

## Instructions to Create a B4.1 +8mm Chassis

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### Tools required

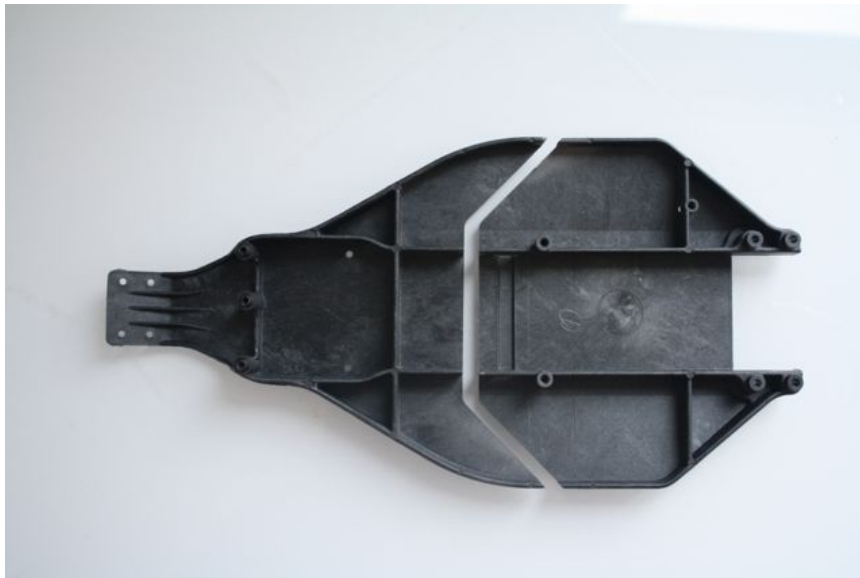
- 3mm tap
- 3mm drill bit
- 2mm drill bit
- x acto knife
- 4 d-clamps
- Hand file
- Loctite 480 super glue
- Dremel with assorted bits

### Parts Required

- Associated T4 Truck chassis (composite)
- Carbon Fiber Strip 2.5mm thick 175mm length 15mm height
- 8 x (3x6mm countersunk screws)

### Step 1 - Cut 11mm out of length of chassis

- Remove 11mm of material from T4 chassis with dremel, hacksaw or CNC Waterjet or alike.
- If possible remove as per picture taking excess battery posts away



Step 2 - Cut 2 pieces of carbon 50mm x10mm for center rib strengtheners and set aside

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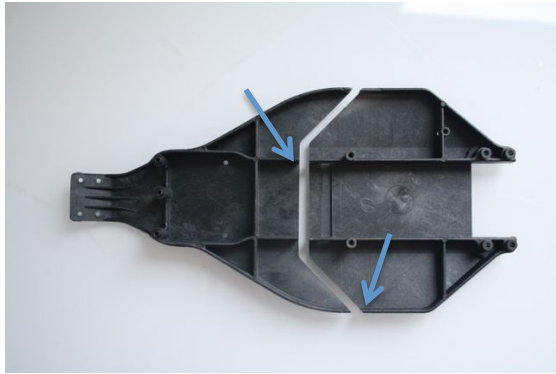
## B4.1 Chassis Mod

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Step 3 - Cut 2 pieces of carbon 25mm x 8mm for outer rib strengtheners and set aside

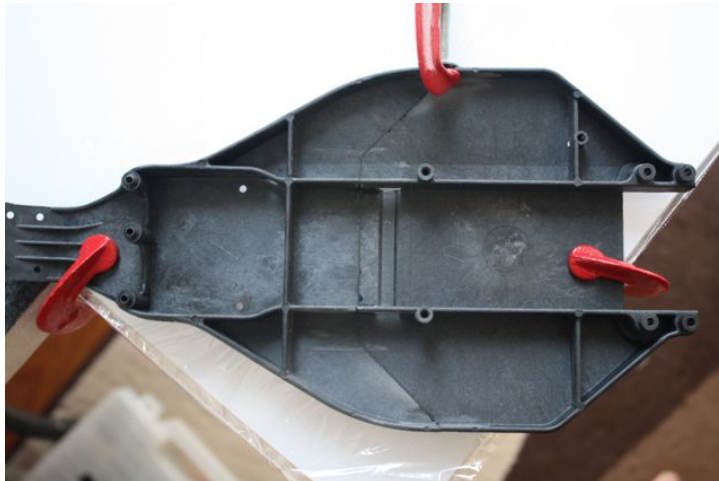
Step 4 – Chassis Prep

- Dremel or sand both carbon ribs and chassis where ribs will glue to. Ie inside of the outer rib on the chassis and outside of the battery ribs



Step 5 – Chassis Gluing

- Check chassis alignment for level and make sure to get edges aligned for good gluing. Patience is required here and small amounts of material removed at a time. Use a hand file if required
- Place the chassis on a flat surface, ensure it all mates correctly and then clamp chassis to test fit



- Once you are comfortable with fit run a bead of Loctite 480 along the edge of one half of the chassis and join it up.
- Clamp it tight and ensure edges are butted up.
- Leave to dry

\*\*Put some cling wrap on your flat surface so the chassis does not stick to it with excess glue.

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### Glued Chassis



#### Step 7 – Outer Rib Carbon Strengtheners

- Locate 25mm outer carbon strengtheners and clamp in position on chassis. Place a clamp on one half of the strengthener leaving enough room to drill one hole
- Drill one 2mm hole through chassis and through carbon strengthener
- Place a second clamp over the hole you just drilled
- Remove first clamp
- Drill the second 2mm hole through chassis and through carbon strengthener
- With 3mm tap proceed to tap carbon strengtheners
- Take 3mm drill bit and enlarge chassis holes
- Take the dremel with a stone tip and countersink holes in chassis



### Step 8 – Gluing Outer Rib Carbon Strengtheners

- Apply Loctite 480 to chassis and Outer Rib Carbon Strengtheners
- Screw Outer Rib Carbon Strengtheners to chassis tightly with 3x6mm c/s screws
- Let glue dry



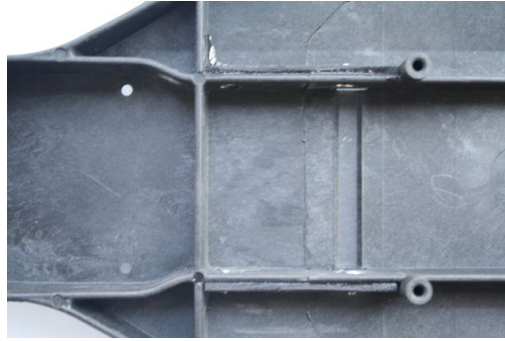
### Step 9 - Inner Rib Carbon Strengtheners

- Locate 50mm inner carbon strengtheners and place in chassis – mark holes to drill.
- Clamp to chassis
- Drill 2mm holes in inner carbon strengtheners where marked through carbon and through chassis. Keep as straight as possible
- Clamp inner carbon strengtheners to chassis rib
- Remove inner carbon strengtheners
- With 3mm drill bit finish hole on inner rib
- Place inner carbon strengtheners against rib and check alignment of holes
- Tap inner carbon strengtheners with 3mm drill bit
- Take the dremel with a stone tip and countersink holes in chassis inside ribs in battery compartment
- Locate esc rx slot in chassis and dremel carbon inner carbon strengthener to match



### Step 10 – Gluing Inner Rib Carbon Strengtheners

- Apply Loctite 480 to chassis and inner Rib Carbon Strengtheners
- Screw inner Rib Carbon Strengtheners to chassis tightly with 3x6mm c/s screws
- Let glue dry



### Completed Chassis

