

ASSEMBLY & INSTALLATION NOTES

JUBU Rollbar with harness bar Emira (JU00247PRD) for EMIRA

Please follow the instructions in this manual for a proper assembly & installation of the JUBU Rollbar with harness bar for Emira.

Please find in this document:

1. PART LIST
2. ASSEMBLY & INSTALLATION NOTES
3. ADJUSTMENT OPTIONS

1. PART LIST for product JU00247PRD

#	ITEM	ART-NO.	UNITS
1	Aluminum rollbar	JU01240ART	1
2	Aluminum harness bar	JU01241ART	1
3	Rollbar bracket (CNC milled)	JU01085ART	2
4	Harness bar bracket right (CNC milled)	JU01077ART	1
5	Harness bar bracket left (CNC milled)	JU01078ART	1
6	Cutting template 1 panel rear left	JU01236ART	1
7	Cutting template 2 panel rear right	JU01237ART	1
8	Cutting template 3 carpet left	JU01238ART	1
9	Cutting template 4 carpet right	JU01239ART	1
10	Shim 1mm seatbelt screwing point	JU01250ART	2
11	Shim 2mm seatbelt screwing point	JU01251ART	2
12	7/16"-20UN x 52mm titanium head cap screw (blk)	JU01087ART	2
13	7/16"-20UN x 19mm titanium seatbelt screw (blk)	JU01097ART	2

#	ITEM	ART-NO.	UNITS
14	ISO 14579 M10x22 titanium head cap screw (blk)	JU01094ART	8
15	ISO 14579 M12x22 titanium head cap screw (blk)	JU01095ART	4
16	M12x30 Center titanium head cap screw (blk)	JU01086ART	1
17	DIN 6926 M6 self-locking nut	-	1
18	Ø5 Rivet	-	12
19	Bodywork adhesive	VM00081	1
20	Bodywork adhesive primer	JU00183ART	1
21	Wool dauber	VM00094	1

