to bracket	
4	Expansion tank to bracket	80120-04	1	Expansion tank to bracket	
5	Expansion tank to bracket	80120-05	1	Expansion tank to bracket	
6	Expansion tank to bracket	80120-06	1	Expansion tank to bracket	
7	Expansion tank to bracket	80120-07	1	Expansion tank to bracket	
8	Expansion tank to bracket	80120-08	1	Expansion tank to bracket	
9	Expansion tank to bracket	80120-09	1	Expansion tank to bracket	
10	Expansion tank to bracket	80120-10	1	Expansion tank to bracket	
11	Expansion tank to bracket	80120-11	1	Expansion tank to bracket	

Pack D		CATERHAM		44	
		PACK NUMBER		38C047B	
COOLING SIGMA					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Expansion tank	80120-01	1	Expansion tank	
2	Expansion tank to bracket	80120-02	1	Expansion tank to bracket	
3	Expansion tank to bracket	80120-03	1	Expansion tank to bracket	
4	Expansion tank to bracket	80120-04	1	Expansion tank to bracket	
5	Expansion tank to bracket	80120-05	1	Expansion tank to bracket	
6	Expansion tank to bracket	80120-06	1	Expansion tank to bracket	
7	Expansion tank to bracket	80120-07	1	Expansion tank to bracket	
8	Expansion tank to bracket	80120-08	1	Expansion tank to bracket	
9	Expansion tank to bracket	80120-09	1	Expansion tank to bracket	
10	Expansion tank to bracket	80120-10	1	Expansion tank to bracket	
11	Expansion tank to bracket	80120-11	1	Expansion tank to bracket	

x1

TIPS

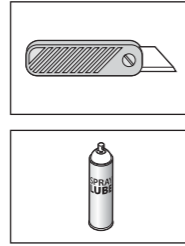
BACK TO THE PLUMBING



MORE PLUMBING

PARTS

TOOLS



FIXINGS

TIPS

Pack D		CATERHAM		44	
		PACK NUMBER		38C047B	
COOLING SIGMA					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Expansion tank	80120-01	1	Expansion tank	
2	Expansion tank to bracket	80120-02	1	Expansion tank to bracket	
3	EV radiator bracket	80120-03	1	EV radiator bracket	
4	Fan bracket for fan	80120-04	1	Fan bracket for fan	
5	Pin for radiator mounting - 20mm	80120-05	2	Pin for radiator mounting - 20mm	
6	Pin for radiator and EV radiator bracket	80120-06	2	Pin for radiator and EV radiator bracket	
7	Radiator bracket	80120-07	1	Radiator bracket	
8	Expansion tank bracket	80120-08	1	Expansion tank bracket	
9	Pin for radiator and EV radiator bracket	80120-09	2	Pin for radiator and EV radiator bracket	
10	Radiator bracket	80120-10	1	Radiator bracket	
11	Radiator bracket	80120-11	1	Radiator bracket	

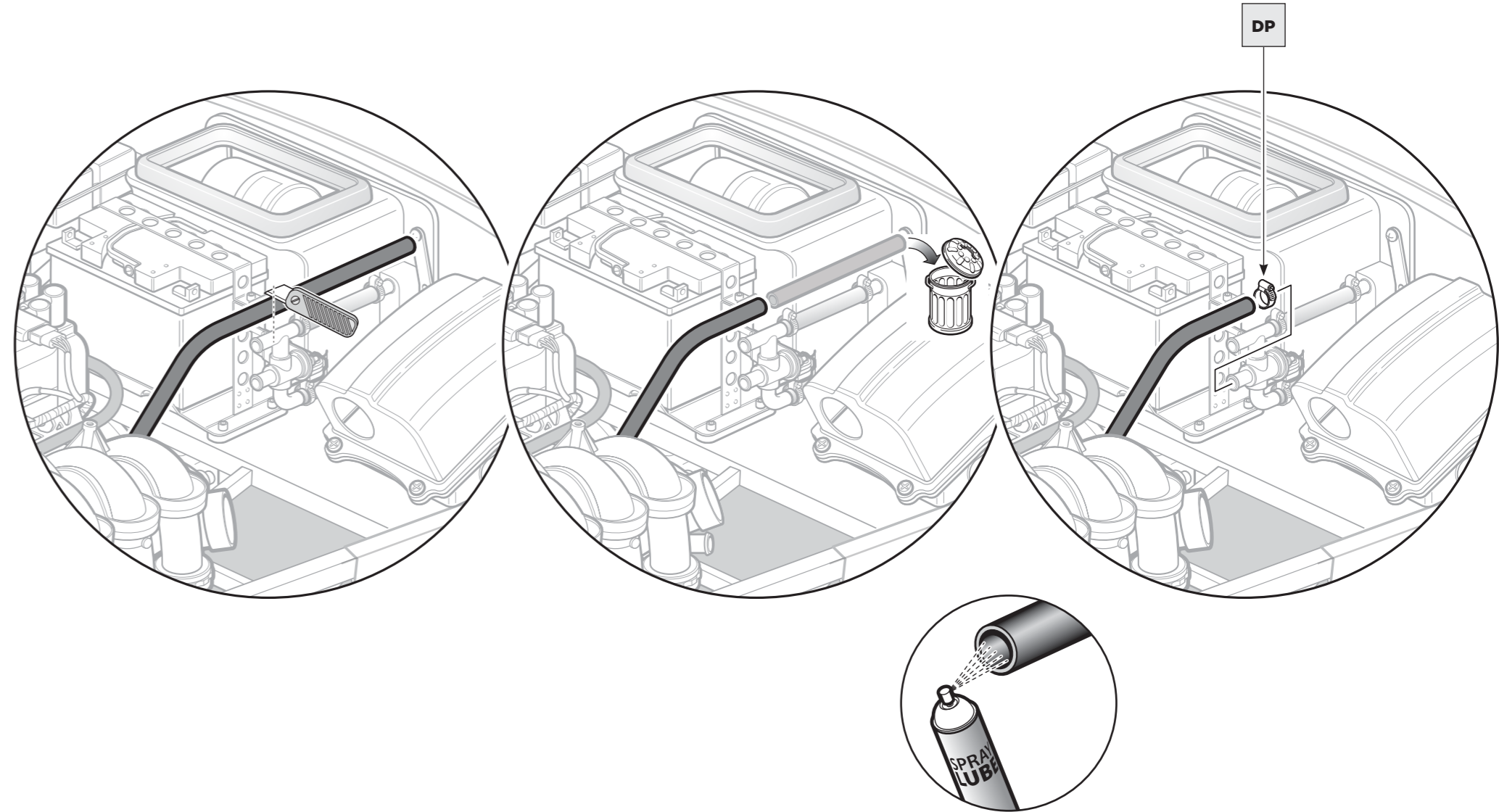
Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

Pack D		CATERHAM		44	
		PACK NUMBER		38C047B	
COOLING SIGMA					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Expansion tank	80120-01	1	Expansion tank	
2	Expansion tank to bracket	80120-02	1	Expansion tank to bracket	
3	EV radiator bracket	80120-03	1	EV radiator bracket	
4	Fan bracket for fan	80120-04	1	Fan bracket for fan	
5	Pin for radiator mounting - 20mm	80120-05	2	Pin for radiator mounting - 20mm	
6	Pin for radiator and EV radiator bracket	80120-06	2	Pin for radiator and EV radiator bracket	
7	Radiator bracket	80120-07	1	Radiator bracket	
8	Expansion tank bracket	80120-08	1	Expansion tank bracket	
9	Pin for radiator and EV radiator bracket	80120-09	2	Pin for radiator and EV radiator bracket	
10	Radiator bracket	80120-10	1	Radiator bracket	
11	Radiator bracket	80120-11	1	Radiator bracket	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

x1

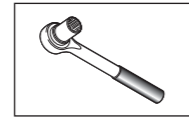
MORE PLUMBING



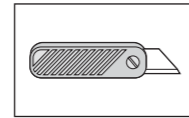
STILL MORE PLUMBING

PARTS

1 U shape hose



7mm



TOOLS

FIXINGS

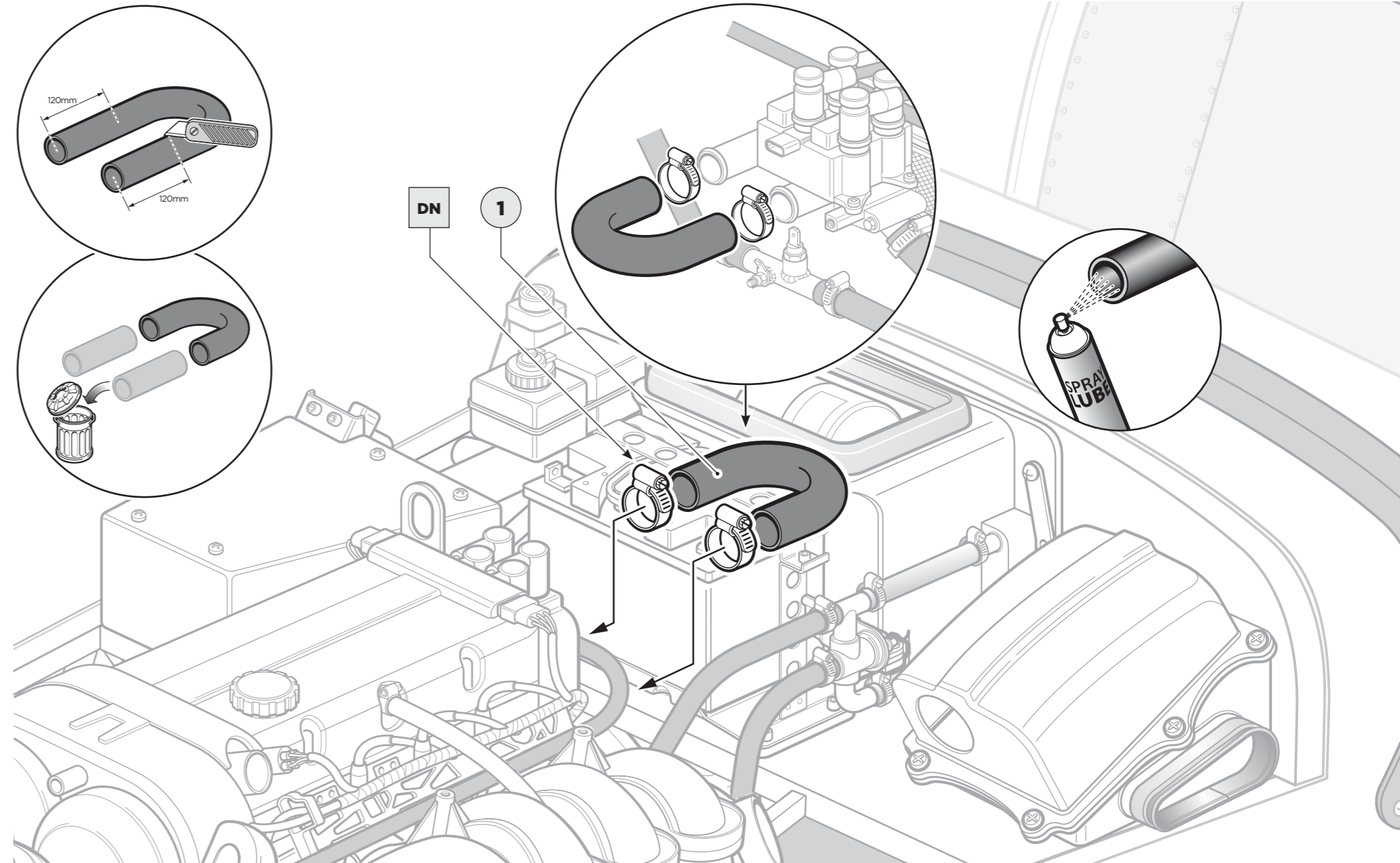
Pack D		CATERHAM		44	
		PACK NUMBER		38C047B	
COOLING SIGMA					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Expansion tank	880000	1	Expansion tank	
2	Expansion tank to bracket	880001	1	Expansion tank to bracket	
3	2x 1/2" shape hose to radiator	880002	2	2x 1/2" shape hose to radiator	
4	2x 1/2" shape hose to top radiator hose	880003	2	2x 1/2" shape hose to top radiator hose	
5	2x 1/2" shape hose to bottom radiator hose	880004	2	2x 1/2" shape hose to bottom radiator hose	
6	2x 1/2" shape hose to expansion tank	880005	2	2x 1/2" shape hose to expansion tank	
7	2x 1/2" shape hose to expansion tank	880006	2	2x 1/2" shape hose to expansion tank	
8	2x 1/2" shape hose to expansion tank	880007	2	2x 1/2" shape hose to expansion tank	
9	2x 1/2" shape hose to expansion tank	880008	2	2x 1/2" shape hose to expansion tank	
10	2x 1/2" shape hose to expansion tank	880009	2	2x 1/2" shape hose to expansion tank	
11	2x 1/2" shape hose to expansion tank	880010	2	2x 1/2" shape hose to expansion tank	

Pack D		CATERHAM		44	
		PACK NUMBER		38C047B	
COOLING SIGMA					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
14	2x 1/2" shape hose to radiator	880011	2	2x 1/2" shape hose to radiator	
15	2x 1/2" shape hose to top radiator hose	880012	2	2x 1/2" shape hose to top radiator hose	
16	2x 1/2" shape hose to bottom radiator hose	880013	2	2x 1/2" shape hose to bottom radiator hose	
17	2x 1/2" shape hose to expansion tank	880014	2	2x 1/2" shape hose to expansion tank	
18	2x 1/2" shape hose to expansion tank	880015	2	2x 1/2" shape hose to expansion tank	
19	2x 1/2" shape hose to expansion tank	880016	2	2x 1/2" shape hose to expansion tank	
20	2x 1/2" shape hose to expansion tank	880017	2	2x 1/2" shape hose to expansion tank	
21	2x 1/2" shape hose to expansion tank	880018	2	2x 1/2" shape hose to expansion tank	
22	2x 1/2" shape hose to expansion tank	880019	2	2x 1/2" shape hose to expansion tank	
23	2x 1/2" shape hose to expansion tank	880020	2	2x 1/2" shape hose to expansion tank	

x2

TIPS

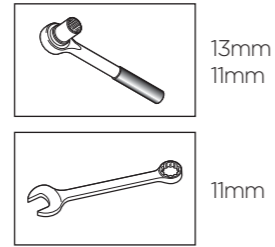
STILL MORE PLUMBING



A BREAK FROM PLUMBING TO FIT THE EXPANSION BOTTLE

PARTS

- 1** Expansion bottle
- 2** Expansion bottle cap
- 3** Expansion bottle bracket



TOOLS

FIXINGS

Pack D		CATERHAM		44	
		PACK NUMBER		38C047B	
COOLING SIGMA					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	DA DA 130 130 x 130	888950	1	Expansion tank bracket to chassis	
2	DB Release 1/4" 1/4" x 1/4"	8F14334	1	Expansion tank to bracket	
3	DL Plain Washer 1/4" x 1/4" Heavy Duty	888950	1	Expansion tank to chassis	
4	DM Spring Washer 1/4" Heavy Duty	888950	1	Expansion tank to chassis	
5	DA DH 1/4" x 1/4" x 1/4"	888950	1	Expansion tank to chassis	
6	DB DH 1/4" x 1/4" x 1/4"	888950	1	Expansion tank to chassis	
7	DL DH 1/4" x 1/4" x 1/4"	888950	1	Expansion tank to chassis	
8	DH DH 1/4" x 1/4" x 1/4"	888950	1	Expansion tank to chassis	
9	DL DH 1/4" x 1/4" x 1/4"	888950	1	Expansion tank to chassis	
10	DL DH 1/4" x 1/4" x 1/4"	888950	1	Expansion tank to chassis	
11	DL DH 1/4" x 1/4" x 1/4"	888950	1	Expansion tank to chassis	

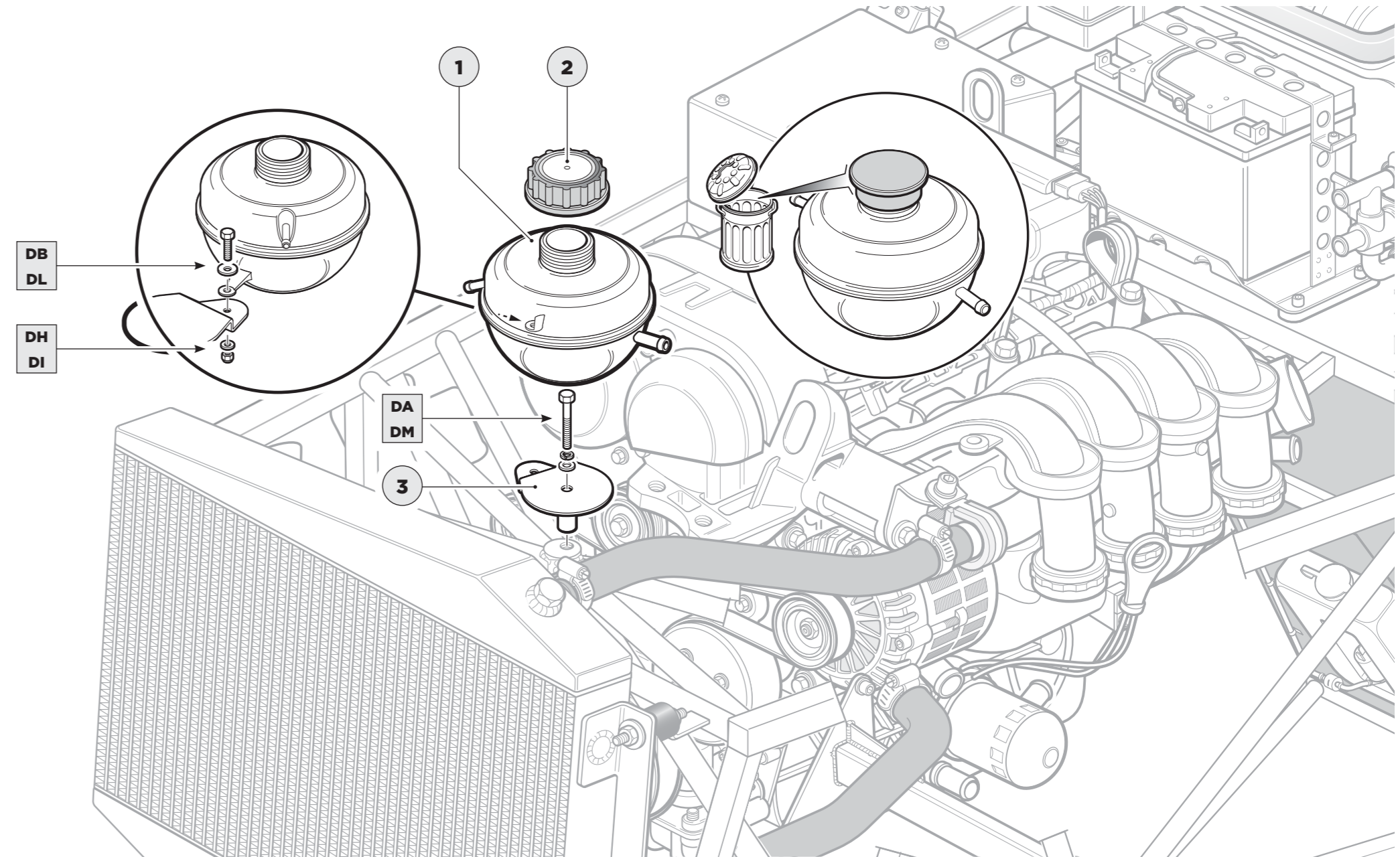
Pack D		CATERHAM		44	
		PACK NUMBER		38C047B	
COOLING SIGMA					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
12	DL Plain Washer 1/4" x 1/4" Heavy Duty	888950	1	Expansion tank to chassis	
13	DM Spring Washer 1/4" Heavy Duty	888950	1	Expansion tank to chassis	
14	DL DH 1/4" x 1/4" x 1/4"	888950	1	Expansion tank to chassis	
15	DL DH 1/4" x 1/4" x 1/4"	888950	1	Expansion tank to chassis	
16	DL DH 1/4" x 1/4" x 1/4"	888950	1	Expansion tank to chassis	
17	DL DH 1/4" x 1/4" x 1/4"	888950	1	Expansion tank to chassis	
18	DL DH 1/4" x 1/4" x 1/4"	888950	1	Expansion tank to chassis	
19	DL DH 1/4" x 1/4" x 1/4"	888950	1	Expansion tank to chassis	
20	DL DH 1/4" x 1/4" x 1/4"	888950	1	Expansion tank to chassis	
21	DL DH 1/4" x 1/4" x 1/4"	888950	1	Expansion tank to chassis	

Throw away the red cap that came on the expansion bottle.

Grant P

TIPS

A BREAK FROM PLUMBING TO FIT THE EXPANSION BOTTLE

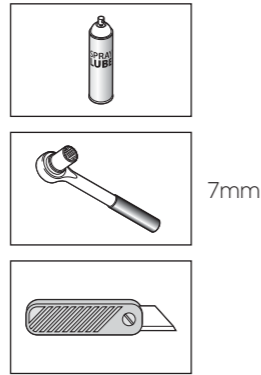


SOME MORE HOSE MODIFICATION

PARTS

1 T-Piece

TOOLS



7mm

FIXINGS

Pack D		CATERHAM		44	
		PACK NUMBER		38C047B	
COOLING SIGMA					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Expansion tank	3800002	1	Expansion tank	
2	Expansion tank to bracket	3800003	1	Expansion tank to bracket	
3	Expansion tank to bracket	3800004	1	Expansion tank to bracket	
4	Expansion tank to bracket	3800005	1	Expansion tank to bracket	
5	Expansion tank to bracket	3800006	1	Expansion tank to bracket	
6	Expansion tank to bracket	3800007	1	Expansion tank to bracket	
7	Expansion tank to bracket	3800008	1	Expansion tank to bracket	
8	Expansion tank to bracket	3800009	1	Expansion tank to bracket	
9	Expansion tank to bracket	3800010	1	Expansion tank to bracket	
10	Expansion tank to bracket	3800011	1	Expansion tank to bracket	
11	Expansion tank to bracket	3800012	1	Expansion tank to bracket	

Pack D		CATERHAM		44	
		PACK NUMBER		38C047B	
COOLING SIGMA					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Expansion tank	3800002	1	Expansion tank	
2	Expansion tank to bracket	3800003	1	Expansion tank to bracket	
3	Expansion tank to bracket	3800004	1	Expansion tank to bracket	
4	Expansion tank to bracket	3800005	1	Expansion tank to bracket	
5	Expansion tank to bracket	3800006	1	Expansion tank to bracket	
6	Expansion tank to bracket	3800007	1	Expansion tank to bracket	
7	Expansion tank to bracket	3800008	1	Expansion tank to bracket	
8	Expansion tank to bracket	3800009	1	Expansion tank to bracket	
9	Expansion tank to bracket	3800010	1	Expansion tank to bracket	
10	Expansion tank to bracket	3800011	1	Expansion tank to bracket	
11	Expansion tank to bracket	3800012	1	Expansion tank to bracket	

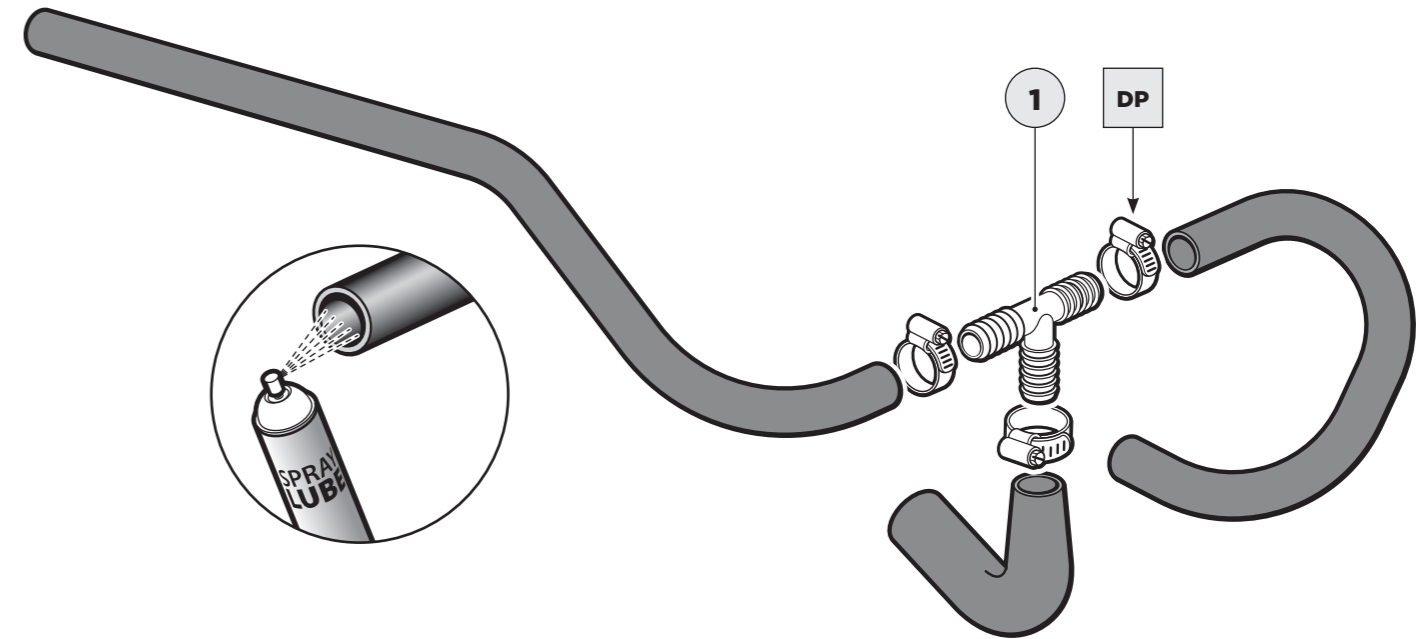
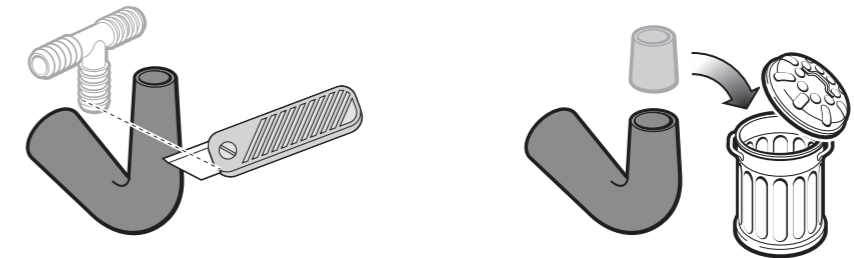
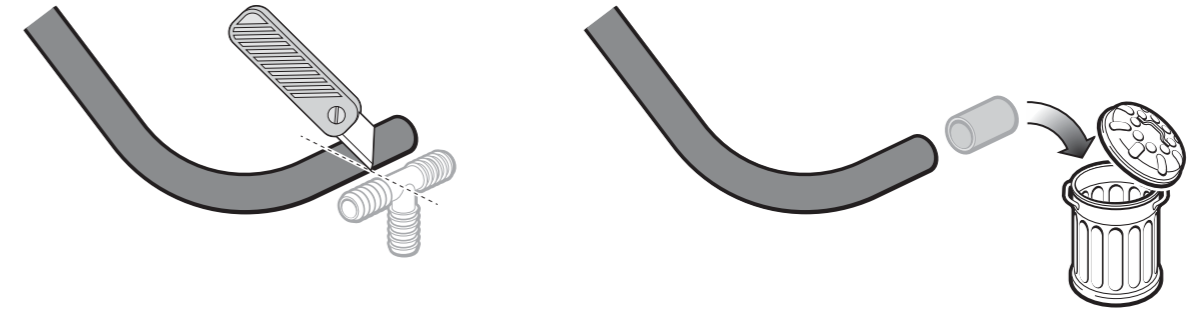
The short 'L' shaped hose is pre-formed.

John S

TIPS

x3

SOME MORE HOSE MODIFICATION

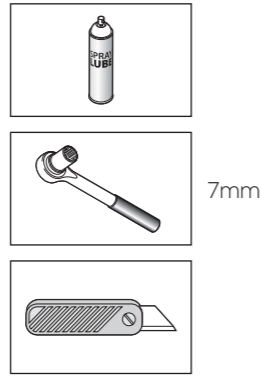


AND BACK TO PLUMBING

PARTS

1 T-Piece assembly

TOOLS



7mm

FIXINGS

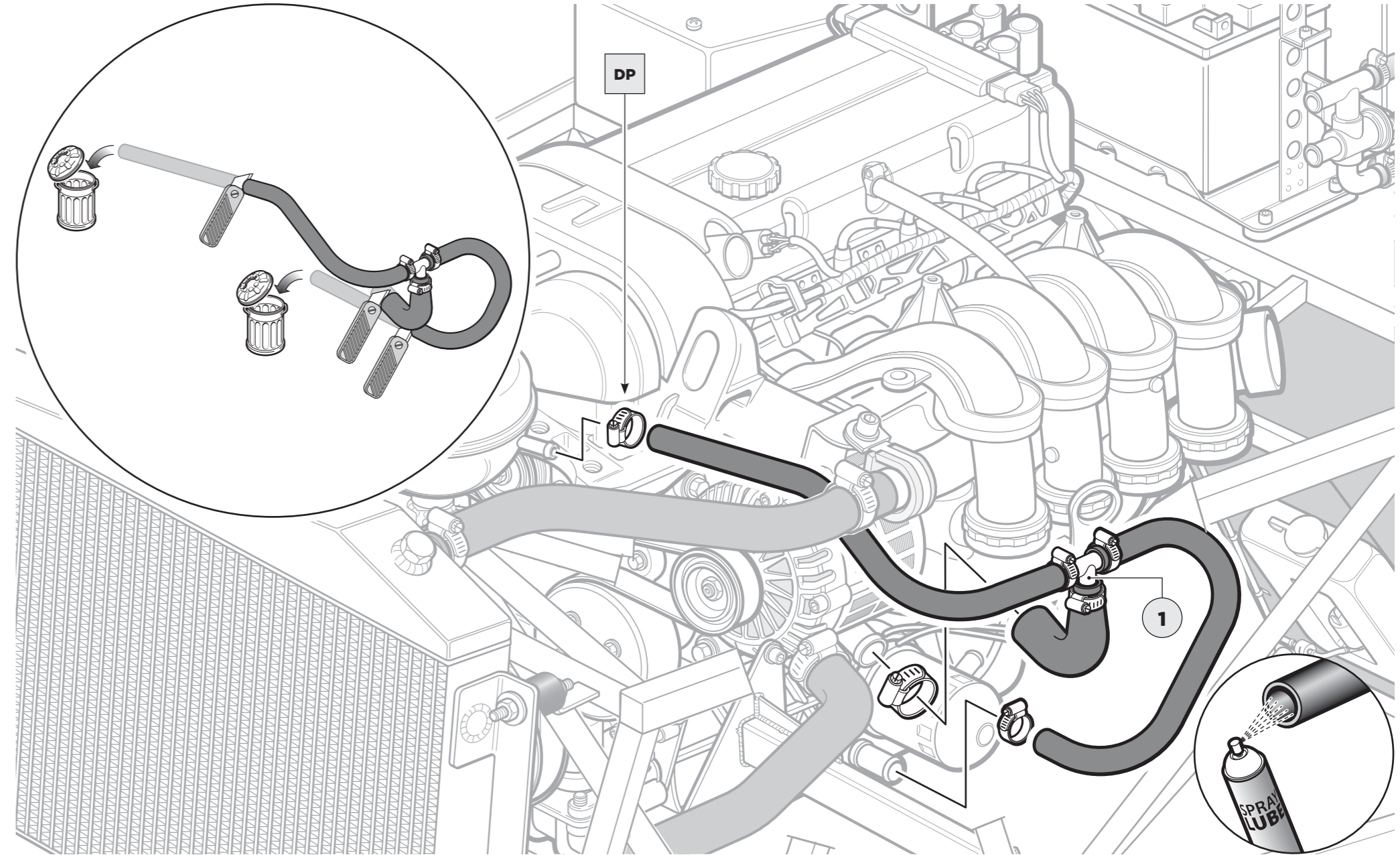
Pack D		CATERHAM		44	
		PACK NUMBER		38C047B	
COOLING SIGMA					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Expansion tank	38C047B	1	Expansion tank	
2	Expansion tank to bracket	38C047B	1	Expansion tank to bracket	
3	Expansion tank to bracket	38C047B	1	Expansion tank to bracket	
4	Expansion tank to bracket	38C047B	1	Expansion tank to bracket	
5	Expansion tank to bracket	38C047B	1	Expansion tank to bracket	
6	Expansion tank to bracket	38C047B	1	Expansion tank to bracket	
7	Expansion tank to bracket	38C047B	1	Expansion tank to bracket	
8	Expansion tank to bracket	38C047B	1	Expansion tank to bracket	
9	Expansion tank to bracket	38C047B	1	Expansion tank to bracket	
10	Expansion tank to bracket	38C047B	1	Expansion tank to bracket	
11	Expansion tank to bracket	38C047B	1	Expansion tank to bracket	

Pack D		CATERHAM		44	
		PACK NUMBER		38C047B	
COOLING SIGMA					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Expansion tank	38C047B	1	Expansion tank	
2	Expansion tank to bracket	38C047B	1	Expansion tank to bracket	
3	Expansion tank to bracket	38C047B	1	Expansion tank to bracket	
4	Expansion tank to bracket	38C047B	1	Expansion tank to bracket	
5	Expansion tank to bracket	38C047B	1	Expansion tank to bracket	
6	Expansion tank to bracket	38C047B	1	Expansion tank to bracket	
7	Expansion tank to bracket	38C047B	1	Expansion tank to bracket	
8	Expansion tank to bracket	38C047B	1	Expansion tank to bracket	
9	Expansion tank to bracket	38C047B	1	Expansion tank to bracket	
10	Expansion tank to bracket	38C047B	1	Expansion tank to bracket	
11	Expansion tank to bracket	38C047B	1	Expansion tank to bracket	

x1

TIPS

AND BACK TO PLUMBING



CONNECTING THE FUEL LINE

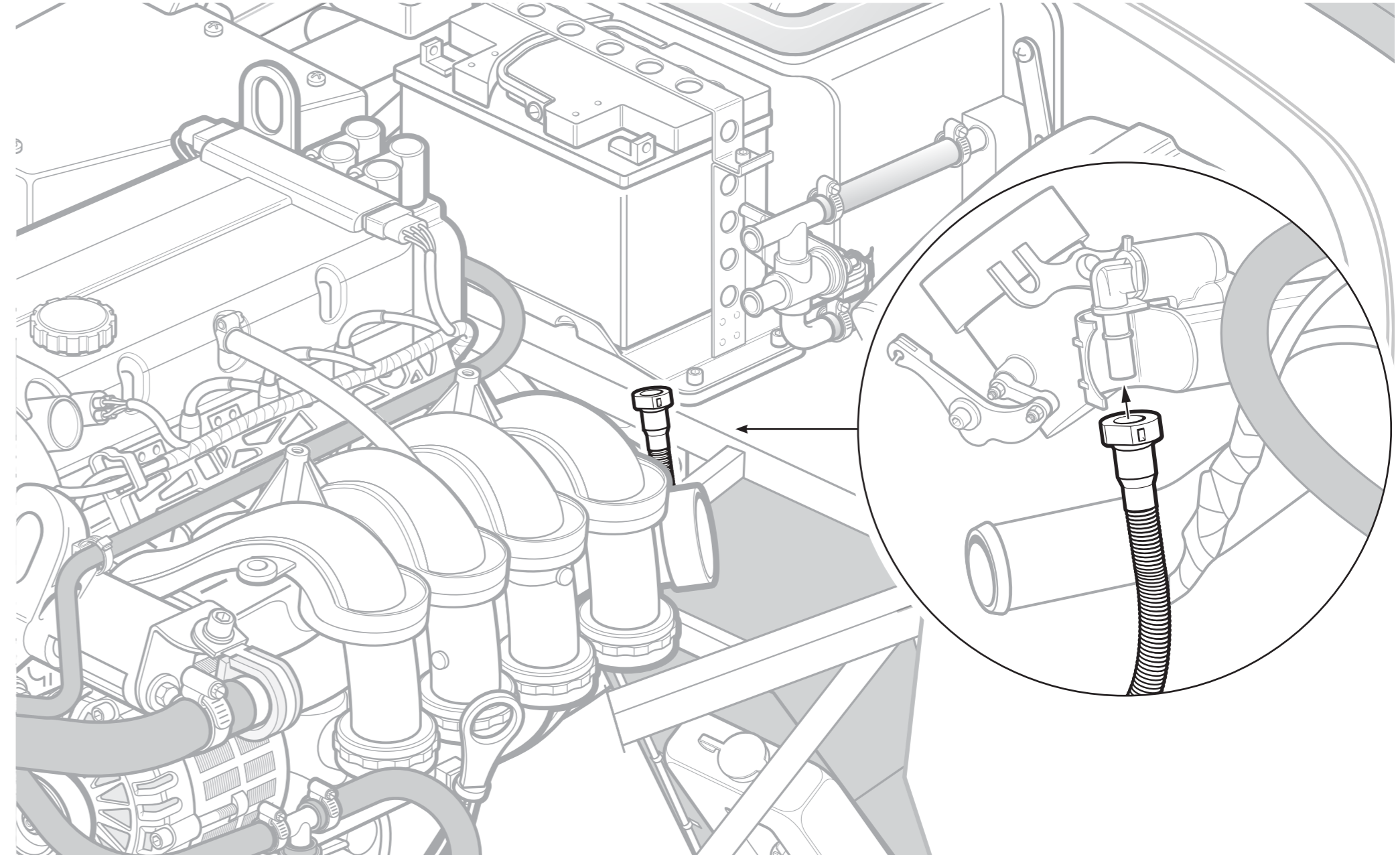
PARTS

TOOLS

FIXINGS

TIPS

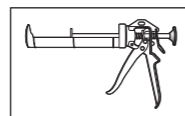
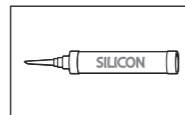
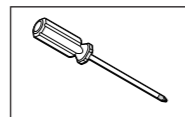
CONNECTING THE FUEL LINE



