



CATERHAM®

ASSEMBLY GUIDE

DURATEC – EDITION 2.3

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Your feedback and comments are welcome: assemblyguide@caterham.com

For help and build support enquiries contact: buildsupport@caterham.com

For help and support with IVA and registrations contact: ivaapplications@caterham.com

WELCOME TO YOUR NEW CATERHAM KIT

Building your own Caterham is immensely rewarding and satisfying. Of course, it should be remembered that you are building a high performance sports car, not a flat-pack wardrobe, so it will be a little challenging from time to time; but we've set out to make it as easy as possible for anyone, whatever their skill level and help is just a phone call away.

But before you do anything else, pop the kettle on or pour yourself a G&T with a slice; and

READ THE NEXT THREE PAGES - THEY ARE REALLY IMPORTANT

No, they will not be very exciting unfortunately, but they are important nonetheless and you will regret it later if you don't.

So there are four important things we need to think about **NOW** before picking up a spanner:

- **This isn't the only guide you'll need**
- **When to apply for an IVA test**
- **Photography (no, really)**
- **Arranging a post build check**

Although we have made this guide as comprehensive as possible, the requirements of IVA change from time to time and even from test centre to test centre. Therefore, it **MUST** be read in conjunction with the 'IVA Checklist Guide', the latest version of which can be **downloaded from the Caterham website**. You'll find the refer-to-IVA-manual symbol in the bottom of each illustration where attention is required. Reading through it now, will save pain later! Don't assume that because you've found a reference to one item relating to that page, it is the only one...

Once you have completed the assembly of your Seven, you are required by law to present it for an 'Individual Vehicle Approval' test (better known as IVA), which is conducted by the Vehicle and Operator Services Agency (VOSA) at a regional test centre.

We **STRONGLY** recommend that you apply for your IVA appointment at least a month before you think you will complete your build, to allow for the application form to be processed at the snail's pace of bureaucracy. Once accepted, your IVA application is valid for 6 months and test dates can be changed up to a minimum of 3 working days prior to your appointment with VOSA (any later and you may incur a charge).

The IVA and Registration application forms, and a guide on how to complete them, are sent out on request when you are midway or nearing completion of your build. Please email ivaapplications@caterham.com for a copy of your prefilled documents.



VOSA and the DVLA are a suspicious bunch and in order to register your car, you will need to provide proof that it is amateur built. When you apply for registration, you will need to include photos from various stages of you build, which will demonstrate to them that it is an 'amateur build'.

Recruiting a few extras (your kids, your spouse, the cat, etc.) and some props (last year's Xmas tree, a radio from the 1980's and a rusty bike) will all contribute to a more authentic home-garage feel; proving that no professional help (i.e. commercial workshop/garage) was involved in the build. Of course, feel free to have yourself working away on the kit in the photos if one of your 'extras' can be trusted with the camera (not the cat; they never get the exposure right).

Finally, we know you haven't started yet, but we need to tell you about the Post Build Inspection now, due to availability at our service centres and the time it takes to get you a slot. Plan ahead!

What is the Post Build Inspection? This is a free service offered by all Caterham service centres which we wholeheartedly recommend you take up on prior to your IVA test. It ensures that your car is correctly assembled and is road-worthy. All safety and operational aspects of your Seven will be checked, concluding in a road test. This will enable us to advise you of any corrective work that may be required (which we will be happy to carry out for you*). It is important to note that this is not the same as the IVA test and whilst every effort will be made to ensure your car passes, there is **NO GUARANTEE** of a first time IVA pass.

*Obviously any additional work is not for free, but we will speak to you first so you can decide whether you want to pay us to do the corrections or you want to do them yourself.

REMEMBER: Post Build Inspection slots are in high demand at our service centres and there may be a two-month lead time at busy times, so please check on availability and book ahead!

All our service centres will be able to offer you a Post Build Inspection and IVA service, where they take the car to IVA on your behalf. This tends to increase the likelihood of a first time pass and means you don't need to take a day out to endure the test, which is beyond dull.

That's it, we're ready to start assembly

ENJOY

MY BUILD NOTES

Download the IVA Checklist Guide: www.caterhamcars.com

Book IVA Test

Take plenty of photos

Arrange post build check

This was more fun than I ever expected!

HINTS & TIPS

When using a torque wrench, listen/feel the click and then stop. It does not need to be any tighter and you might actually weaken the fixing by 'over-torquing' it. Always wind your torque wrench setting back to free when you've finished with it.

John K

A 'nyloc' nut is one with a nylon insert that gets cut by the bolt thread, making it resistant to unwinding itself. This means that they should not be repeatedly re-used.

Chris B

This guide covers optional equipment your car may not have!

Tiago O

1Nm of torque equals 0.736lbft.

Mick F

Thread lock is used to stop something coming undone, but it only needs a little drop on the thread to be effective.

Jamie A

When using a spanner, always use the ring end wherever possible. The open end is really only for those times that access is too limited for a ring spanner or socket.

Mick A

Generally, metric Nyloc nuts have a blue nylon insert and imperial ones a white nylon insert.

Grant P

Teabag, boiling water, then the milk, in that order.

Simon L

Left and right are as viewed from the driver's seat.

Harrison P

You can tell if you have 'wide track suspension' car by looking at the front dampers. Wide track has a 25mm long hexagonal spacer between the top spring retainer and the mounting bush.

Matt T

A 'caphead bolt' has a circular head with a hexagonal drive inside it. It is tightened with an allen key or hex drive socket. Capheads are useful where there is limited space around the head for a spanner or socket. They look nice too!

Richard T

A bolt size is described by its diameter (e.g. M10=10mm) by the length not including the head (e.g. 65mm).

James A

A 'spring washer' has a split in it and squashes up closed when a fixing is tightened. It is usually used under a bolt head to help resist it coming undone.

John S



Speak to an expert
buildsupport@caterham.com

KEY

SYMBOLS

1 Item number

AA
AJ
AM Fixing item


S **R** S Pack / R Pack specific instructions


Nm Required torque (where applicable)


S3
S5 S3 / S5 chassis specific instructions

REPEAT Repeat on other side












 Advice from factory professionals


 Now is a good time to take some photos

 Reminder to apply for your IVA test

 Refer to IVA Checklist Guide

FIXINGS

Pack A		CATERHAM		44	
		PACK NUMBER		38F015B	
FRONT SUSPENSION DeDION CARS (METRIC)					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	AA Bolt M12 x 100 Grade 10.9	BM12X100	2	Lower wishbone rear	
2	AB Bolt M12 x 85 Grade 10.9	BM12X85	2	Lower wishbone front	
3	AC Bolt M10 x 85 Grade 10.9	BM10X85	2	Upper wishbone rear	
4	AD Bolt M10 x 80 Grade 10.9	BM10X80	2	Upper wishbone front	
5	AE Bolt M8 x 40 Grade 10.9	BM8X40	4	Anti-roll bar mounting brackets	
6	AF Plain Nut M14 x 1.5 thread	NM14	1	Temporary use to help lock upper wishbone ball joint	
7	AG Nyloc Nut M12	NM12	2	Lower wishbone rear	
8	AH Nyloc Nut M10	NM10	4	Upper wishbone	
9	AI Plain Washer M12 Oversized	WPCM12	18	Lower wishbone	
AK	Plain Washer M8 Heavy Duty	WPH8	4	Anti-roll bar mounting brackets	
AL	Plain Washer M2 x 2.5 Heavy Duty	WPH2.5	2	Steak stop	

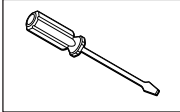

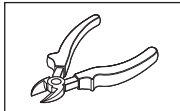
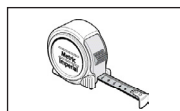
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	AA Bolt M12 x 100 Grade 10.9	BM12X100	2	Lower wishbone rear	

x4 ← (Indicates number of each fixing required)

← (Greyed out area indicates fixings are not required for current step)

KEY

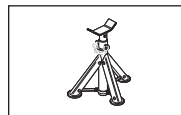
TOOLS

	Adjustable spanner		Engine hoist		Power adhesive		Spanner		Torque wrench
	Allen key		Flat head screwdriver		Pozidrive screwdriver		Spirit level		Torx
	Assistance		Grease		Ruler		Spray adhesive		Trolley jack
	Axle stand		Junior hacksaw		Scissors		Spray lube		WD40
	Cable tie		Latex gloves		Side cutters		Stanley knife		
	Combination spanner		Long nose pliers		Silicon		Super glue		
	Copper grease		Marker Pen		Silicon gun		Tape		
	Drill		Muscle		Socket wrench		Tape measure		
	Drill bit		Pop rivet gun		Socket wrench (allen)		Thread lock / LocTite		

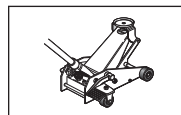
LET'S GET READY

PARTS

TOOLS



x3



FIXINGS

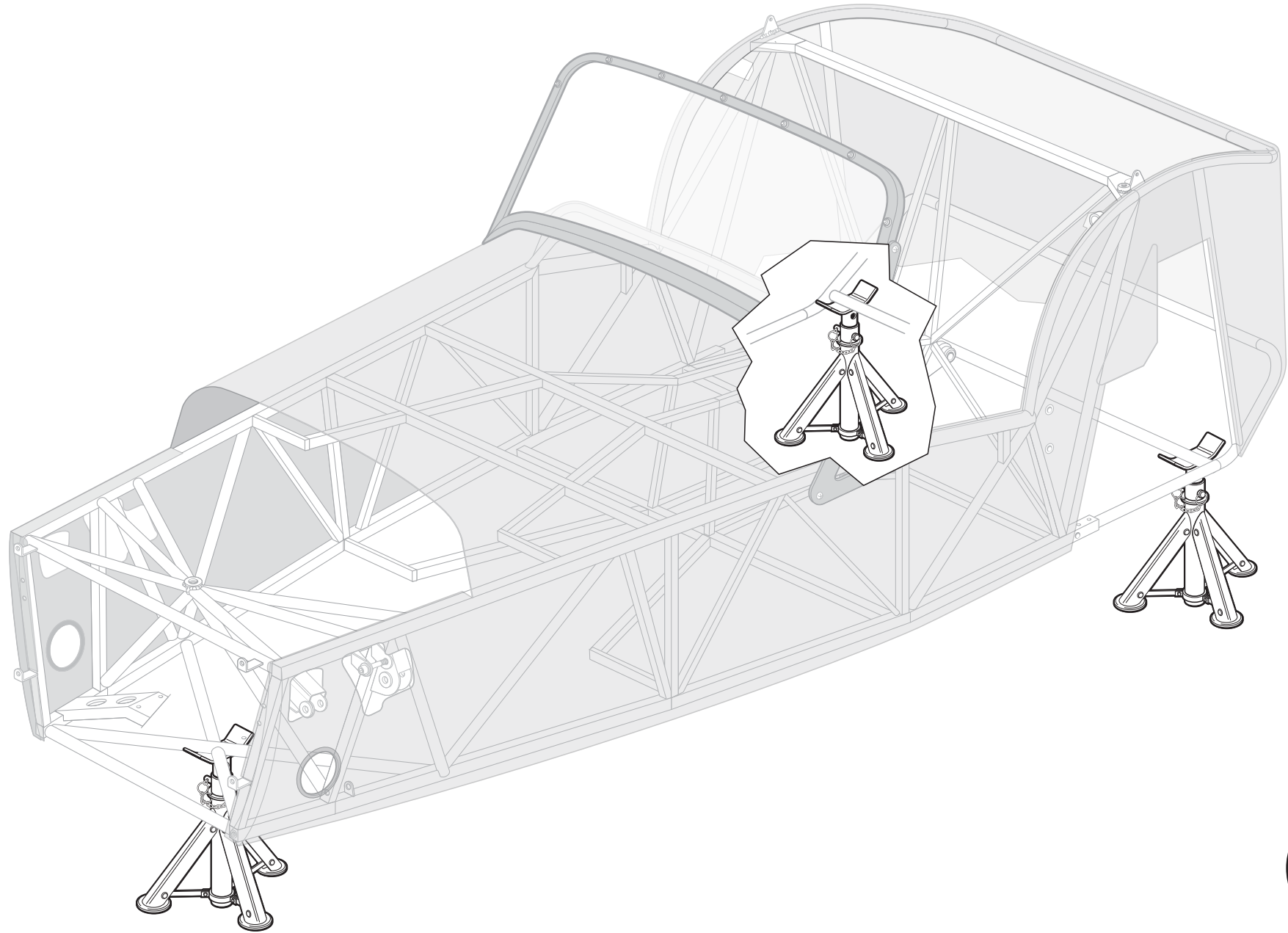
TIPS

When deciding how high your axle stands should be (the higher the better for working on), don't forget that a complete car will need to come down off them, so make sure your trolley jack can reach and lift the height you set them too!

Mick F

Some tape or foam on the top of the axle stands will stop them scratching the chassis.

Matt T

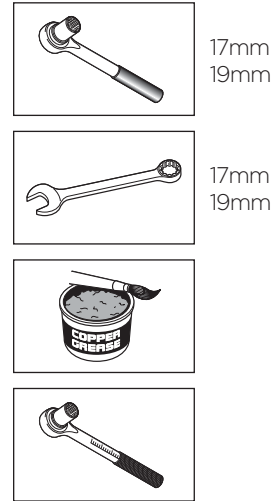


START WITH THE SUSPENSION WISHBONES

PARTS

- 1 Lower wishbone
- 2 Upper wishbone
- 3 Wishbone bush sleeve

TOOLS



FIXINGS

Pack A		CATERHAM		44	
		PART NUMBER		30F015B	
FRONT SUSPENSION DeDION CARS (METRIC)					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Bolt M12 x 100 Grade 10.9	BM12x100	2	Lower wishbone rear	
2	Bolt M12 x 65 Grade 10.9	BM12x65	2	Lower wishbone front	
3	Bolt M10 x 65 Grade 10.9	BM10x65	2	Upper wishbone rear	
4	Bolt M10 x 60 Grade 10.9	BM10x60	2	Upper wishbone front	
5	Bush M8 x 60 Grade 10.9	BM8x60	4	Anti-roll bar mounting brackets	
6	Flan Nut M12 x 1.5 Thread	NM12x1.5	1	Temporary use to fit the lower upper wishbone ball joint	
7	Nylon Nut M12	NM12	2	Lower wishbone rear	
8	Nylon Nut M10	NM10	4	Upper wishbone	
9	Flan Washer M12 Overhead	WPM12	18	Lower wishbone	
10	Flan Washer M8 Overhead	WPM8	4	Anti-roll bar mounting brackets	
11	Flan Washer 1/2" x 1/2" Overhead	WPM1/2	2	Brake pipe	

Pack A		CATERHAM		44	
		PART NUMBER		30F015B	
FRONT SUSPENSION DeDION CARS (METRIC)					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
12	Spring Washer M12	WS-M12	2	Lower wishbone front	
13	Spring Washer M8	WS-M8	4	Anti-roll bar mounting brackets & upper damper rodent	
14	Washer 1/2" Brake pipe	WS1/2	2	Brake pipe	
15	Nylon Nut 1/2" Headlight	NM1/2	2	Wing stay	
16	Nylon Nut 1/2" Headlight	NM1/2	2	Front brake, spring mounting (old track)	

x2

x2

x2

x2

x2

x4

x14

x2

TIPS

For now, only tighten the nuts/bolts lightly and then torque them up when the car is finished and on the ground. This sets the bushes correctly and ensures the best handling.

