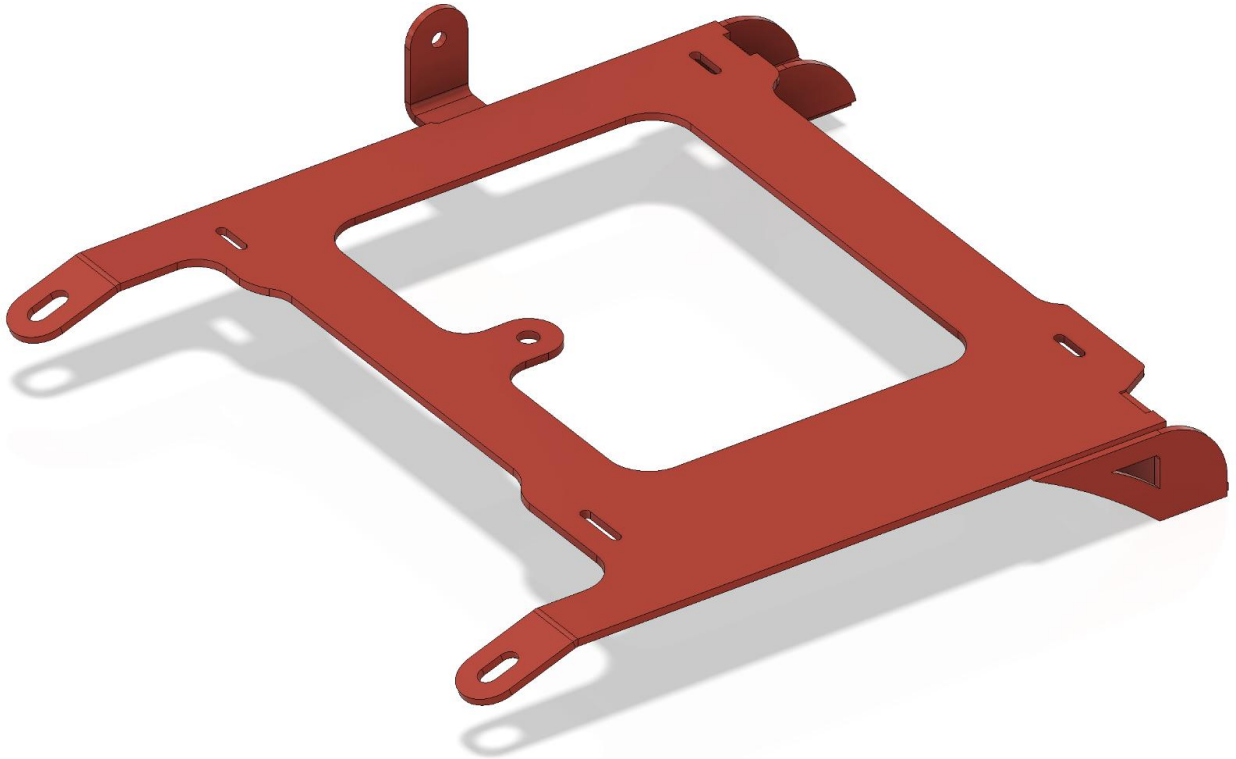


King6fab

DIY PRO Seat Brackets Guide



This guide assumes you are able to weld and capable of bending up to 3/16" thick A36 Steel material.