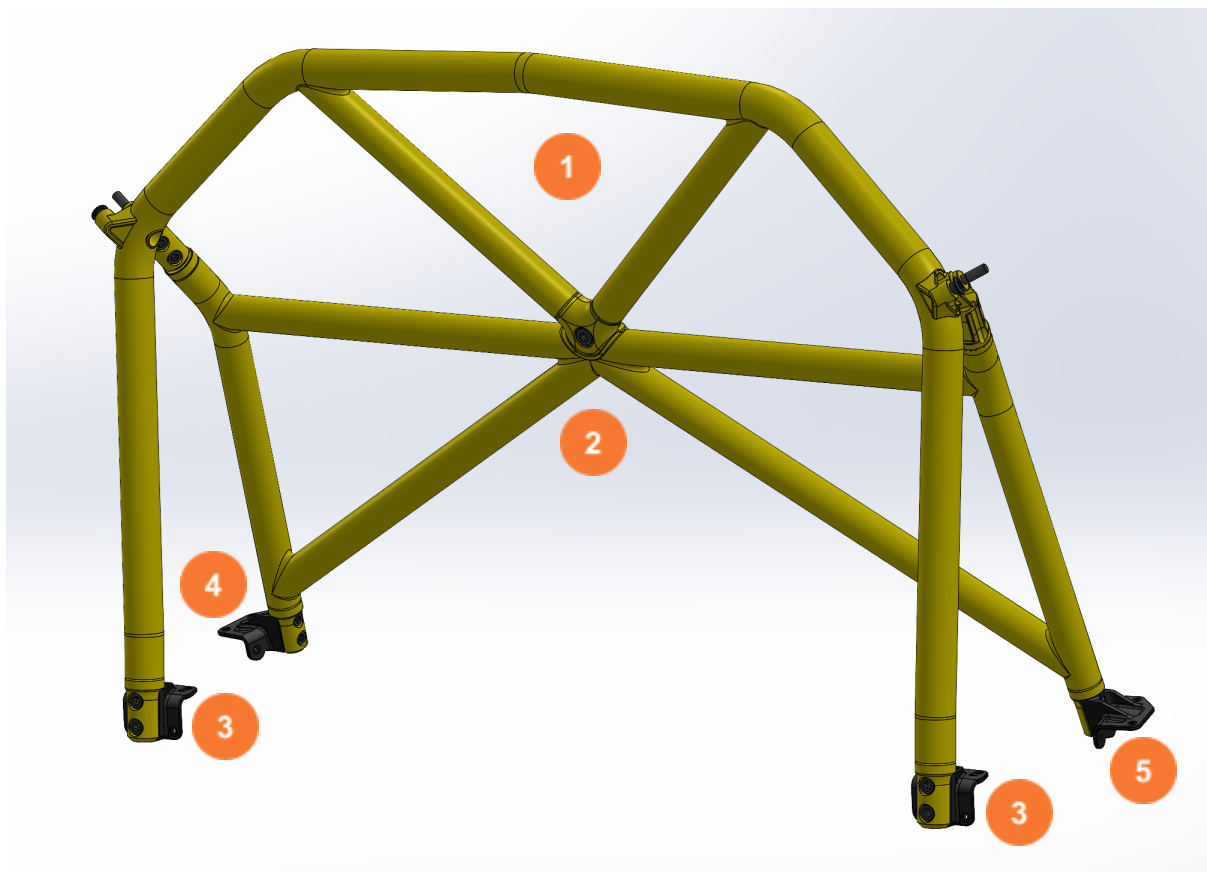


Fig 1: Scope of delivery

2. ASSEMBLY & INSTALLATION NOTES

Level of difficulty: **COMPLEX**

Required time: **3h - 5h** (depends on experience, available tools & skills)

 **NOTE:** Unless specified otherwise, following torques are applied on the screws:

- M5: 6 Nm
- M6: 10 Nm
- M8: 25 Nm
- M10: 50 Nm
- M12: 85 Nm
- 7/16"-20UN: 60 Nm

 **NOTE:** When mentioned left or right, this always refers to the driving direction.

1. Uninstall the panels in the rear interior, as well as the panels that cover the B-pillars.



Fig 2: Uninstall the rear interior panels.

 **NOTE:** At the ! marked points are hidden screwing points.

2. **NOTE:** Before disconnecting the battery the car should be put into sleep mode!
 - Ignition off.
 - Remove the key out from the car and close the doors and the rear tailgate but note the tailgate must be open (only lock the release mechanism)
 - Please wait 5 minutes

3. Trim the OEM plastic brackets in the rear corners as shown in *Fig 3* (on both sides)



Fig 3: Trimming the plastic brackets in the rear corners.

4. Trim the lower ends of the rear bulkhead as shown in *Fig 4* and *Fig 5*, remove the rivets in the marked areas and remove the adhesive residues.

