

**ASSEMBLY & INSTALLATION NOTES**

**JUBU Harness bar Emira (JU00248PRD)**

for EMIRA

**Please follow the instructions in this manual for a proper assembly & installation of the JUBU Harness bar for Emira.**

*Please find in this document:*

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

**1. PART LIST for product JU00248PRD**

#	ITEM	ART-NO.	UNITS
1	Aluminum harness bar	JU01241ART	1
2	Harness bar bracket rear right	JU01077ART	1
3	Harness bar bracket rear left	JU01078ART	1
4	Harness bar standalone bracket right	JU01079ART	1
5	Harness bar standalone bracket left	JU01080ART	1
6	Cutting template 1 panel rear left	JU01236ART	1
7	Cutting template 2 panel rear right	JU01237ART	1
8	Shim 1mm seatbelt screwing point	JU01250ART	2
9	Shim 2mm seatbelt screwing point	JU01251ART	2
10	7/16"-20UN x 52mm titanium head cap screw	JU01087ART	2
11	7/16"-20UN x 19mm titanium seatbelt screw	JU01097ART	2
12	ISO 14579 M10x22 titanium head cap screw	JU01094ART	8
13	DIN 6926 M6 self-locking nut	-	1

#	ITEM	ART-NO.	UNITS
14	Ø5x16 Rivet black	-	6
15	Bodywork adhesive	VM00081	1
16	Bodywork adhesive primer	JU00183ART	1
17	Wool dauber for adhesive primer	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
- 7/16"-20UN: 60 Nm

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

1. Uninstall the carpet panels in the rear interior.



Fig 2: Uninstall the rear interior panels.

2. Disconnect the battery.
3. Trim the OEM plastic brackets in the rear corners as shown in *Fig 3* (on both sides). Take care about the wiring looms!





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.

