



1500 Avenue R • Riviera Beach • Florida 33404

Info & Tech: (561) 863-2188  
Orders Only: (800) 327-9402  
Fax: (561) 863-1424  
WWW.Chassisengineering.com

# 84" Pro Mod Wheelie Bar Kit

## PART # 3617

**Congratulations**, you have purchased the finest wheelie bars available from any manufacturer. Please read these entire instructions before attempting to install these wheelie bars on your car to assure that your installation goes smoothly and to ensure that they work properly.

### PARTS LIST:

4...84" pcs. of 1-1/4"x .095 moly tubing.  
3...24" pcs. of 1"x .058 moly tubing.  
4...48" pcs. of 3/4"x .058 moly tubing 2 Pcs. with bends.  
2...Bearing wheelie bar wheels  
4... Rod end caster brackets for upper bars  
2...1/2" X 3/8" Rod Ends.  
2...Quick release pins  
6...1/2" threaded tub adapters 1-1/4" X .095  
2...1/2"x 2-14" rue pins.  
2...1/2 rue rings  
4...1/2" rod ends  
4...1/2" flat washer  
4...1/2" fine nylock nuts  
4...1/2"x 2" fine Gr. 8 bolts  
8...Chassis tabs 1/2" holes

4...Caster bracket sides  
2...Caster bracket gusset top  
2...Caster bracket gusset bottom  
2...Caster bracket and bar brace  
2...Caster bracket mounting plate  
8...1/8" tabs 5/16" hole  
4...5/16" thread tube adapter  
4...5/16" rod ends  
10...4-1/2" ...6-5/16" jam nuts  
6...5/16" bolts ... 4@1-1/4" long  
6...5/16" Nylock nuts...4 thick  
8...5/16" flat washer  
8 pcs. 1-3/8" tubing 2@3" ...4@1/2" long  
1...12" pc. 5/8" X .058 moly tubing

### FEATURES:

1. These wheelie bars are made of .095 wall chrome moly material that is extremely strong. They don't require a spring to absorb shock because they are engineered to provide a controlled amount of flex between the upper and lower bars.

2. Our unique cross bar and supporting diagonal links on the bars are designed to be positioned in a place that enables you to place a jack under the rear end with out having to disconnect a rear mounted cross bar as on other designs.

1500 Avenue R • Riviera Beach • Florida 33404

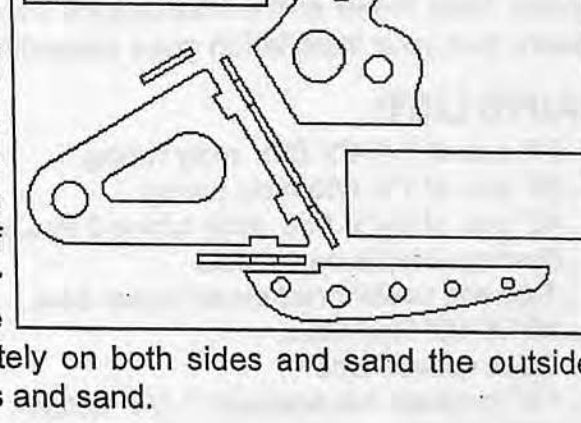


Info & Tech: (561) 863-2188  
Orders Only: (800) 327-9402  
Fax: (561) 863-1424  
WWW.Chassisengineering.com

**STEP 1:** Determine the width of the wheelie bars for your application. Clean the rear end housing in the area where the brackets will have to be welded.

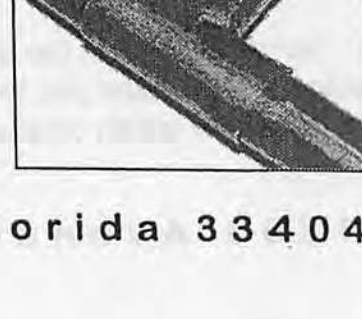
**STEP 2:** Find the center of the rear end housing on the bottom and mark it. Measure half the distance of the total width of the wheelie bars from the center mark outward on each side. This will be where the housing brackets will be welded. Bolt the rod ends between the brackets for the correct width using the non-locking nuts and tack weld in place. (The cross bar on the bottom of the four link brackets will make the best mounting spot for the brackets when using a four link. If using a ladder bar you must mount the tabs on the back side of the brackets or add a crossbar between the brackets for mounting.)

**STEP 3:** Assemble each caster bracket using 2-caster bracket side plates, 1-caster bracket bottom gusset (the gussets with the tabs. The other gussets will be installed later.), and 1-caster bracket mounting plate. Tack weld the side plates to the mounting plate so the large hole on the mounting plate is on the end that has the notches for the lower gusset. Tack Weld the lower gusset to the bottom of the side plates. (See Drawing #1) **Use the wheelie bar wheel to hold the brackets at the correct width while tacking them together.** Weld all of the brackets completely on both sides and sand the outside smooth. When complete weld the top gusset to the brackets and sand.