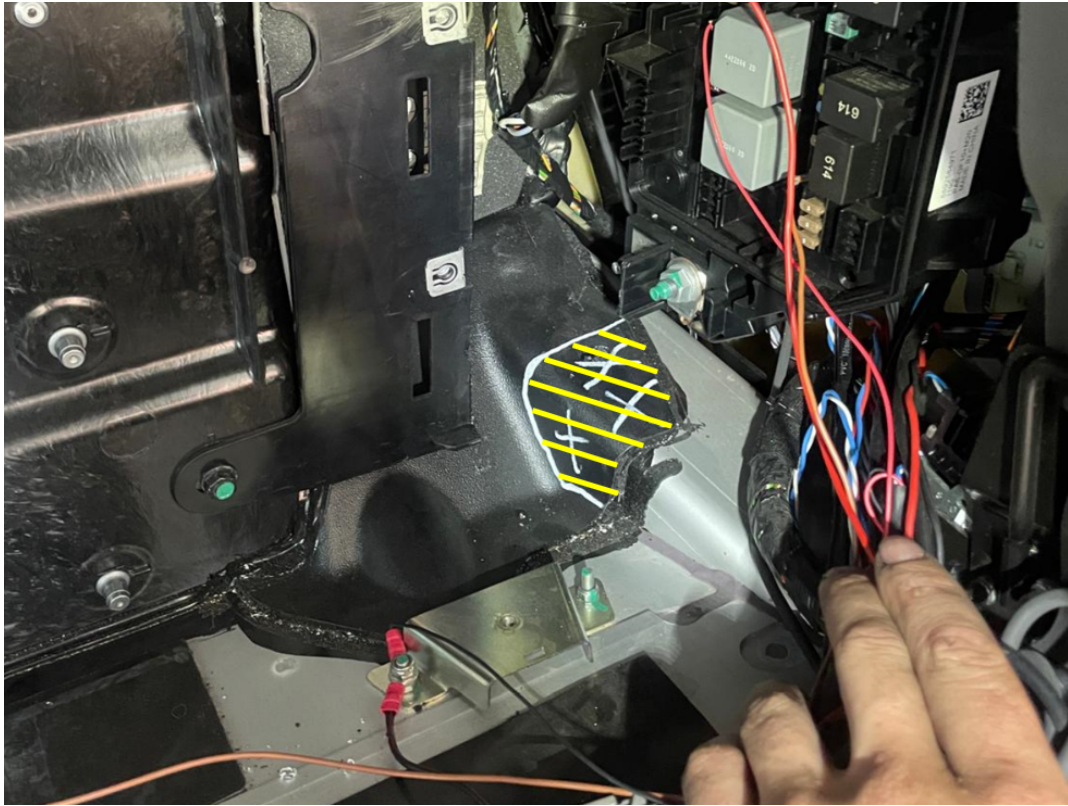


Fig 4: Trim the lower ends of the rear bulkhead



Fig 5: Trim the lower ends of the rear bulkhead II

5. Put the right harness bar bracket (4) in position and fix it loosely using 1x M6 nut (17). Now drill the required Ø5mm holes as marked in Fig 6.



Fig 6: Drill the Ø5mm holes for the right harness bar bracket (4).

⚠ NOTE: The rivets are inserted later.

6. Cut the carpet as shown in Fig 7 using the cutting templates 3 (8) and the cutting template 4 (9) on both sides.

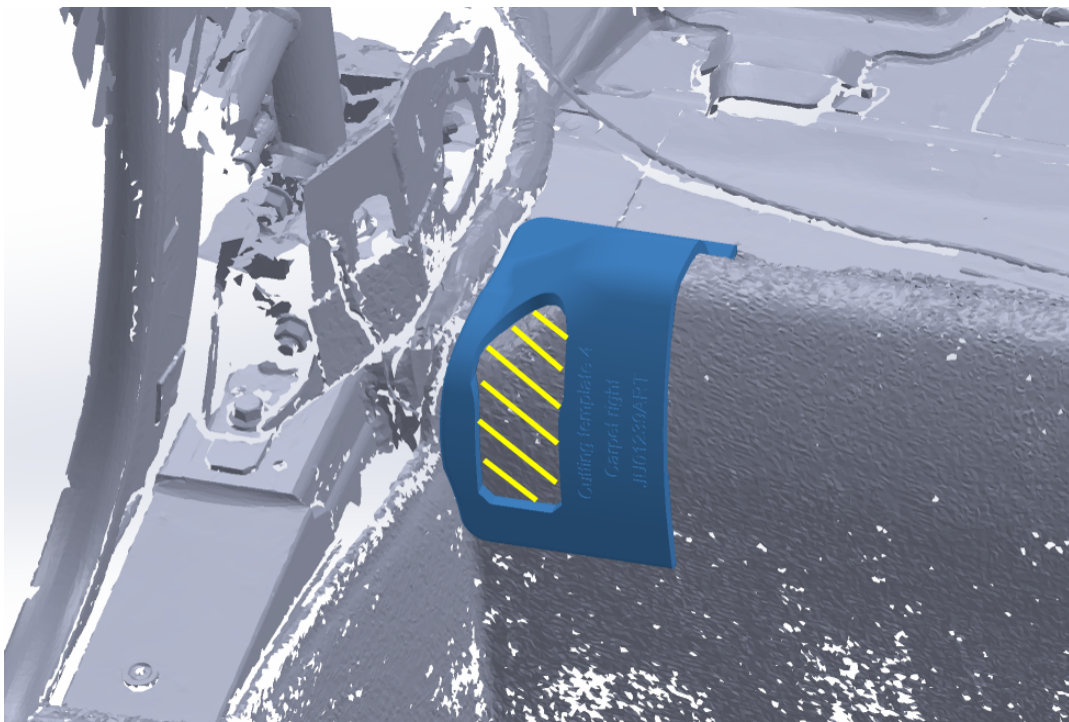


Fig 7: Cut the carpet using the cutting templates 3 (8) and the cutting template 4 (9).

7. Put the 2x rollbar brackets (3) in position and fix them loosely using the OEM M5 nuts. Now drill the required Ø5mm holes as shown in *Fig 8* and *Fig 9*.