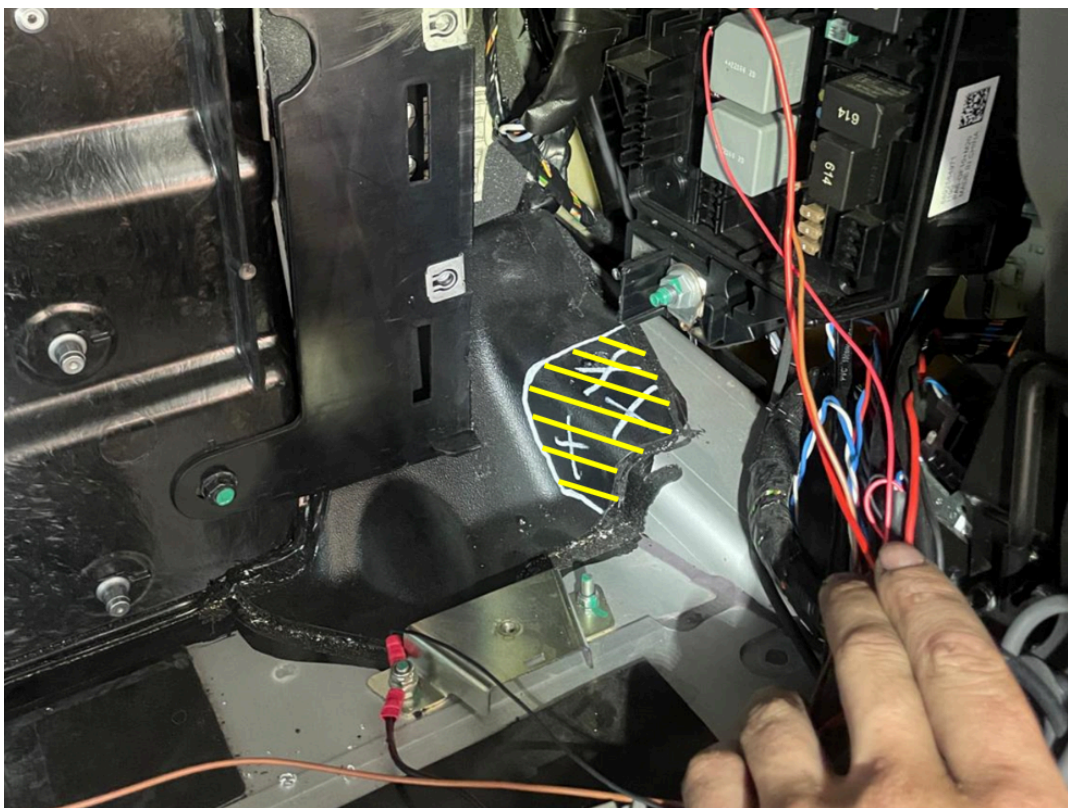


Fig 4: Trim the lower ends of the rear bulkhead I





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

5. Put the rear right harness bar bracket (2) in position and fix it loosely using 1x M6 nut (13). Now drill the required  $\text{\O}5\text{mm}$  holes as marked in Fig 6.

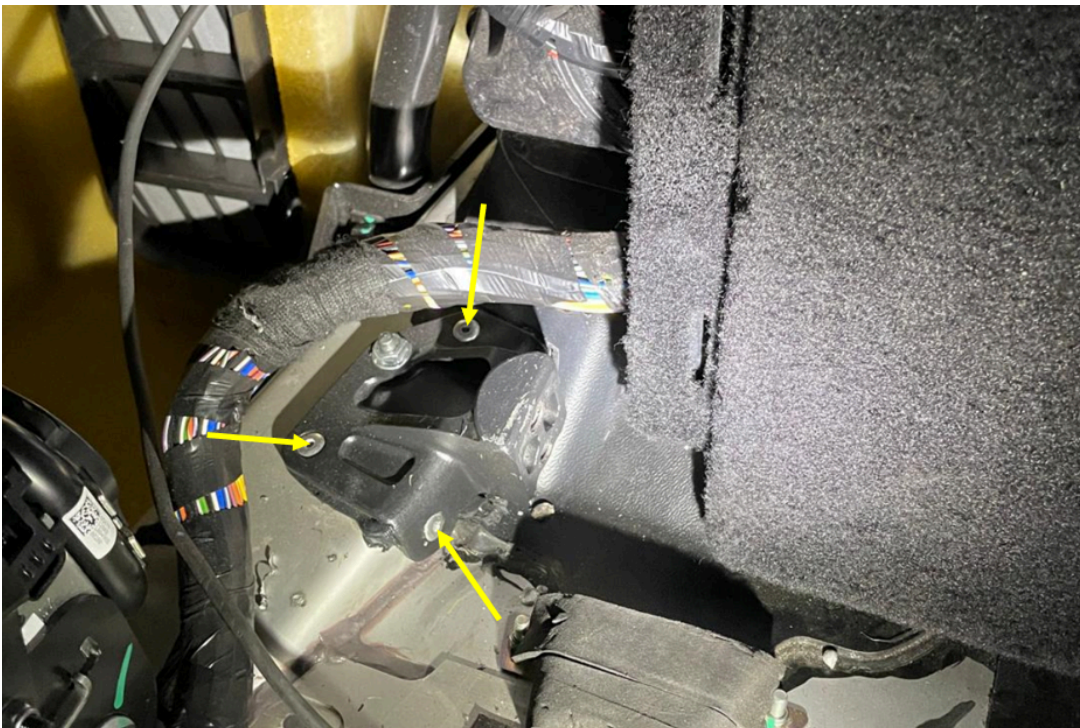


Fig 6: Drill the  $\text{\O}5\text{mm}$  holes for the right harness bar bracket (4).

 **NOTE:** The rivets are inserted later.

6. Do a test-mount of the harness bar (1). This is described more in detail from point 11 to point 13.
7. The position of the rear left harness bar bracket (3) is fixed now. Please mark the holes
8. After removing the harness bar (1), the 3x Ø5 holes for the rear left harness bar bracket (3) are drilled as marked in Fig. 7.

