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How We Installed Our Roadster Dash:

General Description

The installation of the dash is a gray area for most first time roadster builders. This is how we did it. There are 4 major areas to be addressed:

- Mounting the top of the dash to the dash hoop
- Supporting the bottom edge of the dash
- Securing and trimming the ends of the dash
- Covering the dash

I. Parts Needed

To mount the top:

7 ea. 20023 8-32 x 5/8" Button Head Screw, Stainless Steel

7 ea. 20222 #8 Washer, Stainless Steel

To support the bottom:

1 ea. Breeze #70019 Dash Support Bracket Kit

To secure the ends:

2 ea. Dash End "L" Brackets (Fabricated by customer – see below)

4 ea. 20044 10-24 x 3/4" Button Head Screw, Stainless Steel

4 ea. 20042 #10 Washer, Stainless Steel

4 ea. 20363 Rivet, 3/16" Dia. x .250" Grip, All Stainless Steel

To cover the dash

2 yd. Vinyl Dash Covering (source from local auto upholstery shop)

II. Tools and Other Items Supplied by the Builder

- Center Punch and Drill
- Drill Bits (#30 for 1/8" rivets, #10 or 3/16" for 3/16" rivets, #29 for 8-32 Tapped Hole, #25 for 10-24 Tapped Hole, 11/64" for #8 clearance hole, and 3/16" for #10 clearance hole)
- Tap and tap wrench
- Pop-Rivet tool
- Spring Clamps to hold dash in position
- Tin Snips
- Contact cement, disposable brushes
- Razor Blade, scissors, x-acto knife (for trimming dash vinyl material)
- Level
- Vise and hacksaw to fabricate angle brackets

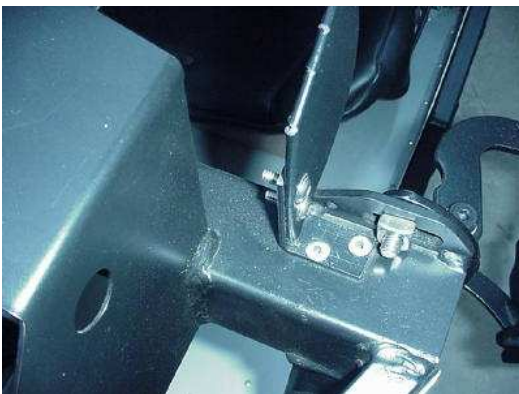


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III. Installation (note: install the dash in bare aluminum, it will be removed, covered and replaced later)

1. Install the upper steering column. This will provide a guide to position the dash laterally with the column, which goes through the oval hole in the dash.
2. Clamp the top of the dash to the dash hoop. Position the center of the dash 1/8" below the top edge of the hoop. The curve of the dash will not match the dash hoop exactly. This is OK as the body lip is about 1/2" deep and will cover the gap.
3. Ensure your chassis is level side to side, then level the dash and clamp securely. Check and adjust the lateral position relative to the steering column hole and adjust if needed.
4. Mark, center punch, and drill 7 holes for the 8-32 dash mounting screws using a #29 drill, which is the tap drill size for the 8-32 screws.
5. Remove the dash and set aside.
6. Tap the holes you just made in the dash **hoop** to 8-32.
7. Open the dash holes to 11/64" for clearance for the mounting screws.
8. Fasten the dash to the hoop with the x-32 screws. (Save the washers for the final installation to protect the vinyl covering if desired. We carefully tightened our screws so as not to damage the vinyl and did not use the washers.)
9. Position a dash support bracket with the tab pointing down and the top surface flush with the top of the 2" square tube. The outer end goes above the bottom lip of the dash. We bent the last 1" of the bracket up about 10 degrees to match the angle of the lower dash lip.
10. Choose the three locations for the brackets. We chose one on each end and the third to mirror the left hand bracket at the right side of the steering wheel.
11. Mark and drill the 1/8" rivet holes in the 2" square tube and the dash lip. Secure the brackets with 1/8" aluminum rivets or temporary fasteners (Cleco's or Wedgelocks)
12. Bend the ends of the dash around to point forward until they are just inside the upper hinge mounts on the top of the 2" square tube. The ends will be held in this position by the fabricated "L" brackets. See photo below.





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13. Mark the position of the L brackets and rivet in place with stainless 3/16" rivets. Note the diagonal placement of the rivets is intentional to provide the most stability with only two rivets. Also be sure to position the hole closest to the leg of the L, far enough from the leg, to allow clearance for the rivet tool.
14. With the brackets in place, bend the dash around to the desired position against the bracket. You can force a tighter radius into the dash by pushing to the rear to avoid a kink in the dash at the ends of the hoop. Clamp the dash in position.
15. Mark, center punch and drill two #25 holes through the dash end and into the L bracket. Repeat for the other side.
16. Remove the clamps and open the holes in the dash to 3/16".
17. Tap the holes in the L brackets to 10-24. Use lubricant and caution as the 10-24 taps are fragile.
18. Fasten the dash ends to the brackets using the 10-24 screws.
19. Mark and trim the ends of the dash. We cut ours at the end of the bracket, but you could leave yours longer and trim to the side of the 2" square tube.
20. Once you have mocked up all your gauges, indicator lamps, and switches, and all dash holes have been drilled, remove the dash (drill out aluminum lower support rivets if used) and cover with vinyl using brush on contact cement. We prefer not to use the FFR supplied foam backed vinyl. In many cases it has wrinkles from storage that can't be removed. We also find the foam makes it difficult to get the vinyl to stick for the long haul, as the foam eventually straightens itself out and does not stay put. Remember when cutting out the vinyl for the gauge holes to cut tabs to fold through the hole. This is important because the FFR holes are slightly over-sized, assuming you are folding the thick foam backed vinyl through the hole.
21. Reinstall the dash using the 7 screws on top, 6 rivets on the bottom, and 4 screws on the ends.
22. END