41240000 68-72 GM “A” Body TigerCage

Basic Cage

1 41240904   Main Hoop
1 41240908   Driver side hoop mount
1 41240907   Passenger side hoop floor mount
2 41240905   Hoop to frame mount (inner, front)
1 41240910   Driver side hoop to frame mount (inner, rear)
1 41240909   Passenger side hoop to frame mount (inner, rear)
1 41240913   Driver side hoop to frame mount (outer)
1 41240912   Passenger side hoop to frame mount (outer)
1 41240903   Driver side package tray bar
1 41240902   Passenger side package tray bar
2 41240911   Package tray reinforcement plate
1 41240901   Driver side trunk bar
1 41240900   Passenger side trunk bar
2 41240906   Trunk bar to frame mount
2 49990005   Clamp tabs
1 49990003   TigerClamp P (threaded)
1 49990001   TigerClamp P
1 49990004   TigerClamp D (threaded)
1 49990000   TigerClamp D
1 90002276   Tube of Anti-Seize
1 41249900   (ENG34115) Polyurethane body mount kit

Hardware:

16 99371023  3/8" x 1" USS Gr. 8 SHCS   Clamps / Main hoop to mount
46 99371004  3/8" x 1 ¼" USS Gr. 8 bolt  Mounting brackets
12 99373007  3/8" x 1" self-tapping screws Mounting brackets
46 99372001  3/8" USS Gr.8 Nylok nut   Mounting brackets
12 99373005  3/8" Lock washer     Mounting brackets
104 99373002  3/8" SAE flat washer  Mounting brackets
2 49990008   ½" x 1 ½" 12 point Gr. 8 bolt  Bar to clamp tab
2 49990009   ½" Flange nut     Bar to clamp tab
41240000 Installation Instructions

- Initial fitment of the floor mount brackets must be done under the carpet. Final installation can be done under or over the carpet.
- Use Anti-Seize on all fasteners that are threaded into stainless clamps or brackets.
- Install all bars before final tightening.
- Always tighten the tab side of the clamp first.
- Torque all 3/8" fasteners to 45 ft-lbs and all 1/2" fasteners to 75 ft-lbs.
- Make sure the clamp is exactly where you want it before tightening as the clamp may scratch the tubing.
- **Watch for fuel and brake lines when drilling holes through the floor pan.**

1. Start by replacing all of the body mounts with the new polyurethane mounts included. Using the old rubber mounts can cause clearance and fitment issues.
2. Position the main hoop floor mount so that the front of it is 38 5/8” behind the pinch weld at the front of the door opening.
3. Using the bracket as a template; drill six 3/8” holes through the floor pan. Drop 3/8” x 1 ¼" bolt w/ flat washers down through floor pan.
4. Bolt the frame brackets to the bottom of the floor pan using 3/8” Nylok nuts and flat washers. These two brackets attach to the inside of the frame rail.
5. The frame should be drilled with a 3/8” bit for the **rear bracket**. Use 3/8” x 1 ¼” Nylok nut and flat washers to secure the bracket to the frame.
6. The holes for the **front** bracket need to be drilled with a 5/16”. A 3/8” x 1” self-tapping screw is used on this bracket since the frame is boxed in this section.
7. The hoop mount ties into the outside of the frame rail with this bracket. Two 3/8" Nylok nuts with flat washers will fasten it to the floor and four 3/8" x 1" self-tapping screws will secure it to the frame rail. Use a 5/16" bit to pre-drill the holes.

8. Bolt the main hoop to the floor mounts using four 3/8" x 1" socket head cap screws.

9. In order to keep the "T" in the casting facing up, and the bolts facing the correct direction, there are two different direction clamps. Be very careful as to which clamp halves you are bolting together. Refer to the image on page 5 for clamp locations.

10. A correctly assembled clamp should look like the one in the picture shown to the left; there should be a gap on one side for the tab to slide into.

11. Using the template on page 6; drill four 3/8" holes into the top of the package tray.

12. Attach a "D" Clamp to the main hoop with the tab facing rearward with the top of the clamp approximately 35 1/8" above the floor mount. Use 3/8" x 1" socket head cap screws on the clamp.

13. Place the driver side package tray bar on the package tray and secure it to the clamp with a 1/2" x 1 1/2" 12 point bolt and flange nut.
14. Drop four 3/8” x 1 ¼” bolts with flat washers down through the bar mount and the holes in the package tray.

15. Fasten the trunk bar to the package tray bar with four 3/8” Nylok nuts and flat washers.

16. Using the trunk bar as a template drill two 3/8” holes through the vertical surface of the package tray.

17. Place the reinforcement plate on the inside of the package tray and secure with assembly with two 3/8” x 1 ¼” bolts, flat washers and Nylok nuts. Nuts should face the trunk.

18. Using the trunk bar as a template; mark the 4 hole in the floor pan with a center punch. First drill the hole with a 1/8” bit. Before drilling the holes to 3/8”, hold the frame bracket up against the frame rail to ensure that the bolt holes will align. Re-drill 1/8” holes if necessary.

19. Drop four 3/8” x 1 ¼” bolts with flat washers down through the floor pan.
20. Secure the frame bracket to the floor pan with four 3/8” Nylok nuts and flat washers.

21. Using the bracket as a template; drill four 3/8” holes through the frame rail. Fasten the bracket to the frame with four 3/8” x 1 ¼” bolt, Nylok nuts and flat washers.

22. You may now tighten all clamps and bolts. Installation complete!