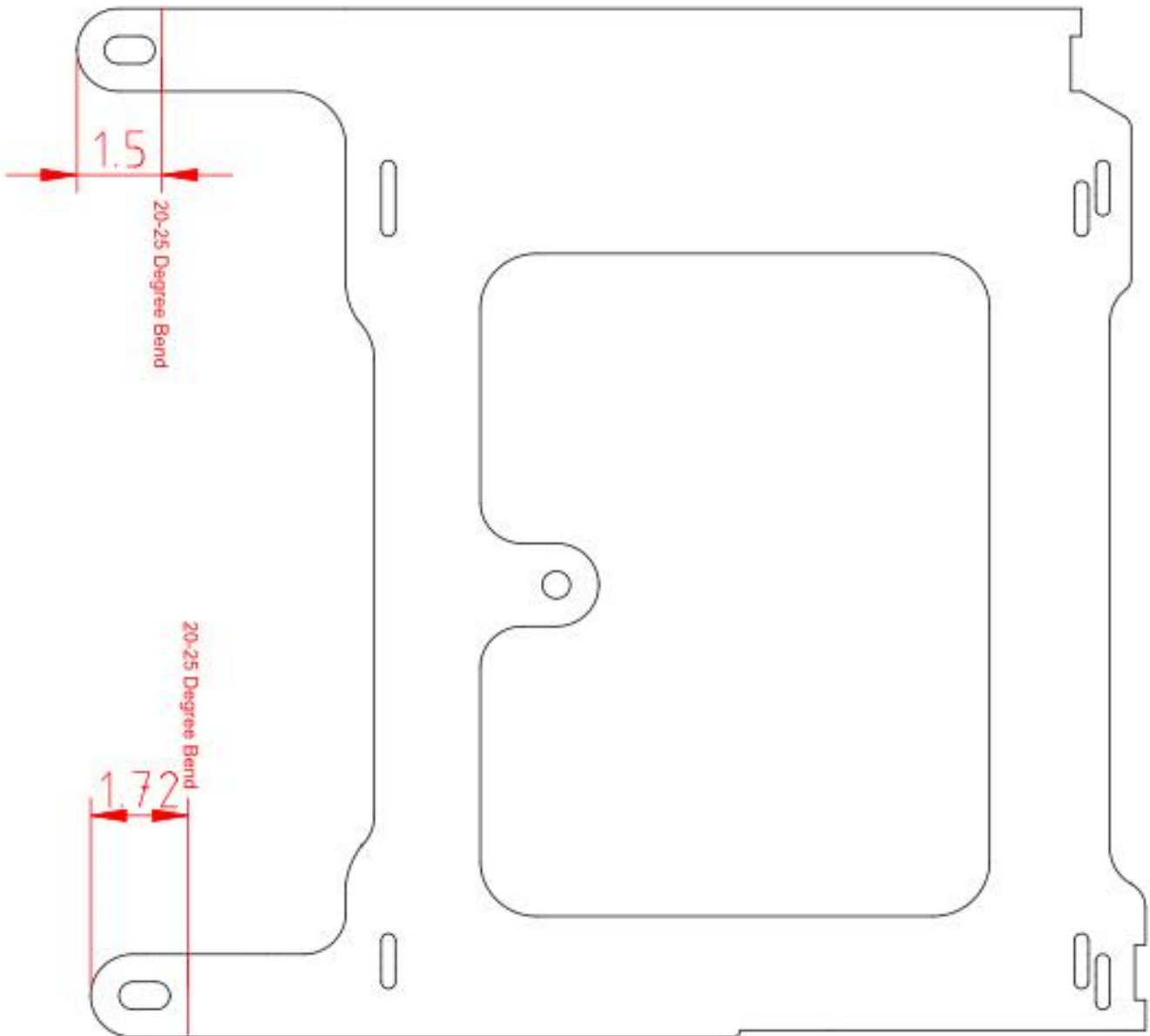
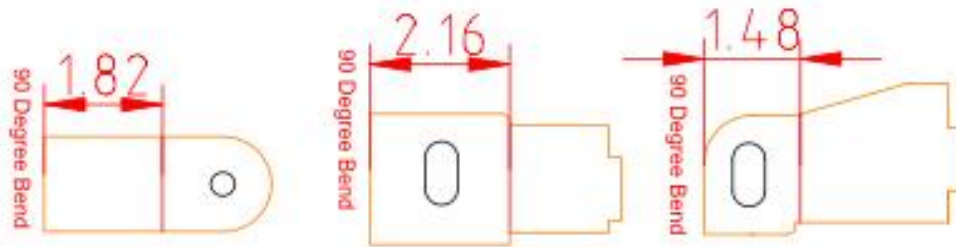
Welding machine type and technique does not matter and are completely up to the users choice.

These brackets are CNC Plasma cut, as result the holes and notches in the material are slightly hardened and will require a reamer or carbide burr to enlarge if necessary.

Getting started, It is recommended starting with bending the legs for your seat brackets using the bend spec diagram. The bend positions are notated with a red line distanced in inches from the end of the leg as illustrated.

