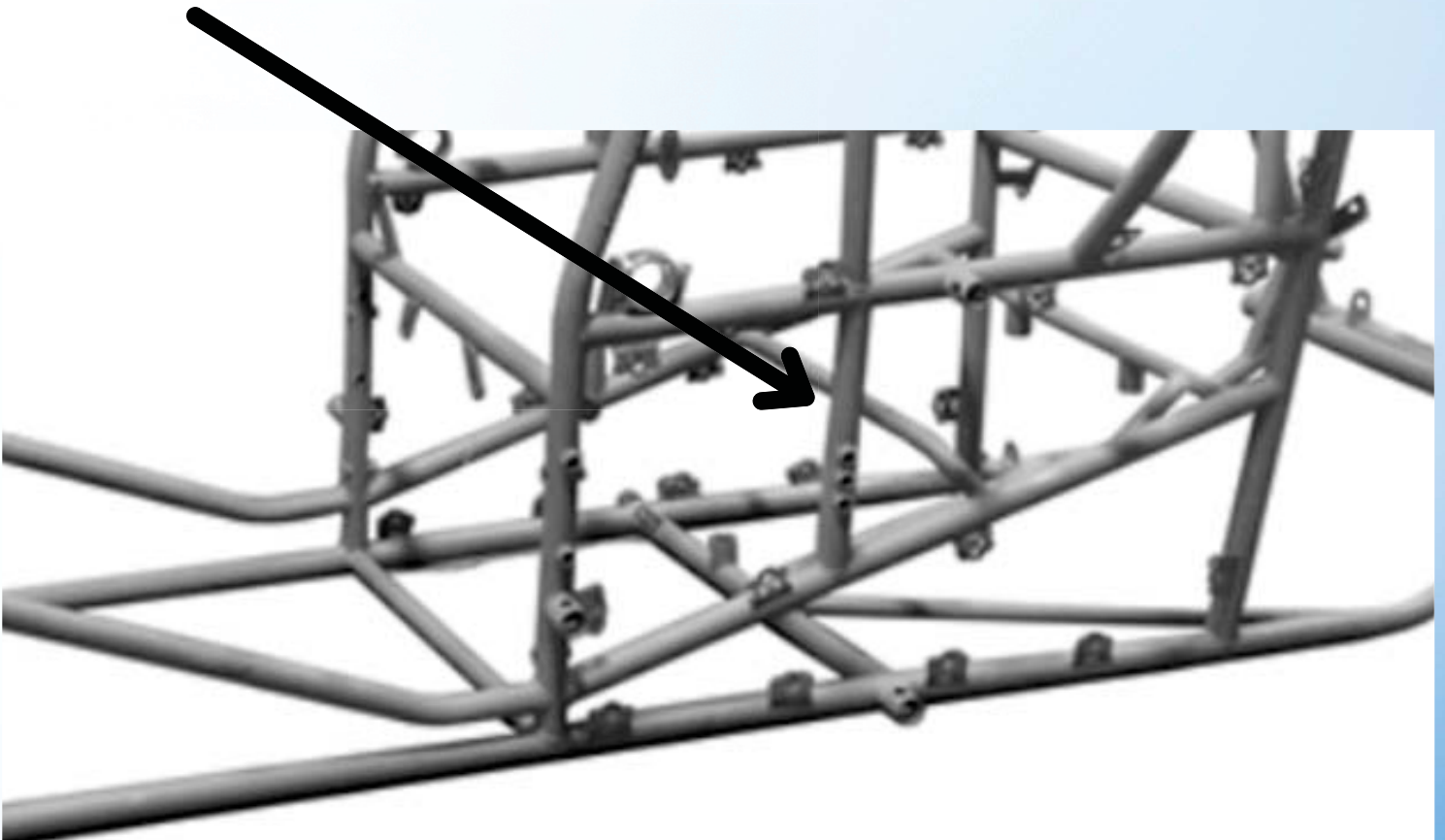# CASM
WELD ON INSTRUCTIONS

The CASM Weld in System is designed to replace the welded seat mount tube. These instructions are a description as to how to install the system in a Sprint Car. Please take into account this system is fully adjustable so finding the correct angle needed is possible on every chassis.

CUT SEAT TUBE AT CHASSIS SIDES

Each chassis will be slightly different as far as tube sizes for seat mount lower tube. some are 1" and others 1.250".