Harrison P

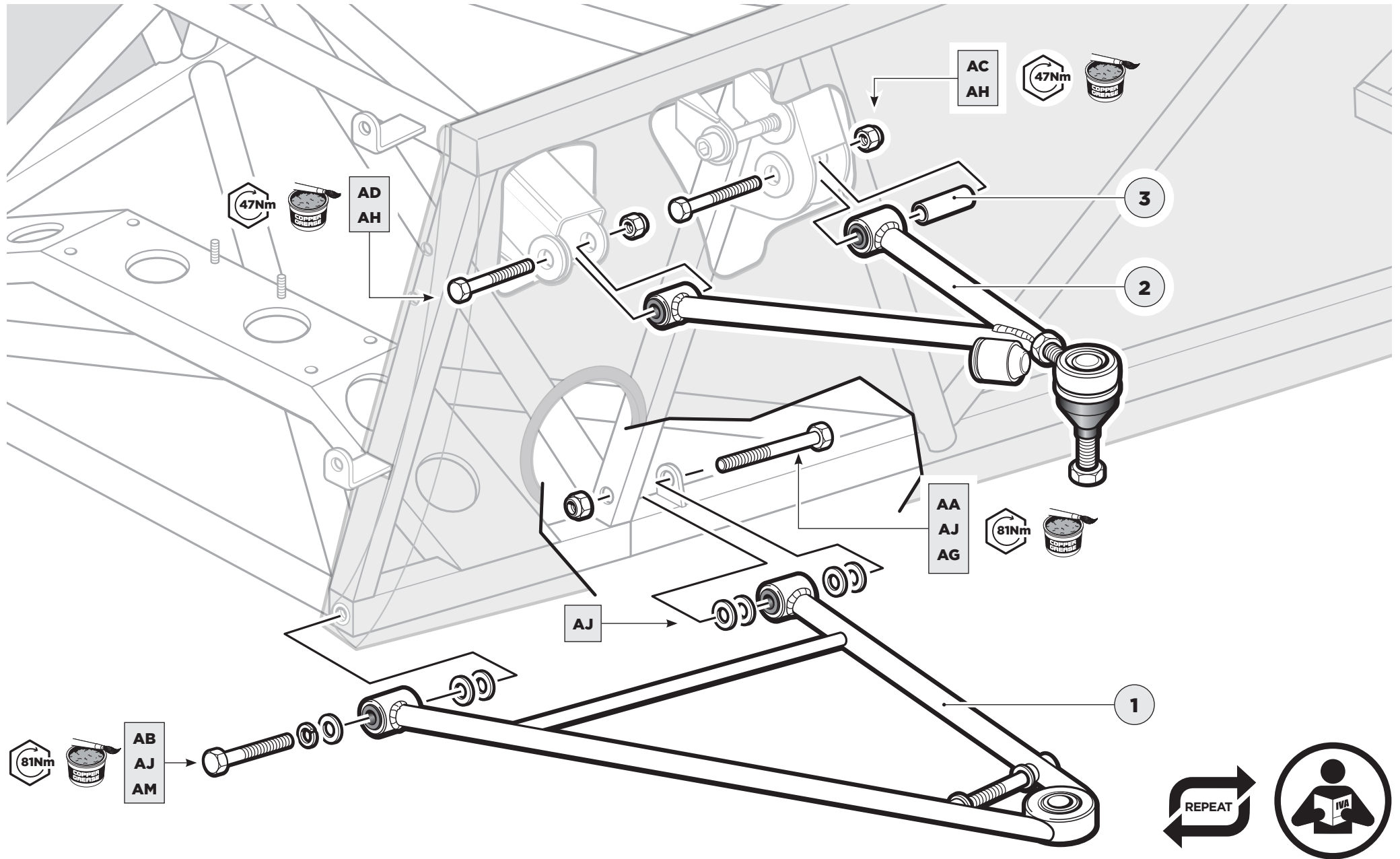
The big washers are chamfered and the chamfered side should be towards the wishbone.

Alex H

Leave bolt AD loose for now, as we have to take it back out again to put the headlight bracket on later.

John K

START WITH THE SUSPENSION WISHBONES

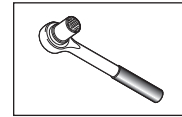


NOW FOR THE STEERING RACK

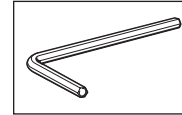
PARTS

- 1 Steering rack
- 2 Rack clamps
- 3 Column universal joint
- 4 Track rod end
- 5 IVA cover

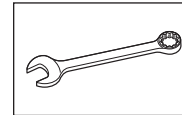
TOOLS



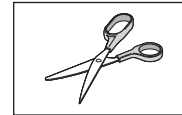
13mm



5mm



10mm
13mm
22mm
3/4"



FIXINGS

Pack B		CATERHAM		55	
		PACK NUMBER		JACK7001	
		RELEASED NOV-19			
STEERING DeDION CARS (METRIC)					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Clamped Bolt M6 x 70 DM142	BMCHEX70	4	Rack clamps	x4
2	Bolt 12 x 110	BF12x110	2	Column clamp	x2
3	Bolt M6 x 60 GSW 10.9	BMSM60	2	Column to rack universal joint	x2
4	Washer Nut 12	WPN12	1	Steering wheel boss	x2
5	Plain Nut 12	NPN12	2	Track rod lock nut	x2
6	Plain Nut 10	NPN10	1	Column clamp (production vehicle)	x2
7	Nyloc Nut M6	NMY6	2	Column to rack universal joint	x2
8	Nyloc Nut M6	NMY6	4	Steering rack clamps	x4
9	Plain Washer 12 x 16	WPN12	1	Steering wheel boss	x4
10	Plain Washer 12 x Heavy Duty	WPH14	6	Rack clamps and column clamp	x4
11	Spring Washer 12 x Heavy Duty	WSP14	2	Column clamp	x4

TIPS

Finding the right IVA cover isn't obvious because it is effectively a long cap. To use it, you cut the closed end off.

Jamie A

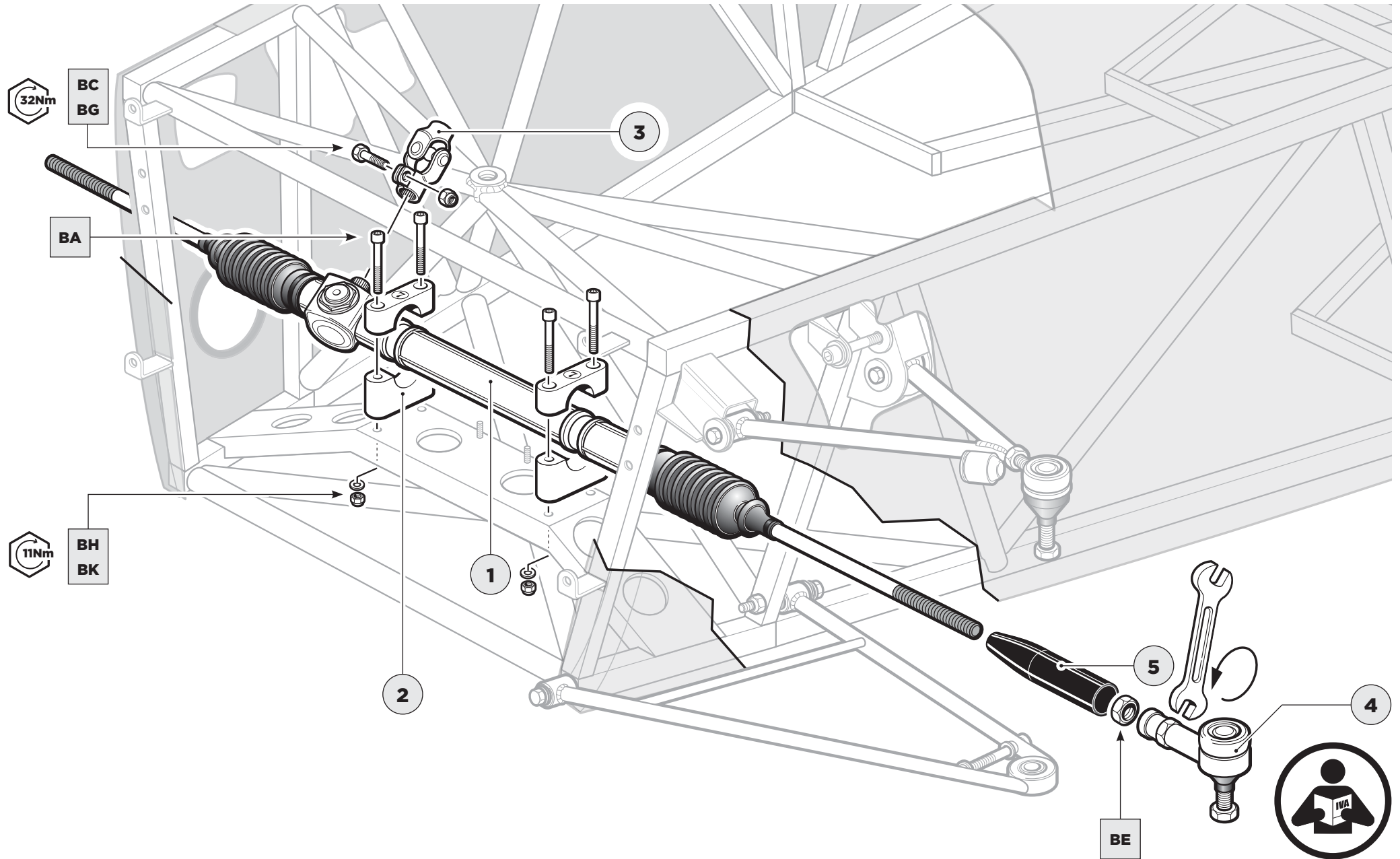
The trackrod end needs to screw on about 12 turns (it will be properly set later when the tracking is done).

Matthew H

Don't fully tighten steering rack for now.

Dan D

NOW FOR THE STEERING RACK

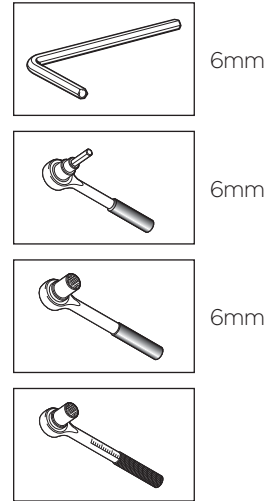


AND THEN THE DAMPERS

PARTS

- 1 Spring / damper
- 2 Lower damper sleeve
- 3 Upper damper sleeve

TOOLS



FIXINGS

Pack A		CATERHAM		44	
		PACK NUMBER		30F015B	
FRONT SUSPENSION DeDION CARS (METRIC)					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Ball M12 x 100 DIN913	8M12100	2	Lower wishbone rear	
2	Ball M12 x 60 DIN913	8M12060	2	Lower wishbone front	
3	Ball M12 x 60 DIN913	8M12060	2	Upper wishbone rear	
4	Ball M12 x 60 DIN913	8M12060	2	Upper wishbone front	
5	Ball M8 x 40 DIN913	8M08040	4	Anti-roll bar mounting brackets	
6	Flan Nu M14 x 1.5 Thread	8M1415	1	Temporary use to help lock upper wishbone ball joint	
7	Nylon Nut M12	8M1212	2	Lower wishbone rear	
8	Nylon Nut M12	8M1212	4	Upper wishbone	
9	Flan Wishbone M12 DIN913	8M1212	18	Lower wishbone	
10	Flan Washer M8 DIN913	8M0808	4	Anti-roll bar mounting brackets	
11	Flan Washer 1/2" x 1/2" DIN913	8M1208	2	Brake pipe	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

Pack A		CATERHAM		44	
		PACK NUMBER		30F015B	
FRONT SUSPENSION DeDION CARS (METRIC)					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
12	Spring Washer M8	8M0808	2	Lower wishbone rear	
13	Spring Washer M8	8M0808	6	Anti-roll bar mounting brackets & upper damper mount	
14	Washer 1/2" DIN913	8M1208	2	Brake pipe	
15	Nylon Nut 1/2" DIN913	8M1212	2	Wing stay	
16	Nylon Nut 1/2" DIN913	8M1212	2	Front brake, spring mounting (old track pipe)	

Drawings are for illustrative purposes only and are not to scale. Page 2 of 2

Fixings not contained in the pack will be supplied loosely fitted to the chassis and the wishbone

TIPS

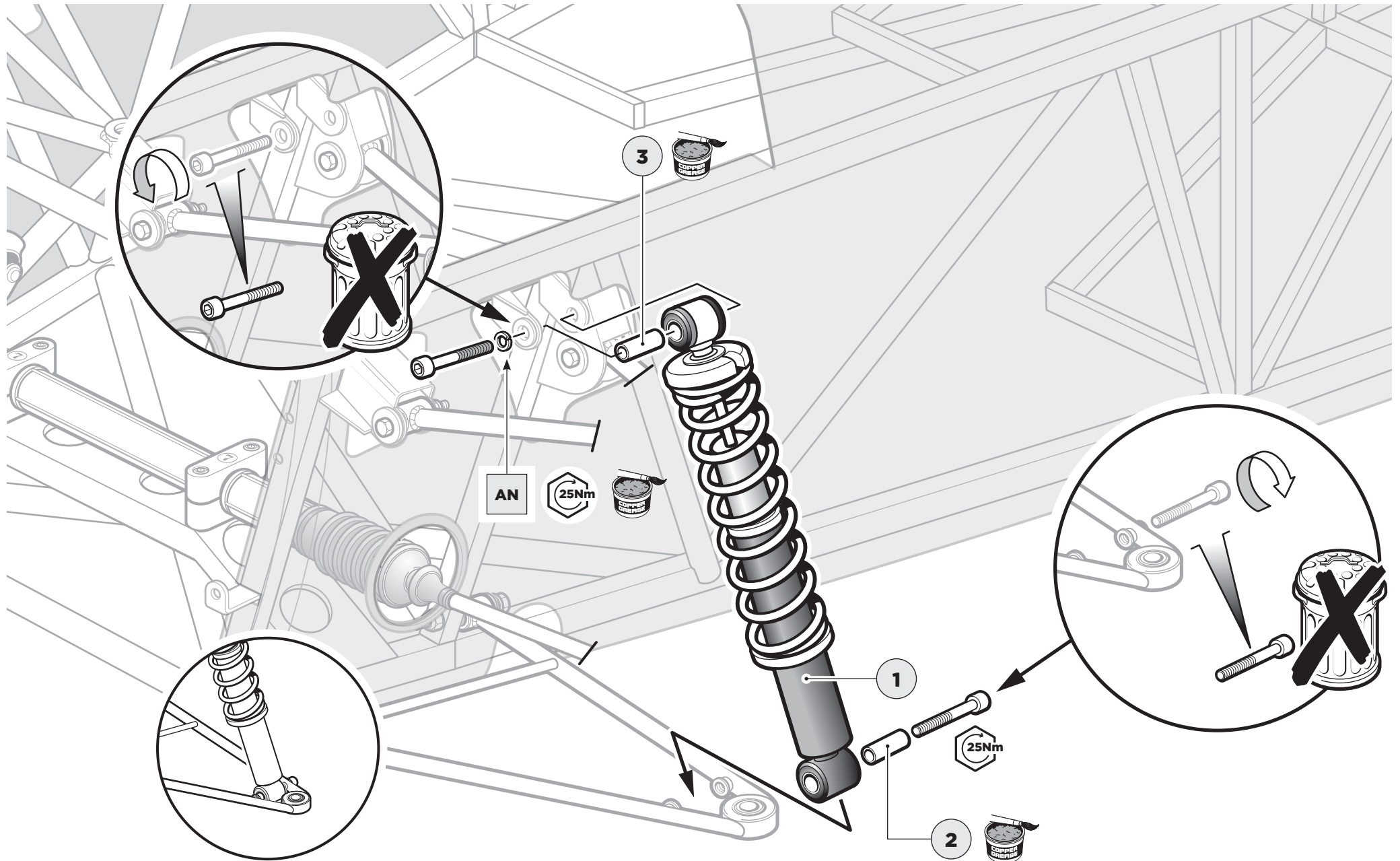
Put the top of the damper on first and be careful not to let it swing into the side of the chassis.

