



Controlled Documentation

Part Number: 33658      Revision: B      Effective Date: 4/4/11      By: J. INGERSLEV

Document Type (indicate):

- Bill of Material
- Drawing (may be attached)
- Specification
- **Assembly Instructions**
- Operating Procedure
- Other

## Coupe Rear Hatch Retrofit kit

### Components

REAR GLASS HATCH RETROFIT COMPONENTS			
15341		EA	1.00
15242	LARGE BUTTON STUD	EA	4.00
15243	1.32" OD RUBBER WASHER	EA	8.00
15265	SMALL BUTTON STUD	EA	2.00
15266	0.813" OD RUBBER WASHER	EA	2.00
15267	0.922" OD RUBBER WASHER	EA	2.00
15244	WASHER	EA	2.00
15245	JAM NUT	EA	6.00
15246	THREADED BALLSTUD	EA	2.00
15217	HATCH LATCH INSIDE GASKET	EA	1.00
25562	5/16"x 3/4" CARRIAGE BOLT	EA	4.00
13963	5/16"-18 NYLON LOCK NUT	EA	6.00
15165	NYLON BUSHING	EA	4.00
33432	1" SHOULDER BOLT	EA	2.00
14886	REAR HATCH GLASS	EA	1.00
15257	40# GAS STRUT	EA	2.00
15248	M5-0.8 x 16MM PAN HEAD SCREW	EA	3.00
13094	REAR WINDOW WEATHERSTRIPPING	FT	15.00
15342	COUPE REAR GLASS BOX	EA	1.00
15255	REAR HATCH LASER CUT STEEL	EA	1.00
15254	REAR HATCH HINGE ARM FRAME SIDE	EA	2.00
15252	REAR HATCH HINGE ARM HATCH SIDE, DRIVER	EA	1.00
15253	REAR HATCH HINGE ARM HATCH SIDE, PASS	EA	1.00

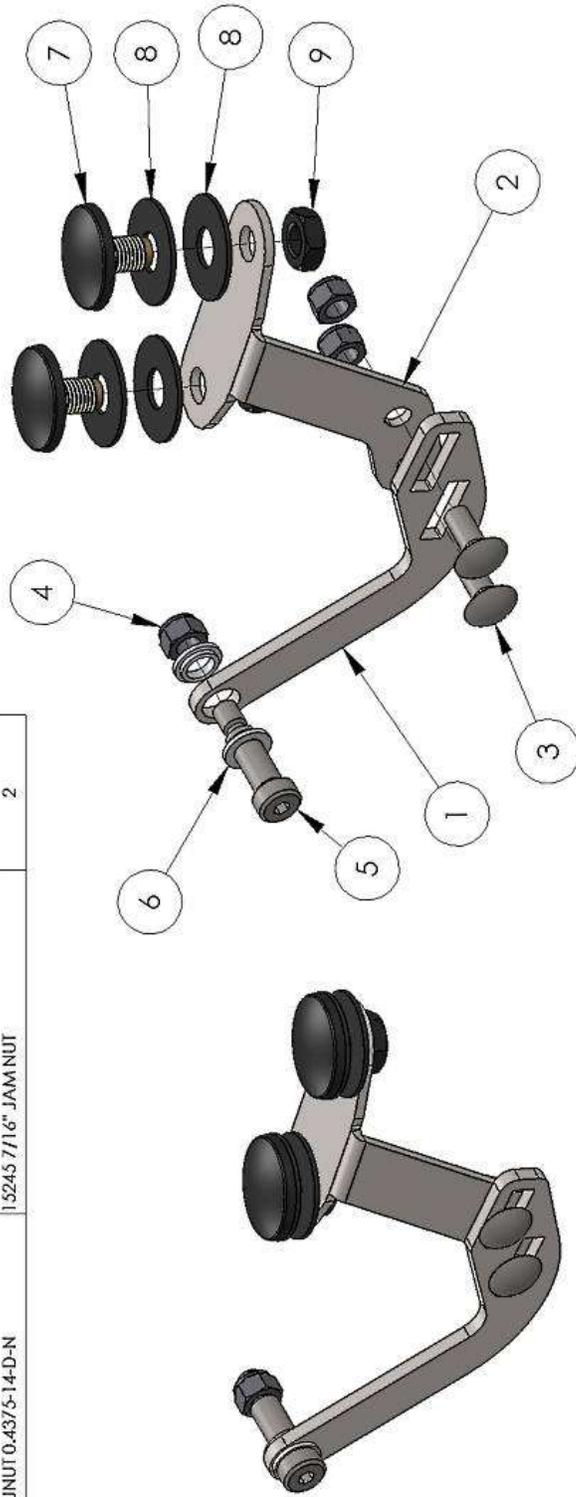
### Instructions

- Remove the old hatch and hinges.
- Remove the latch from the hatch.
- Save the latch, hinge to frame bolts and nuts.

