

PCC/SB

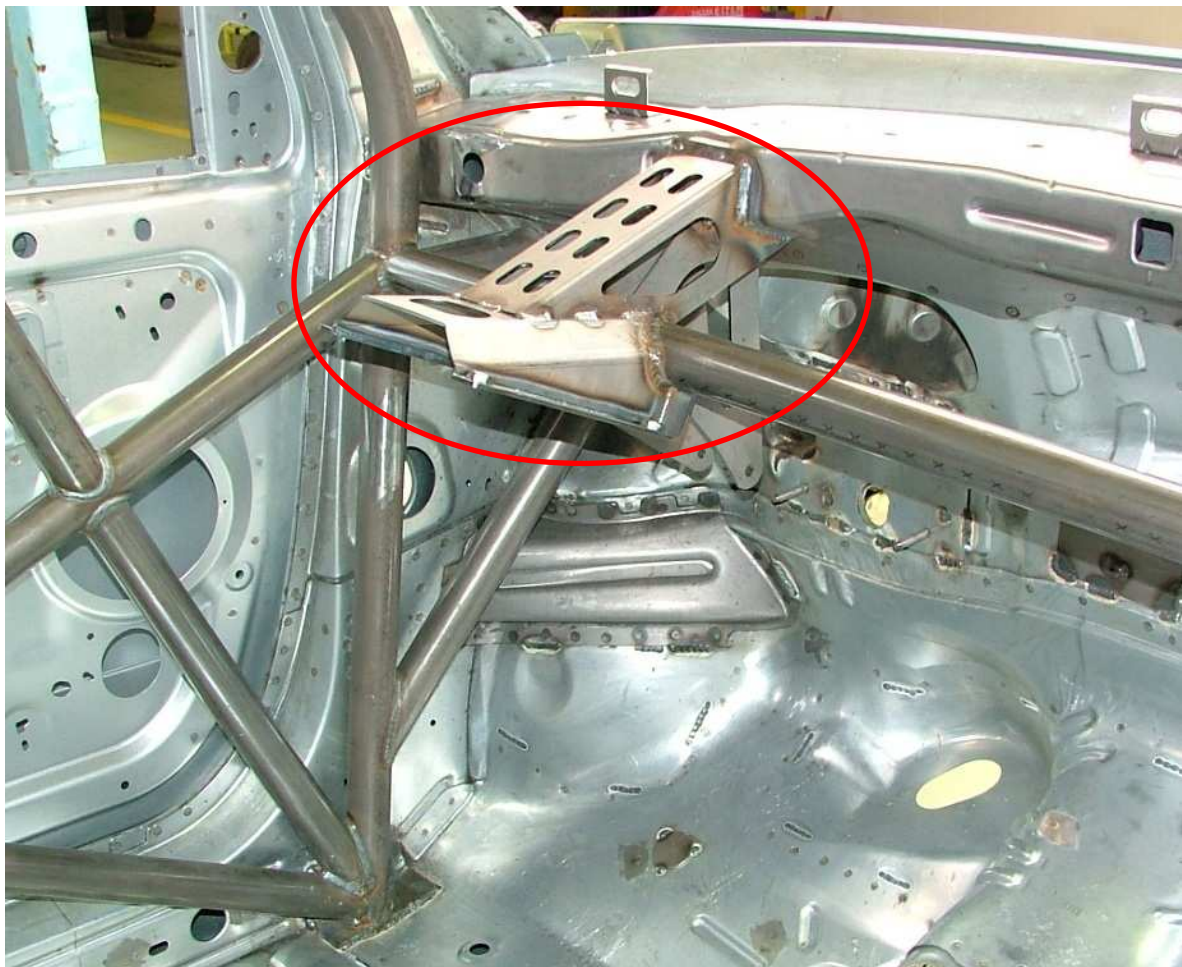
Versailles le 09/05/2007.

