

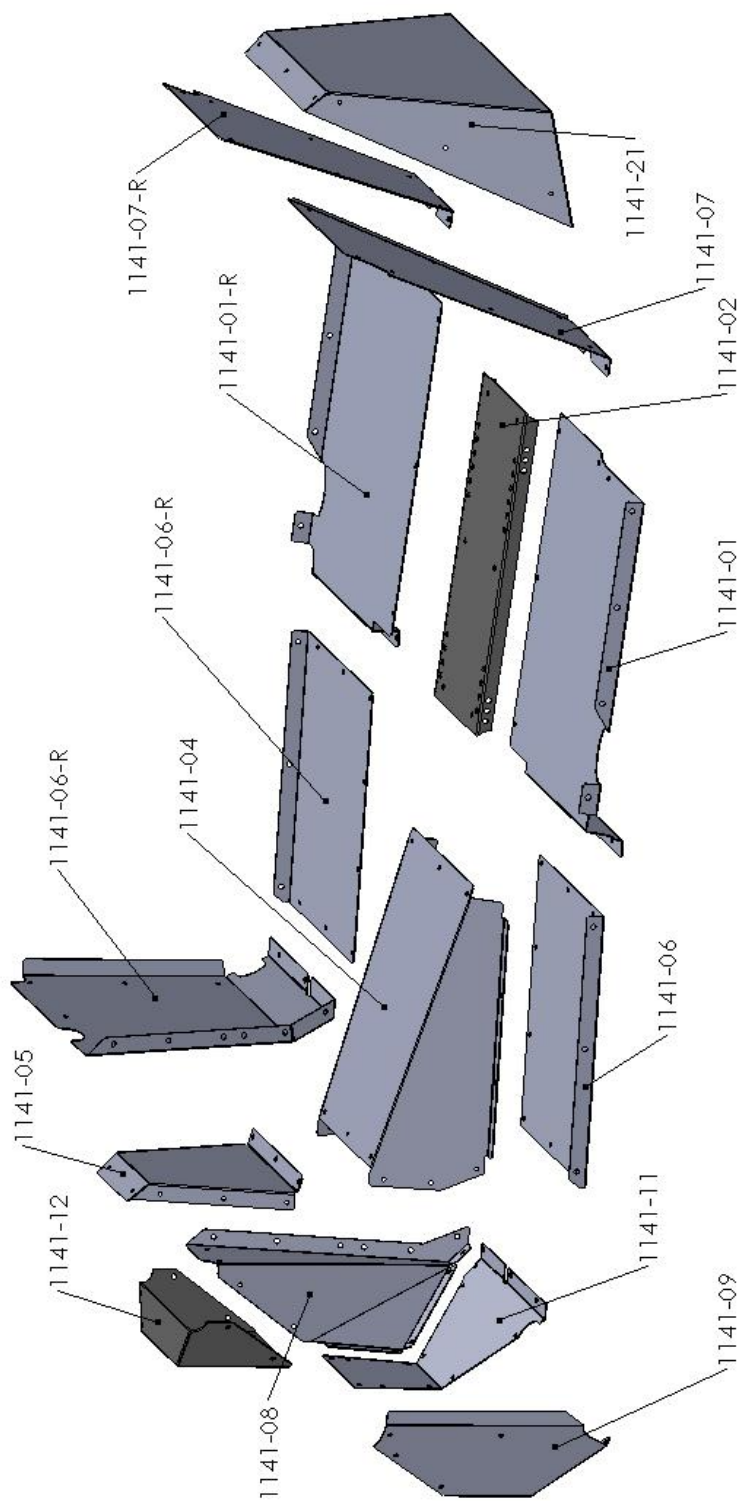


GOAT BUILT IBEX FLOOR/FIREWALL PANELS

Thank you for purchasing Ibex chassis kit components, before starting your build, we recommend that you read through these instructions to familiarize yourself with the steps and parts so you can plan and prepare for your built accordingly.