FIT THROTTLE CABLE

PARTS

1 Throttle cable



TOOLS

FIXINGS

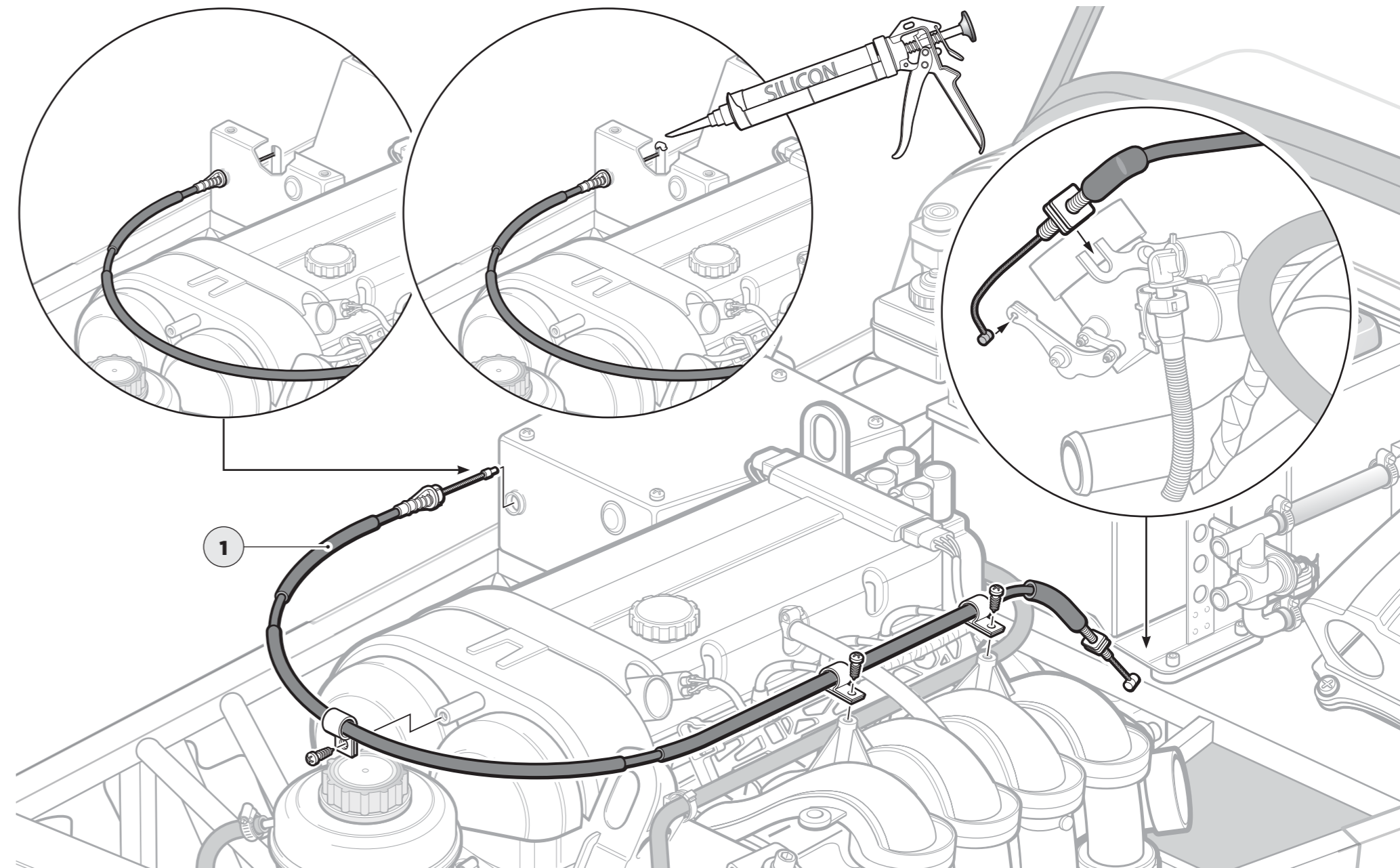
Fixings are supplied loosely attached to the engine in place

TIPS

The silicone goes in the top of the pedal to prevent the cable coming out.
Rich T

Max throttle pedal travel may need adjusting in the pedalbox.
Jamie A

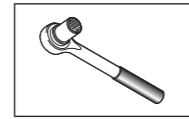
FIT THROTTLE CABLE



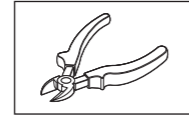
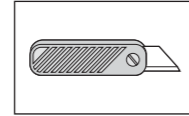
PROTECTING & ATTACHING THE CLUTCH HOSE

PARTS

1 8mm water hose



14mm



FIXINGS

Nip up the banjo bolt.

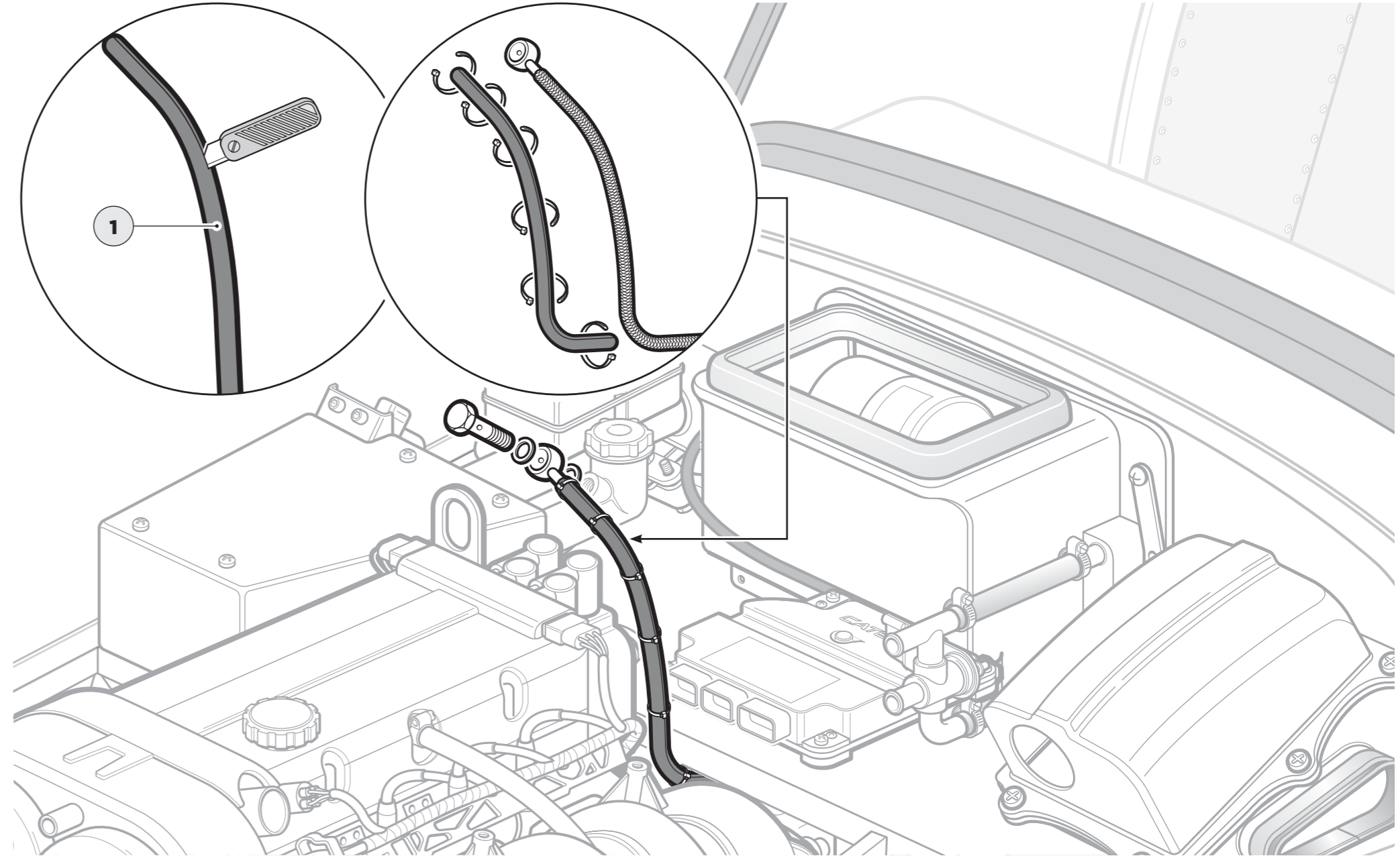
John K

TIPS

The hose is used to stop chaffing.

James A

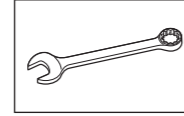
PROTECTING & ATTACHING THE CLUTCH HOSE



CONNECTING THE BATTERY (POSITIVE / RED FIRST)

PARTS

TOOLS



10mm (x2)

FIXINGS

TIPS

Always connect live side of battery first (red wire).

Chris B

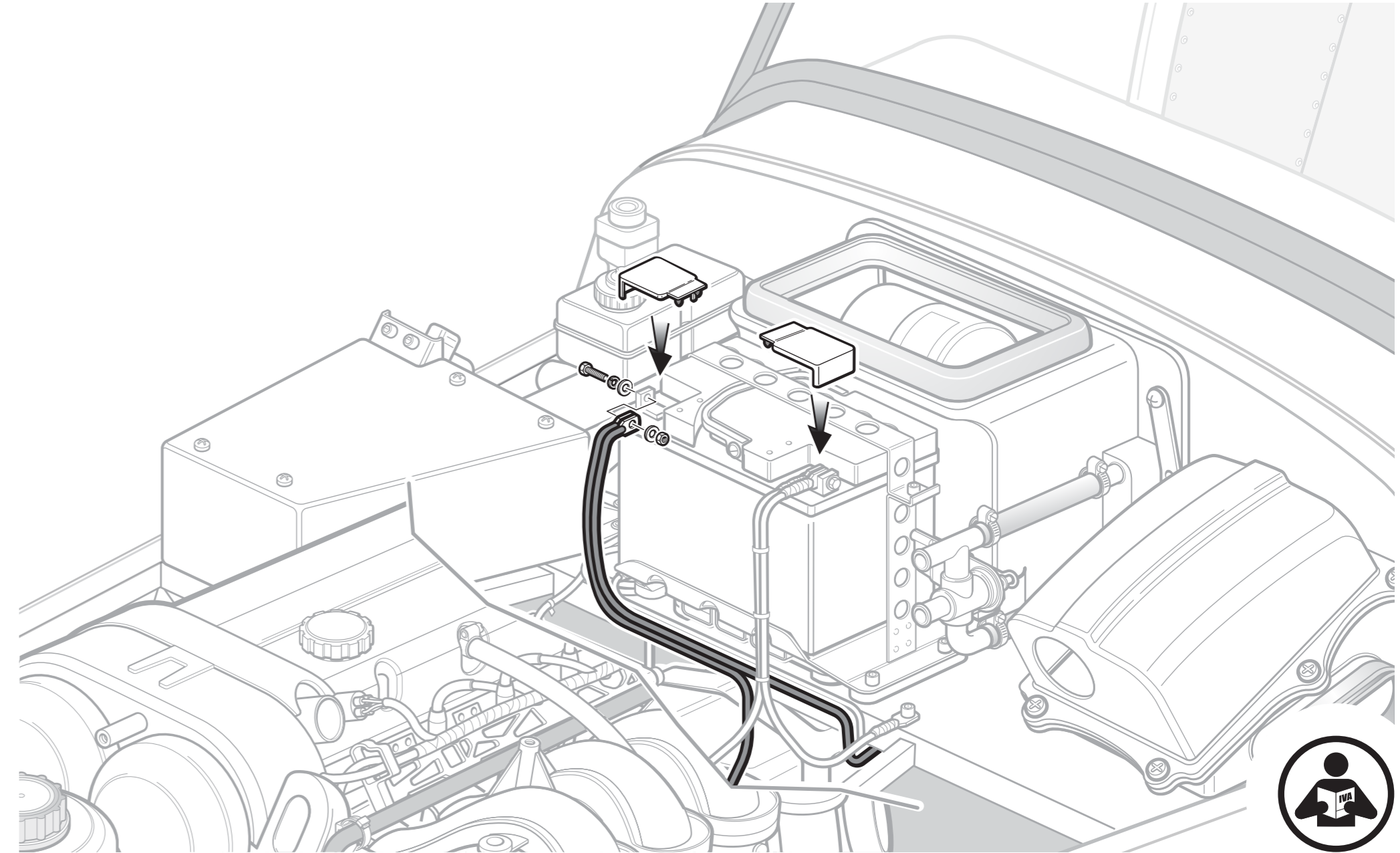
Make the battery the last thing you connect.

Jamie A

Be careful to ensure that the red leads go to the + side and the black wires to the - side.

Dan D

CONNECTING THE BATTERY (POSITIVE / RED FIRST)



PARTS

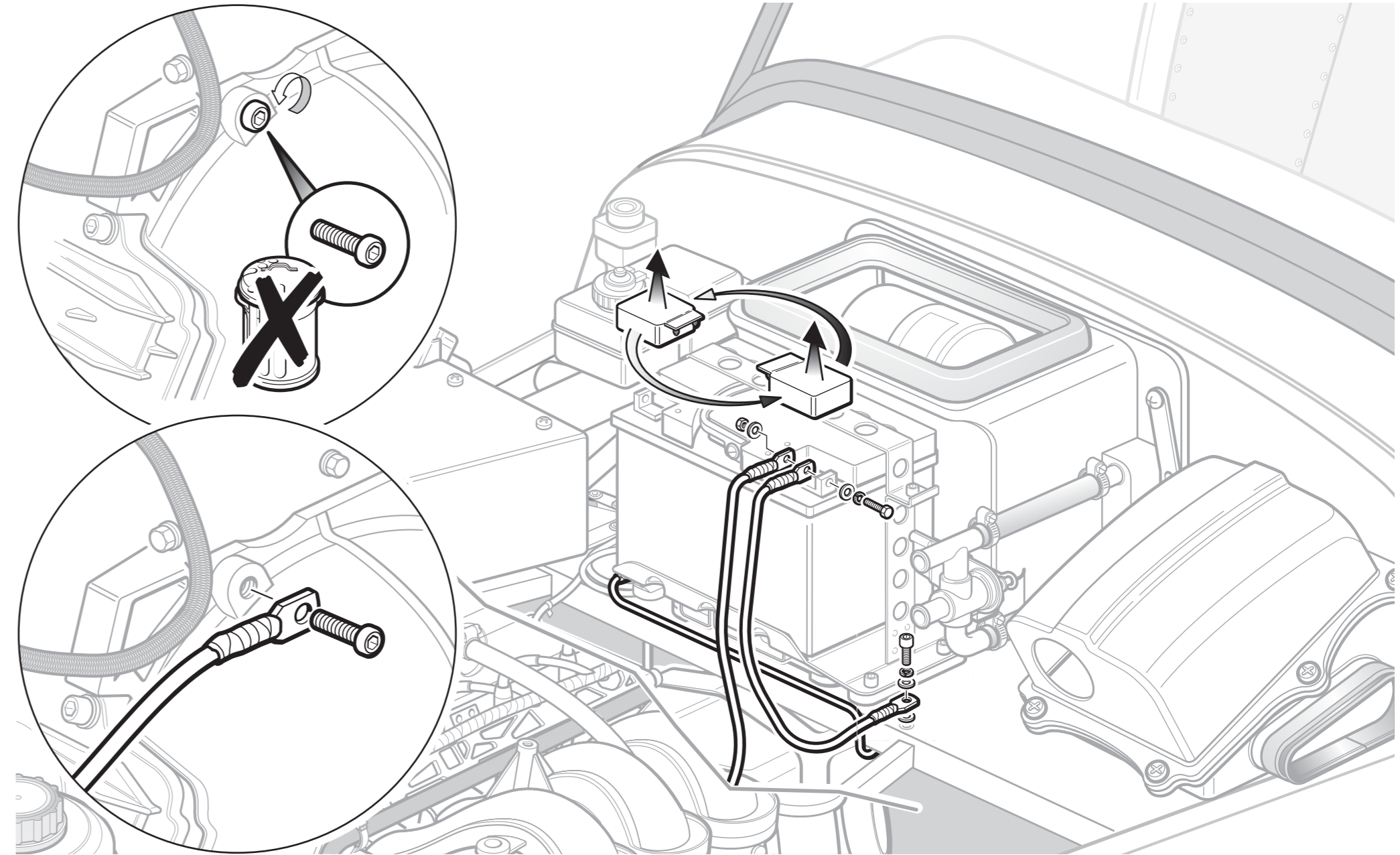
TOOLS

FIXINGS

TIPS

Add a plain M8 or 5/16 washer underneath the earth lead to chassis.

Dan P

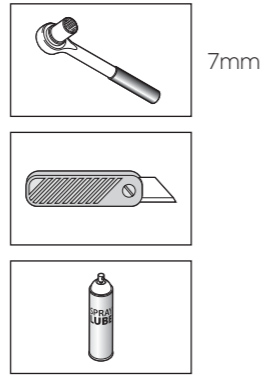


ONE LAST BIT OF PLUMBING...

PARTS

1 Hose

TOOLS



7mm

FIXINGS

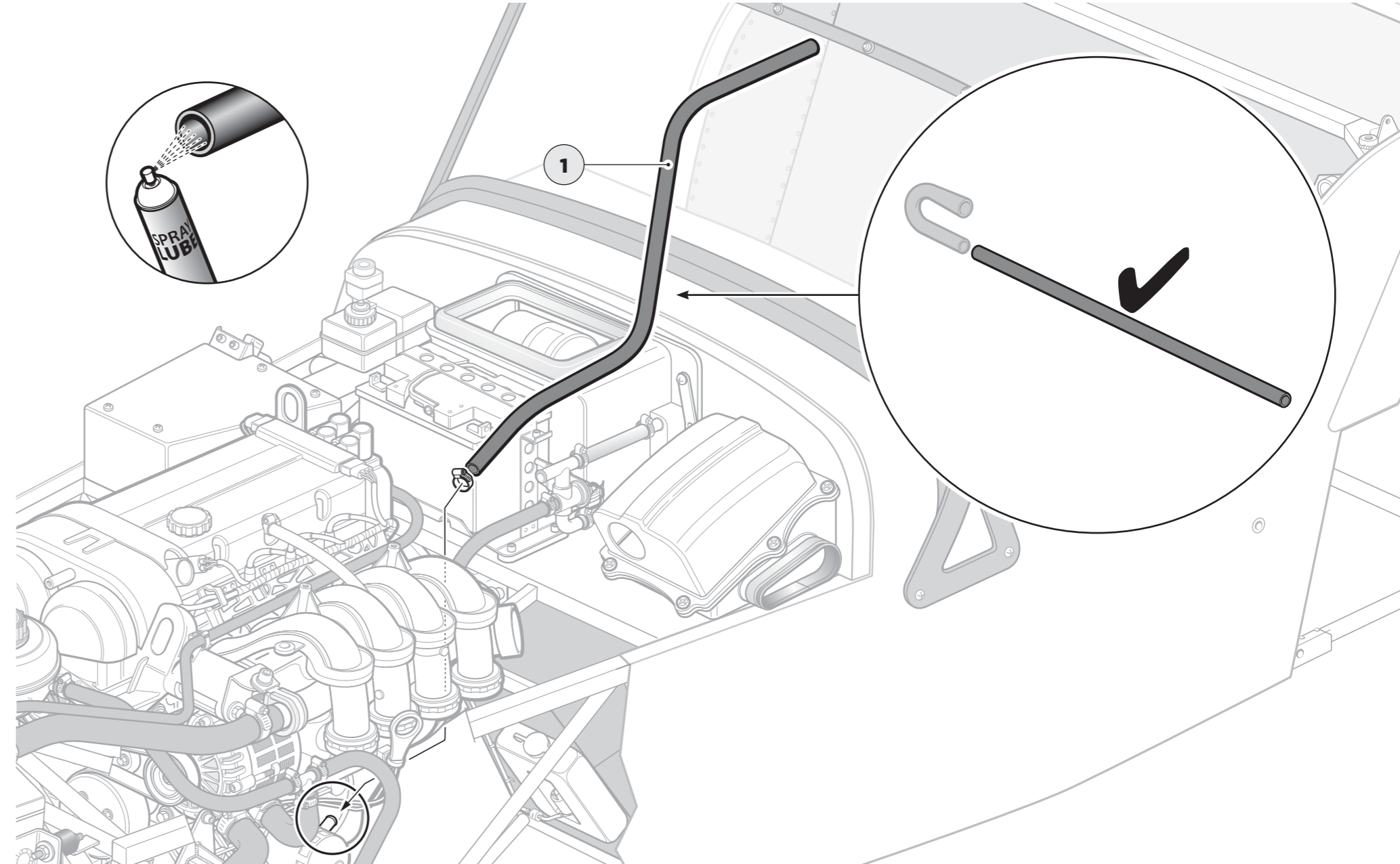
Pack D		CATERHAM		44	
		PACK NUMBER		38C047B	
COOLING SIGMA					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Expansion tank	38C047B	1	Expansion tank	
2	Expansion tank to bracket	38C047B	1	Expansion tank to bracket	
3	Expansion tank to bracket	38C047B	1	Expansion tank to bracket	
4	Expansion tank to bracket	38C047B	1	Expansion tank to bracket	
5	Expansion tank to bracket	38C047B	1	Expansion tank to bracket	
6	Expansion tank to bracket	38C047B	1	Expansion tank to bracket	
7	Expansion tank to bracket	38C047B	1	Expansion tank to bracket	
8	Expansion tank to bracket	38C047B	1	Expansion tank to bracket	
9	Expansion tank to bracket	38C047B	1	Expansion tank to bracket	
10	Expansion tank to bracket	38C047B	1	Expansion tank to bracket	
11	Expansion tank to bracket	38C047B	1	Expansion tank to bracket	

Pack D		CATERHAM		44	
		PACK NUMBER		38C047B	
COOLING SIGMA					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Expansion tank	38C047B	1	Expansion tank	
2	Expansion tank to bracket	38C047B	1	Expansion tank to bracket	
3	Expansion tank to bracket	38C047B	1	Expansion tank to bracket	
4	Expansion tank to bracket	38C047B	1	Expansion tank to bracket	
5	Expansion tank to bracket	38C047B	1	Expansion tank to bracket	
6	Expansion tank to bracket	38C047B	1	Expansion tank to bracket	
7	Expansion tank to bracket	38C047B	1	Expansion tank to bracket	
8	Expansion tank to bracket	38C047B	1	Expansion tank to bracket	
9	Expansion tank to bracket	38C047B	1	Expansion tank to bracket	
10	Expansion tank to bracket	38C047B	1	Expansion tank to bracket	
11	Expansion tank to bracket	38C047B	1	Expansion tank to bracket	

Cut off hook and trim if required.
Grant P

TIPS

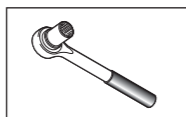
ONE LAST BIT OF PLUMBING...



...TO CONNECT THE HEATER

PARTS

TOOLS



7mm



FIXINGS

TIPS

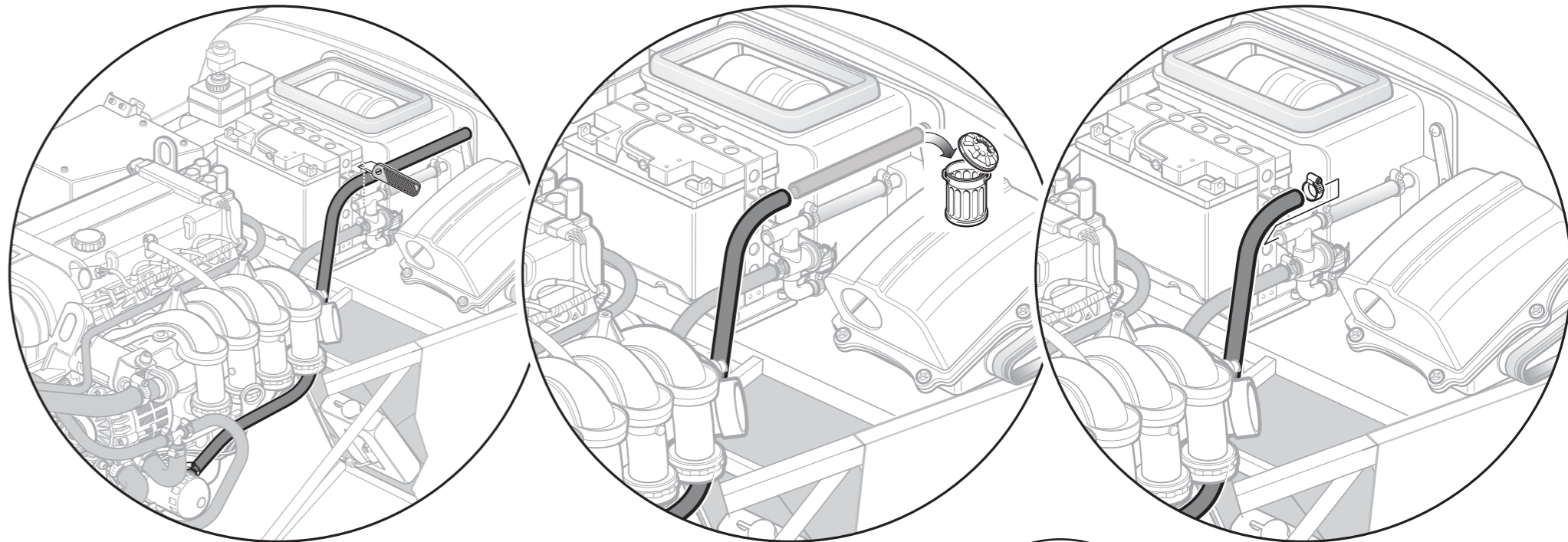
Pack D		CATERHAM		44	
ITEM		BASIC DESCRIPTION	PART NUMBER	QTY	USED ON
1	EA	Expansion tank	380802	1	Expansion tank
2	EA	Expansion tank to bracket	380803	1	Expansion tank to bracket
3	EA	Expansion tank to bracket	380804	1	Expansion tank to bracket
4	EA	Expansion tank to bracket	380805	1	Expansion tank to bracket
5	EA	Expansion tank to bracket	380806	1	Expansion tank to bracket
6	EA	Expansion tank to bracket	380807	1	Expansion tank to bracket
7	EA	Expansion tank to bracket	380808	1	Expansion tank to bracket
8	EA	Expansion tank to bracket	380809	1	Expansion tank to bracket
9	EA	Expansion tank to bracket	380810	1	Expansion tank to bracket
10	EA	Expansion tank to bracket	380811	1	Expansion tank to bracket
11	EA	Expansion tank to bracket	380812	1	Expansion tank to bracket

Pack D		CATERHAM		44	
ITEM		BASIC DESCRIPTION	PART NUMBER	QTY	USED ON
1	EA	Expansion tank	380802	1	Expansion tank
2	EA	Expansion tank to bracket	380803	1	Expansion tank to bracket
3	EA	Expansion tank to bracket	380804	1	Expansion tank to bracket
4	EA	Expansion tank to bracket	380805	1	Expansion tank to bracket
5	EA	Expansion tank to bracket	380806	1	Expansion tank to bracket
6	EA	Expansion tank to bracket	380807	1	Expansion tank to bracket
7	EA	Expansion tank to bracket	380808	1	Expansion tank to bracket
8	EA	Expansion tank to bracket	380809	1	Expansion tank to bracket
9	EA	Expansion tank to bracket	380810	1	Expansion tank to bracket
10	EA	Expansion tank to bracket	380811	1	Expansion tank to bracket
11	EA	Expansion tank to bracket	380812	1	Expansion tank to bracket

The coolant concentrate should be diluted 50/50 with water. It does not need to be exact!

Anthony L

...TO CONNECT THE HEATER



FILL WITH COOLANT

PARTS

Coolant concentrate



TOOLS

FIXINGS

TIPS

FILL WITH COOLANT



IMPORTANT



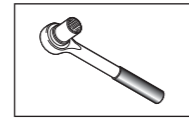
Fill expansion bottle to max mark

CONNECT THE AIRBOX TO THE ENGINE

PARTS

- 1 Airbox hose
- 2 Insert set
- 3 Hose clip

TOOLS



7mm

FIXINGS

All fixings for this step should be in the supplied airbox box

TIPS

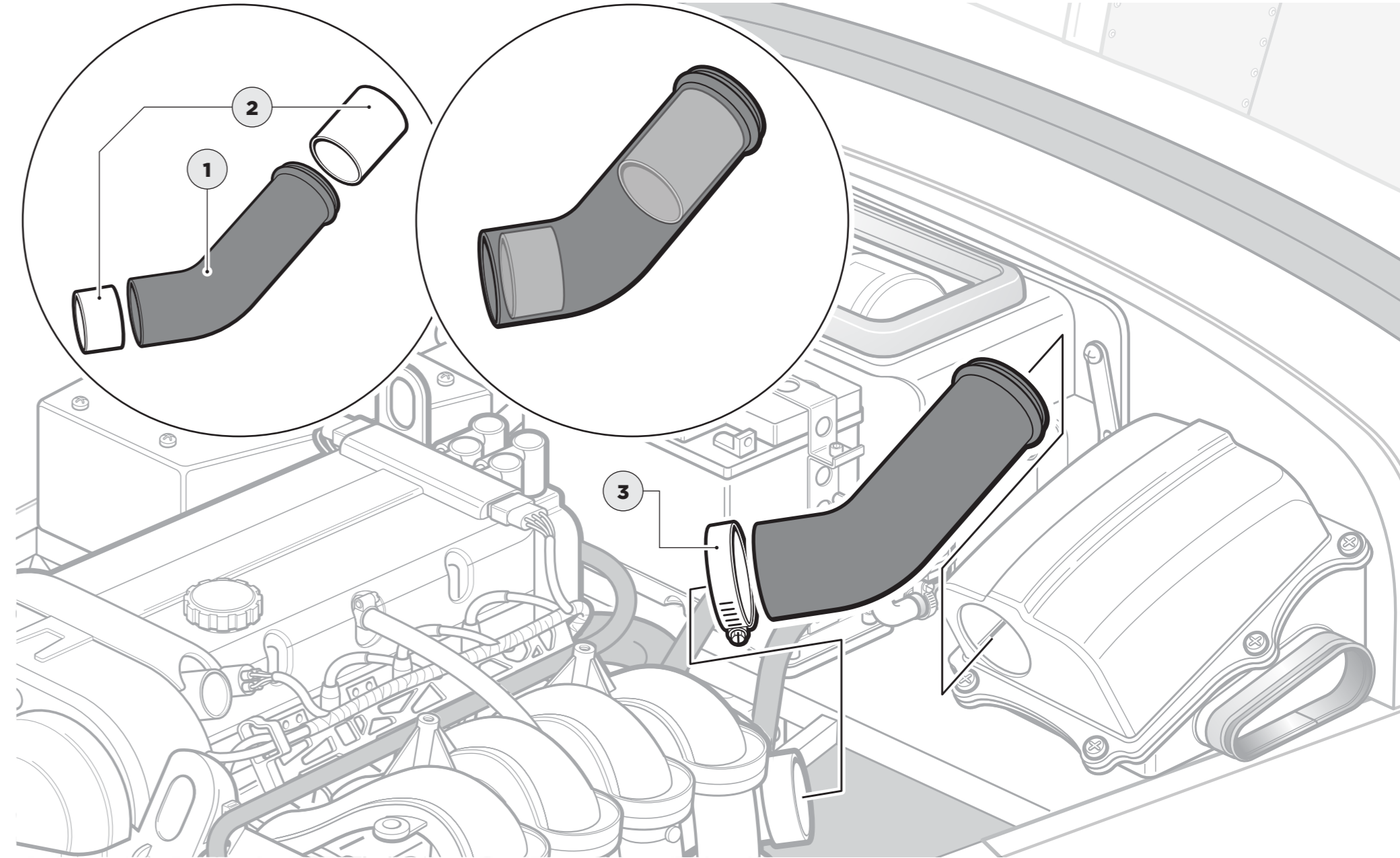
To help push insert in use the work bench.

Rich T

Spray brake cleaner in the hose and on the insert.

John K

CONNECT THE AIRBOX TO THE ENGINE

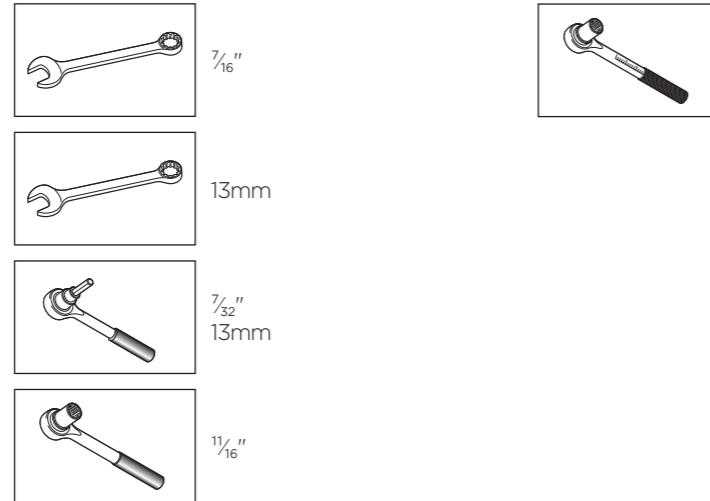


GIVING IT SOME DIRECTION

PARTS

- 1 Lower steering column
- 2 Upper steering column
- 3 Steering column clamp
- 4 Steering column clamp plate
- 5 Grub screw
- 6 Steering column bush

TOOLS



FIXINGS

Pack B		CATERHAM		55	
STEERING DeDION CARS (METRIC)					
This pack may include extra fasteners to cover different options					
ITEM	PART DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Steering rack	BB00010	1	Steering rack	
2	Steering column clamp	BB00011	2	Steering column clamp	
3	Rack MB 6 35 Grade 8.8	BB00012	2	Column to rack universal joint	
4	Steering wheel boss	BB00013	1	Steering wheel boss	
5	Rack top lock on	BB00014	2	Rack top lock on	
6	Column clamp grub screw lock on	BB00015	1	Column clamp grub screw lock on	
7	Column to rack universal joint	BB00016	2	Column to rack universal joint	
8	Steering rack steering	BB00017	1	Steering rack steering	
9	Steering wheel boss	BB00018	1	Steering wheel boss	
10	Steering column clamp	BB00019	2	Steering column clamp	
11	Steering column bush	BB00020	2	Steering column bush	

Check clearance between steering column & Aux belt tensioner once engine is installed. If necessary, rotate steering rack.

Dan P

Put the clamp in the middle of column with the grooved face of the clamp plate ④ against the column.

Jamie A

Grease the steering bushes.