After removing the Seat Tube grind or sand the remaing tube welds of the chassis sides. This will be the most time consuming process in this Installation

In order for the CASM System to work correctly the Weld On Mounts Need to be Square with the Rear Torsion Rack. The very next step is to Zero out your angle finder on the rear rack

MOTORPLATE

17-3/4"

Measure from the Back of the motorplate to the front of the side Weld On Brackets
(This measurement is on a standard 40" chassis)

Before Tacking Bracket In Place the Sides of the Bracket Need to be Square with the Rear Torsoin Rack

INSTALL CENTER GUSSET ON BRACKET

Unassemble the Piston Housing from Packing and reassemble exact same on bracket,we now have a piston transfer that bolts to the top of the piston that will accept the 1" seat tube

piston transfer

In the final step of the lower mounts the Installer will need to determine the top of the seat Bar height wanted by the Driver. Standard Seat Bar is Typically 10-1/4" top of bar from bottom frame rail. For this exact reason we supply a 1"seat cross tube. Every Driver is a different size and each chassis is a Different Width. We recommend using the provided 120 wall x 1" supplied seat tube. one system is all put together and transfers are bolted down ,this is when you mount your seat to lower bar .
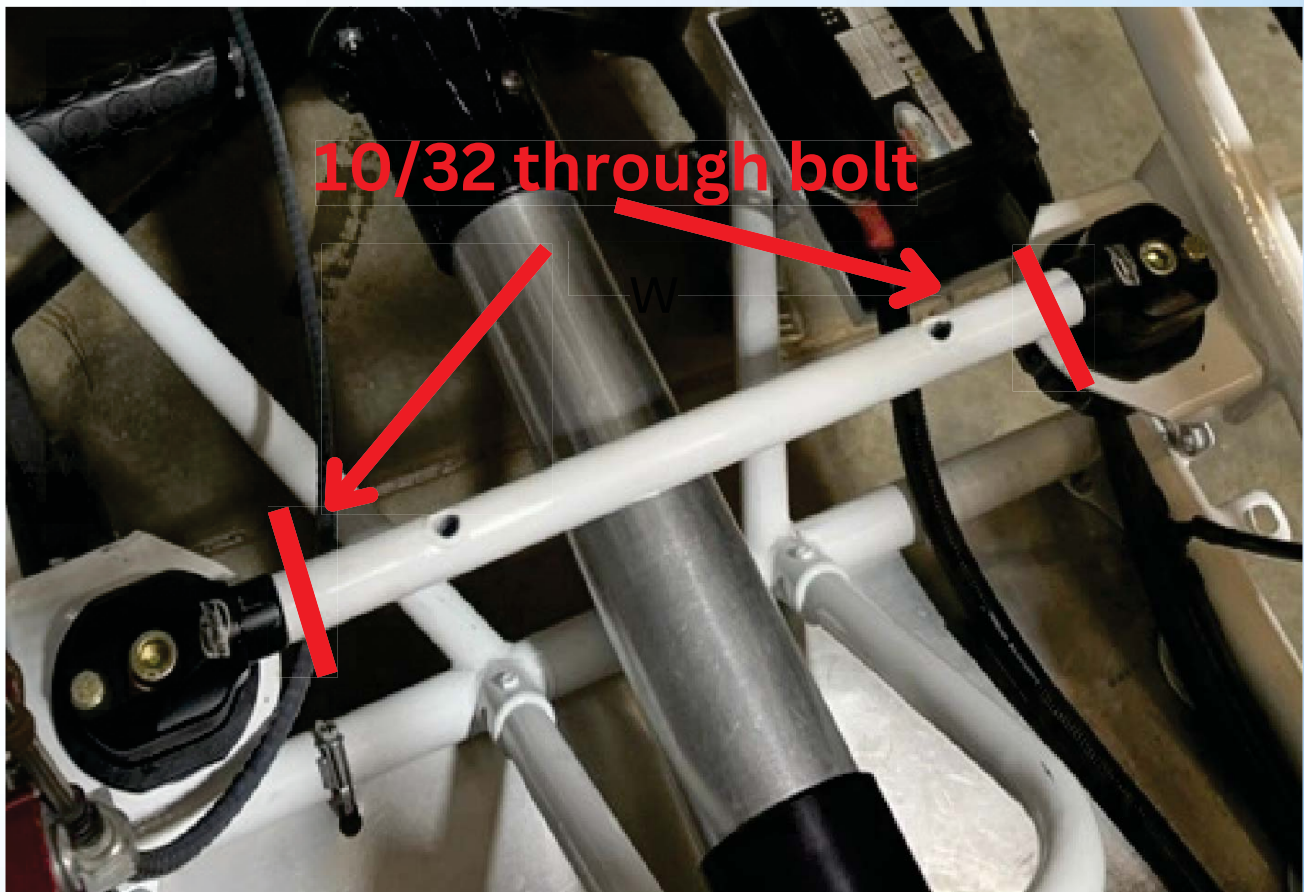
10/32 through bolt

