

## **First Notes with assembly of the body of the Heeler**

- **Painting of the upper body panel and mudguard is done much easier when the body panels are not assembled.**
- **Because of the UV light off the sun painting of the upper panel is necessary, the lower panel does not have to be painted because it is not in the direct sunlight.**
- **When assembling the cover before painting it is wise to use 3,2 mm screws to fasten the press studs first. Then when all are mounted and the cover fits correctly drill the 4 mm holes. Then after painting you can use the rivets to fasten press studs the definitely. Use the M4 rings to**
- **Use only the enclosed sealant; this is tested and approved by us.**
- **In the original construction the complete body is sealed to the sidecar chassis with the enclosed sealant. If this cannot be done the body should be supported with an 2mm thick aluminium plate (see the construction manual).**
- **The quality of the product is very dependant off the quality of assembly.**

## Assembly off the Body.

**Note:** Painting of the upper body panel and mudguard can better be done before connecting upper and lower panels.



First assemble the hinge with the backrest.

You can see in the pictures that the hinge should be on the front side of the backrest. Make sure the backrest is assembled as in the right picture.

Drill the holes with a 4,5 mm drill.

Insert the rivets from behind of the backrest.



Make sure the lower panel is on flat surface. Temporarily assemble the upper panel and position the backrest in the body and mark the holes.

Take the backrest out and drill the holes with a 4,5 mm drill.

Insert the rivets from the hinge side of the lower panel and use the M4 washer to secure the rivets.



To strengthen the lower part we use brackets. They should be assembled at 6 to 8 centimetres from the hinge. Mark the holes and drill with a 4,5 mm drill.



Use the sealant before assembling the bracket with the rivets as shown in the pictures.



Position the lower panel on the sidecar chassis and mark the holes where the body should be connected with the sidecar chassis. Drill the holes with an 11 mm drill.



Apply sealant to the tubes on which the body rests on the frame.  
Place the body on the frame and insert a M10x70 bolt with big washer in each hole. Use a washer, spring-washer and nylock nut to tighten the body.



When the lower panel is assembled to the sidecar chassis the upper panel can be sealed to the lower panel. Grind the surfaces which are sealed to get a better result. **The backrest should be faced forward!** Make sure that you apply enough sealant all over the lower panel. **Use only the enclosed sealant!!!!!!**  
Place the upper panel on the lower panel. A clamp can be used to keep pressure on the body panels. The sealant should harden for at least 24 hours.



Check if the upper panel and lower panel fit correctly at the location of the passenger. If necessary widen the lower panel with a rod during the hardening of the sealant.



At the location of the mudguard there will be an open space. Use the aluminium profile with the sealant to close this space.



Position the mudguard and mark 3 holes. One can use double coated tape to make the marking easier. Drill the holes with a 6,5 mm drill.



Assemble the mudguard with 3 M6 x 20 bolts with the big washer and secure ring on the inside.



Mark the middle hole for the windscreen, drill the hole with a 6,5 mm drill and assemble the first plastic bolt with big washer and secure ring. Repeat these actions for the both sides of the windscreen. Release the screen and clean the holes.





Assemble the windscreen again and mount the windscreen cover tube. We paint the lower part of the windscreen to get a nicer result. The paint should be on the outside of the windscreen.



The seat can be pushed over the backrest. Take of the tape and glue the connecting tape to the upper panel by turning the backrest to it's place.