Grant P

The bottom can be a tight fit!

Mick F

AND THEN THE DAMPERS

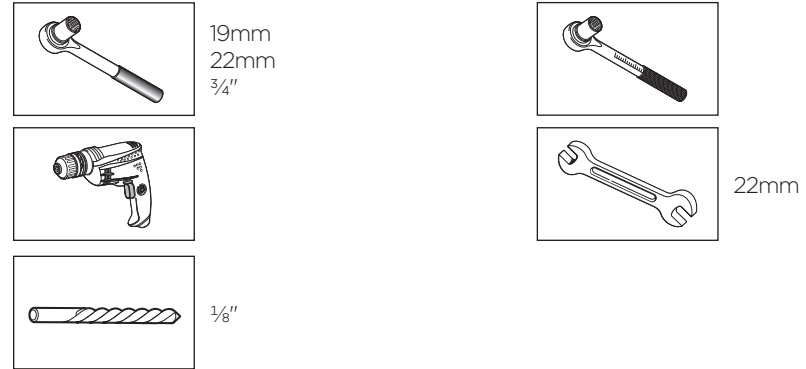


IT'S TIME FOR THE WINGSTAYS

PARTS

- 1 Wingstay
- 2 Front brake & upright assembly

TOOLS



FIXINGS

Pack A		CATERHAM		44	
		PART NUMBER		30F015B	
FRONT SUSPENSION DeDION CARS (METRIC)					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	AA Bolt M12 x 100 DIN9132	BA122100	2	Lower wishbone rear	
2	AB Bolt M12 x 60 DIN9132	BA122060	2	Lower wishbone front	
3	AC Bolt M12 x 60 DIN9132	BA122060	2	Upper wishbone rear	
4	AD Bolt M12 x 60 DIN9132	BA122060	2	Upper wishbone front	
5	AE Bolt M8 x 40 DIN9132	BA082040	4	Anti-roll bar mounting brackets	
6	AF Plain Nut M14 x 1.5 thread	NB1414	1	Temporary use to help lock upper wishbone ball joint	
7	AG Nylon Nut M12	NB1212	2	Lower wishbone rear	
8	AH Nylon Nut M12	NB1212	4	Upper wishbone	
9	AJ Plain Washer M12 DIN9132	WA1212	18	Lower wishbone	
10	AK Plain Washer M8 DIN9132	WA0808	4	Anti-roll bar mounting brackets	
11	AL Plain Washer 1/2" x 1/2" DIN9132	WA1616	2	Brake pipe	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

Pack A		CATERHAM		44	
		PART NUMBER		30F015B	
FRONT SUSPENSION DeDION CARS (METRIC)					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
12	AM Spring Washer M12	WS1212	2	Lower wishbone rear	
13	AN Spring Washer M8	WS0808	6	Anti-roll bar mounting brackets & upper damper rodnut	
14	AP Washer 1/2" x 1/2" DIN9132	WA1616	2	Brake pipe	
15	AR Nylon Nut 1/2" x 1/2" DIN9132	NB1616	2	Wing stay	
16	AS Nylon Nut 1/2" x 1/2" DIN9132	NB1616	2	Front brake, upright mounting (std track ONLY)	

Drawings are for illustrative purposes only and are not to scale. Page 2 of 2

x2
x2

TIPS

The drilled hole is for the side repeater earth that we'll fit later. It's easier to drill from the top and down through both sides of the tube, rather than through one side from the bottom (where the earth will be fixed).

Tiago O

Put the 'upright' into the lower wishbone joint then attach the steering before tightening the bottom nut. This stops it all swinging around hitting the side of the chassis.

John S

Some of the fixings required and shown on the drawings, such as the ball joint nut, are already on the part and not in the fixing pack.

Anthony L

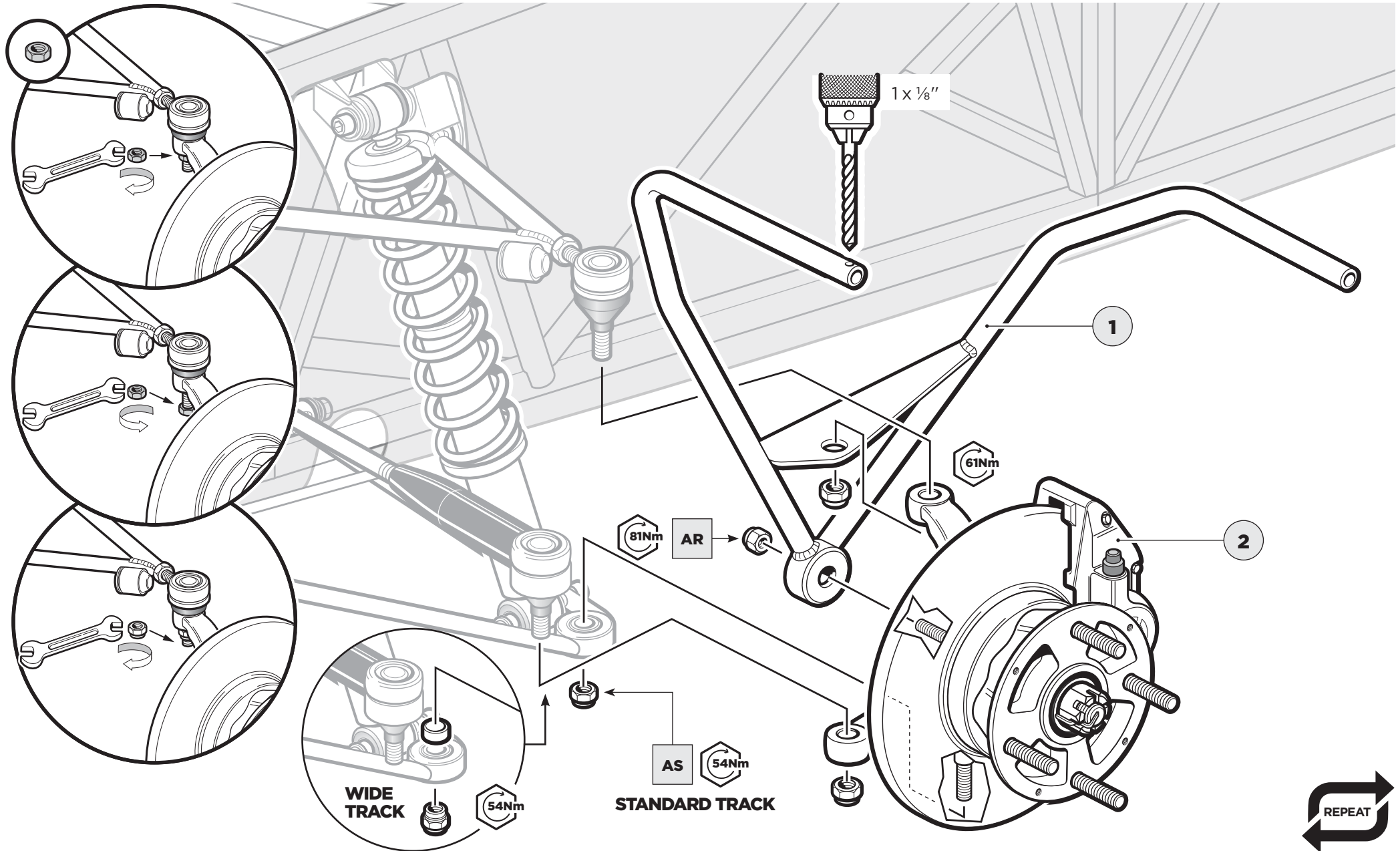
Remove and discard the washer that comes on the back of the assembly before fitting the wingstay; it's not needed.

Rich T

Use the plain nut to pull the top ball joint home before using a nyloc, otherwise the thread will spin.

Chris N

IT'S TIME FOR THE WINGSTAYS





Now is a good time to take some photos



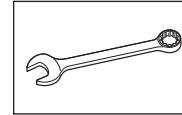
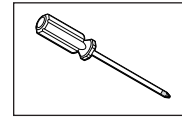
Have you applied for your IVA yet?

LET THERE BE LIGHTS

PARTS

- 1 Headlight assembly
- 2 Indicator pod
- 3 Indicator assembly
- 4 Headlight bracket
- 5 IVA trim

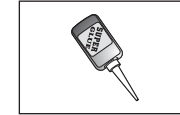
TOOLS



17mm
24mm



17mm



17mm

TIPS

It's very important to read the IVA Guide before starting this job to ensure grommets and sheathing are in the right place. It's very difficult to add them once fitted!

John S

This is the trickiest job on the car, so once done you can breathe a sigh of relief!

Tiago A

The wiring for the headlights is attached to the chassis when you receive your kit. The wires go through the hole in the end of the headlight bracket and out of the other hole in order to go up into the headlight and over to the indicator.

Jamie A

Glue IVA trim all around the edge of the pod before fitting.

Chris B

The tab on the headlight bracket ④ hooks under the wishbone bracket on the chassis.

Harrison P

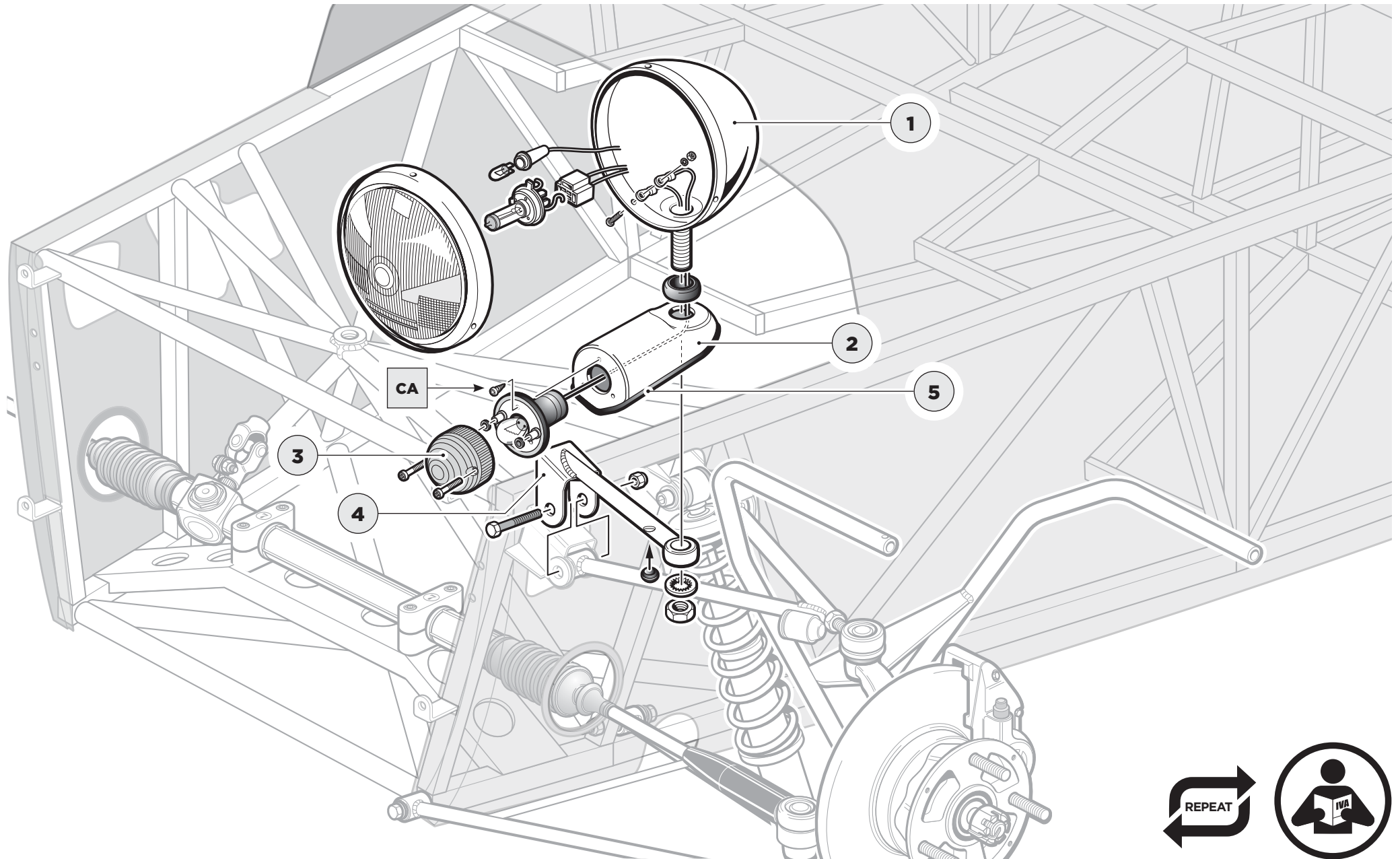
FIXINGS

Pack C		CATERHAM		45	
		PACK NUMBER		30L002B	
LIGHTING & HORNS					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Screw 10 x 1" (25mm)	F1080	6	Indicator assembly to indicator pod	
2	Screw 8 x 1" (20mm)	F1071	2	Side regulator earth on wing/body	
3	Screw 12 x 1/2" (30mm)	F1072	4	Rear light cluster upper fixing	
4	Screw 12 x 1/2" (30mm)	F1073	4	Rear light cluster lower fixing	
5	Wash Hex 100	H0170	2	Horn bracket to mounting plate (1800/210/10)	
6	Wash Washer 100	H0171	2	Horn bracket to mounting back plate (1800/210/10)	
7	Ball 100 x 10 (30mm)	H0172	1	Through steering rack column at motor (1800)	
8	Wash Washer 100	H0173	2	Ball Head/hub	
9	Wash Hex 100	H0174	1	Horn base	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 1

x6

LET THERE BE LIGHTS

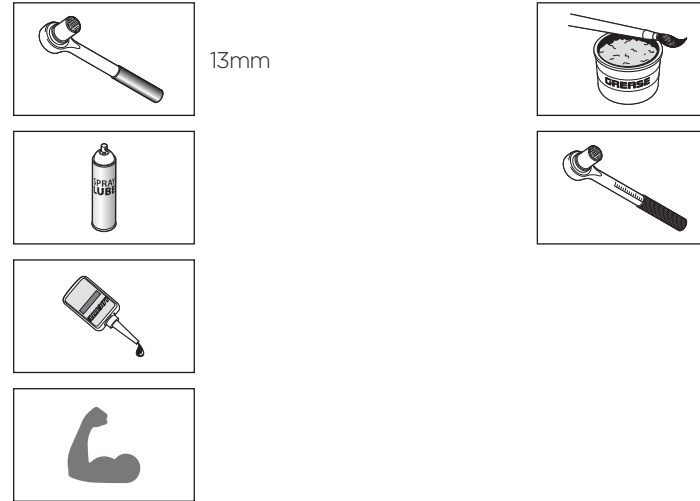


LAST PART OF THE FRONT SUSPENSION: CONNECTING THE TWO SIDES TOGETHER

PARTS

- 1 Anti-roll bar
- 2 Anti-roll bar bracket
- 3 Anti-roll bar rubber
- 4 Anti-roll bar ball
- 5 Anti-roll bar dust cover

TOOLS



FIXINGS

ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Ball M12 x 40 DIN913B	BM12100	2	Lower wishbone rear	
2	Ball M12 x 40 DIN913B	BM12000	2	Lower wishbone front	
3	Ball M12 x 40 DIN913B	BM12040	2	Upper wishbone rear	
4	Ball M12 x 40 DIN913B	BM12000	2	Upper wishbone front	
5	Ball M8 x 40 DIN913B	BM840	4	Anti-roll bar mounting brackets	
6	Plain Washer M12 DIN913	WP112	1	Temporary use to temporarily secure wishbone ball joint	
7	Upper Ball M12	BM112	2	Lower wishbone rear	
8	Upper Ball M12	BM112	4	Upper wishbone	
9	Plain Washer M12 DIN913	WP112	18	Lower wishbone	
10	Plain Washer M8 Heavy Duty	WP148	4	Anti-roll bar mounting brackets	
11	Plain Washer 1/2" x 1/2" DIN913	WP125	2	Brake pads	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
12	Spring Washer M8	WS184	2	Lower wishbone rear	
13	Spring Washer M8	WS184	6	Anti-roll bar mounting brackets & upper damper mount	
14	Washer 1/2" DIN913	WP125	2	Brake pads	
15	Nylon Nut M12 DIN913	NP112	2	Wing nut	
16	Nylon Nut M12 DIN913	NP112	2	Front brake, spring mounting (ball track plate)	

Drawings are for illustrative purposes only and are not to scale. Page 2 of 2

x4

x4

x4

TIPS

Use four small cable ties to secure the dust cover.

