

## ASSEMBLY & INSTALLATION NOTES

# JUBU front splitter with chassis protection and sideskirts

for Exige S, 350 Sport, 360 CUP, 380 Sport and CUP R

Please follow the instructions in this manual for a proper assembly & installation of the JUBU front splitter with chassis protection and sideskirts for Exige S, 350 Sport, 360 CUP, 380 Sport und CUP R.

Please find in this document:

1. PART LIST
2. ASSEMBLY & INSTALLATION NOTES

### 1. PART LIST for product JU00340PRD

#	ITEM	ART-NO.	UNITS
1	Exige front splitter 350 road	JU01182ART	1
2	Exige front splitter 350 track	JU01183ART	1
3	Exige front splitter CUP R	JU01224ART	1
4	Exige chassis protection right	JU01184ART	1
5	Exige chassis protection left	JU01185ART	1
6	Exige chassis protection connection	JU01186ART	1
7	Crashbox reinforcement right	JU01187ART	1
8	Crashbox reinforcement left	JU01188ART	1
9	Crashbox reinforcement center	JU01189ART	1
10	Exige 350 front clam reinforcement center	JU01190ART	1
11	Exige 350 front clam reinforcement sides	JU01191ART	2
12	Frontsplitter bracket right	JU01192ART	1
13	Frontsplitter bracket left	JU01193ART	1
14	Spacer for frontclam center 11mm	JU01194ART	2
15	Spacer for crashbox	JU01195ART	2

#	ITEM	ART-NO.	UNITS
16	Spacer for chassis front	JU01196ART	1
17	Spacer for A-pannel 20mm	JU01197ART	4
18	Spacer for rear undertray plate 6mm	JU01198ART	6
19	M6 countersunk washer	JU01199ART	4
20	ISO 7380-2M5x20 lens head screw	-	2
21	ISO 7380-2M5x25 lens head screw	-	6
22	DIN 912 M6x16 head cap screw	-	6
23	ISO 14581 M6x16 countersunk screw	-	8
24	ISO 7380-2 M6x20 lens head screw	-	27
25	ISO 7380-2M6x30 lens head screw	-	6
26	ISO 7380-2 M6x40 lens head screw	-	6
27	ISO 7380-2 M8x16 lens head screw	-	6
28	M6 rivet nut	-	10
29	DIN 934 M6 nut	-	2
30	M6 slip nut	-	16
31	DIN 9021 M5 bodywork washer	-	8
32	DIN 125 M6 washer	-	8
33	DIN 9021 M6 bodywork washer	-	37
34	DIN 9021 M8 bodywork washer	-	6
35	Bodywork adhesive	VM00081	1
36	Bodywork adhesive primer	JU00183ART	1
37	Wool dauber	VM00094	1
38	Super glue	VM00159	1
39	Double-sided tape	JU00541ART	1

- either 1, 2 or 3, depending which part you have ordered.