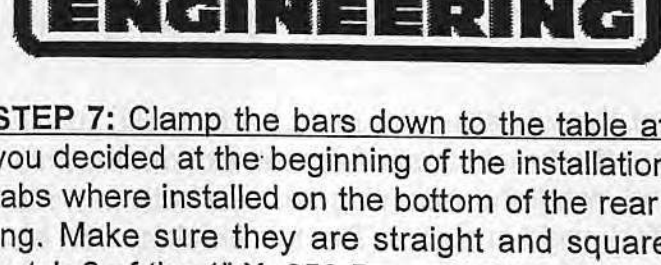
**STEP 4:** With the car at ride height, measure from the lower mounting brackets to where you want the center of the wheelie bar wheel to be. Take this measurement and subtract 2-3/4" for the caster bracket and 2-1/2" for the rod end and tube adapter. Use this dimension to cut two of the 1-1/4" x .095 pieces of tubing to size. Cut at 90 degrees on both ends.

**STEP 5:** Using a work bench tack weld the caster brackets to the end of each tube cut in step 4. Slide the tube into the caster bracket so the top end of the tube is flush with the top of the hole and the bottom of the tube will protrude into the bottom of the hole so it can be welded to the bottom gusset. Make sure that the tube is the same angle as the bottom of the caster bracket. An 1/8" spacer will be needed under the other end of the tube to bring it up to level with the caster bracket. When they are square and level tack weld in place.



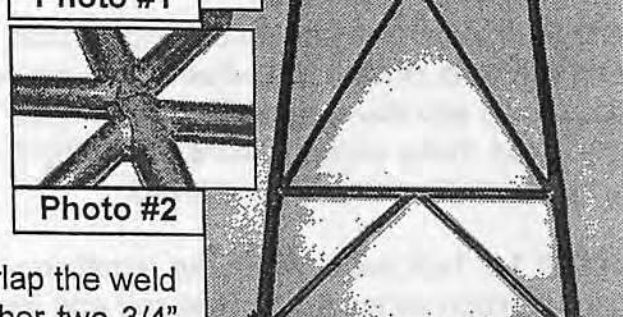
**STEP 6:** With the bars still on the work bench measure from the center of the wheelie bar wheels up each bar and mark at 12-1/2" and 14". Measure down from the top of the bar to the mark made at 14" from the bottom. Take half this length and mark both bars. This will be the mounting point for the upper crossbar. Slide one of the 1-3/8" x .058 sleeves on each bar and line the end closest to the caster bracket up with the 12-1/2" line.

1500 Avenue R • Riviera Beach • Florida 33404

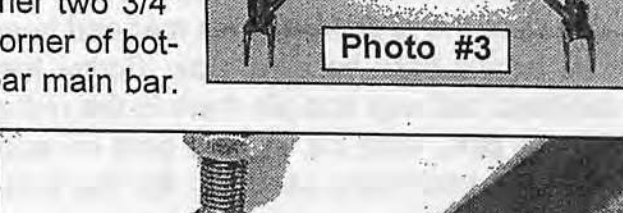


Info & Tech: (561) 863-2188  
Orders Only: (800) 327-9402  
Fax: (561) 863-1424  
WWW.Chassisengineering.com

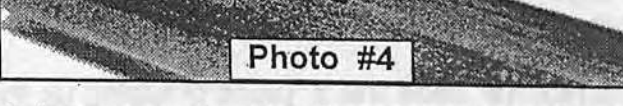
**STEP 7:** Clamp the bars down to the table at the width you decided at the beginning of the installation when the tabs were installed on the bottom of the rear end housing. Make sure they are straight and square. Cut and notch 2 of the 1" X .058 Pcs. of tubing to fit between the bars even with the upper marks made and the center of the piece of tubing slid over the tube. Once you have the bars square and level centered on the marks and tubing sleeve tack weld them in place.



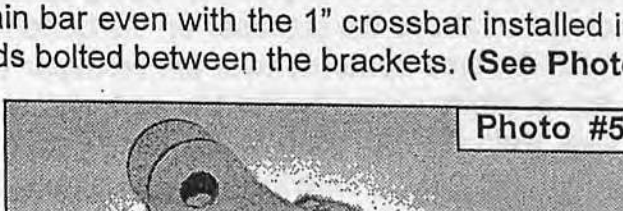
**STEP 8:** Cut and fit two 3/4" bent tubes to go from the center of the upper crossbar that you just tack welded in place (See Photo #2) to the top of each tube so they overlap the weld on the tube adapters. (See Photo #1) Cut and fit the other two 3/4" tubes to go from the center of the upper crossbar to the corner of bottom crossbar where it meets the sleeve on the wheelie bar main bar. Cut and fit the last piece of 3/4" tubing to go from the center of the lower crossbar to the tubes just behind the caster brackets. (See Photo #3) Tack weld all six bars in place when fit. **DO NOT WELD THE SLEEVE TO THE MAIN WHEELIE BAR TUBE IT MUST ROTATE.**



**STEP 10:** Bolt two small 1/8" thick tabs to all four 5/16" rod ends using the regular jam nuts that are supplied in the kit for set up. (Do not use the lock nuts). With the bars still clamped to the work bench tack weld one set of brackets that are bolted together to the top of each main bar even with the 1" crossbar installed in step 7. Repeat this on the other bar and leave the rod ends bolted between the brackets. (See Photo #4)



**STEP 11:** The rod end caster brackets for the upper bars will be the next to weld on. Take two of the rod end caster brackets and one of the 3/8" hole rod ends and pin them together using the 3/8" quick release pins. Place the brackets on the bars as shown in Photo #5 and weld in place making sure the rod ends fits between the brackets at both upper and lower mounting holes.