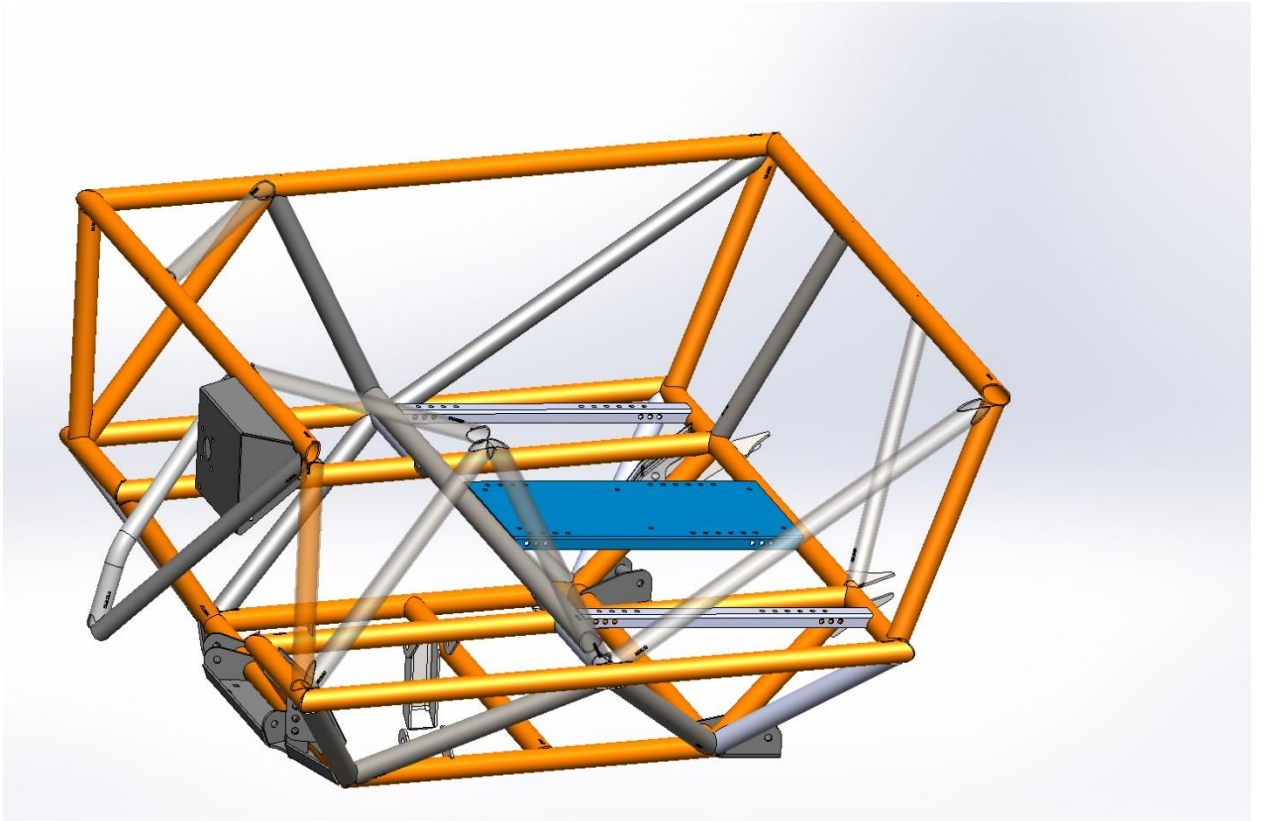
A few notes about the 1141 floor/firewall panels:

- These instructions are assuming you are also installing the 1151-2, front seat brackets, reference to these brackets are made in these instructions, but the seat brackets are not included in the 1141 kit.
- We recommend that you bolt all of the attaching panels together with all of the screws prior to tack welding any of the nutsert tabs.
- Tack weld all the panels and nutsert tabs in place, after all the nutserts tabs are tack welded and you are satisfied with the fitment, you can remove the aluminum panels and weld all the panels and nutsert tabs
- You will likely get some welding spatter on the back side of the panels while tack welding the nutsert tabs, you can put some masking tape or similar on the panel under the nutsert tabs to prevent this.
- You may need to do some minor trimming to fit the panels around the tubes or welds.
- Take your time to make sure all the parts fit correctly before tack welding. Use a level, digital protractor and tape measure to double check according to the instructions.
- We recommend that brackets be welded by MIG or TIG. The person welding must be a competent welder capable sufficient weld penetration and weld quality
- For MIG welding, we recommend 75/25 AR/CO2 shielding gas; we have found that .035 Lincoln Super-Arc L-56 wire works best.
- For TIG welding, use 100% Argon with ER70S-2 filler rod, we like to use 1/16 diameter filler rod with this thickness of material.
- Additional assembly pictures are posted on the website, www.goatbuilt.com/