Mick F

Grease the balls and cups generously.

Matt T

Check that the colour of the mounting rubbers matches the colour spot on the bar.

John K

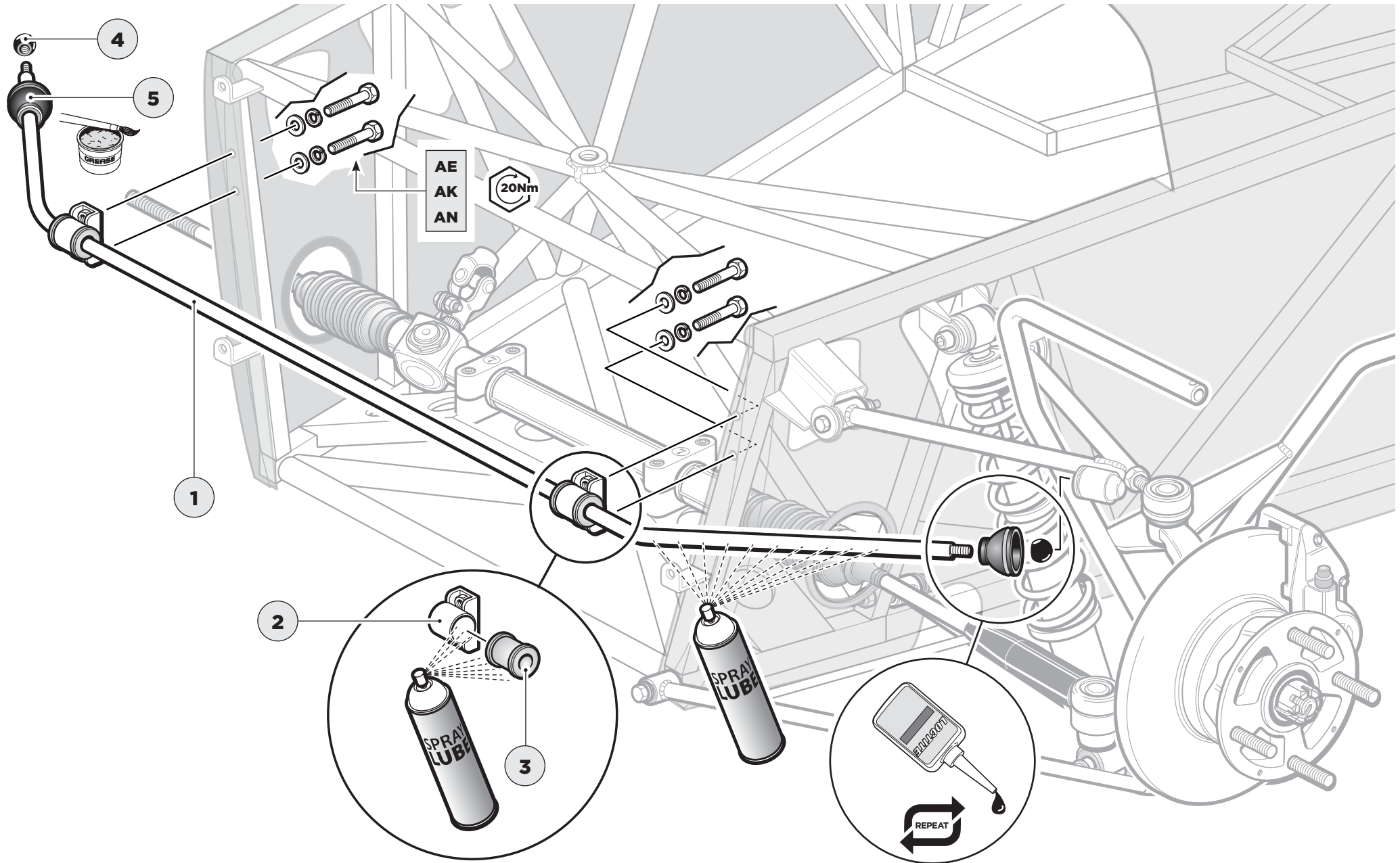
Getting the assembled anti-roll bar fully into both cups on the upper wishbone can be a bit of a fight. It's made of springy stuff, so don't worry that you are bending it.

Jamie A

Use the thread lock on the thread of the anti-roll bar, not in the thread of the ball.

Dan D

LAST PART OF THE FRONT SUSPENSION: CONNECTING THE TWO SIDES TOGETHER

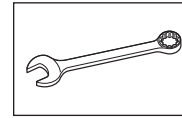


FITTING THE BRAKE HOSES

PARTS

- 1** Brake hose
- 2** Copper washer

TOOLS



13mm (x2)
9/16"

FIXINGS

Pack A		CATERHAM		44	
		PACK NUMBER		30F015B	
FRONT SUSPENSION DeDION CARS (METRIC)					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	AA Bolt M12 x 100 Hex Hd	BA122100	2	Lower wishbone rear	
2	AE Bolt M12 x 60 Hex Hd	BA120060	2	Lower wishbone front	
3	AC Bolt M12 x 60 Hex Hd	BA120060	2	Upper wishbone rear	
4	AD Bolt M12 x 60 Hex Hd	BA120060	2	Upper wishbone front	
5	AE Bolt M8 x 40 Hex Hd	BA080040	4	Anti-roll bar mounting brackets	
6	AF Flan Nut M14 x 1.5 Thread	BA09114	1	Temporary use to tighten lock upper wishbone ball joint	
7	AG Nylon Nut M12	BA09112	2	Lower wishbone rear	
8	AM Nylon Nut M10	BA09110	4	Upper wishbone	
9	AJ Flan Washer M12 Oversize	WP03112	18	Lower wishbone	
10	AK Flan Washer M8 Hex Hd	WP03008	4	Anti-roll bar mounting brackets	
11	AL Flan Washer 1/2" x 1/2" Hex Hd	WP03008	2	Brake pipe	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

Pack A		CATERHAM		44	
		PACK NUMBER		30F015B	
FRONT SUSPENSION DeDION CARS (METRIC)					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
12	AM Spring Washer M12	WP04012	2	Lower wishbone rear	
13	AN Spring Washer M8	WP04008	6	Anti-roll bar mounting brackets & upper damper rod ends	
14	AP Washer 1/2" Hex Hd	WP03008	2	Brake pipe	
15	AR Nylon Nut 1/2" Hex Hd	BA09110	2	Wing stay	
16	AS Nylon Nut 1/2" Hex Hd	BA09110	2	Front brake, spring mounting (left track rod)	

Drawings are for illustrative purposes only and are not to scale. Page 2 of 2

x2

x2

TIPS

The hose will want to curve once fitted. Make sure the curve points towards the front of the car.

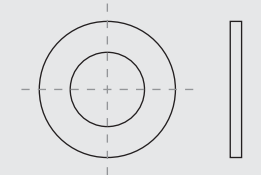
Khalfani D

Brake hoses come in packs of 3: 2 front, 1 back.

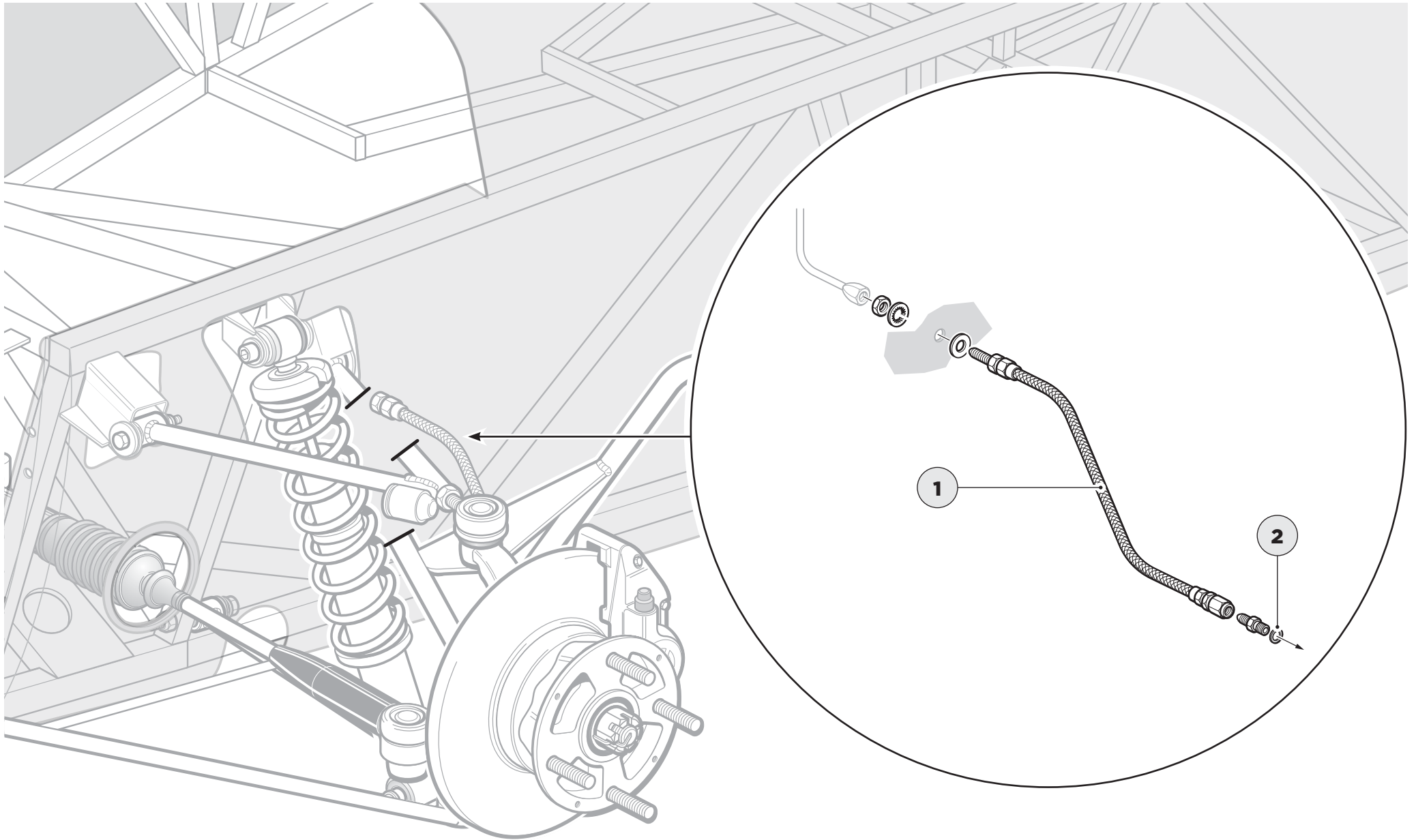
Anthony L

The copper washer should be this size.