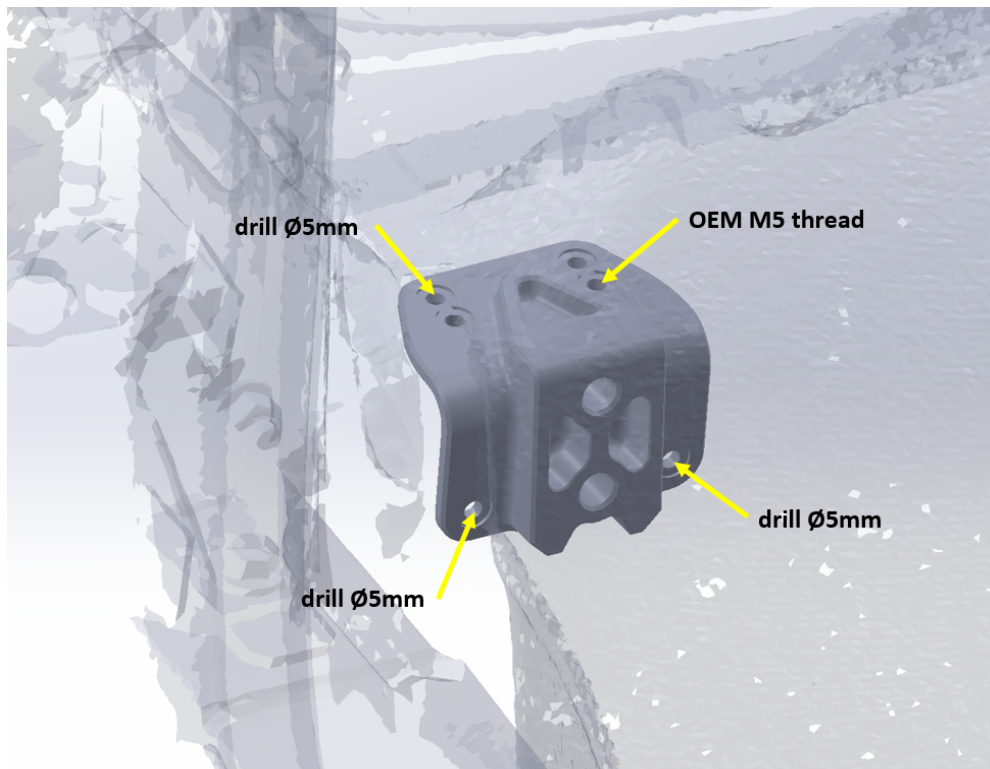


Fig 8: Drill the Ø5mm holes for the right rollbar brackets (3).

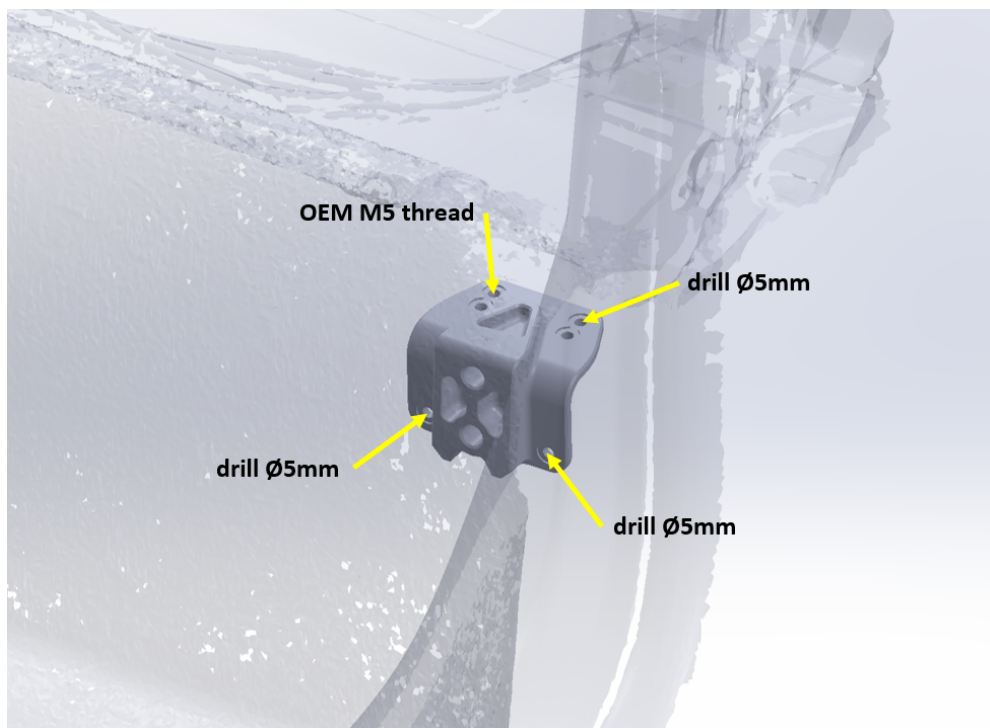


Fig 9: Drill the Ø5mm holes for the left rollbar brackets (3).