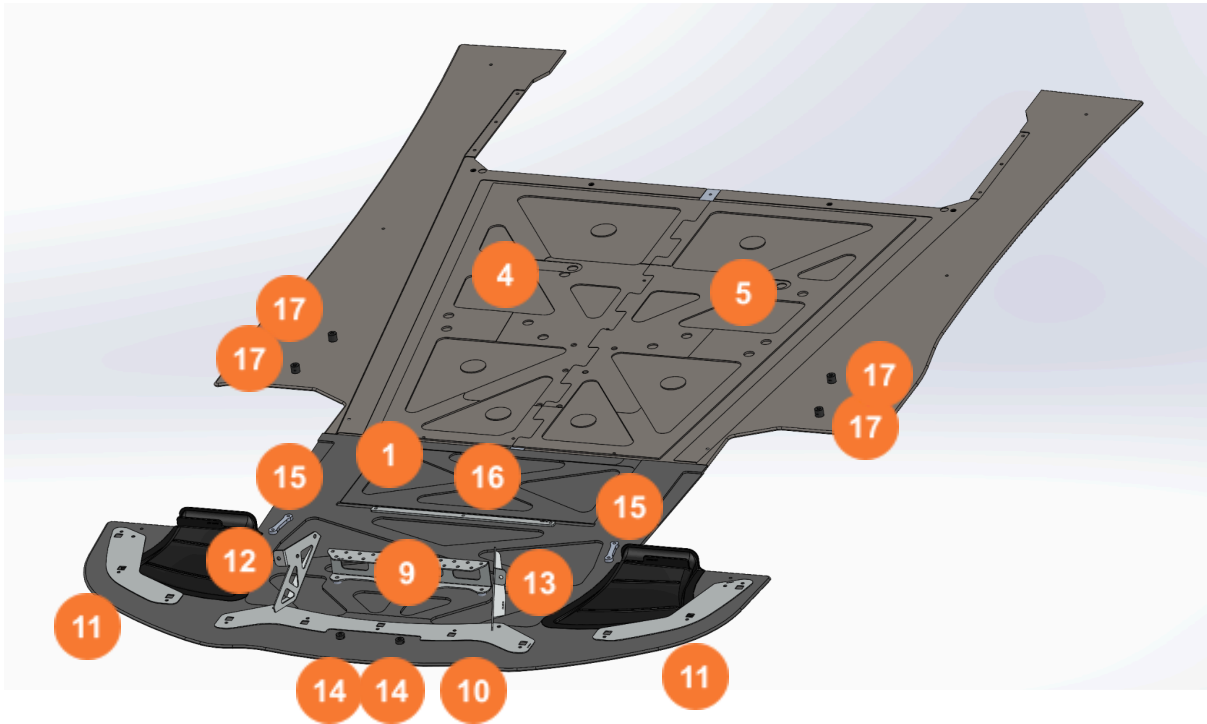


Fig 1: Scope of delivery

## 2. ASSEMBLY & INSTALLATION NOTES

Level of difficulty: **MEDIUM - COMPLEX**

Required time: **4h - 7h** (depends on experience, available tools & skills)

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

- M5: 6Nm
- M6: 10Nm
- M8: 25Nm
- M10: 50Nm

1. Disassemble the center grille, the aluminum plate below the crashbox and the rear undertray plate.
2. Remove the OEM M5 slip nuts from the bottom of the frontclam and glue the frontclam reinforcements (10, 11) into the frontclam as shown in Fig. 2 using bodywork adhesive (35) and bodywork adhesive primer (36)

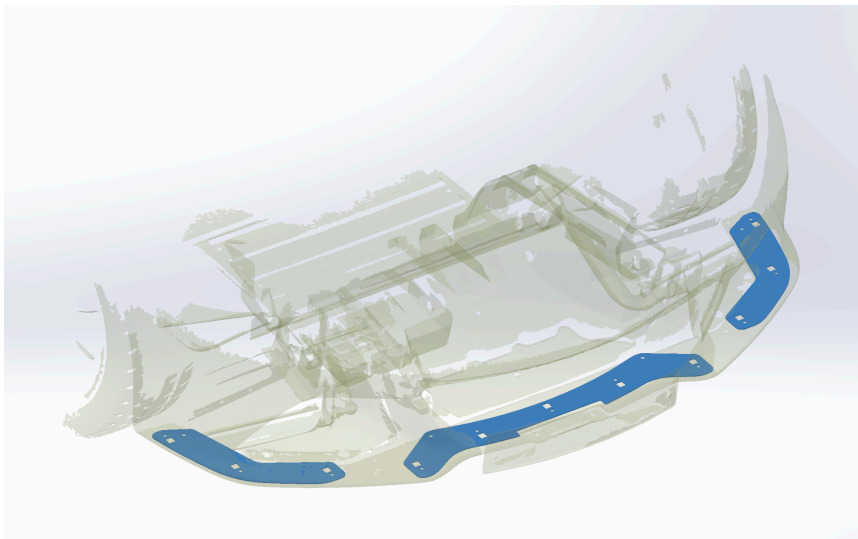


Fig 2: Installing the frontclam reinforcements (10 & 11).

**!** **NOTE:** The bodywork adhesive (35) needs at least 90 minutes curing time.

3. Place the frontsplitter brackets (12, 13) as shown in Fig 5, mark the holes (Fig. 3) and drill them with  $\varnothing 7\text{mm}$ .

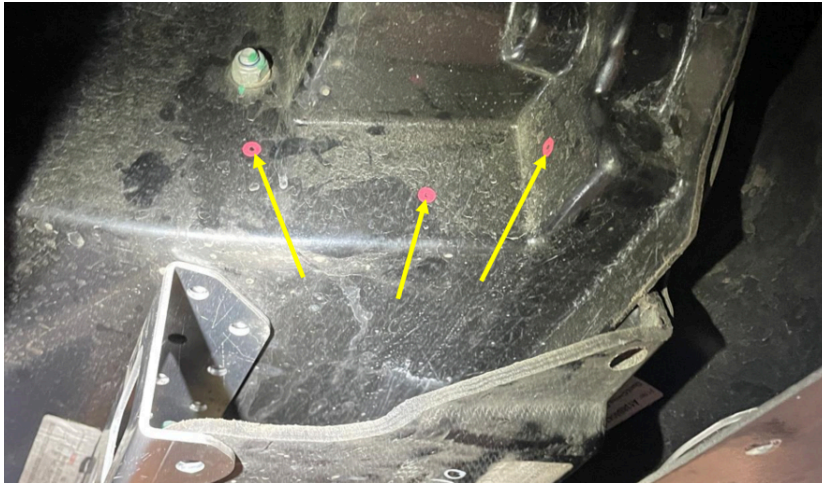


Fig 3: Drilling the holes for the frontsplitter reinforcements (10 & 11).

4. Glue the crashbox reinforcements into the crashbox by using the frontsplitter brackets (12, 13). The adhesive surface must be pre-treated with primer (36) .