# HATCH HINGE

ITEM NO.	PART NUMBER	DESCRIPTION	RIGHT SIDE/QTY.
1	15254	REAR HATCH HINGE ARM FRAME SIDE	1
2	15251	RIGHT HATCH SIDE HINGE ARM	1
3	RHSNBOLT0.3125-18x0.75x0.75-N	25562 SHOULDER BOLT	2
4	NLN-3125C	NYLON INSERT LOCKNUT, 5/16-18 UNC	3
5	SHSSCREW0.375x1-N	33432 SHOULDER BOLT	1
6	15165	NYLON BUSHING	2
7	15242	LARGE BUTTON STUD	2
8	15243	1.32" OD RUBBER WASHER	4
9	HJNUT0.4375-14-D-N	15245 7/16" JAMNUT	2

REV.	DESCRIPTION	DATE	APPROVED
A	INITIAL RELEASE	3/11/11	



UNLESS OTHERWISE SPECIFIED:		DRAWN	NAME	DATE
DIMENSIONS ARE IN INCHES		JJ		3/11/11
TOLERANCES:		COMMENTS:		
TWO PLACE DECIMAL ±0.01				
THREE PLACE DECIMAL ±0.005				
FOUR PLACE DECIMAL ±0.001				
MATERIAL				
FINISH				
USED ON:		PRINTED		
APPLICATION:		3/11/2011		
HATCH HINGE		SHEET 2 OF 2		

**Factory Five Racing, Inc.**

**5** FIVE RACING

TITLE: RIGHT SIDE HINGE ASSEMBLY

SIZE DWG. NO. **A** HATCH HINGE REV **A**

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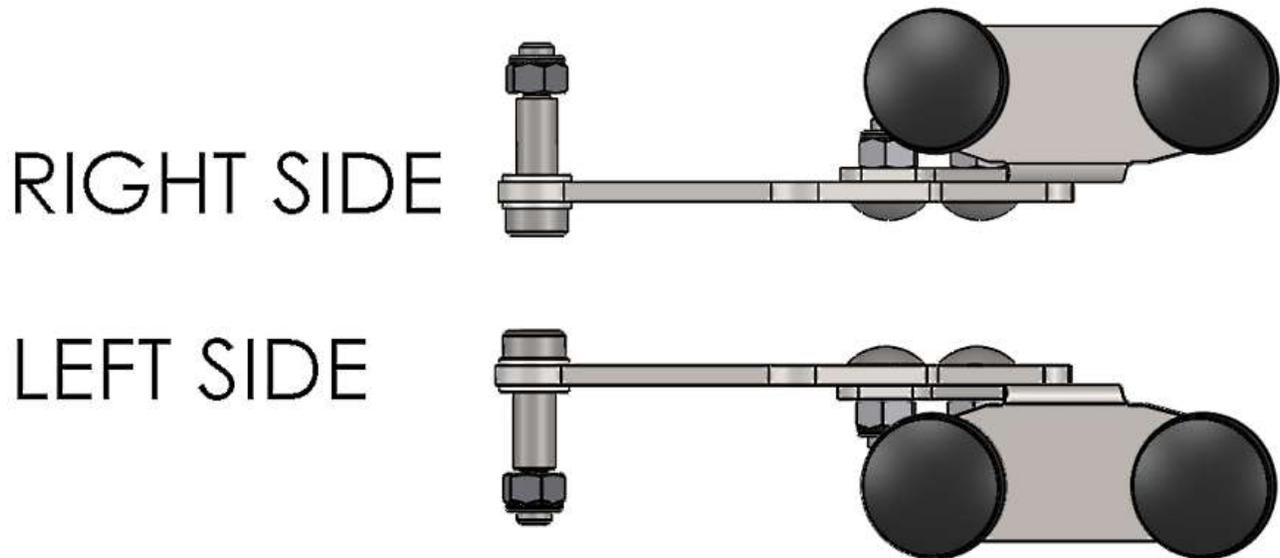
- ✂  $\frac{7}{16}$ " ,  $\frac{9}{16}$ " ,  $\frac{11}{16}$ " wrench,  $\frac{1}{8}$ " ,  $\frac{3}{16}$ " hex key, marker, drill,  $\frac{7}{32}$ " ,  $\frac{7}{16}$ " drill bit, hack saw, Philips head screwdriver, ruler, Friend
- 🛠 Rear glass hatch components, glass hatch.

Push the large 1.32" rubber washers onto the large button studs.

From the outside of the glass, push the Large button studs through the hinge holes in the glass hatch

Push another large 1.32" rubber washers onto the large button studs on the inside of the glass.

Put the hatch hinge arms onto the button studs so that they point forward and the arms are on the inside.



Hand tighten the jam nuts on the bottom of the studs.



Repeat for the other side.

Push the small 0.813" rubber washers on the small button studs.

Push the small button studs through the holes on the sides of the glass.

Push the medium 0.922" rubber washers onto the small button studs on the inside of the glass.