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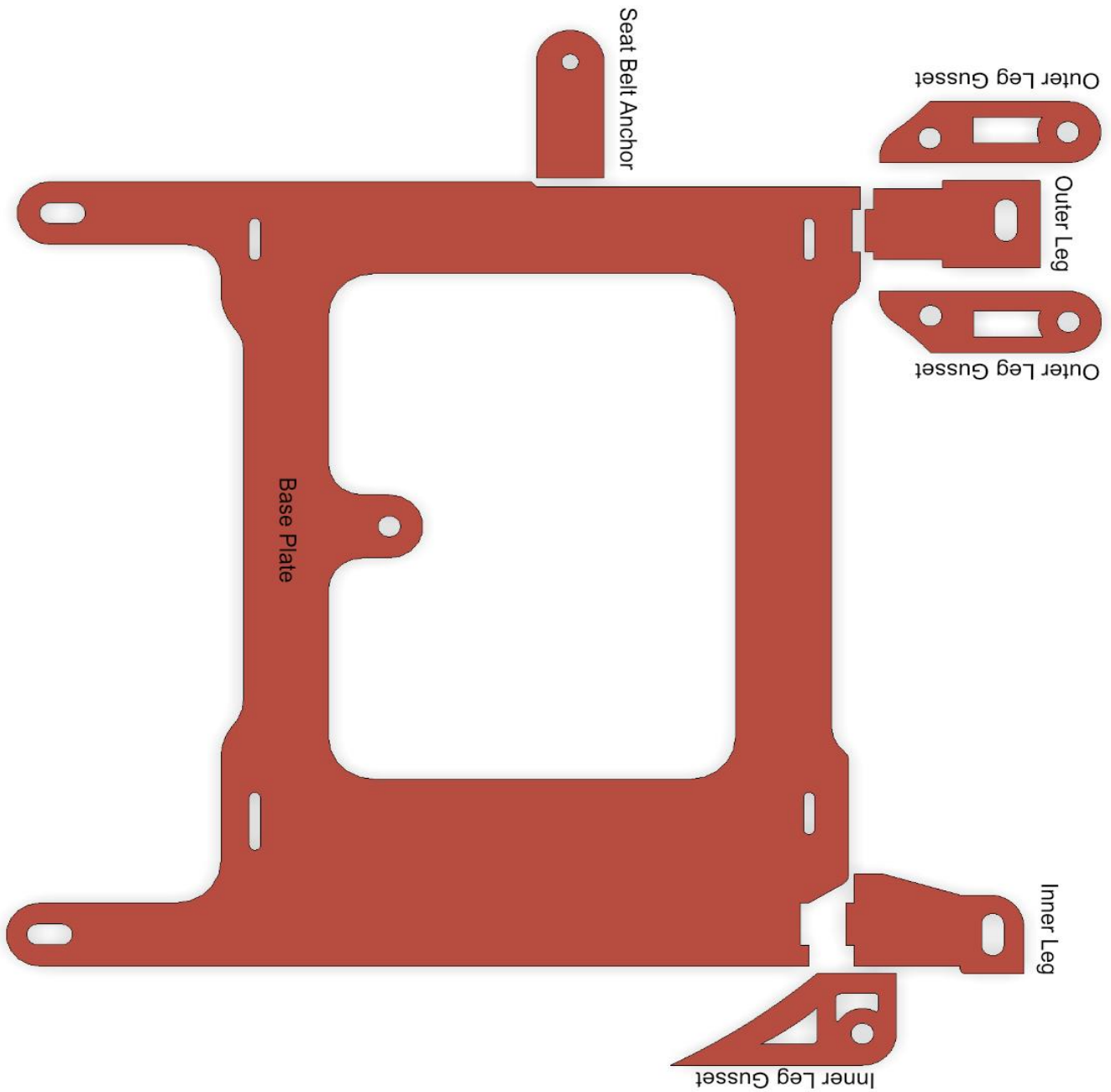
Bend Spec Diagram



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Parts List

The below diagram illustrates the parts for each bracket and its correct orientation on the base plate. This illustration is facing up, the inner and outer brackets are notched specifically to fit one way, pay close attention that when you are bending, the pattern that is face up is like shown here.