Lee A

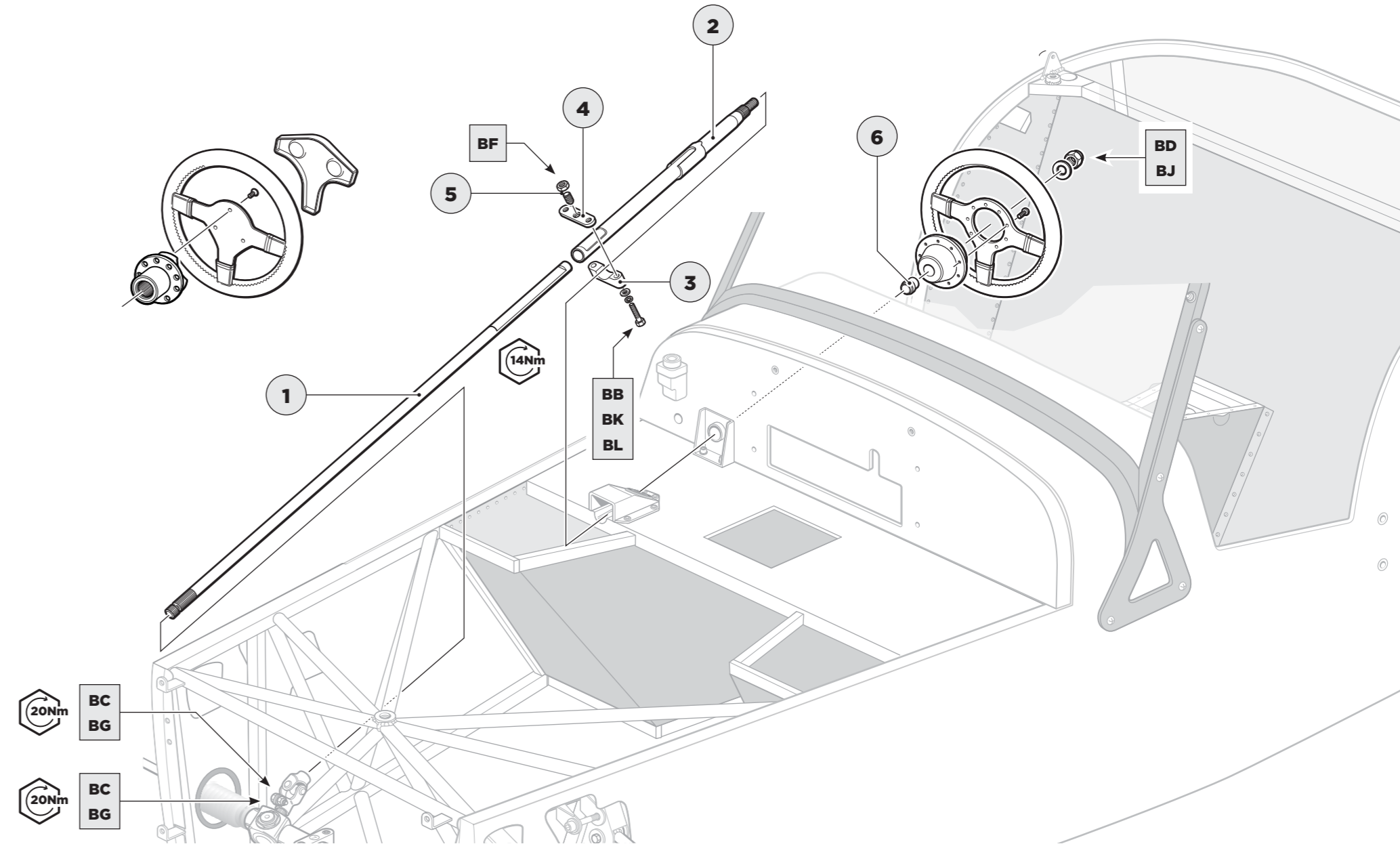
Steering rack to be rotated to fit column – don't forget to tighten rack brackets!

Harrison P

Fit the clamp bolts first, then grub screw & finish with the locking nut.

Tiago O

GIVING IT SOME DIRECTION



THIS IS EXHAUSTING

PARTS

- 1** Exhaust manifold gasket
- 2** Exhaust primary pipes
- 3** Cat / Collector
- 4** Exhaust collector springs

TOOLS



FIXINGS

Fixings are supplied loosely attached to the engine in place

TIPS

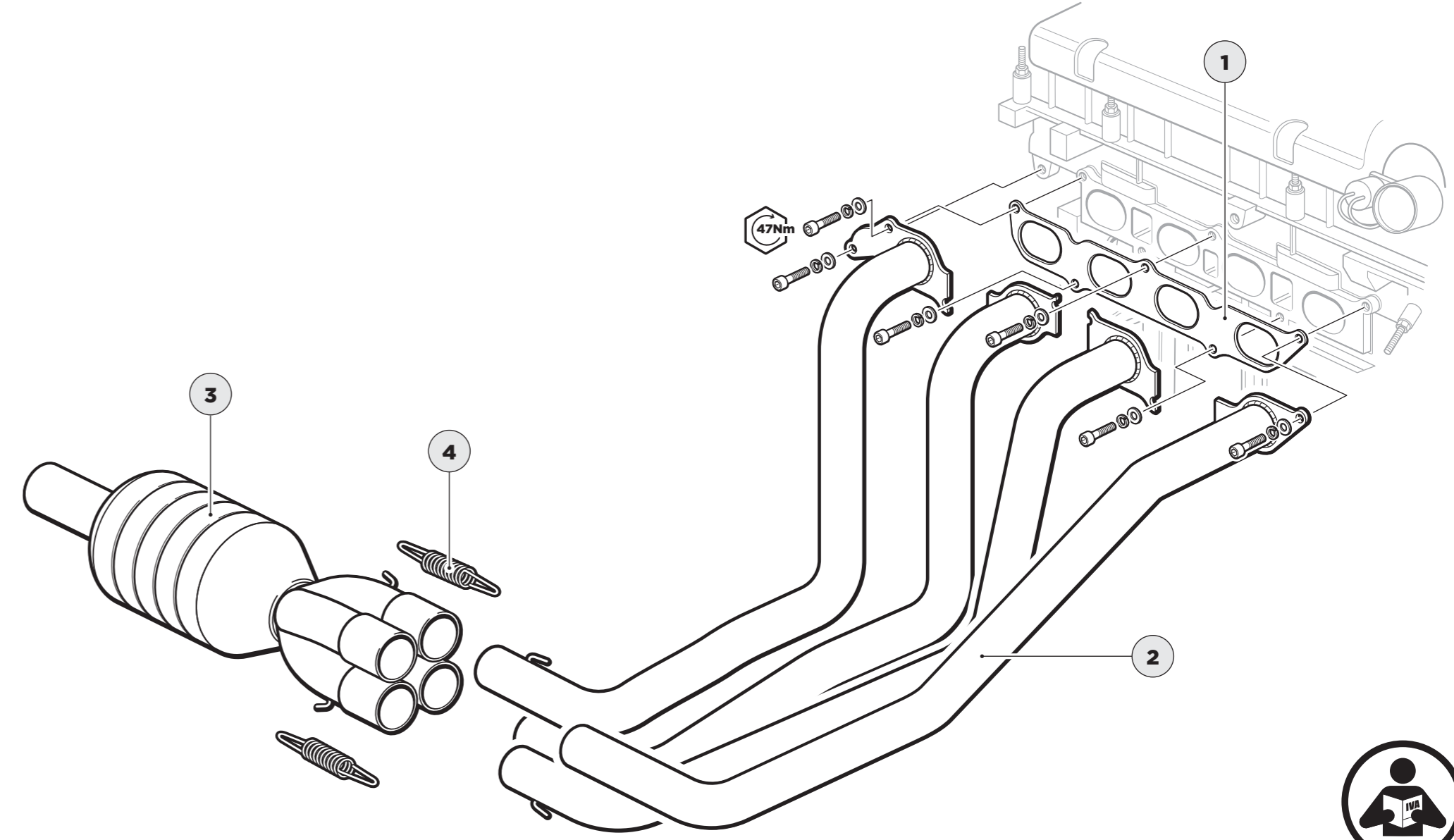
Use cable ties to compress exhaust spring.
Mick F

A pair of pliers are best to help hook over.
James A

Work out which primary pipe goes where, individually then put all four in plane, starting with the front one & working back. Take care with the hooks on your paintwork.
Chris N

Put masking tape round exhaust hole to prevent scratches.
Chris B

THIS IS EXHAUSTING



FITTING THE HANDBRAKE

PARTS

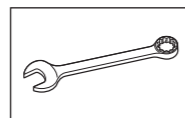
- 1 Handbrake assembly
- 2 Handbrake pulley
- 3 Handbrake clevis
- 4 Pulley clevis pin
- 5 Handbrake clevis pin
- 6 Handbrake cable

FIXINGS

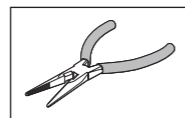
Miscellaneous pack

- Setscrew 8 (x25)
- Washer M8
- Washer M6

TOOLS



13mm (x2)



TIPS

Remember to put a loop in inner cable around pulley.

Grant P

Cable tie adjuster end of cable to diff.

Dan D

Use pliers to bend the legs of the split-pins once in place, which then holds them loosely in the clevis pins.

Chris B

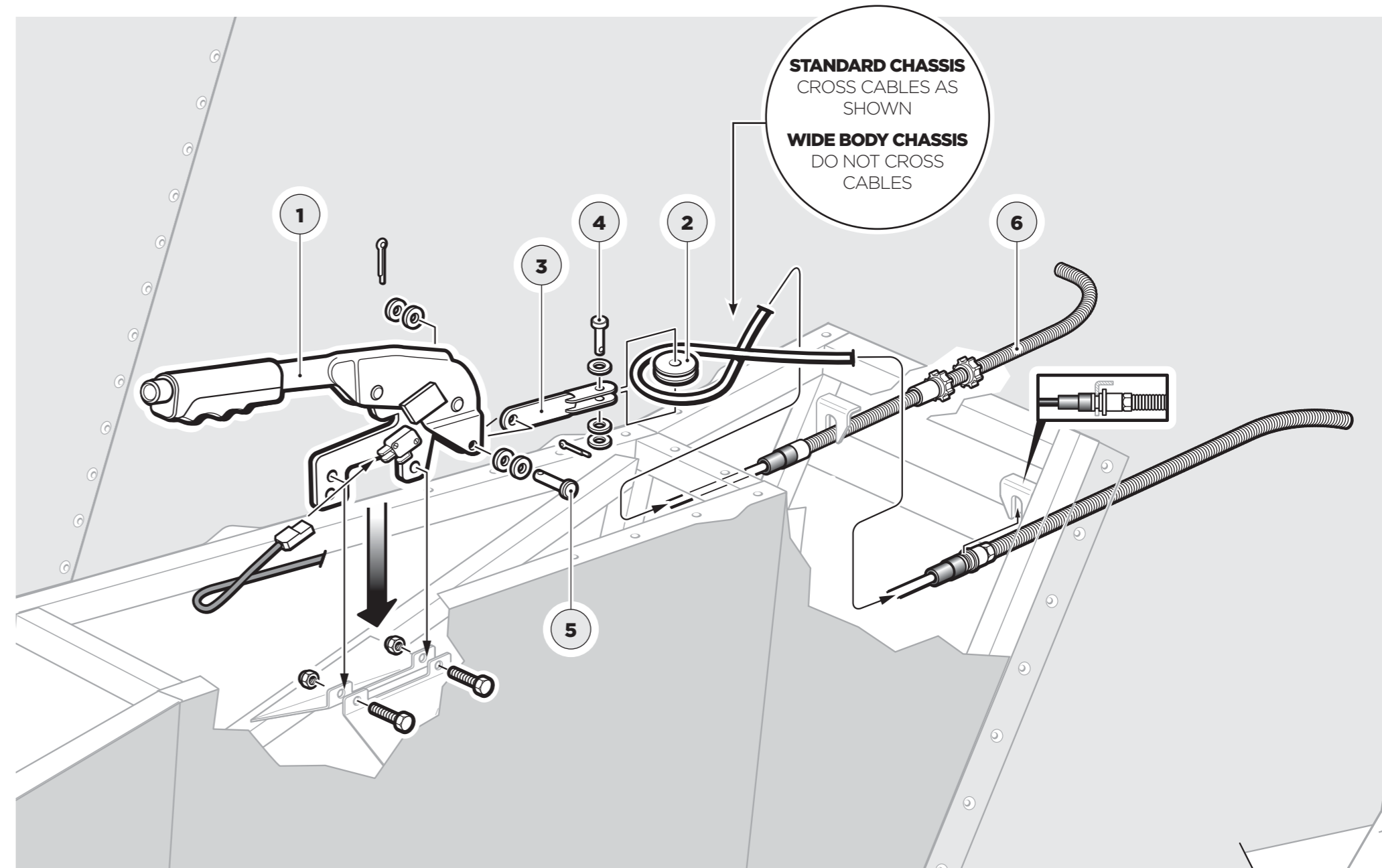
Handbrake wire connector goes to top of terminal & ties up.

Jamie A

After plugging in connector, cable tie and secure any excess wiring.

Dan P

FITTING THE HANDBRAKE



SLIDE IN THE PROPSHAFT

PARTS

1 Propshaft

TOOLS



FIXINGS

TIPS

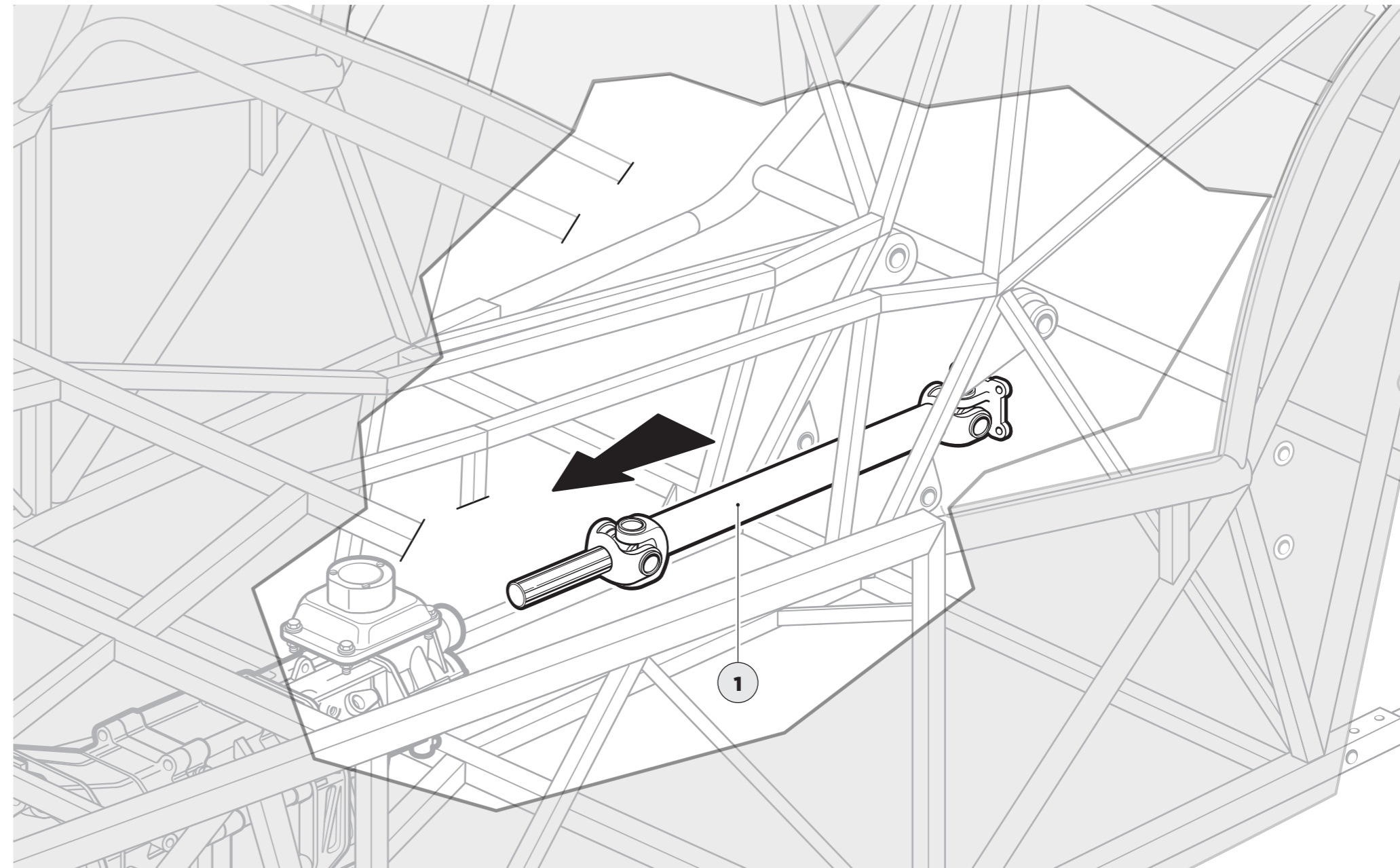
Line the splines in the propshaft to the gearbox.

Anthony L

Grease prop if necessary, it will have a grease nipple.

John S

SLIDE IN THE PROPSHAFT



HEAVY STUFF: FITTING THE DIFF

PARTS

1 Differential

ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Ball 1/2" x 1 1/4" UNF	BF122X1	1	Upper diff mounting bolt	
2	Control Bolt M10 x 45 Grade 12.9	BAC11262	2	Lower diff mounting bolt	
3	Rear Axle Tube 1.5" Dia	BA11263	4	Rear Axle through use to front DaDum	
4	1/2" Flange Tube through use to front DaDum	BA11264	8	1/2" Flange Tube through use to front DaDum	
5	Ball Race 1.5" Dia	BA11265	4	Through rear of axle and through DaDum	
6	Control Bolt M10 x 45 Grade 12.9	BAC11262	4	Propshaft bolts	
7	Control Bolt M10 x 45 Grade 12.9	BAC11262	2	Diff caps	
8	Half Flange 1/2" x 1 1/4" UNF	BF11262	1	Upper diff bolt	
9	Flange Nut 1/2" x 1 1/4" UNF	BF11263	1	Flange through use to DaDum	
10	1/2" Flange Nut 1/2" x 1 1/4" UNF	BF11264	4	Rear and off Cap supports	
11	1/2" Flange Nut 1/2" x 1 1/4" UNF	BF11265	2	Brake pipe	

x1

x2

x4

x1

* Use as required for spacing

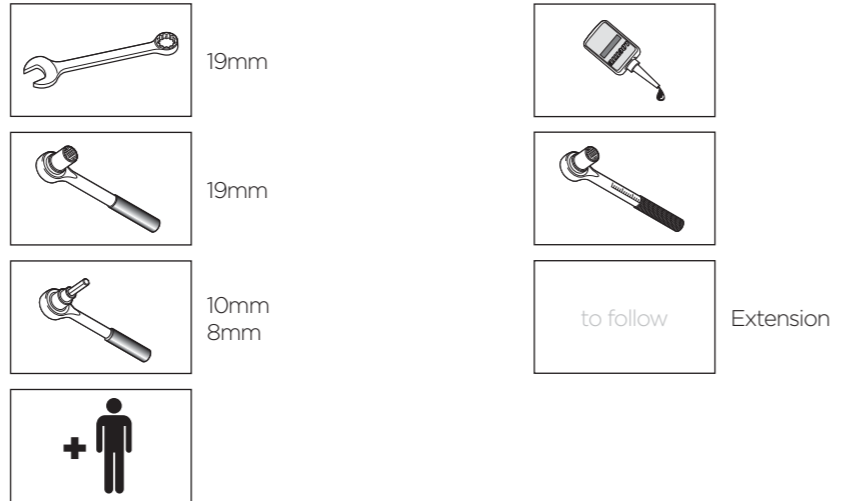
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
13	Pin washer 1/2" x 3/4" Dia	79017	8	Free play on diff	
14	Pin washer 1/2" x 3/4" Dia	79017	14	Off axle supports	
15	Pin washer 1/2" x 3/4" Dia	79017	16	Rear Diffion Upper Control Arm	
16	Pin washer 1/2" x 3/4" Dia	79017	16	Rear DaDum Tube Control Arm	
17	Ballnut washer 402		4	Behind bolt heads on diff	
18	Pin washer 1/2" x 3/4" Dia	79017	1	Behind lower tube	
19	Pin 1/2" x 3/4" Dia	181-0414	5	Plugs on DaDum for brake pipe	
20	P-Clip	500	5	Brake pipe on DaDum	

*

x4

Page 2 of 2

TOOLS



TIPS

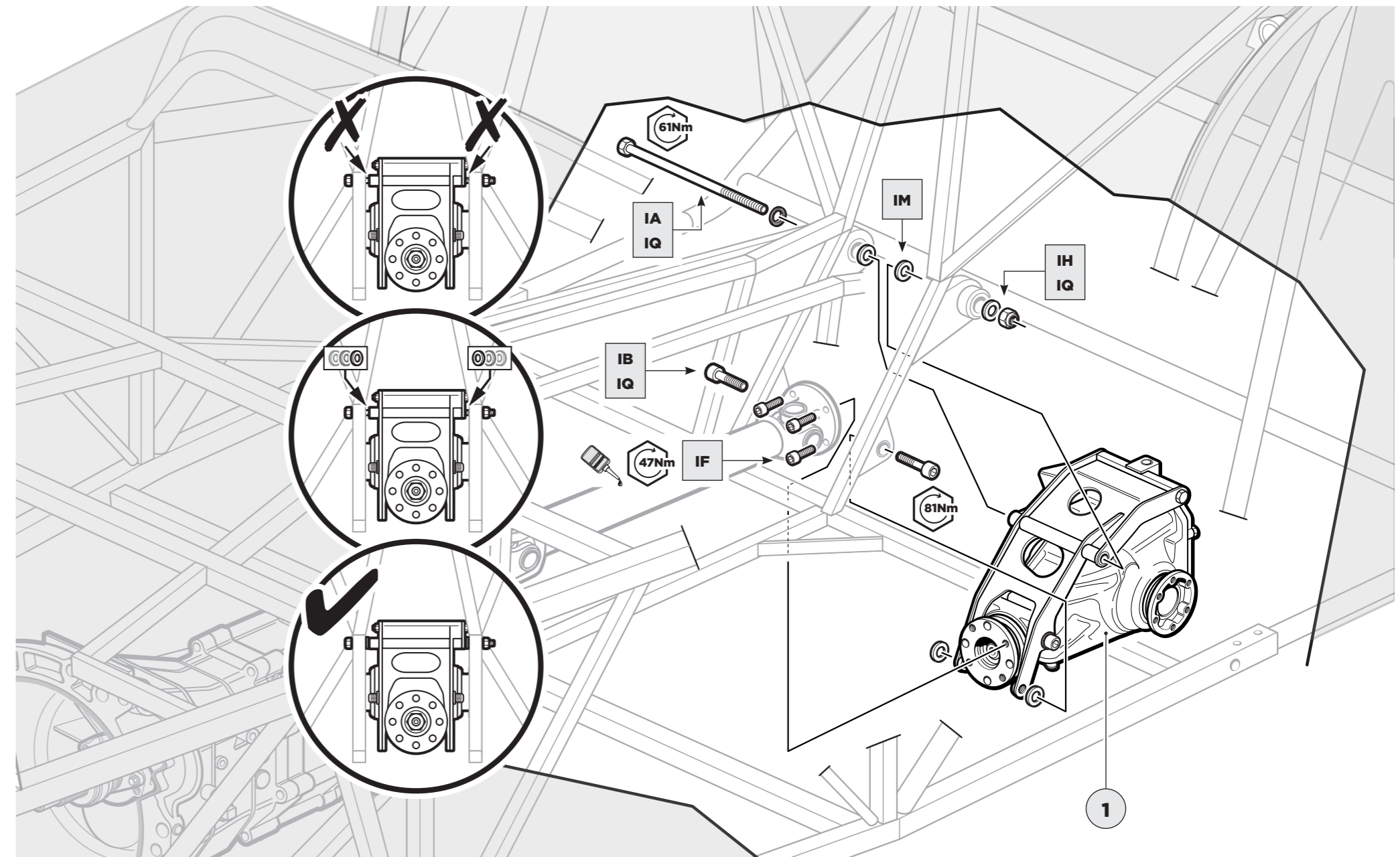
Start at bottom right with spanner & work your way around.
Chris B

Make sure propshaft is in first!
Harry P

Lower diff bolts may require more than one washer – try to keep them even.
Tiago O

to follow Extension

HEAVY STUFF: FITTING THE DIFF



FILL THE DIFFERENTIAL WITH OIL

PARTS

Differential oil

TOOLS

FIXINGS

TIPS

FILL THE DIFFERENTIAL WITH OIL



IMPORTANT



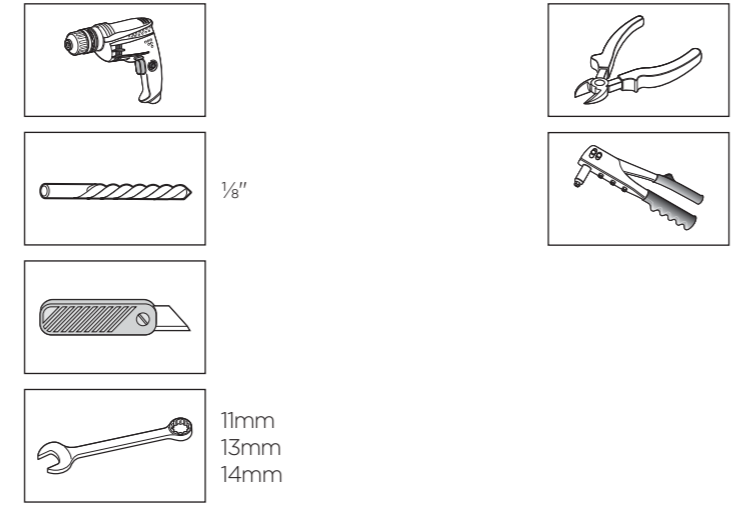
Differential = 0.8L

PREPARING THE DEDION TUBE

PARTS

- 1 DeDion tube
- 2 LHS brake pipe
- 3 RHS brake pipe
- 4 3 way union
- 5 Brake hose

TOOLS



FIXINGS

ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
11	HK Nylon Nut 1/4"	NP1414	1	3-way union on DeDion tube	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

x1

ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
11	HK Nylon Nut 1/4"	NP1414	2	Brake pipe	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

x2

ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
18	IR Shakedown Washer 3/8"	W3838	1	Braked brake hose	
19	IR Hose 1/4" x 0.51"	1881-0414	5	P-pipe on DeDion for brake pipe	
20	IT P-Clip	1001	5	Brake pipe on DeDion	

Drawings are for illustrative purposes only and are not to scale. Page 2 of 2

x1

x5

x5

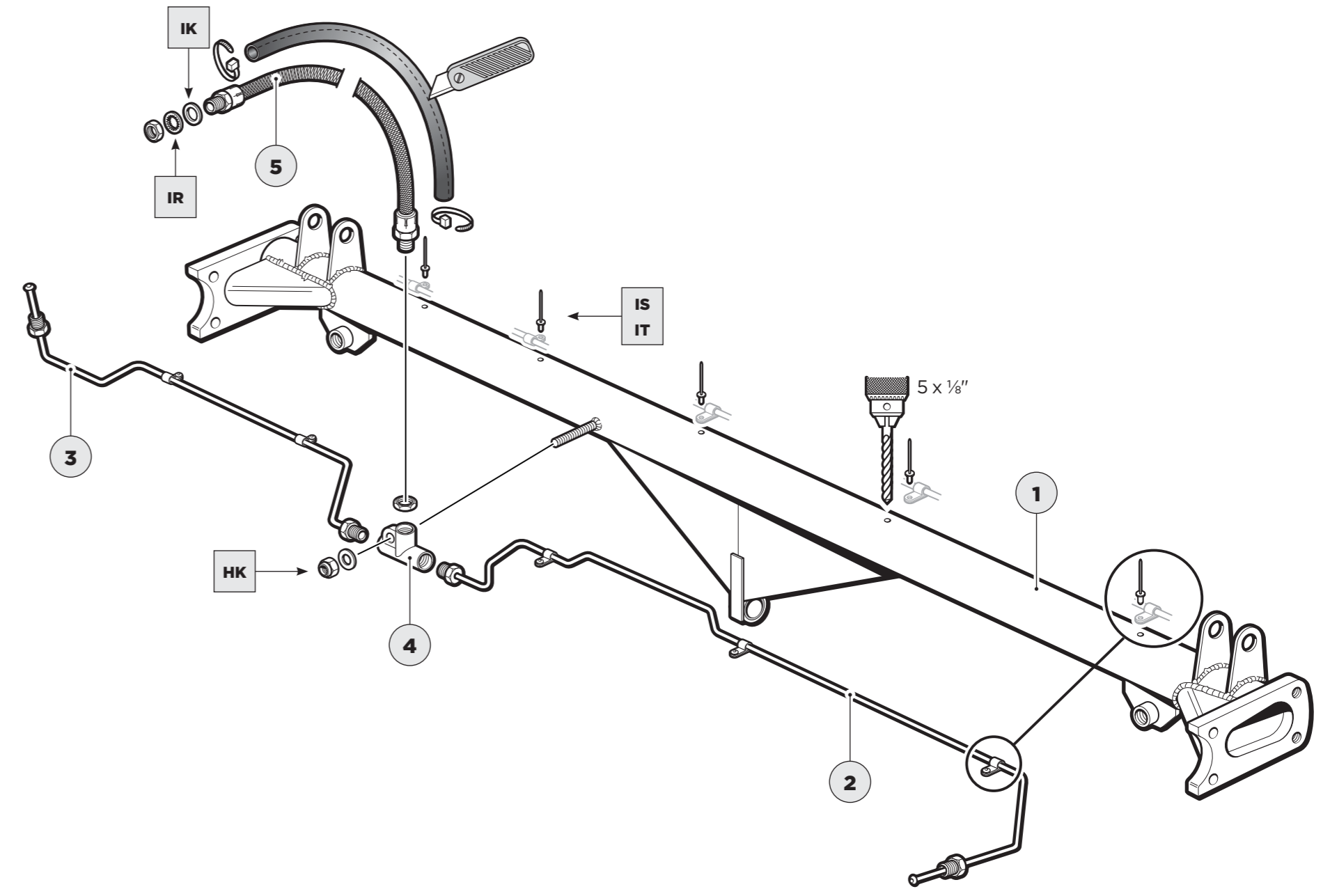
Brake pipe washers and nuts are included with the hose

TIPS

The upper brake hose fittings will become self explanatory on the rear damper installation page.
John K

Tighten the braided pipe 5 into the union before nipping up the locknut.
Chris N

PREPARING THE DEDION TUBE



AND FITTING IT IN PLACE

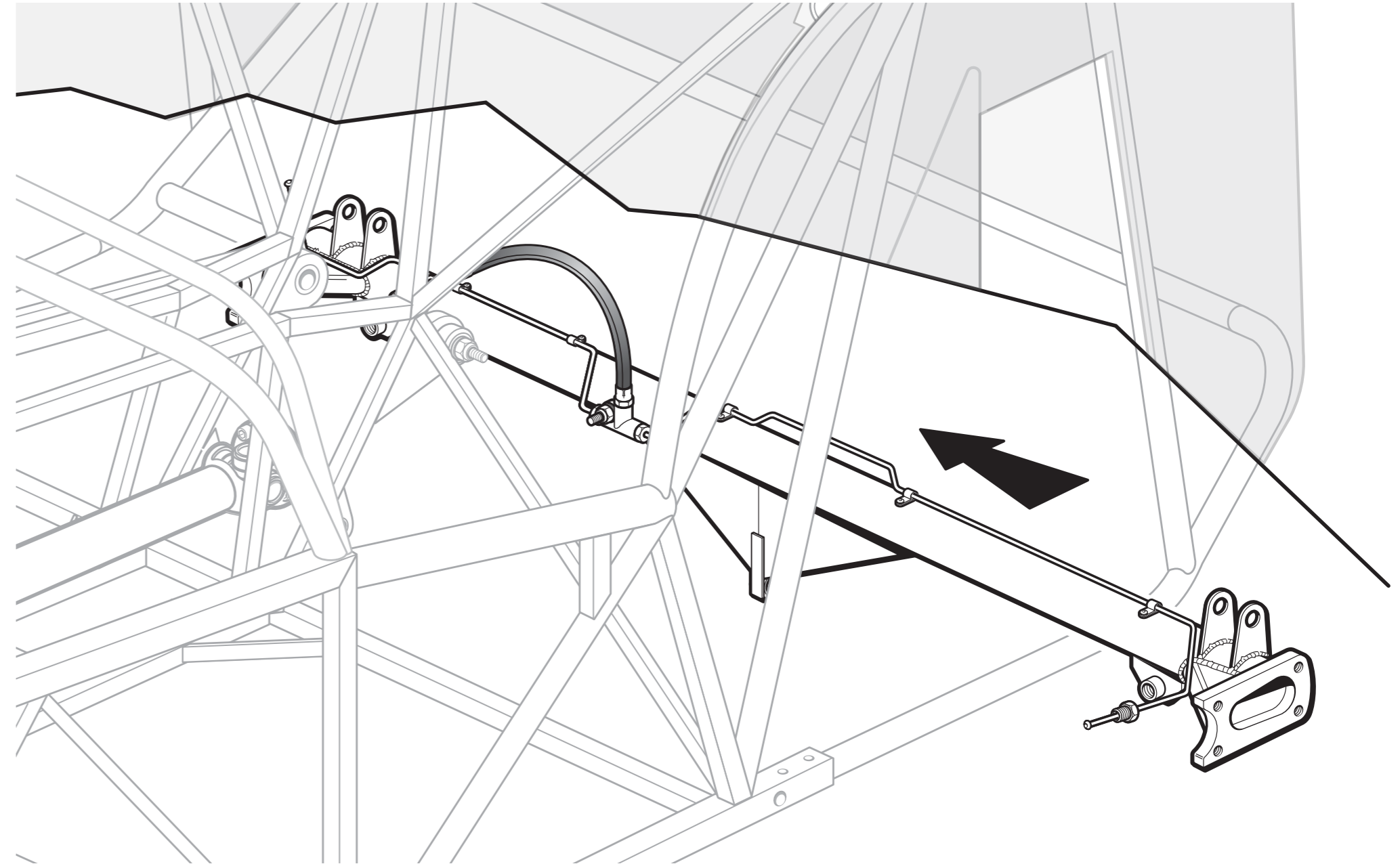
PARTS

TOOLS

FIXINGS

TIPS

AND FITTING IT IN PLACE

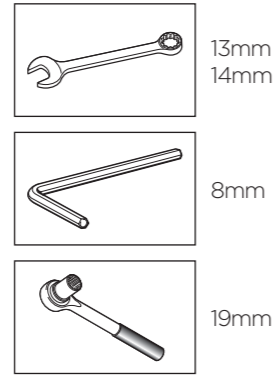


ATTACHING THE REAR DAMPERS

PARTS

- 1 Rear damper assembly
- 2 Rear damper sleeve

TOOLS



FIXINGS

Pack H		CATERHAM		53	
		PACK NUMBER		3680110	
REAR SUSPENSION DEDION METRIC					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Ball Joint	3680110	2	A-frame rear mounting	
2	Coilover	3680110	2	Front radius arm through cutout	
3	Ball Joint	3680110	4	x 2 Lower Rear Damper x 2 Rear Radius Arm	
4	Front Radius Arm	3680110	2	Front Radius Arm	
5	Front Radius Arm	3680110	2	Front Radius Arm	
6	Front Radius Arm	3680110	2	Front Radius Arm	
7	Front Radius Arm	3680110	2	Front Radius Arm	
8	Front Radius Arm	3680110	2	Front Radius Arm	
9	Front Radius Arm	3680110	2	Front Radius Arm	
10	Front Radius Arm	3680110	2	Front Radius Arm	
11	Front Radius Arm	3680110	2	Front Radius Arm	

x2

x4

x2

x2

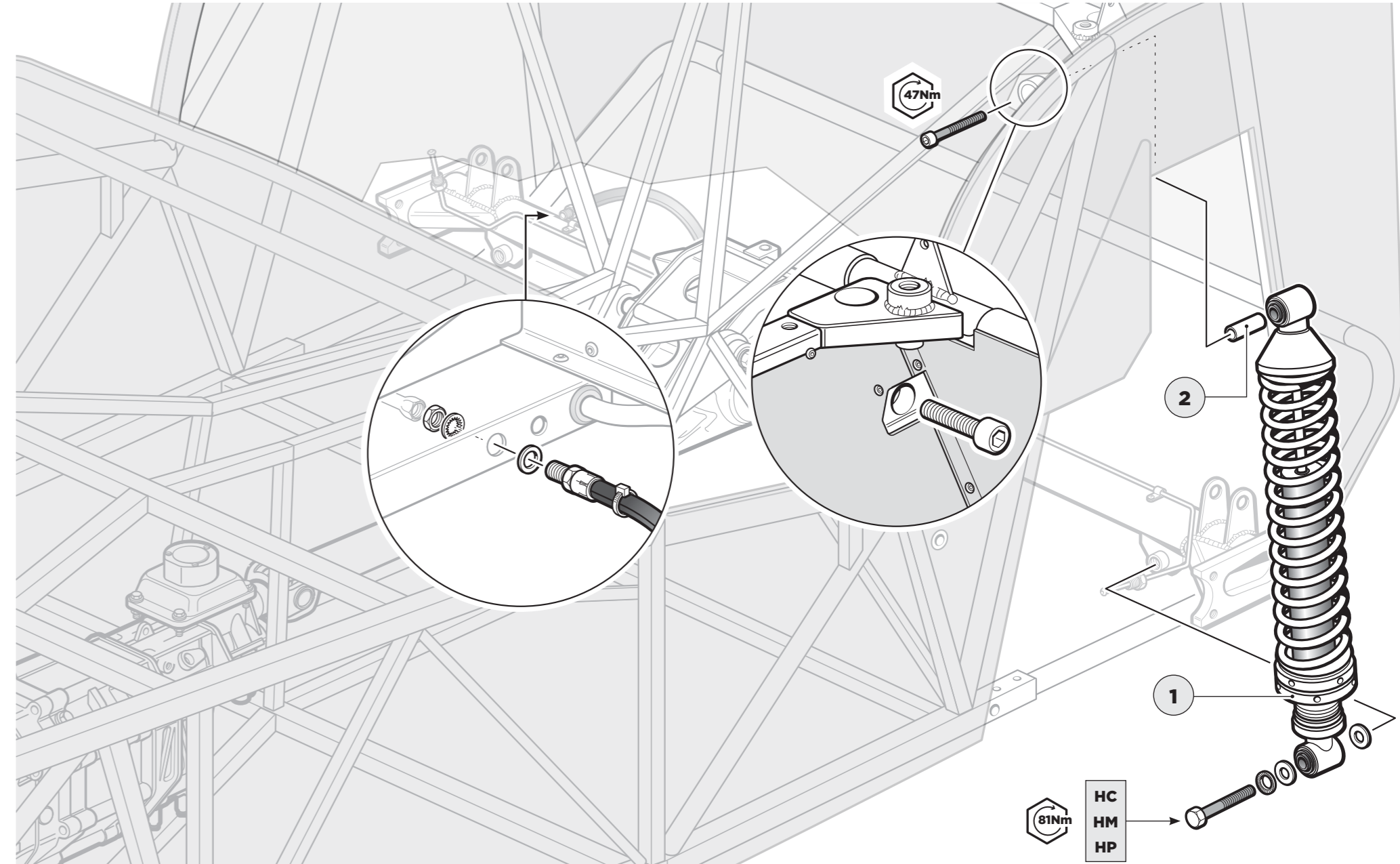
x2

TIPS

Although we show the fitting of the dampers here as part of the rear suspension, it is better to leave this step until you've fitted the roll over bar much later in the process.