INFO-TECH CITROËN Sport C2 R2 N° 27/07

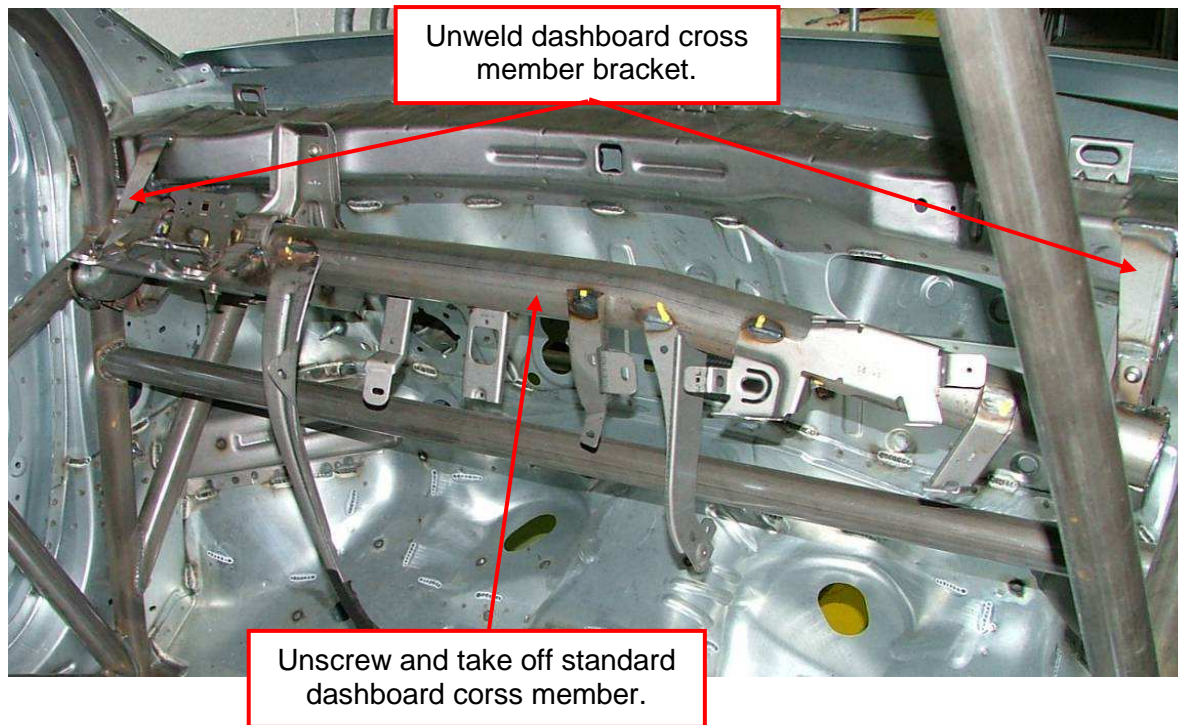
Subject : Steering column bracket.

Dear Customers,

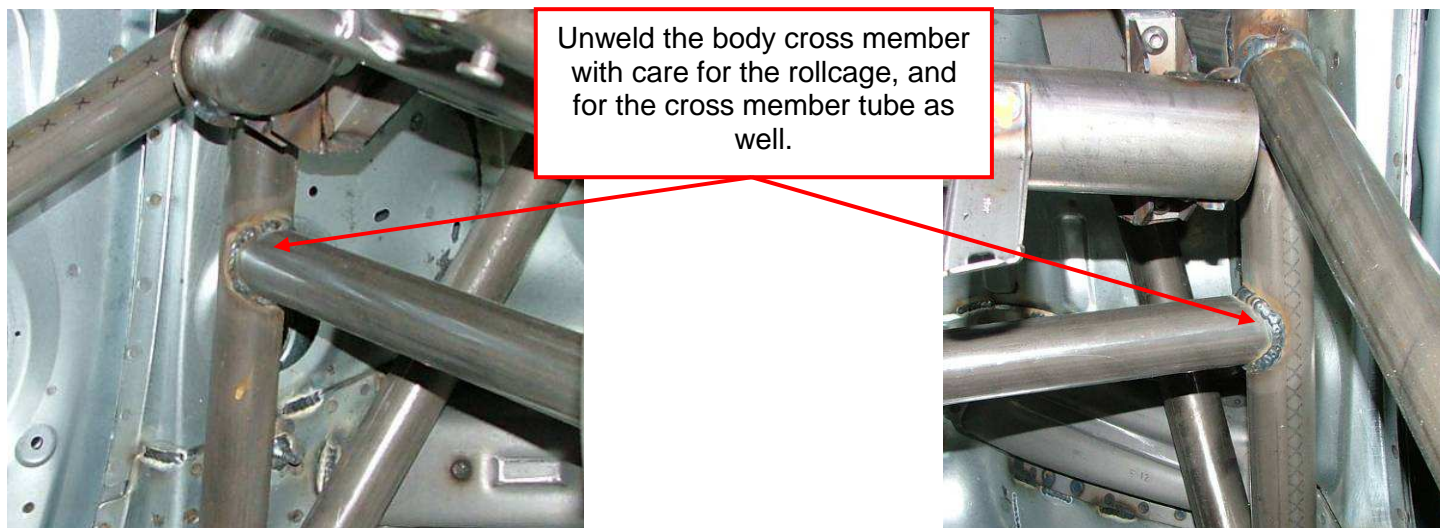
For your C2R2, a new steering column bracket is available at CITROËN Sport shop. Please find thereafter how to assembly it on your bodyshell.