Put a washer on the small button stud.

Carefully thread on and tighten a jam nut on the bottom of the small button stud.

Thread on and tighten a ball stud on the small button stud.

Repeat for the other side.

Attach the trunk latch to the rear window using the included gasket on the inside of the glass and the 5/8" long Philips head screws provided. Make sure there is a rubber gasket on each side of the glass.

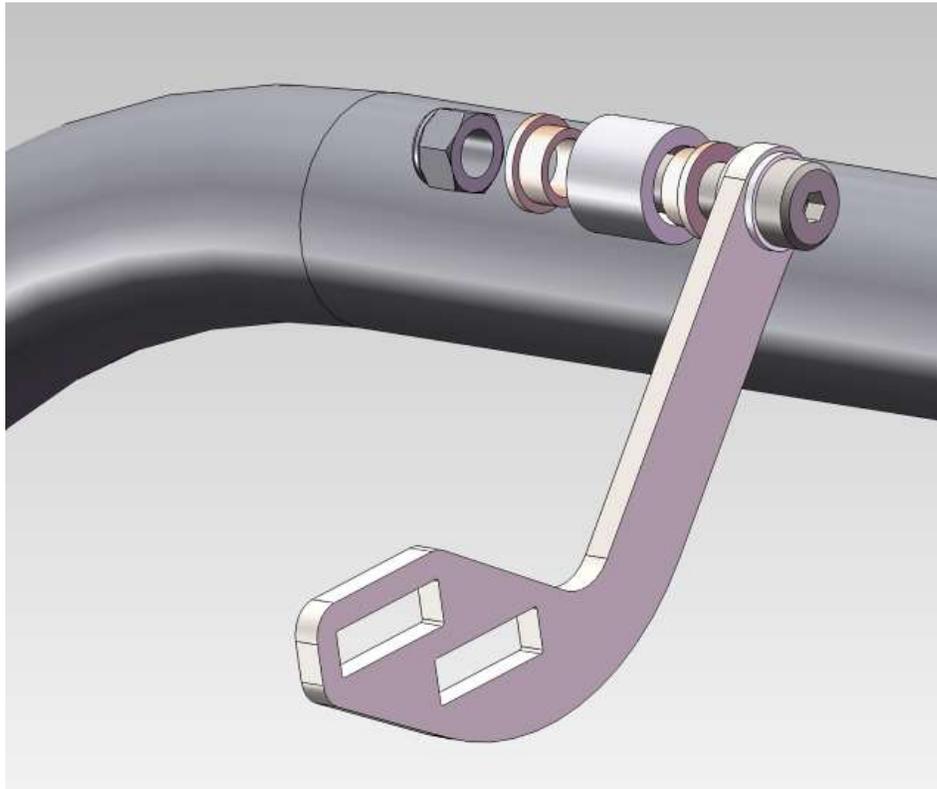




Push plastic bushings into both sides of the hatch frame hinge bracket. Use a vise to push them in evenly if necessary.

Insert the bronze bushings into the frame mounts on the roll bar.

From the inside of the rollbar, attach the frame side hatch hinge arm using the shoulder bolt and  $\frac{5}{16}$ " lock nut. Tighten the lock nut so that it will rotate freely but does not allow any side to side movement.



Rotate the hinge arm up so that it touches the body and mark the body where it hits.  
Use a  $\frac{7}{16}$ " drill bit to drill a hole just below the rear hatch flange.  
Cut the sides of the hole with a hack saw so the hinge arm has clearance.



## HATCH STRUTS

The strut bracket should be positioned with the bracket starting  $\frac{3}{8}$ " from the top corner of the hatch support area. The bracket should be on the inside of the hatch area with the strut ball pointing in. Make sure all of the mount holes land on the tube. Mark the locations of the mounting holes.

Use a  $\frac{7}{32}$ " drill bit for the mounting screws.

Attach the strut brackets to the frame. If there is a slight gap between the body and the aluminum as there was on ours, put the bracket between the body and the aluminum.



Attach the body side of the strut to the frame ball stud.



## **HATCH**

With the help of a friend, place the glass hatch in the opening.

Locate the glass so that the gap is even all the way around the hatch opening. Use coins or washers, etc... along the bottom and sides so that the hatch is held in position.

The hatch should be flush with the body.

Rotate the frame side hinge arms up and if necessary loosen and rotate the hatch side hinge arms so that they are flat on each other or parallel.

Use the carriage bolts and locknuts to bolt the arms together from the inside out.



Carefully try opening the hatch.  
Attach the rod side of the gas strut to the ball stud mounted on the hatch.





The rear hatch uses the weather stripping that has two legs on it, one longer than the other and has no adhesive on the back.

Press the double stick tape around the rear hatch recess area.

Starting at the bottom in the middle, press the weather stripping onto the double stick tape with the longer leg towards the inside of the hatch to help prevent water getting to the hatch area.