

Indy XC Carbon Fiber Over Structure Reinforcement

Recommended when Racing the 2019 Indy XC

Order 3' of 1.125" x .058" x 1.009" 6061-T6 aluminum tube from [onlinemetals.com](https://www.onlinemetals.com) (Part number #6996)

- 1.) Remove complete over structure assembly from vehicle.
- 2.) Drill lower aluminum rivet out from bottom of carbon fiber tube. Clean off any glue from around the rivet.
- 3.) Slide aluminum tube into carbon fiber tube and make sure aluminum tube goes past rivet hole. May have to use slight force due to glue build up inside of carbon fiber tube.
- 4.) Mark the tube length, lower rivet hole and both upper mounting holes.
- 5.) Remove the tube. Drill holes to size. Cut tube to overall length.
- 6.) Re-install aluminum tube. Use 3/16" aluminum rivet to secure aluminum tube to carbon fiber tube and aluminum casting.
- 7.) .060" must be removed from both sides of the tube insert to fit into the smaller I.D.
- 8.) Grind radius on tube inserts to match inner radius of aluminum tube
- 9.) Install tube inserts into over structure and re-install onto vehicle

Installing aluminum tube for overall length and marking hole locations



Aluminum tube cut and drilled. Notice lengths between each side may not be the same due to excess glue build up inside. Ready for Re-install



Tube inserts machined down and ground to fit inside aluminum tube



Reinforcement complete and ready for re-install on vehicle