The M6x16 head cap screws (6 pcs) (22) and the M6 washers (6 pcs) (32) must be screwed together by using *LOCTITE 243*.

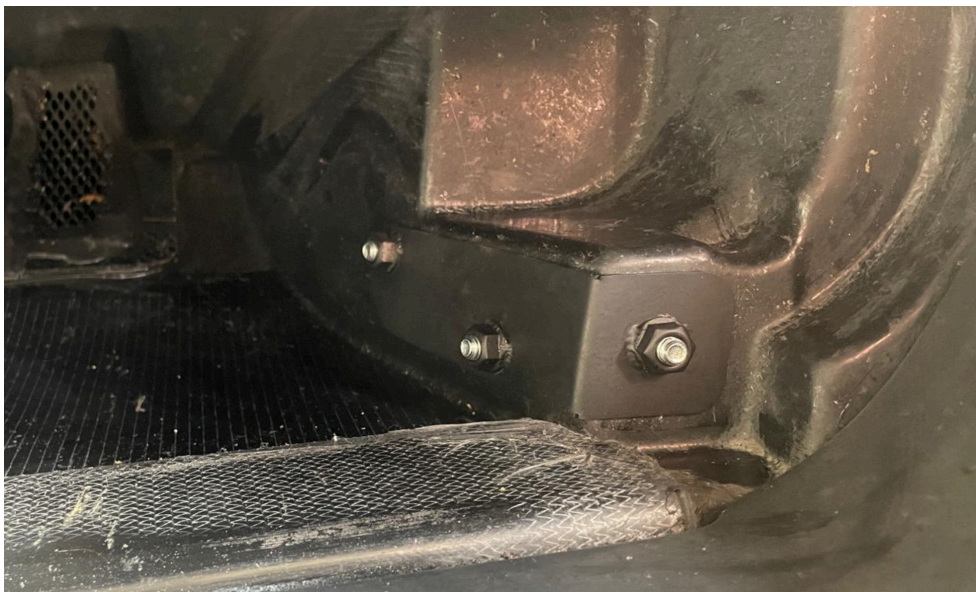


Fig 4: Mounting the crashbox reinforcement (7).

5. Drill Ø7mm holes in the front clam as marked in *Fig 5*. and put M6 slip nuts (30) on the frontsplitter brackets (12, 13) above the newly drilled holes.



Fig 5: Mounting the frontsplitter bracket (12) and drilling the required Ø7mm into the frontclam.

6. Mount the center crashbox reinforcement (9) as shown in Fig 6. Glue in the reinforcement (9) part with bodywork adhesive (35). The adhesive surface must be pre-treated with primer (36). Fix the reinforcement aluminum part to the crashbox by using 2 pcs M6x20 lens head screws (24) with 2 pcs M6 washers (32).

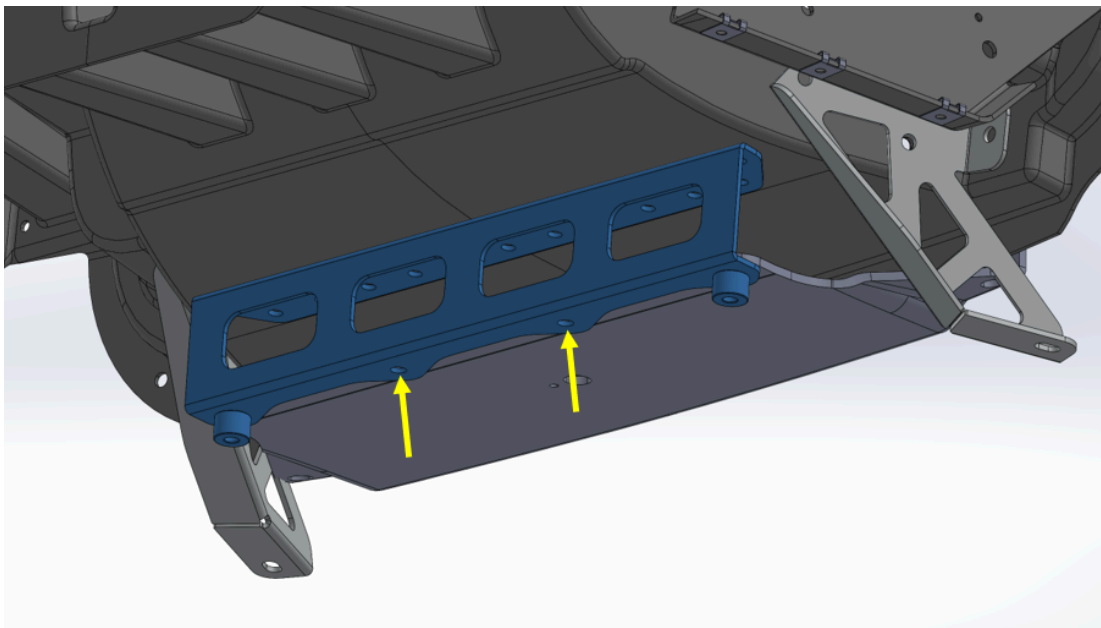


Fig 6: Fix the reinforcement part (9) to the crashbox with two screws in the center.