James A



FITTING THE BRAKE HOSES



LET'S MAKE SOME NOISE

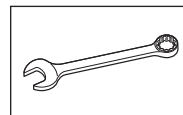
PARTS

- 1 Horn kit (x2)
- 2 Spacer (miscellaneous box)
- 3 Bolt for spacer

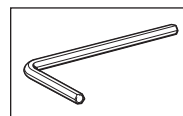
TOOLS



10mm



13mm



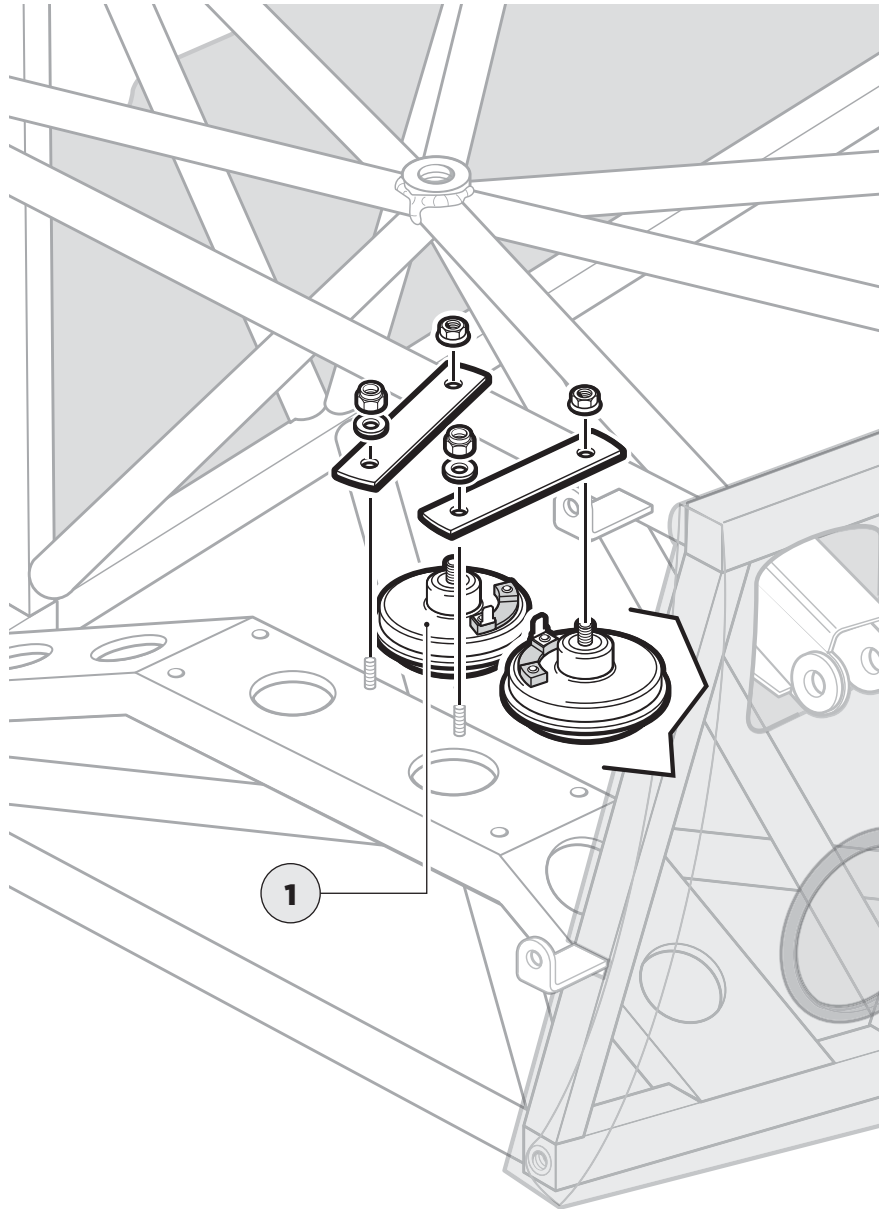
6mm

FIXINGS

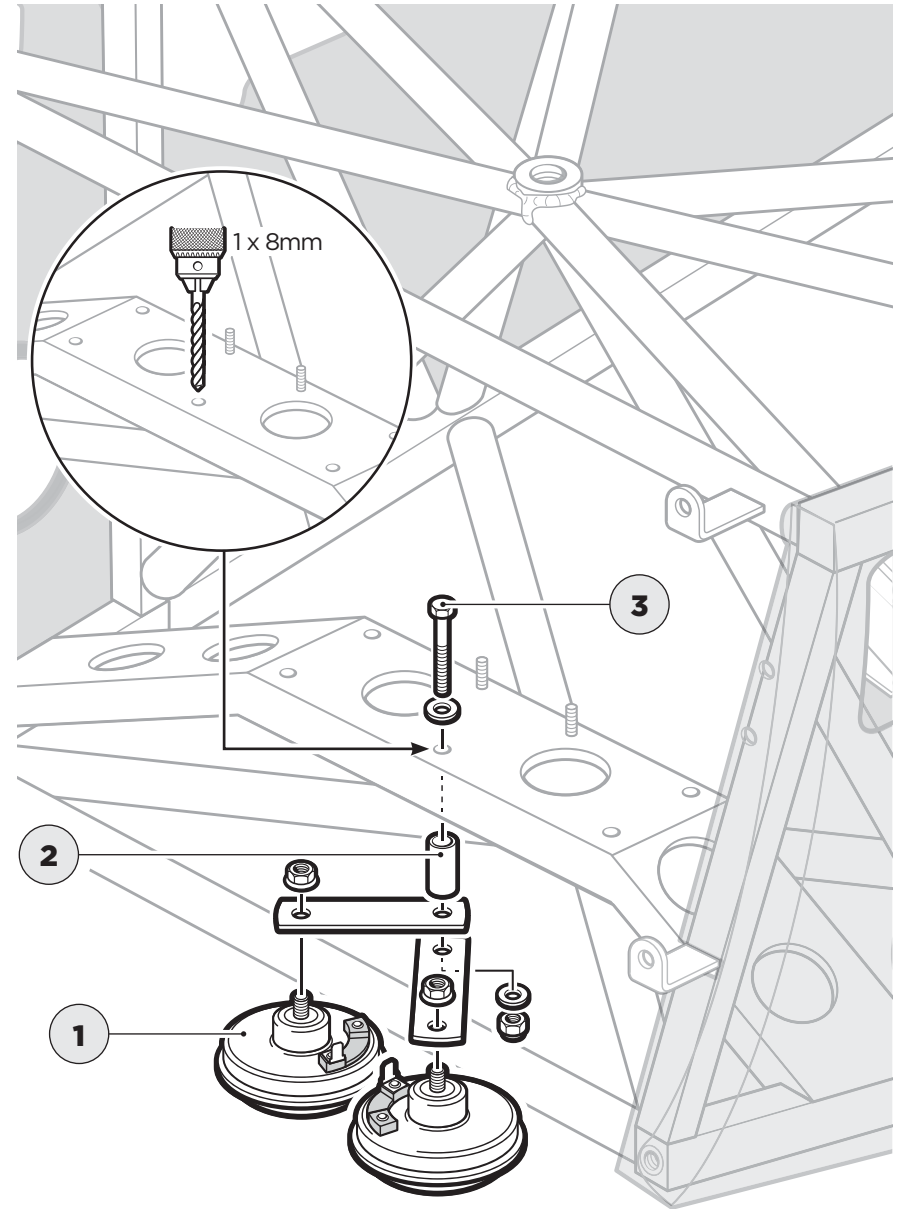
Miscellaneous box

TIPS

270/310/360



420

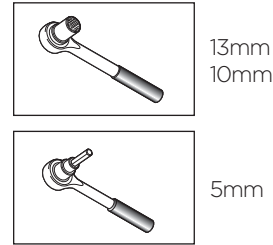


WET SUMP FITTING THE RADIATOR

PARTS

- 1 Radiator
- 2 Blanking plate
- 3 Fan
- 4 Radiator bobbins

TOOLS



FIXINGS

Pack D		CATERHAM		44	
		PACK NUMBER		SICCATB	
COOLING SIGMA					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	DA Nut M8 x 20 Heavy Duty	888440	1	Expansion tank bracket to chassis	
2	DB Bolt M8 x 16 Heavy Duty	88714024	1	Expansion tank to bracket	
3	DC Substrate M8x20 Heavy Duty	888420	4	SM radiator bracket	
4	DD Nut M8 x 16 with Square Washer	88710204	4	Fan brackets to fan	
5	DE Substrate M8x20 Heavy Duty	88844010	4	Fan to radiator mounting to SM	
6	DF Nylon Nut M8	NMPP8	8	4x Fan to radiator 4x 4x DV radiator bracket	
7	DG Plain Nut M8	NMPP8	8	Radiator bobbin	
8	DH Nylon Nut M8	NMPP8	1	Expansion tank bracket	
9	DI Plain Washer 16 Heavy Duty	888410	13	13 x DV Fan brackets 4 x 4x Fan brackets 1 x Expansion tank to Expansion tank to fan	
10	DJ Plain Washer 12 Heavy Duty	88841016	4	Radiator bobbin back	
11	DK Plain Washer 16 Heavy Duty	88841020	4	Radiator bobbin front	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

x4

x4

x4

x4

Pack D		CATERHAM		44	
		PACK NUMBER		SICCATB	
COOLING SIGMA					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
12	DL Plain Washer 16 Heavy Duty	88841020	1	Expansion tank bracket	
13	DM Spring Washer 16 Heavy Duty	8884010	8	8 x Radiator bobbin 1 x Expansion tank	
14	DN Hex Cap 16 Heavy	8872040	6	2 x 4x where fan to radiator 2 x 4x radiator tank to 2x Radiator bobbin	
15	DO Hex Cap 16 Heavy	8872030	2	1 x Engine outlet to top 1 Engine 1 x Engine outlet to motor (top)	
16	DP Hex Cap 16 Heavy	8872030	18	6 Radiator bobbin to DV Fan 6 Expansion tank to DV Fan 6 Radiator bobbin to DV Fan	
17	DI Hex Cap 16 Heavy	8872030	6	Expansion tank small 1 piece	
18	DR Hex Bolt 12x16 Heavy Duty	887201010	12	Cooling fan	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

TIPS

Be careful to tighten the fan gently and with just a nip.

Dan P

The fan should have a 'flat' section on the rim. This should be at the top.

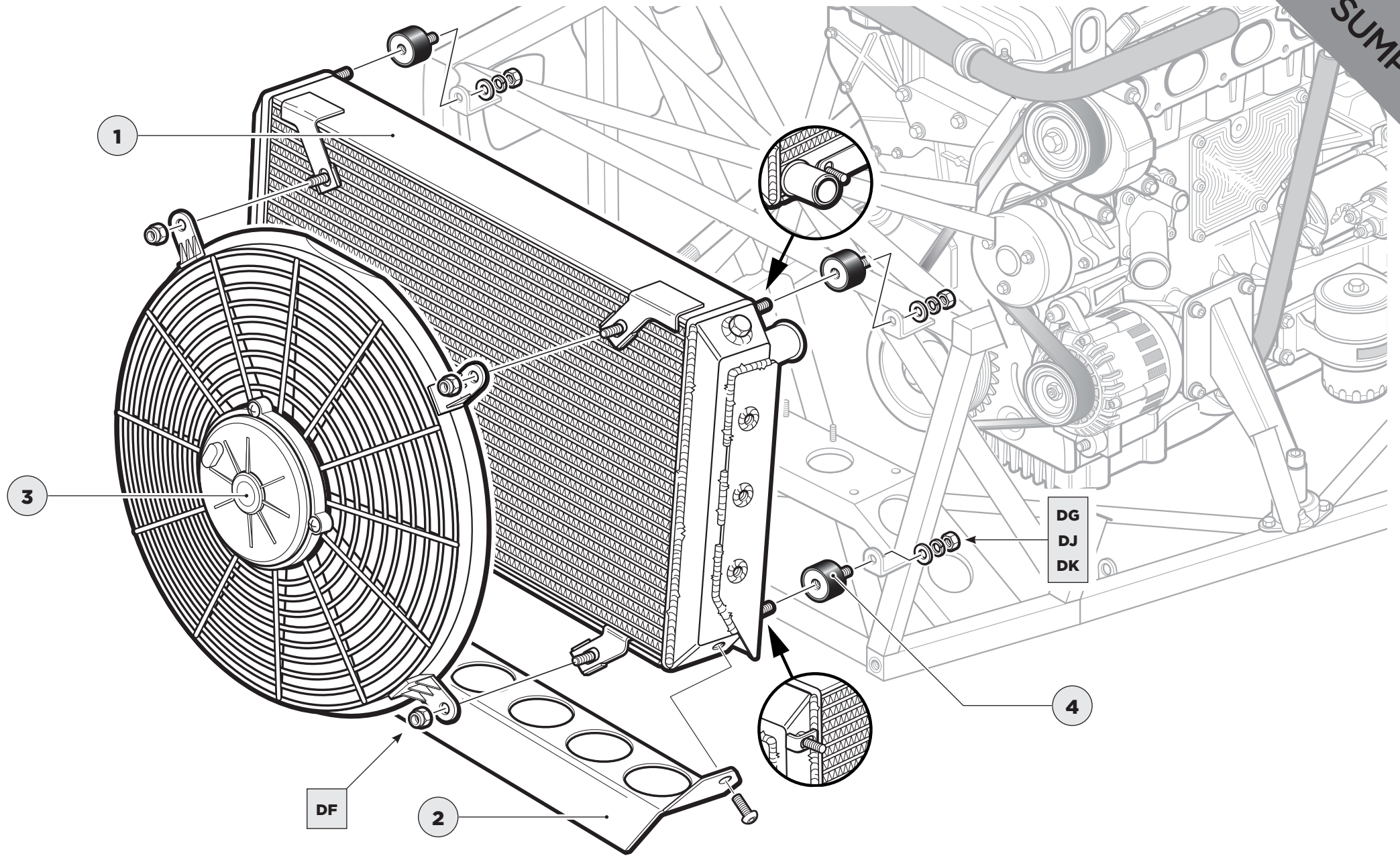
Grant P

The blanking plate is fitted using two M8x16 bolts, they should be in the box.

James A

WET SUMP FITTING THE RADIATOR

WET SUMP

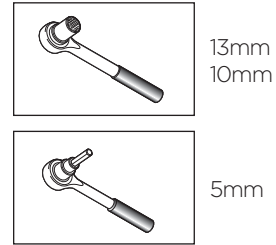


DRY SUMP FITTING THE RADIATOR

PARTS

- 1 Radiator
- 2 Blanking plate
- 3 Fan
- 4 Radiator bobbins

TOOLS



FIXINGS

Pack D		CATERHAM		44	
		PACK NUMBER		SICCATB	
COOLING SIGMA					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	DA Bolt M8 x 20 Heavy Duty	888440	1	Expansion tank bracket to chassis	
2	DB Bolt M8 x 16 Heavy Duty	88714224	1	Expansion tank to bracket	
3	DC Bolt M8 x 20 Heavy Duty	888440	4	SM radiator bracket	
4	DD Bolt M8 x 16 with Square Washer	88714224	4	Fan brackets to fan	
5	DE Bolt M8 x 16 with Square Washer	88714224	4	Fan to radiator mounting to SM radiator bracket	
6	DF Nylon Nut M8	NMFF8	8	4x Fan to radiator bracket 4x DV radiator bracket	
7	DG Plain Nut M8	NMFF8	8	Radiator bobbin	
8	DH Nylon Nut M8	NMFF8	1	Expansion tank bracket	
9	DI Plain Washer 16 Heavy Duty	8891114	13	8x 4 DV Fan Brackets 4x Expansion tank to Expansion tank	
10	DJ Plain Washer 12 Heavy Duty	8891116	4	Radiator bobbin back	
11	DK Plain Washer 12 Heavy Duty	88911208	4	Radiator bobbin front	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

x4

x4

x4

x4

Pack D		CATERHAM		44	
		PACK NUMBER		SICCATB	
COOLING SIGMA					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
12	EL Plain Washer 16 Heavy Duty	8891114	1	Expansion tank bracket	
13	EM Spring Washer 16 Heavy Duty	8891112	8	8x Radiator bobbin 1x Expansion tank	
14	EN Hex Cap 16 Heavy	8872040	6	2x 4x where hoses meet 2x 4x on radiator hose 2x where radiator hose	
15	EO Hex Cap 16 Heavy	8872038	2	1x Engine outlet to top of tank 1x Engine outlet to bottom of tank	
16	EP Hex Cap 16 Heavy	8871625	18	6 where hoses meet 6 on fan 6 on expansion tank 6 on DV hoses	
17	EQ Hex Cap 8 Heavy	8871616	6	Expansion tank small T piece	
18	ER Bolt - Black 12 Heavy Duty	88716110	12	Cooling fan	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

TIPS

Be careful to tighten the fan gently and with just a nip.