Jamie A

ATTACHING THE REAR DAMPERS

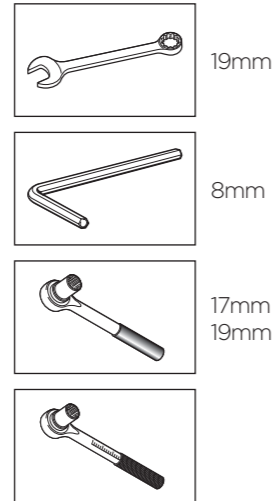


THEN THE RADIUS ARM

PARTS

1 Radius arm

TOOLS



FIXINGS

Pack H		CATERHAM		53	
REAR SUSPENSION DEDION METRIC		PART NUMBER		QUANTITY	
1	Hub	102 X 45	102 X 45	2	2
2	Hub Bolt	M8 X 45	84CH10080	2	2
3	Bolt	12" X 2.12" Grade 10.9	MF1020.10	4	4
4	Hub Bolt	M8 X 45	84CH10080	2	2
5	Hub Bolt	M8 X 45	84CH10080	2	2
6	Hub Bolt	M8 X 45	84CH10080	2	2
7	Hub Bolt	M8 X 45	84CH10080	2	2
8	Hub Bolt	M8 X 45	84CH10080	2	2
9	Hub Bolt	M8 X 45	84CH10080	2	2
10	Hub Bolt	M8 X 45	84CH10080	2	2
11	Hub Bolt	M8 X 45	84CH10080	2	2

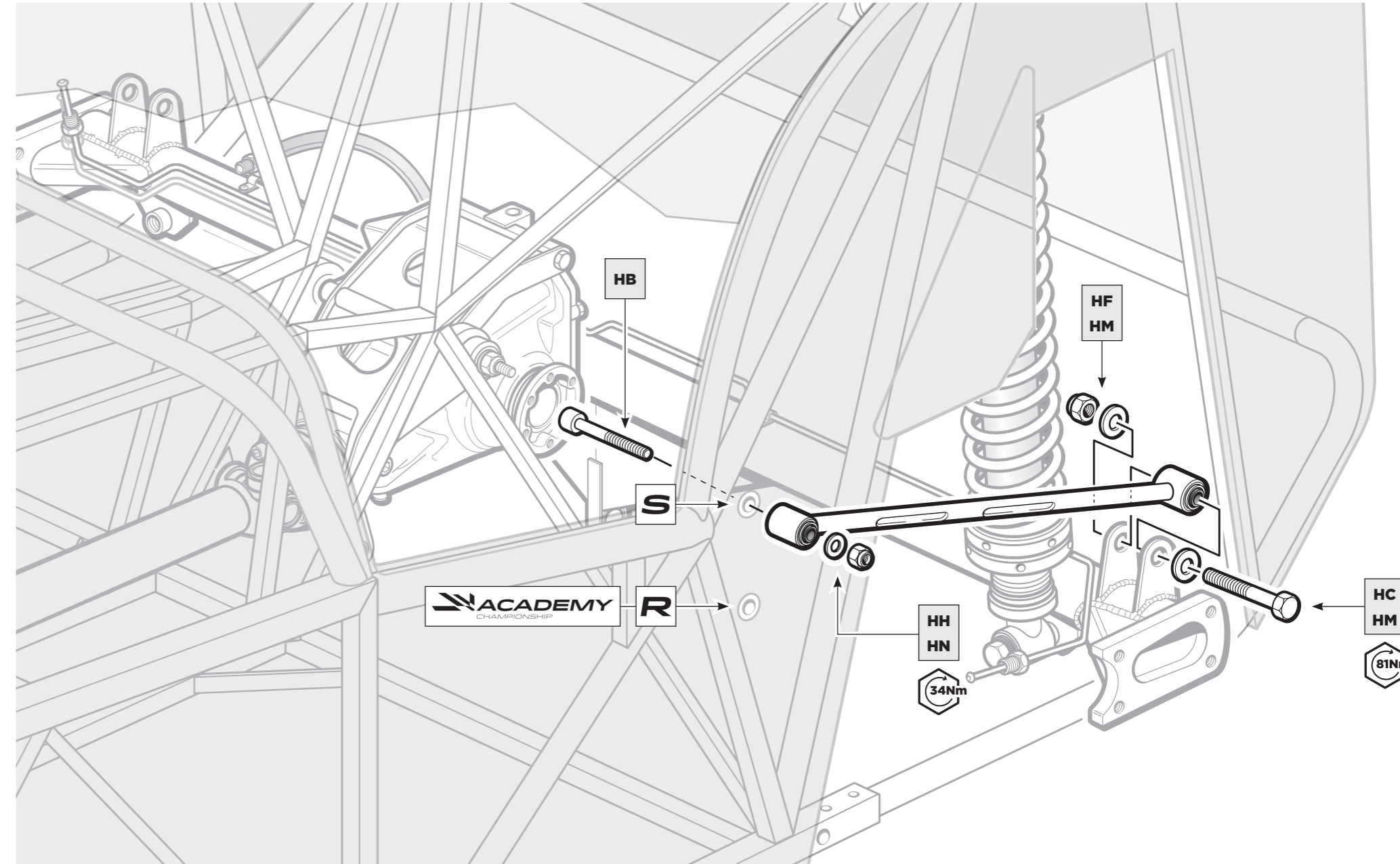
Pack H		CATERHAM		53	
REAR SUSPENSION DEDION METRIC		PART NUMBER		QUANTITY	
12	Hub Bolt	M8 X 45	84CH10080	2	2
13	Hub Bolt	M8 X 45	84CH10080	2	2
14	Hub Bolt	M8 X 45	84CH10080	2	2
15	Hub Bolt	M8 X 45	84CH10080	2	2
16	Hub Bolt	M8 X 45	84CH10080	2	2
17	Hub Bolt	M8 X 45	84CH10080	2	2
18	Hub Bolt	M8 X 45	84CH10080	2	2
19	Hub Bolt	M8 X 45	84CH10080	2	2
20	Hub Bolt	M8 X 45	84CH10080	2	2

Before torquing up these bolts, reposition the axle stands to under the DeDion tube (to hold up the suspension). Make sure front has two axle stands so it is steady when jacking up the rear!

Mick F

TIPS

THEN THE RADIUS ARM

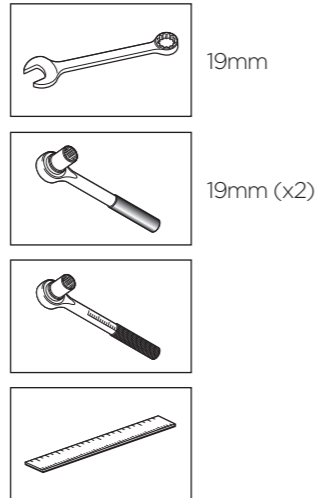


AND NOW THE (CAREFULLY SPACED) A-FRAME

PARTS

- 1 A-frame
- 2 White nylon anti-squeak washers

TOOLS



FIXINGS

ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	HA 19x2.5 100 Grade 10.9	BM123100	2	A-frame front mountings	
2	HE 1/2" X 2 1/4" Grade 10.9	MF1300.34	1	A-frame to DeDion	
3	HF Half Nylon 1/2" UNF	MF0112	3	x2 Rear Radius Arms 1 A-frame to DeDion	
4	HM Nylon Nut M12	MF0112	2	A-frame front mounts	

x2

x1

x1

x2

ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
13	HB Plain Washer 1/2" Checkered	WB0112	20	x2 Lower Damper x10 A-frame washers & Radius Arm	

*

* Use as required for spacing

TIPS

Make sure the DeDion tube is equal on both sides.
Tiago O

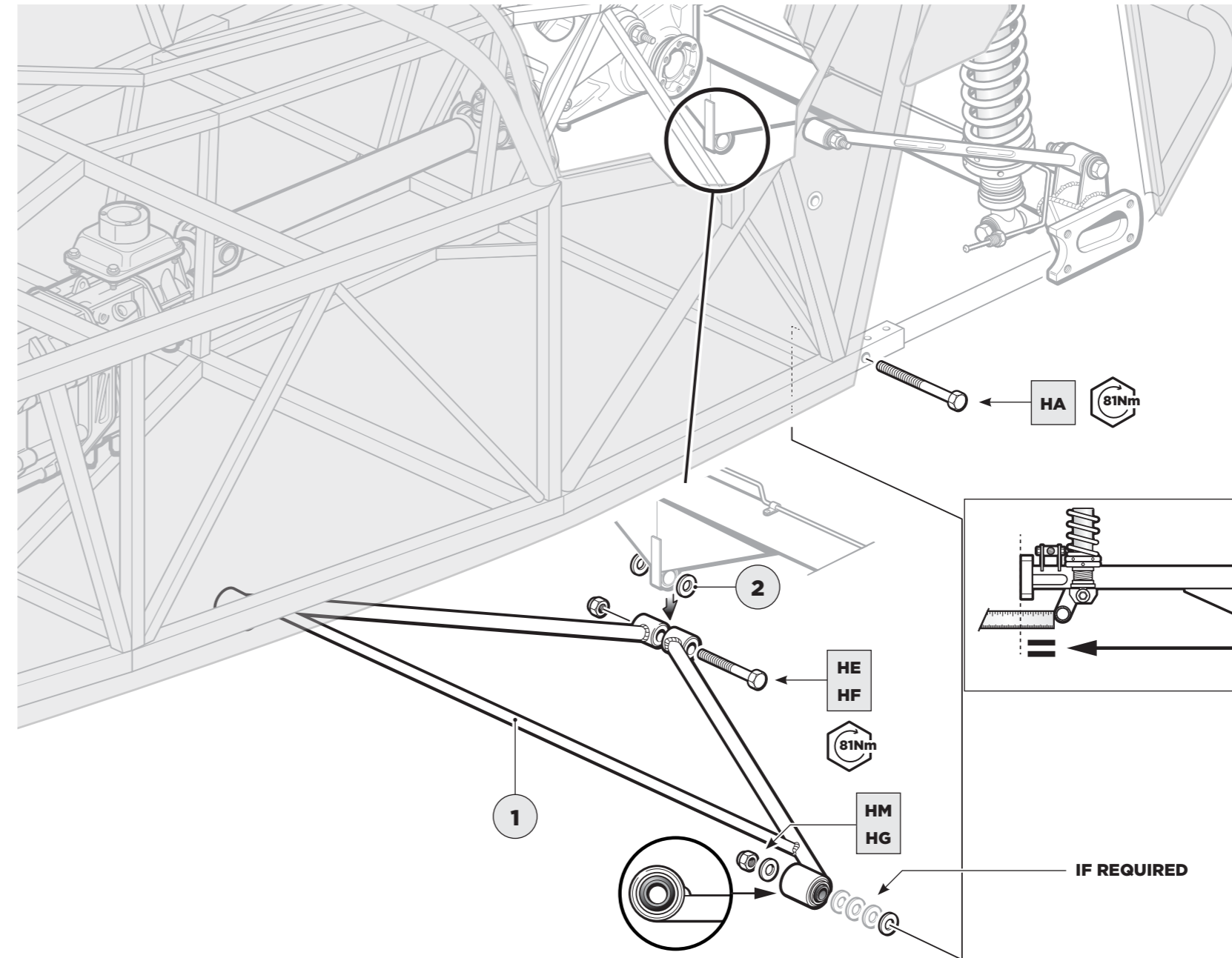
Use as many HM washers as required to space A-frame.
John K

The A-frame has a 'way up'. The arms should be offset downwards in relation to the front bushes.
Chris N

Take care to use the correct nuts as there is a mixture of metric and imperial here.
Lee A

Torque up as before on axle stands.
Rich T

AND NOW THE (CAREFULLY SPACED) A-FRAME

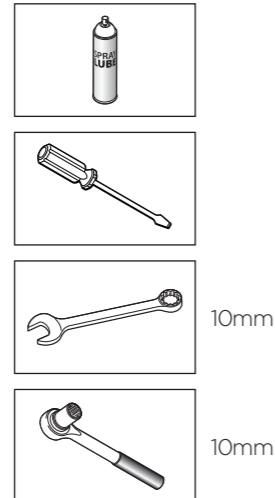


IF YOU HAVE THE OPTIONAL REAR ANTI-ROLL BAR, IT GOES ON LIKE THIS

PARTS

- 1 Rear anti roll bar
- 2 Anti roll bar rubber
- 3 Rear anti roll bar clamp

TOOLS



10mm

10mm

FIXINGS

ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Rear Anti Roll Bar	3600110	1		
2	Anti Roll Bar Rubber	3600111	2		
3	Rear Anti Roll Bar Clamp	3600112	1		
4	Rear Anti Roll Bar Mounting Blocks	3600113	4		
5	Rear Anti Roll Bar Mounting Blocks	3600114	4		
6	Rear Anti Roll Bar Mounting Blocks	3600115	4		
7	Rear Anti Roll Bar Mounting Blocks	3600116	4		
8	Rear Anti Roll Bar Mounting Blocks	3600117	4		
9	Rear Anti Roll Bar Mounting Blocks	3600118	4		
10	Rear Anti Roll Bar Mounting Blocks	3600119	4		
11	Rear Anti Roll Bar Mounting Blocks	3600120	4		

x4

x4

ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
12	Rear Anti Roll Bar Mounting Blocks	3600121	4		
13	Rear Anti Roll Bar Mounting Blocks	3600122	4		
14	Rear Anti Roll Bar Mounting Blocks	3600123	4		
15	Rear Anti Roll Bar Mounting Blocks	3600124	4		
16	Rear Anti Roll Bar Mounting Blocks	3600125	4		
17	Rear Anti Roll Bar Mounting Blocks	3600126	4		
18	Rear Anti Roll Bar Mounting Blocks	3600127	4		
19	Rear Anti Roll Bar Mounting Blocks	3600128	4		
20	Rear Anti Roll Bar Mounting Blocks	3600129	4		
21	Rear Anti Roll Bar Mounting Blocks	3600130	4		

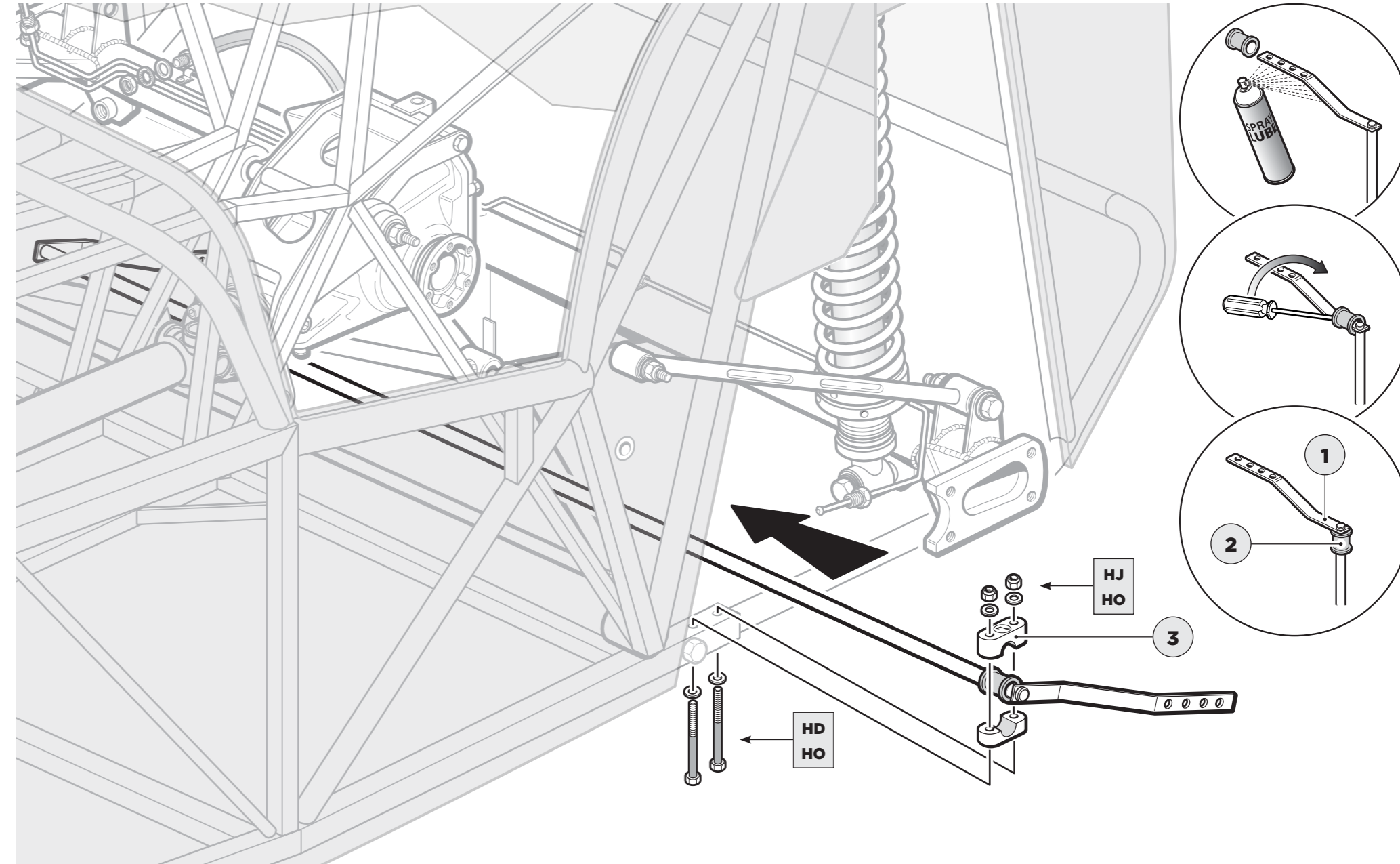
x8

TIPS

Be careful not to slip with the screwdriver!

John S

IF YOU HAVE THE OPTIONAL REAR ANTI-ROLL BAR, IT GOES ON LIKE THIS



INSERT THE DRIVESHAFTS

PARTS

- 1 Driveshaft
- 2 Driveshaft nut

TOOLS

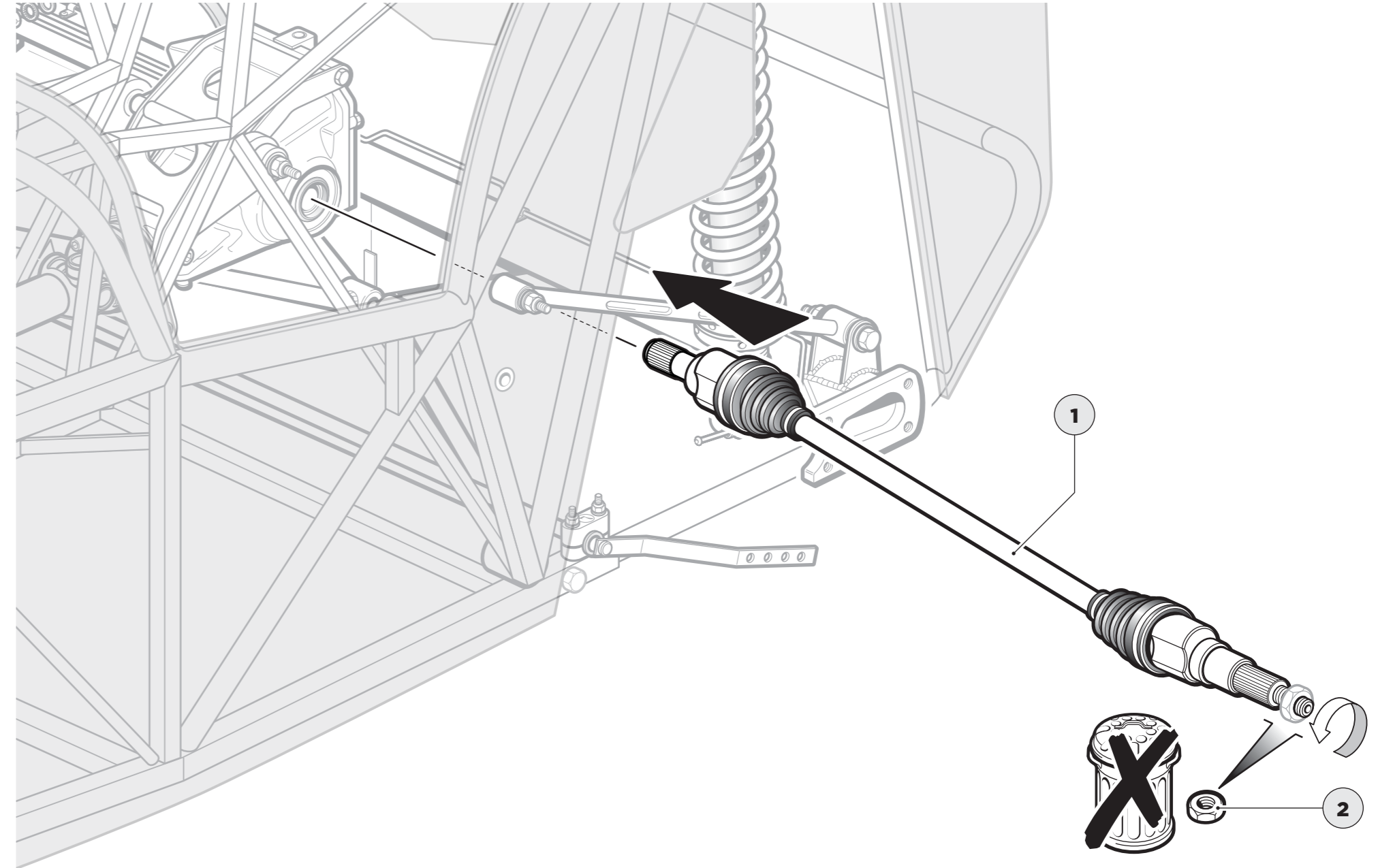
FIXINGS

TIPS

Driveshafts are handed, and so are the nuts, the left hand nut tightens anti-clockwise.

James A

INSERT THE DRIVESHAFTS

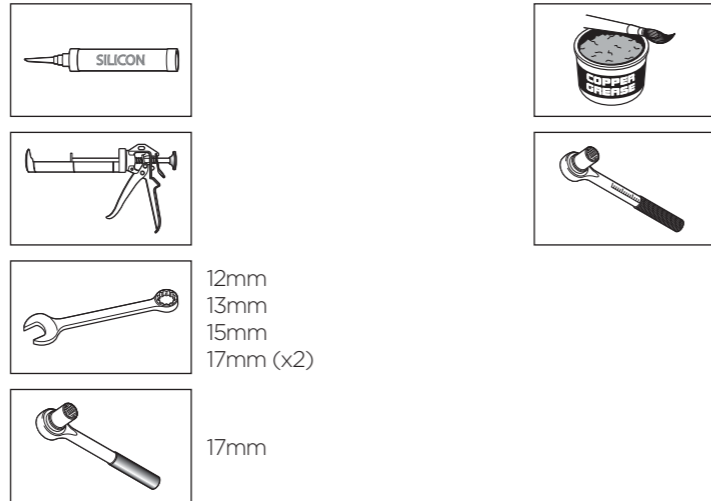


FITTING THE REAR HUB

PARTS

- 1** Rear brake disc / flange assembly
- 2** Rear hub
- 3** DeDion ear
- 4** Anti roll bar bracket
- 5** Anti roll bar drop link
- 6** Brake calliper
- 7** Brake calliper mount
- 8** Brake pads
- 9** Driveshaft nut
- 10** Driveshaft washer

TOOLS



FIXINGS

ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Rear brake disc / flange assembly	BM1010	1	Rear wheel	
2	Rear hub	BM1011	1	Rear wheel	
3	DeDion ear	BM1012	1	Rear wheel	
4	Anti roll bar bracket	BM1013	1	Rear wheel	
5	Anti roll bar drop link	BM1014	1	Rear wheel	
6	Brake calliper	BM1015	1	Rear wheel	
7	Brake calliper mount	BM1016	1	Rear wheel	
8	Brake pads	BM1017	1	Rear wheel	
9	Driveshaft nut	BM1018	1	Rear wheel	
10	Driveshaft washer	BM1019	1	Rear wheel	

ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Rear brake disc / flange assembly	BM1010	1	Rear wheel	
2	Rear hub	BM1011	1	Rear wheel	
3	DeDion ear	BM1012	1	Rear wheel	
4	Anti roll bar bracket	BM1013	1	Rear wheel	
5	Anti roll bar drop link	BM1014	1	Rear wheel	
6	Brake calliper	BM1015	1	Rear wheel	
7	Brake calliper mount	BM1016	1	Rear wheel	
8	Brake pads	BM1017	1	Rear wheel	
9	Driveshaft nut	BM1018	1	Rear wheel	
10	Driveshaft washer	BM1019	1	Rear wheel	

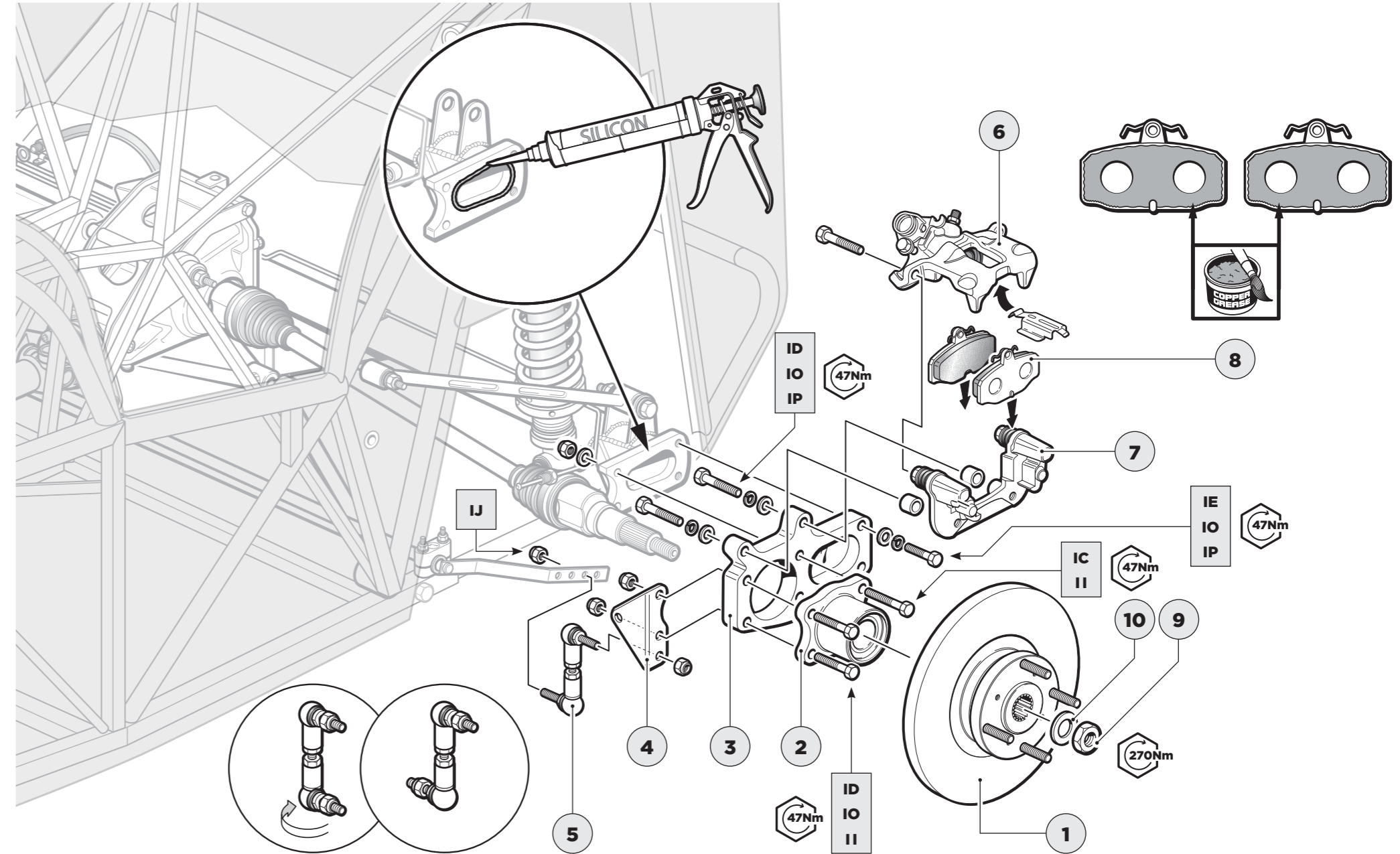
x4
x8
x4
x8
x4

x16
x8

TIPS

- Chris B**: Swap the plain nuts on the droplinks for nylons.
- Dan D**: Torque up the bearing and ear before fitting the disc.
- Grant P**: Remember the driveshaft nuts are handed.
- Rich T**: If you don't have an anti roll bar you will only have one bracket (for the right hand side) which holds the speed sensor.

FITTING THE REAR HUB

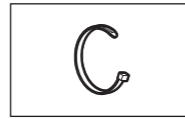


AND SPEED SENSOR (ONE SIDE ONLY)

PARTS

1 Speed sensor

TOOLS



FIXINGS

TIPS

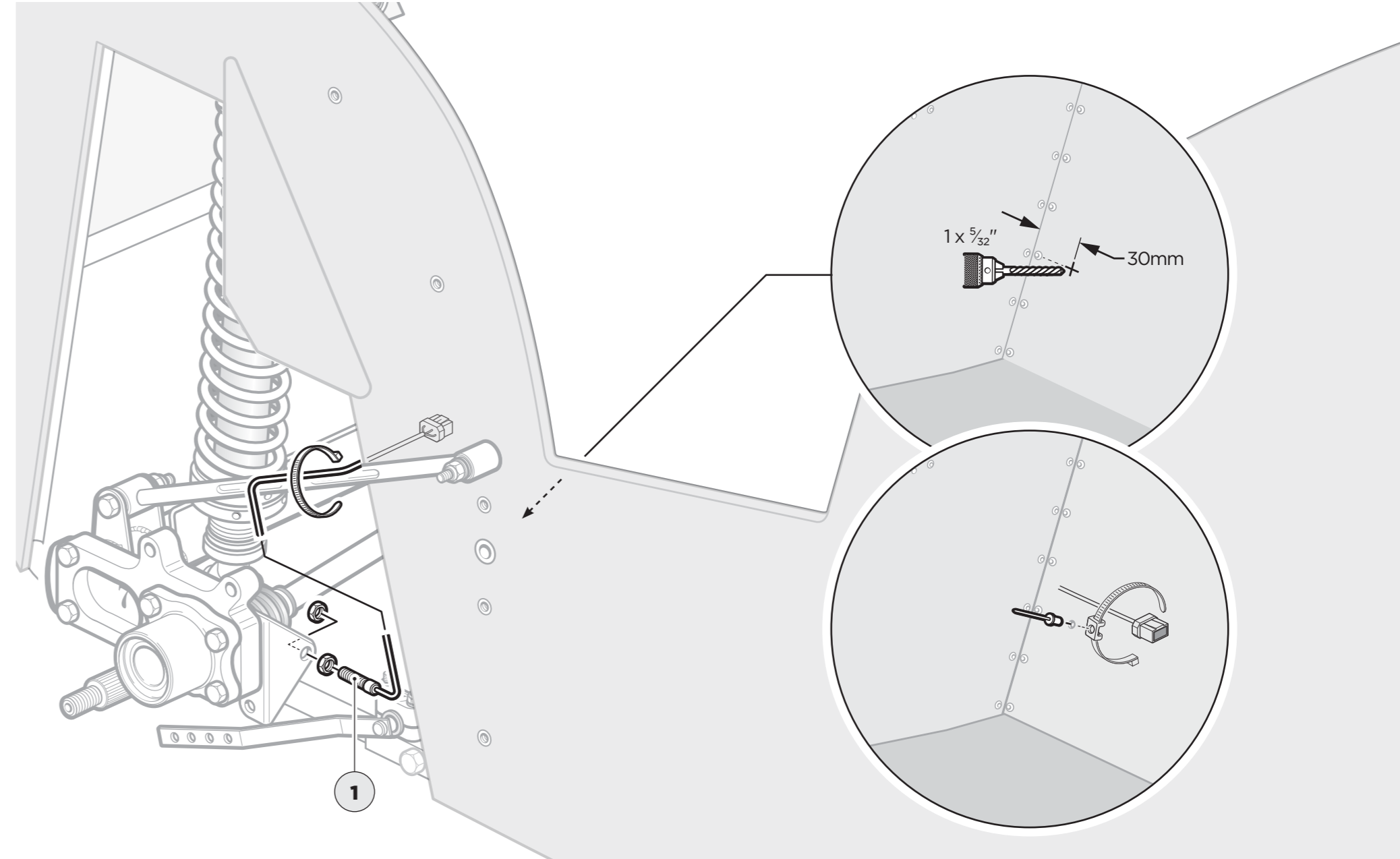
Ensure there is enough slack in the wire to allow for suspension travel.

Tiago O

Adjust sensor gap to approx. 0.8–0.9mm.

Lloyd D

AND SPEED SENSOR (ONE SIDE ONLY)





Now is a good time to take some photos



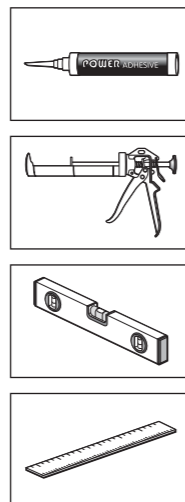
Have you applied for your IVA yet?