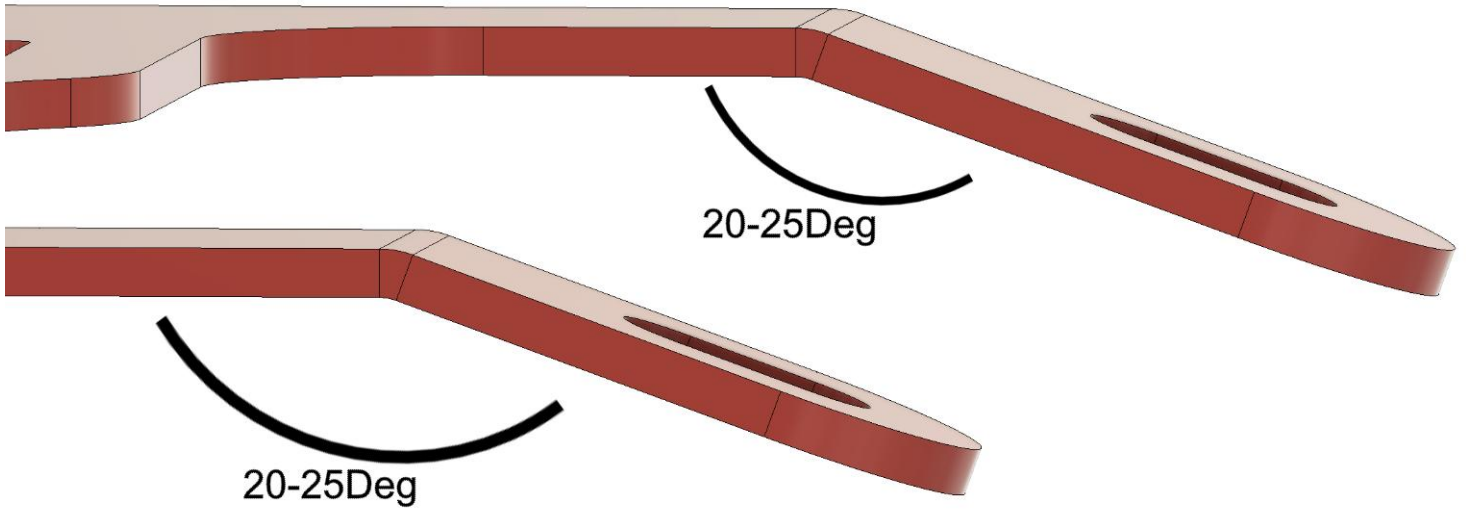


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Front Legs

First thing you will want to do is bend the front legs according to the bend spec diagram.

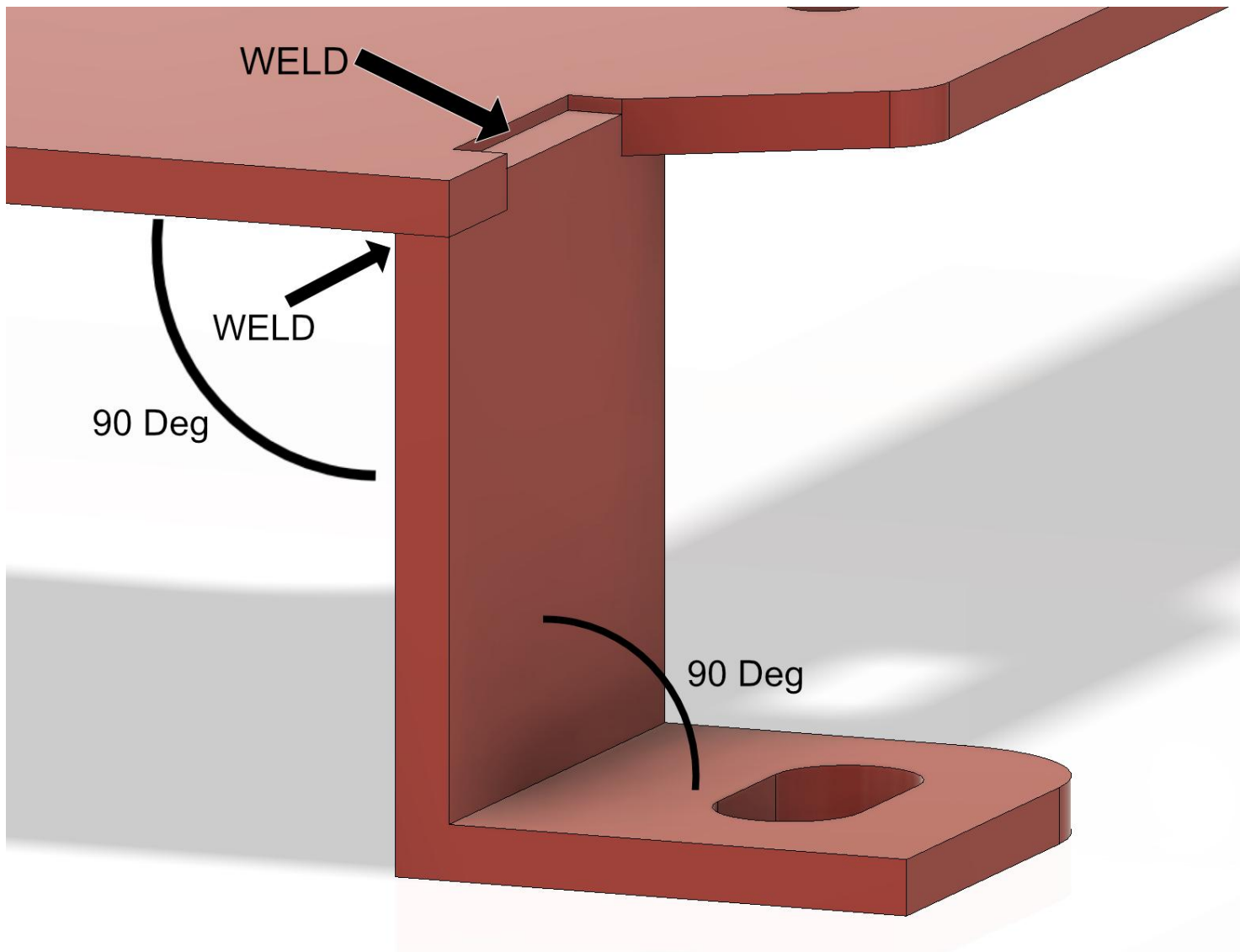
Start out with a 20 degree bend, they can always be bent more later if needed.