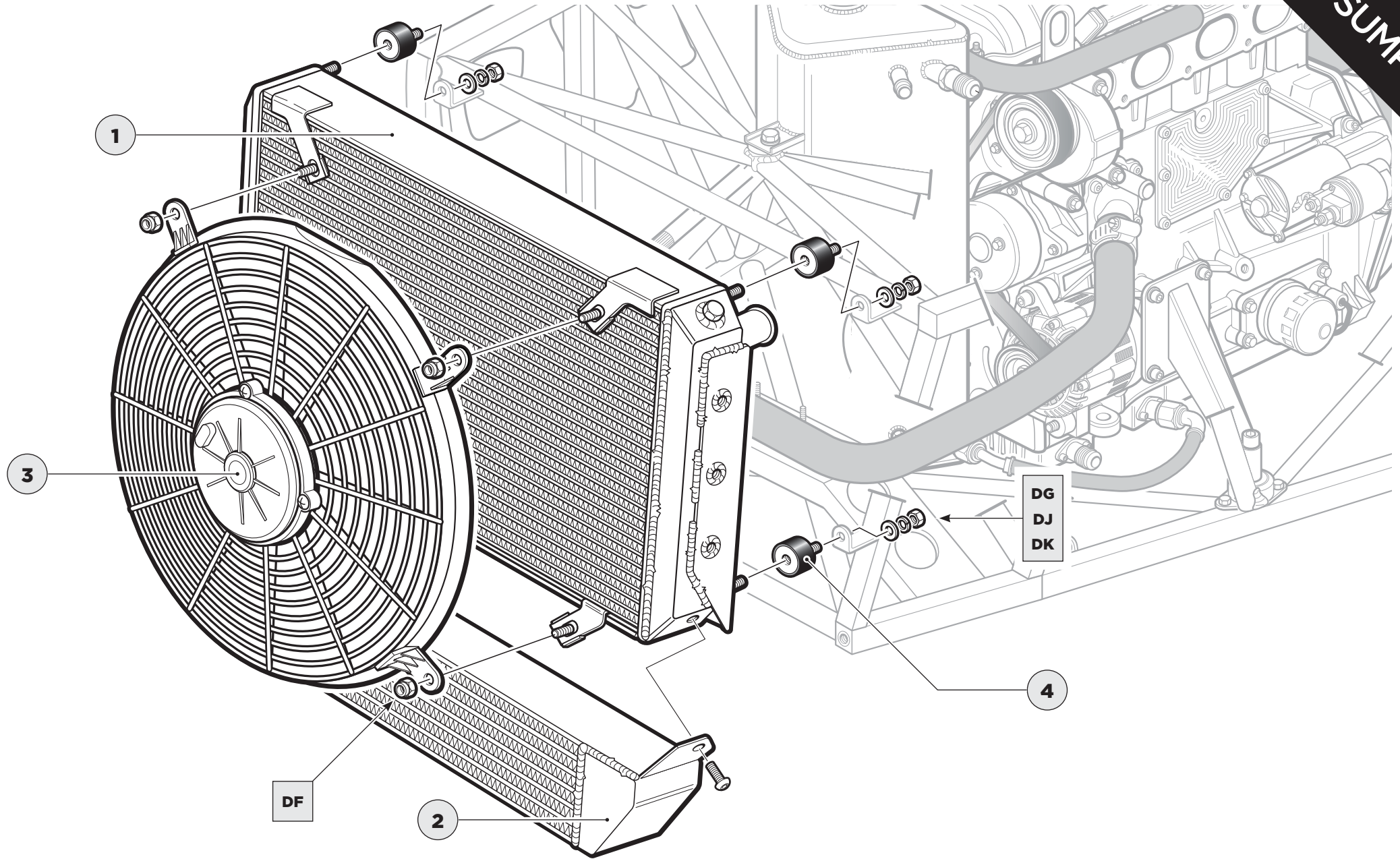
Dan P

The fan should have a 'flat' section on the rim. This should be at the top.

Grant P

DRY SUMP FITTING THE RADIATOR

DRY SUMP

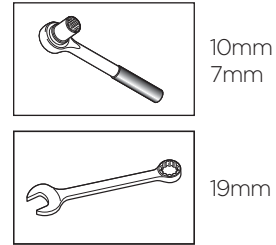


THINGS ARE HEATING UP

PARTS

- 1 Heater
- 2 Valve
- 3 Heater cable
- 4 Lower hose 110mm (cut from long length)
- 5 Upper hose 120mm (cut from long length)
- 6 Grommet

TOOLS



FIXINGS

Pack D CATERHAM 44					
COOLING SIGMA					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Expansion tank bracket to chassis	888440	1		
2	Expansion tank to bracket	88714024	1		
3	SM radiator bracket	888420	4		
4	Fan brackets to fan	8871024	4		
5	Fan to radiator coating - SI only	8884015	4		
6	1/4 Fan to radiator and SV radiator bracket	888475	8		
7	Radiator bobbin	888475	8		
8	Expansion tank bracket	8871014	1		
9	1/4 Fan to radiator and SV radiator bracket	888475	13		
10	Radiator bobbin back	8871015	4		
11	Radiator bobbin front	888475	4		

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

x2

Pack D CATERHAM 44					
COOLING SIGMA					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
12	Expansion tank bracket	888440	1		
13	Expansion tank to bracket	88714024	1		
14	SM radiator bracket	888420	4		
15	Fan brackets to fan	8871024	4		
16	Fan to radiator coating - SI only	8884015	4		
17	1/4 Fan to radiator and SV radiator bracket	888475	8		
18	Radiator bobbin	888475	8		
19	Expansion tank bracket	8871014	1		
20	1/4 Fan to radiator and SV radiator bracket	888475	13		
21	Radiator bobbin back	8871015	4		
22	Radiator bobbin front	888475	4		

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

x4

TIPS

Remember to remove bungs from heater.

Jamie A

Use 7mm for jubilee clips but not too tight!

Chris B

It's worth re-tightening the jubilee clips after a couple of uses of car.

John S

WET / DRY SUMP REMOVE ENGINE PARTS

PARTS

- 1 Engine mounts
- 2 Starter motor
- 3 Bellhousing

TOOLS

FIXINGS

TIPS

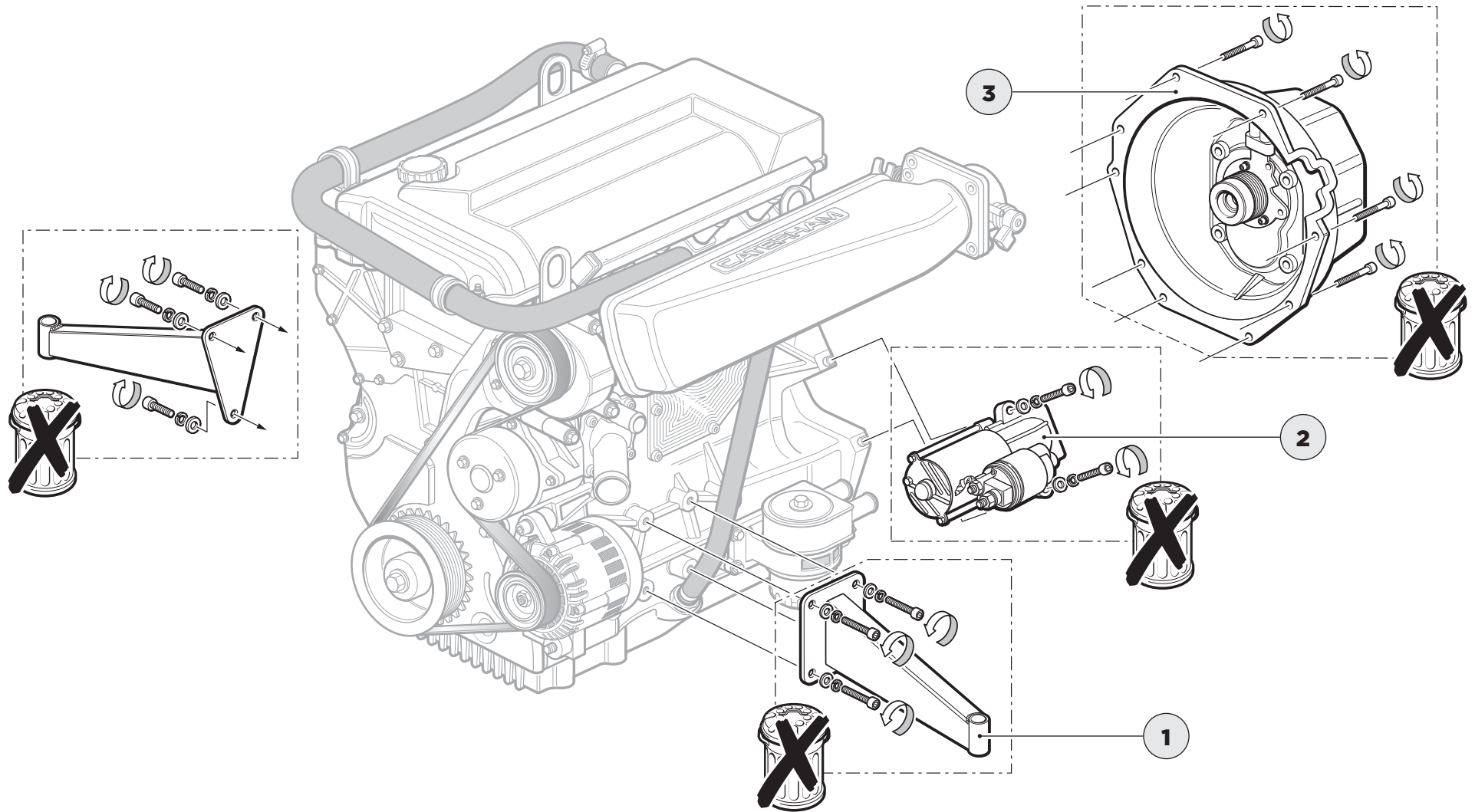
Remove the engine mounts, starter motor and bellhousing.

Mick F

Remember where the bolts go.

John S

WET / DRY SUMP REMOVE ENGINE PARTS

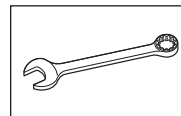


WET / DRY SUMP REMOVE ENGINE PARTS

PARTS

- 1 Alternator
- 2 Alternator Belt
- 3 Plenum

TOOLS



15mm

FIXINGS

TIPS

Remove alternator, alternator belt and plenum.

Richard T

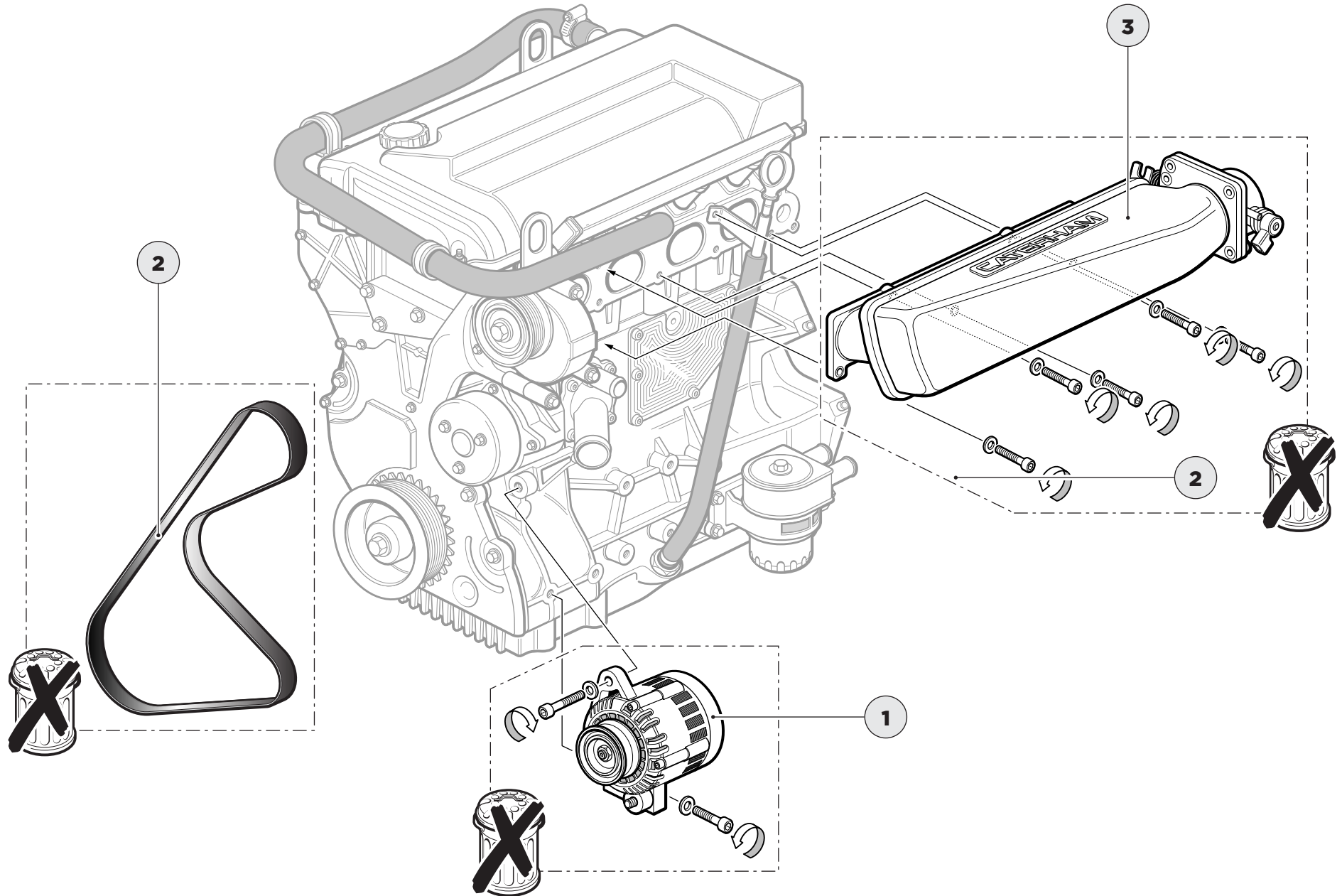
Use a 15mm spanner and turn anti-clockwise to remove alternator.

Harrison P

Remember where the bolts go.