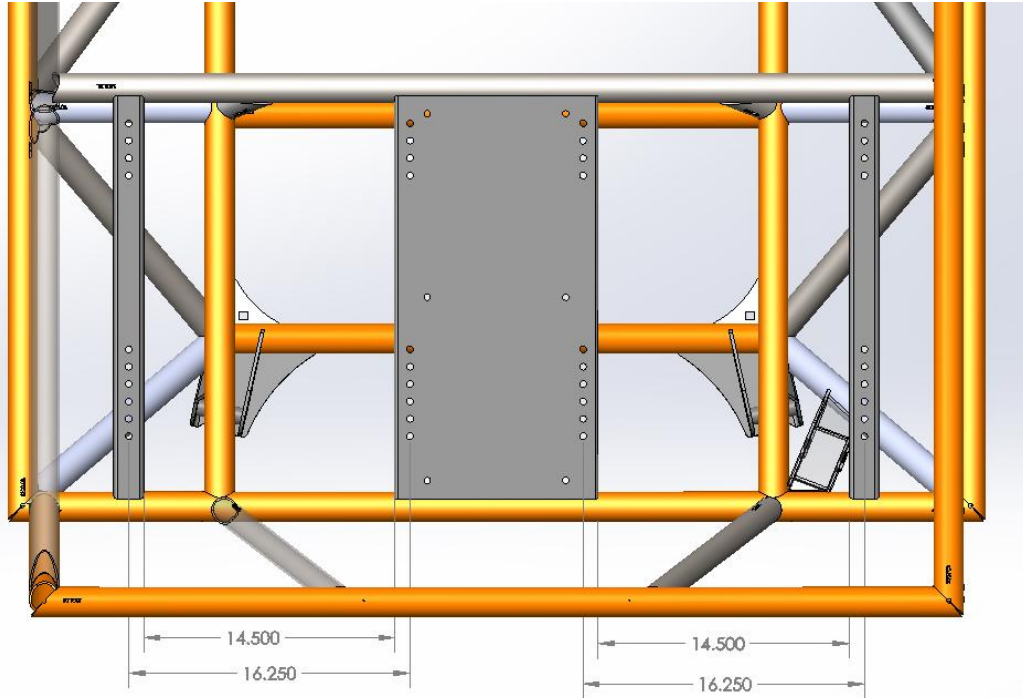
1. 1141-02 and 1141-12.

- 1.1) The 1141-02 and 1141-12 parts anchor the entire floor/fire wall assembly together, install these first and take care to correctly position them. Tack weld these only at this time.
- 1.2) Install the 1141-02 floor/seat mount between chassis tubes 1100-01 and 1101-31. The 1141-02 part is a formed steel part that is welded to the chassis tubes. There are a series of holes in the 1141-02 panel, orient the panel as shown below. There are two sets of seat mount holes in the top of the 1141-02 panel, the set of 4 holes goes towards the front, the set of 6 holes at the rear. The top surface of this panel should be flush with the top of the chassis tubes, you may need to grind the ends or the tube notches in the side of the 1141-02 panel to the top flush. Center the panel in the chassis and tack weld.