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Inner Leg

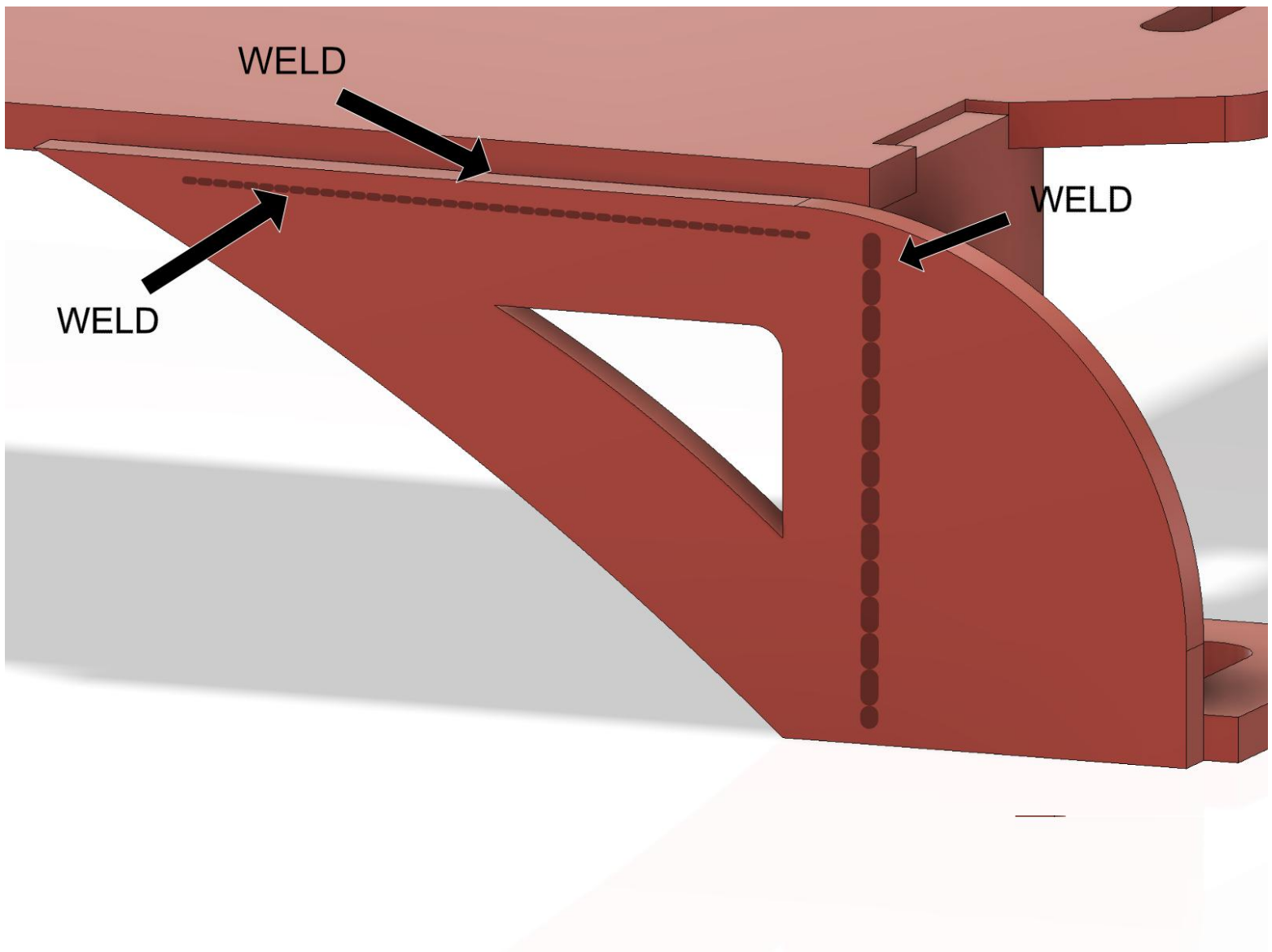
After the inner leg is bent per bend spec diagram, position it on the bracket as follows in the below picture. The leg is notched to fit into position. It is best to flip the base plate upside down and use a square edge to make it a perfect 90 degree. Only tack weld the top and bottom for now.