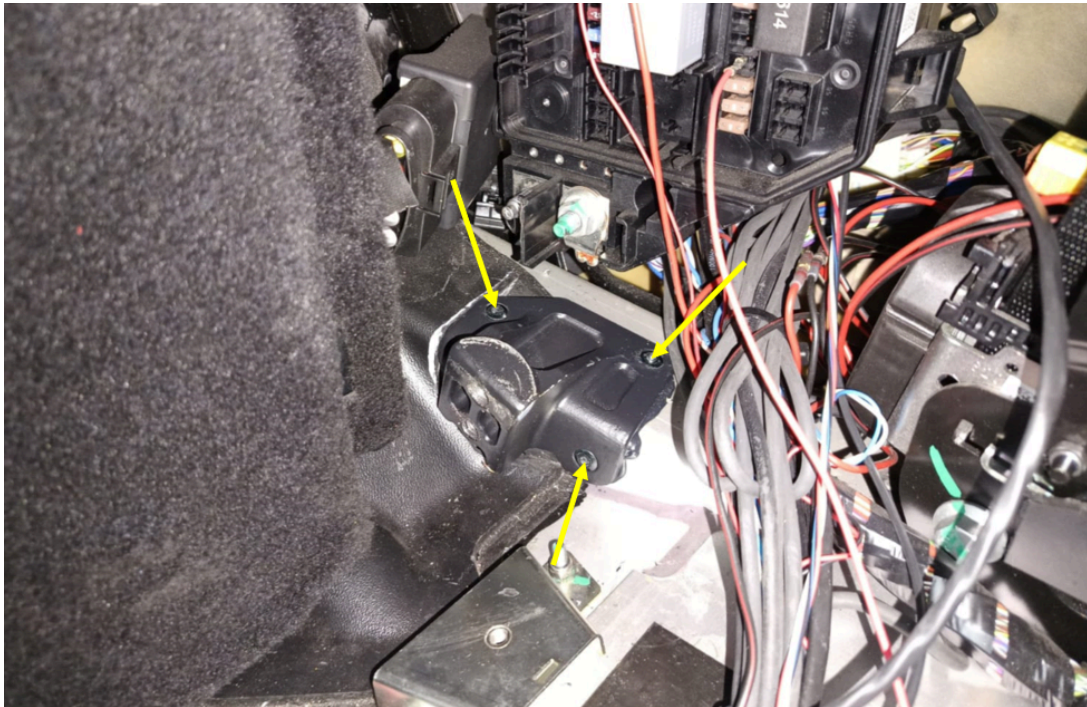


Fig 7: Drill the Ø5mm holes for the left harness bar bracket (3).

9. Glue the rear harness bar brackets (2 & 3) to the chassis using bodywork adhesive (15). Before applying the bodywork adhesive (15) treat the surfaces with primer (16) by using the wool dauber (17). (Drying time for the primer about 10 minutes)  
The rear right harness bar bracket (1) is fixed with 1x M6 nut (13) and 3x Ø5 rivets (14) and the rear left harness bar bracket (3) is fixed with 3x Ø5 rivets (14).

**⚠ NOTE:** The bodywork adhesive (15) needs at least 90 minutes curing time.

10. Install the carpet panel in the center.

**⚠ NOTE:** The screws number 11, 13 and 14 are only loosely screwed for positioning.

11. Screw the harness bar (1) to its rear brackets (2 & 3) by using 4x M10x22 head cap screws (12).
12. Mount the seatbelt turning loops to the harness bar standalone brackets (4 & 5) by using 2x 7/16"-20UN x 19 seatbelt screws (11) and fix them with LOCTITE 243.



13. Bolt on the harness bar standalone brackets (4 & 5) and the harness bar (1) with 4x M10x22 head cap screws (12).

14. The harness bar standalone brackets (4 & 5) are fixed to the chassis on the seatbelt screwing points with 2x 7/16"-20UN x 52 (10) head cap screws.