JUST WING IT

PARTS

- 1 Cycle wing
- 2 Wheel
- 3 Wheel nuts

TOOLS



FIXINGS

TIPS

Key the wing & wingstay before using adhesive.
John S

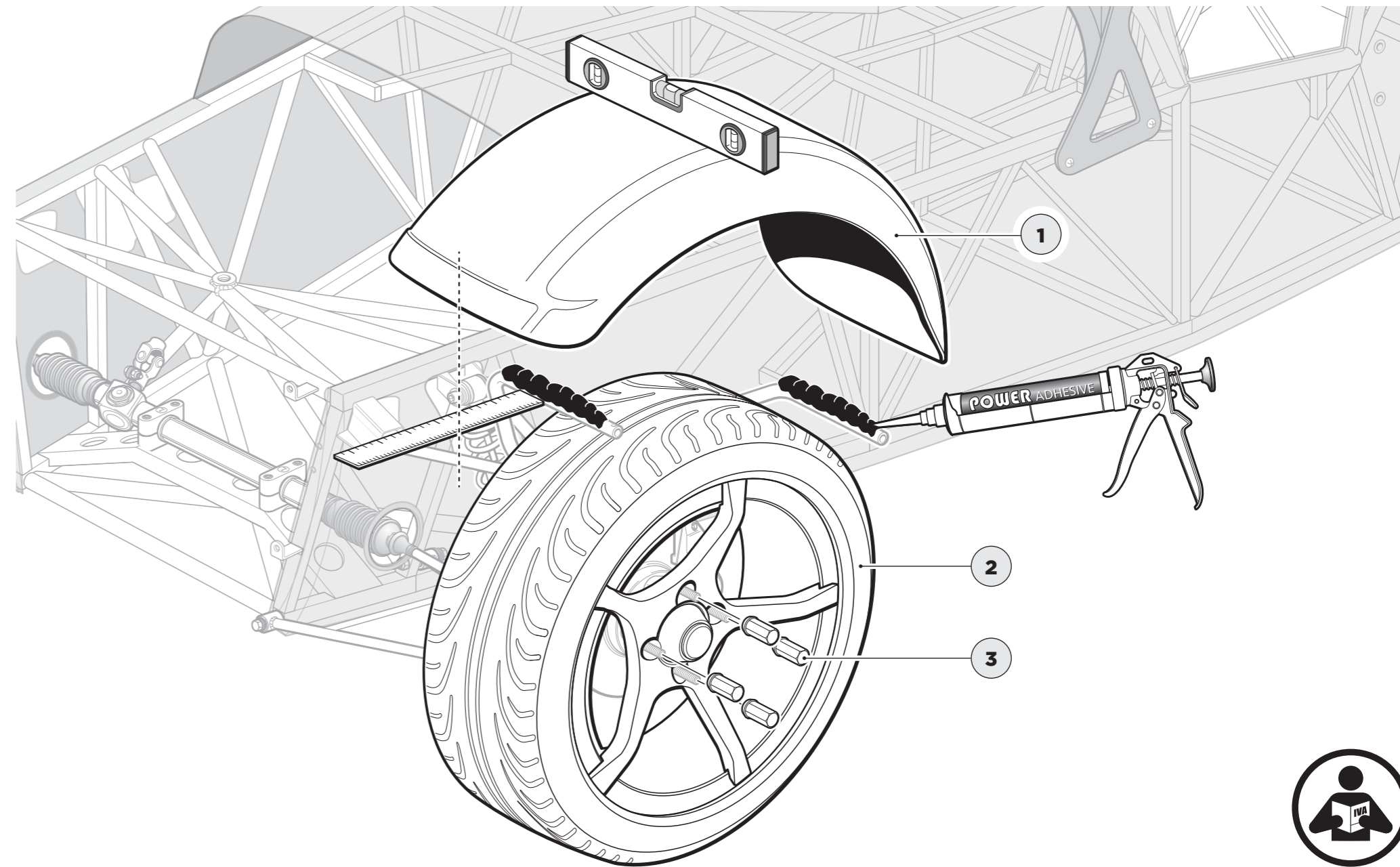
You may need to bend the arms of the wingstay to make the wing level.
Anthony L

The $\frac{1}{8}$ " hole you drilled earlier is for the indicator earth.
Harry P

The distance from the front edge of the wing to the wingstay should be 80mm.
Lee A

Do a 'dry run' first to make sure the wings are level before using power adhesive.
Chris N

JUST WING IT



TAPE IN PLACE FOR 24 HOURS

PARTS

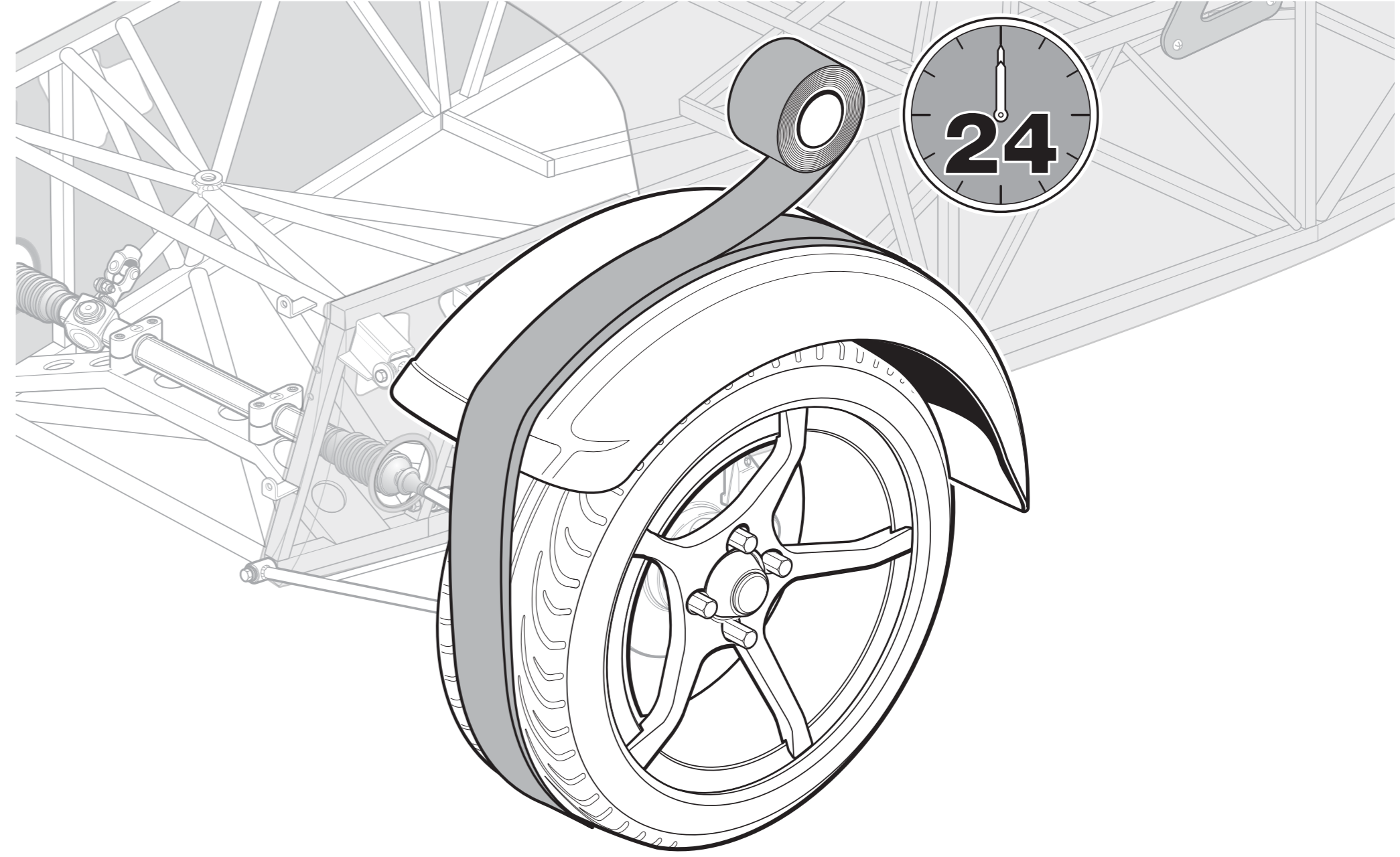


TOOLS

FIXINGS

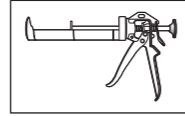
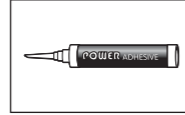
TIPS

TAPE IN PLACE FOR 24 HOURS



SOME EXTRA ADHESIVE UNDERNEATH

PARTS



FIXINGS

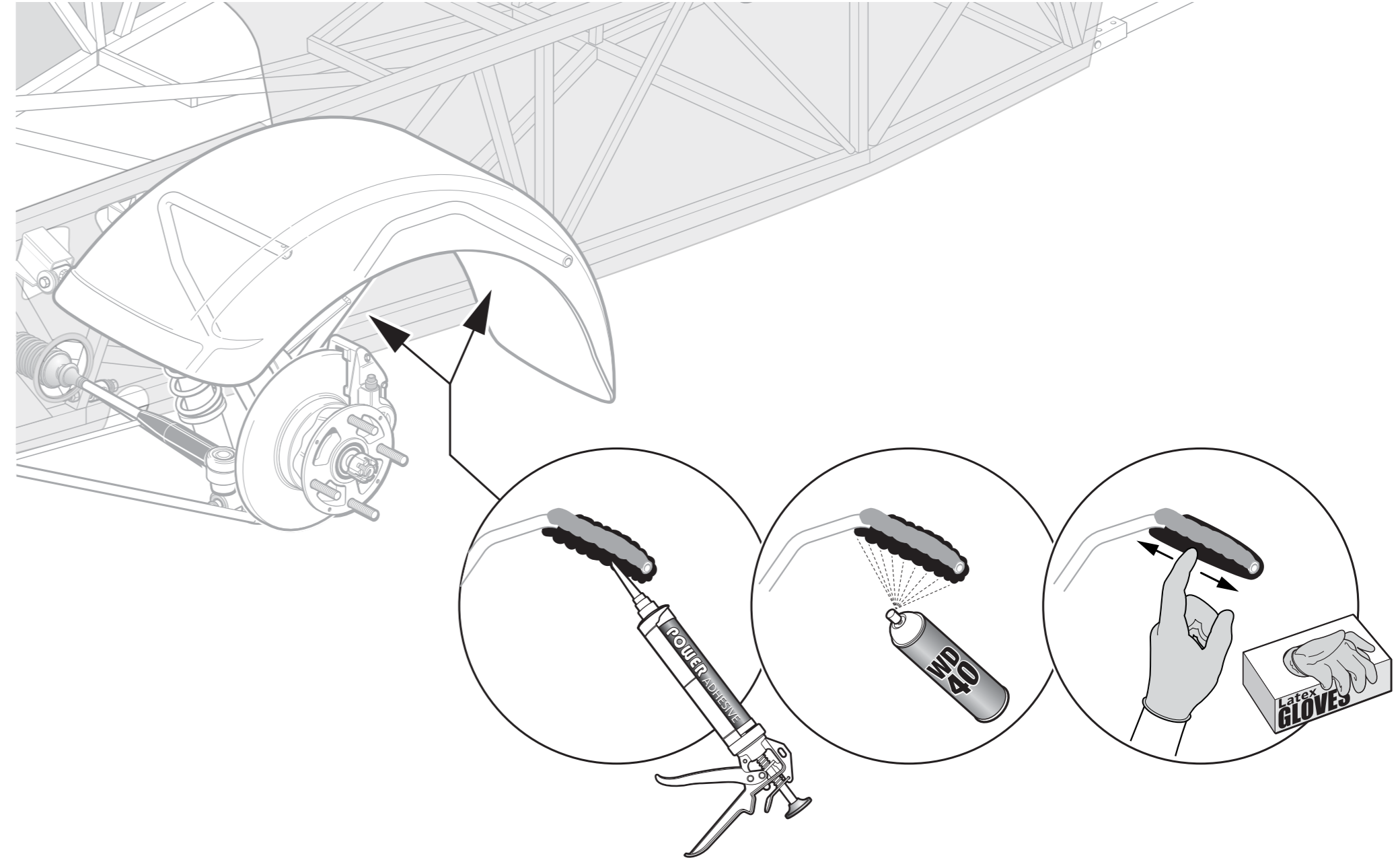
TOOLS

TIPS

The WD40 will help spread the adhesive.

Mick F

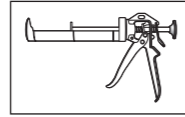
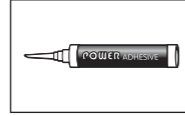
JUST WING IT



FINISH WITH TRIM

PARTS

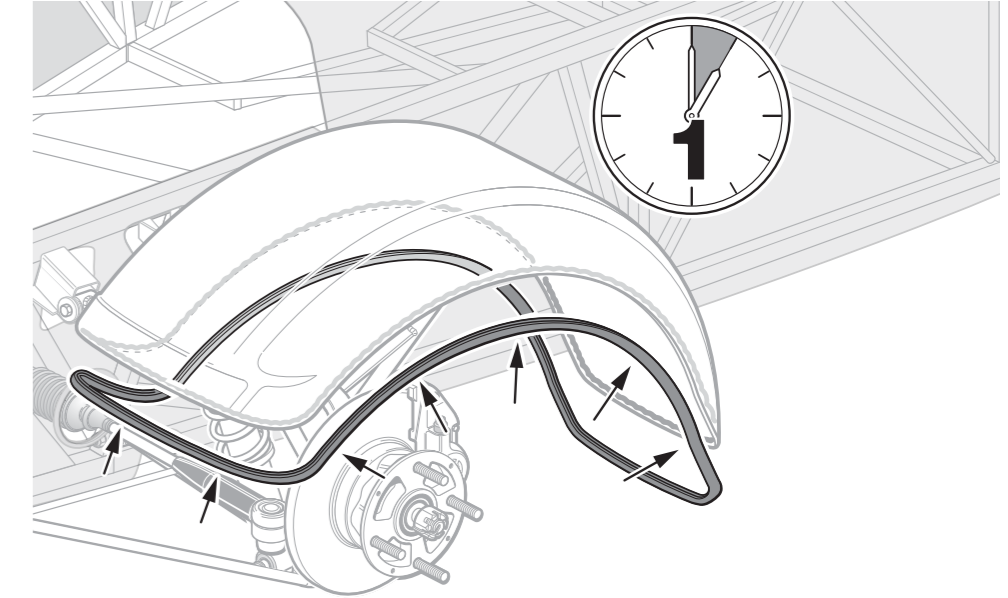
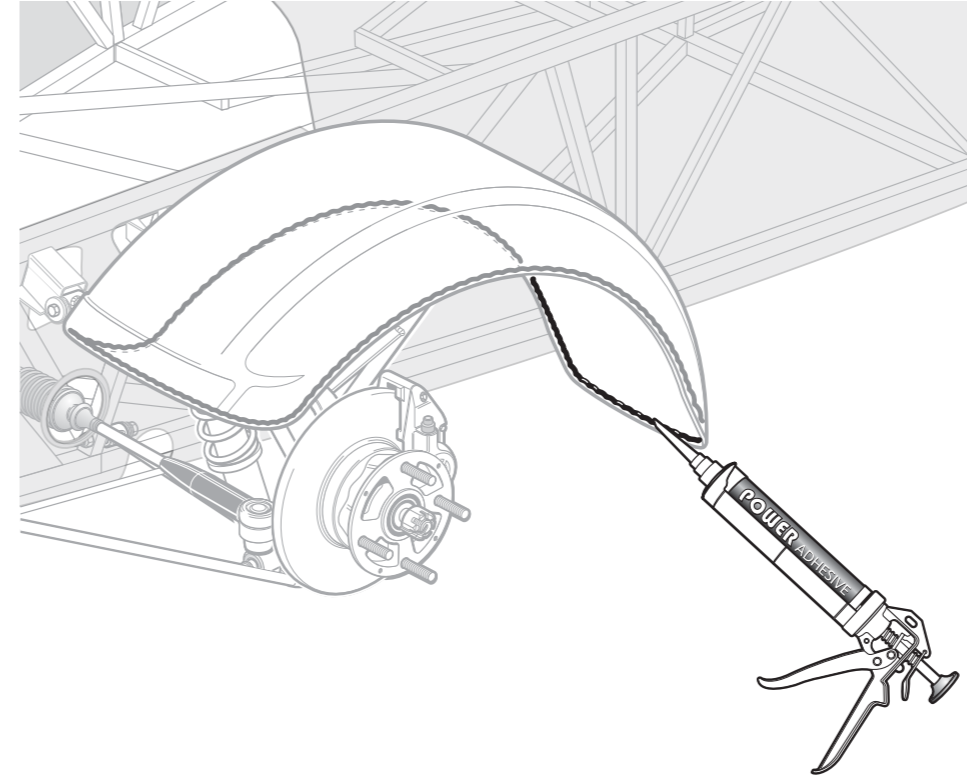
TOOLS



FIXINGS

TIPS

FINISH WITH TRIM

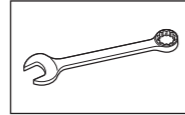
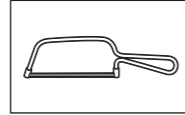


FITTING THE REAR WINGS

PARTS

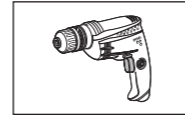
1 Rear wing

TOOLS



8mm

8mm



to follow

Sanding Drum

FIXINGS

Pack Q		CATERHAM		31		
		PACK NUMBER		27612		
REAR WINGS						
This pack may include extra fasteners to cover different options						
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION	
1	QA	SAE Bolt M8 x 20	SM8320	20	Rear Wings	
2	QB	Nut M8	MM815	10	Rear wings through body	
3	QC	Plain Washer 5/16" x 3/4"	W516X34	30	Wing washers	
4	QD	Wing Pairs 1/4" x 1"	7692	48	Between wing and body	

x20

x10

x30

x4

TIPS

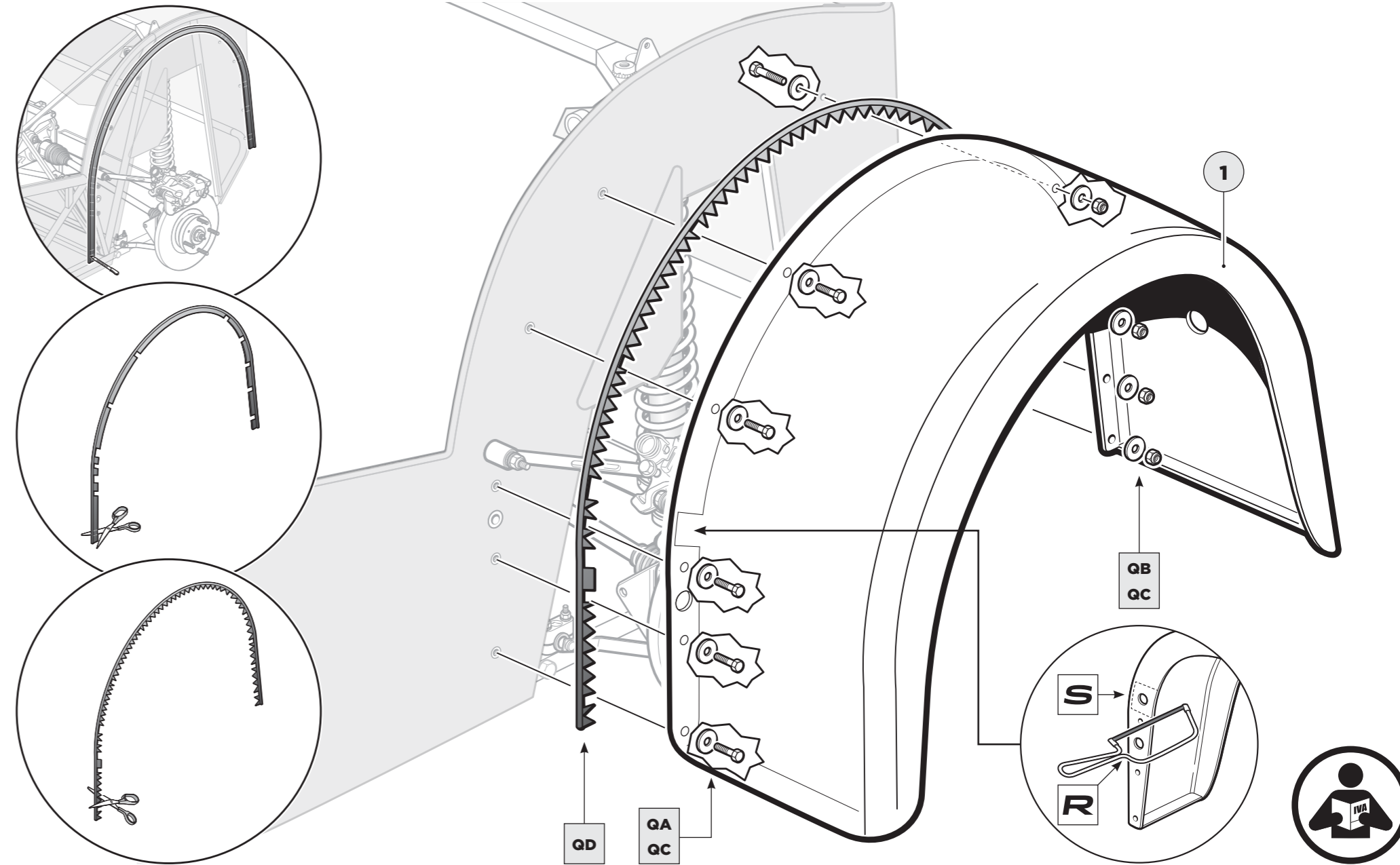
Cut the supplied piping in half and it will be enough for both wings.

Rich T

Don't forget the fuel tank earth strap gets bolted to the RH wing bolt.

Tiago O

FITTING THE REAR WINGS

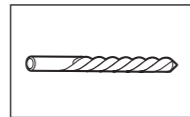
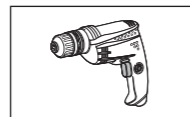
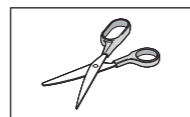


AND THE WING PROTECTORS

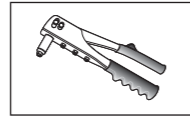
PARTS

1 Wing protector

TOOLS



1/8"



FIXINGS

For stainless steel protectors

Pack O		CATERHAM		PART NUMBER	
				ZW501	
WING PROTECTORS STAINLESS STEEL					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	CA Flat 1/8" x 3 1/2"	1610-0144	30	Wing protector to wing	
2	CB Wing Pairs	7801	2m	Between wing protector and wing	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 1

For carbon fibre protectors

Pack P		CATERHAM		PART NUMBER	
				ZW502	
WING PROTECTORS CARBON FIBRE					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	PA Flat Bolt 1/8" x 3 1/2"	1610-0144	30	Wing protector to wing	
2	FB Wing Pairs	7801	2m	Between wing protector and wing	

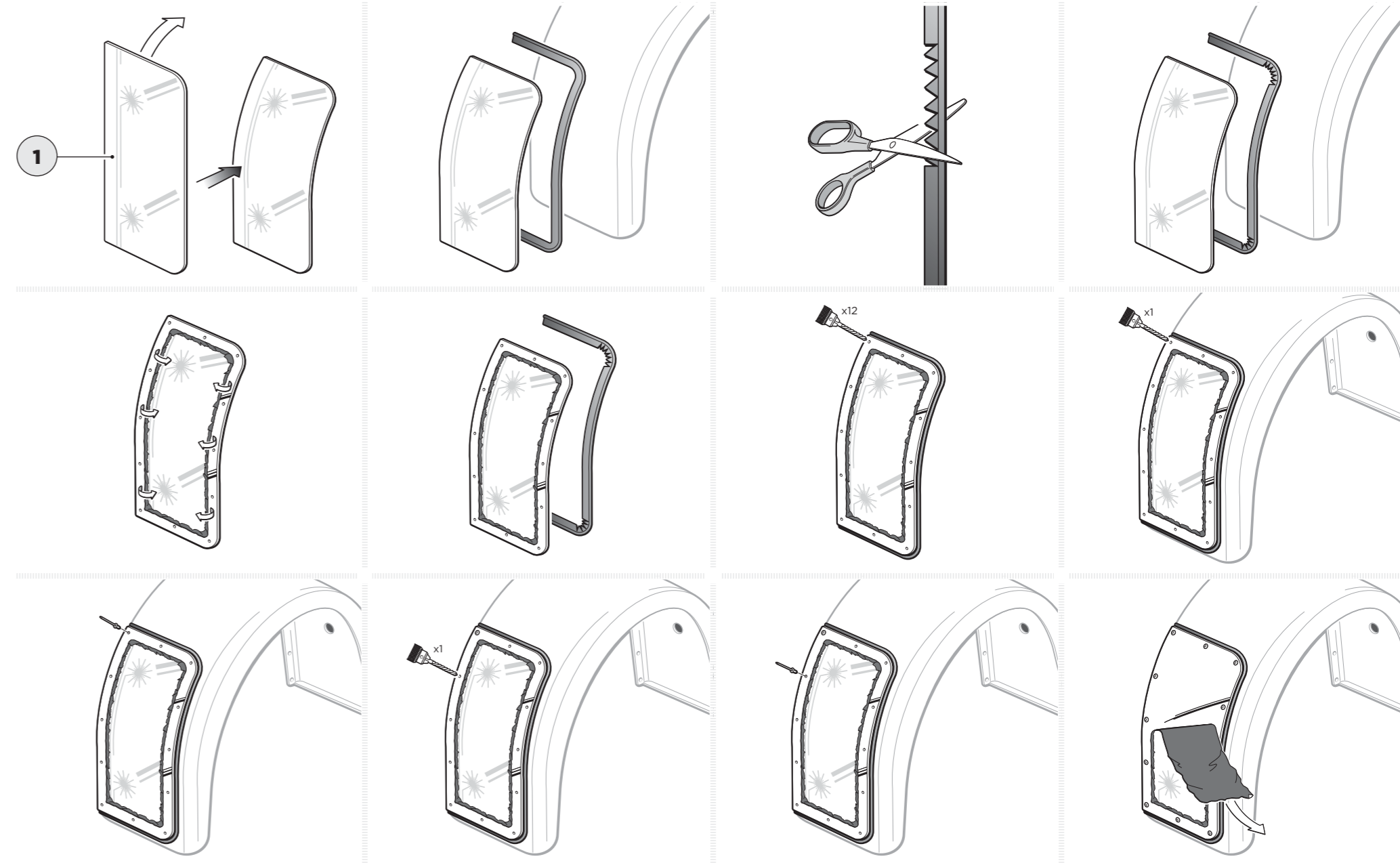
Drawings are for illustrative purposes only and are not to scale. Page 1 of 1

TIPS

When drilling through protector start on the closest edge to the body. This will help the protector fit correctly.
Chris B

Carbon fibre protectors will not have the protective film shown.
Anthony L

AND THE WING PROTECTORS

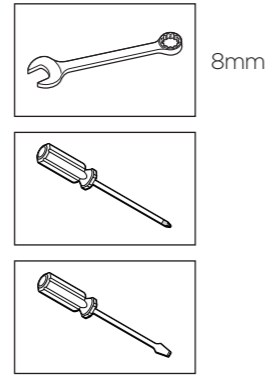


FITTING THE LIGHTS

PARTS

- 1** Side repeater
- 2** Rear light
- 3** Numberplate lamp

TOOLS



FIXINGS

Pack C		CATERHAM		45	
		FASTENER PACK - LIGHTING		302.002B	
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
CA	Socket 12 x 1/4" Hex Screws	71079	4	Rear light assembly to indicator post	
CB	Socket 12 x 1/4" Hex Screws	71079	2	Side repeater with wingstay	
CC	Socket 12 x 1/4" Hex Screws	71079	4	Rear light cluster upper fixing	
CD	Socket 12 x 1/4" Hex Screws	71079	4	Rear light cluster lower fixing	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 1

x4

x4

TIPS

Use a cradle clip & cable tie to keep the rear light loom out of the way.

John S

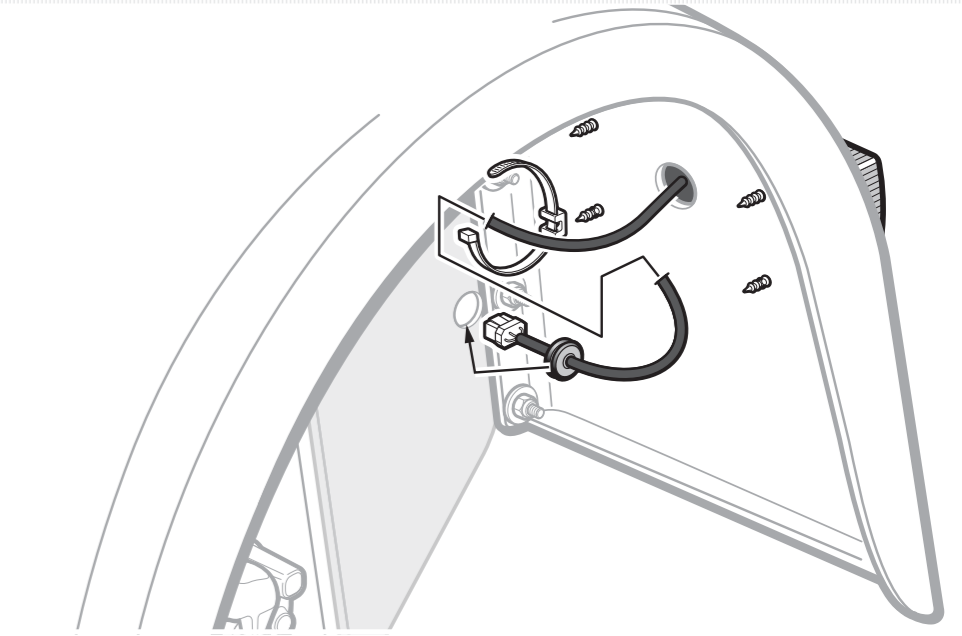
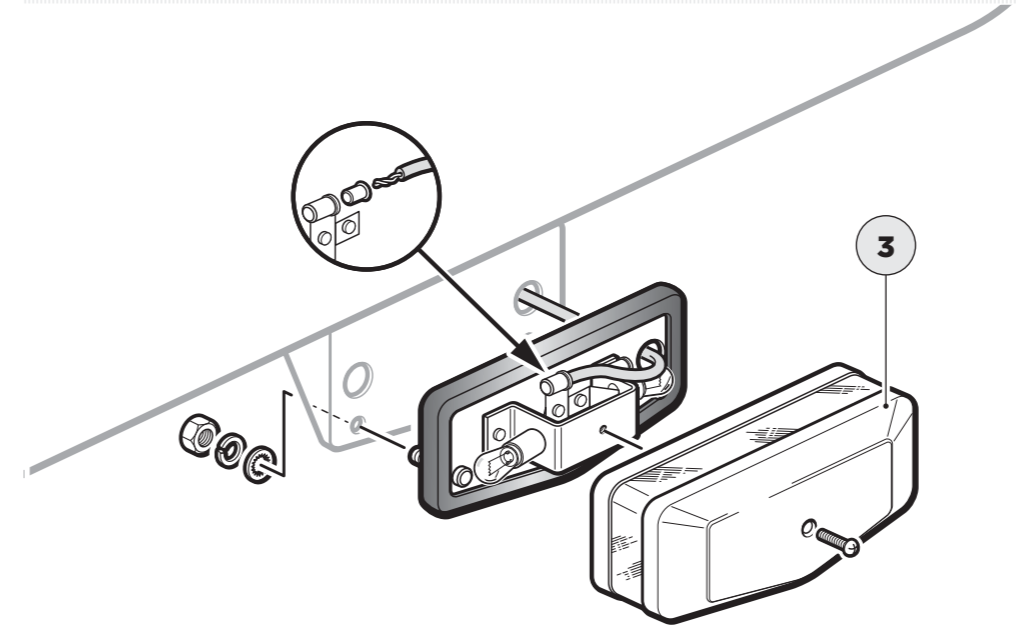
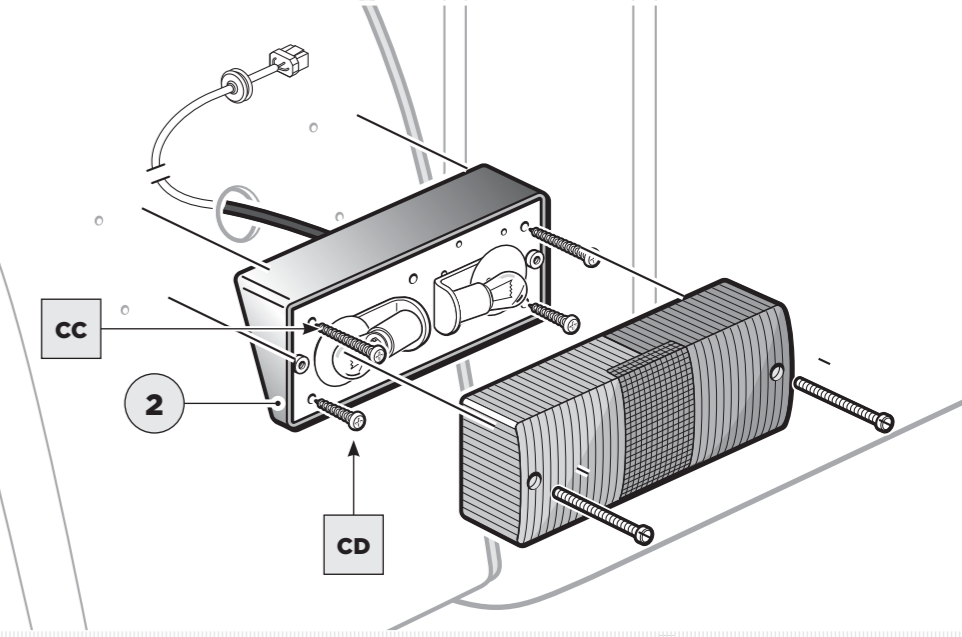
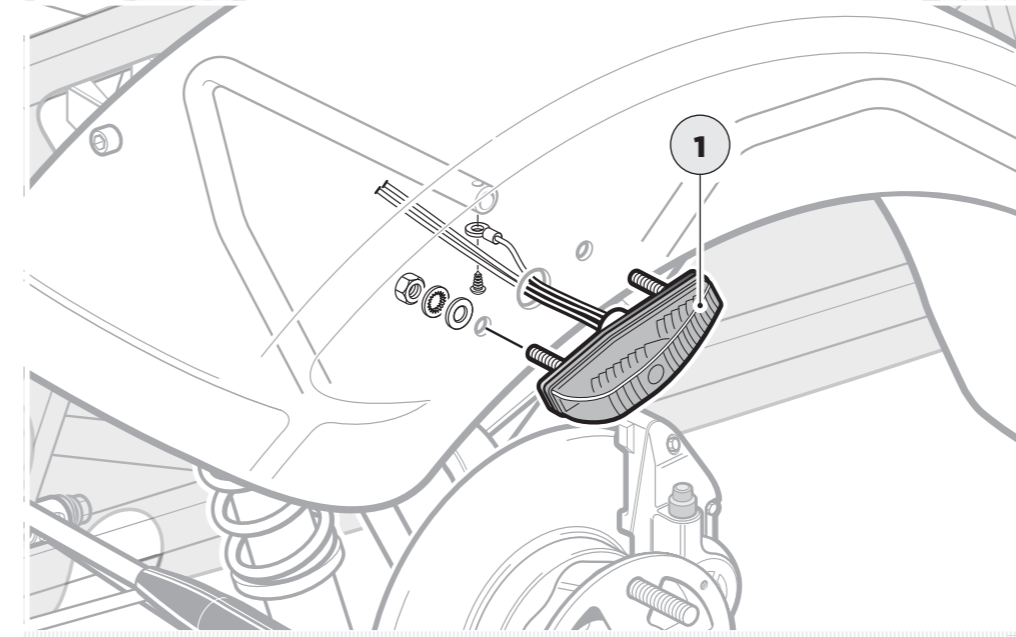
Rubber grommet on rear light goes in the body not the wing.

Jamie A

Indicator repeater wires go through the wingstay.