John S

WET / DRY SUMP REMOVE ENGINE PARTS

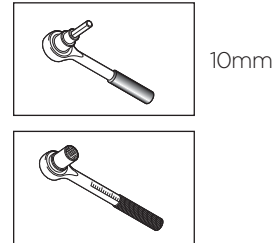


WET / DRY SUMP ATTACH GEARBOX TO BELLHOUSING

PARTS

- 1** Gearbox
- 2** Bellhousing

TOOLS



FIXINGS

Pack F		CATERHAM		66	
		PACK NUMBER		3E22029B	
DURATEC GEARBOX 5 SPEED					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	FA Pin M10 x 20 x 3.5 Grade 12.9	302202A	2	AV Mount	
2	FB Caphead M12 x 40 x 1.75 Grade 12.9	3MCH12040	4	Bellhousing	
3	FC Caphead Bolt M10 x 20 Grade 12.9	3MCH10020	1	Bellhousing	
4	FD Caphead Bolt M10 x 20 Grade 12.9	3MCH10020	3	Bellhousing	
5	FE Caphead Bolt M10 x 4.4 Grade 12.9	3MCH10044	7	x 0 Bellhousing x 2 Starter Motor	
6	FF Caphead Bolt M8 x 20 Grade 12.9	302207A	4	AV Mount	
7	FG Caphead Bolt M8 x 20 Grade 12.9	3MCH08020	3	Clutch Release Bearing	
8	FH Substandard Bolt M8 x 10 Grade 10.9 HexHead Fin	3021100A	1	Gear Lever	
9	FI Nylon Nut M8	MM378	4	AV Mount	
10	FJ Plain Washer M10	3M1014	2	AV Mount	
11	FK Plain Washer M12	302203A	4	Bellhousing	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

x4

x4

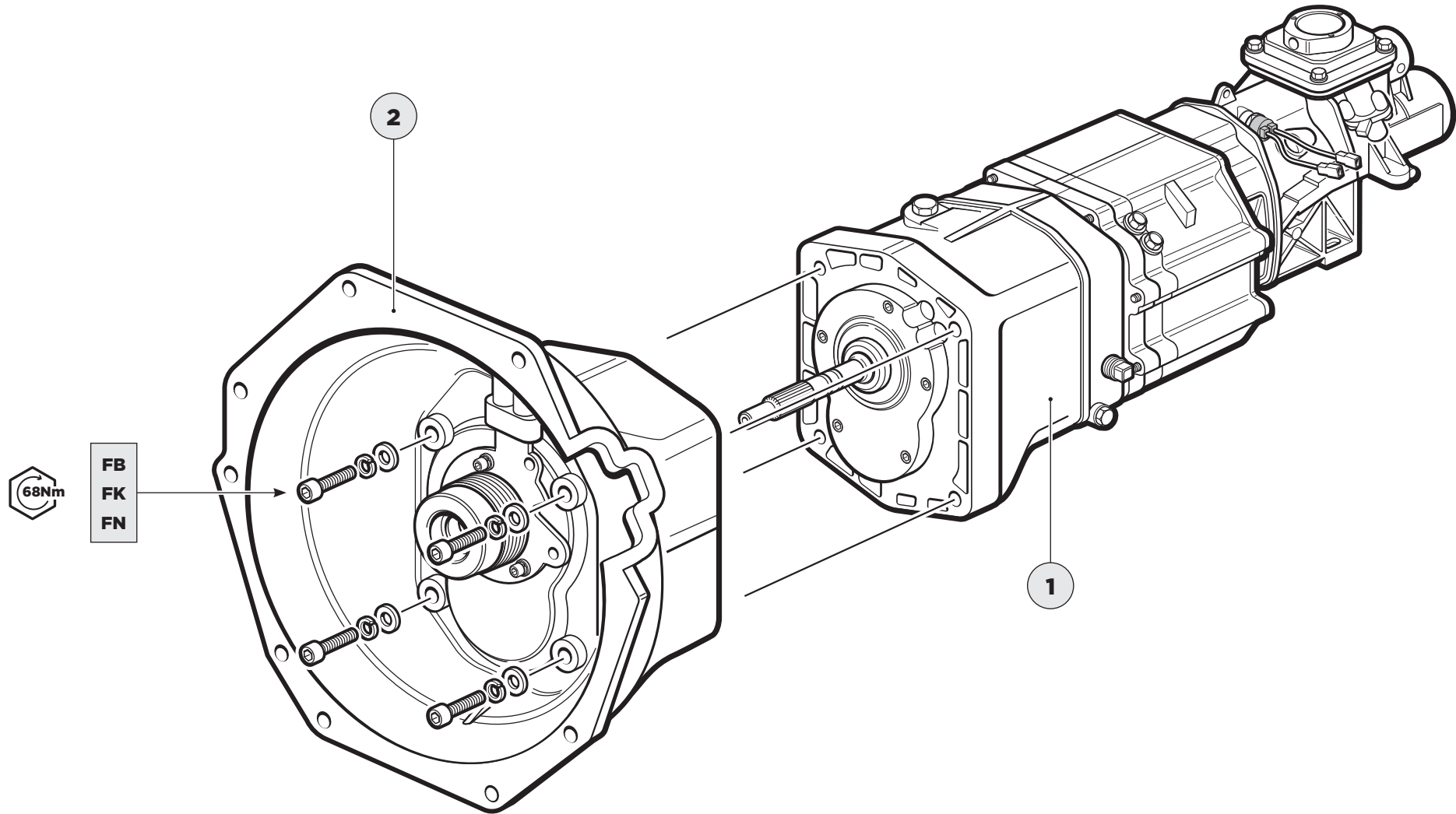
Pack F		CATERHAM		66	
		PACK NUMBER		3E22029B	
DURATEC GEARBOX 5 SPEED					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
12	FL Plain Washer M8	3M1008	3	Gear Lever	
13	FM Spring Washer M10	302202A	2	AV Mount	
14	FN Spring Washer M12	W5HM12	4	Gearbox	
15	FO Spring Washer M10	W5HM10	4	x 2 Starter Motor x 3 Front Bellhousing	
16	FP Spring Washer M8	W3HM8	3	Clutch Slave Cylinder	

Drawings are for illustrative purposes only and are not to scale. Page 2 of 2

x4

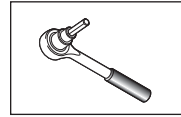
TIPS

WET / DRY SUMP ATTACH GEARBOX TO BELLHOUSING



WET / DRY SUMP AND THEN GEARBOX TO ENGINE

TOOLS



8mm



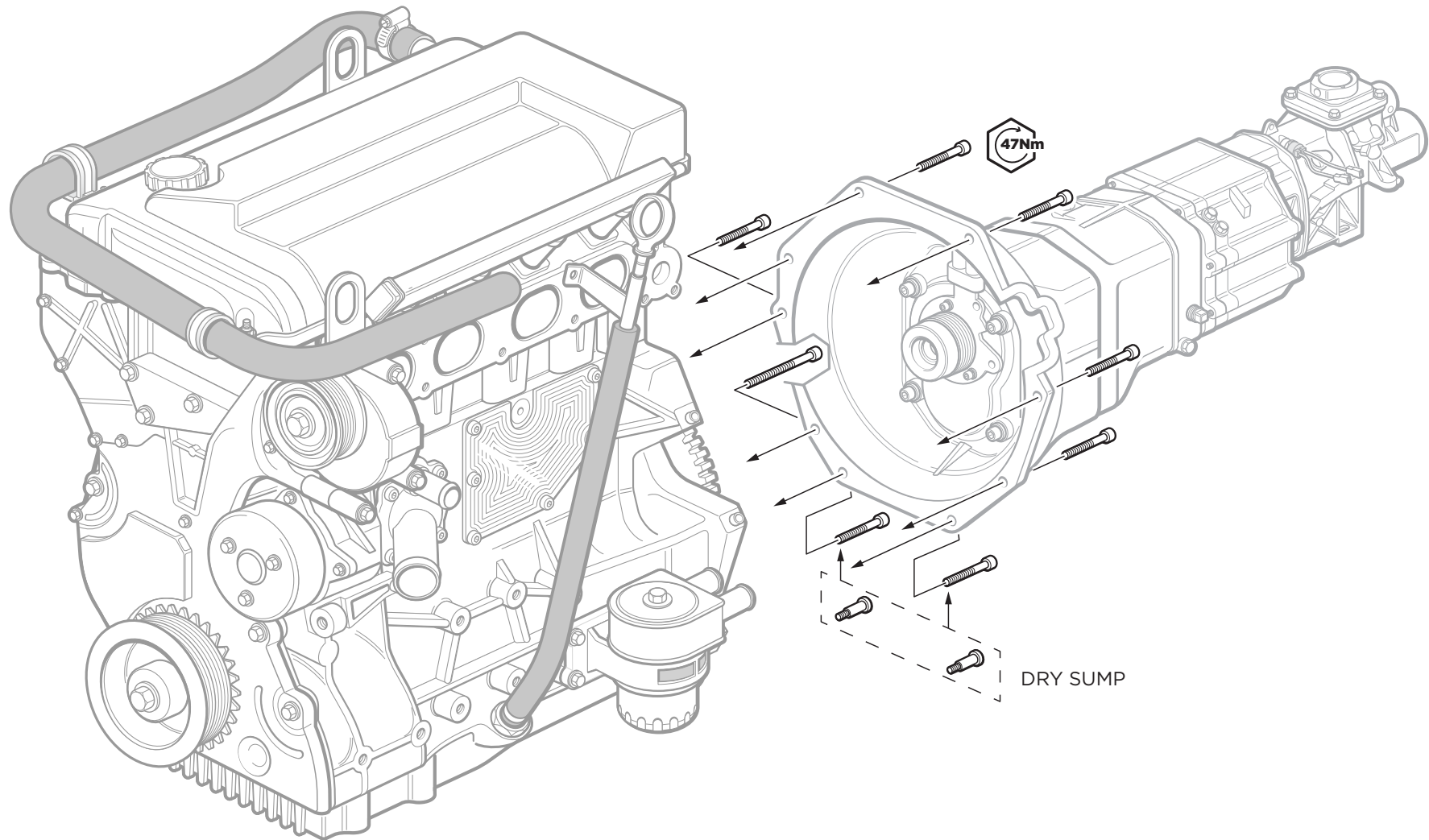
FIXINGS

TIPS

Refit bellhousing and gearbox to engine.

Harrison P

WET / DRY SUMP AND THEN GEARBOX TO ENGINE



FILLING THE ENGINE AND GEARBOX WITH OIL

PARTS

Engine oil SW-30

Gear oil GL4

TOOLS

FIXINGS

TIPS



Ford 2.0L Engine

Wet Sump = 4.5 Litres

Dry Sump = 6.0 Litres (3 Litres in Engine,
3 Litres in Tank, top up if required)

5 Speed Gearbox = (Pre-Filled)

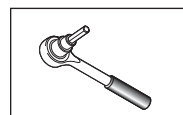
Before Installation. You can double check the oil level by removing the plug on the side. The oil should be to this level.

WET / DRY SUMP AT LAST THE ENGINE IS GOING IN

PARTS

- 1 Engine mounts
- 2 Engine rubbers

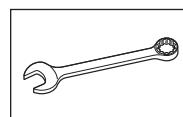
TOOLS



6mm
8mm
3/8



13mm



13mm
15mm

FIXINGS

TIPS

When fitting engine rubbers and mounts, fit as loosely as possible so you can wiggle things to get bolts in.

James A

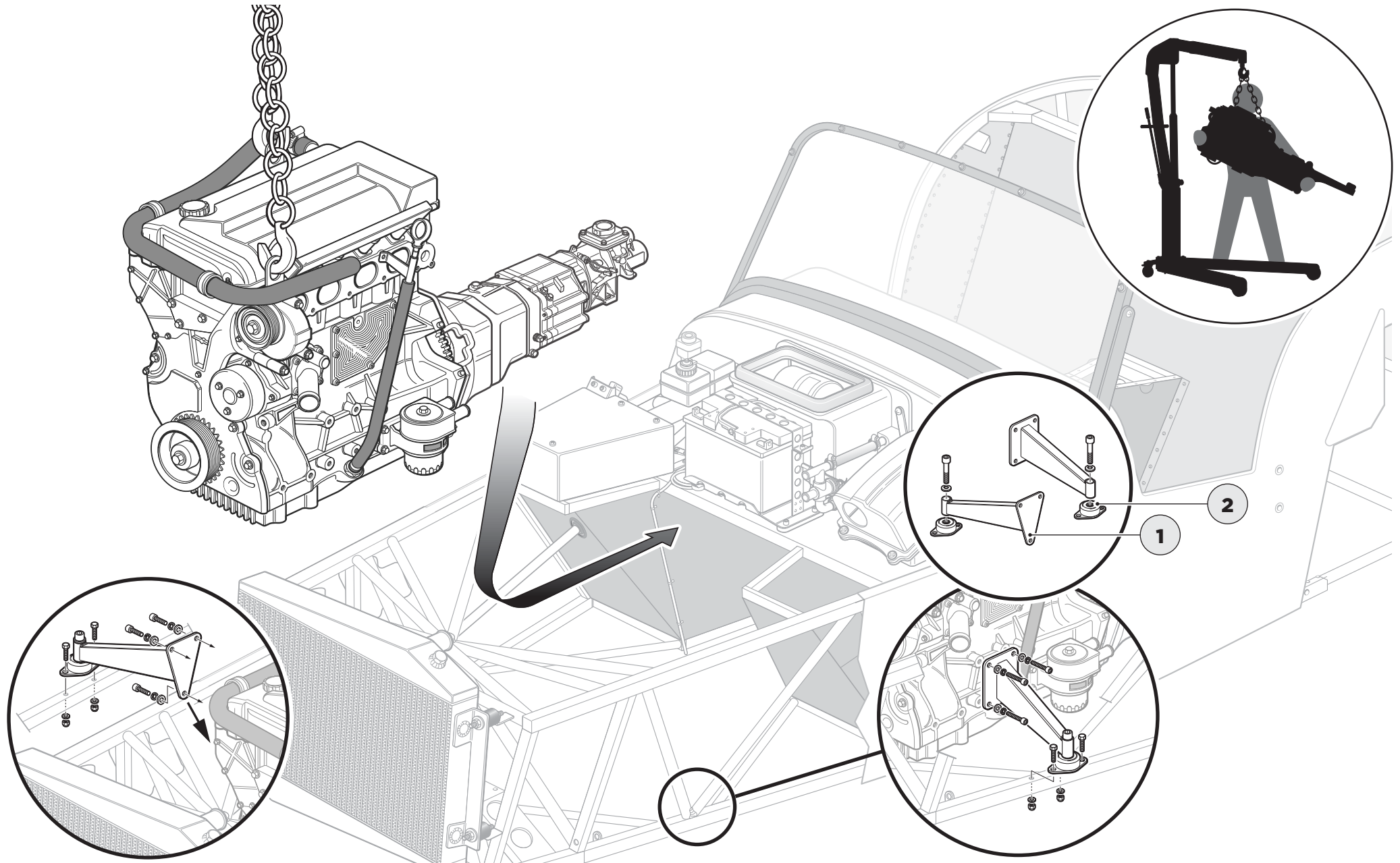
Tighten gradually once all bolts are in.

Chris N

Protect the chassis with soft stuff such as cardboard or a folded towels / blankets.