**!** **NOTE:** If required 1mm Shims (8) and 2mm Shims (9) can be used between the standalone brackets (4 & 5) and the seatbelt screwing points to compensate for possible manufacturing tolerances of the OEM steel rollbar.

15. Finally fix all the screws 11, 13 and 14 (10, 12) with screw lock LOCTITE 243 and tighten them according to the torque. (beginning of Chapter 2. **Assembly & Installation Notes.**)

**!** **NOTE:** Due to the welded construction, the system may exhibit stresses during installation. 1-3mm

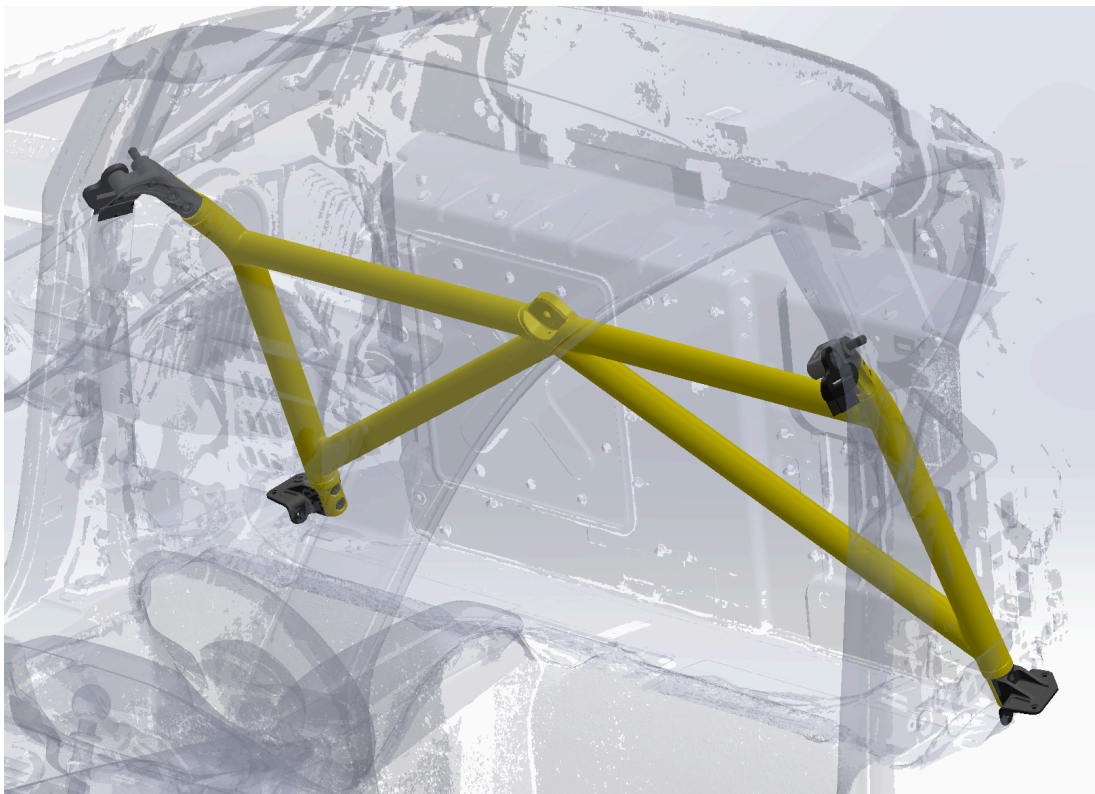


Fig 8: Installing the harness bar (1).



16. Trim the panels for the rear corners by using the cutting template 3 (6) and the cutting template 4 (7) as shown in Fig 9.



Fig 9: Trimming the carpet panels for the rear corners.

17. Install the carpet panels for the rear corners.
18. Install the seats and connect the battery.

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

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