**⚠ NOTE:** The bodywork adhesive needs at least 90 minutes curing time.

- Put 10 pcs M6 slip nuts (30) on blue marked positions of frontclam as shown in Fig. 7 and exchange the red marked OEM ones to 4 pcs M6 slip-nuts (30).

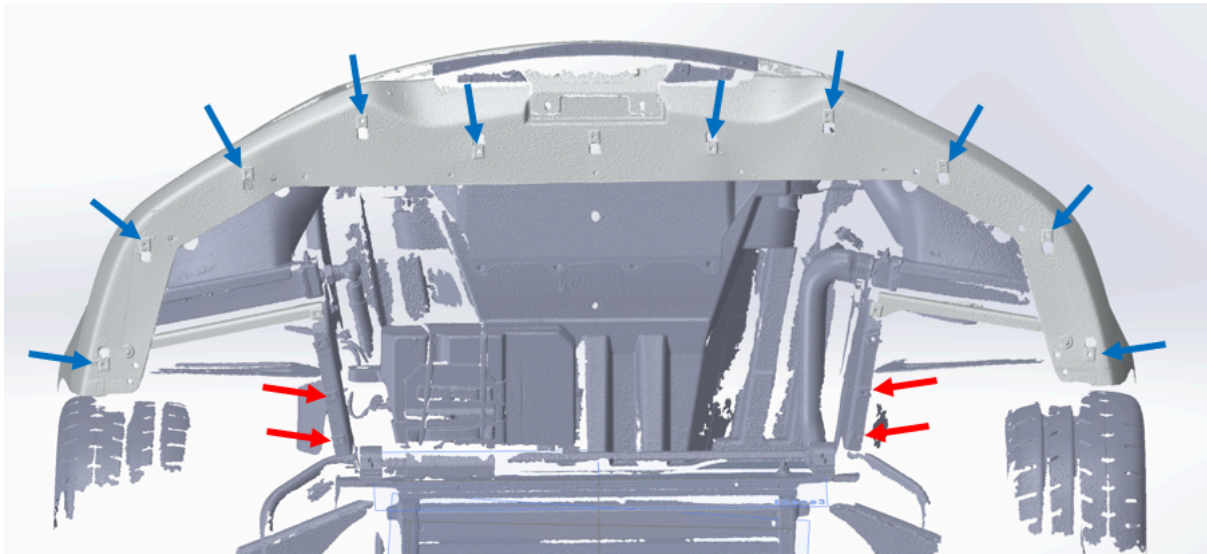


Fig 7: Put M6 slip nuts (30) on the marked positions.

- Remove the in Fig 8 yellow marked screws from the A-panel and as well the blue marked screws. (to loosen the blue marked screws a few hits are necessary to loosen the bodywork adhesive) Recut the M6 threads of the blue marked screwing points. The green marked rivet must be removed and must be drilled out to  $\varnothing 7\text{mm}$ .

**!** **NOTE:** If there is a lot of unused OEM bodywork adhesive next to existing rivets or screws, please remove it. Otherwise a collision with the chassis protection is possible!

