

SRG Chassis Build Phases

- 1. Documentation / R&D / CAD / Prototyping & Design** (Design only when chassis is a one-off custom or has specific customer requested modifications. Time will vary here depending on complexity of your desired design and chassis and designer availability. This part takes time, please be patient we don't want mistakes here.)
- 2. CNC Plasma cut all parts for frame / clean all parts** All or part of this phase may be delayed until approved drawings come down from our designer. (This phase usually takes 1-2 days. There will be a hold time usually after this phase waiting on a fixture to come open and/or waiting on personnel that may be on other projects.)
- 3. Jig and build frame rails**
This includes jiggling all pieces from step 2 plus adding our inner structure bracing and fully welding rails inside and out. (Depends on chassis as to how long on this phase, but usually no more than 2 weeks unless a custom with needed design and R&D during the construction process)
- 4. Grind rails and re-jig for final assembly**
Frame rails are ground through 80 grit and cleaned then are re-installed in fixture. (This phase will normally take 1-2 days but may have a hold time before they will be placed back into the fixture because other frames are being built in that particular fixture or personnel will have to be moved to another project for a few days.)
- 5. Install all cross members / install radiator core support / install body mounts**
All cross members are built and installed along with "J-Leg" center bracing. Radiator core support is installed. Also all body mounts are installed using preset fixtures on the jig. (The time on this phase varies depending on different frames and or personnel being available but will normally only take a few days to complete)
- 6. Pull frame / install exhaust porting / clean and prep for setup table**
Frame is pulled from jig and all exhaust porting is added. Frame is touched up and cleaned for the setup table. (This phase will normally take 1-2 days but frame will more than likely be on hold for a short time waiting on a setup table and personnel to free up)
- 7. Setup Table --- Congratulations!! You are halfway!**
Setup table is prepped according to specific frame and then the frame is installed on table. (The time on this phase varies and may be delayed to due to lack of personnel or waiting on parts from our fab shop, machine shop or other outside manufacturer)
- 8. Front suspension mock up**
Control arms are made and installed / sway bar is made and installed / coil over mounts are installed / rack and pinion steering is installed. (Time required on this phase will vary from chassis to chassis and the availability of personnel and/or waiting on parts from our fab shop or other suppliers.)

SRG Chassis Build Phases

9. Rear suspension mock up

Rear end is set according to ride height / all brackets are CNC plasma cut and fabricated then installed on housing / 4 bar setup is made and installed / upper coil mounts are installed / rear sway bar is installed. (Time on this phase same as #8)

10. Motor and transmission mock up / finish welding

Motor and transmission combo specific to your frame is mocked in the frame and all mounts are CNC plasma cut and installed. Frame is completely disassembled and all finish welding is done at this time. (Time on this phase varies but usually 1-2 days)

This phase may be put on hold due to our mockup engine and transmission for that particular setup being used or tied up in another project.

11. Final assembly

Frame has a final cleaning and touch up grinding. Then all components removed in step 10 are re-installed. Brake lines are installed / fuel lines are installed / fuel tank is mounted if applicable. (This step usually takes 1 week or less but may vary depending on chassis, etc.) Your getting real close from this point!

12. Crating and Shipping (1 day to crate and prep for shipping, usually shipper picks up within 2 days excluding holidays and weekends and then 3-5 days in transit to your door. There will be no phase #12 if you are picking up.)