1500 Avenue R • Riviera Beach • Florida 33404



Info & Tech: (561) 863-2188  
Orders Only: (800) 327-9402  
Fax: (561) 863-1424  
WWW.Chassisengineering.com

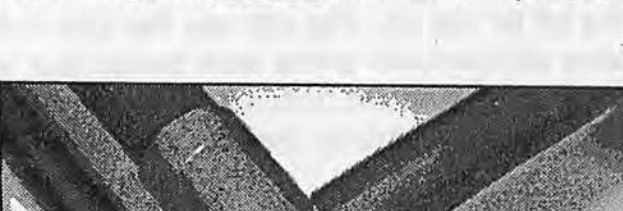
**STEP 12:** The hole in the top tabs that mount the top of the wheelie bars must be at least 10" or more higher than the hole in the lower mounts. The higher the brackets are from the bottom mounts the stronger the bars will be. Sand the housing clean and install the mounting tabs so both mounts are level to the ground and are the same front to back. Tack weld in place. (The top brackets can be narrower than the bottom.)

**STEP 13:** With the car at ride height install the rod ends half way and bolt the bottom bar to the rear end brackets. Install the wheelie bar wheels using the rue pins and rings. Place wood under the wheels so you have about 5"-1/2" from the ground to the center of the pin on each wheel. Once on the wood make sure the bars are straight and in the center of the car. If not the rod ends can be adjusted or the tabs can be moved.

**STEP 14:** Tack weld two of the remaining 1/2" tube adapters into one end of each 84" pc. of 1-1/4" tubing. Then screw a 1/2" hole rod end into the end of each tube half way. Install the rod ends and tubes into the brackets on the rear end housing by just sliding the bolts into the holes in the brackets. Just let the bars hang for now. Screw the 1/2" thread 3/8" hole rod ends into the other two tube adapters half way and pin them to the rod end caster brackets for the upper bars using the 3/8" quick release pins. With the wheelie bars on wood at the right height hold the top bars up next to the tube adapters and mark each bar for the correct length. Remove both bars from the car and cut as marked.

**STEP 15:** Before reinstalling the bars in the kit there are 2 pcs. of 1-3/8" OD tubing 3" long and 4 pcs. 1/2" long. Slide 1 of the 1/2" long pcs. of tubing on to the tube followed by 1 of the 3" pcs and then another 1/2" pc. Repeat this on the other tube. (These and the tube adapter will be welded later.) Slide a 1/2" tube adapter into the end of each piece of tubing but **DON'T** tack weld in place at this time.

**STEP 16:** Slide the 3" piece of tubing up the bar so it is centered above the crossbar on the bottom set of bars. With the tube centered over the crossbar slide the 1/2" pc. of tubing down to the top end of the 3" tube and tack weld the 1/2" tube to the bar. Repeat this on the other bar making sure they are the same distance from the end.



**STEP 17:** Slide the bottom 1/2" wide sleeve up to the 3" sleeve and clamp to hold the 3" sleeve in place. There should be two rod ends with bracket bolted to them left over from STEP 10. Clamp the rod end and brackets to the bottom of the 3" sleeve directly over the bottom rod end and tack weld in place. Repeat this on the other side. (See Photo #6)

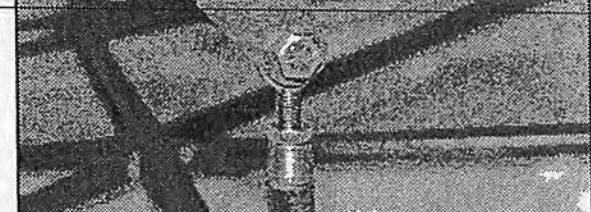


1500 Avenue R • Riviera Beach • Florida 33404



Info & Tech: (561) 863-2188  
Orders Only: (800) 327-9402  
Fax: (561) 863-1424  
WWW.Chassisengineering.com

**STEP 17:** Screw a 5/16" tube adapter onto each rod end half way. Hold the piece of 7/8" tube up next to the tube adapter and mark for the length. Cut and check for fit. Repeat on the other side. Both tubes should be the same length if the mounts on the rear are the same. Tack weld both bars together when fit. (See Photo #7)



**STEP 18:** Cut and fit a piece of 1" X .058 tubing to go between the sleeves on the top bars. Tack weld in place when fit. (See Photo #8)



**STEP 19:** Weld as much as you can on all of the crossbars and X braces before removing the wheelie bars from the car to finish welding.

**STEP 20:** Remove the wheelie bars from the car and remove the rod ends. Clamp the bars down to the table at the width you decided at the beginning of the installation when the tabs were installed on the rear end housing. Make sure they are straight and square. This will help keep the bars from pulling when they are finished welded.



1500 Avenue R • Riviera Beach • Florida 33404