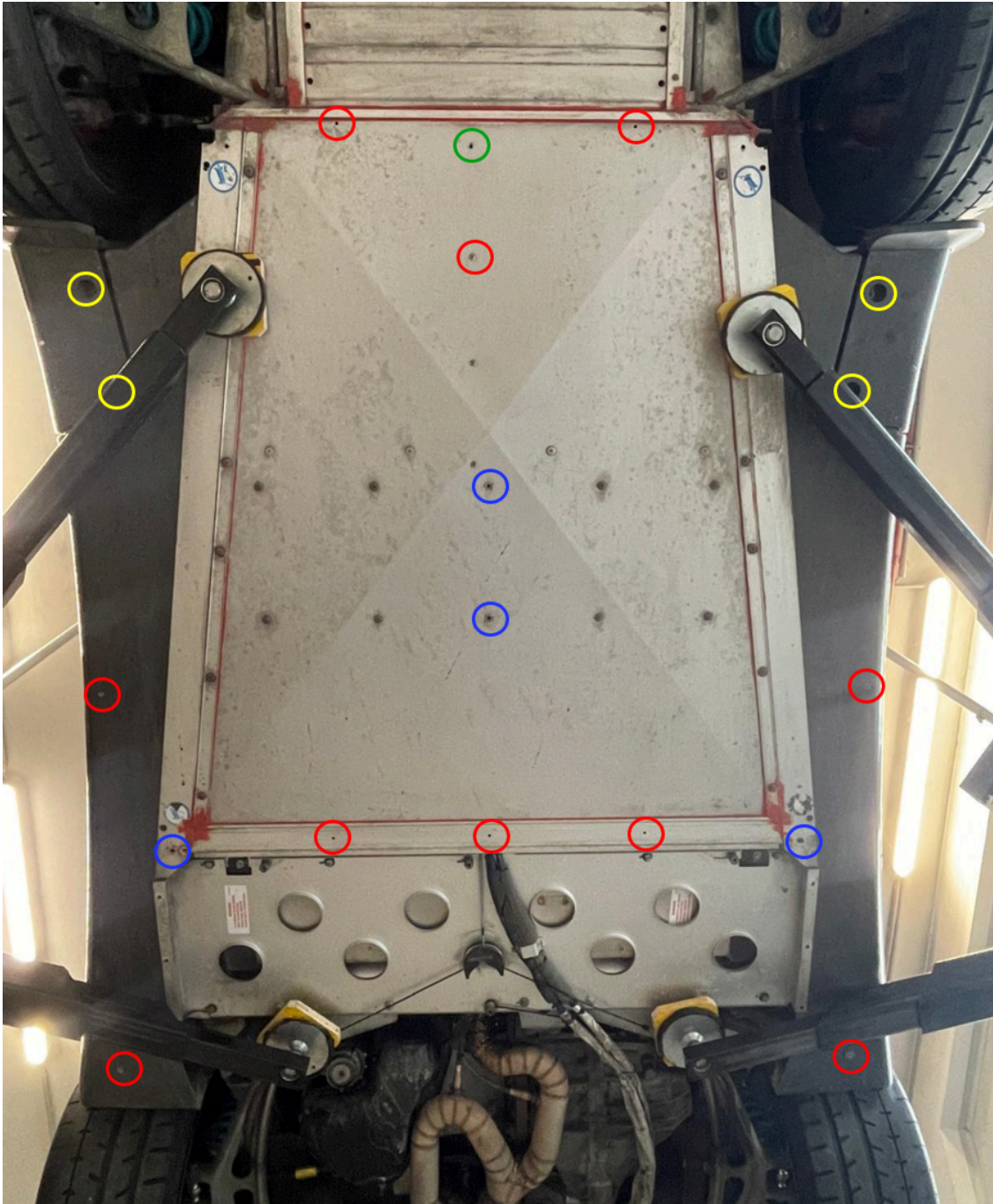


Fig 8: Preparing the screwing points at the underfloor

9. To get the positions for the red marked holes the chassis protection (4,5) must be test-mounted. After marking the positions, the holes need to be drilled to  $\text{Ø}7\text{mm}$ .
10. After removing the chassis protection, M6 rivet nuts (28) are put into the in Fig 8 red and green marked holes.



11. Put the spacers for the frontsplitter (14, 15, 16) in position and fix them with super glue (38). As shown in Fig. 9.