When bottom assembly is complete please drill 10/32 bolt hole through both side of seat bar where attached to transfer When completed the lower mount should look similar to this, Install foam to raise pistons to install back slides

REAR SLIDING MOUNTS

we supply the requested brackets from when order is placed

When positioning the rear brackets for attachment to the A Frame Tube set the weld on brackets centered over the seat bolt hole. This should be very close to the standard seat position for the bolting application. It is very nice to use a couple small magnets to hold the brackets to the seat tube for welding.

The rear slider brackets are designed with a rotation slot to make it easier for you to get the face of the Rear Slider and the Top of the Compression Pistons at the Same Angle. Piston Top and Slide face have to be the same angle or similar to each other for this system to work.
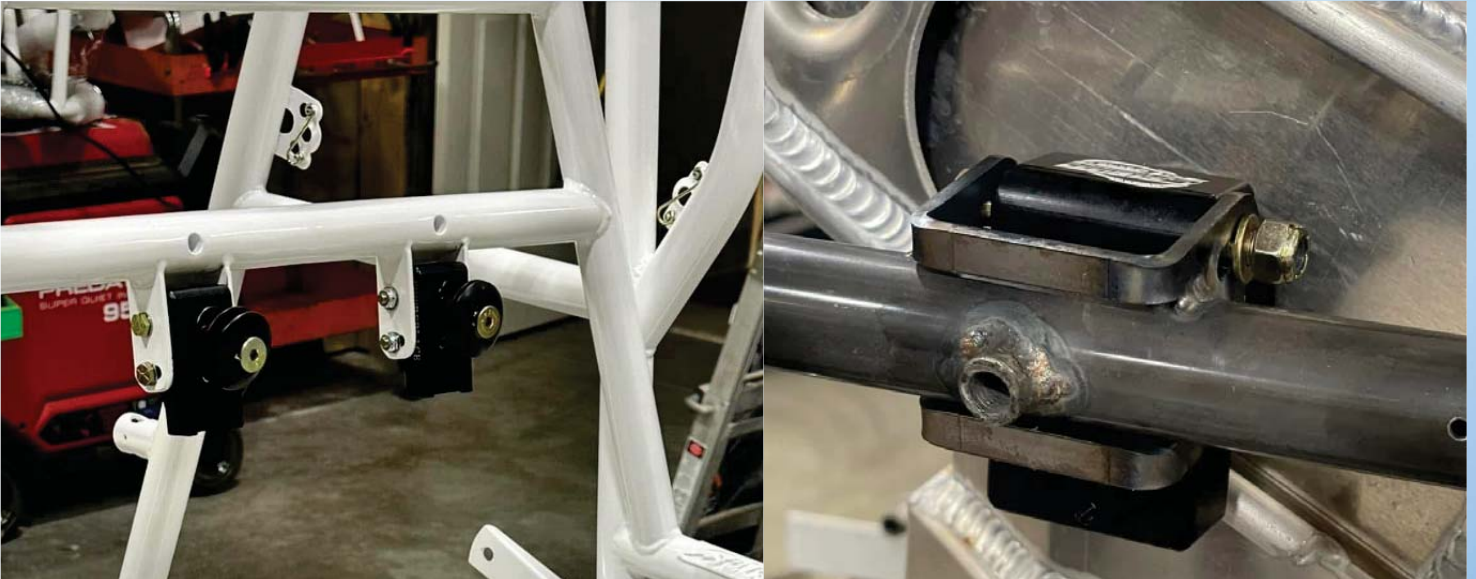