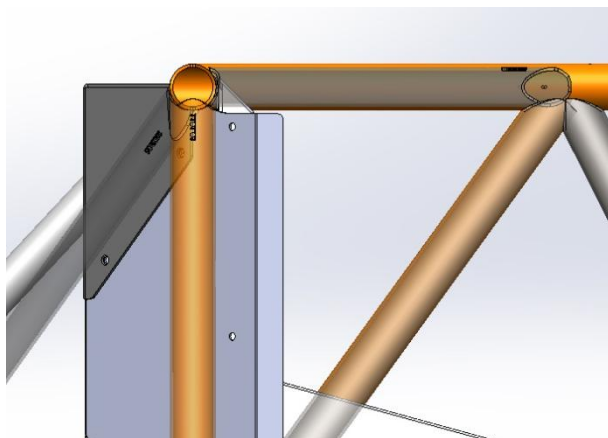
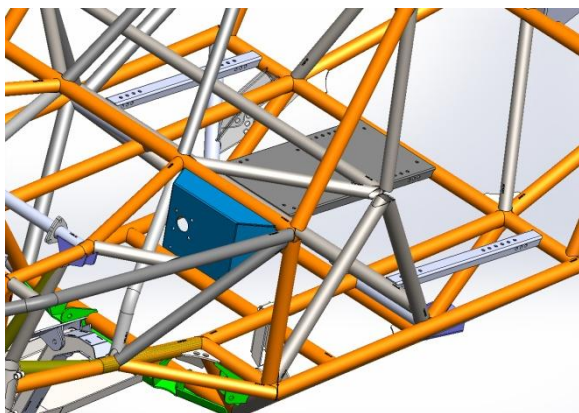


- 1.3) Now is a good time to install the other seat mount brackets. Install the 1151-01 brackets on both sides of the 1141-02 panel as shown above. Orient the seat mount holes in the top of these brackets to match the holes in the 1141-02 panel. The side to side dimension can be adjusted to fit your specific seats, most seats (PRP, Beard, etc) are 14 inside tab width, so we will continue assuming you are using seats with this dimension, if you are not, you will need to figure out the seat mount dimensions on your own.

- 1.4) Make sure the top surface of the seat mount brackets are flush to the top of the chassis tubes, if not, grind the ends of the brackets to fit. Using a measuring tape, position the 1151-01 brackets as shown below, the holes are 16.25" center to center, and the inside to inside of the brackets are 14.5", tack weld the seat mounts in place