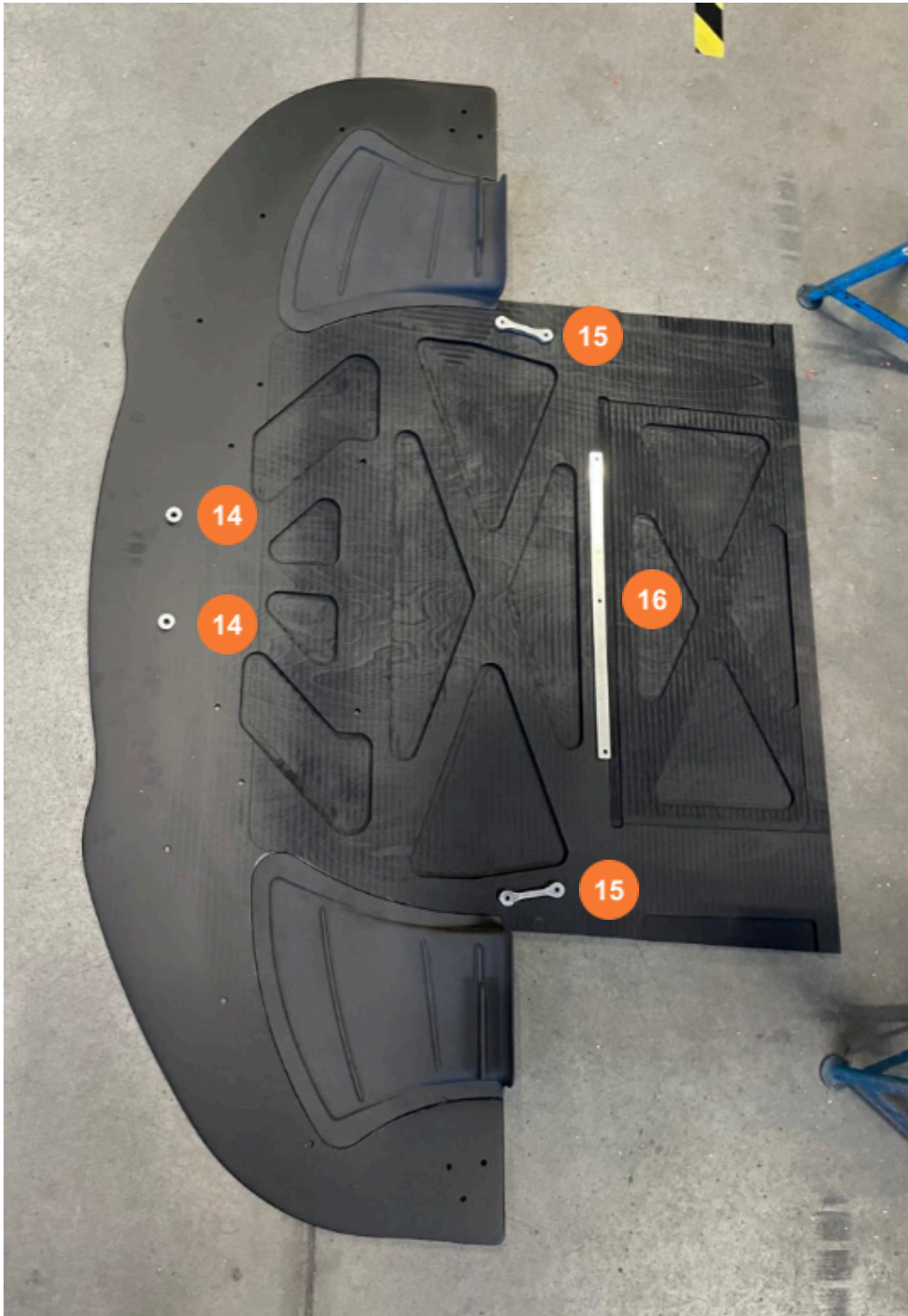


Fig 9: Preparing the spacers (14, 15, 16) for the frontsplitter.

12. Mount the frontsplitter (1/2/3) by using 2 pcs M5x20 lens head screws (20), 17 pcs M6x20 lens head screws (24), 6 pcs M6x30 lens head screws (25) and 2 pcs M6x40 lens (26) head screws with 2pcs M5 bodywork washers (31) and 25 pcs M6 bodywork washers (33).



Fig 10: Screw usage on Frontsplitter.

13. If required the wheel arches can be fixed to the top of the front-diffusers by drilling  $\text{\O}8.5\text{mm}$  holes and fixing them by using the OEM expanding rivets.

14. Put double sided tape (39) along the marked line as shown in *Fig 11*. This prevents dirt from getting into the area underneath the chassis.

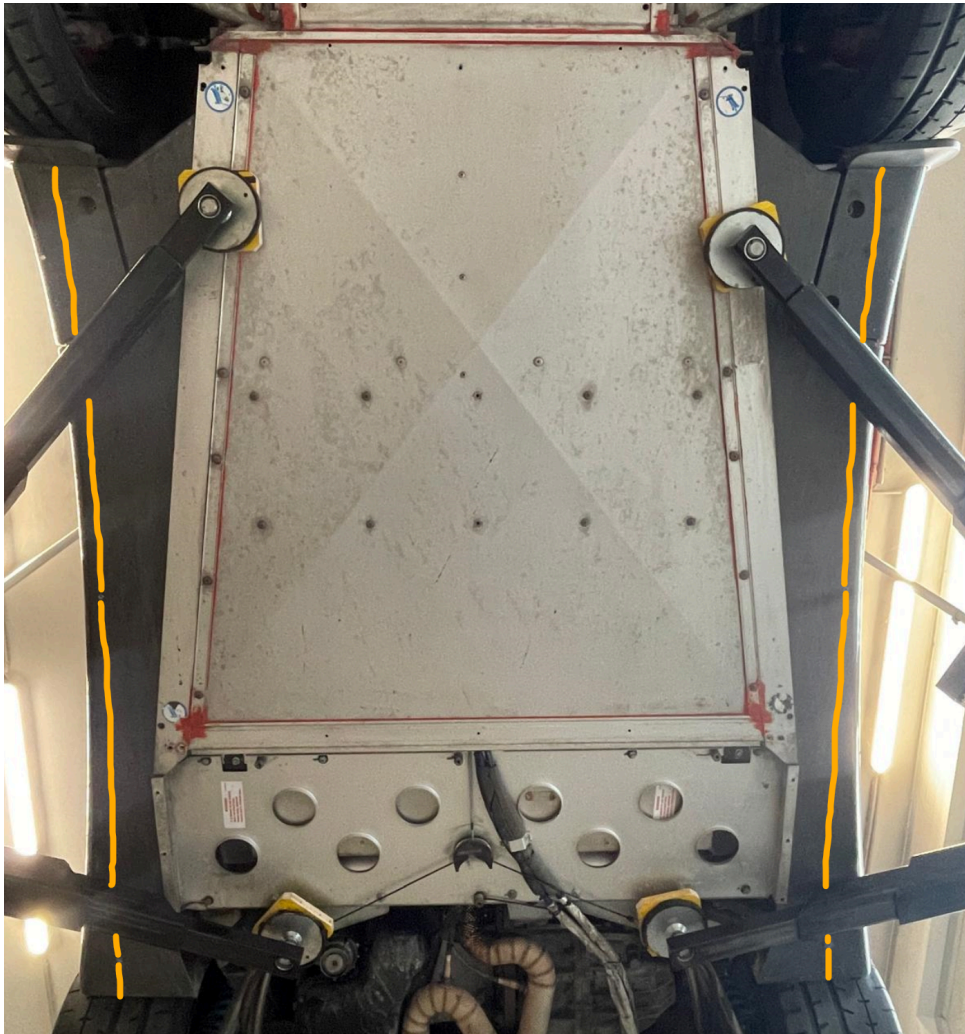


Fig 11: Put double sided tape (39) along the marked lines.