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Inner Leg Side Gusset

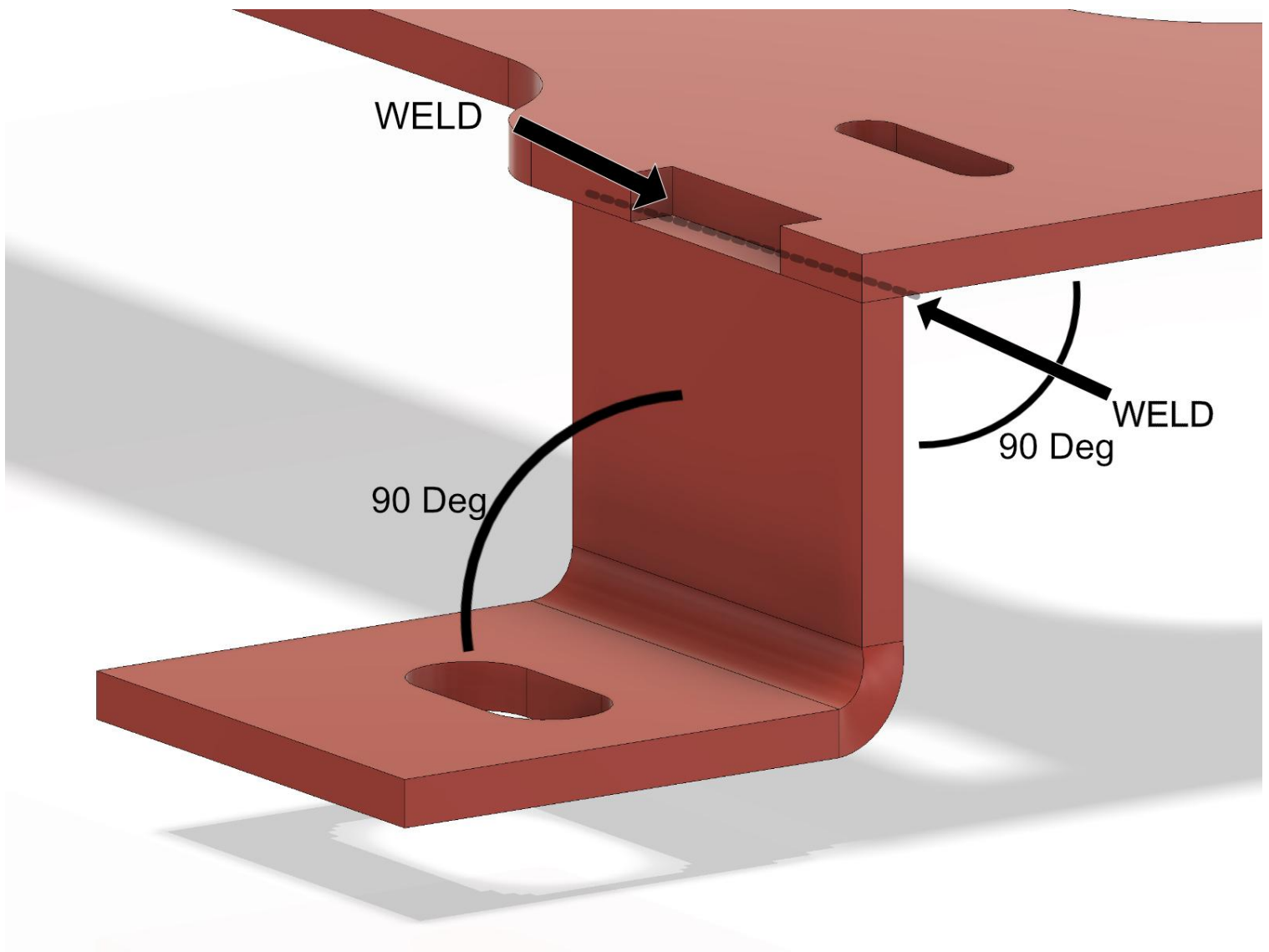
Next Position the side gusset just below the depth of the material, Only tack weld in the 3 positions noted in the below picture for now.