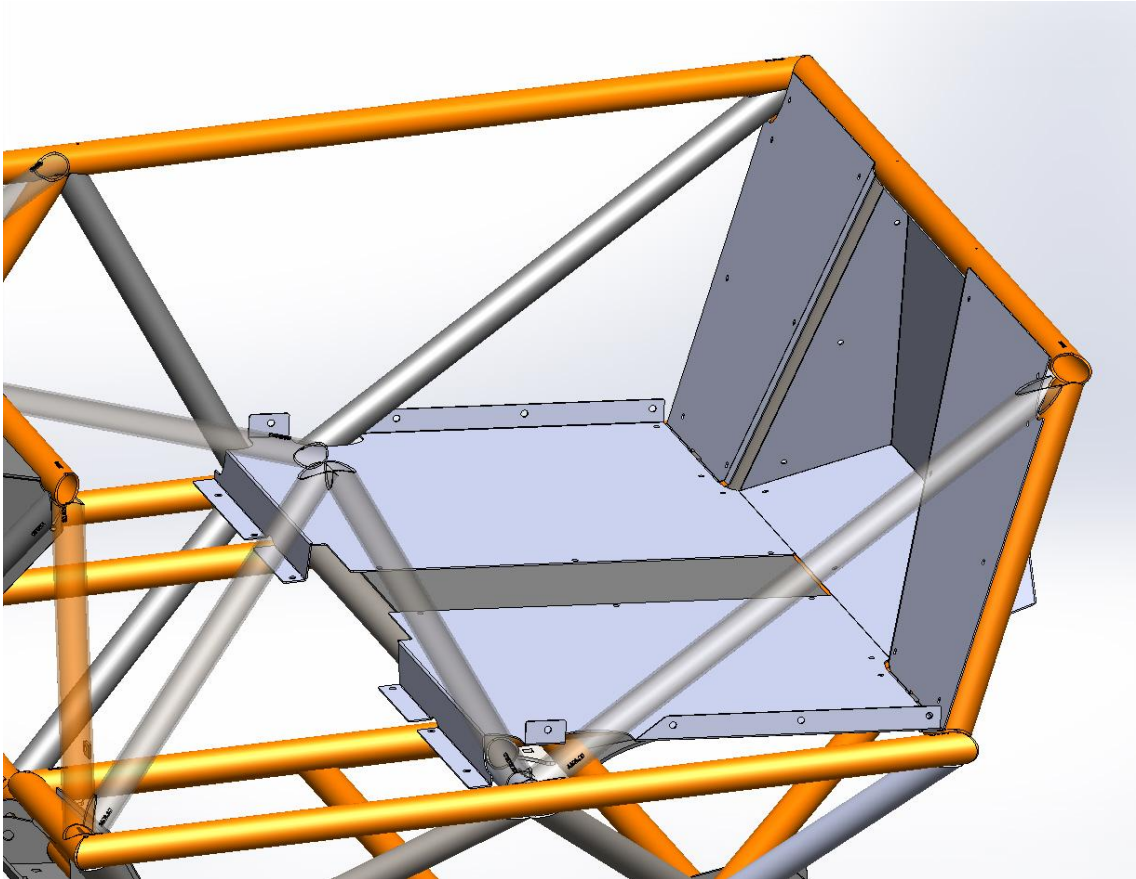


- 1.5) Install the 1141-12 bracket to the 1101-06 chassis cross tube. The 1141-12 bracket should fit in-between the 1103-13 and 1103-06 tubes with small gap on either side. Orient the front face of the 1141-12 vertical to the chassis or the top face horizontal. One of the main chassis tubes like 1100-02 or 1101-03 is a good reference. Tack weld in place



2. Seat back/bottom panels

- 2.1) Assemble the 1141-01 and 1141-07 panels to the chassis. The inside of the -01 panels will attach to the -02 seat center panel and the bottom of the -07 panels will attach to the back of the -01 panels.



- 2.2) Check the alignment of the -01 panels. The flanges on the outside of the -01 panels should be flush to the outside of the chassis side tubes. The flanges are used to attach side skins.
- 2.3) Check the alignment of the -07 seat back panels, the top should be level, the outside edges should be just under 1/8 from being flush with the outside of the chassis tubes.
- 2.4) If you are building a 2-seat Ibex, install the 1141-21 2-seat center panel as shown above.
- 2.5) Attach the nutsert tabs to the back of the panels and tack weld to the chassis tubes, you may need to grind the long end of the nutsert tabs shorter to align the tab to the hole.

3. Firewall/foot panels, trans tunnel

- 3.1) Assemble remainder of the panels in the order below, leave the screws loose until all the panels are assembled
- 3.2) Driver side foot well, -08, -09, -11. These panels will attach to the -12 panel installed in step 1.5.

- 3.3) Position the passenger side firewall, -03. You will need to clamp this panel to the chassis tubes to hold it in place.
- 3.4) Position the -05, firewall center panel and attach to the -08 and -03 panels.
- 3.5) Position the -04 transmission tunnel panel and attach to the -08, -03, and -05 panels.
- 3.6) Position the left and right -06 foot panels and attach to all the panels surrounding them.
- 3.7) Install all of the screws that attach the panels to each other. Check that the panels are aligned and snug all the screws down.
- 3.8) Attach the nutsert tabs to the back of the panels and tack weld to the chassis tubes, you may need to grind the long end of the nutsert tabs shorter to align the tab to the hole.

4. Final assembly and notes

- 4.1) After all the nutsert tabs are tack welded, remove all the aluminum panels and weld the tabs and 1141-02 and 1141-12 panels to the chassis tubes.
- 4.2) The 1141-02 center panel is permanently part of the chassis and a convenient location to mount shifters or cutting brakes so you can remove the other panels and not have to remove the shifter.
- 4.3) If you are using an Atlas transfer case, if you use their standard shifter, you can simply cut a hole in the 1141-04 transmission tunnel for the shifter and boot.