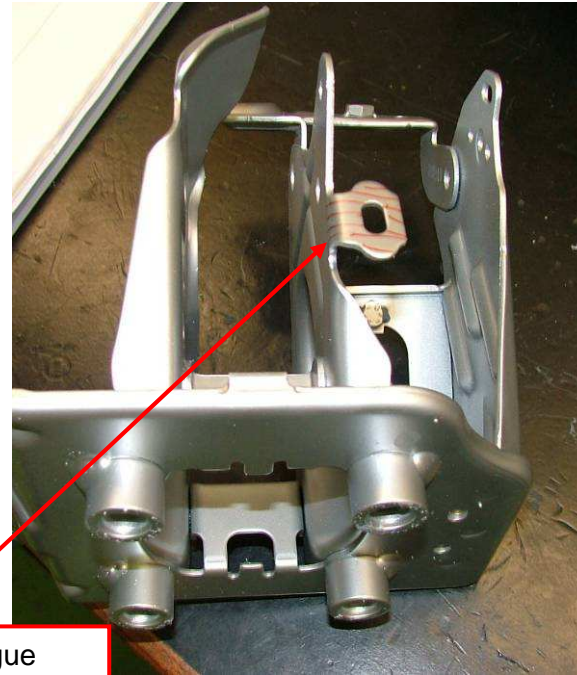
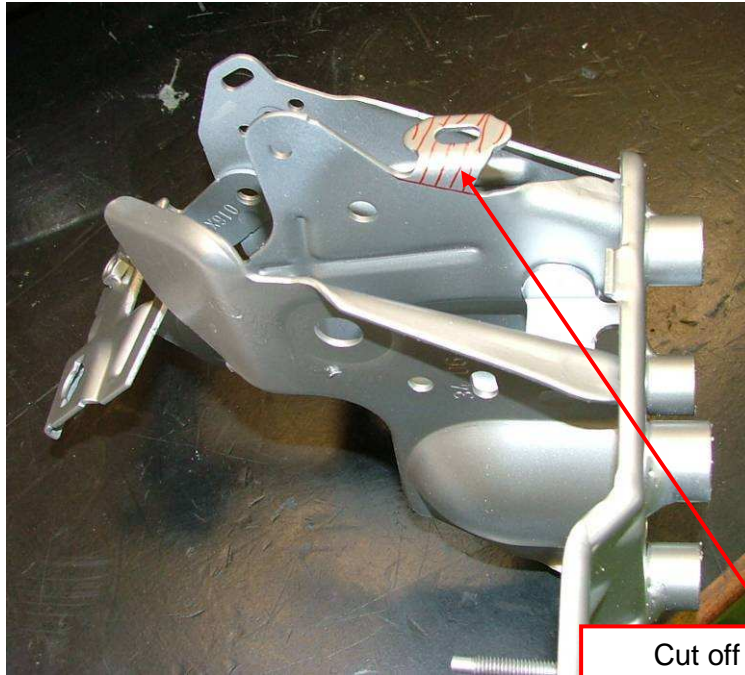
**Dashboard
cross member
and brackets.**