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Outer Leg

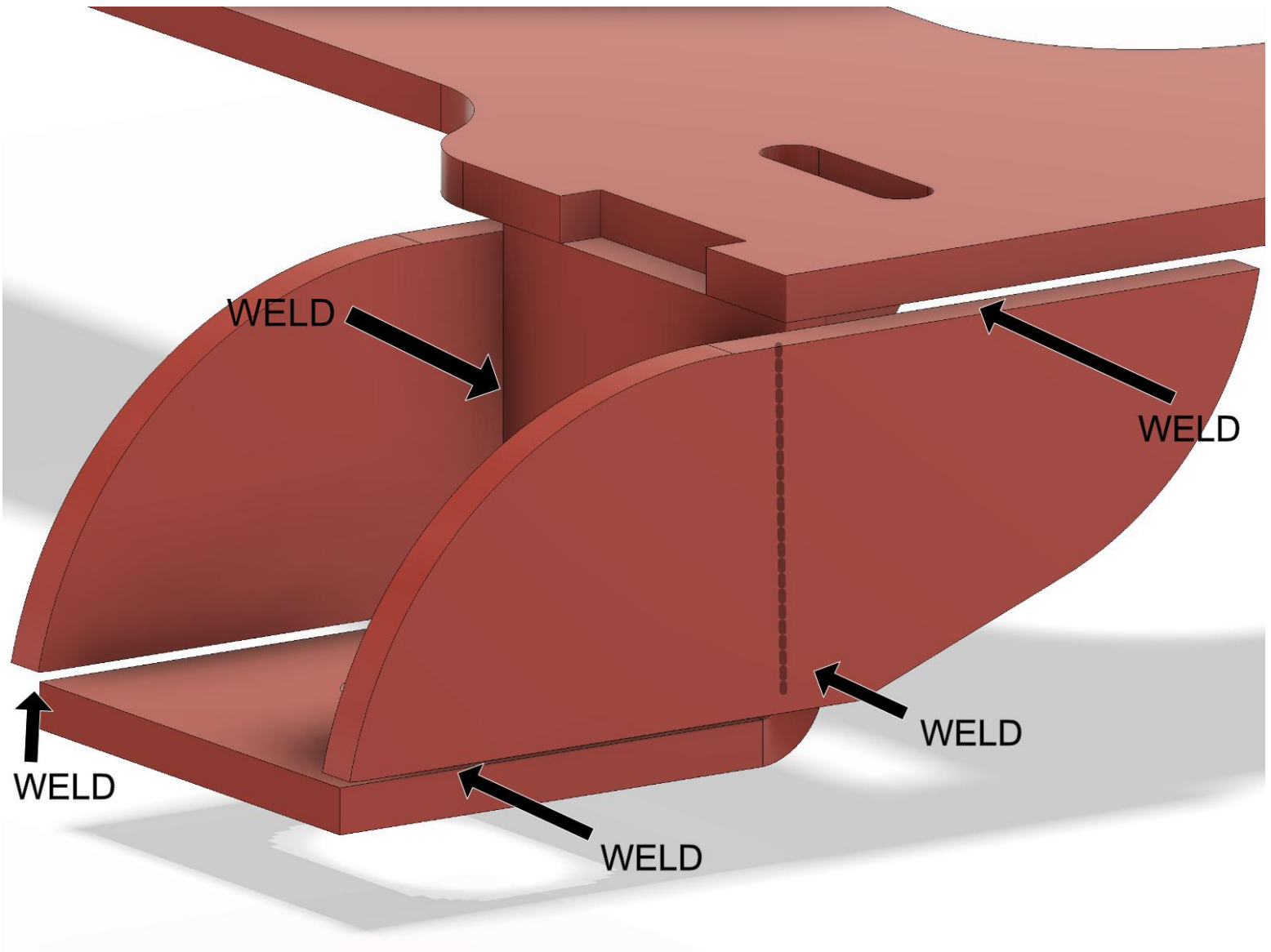
After the outer leg is bent per bend spec diagram, position it on the bracket as follows in the below picture. The leg is notched to fit into position. It is best to flip the base plate upside down and use a square edge to make it a perfect 90 degree. Only tack weld the top and bottom for now.