8. Do a test-mount of the harness bar (2) and the rollbar (1). This is described in more detail from point 13 to point 17.

9. Now the position of the left harness bar bracket (5) is marked.
10. After removing the rollbar (1) and the harness bar (2), the 3x Ø5 holes for the left harness bar bracket (5) are drilled as marked in Fig. 9.

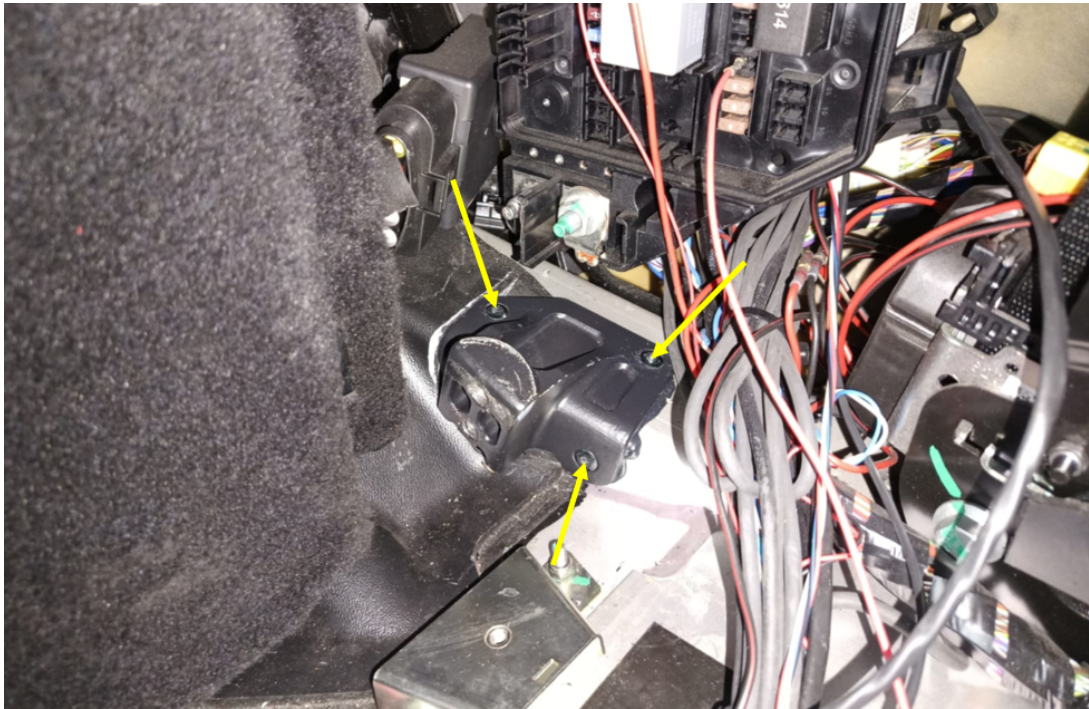


Fig 9: Drill the Ø5mm holes for the left harness bar bracket (5).

11. Glue the rollbar brackets (3) and the harness bar brackets (4 & 5) to the chassis by using bodywork adhesive (19). Before applying the bodywork adhesive (19) treat the surfaces with primer (20) using the wool dauber (21). Additionally the rollbar brackets (3) are each fixed with 3x Ø5 rivets (18) and 1x OEM M5 nuts.
The right harness bar bracket (4) is fixed with 1x M6 nut (17) and 3x Ø5 rivets (18).
And the left harness bar bracket (5) is fixed with 3x Ø5 rivets (18).