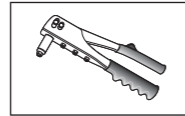
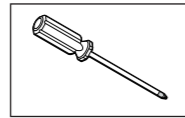
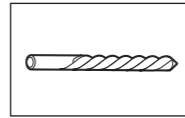
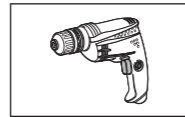
Chris B

FITTING THE LIGHTS



FUSE BOX COVER & KNEE TRIM PADS

PARTS



FIXINGS

Chassis fastener pack ZCH01 supplied loose:

- Screw 3/4" x 10
- Rivet 5/32 x 0.47"

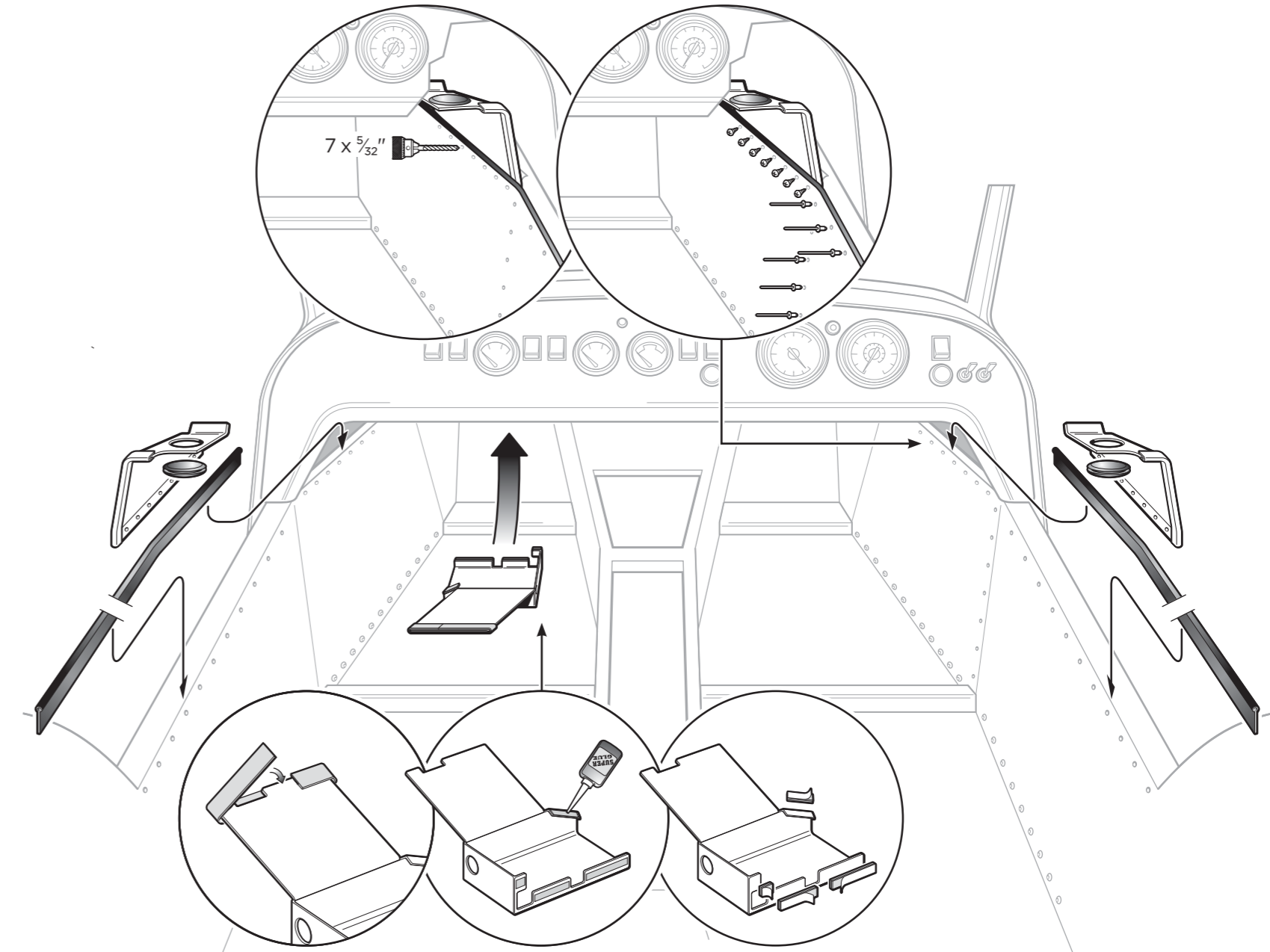
TOOLS

TIPS

Building an Academy Car? If so you'll need to leave the riveting-in of the side panels until after you've fitted the roll cage (p154-155) as the front legs go behind the panel, not over the top of it.

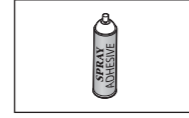
John S

FUSE BOX COVER & KNEE TRIM PADS



FIT THE TUNNEL CARPET

PARTS



TOOLS

FIXINGS

TIPS

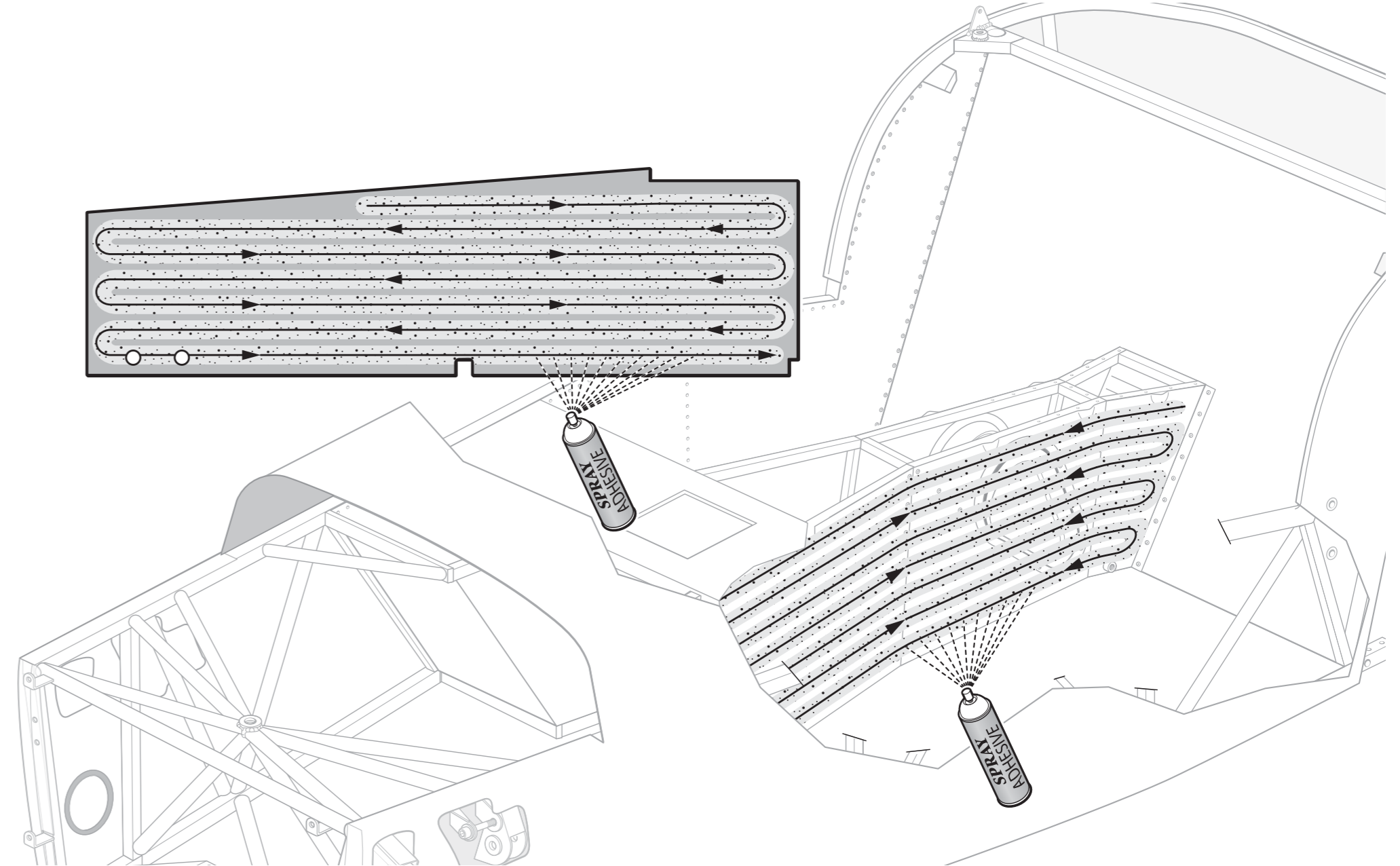
Spray on both tunnel panel and carpet.

John K

Allow the adhesive to go tacky before fitting.

Harry P

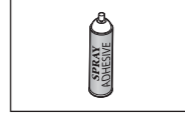
FIT THE TUNNEL CARPET



AND THE BOOT CARPET

PARTS

TOOLS



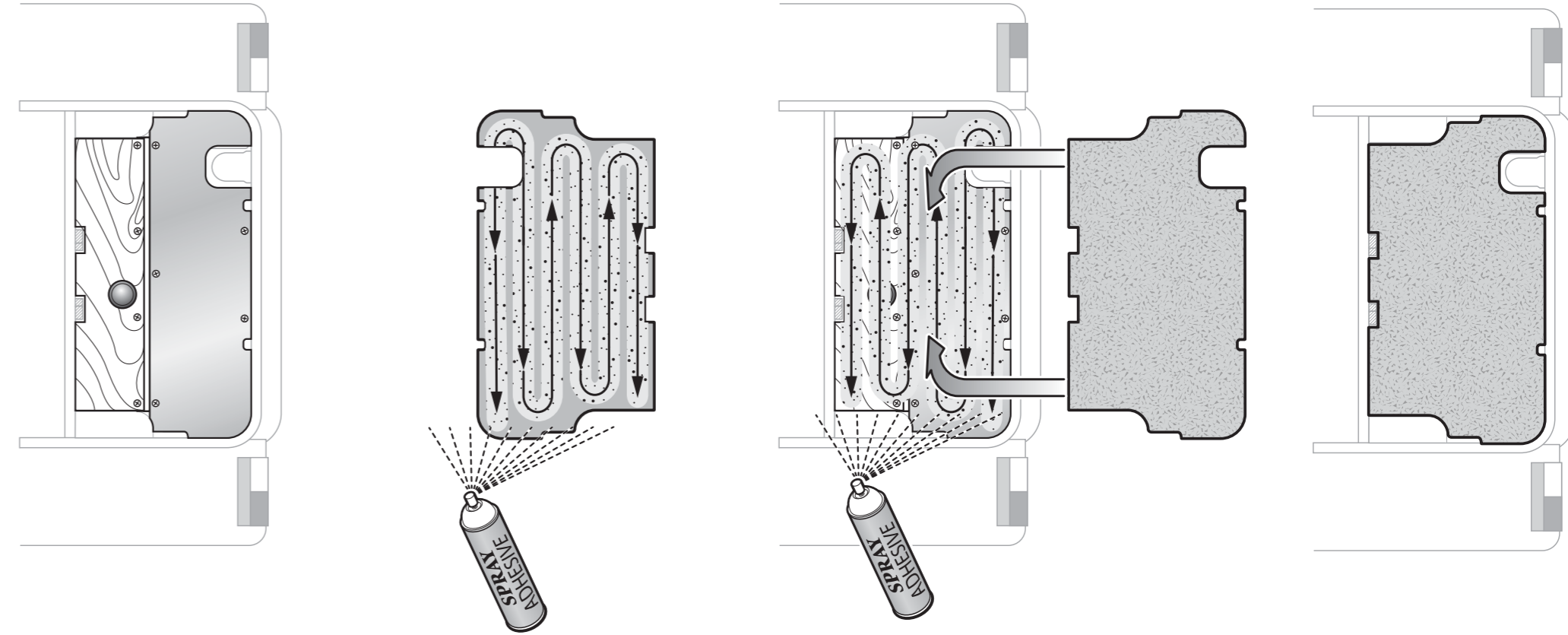
FIXINGS

TIPS

S-Pack cars have a fully carpeted boot. It's something of a jigsaw pattern, but the parts are simply glued in place like the bigger bits.

John S

AND THE BOOT CARPET

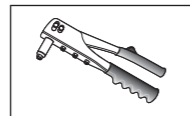
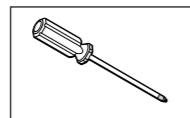
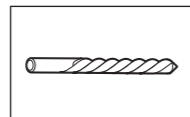


THIS IS A COVER UP

PARTS

- 1 Fuel filler cove
- 2 Tunnel closing panel

TOOLS



FIXINGS

Supplied loose:

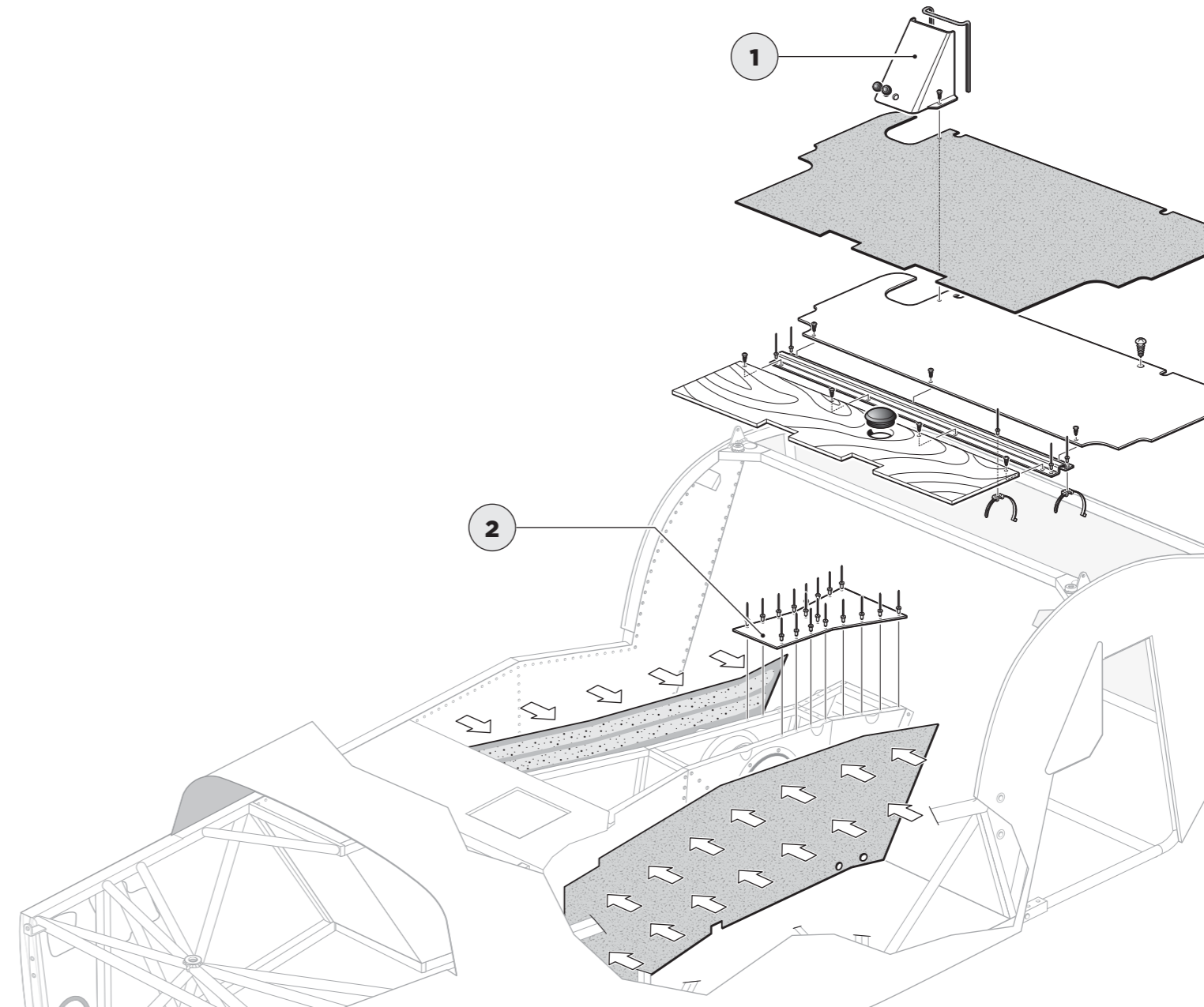
- Rivets
- Screws

TIPS

The fuel filler cover just screws to the boot floor.
Drill two holes and use self tapping screws.

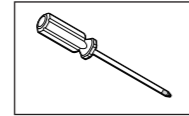
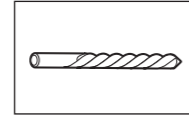
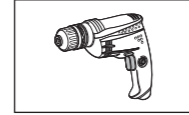
Rich T

THIS IS A COVER UP



NOW FIT THE TUNNEL TOP

PARTS



1/8"

FIXINGS

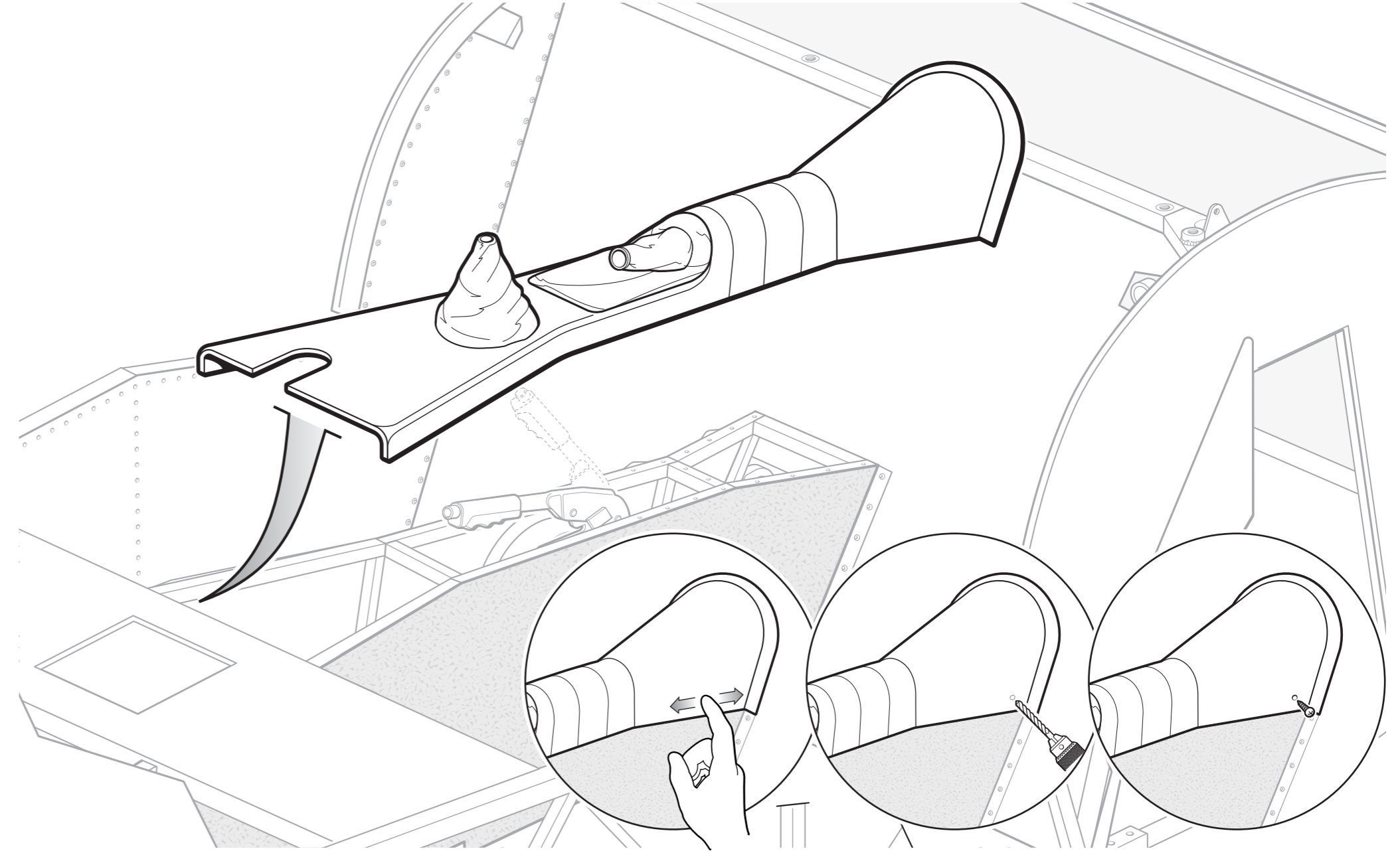
TOOLS

TIPS

The hole can be seen if you flip the tunnel top over.

Mick F

NOW FIT THE TUNNEL TOP



BELT UP

PARTS

TOOLS



FIXINGS

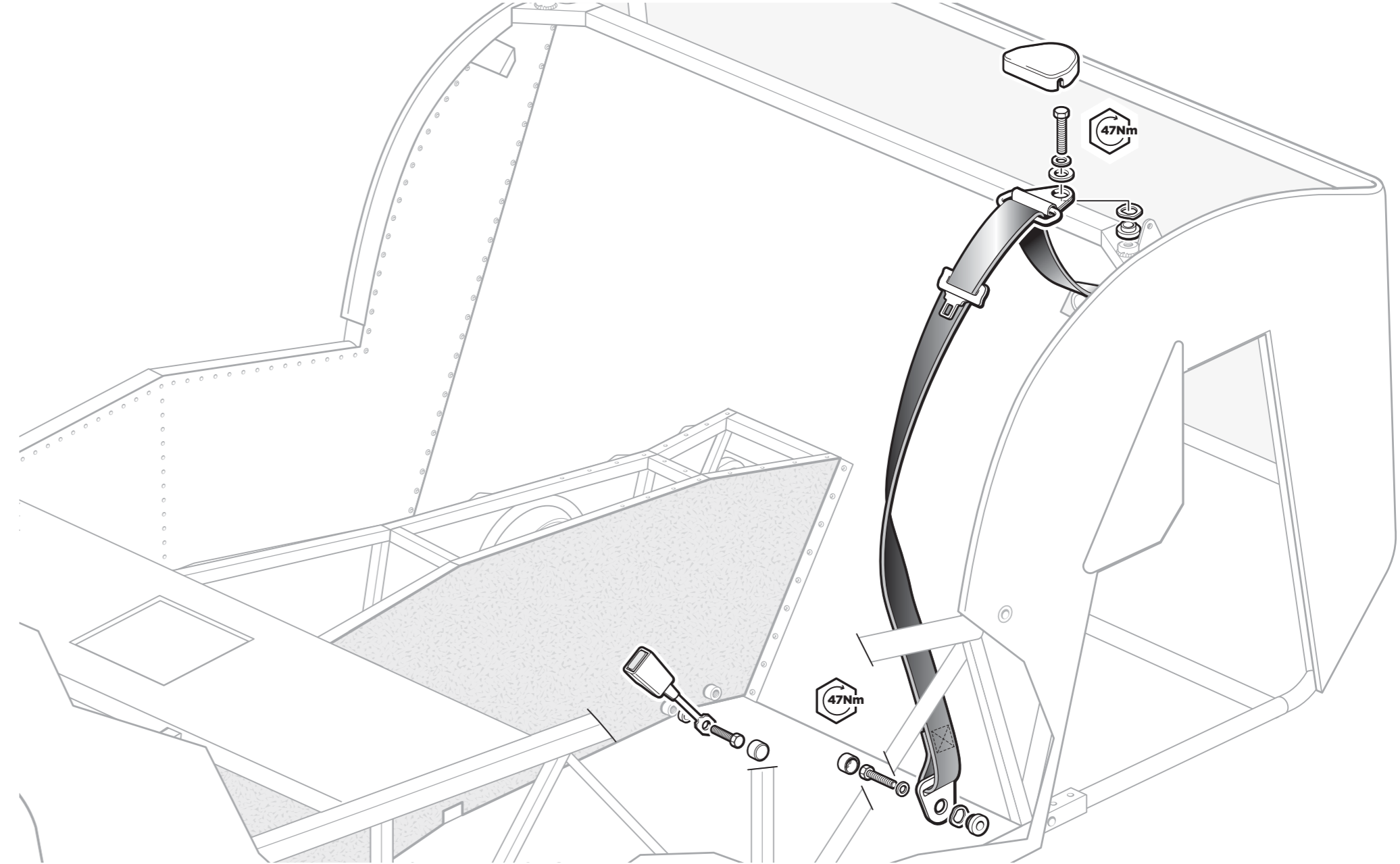
TIPS

Supplied with seat belts

These will be loosely fitted already – you'll need to tighten & torque.

Chris N

BELT UP



FITTING THE FOUR-POINT HARNESS

PARTS



17mm



TOOLS

FIXINGS

All fixings supplied with the harnesses

TIPS

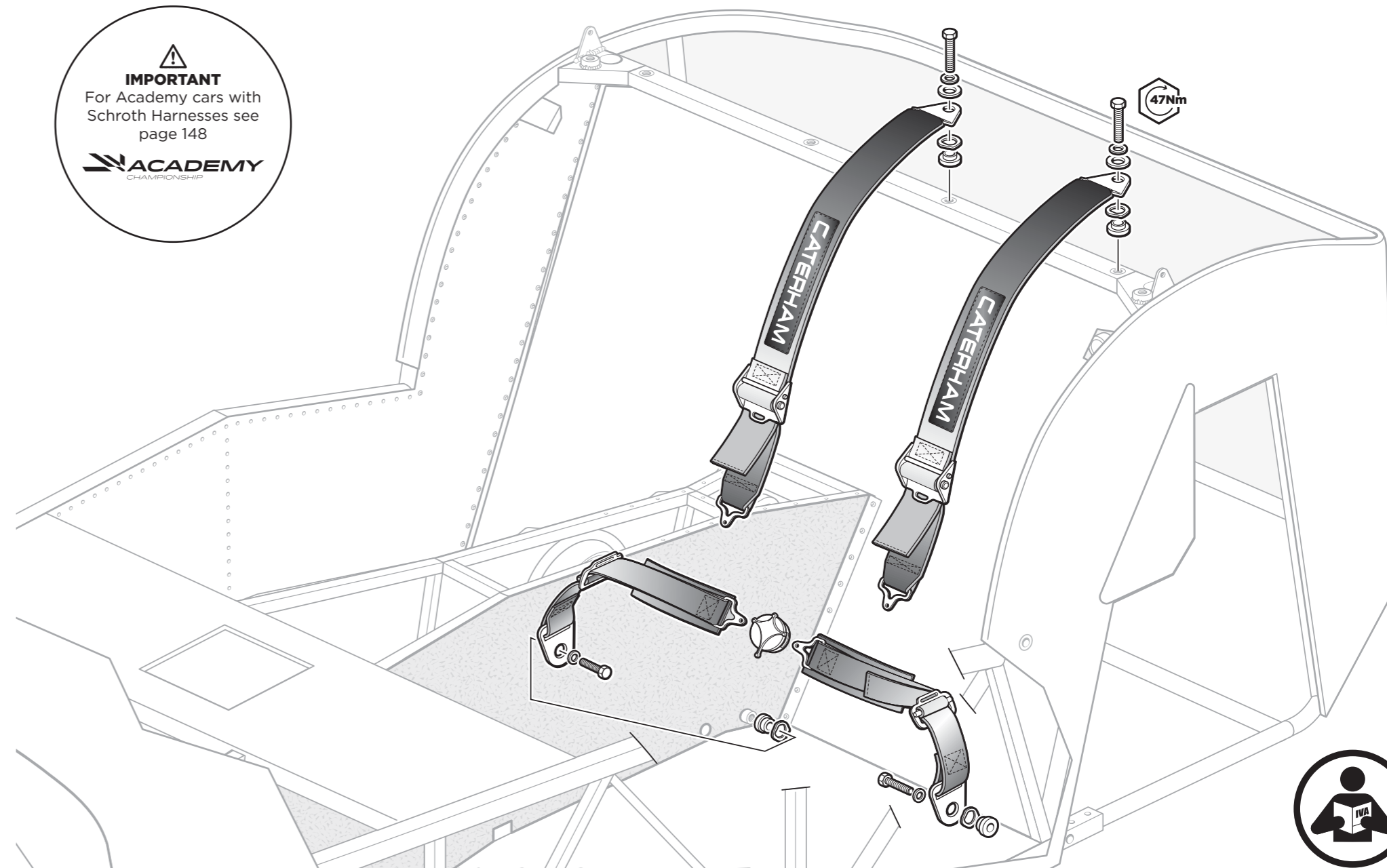
The buckle is attached to a lap strap and this should be fitted to the tunnel side.

Chris N

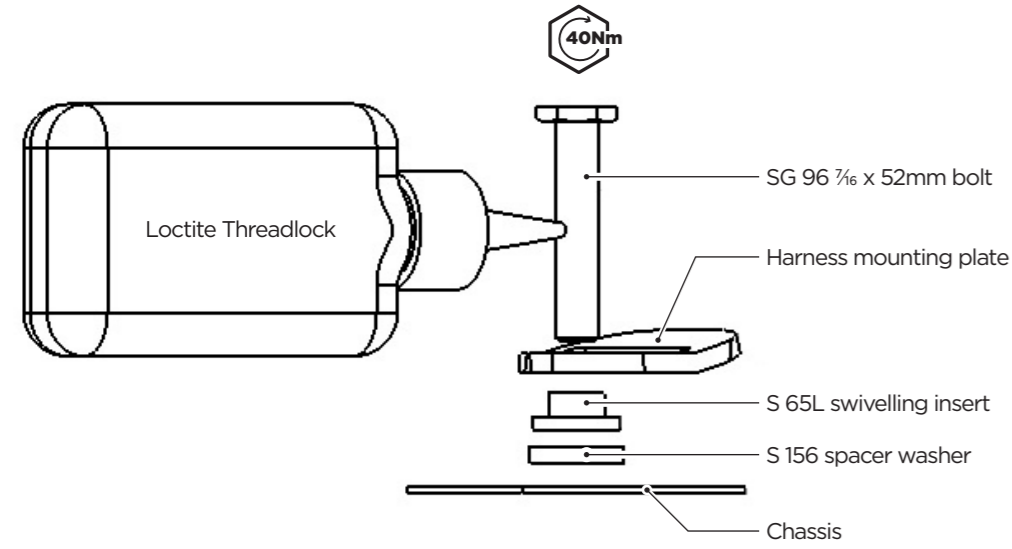
For Academy cars with Schroth Harnesses see Page 148.

Dan P

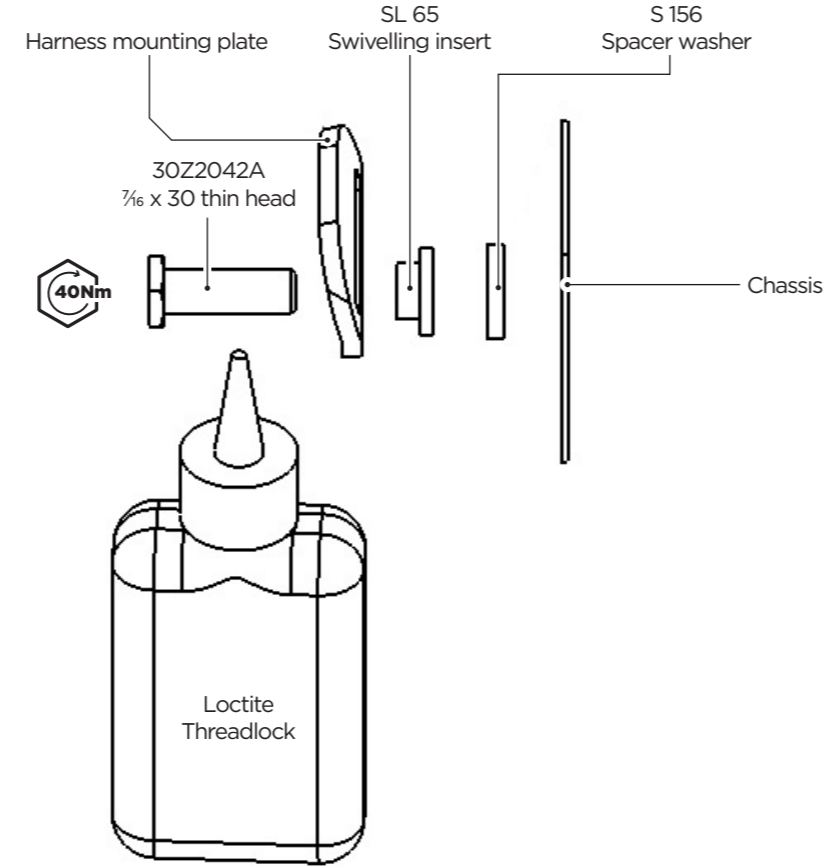
FITTING THE FOUR-POINT HARNESS



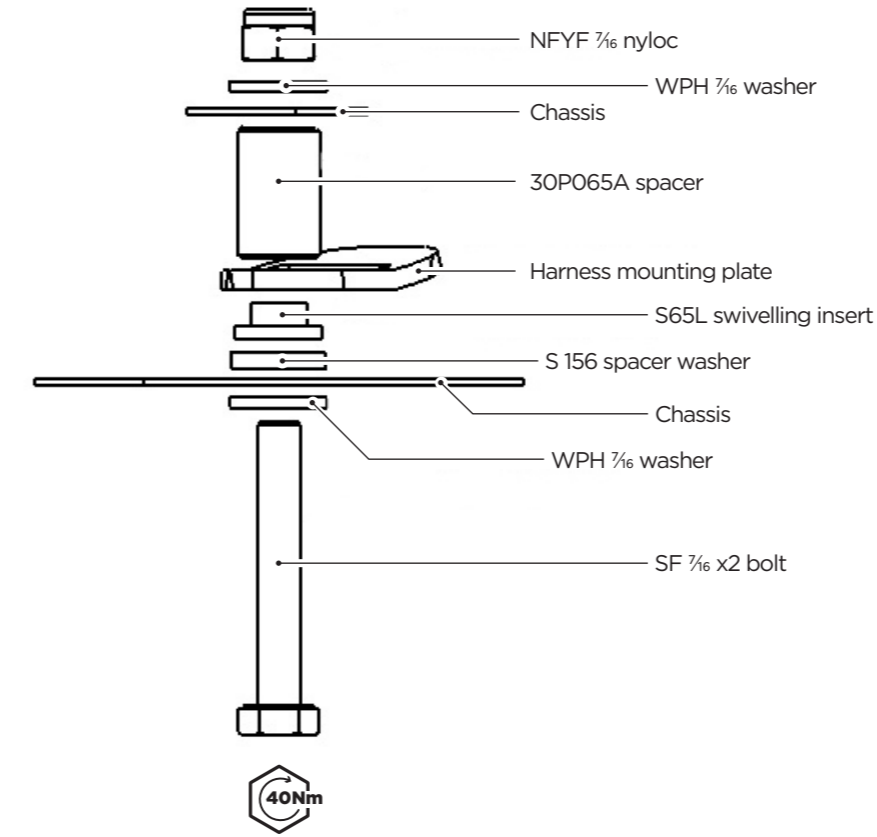
SHOULDER STRAP MOUNTING ORIENTATION



WAIST STRAP MOUNTING ORIENTATION



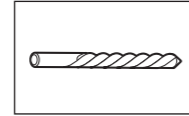
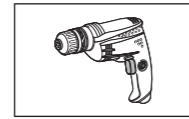
CRUTCH STRAP MOUNTING ORIENTATION



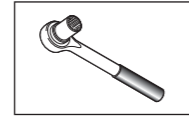
FITTING THE SIX-POINT HARNESS

PARTS

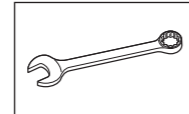
TOOLS



7/16"



16mm
17mm



16mm
17mm

FIXINGS

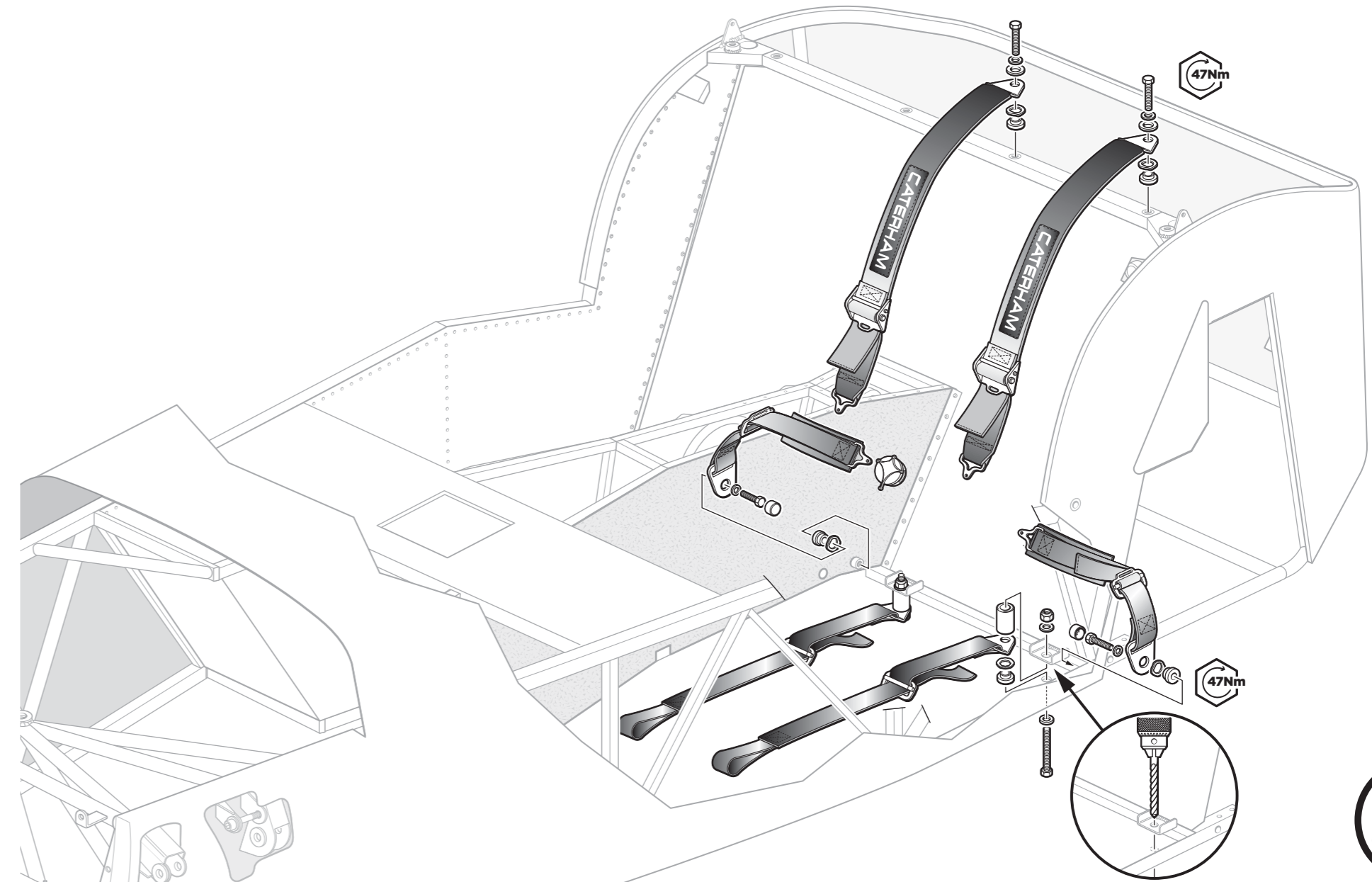
All fixings supplied with the harnesses

TIPS

The buckle is attached to a lap strap and this should be fitted to the tunnel side.