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Outer Leg Side Gussets

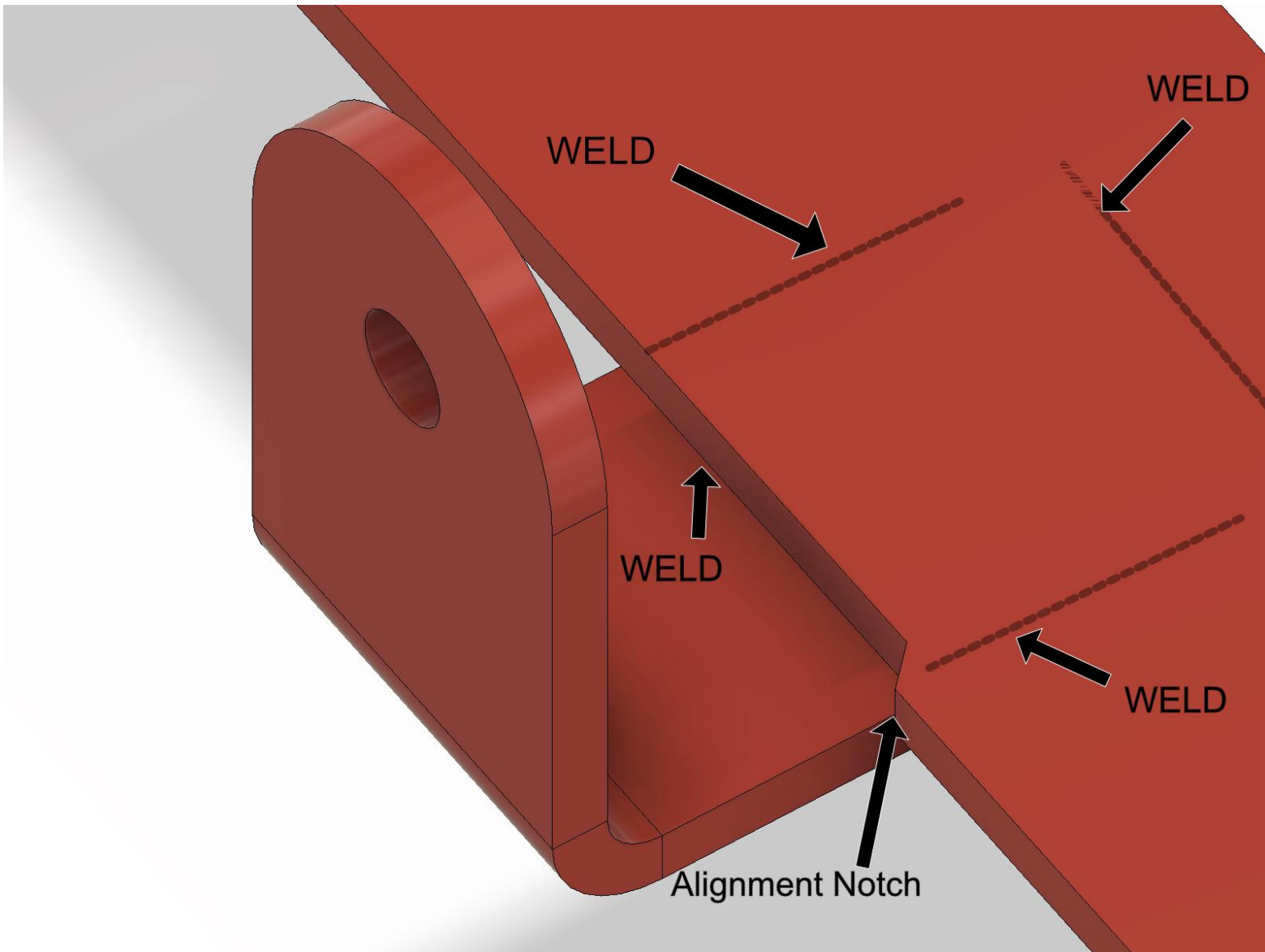
Next Position the side gussets just below the depth of the material, Only tack weld in the positions noted in the below picture for now.



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Seat Belt Anchor

After the seat belt anchor is bent to spec per bend diagram, Find the notch on the base plate and align the anchor edge to it. Only tack weld the anchor to the base plate. How far the anchor sticks out from the base plate is to be determined by your seat width. Roughly 1-1.5" is usual.



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Tack Welded Seat Bracket Stage

At this point you should have an assembled seat bracket that is only tack welded together.

**** Important ****

Test fit the bracket in your car to determine if any adjustments need to be made. You can break the tack welds and move pieces as needed.

**** Important ****

Test fit the bracket to the bottom of your seat to determine if the seat belt anchor will not rub the seat. You can break the tack welds and move as needed.

Once you have confirmed the above,
Weld the brackets in all the positions shown in the above illustrations.