 **NOTE:** The bodywork adhesive (19) needs at least 90 minutes curing time.

12. Reinstall the panels that cover the B-pillars, as well as the panels in the center.

 **NOTE:** The screws in following points 13, 15, 16 and 17 are only loosely screwed for positioning.

13. Screw the harness bar (2) to its brackets (4 & 5) using 4x M10x22 head cap screws (14).

14. Mount the seatbelt turning loops to the rollbar (1) by using 2x 7/16"-20UN x 19 seatbelt screws (13) and fix them with screw lock LOCTITE 243 screw locking lacquer.
 15. The rollbar (1) is fixed to the chassis on the seatbelt screwing points with 2x 7/16"-20UN x 52 (12) head cap screws. Between the Rollbar and the chassis the OEM 7mm seatbelt spacer is used.
- NOTE:** If required 1mm Shims (9) and 2mm Shims (10) can be used additionally to the OEM 7mm seatbelt spacer to compensate for possible manufacturing tolerances in Chassis and rollcage.
16. The rollbar (1) is bolted to its brackets by 4x M12x22 head cap screws (15).
 17. Connect the rollbar (1) and the harness bar (2) with 4x M10x22 head cap screws (14) and 1x M12x30 head cap screw (16) in the center.
 18. Finally fix all the screws from the points 13, 15, 16 and 17 (12, 14, 15, 16) with screw lock LOCTITE 243 screw locking lacquer and tighten them according to the torque at the beginning of Chapter 2. **Assembly & Installation Notes.**

NOTE: Because of manufacturing tolerances, in the chassis and the rollcage the system might experience some tensions during installation.

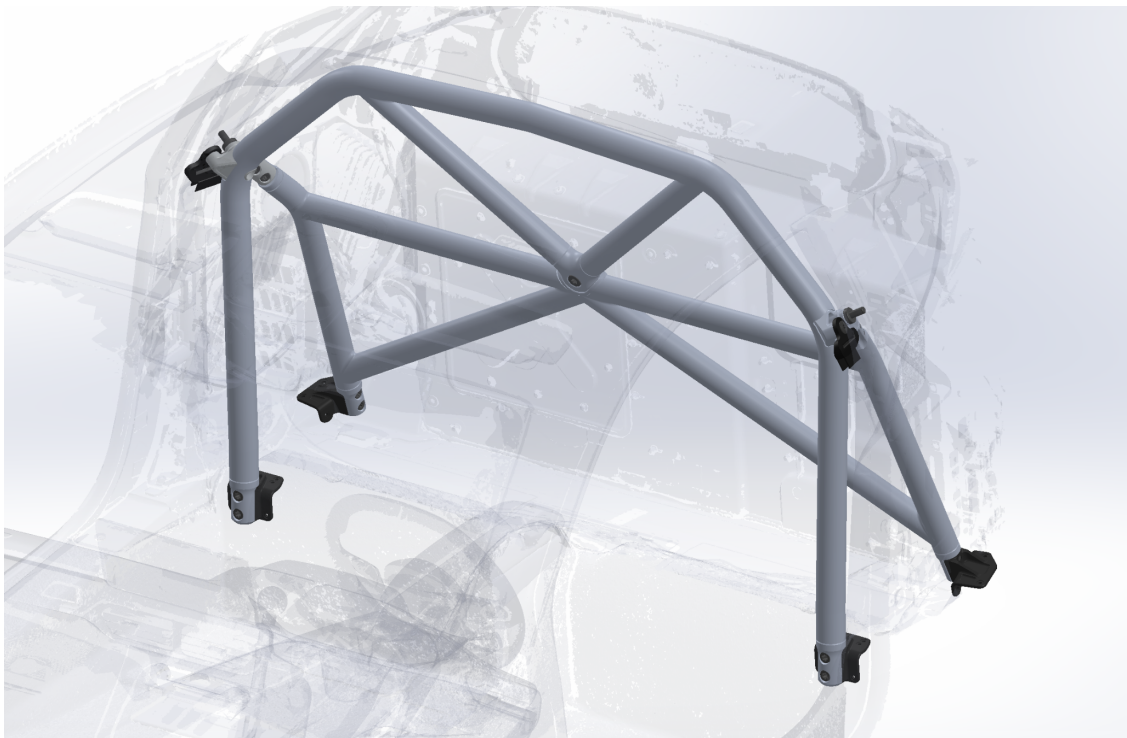


Fig 10: Installing the rollbar (1) and the harness bar (2).

19. Trim the panels for the rear corners by using cutting template 3 (6) and cutting template 4 (7) as shown in *Fig 11*.



Fig 11: Trimming the panels for the rear corners.

20. Reinstall the panels for the rear corners.
21. Reinstall also the seats and connect the battery

If you have any questions or need additional information, please contact us by email:

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