15. Add bodywork adhesive to the in *Fig 12* marked areas and put the 4x 20mm spacers for the A-panel (17) in position and fix them with super glue (38).



Fig 12: Put bodywork adhesive on the marked areas and prepare the spacers for the A-panels (17).

16. The chassis protection (4,5,6) is ready for mounting. Use 8 pcs M6 countersunk screws (23) with 8 pcs M6 countersunk washers (19), 8 pcs M6x20 lens head screws (24) and 4 pcs M6x40 lens head screws (26) with 12 pcs M6 bodywork washers (33). To fix the two screws at the yellow arrow area additional 2 pcs M6 nuts (29) must be used.

**!** NOTE: The bodywork adhesive needs at least 90 minutes curing time.

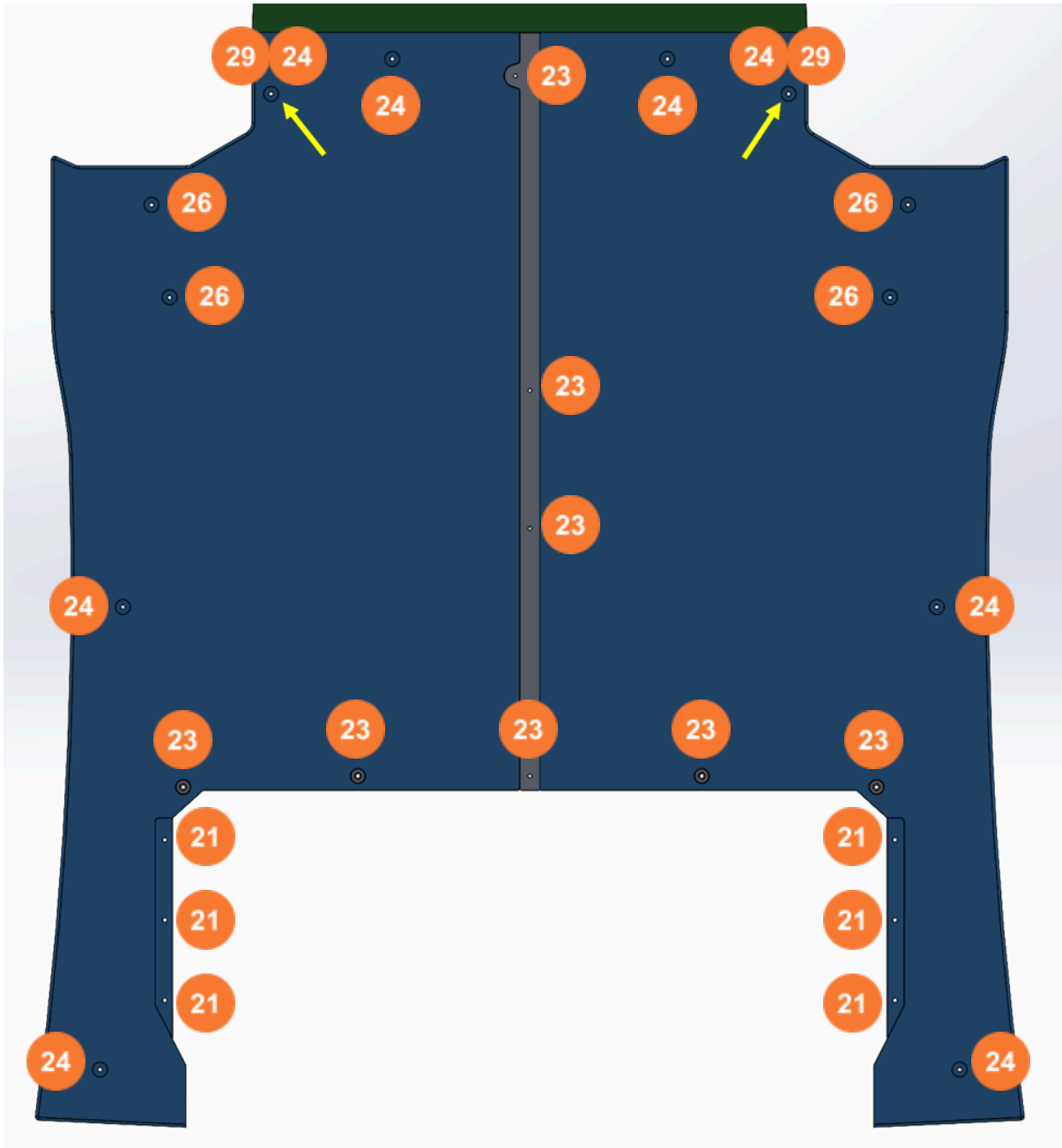


Fig 13: Screw usage on chassis protection.