**Body cross
member**

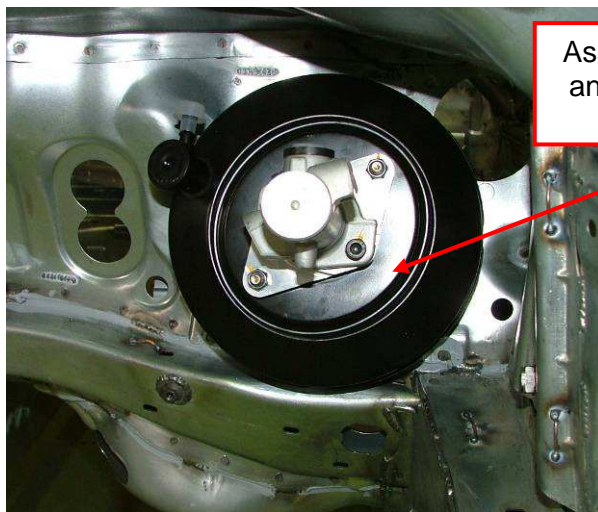


Brake pedal bracket

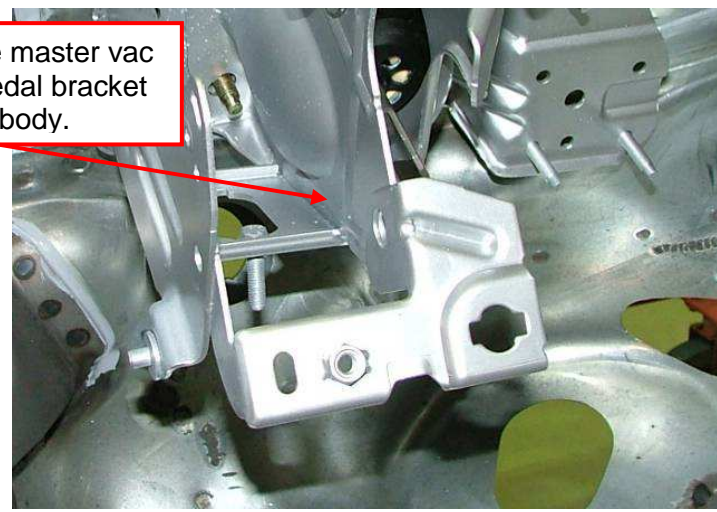


Cut off this tongue

Brake master vac



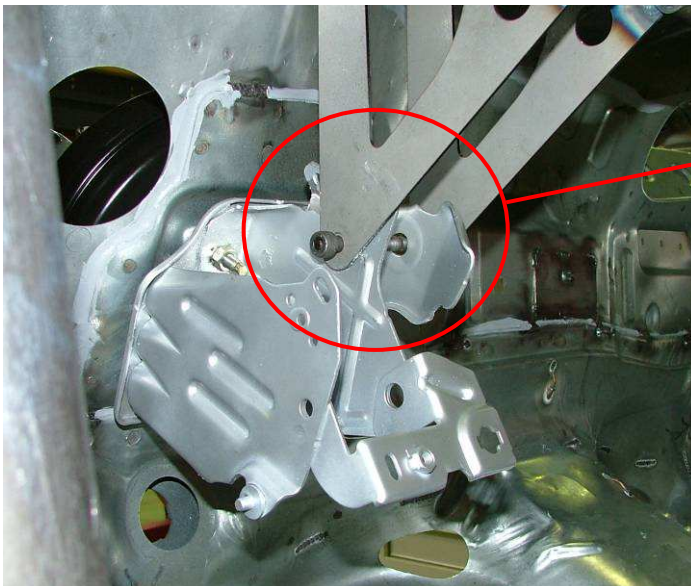
Assembly the master vac and brake pedal bracket on the body.



Steering column bracket, L and R Tsquare.

IMPORTANT : The brake pedal bracket will define the location of the cross member and the brackets for the steering column before welding.

Tig or Mig Welding.



Fit the T square to the brake pedal bracket with following parts :

Screw : BCSP 692597
Nut : BCSP 693644
Spacer : 1G1162886A

Welding recommendation :

Gas and filling metal suggestion :

Welding	Gas	Filling Metal
MIG	Arcal 21	Aubert et Duval F 66 S
TIG	Arcal 1	Aubert et Duval F 66 S

Aubert et Duval F66S details (chemical composition) : 25 CrMo4, equivalence classification.

C	≤ 0.25	Ni	< 0.3
Mn	= 0.6	Mo	= 0.23
Si	≤ 0.25	S	≤ 0.020
Cr	= 1.0	P	≤ 0.020

When the right location is found, weld both T squares, steering column bracket and the cross member like shown on pictures below :

!!! Pay attention to have the cross member in horizontal line !!!





Thank you for your attention.

S. BARRAUD, le 09/05/07