Lee A

FITTING THE SIX-POINT HARNESS

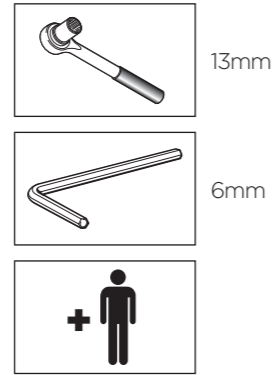


FITTING CLOTH OR LEATHER SEATS

PARTS

- 1** Seat
- 2** Seat base
- 3** Headrest

TOOLS



FIXINGS

Pack L		CATERHAM		62	
		PACK NUMBER		3A21048B	
CLOTH/LEATHER SEATS ALL CARS					
This pack may include extra fasteners to cover different options					
ITEM	PART NUMBER	QTY	USED ON	ILLUSTRATION	
1	LA	4	Through seat runner & floor		
2	LB	4	Under floor		
3	LC	4	Under floor		

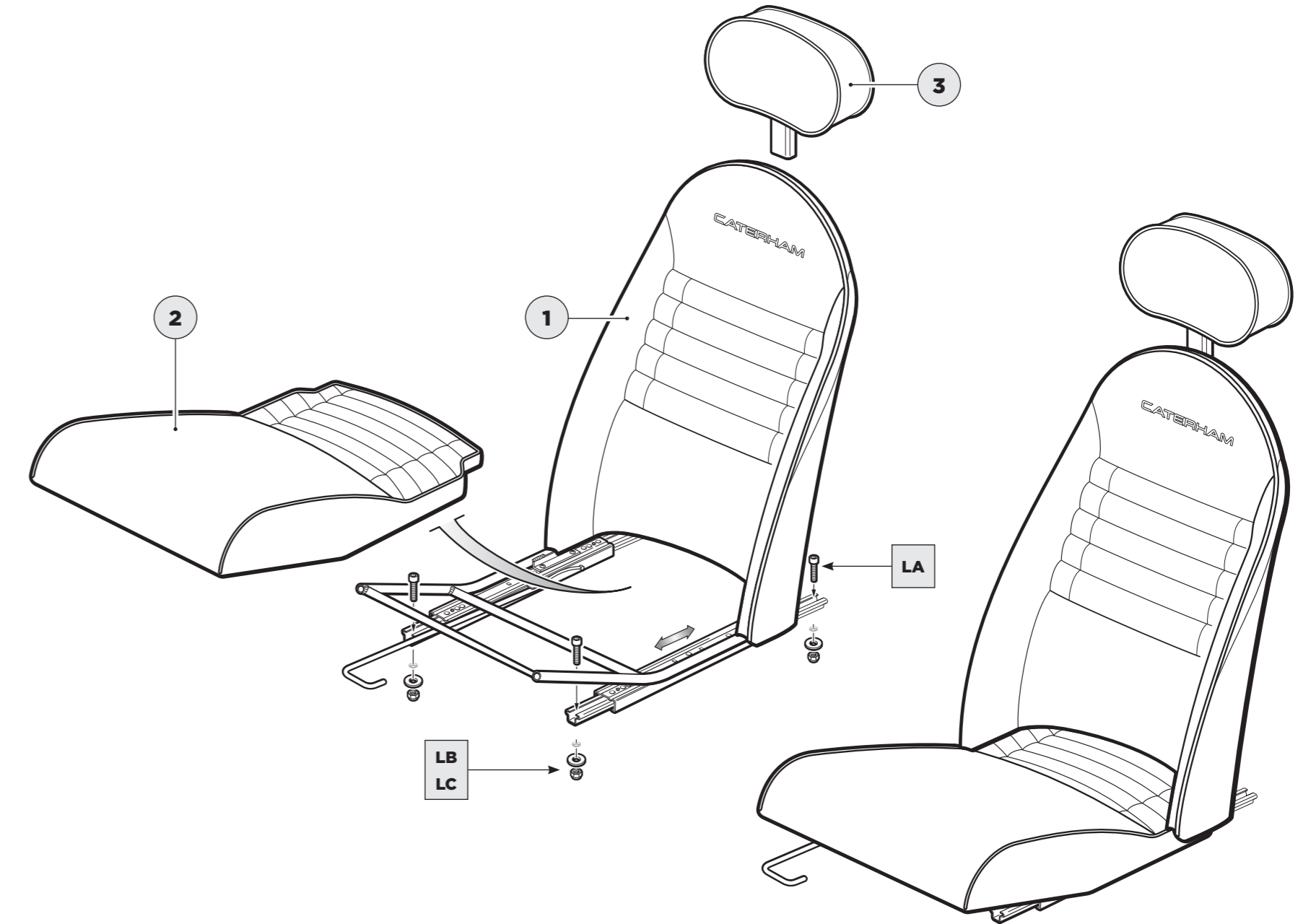
x4
x4
x4

TIPS

Loosely fit the rear bolts to help locate the front.
Dan D

Nip up all bolts once fitted.
Anthony L

FITTING CLOTH OR LEATHER SEATS

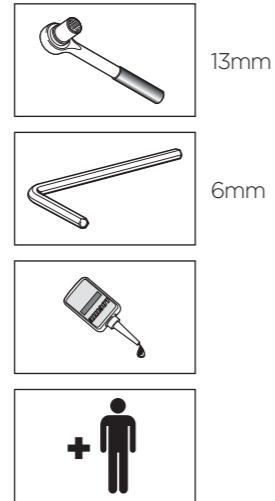


OR FITTING THE RACE SEATS

PARTS

- 1 Seat
- 2 Adjustable runner
- 3 Fixed seat spacer

TOOLS



FIXINGS

For fixed seats

ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION	
1	Cuphead Bolt M8 x 20	8MCH623	4	Spacer box section to seat		x4
2	Cuphead Bolt M8 x 20	8MCH623	4	Floor to mount in spacer box section		x4
3	Spring Washer 5/16"	W516/16	8	Bolt heads		x8
4	Washer 5/16" x 1 1/4"	W516X1 1/4	4	Under floor		x4
5	Washer M8 x 16	W8M816A1	4	Spacer box section to seat		x4
7	Spacer Block Plastic	T93	3	Seat spacer		x3
8	Spacer Block Plastic	T93	5	Seat spacer		x5

For adjustable seats

ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION	
1	Cuphead Bolt M8 x 20	8MCH623	4	Runner to seat		x4
2	Cuphead Bolt M8 x 20	8MCH623	4	Runner to floor		x4
3	Washer 5/16" x 1 1/4"	W516X1 1/4	4	Under floor		x4
4	Nylon Nut M8	NM8F8	4	Under floor		x4
5	Spacer Block Plastic	T92	3	Seat spacer		x3
6	Spacer Block Plastic	T93	5	Seat spacer		x5

TIPS

Put a bit of Loctite on bolts that go into the seat on the runner version.

Chris B

Loosely fit the rear bolts to help locate the front.

Harry P

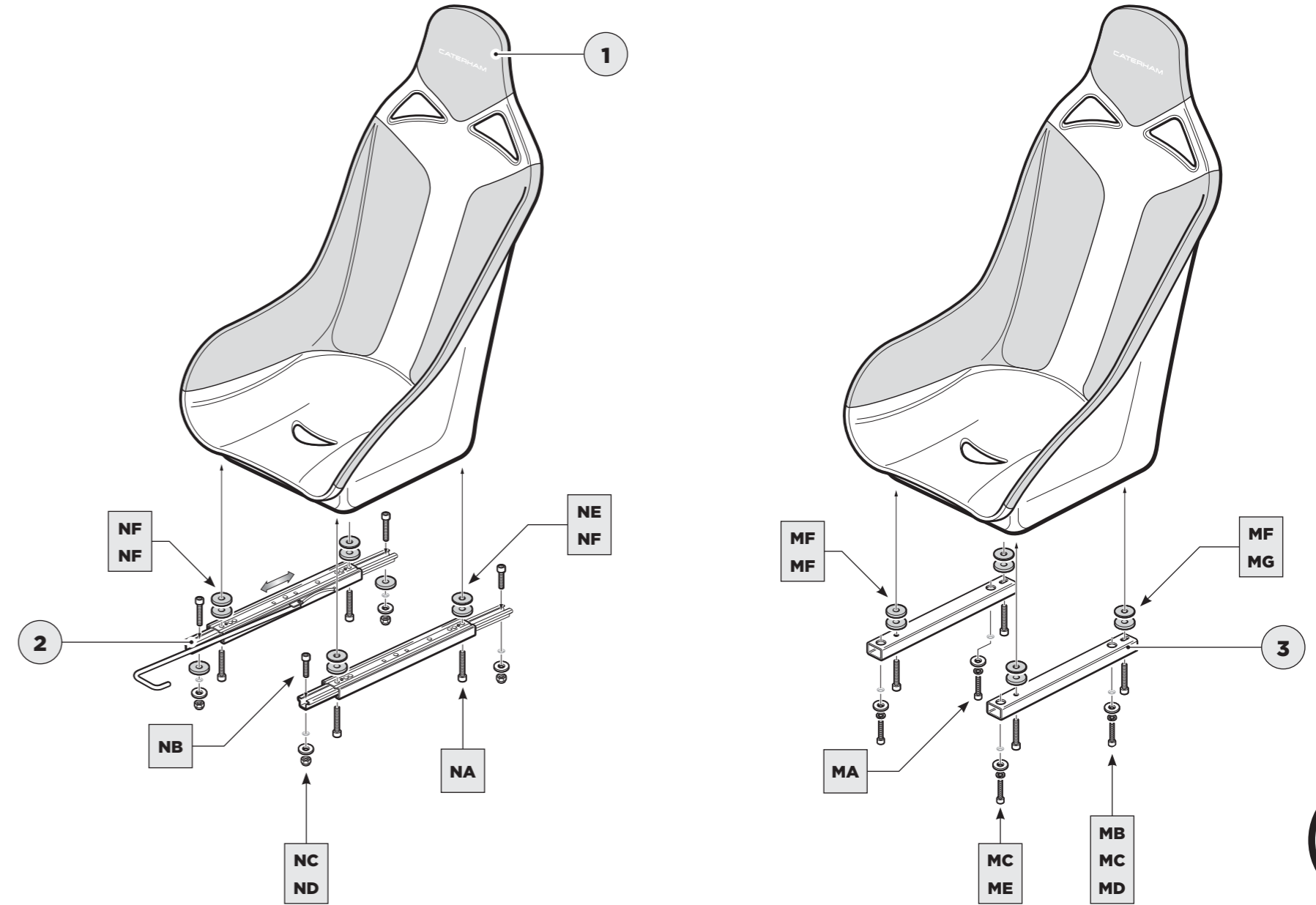
The fixed position seat is for the passenger side!

Chris N

Runners / seat spacers can be fitted to seat before putting in car.

Mick F

OR FITTING THE RACE SEATS

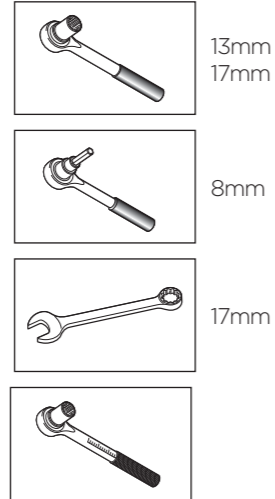


FITTING THE ROLL OVER BAR

PARTS

1 Roll over bar

TOOLS



FIXINGS

Pack J		CATERHAM		47	
ROLL OVER & TRACK DAY BAR SERIES 3 METRIC		PACK NUMBER		30P18A	
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	JA Roll over bar 1400 Series 3.3	BM1000	2	Rear diagonals of roll over bar to mounting brackets	
2	JB Roll over bar bracket to chassis	SM800	3	Roll over bar bracket to chassis	
3	JC Caphead Bolt M10 x 20	MC3000	2	Roll over bar boss	
4	JD Nylon Nut M10	NM10	2	Rear diagonals of roll over bar to mounting brackets	
5	JE Plain Washer M8	WM8	3	Roll over bar bracket to chassis	
6	JF Spring Washer M8	WSM8	2	Roll over bar bracket to chassis	
7	JG Plain Washer M10	WM10	4	Rear diagonals of roll over bar to mounting brackets	

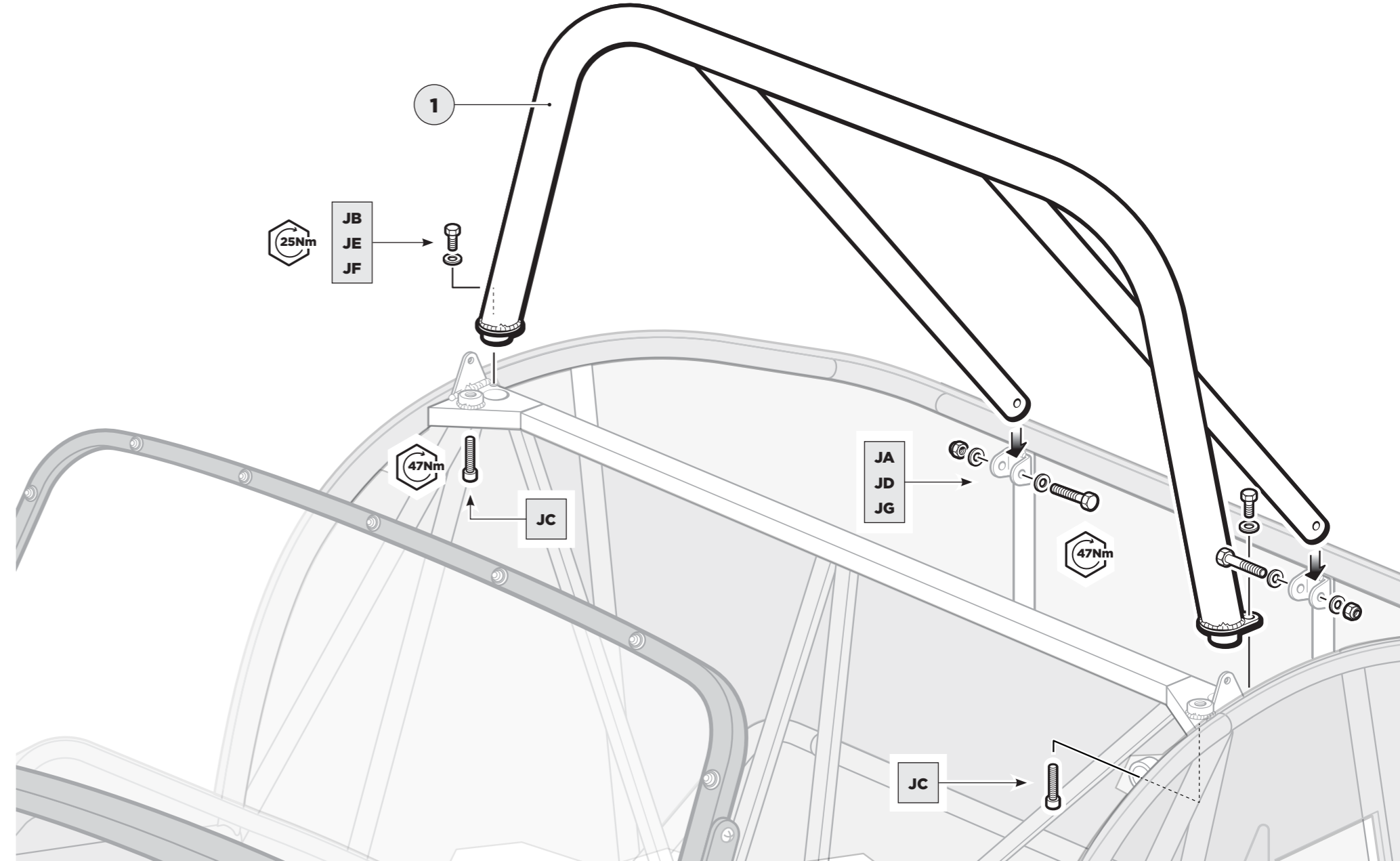
x2
x2
x2
x2
x2
x2
x4

TIPS

If you've fitted the rear dampers they'll need to come off again to do this properly.

Chris B

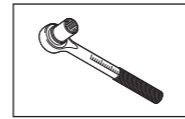
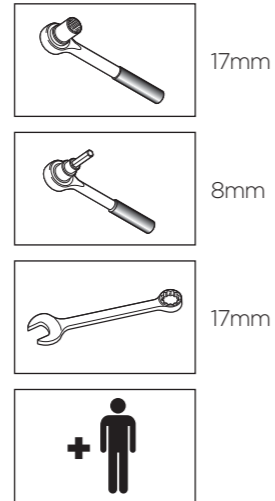
FITTING THE ROLL OVER BAR



OR THE ROLL CAGE FOR ACADEMY CARS

PARTS

TOOLS



FIXINGS

TIPS

Pack K		CATERHAM		47	
ROLL CAGE SERIES 3 METRIC		PACK NUMBER		SUPERITA	
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	KA Roll over bar Guide 8.8	BM10303	2	Rear diagonals of roll over bar to mounting brackets	
2	KB Front cage bracket	BM10316	4	Front cage bracket	
3	KC Caphead Bolt M10 x 20	BMCH1020	2	Roll over bar boss	
4	KD Nylon Nut M10	BMNF10	2	Rear diagonals of roll over bar to mounting brackets	
5	KE Plain Washer M10	BMFM10	8	4 x Front cage bracket Rear diagonals	

x2
x4
x2
x2
x8

Mask up the paintwork before fitting to avoid scratches.

John S

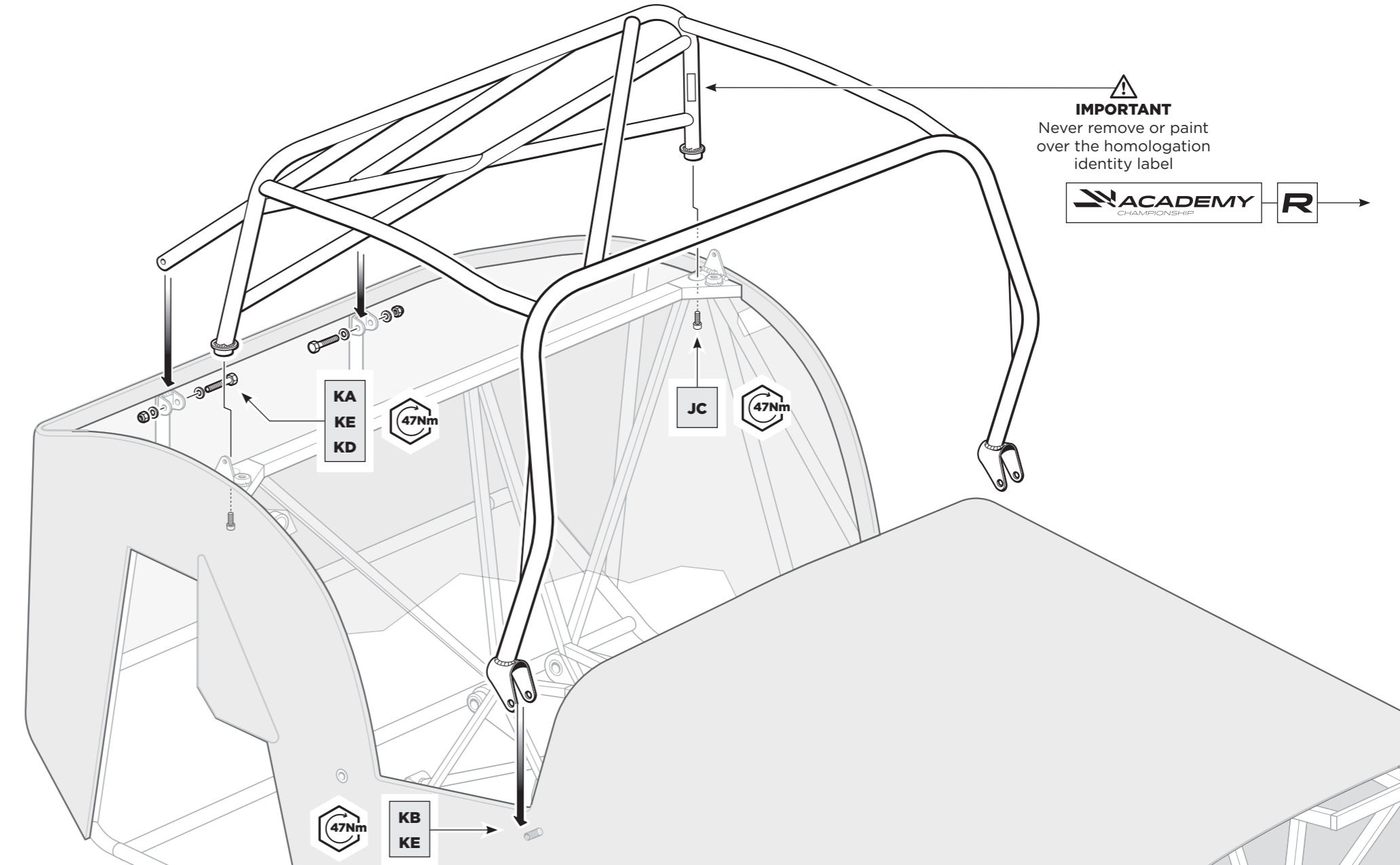
The front leg has two bolts – one from the inside & one from the outside. Great care should be taken to ensure they go in straight.

James A.

The front legs go over the sill and inside the inner panel, not over the panel.

Mick F

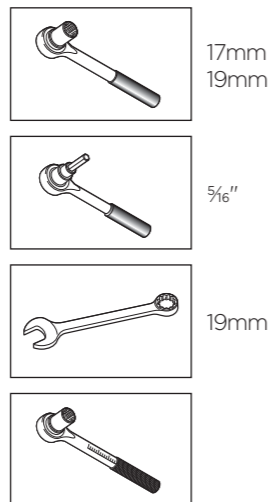
OR THE ROLL CAGE FOR ACADEMY CARS



AND THE SIDE IMPACT BAR

PARTS

TOOLS



17mm
19mm

5/16"

19mm

FIXINGS

TIPS

Pack R		CATERHAM		46	
		PACK NUMBER		30P88C	
SIDE PROTECTION BAR SERIES 3					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Roller 10 x 100 Gauge 10.9	BM12K10	1	A-frame	
2	Catched Bolt 7/16" x 1 1/2"	BF0116x1.5	1	Boots on top of chassis	
3	Std screw M10 x 25, Grade 10.9	BM10X25	1	Front cage bracket	
4	Flats Washer M10	WPM10	1	Front cage bracket	
5	Spring Washer 1/4"	WB0114	1	Boots on top of chassis	

Use washers from rollcage pack

x1

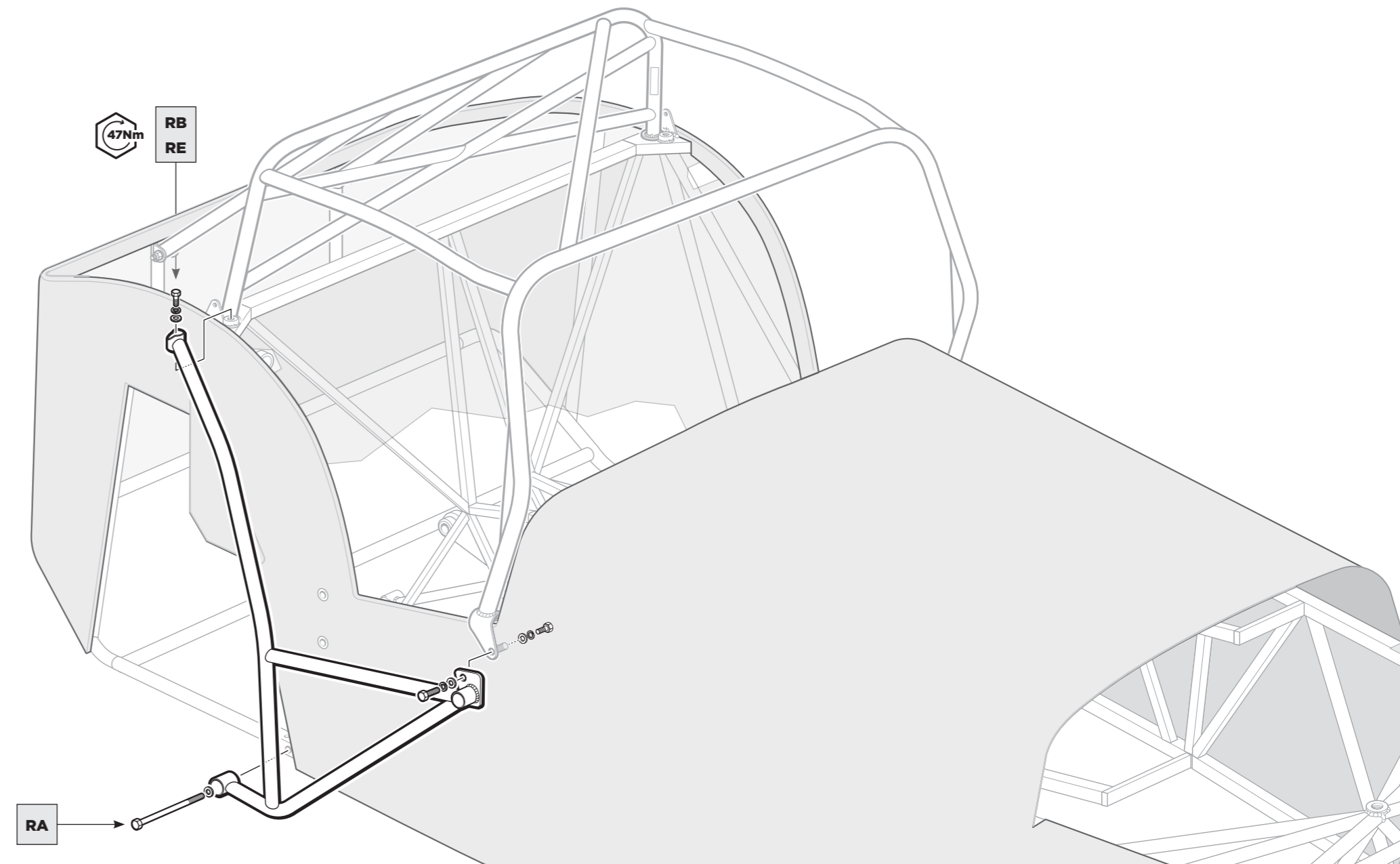
x1

x1

x1

x1

AND THE SIDE IMPACT BAR



RA

47Nm

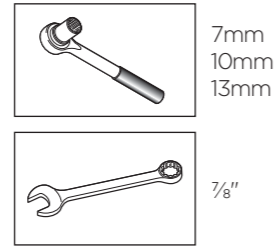
RB
RE

EVEN MORE EXHAUSTING

PARTS

- 1** Silencer
- 2** Exhaust clamp
- 3** Lambda sensor
- 4** Cat guard
- 5** Clip
- 6** Silencer mounting bracket
- 7** Exhaust mounting bobbin

TOOLS



7mm
10mm
13mm

7/8"

FIXINGS

Pack G		CATERHAM		56	
		PACK NUMBER		SEXLEDB	
EXHAUST					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Silencer	SMX25	1	Exhaust Mounting Bracket	
2	Plan Nut	NFF6	2	Exhaust Bobbin	
3	Spring Washer	WVW48	3	1 Exhaust Mounting Bracket 2 Exhaust Bobbin	

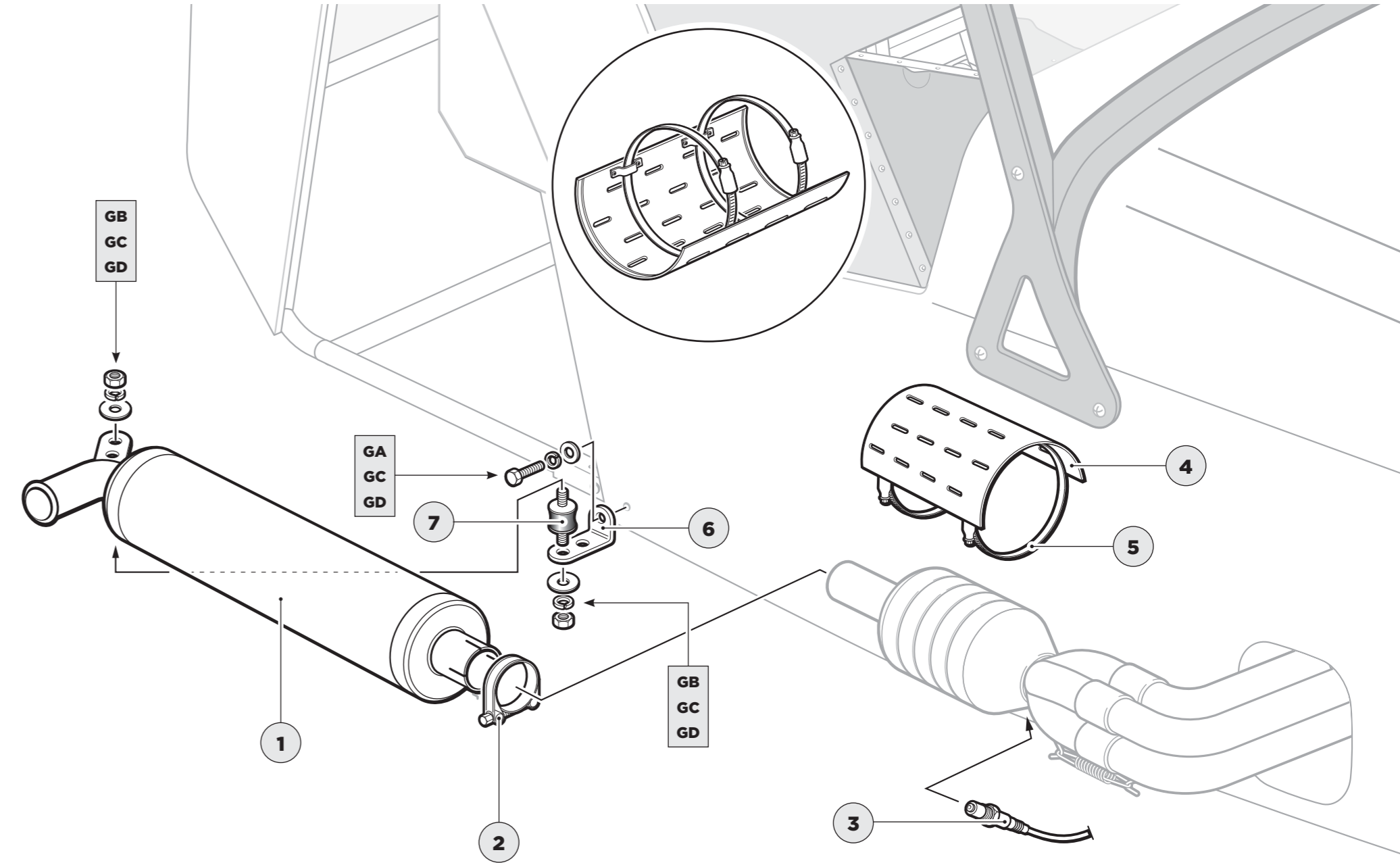
x1
x2
x3

TIPS

Cable tie the Lambda sensor lead neatly out of the way.