17. To adjust the rear undertray plate height to the system, 6 pcs 6mm spacers (18) must be glued by using super glue (38) at the blue marked arrows and the edge at the front must be folded as shown in Fig 15.

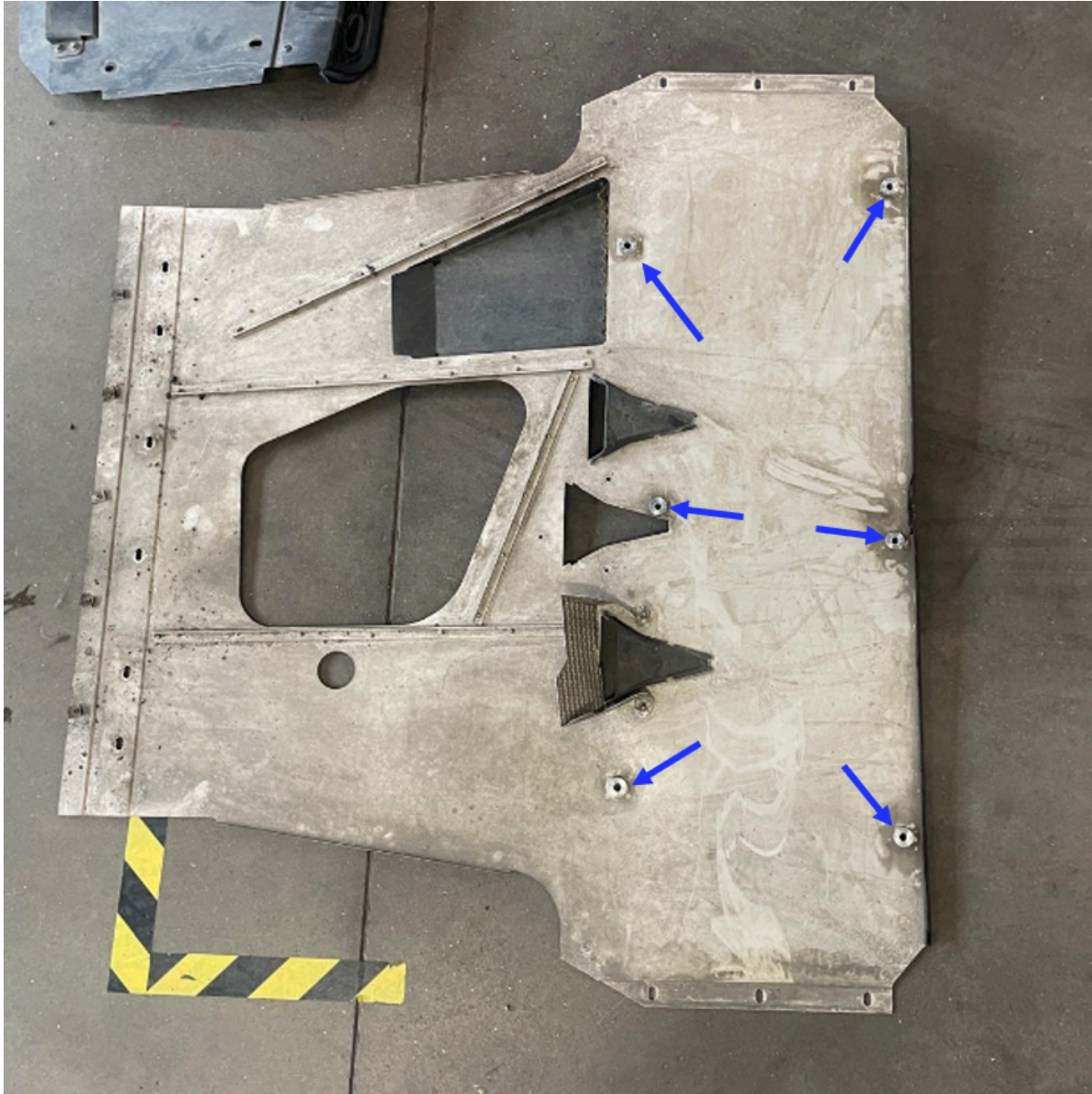


Fig 14: Glue spacers (18) to the rear undertray plate.



Fig 15: Fold the front edge of the rear undertray plate.

18. The rear undertray plate is mounted to the car by using 6 pcs M5x25 lens head screws (21) with M5 bodywork washers (31) at the sides and 8 pcs M8x16 lens head screws (27) with M8 bodywork washers (34) at the screwing points with the spacers. For the remaining holes the OEM screws must be used.

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

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