There are two types of back weld on brackets zero clearance (hang below tube), and standard (set on face of tube)

Tack brackets in place when just doing the first part of installation, when system is completed after seat moves freely finish welding brackets entirely

Install Rear Sliders and set the angle to equal to top of Piston or square to Piston Bracket.
Tighten all Bolts.
You will now attach the right rear mount first, make bottom and one side work before attaching other side the Seat in place. If the seat is used most likely spacers up to 1/2" more will be used on the left rear slide
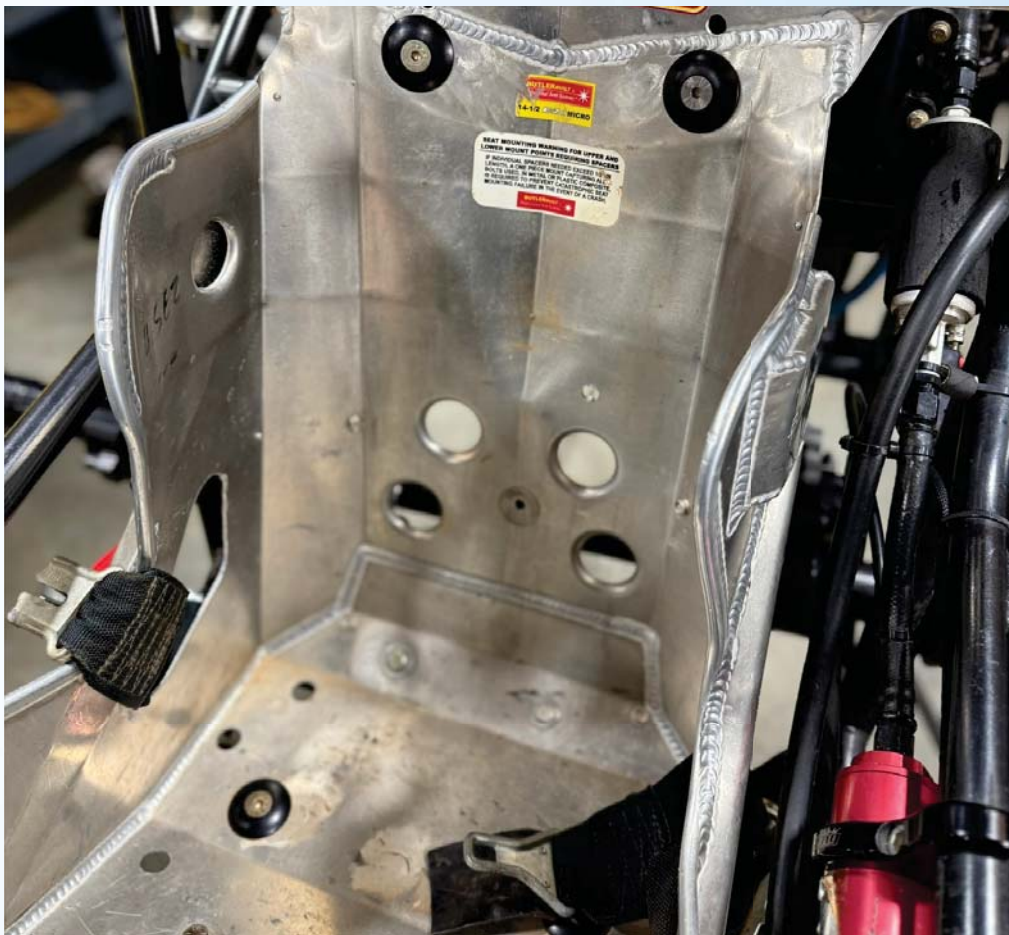
With Foam out of Pistons slide seat up and down to determine if all angles are equal. If there is any bind adjust each Bracket as necessary until Seat moves Freely. Then tighten all Bolts and Install foam. be sure to finish all welds

Troubleshooting/Maintenance

- new seats are far simpler to install as they have not been twisted in crashes
- Used seats we have found are always twisted left shoulder forward. sometimes we have seen the left side needing 1" of spacers for system to slide properly

- Always oversize holes where bolts go through seat minimum 7/16"

- Remove foam each time car is washed, clean piston assemblies as normal,blow out with air if possible and lube with WD-40 or Silicone spray

- Always check seat movement before foam is reinstalled. also after a big crash please replace foam