Lee A

EVEN MORE EXHAUSTING

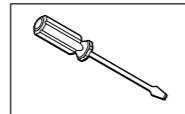


THE NOSE CONE BADGE

PARTS

- 1 Nose cone
- 2 Bonnet
- 3 Badge

TOOLS



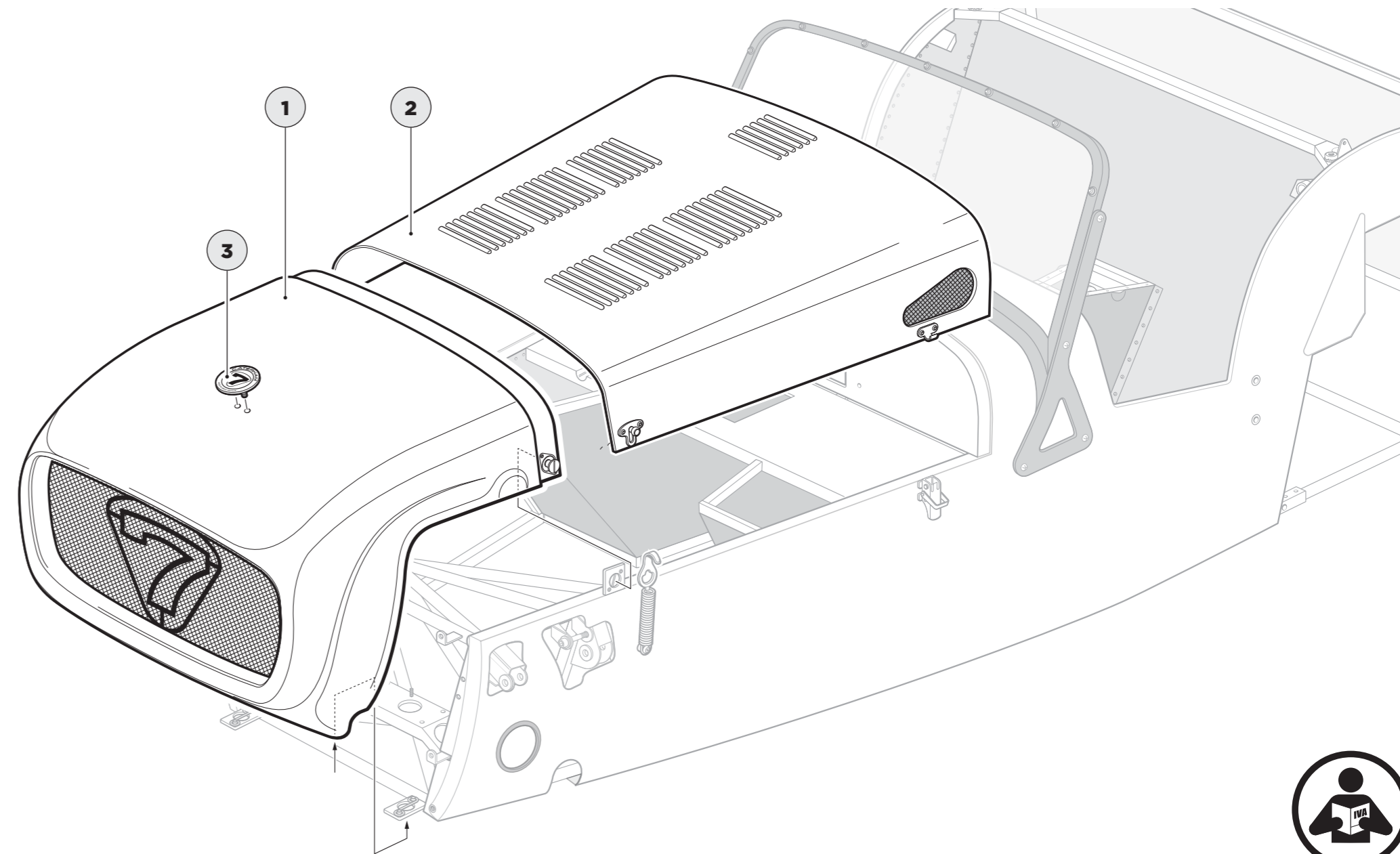
FIXINGS

TIPS

The nose cone goes on before the bonnet.
Anthony L

Stick the supplied foam around the edge of the nose and scuttle where the bonnet will sit (if you've not done already).
Harry P

THE NOSE CONE BADGE



FITTING THE WIPERS

PARTS

- 1 Wiper arm
- 2 Wiper blade

TOOLS

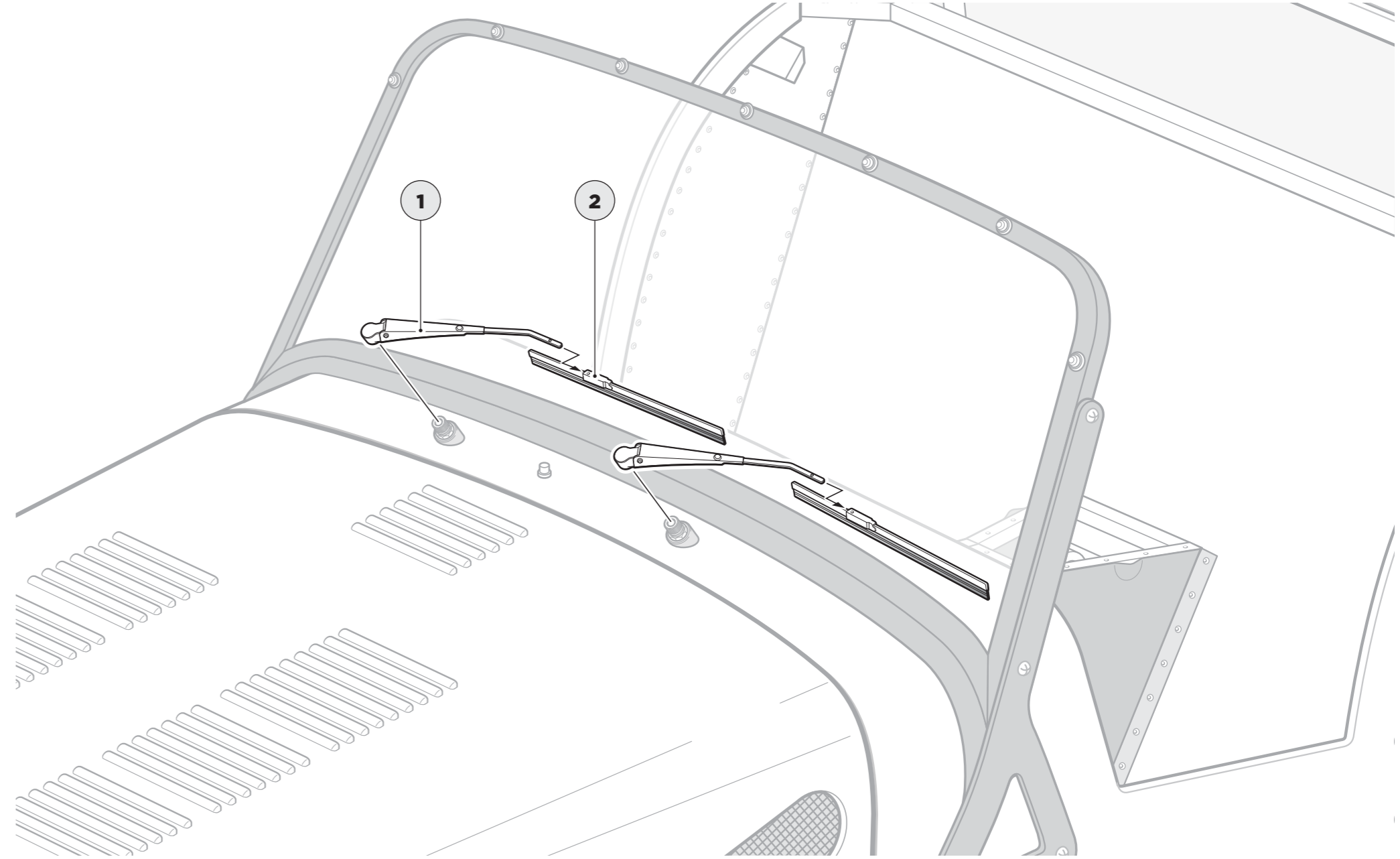
FIXINGS

TIPS

Ensure wipers are in paused position before fitting the wiper arms.
John S

Now would be a good time to fill the washer bottle with fluid and test the washers and wipers.
Chris B

FITTING THE WIPERS

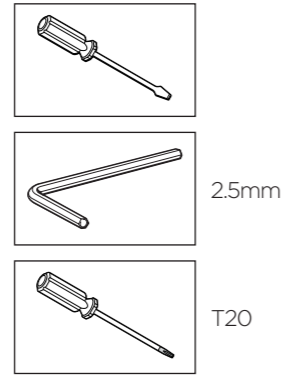


AND FINALLY, AT LAST, THE WING MIRRORS

PARTS

- 00 Mirror head
- 00 Mirror mount
- 00 Mirror mount stud
- 00 Grub screw
- 00 Fibre washer

TOOLS



FIXINGS

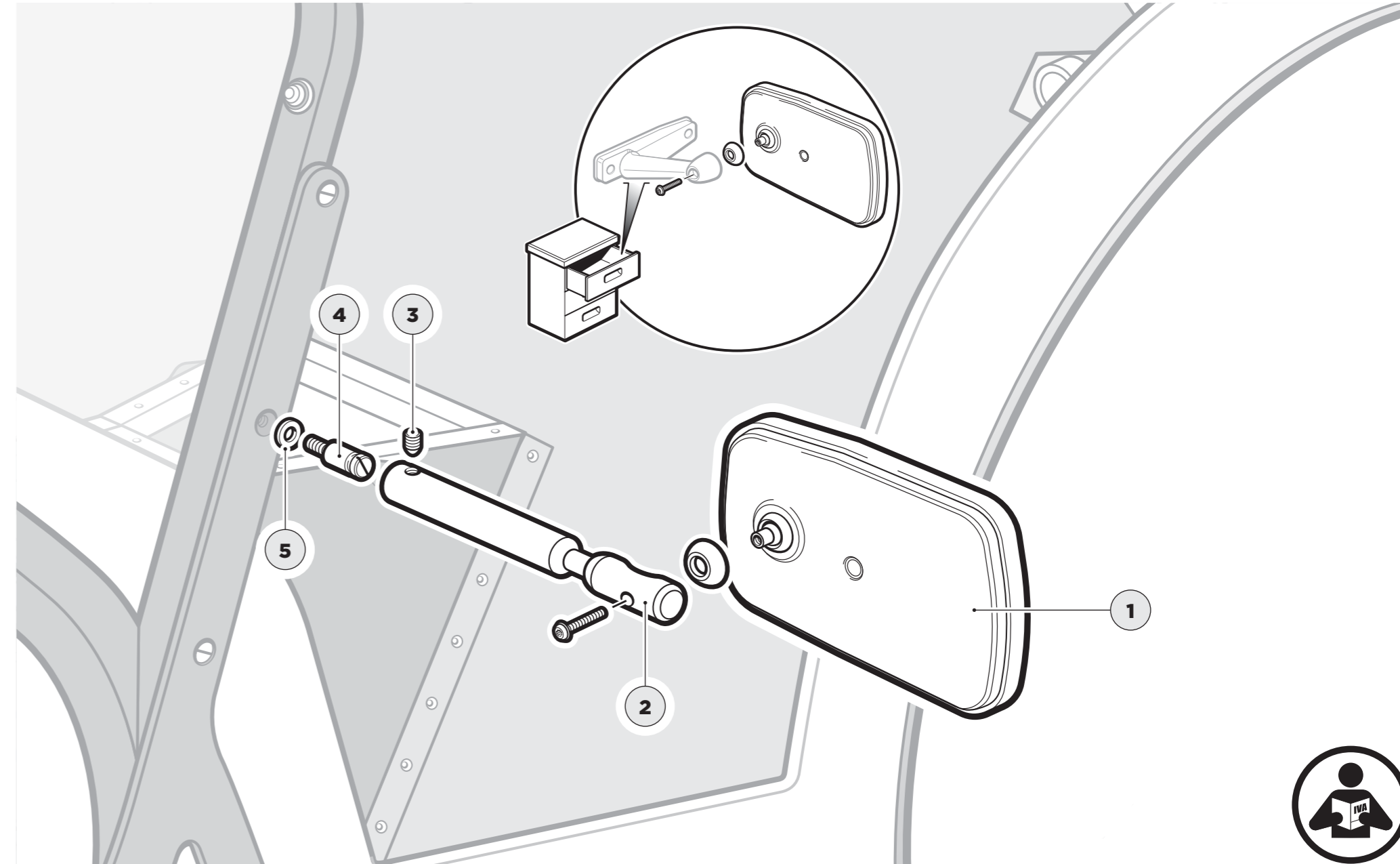
Wing mirror bag

TIPS

You may have to unclick the glass out to tighten up.

Mick F

AND FINALLY, AT LAST, THE WING MIRRORS



WIRING THE STARTER MOTOR

PARTS

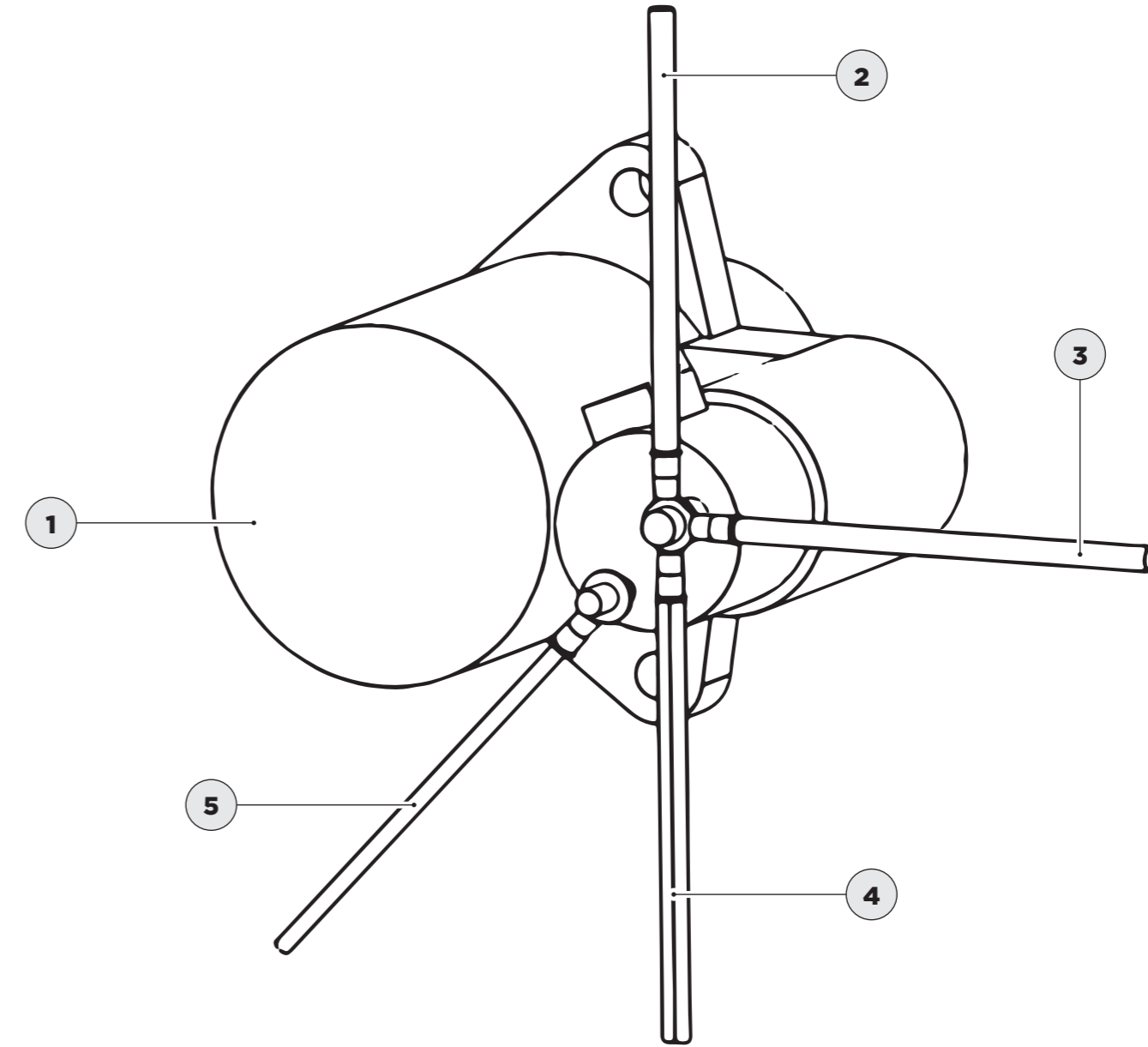
- 1 Starter motor
- 2 Cable from alternator (brown wire with black sheath)
- 3 Cable from battery (positive - red wire)
- 4 2 cables from main loom (2 brown wires joined)
- 5 Cable from engine loom (white wire with red stripe)

FIXINGS

TOOLS

TIPS

WIRING THE STARTER MOTOR



THE LAST FEW STEPS...

Your car is almost complete, but before you can drive triumphantly out of the garage (and legally, as far as the end of your driveway) there are a few important things that need to be done. These are, bleeding the brakes, preparing the engine for the its first grand firing-up ceremony (it will feel like that, even if you are doing it on your own) and lastly torquing up the suspension.

So, on with bleeding the brakes which cannot be explained with a simple diagram unfortunately:

- 1 Assemble the things you'll need: Brake fluid, both a 10mm and an 11mm spanner, a length of washer hose (or similar clear plastic hose) and a waster fluid receptacle (some form of used bottle is ideal; you won't want to use it again after this)
- 2 Find a volunteer. They need to be able to reach and press the brake pedal, plus respond to your instructions, so whilst a child is fine for this job, someone's might be more inclined to listen to you.
- 3 Fill the brake master cylinder with fresh brake fluid and leave the cap off. **BE CAREFUL NOT TO SPILL ANY ONTO THE PAINTWORK;** if you do, wipe it off immediately. Brake fluid will react with the paintwork causing it to blister and peel.
- 4 Starting at the left rear corner, locate the bleed nipple on the caliper. It will have a rubber cap on it. Remove the cap, remember where you put it, and attach the washer hose to the nipple and put the other end in the waste bottle. This sometimes needs the hose warming up in a cup of hot water to allow it to stretch over the nipple.

- 5 Using the 10mm spanner, 'crack off' the nipple about half of a turn.
- 6 Ask your assistant to pump the pedal a few times. You should see bubbly fluid flowing through the pipe. When the bubbles die down, ask them to hold the pedal down, then tighten the nipple back up. Check and top of the fluid level in the reservoir as necessary.
- 7 Ask them to lift off, then pump it a couple of times, then press the pedal down and hold it down.
- 8 Crack off the nipple again and let the fluid and bubbles flow. It will stop flowing as soon as your assistant has run out of brake pedal travel. Tighten the nipple.
- 9 Repeat steps 8 and 9 until you get 100% bubble free fluid passing through the pipe, remembering to check and top up the reservoir. You will waste quite a lot of brake fluid during this process.
- 10 Once you are satisfied that there are no more bubbles (no more air in the caliper), then you can remove the washer hose and refit the dust cover.
- 11 Repeat steps 5 to 10 for the remaining brakes in this order, right rear next, then right front and lastly left front. The front brake nipples use an 11mm spanner.
- 12 Although tedious, getting all the air out of the braking system is important and will give you a good, firm brake pedal, which is what you need; not a soft spongy one like you have in a regular car. You may need to repeat the whole process after the first drive or two (or even after the car has had a ride on a trailer); air in the braking system is very good at hiding.

Brakes bled and we are ready to fire up the engine. Again, it's easier to explain in writing than draw a diagram. The only thing you'll need for this job is to ensure that you have put some fuel in the car. The shape of the Caterham fuel tank does not lend itself to making use of every last drop, so we recommend an absolute minimum of 10 litres in the tank before trying to start the car. With the tank filled, we are ready for initialisation.

But before anything else:

YOU DID REMEMBER TO PUT OIL IN THE ENGINE AND GEARBOX, RIGHT?

- 1 Reassure yourself the engine is full of oil.
- 2 Disconnect the inertia switch; it's the black thing attached to the engine bay bulkhead under the windscreen that has rubber cap on top and a plug with two wires connecting from underneath. By disconnecting the inertia switch, the fuel pump will not work, so intentionally, the engine will not fire.
- 3 Ensure the gearbox is in neutral, then turn the ignition key and press and hold the start button.
- 4 As the engine cranks over, watch the oil pressure gauge. Keep cranking until the needle starts to climb, then steadies out.
- 5 We now have oil pressure circulating in the engine, which means the engine is ready to be started.
- 6 Reconnect the inertia switch.
- 7 Take a deep breath, mutter 'this is it', cross your fingers and brace yourself.
- 8 Turn the ignition key, press and hold the start button. It will take a few moments for the fuel to get through, so do not expect an instant start.
- 9 All things willing, the engine will start. Hooray! If it stops straight away, don't worry. Try again and once it starts give it a little rev.

YOUR SEVEN
Adventure
AWAITS

That's it. Your car is complete! Well done – you have built a car; a real live car; not many people can say that. If you remembered to put in gearbox and differential oil, and fill the system with coolant, then a tentative edge out onto the driveway is in order. You'll need to pop the wheels on and lower it from the axle stands and just tighten the suspension first.

Let's just run through that quickly:

- i. **Put a wheel on and do the nuts up a few turns by hand (to ensure they do not cross-thread).**
- ii. **Tighten them up the best you can with the wheels off the ground.**
- iii. **Lower the car from the axle stands, front first; taking care that it doesn't lean back on the axle stands at the back (a helper might be handy).**
- iv. **Torque the wheel nuts to 65lbft (about 85Nm).**
- v. **Flick back to the pages where we put the wishbones on and torque as shown**
- vi. **That's it, you're ready to go!**

Take care and good luck with the IVA and registration process.

You will soon be experiencing the sheer pleasure of being a Caterham driver. Once again, enjoy!

APPENDIX

FIXING PACKS

Pack A		CATERHAM		SERIAL NUMBER	44
				PACK NUMBER	30F015B
FRONT SUSPENSION DeDION CARS (METRIC)					
<i>This pack may include extra fasteners to cover different options</i>					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	AA Bolt M12 x 100 Grade 10.9	BM12X100	2	Lower wishbone rear	
2	AB Bolt M12 x 65 Grade 10.9	BM12X65	2	Lower wishbone front	
3	AC Bolt M10 x 65 Grade 10.9	BM10X65	2	Upper wishbone rear	
4	AD Bolt M10 x 60 Grade 10.9	BM10X60	2	Upper wishbone front	
5	AE Bolt M8 x 40 Grade 10.9	BM8X40	4	Anti-roll bar mounting brackets	
6	AF Plain Nut M14 x 1.5 thread	NMPH14	1	Temporary use to help lock upper wishbone ball joint	
7	AG Nyloc Nut M12	NMYF12	2	Lower wishbone rear	
8	AH Nyloc Nut M10	NMYF10	4	Upper wishbone	
9	AJ Plain Washer M12 Chamfered	WPCM12	18	Lower wishbone	
10	AK Plain Washer M8 Heavy duty	WPHM8	4	Anti-roll bar mounting brackets	
11	AL Plain Washer 3/8" x 3/4" Heavy duty	WPH3/8	2	Brake pipe	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

Pack A		CATERHAM		SERIAL NUMBER	44
				PACK NUMBER	30F015B
FRONT SUSPENSION DeDION CARS (METRIC)					
<i>This pack may include extra fasteners to cover different options</i>					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
12	AM Spring Washer M12	WSHM12	2	Lower wishbone front	
13	AN Spring Washer M8	WSHM8	6	Anti-roll bar mounting brackets & upper damper mount	
14	AP Washer 3/8" Shake-proof	WSS3/8	2	Brake pipe	
15	AR Nyloc Nut 1/2" Half height	NFYH1/2	2	Wing stay	
16	AS Nyloc Nut 1/2" Full height	NFYF1/2	2	Front brake, upright mounting (std track ONLY)	

Drawings are for illustrative purposes only and are not to scale. Page 2 of 2

FIXING PACKS

Pack B		CATERHAM		SERIAL NUMBER	55
				PACK NUMBER	30S003B
STEERING DeDION CARS (METRIC)					
<i>This pack may include extra fasteners to cover different options</i>					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	BA Caphead Bolt M6 x 70 DIN 912	BMCH6X70	4	Rack clamps	
2	BB Bolt 1/2" x 1 1/2"	BF1/4X1.1/2	2	Column clamp	
3	BC Bolt M8 x 35 Grade 8.8	BM8X35	2	Column to rack universal joint	
4	BD Nyloc Nut 1/2" Half height	NFYH1/2	1	Steering wheel boss	
5	BE Plain Nut 1/2"	NFPF1/2	2	Track rod lock nut	
6	BF Plain Nut 3/4" Half height	NFPFH7/16	1	Column clamp grubscrew locknut	
7	BG Nyloc Nut M8	NMYF8	2	Column to rack universal joint	
8	BH Nyloc Nut M6	NMYF6	4	Steering rack clamps	
9	BJ Plain Washer 1/2" x 1 1/4" Chamfered	WPH1/2	1	Steering wheel boss	
10	BK Plain Washer 3/8" Heavy duty	WPH1/4	6	Rack clamps and column clamp	
11	BL Spring Washer 3/8" Heavy duty	WSH1/4	2	Column clamp	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 1

Pack C		CATERHAM		SERIAL NUMBER	45
				PACK NUMBER	30L002B
LIGHTING & HORNS					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	CA Screw 10 x 1/4" Black Supaflange	71080	6	Indicator assembly to indicator pod	
2	CB Screw 8 x 1/4" Black Supaflange	71077	2	Side repeater earth on wingstay	
3	CC Screw 12 x 1 1/4" Self tapping	71079	4	Rear light cluster upper fixing	
4	CD Screw 12 x 1" Self tapping	71078	4	Rear light cluster lower fixing	
5	CE Nyloc Nut M6	NMYF6	2	Horn bracket to steering rack platform (160/270/310)	
6	CF Plain Washer 1/2" Heavy duty	WPH1/4	2	Horn bracket to steering rack platform (160/270/310)	
7	CG Bolt M8 x 5 Grade 8.8	BM8X50	1	Through steering rack platform & spacer (420)	
8	CH Plain Washer 5/16"	WPH5/16	2	Bolt head/nut	
9	CI Nyloc Nut M8	NMYF8	1	Horn bolt	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 1

FIXING PACKS

Pack D		CATERHAM		SERIAL NUMBER	44
				PACK NUMBER	30C047B
COOLING SIGMA					
<i>This pack may include extra fasteners to cover different options</i>					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	DA Bolt M8 X 50 Grade 8.8	BM8X50	1	Expansion tank bracket to chassis	
2	DB Setscrew 1/4" X 3/4"	SF1/4X3/4	1	Expansion tank to bracket	
3	DC Setscrew M8X20 Grade 8.8	SM6X20	4	SV radiator bracket	
4	DD Bolt M6 X 16 with square section	30Z1072A	4	Fan brackets to fan	
5	DE Setscrew M6X16 Panhead Pazi	SPHM6X16	4	Fan to radiator cowling - SV only	
6	DF Nyloc Nut M6	NMYF6	8	x4 Fan to radiator x4 SV radiator bracket	
7	DG Plain Nut M8	NMPF8	8	Radiator bobbin	
8	DH Nyloc Nut 1/4"	NFYF1/4	1	Expansion tank bracket	
9	DI Plain Washer 1/4" Heavy duty	WPH1/4	13	8 x SV rad bracket 4 x Fan fixings 1 x Expansion tank braket	
10	DJ Plain Washer 5/16" Heavy duty	WPH5/16	4	Radiator bobbin back	
11	DK Plain Washer 5/16" X 7/8" Heavy duty	WPH5/17X7/8	4	Radiator bobbin front	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

Pack D		CATERHAM		SERIAL NUMBER	44
				PACK NUMBER	30C047B
COOLING SIGMA					
<i>This pack may include extra fasteners to cover different options</i>					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
12	DL Plain Washer 1/4" X 7/8" Heavy duty	WPH1/4X7/8	1	Expansion tank bracket	
13	DM Spring Washer 5/16" Heavy duty	WSH5/16	9	8 x Radiator bobbin 1 x Expansion tank	
14	DN Hose Clip 30 - 40mm	SGT25-40	6	2 x U shape hose to water rail 2 x Top radiator hose 2 x Bottom radiator hose	
15	DO Hose Clip 23 - 35mm	SGT23-35	2	1 x Engine outlet to big T piece 1 x Engine outlet to heater inlet	
16	DP Hose Clip 17 - 25mm	SGT16-25	18	6 x Heater inlet/outlet 3 x Big T-piece 1 x Expansion tank 2 x Modine 4 x Dry Sump 2 x Submarine	
17	DQ Hose Clip 8 - 16mm	SGT8-16	6	Expansion tank small T-piece	
18	DR Rivet - Black 5/32" X 0.47"	1610-01015	12	Cowling flap	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

FIXING PACKS

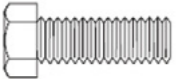

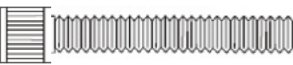
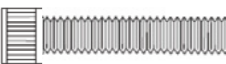
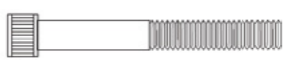
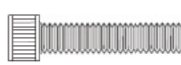
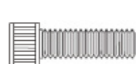




Pack E		CATERHAM		SERIAL NUMBER	66
				PACK NUMBER	3EZ1105F
SIGMA GEARBOX 5 SPEED					
<i>This pack may include extra fasteners to cover different options</i>					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	EA Bolt M14 X 40 Grade 12.9	3EZ1137A	2	AV Mount	
2	EB Caphead Bolt M8 X 40 Grade 12.9	30Z1076A	4	AV Mount	
3	EC Caphead Bolt M12 X 50 Grade 12.9 Coarse Thread	3EZ1142A	4	Gearbox	
4	ED Caphead Bolt M10 X 60 Grade 12.9	BMCH10X60	4	1 x Bellhousing 3 x Starter Motor	
5	EE Caphead Bolt M10 X 55 Grade 12.9	BMCH10X55	3	Bellhousing	
6	EF Caphead Bolt M10 X 40 Grade 12.9	BMCH10X40	3	Bellhousing	
7	EG Caphead Bolt M10 X 35 Grade 12.9	BMCH10X35	2	Engine Mount RHS Top	
8	EH Caphead Bolt M8 X 25 Grade 12.9	BMCH8X25	2	Engine Mount 1 x LHS Top 1 x LHS Bottom	
9	EI Caphead Bolt M8 X 30 Grade 12.9	BMCH8X30	1	Engine Mount LHS Bottom	
10	EJ Caphead Bolt M8 X 35 Grade 12.9	BMCH8X35	2	Engine Mount RHS Bottom	
11	EK Caphead Bolt M6 X 25 Grade 12.9	BMCH6X25	3	Clutch Slave Cylinder	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2






Pack E		CATERHAM		SERIAL NUMBER	66
				PACK NUMBER	3EZ1105F
SIGMA GEARBOX 5 SPEED					
<i>This pack may include extra fasteners to cover different options</i>					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
12	EL Buttonhead Bolt M6 X 10 Grade 10.9 Internal Hex	3GZ1163A	3	Gear Lever	
13	EM Plain Washer M14	WPH14	2	AV Mount	
14	EN Plain Washer M12	30Z2031A	4	Gearbox	
15	EO Plain Washer M6	WPHM6	3	Gear Lever	
16	EP Plain Washer 5/16"	WPH5/16	8	AV Mount	
17	EQ Spring Washer M12	WSHM12	4	Gearbox	
18	ER Spring Washer M10	WSHM10	10	x 7 Bellhousing x 3 Engine Mount	
19	ES Wire Spring Washer M10	WSHM10	3	Starter Motor	
20	ET Spring Washer M8	WSHM8	5	Engine Mount	
21	EU Spring Washer M6	WSHM6	3	Clutch Slave Cylinder	
22	EV Myloc Nut M8	NMYF8	4	AV Mount	
23	EW Spring Washer M14	30Z2030A	2	AV Mount	

Drawings are for illustrative purposes only and are not to scale. Page 2 of 2

FIXING PACKS


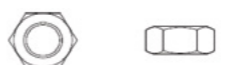

Pack F		CATERHAM		SERIAL NUMBER 66	
				PACK NUMBER	
				3EZ2029B	
DURATEC GEARBOX 5 SPEED					
<i>This pack may include extra fasteners to cover different options</i>					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	FA Bolt M14 X 30 X 1.5 Grade 12.9	30Z2032A	2	AV Mount	
2	FB Caphead M12 X 40 X 1.75 Grade 12.9	BMCH12X40	4	Bellhousing	
3	FC Caphead Bolt M10 X 90 Grade 12.9	BMCH10X90	1	Bellhousing	
4	FD Caphead Bolt M10 X 55 Grade 12.9	BMCH10X55	3	Bellhousing	
5	FE Caphead Bolt M10 X 45 Grade 12.9	BMCH10X45	7	x 5 Bellhousing x 2 Starter Motor	
6	FF Caphead Bolt M8 X 40 Grade 12.9	30Z1076A	4	AV Mount	
7	FG Caphead Bolt M6 X 25 Grade 12.9	BMCH6X25	3	Clutch Release Bearing	
8	FH Buttonhead Bolt M6 X 10 Grade 10.9 Internal Hex	3GZ1163A	3	Gear Lever	
9	FI Nyloc Nut M8	NMYF8	4	AV Mount	
10	FJ Plain Washer M14	WPH14	2	AV Mount	
11	FK Plain Washer M12	30Z2031A	4	Bellhousing	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

Pack F		CATERHAM		SERIAL NUMBER 66	
				PACK NUMBER	
				3EZ2029B	
DURATEC GEARBOX 5 SPEED					
<i>This pack may include extra fasteners to cover different options</i>					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
12	FL Plain Washer M6	WPHM6	3	Gear Lever	
13	FM Spring Washer M14	30Z2030A	2	AV Mount	
14	FN Spring Washer M12	WSHM12	4	Gearbox	
15	FO Spring Washer M10	WSHM10	4	x 2 Starter Motor x 2 Front Bellhousing	
16	FP Spring Washer M6	WSHM6	3	Clutch Slave Cylinder	

Drawings are for illustrative purposes only and are not to scale. Page 2 of 2

FIXING PACKS

Pack G		CATERHAM		SERIAL NUMBER 56	
				PACK NUMBER	
				30X020B	
EXHAUST					
<i>This pack may include extra fasteners to cover different options</i>					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	GA Setscrew M8 X 25 Grade 8.8	SM8X25	1	Exhaust Mounting Bracket	
2	GB Plain Nut M8	NFPF8	2	Exhaust Bobbin	
3	GC Spring Washer M8	WSHM8	3	x 1 Exhaust Mounting Bracket x 2 Exhaust Bobbin	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 1

FIXING PACKS

Pack H		CATERHAM		SERIAL NUMBER 53	
		PACK NUMBER 30R011D			
REAR SUSPENSION DEDION METRIC					
<i>This pack may include extra fasteners to cover different options</i>					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	HA Bolt M12 X 100 Grade 10.9	BM12X100	2	A-frame front mountings	
2	HB Caphead Bolt M10 X 65	BMCH10X65	2	Front radius arm (through cockpit)	
3	HC Bolt 1/2" X 2.1/2" Grade 10.9	BF1/2X2.1/2	4	x 2 Lower Rear Damper 2 Rear Radius Arm	
4	HD Bolt M6 X 80 Grade 10.9	BM6X80	4	Rear Anti Roll Bar Mounting Blocks	
5	HE Bolt 1/2" X 2.3/4" Grade 10.9	BF1/2X2.3/4	1	A-frame to DeDion	
6	HF Half Nyloc 1/2" UNF	NFYH1/2	3	x 2 Rear Radius Arm 1 A-frame to DeDion	
7	HG Nyloc Nut M12	NMYF12	2	A-frame front mounts	
8	HH Nyloc Nut M10	NMYF10	2	Front radius arm (through cockpit)	
9	HI Half Nyloc M8	NMYH8	2	Rear Anti Roll Bar Drop Link	
10	HJ Nyloc Nut M6	NMYF6	4	Rear Anti Roll Bar Mounting Blocks	
11	HK Nyloc Nut 1/4"	NFYF1/4	1	3 - way union on DeDion tube	
Drawings are for illustrative purposes only and are not to scale.					Page 1 of 2

Pack H		CATERHAM		SERIAL NUMBER 53	
		PACK NUMBER 30R011D			
REAR SUSPENSION DEDION METRIC					
<i>This pack may include extra fasteners to cover different options</i>					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
12	HL Washer	79029	10	Differential Isolation	
13	HM Plain Washer 1/2" Chamfered	WPH1/2	20	x 2 Lower Damper x 10 A-frame washers 4 Radius Arm	
14	HN Plain Washer 3/8" X 7/8"	WPH3/8X7/8	2	Front Radius Arm	
15	HO Plain Washer M6	WPHM6	4	Rear Anti Roll Bar Mounting Block	
16	HP Schnorr Washer M12	30Z1069A	2	Lower Damper	
Drawings are for illustrative purposes only and are not to scale.					Page 2 of 2

FIXING PACKS

Pack J		CATERHAM		SERIAL NUMBER 47	
		PACK NUMBER 30P010A			
ROLL OVER & TRACK DAY BAR SERIES 3 METRIC					
<i>This pack may include extra fasteners to cover different options</i>					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	JA Bolt M10 X 60 Grade 8.8	BM10X60	2	Rear diagonals of roll over bar to mounting brackets	
2	JB Setscrew M8 X 20 Grade 8.8	SM8X20	2	Roll over bar bracket to chassis	
3	JC Caphead Bolt M10 X 20	BMCH10X20	2	Roll over bar boss	
4	JD Nyloc Nut M10	NMYF10	2	Rear diagonals of roll over bar to mounting brackets	
5	JE Plain Washer M8	WPHM8	2	Roll over bar bracket to chassis	
6	JF Spring Washer M8	WSHM8	2	Roll over bar bracket to chassis	
7	JG Plain Washer M10	WPHM10	4	Rear diagonals of roll over bar to mounting brackets	
Drawings are for illustrative purposes only and are not to scale.					Page 1 of 1

Pack O		CATERHAM		SERIAL NUMBER ZWS01	
		PACK NUMBER ZWS01			
WING PROTECTORS STAINLESS STEEL					
<i>This pack may include extra fasteners to cover different options</i>					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	OA Rivet 1/8" X 0.51"	1661-0414	30	Wing protector to wing	
2	OB Wing Piping	76901	2m	Between wing protector and wing	
Drawings are for illustrative purposes only and are not to scale.					Page 1 of 1

FIXING PACKS

Pack P		CATERHAM		SERIAL NUMBER	
				PACK NUMBER	
				ZWS02	
WING PROTECTORS CARBON FIBRE					
<i>This pack may include extra fasteners to cover different options</i>					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	PA Rivet Black 1/8" X 0.51"	1610-01049	30	Wing protector to wing	
2	PB Wing Piping	76901	2m	Between wing protector and wing	
Drawings are for illustrative purposes only and are not to scale.					Page 1 of 1

Pack Q		CATERHAM		SERIAL NUMBER	
				31	
				PACK NUMBER	
				ZFG12	
REAR WINGS					
<i>This pack may include extra fasteners to cover different options</i>					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	QA Set Screw M5 X 20	SM5X20	20	Rear Wings	
2	QB Nyloc Nut M5	NMYF5	10	Rear wings through boot	
3	QC Plain Washer 3/16" X 3/4"	WP3/16X3/4	30	Wing washers	
4	QD Wing Piping 1/4" X 1"	76902	4m	Between wing and body	
Drawings are for illustrative purposes only and are not to scale.					Page 1 of 1

CATERHAM

Caterham Cars Limited, 2-3 Kennet Road, Dartford, Kent, DA1 4QN
+44 (0) 1322 625800

CATERHAMCARS.COM

 /CaterhamCars  @caterhamcars

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