Harry P

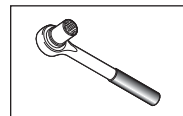
WET / DRY SUMP AT LAST THE ENGINE IS GOING IN



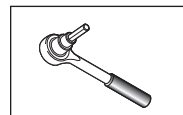
WET / DRY SUMP AND THE GEARBOX IS FIXED IN PLACE

PARTS

TOOLS



13mm
22mm



6mm

FIXINGS

TIPS

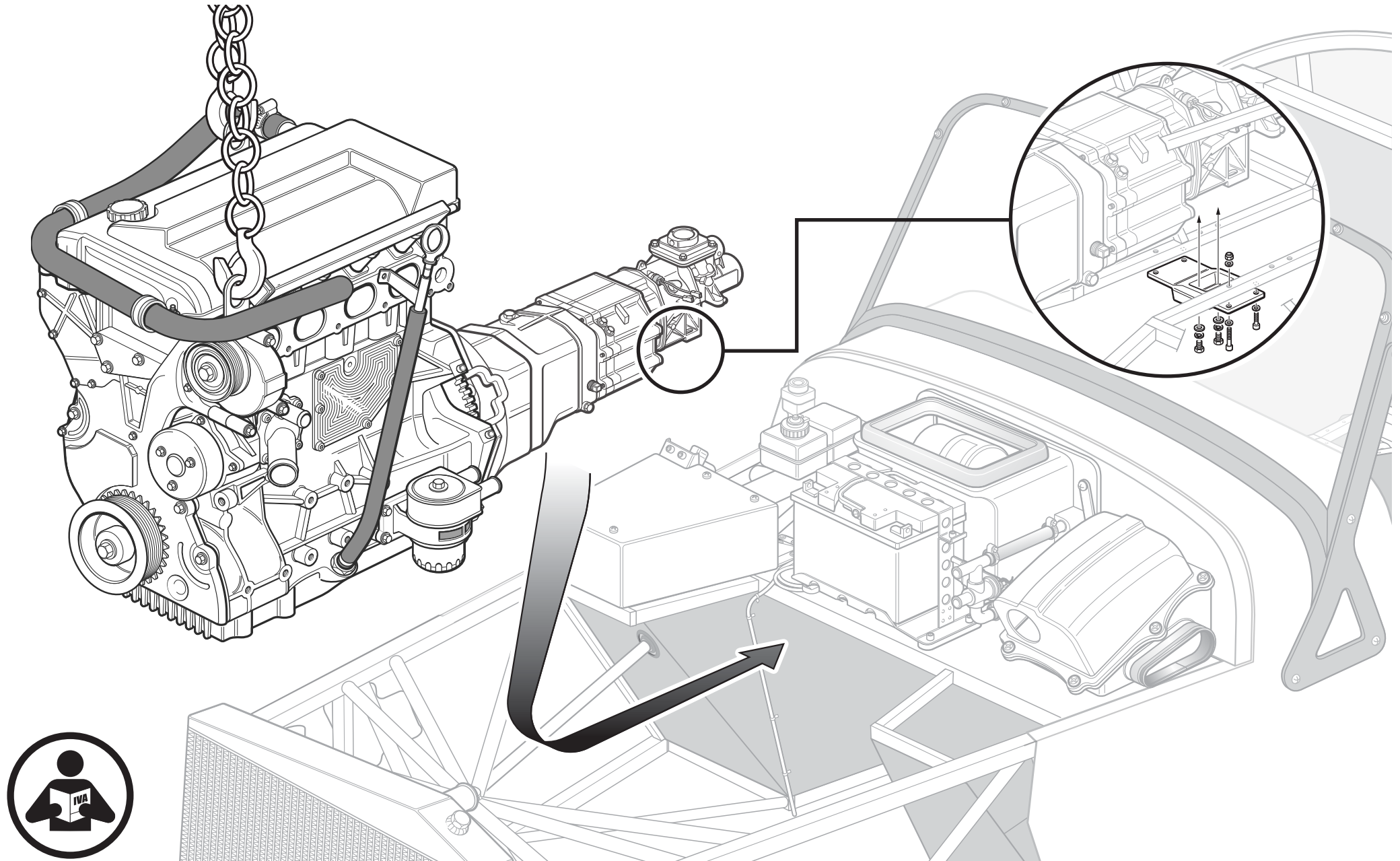
Once the engine is in, the wiring can be connected to the car's loom. It should be self explanatory.

Chris B

See IVA guide – how to secure a loom.

Grant P

WET / DRY SUMP AND THE GEARBOX IS FIXED IN PLACE

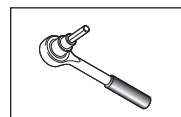


WET / DRY SUMP REFIT ALTERNATOR, BELT & STARTER MOTOR

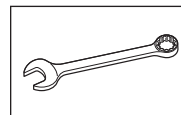
PARTS

- 1** Alternator belt
- 2** Alternator
- 3** Starter motor

TOOLS



8mm



15mm

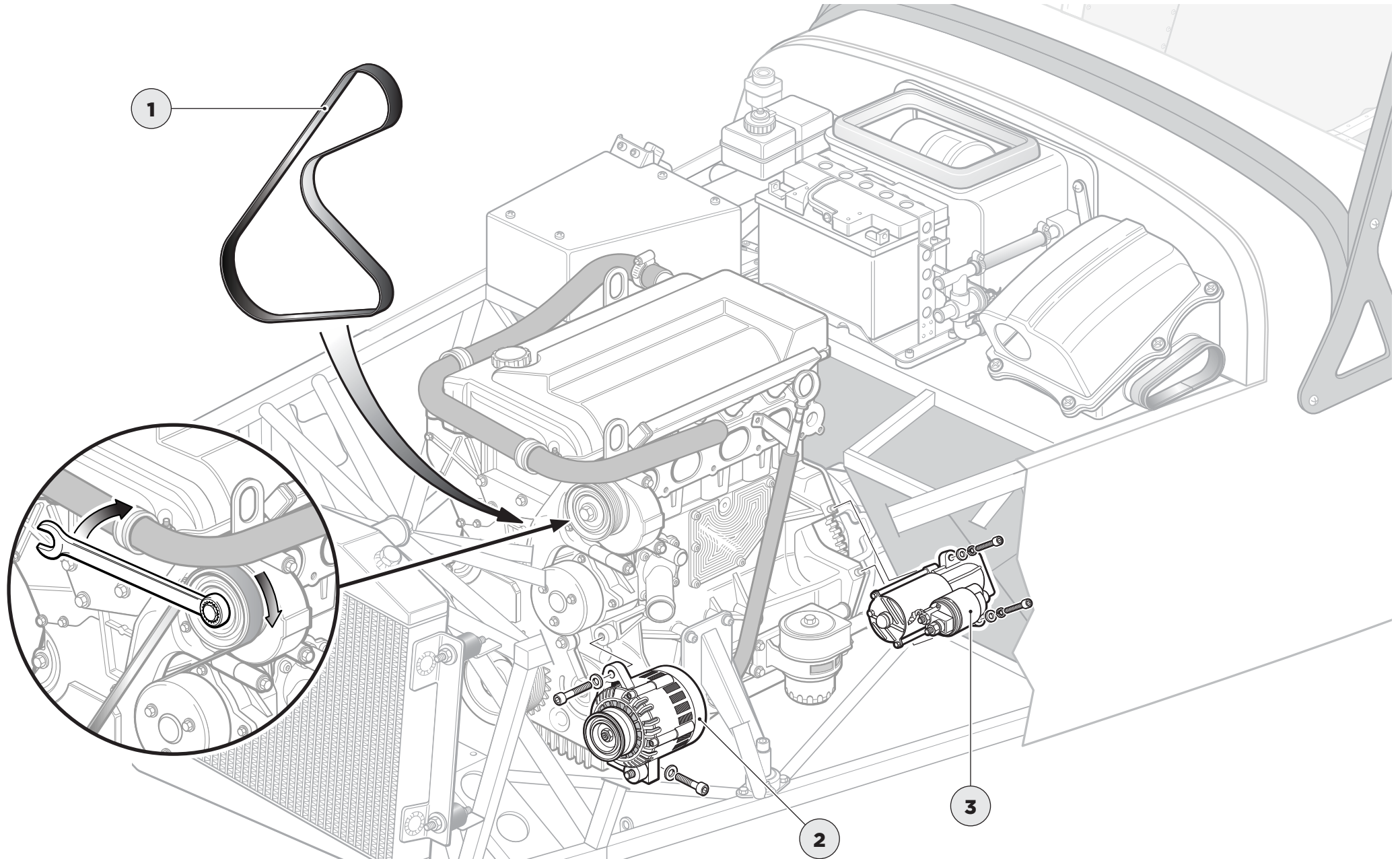
FIXINGS

TIPS

Refit alternator, alternator belt and starter motor.

Lee A

WET / DRY SUMP REFIT ALTERNATOR, BELT & STARTER MOTOR

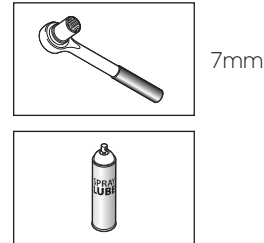


WET SUMP LOWER RADIATOR HOSE

PARTS

- 1 Lower radiator hose

TOOLS



FIXINGS

Pack D		CATERHAM		44	
		PACK NUMBER		SICCATB	
COOLING SIGMA					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Expansion tank bracket to chassis	888440	1		
2	Expansion tank to bracket	888420	4		
3	SM radiator bracket	888420	4		
4	Fan brackets to fan	887102A	4		
5	Fan to radiator mounting - 20 (top)	8884210	4		
6	40 Fan to radiator and CVT radiator bracket	888470	8		
7	Radiator bobbin	888470	8		
8	Expansion tank bracket	887114	1		
9	18 x 50V nut bracket 4 x 4 Fan bungs 1 x Expansion tank bracket	888410	13		
10	Radiator bobbin back	8884710	4		
11	Radiator bobbin front	88847020	4		

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

Pack D		CATERHAM		44	
		PACK NUMBER		SICCATB	
COOLING SIGMA					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
12	Expansion tank bracket	888440	1		
13	8 x Radiator bobbin 1 x Expansion tank	888410	9		
14	2 x 1/2 shape hose to water rail 2 x Top radiator hose 2 x Bottom radiator hose	SOT25-40	6		
15	1 x Engine outlet to top 1 1/2" 1 x Engine outlet to bottom 1 1/2"	SOT23-30	2		
16	1 x Radiator bobbin 1 x Expansion tank 1 x Fan bungs 1 x 1/2" hose	SOT10-20	18		
17	Expansion tank small T piece	SOT18-18	6		
18	Cowling flap	1019-01010	12		

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

x2

TIPS

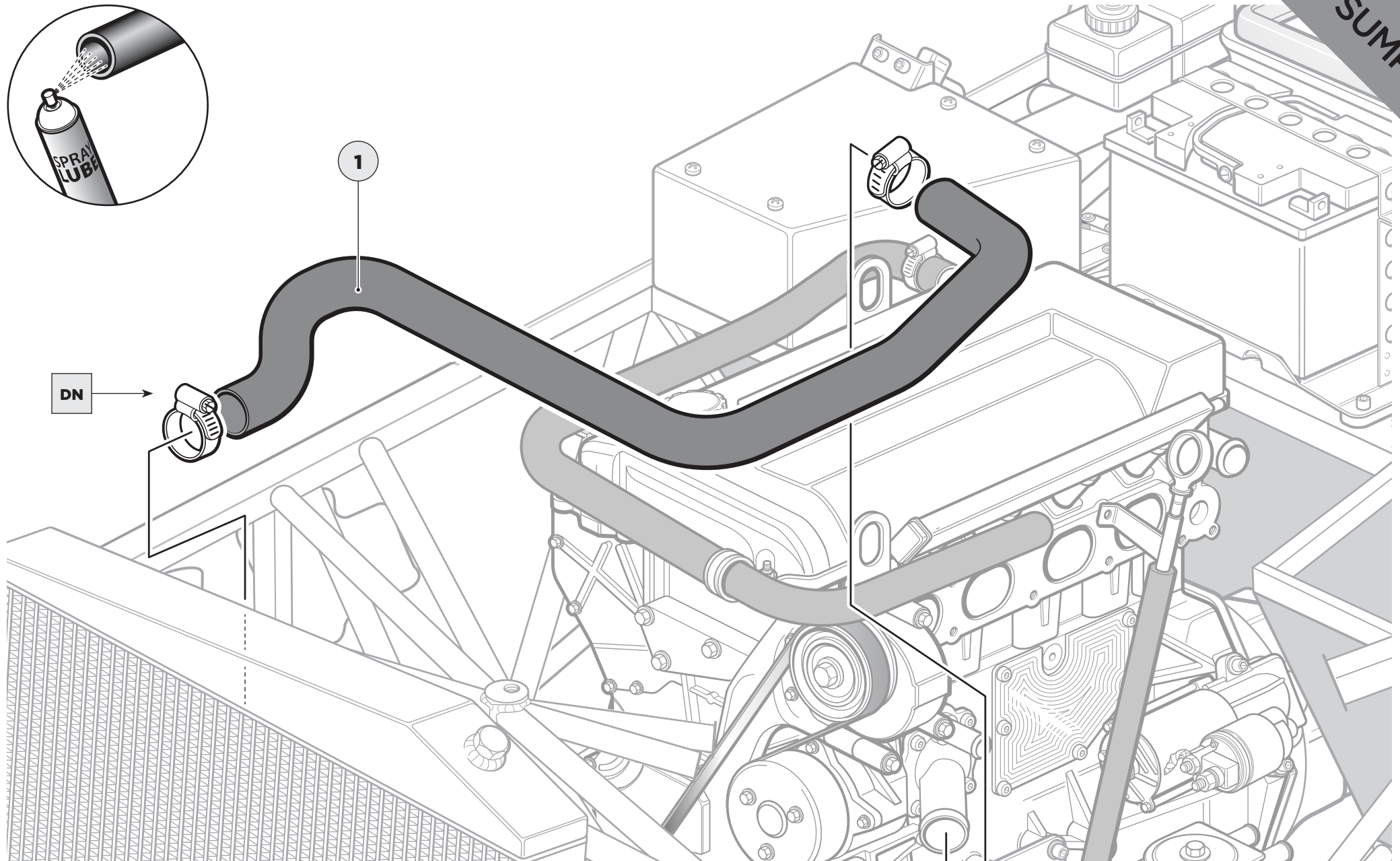
Reminder for later on – nip up once the car has been run.
Mick F

Support hose by cable tying to chassis rails. Make sure they are clear of the steering rack.
Grant P

Fit the hose to the larger outlet on the engine.
Dan D

WET SUMP LOWER RADIATOR HOSE

WET SUMP

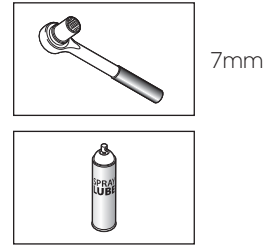


WET SUMP UPPER RADIATOR HOSE

PARTS

- 1 Upper radiator hose

TOOLS



FIXINGS

Pack D		CATERHAM		44	
		PACK NUMBER		3002478	
COOLING SIGMA					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Ball Mt 2 20 Hose Mt	888440	1	Expansion tank bracket to chassis	
2	Ball Mount 1 1/2 x 3/4"	88714424	1	Expansion tank to bracket	
3	Ball Mount 1/2 Hose Mt	888420	4	SM radiator bracket	
4	Ball Mt 1/2 18 mm Square neck	88710724	4	Fan brackets to fan	
5	Ball Mount 1/2 Fan Mount	88844110	4	Fan to radiator bracket - 20 1/2"	
6	Ball Mt 1/2 Hose Mt	888170	8	1/4 Fan to radiator to SM radiator bracket	
7	Ball Mt 1/2 Hose Mt	888170	8	Radiator bobbin	
8	Ball Mt 1/2 Hose Mt	88710714	1	Expansion tank bracket	
9	Ball Mount 1/2 Hose Mt	888110	13	1/4 x 1/4 Fan bracket 1/4 Fan bracket 1/4 Expansion tank bracket	
10	Ball Mount 1/2 Hose Mt	888110	4	Radiator bobbin back	
11	Ball Mount 1/2 Hose Mt	888110	4	Radiator bobbin front	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

Pack D		CATERHAM		44	
		PACK NUMBER		3002478	
COOLING SIGMA					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
12	Ball Mount 1/2 Hose Mt	888110	1	Expansion tank bracket	
13	Ball Mount 1/2 Hose Mt	888110	8	1/4 Radiator bobbin 1 x Expansion tank	
14	Hose Clip 20 1/2"	50725-40	6	12 x 1/4 shape hose to upper rail 2 x Top radiator hose 2 x Bottom radiator hose	
15	Hose Clip 20 1/2"	50723-30	2	1 x Engine outlet to top 1/2 hose 1 x Engine outlet to middle hose	
16	Hose Clip 17 1/2"	50710-20	18	1 x Radiator bobbin 1 x Expansion tank 1 x Fan hose 1 x Fan hose	
17	Hose Clip 16 1/2"	50709-16	6	Expansion tank small 1/2 piece	
18	Ball - Black 1/2 x 1/4"	1070-01010	12	Coupling cap	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

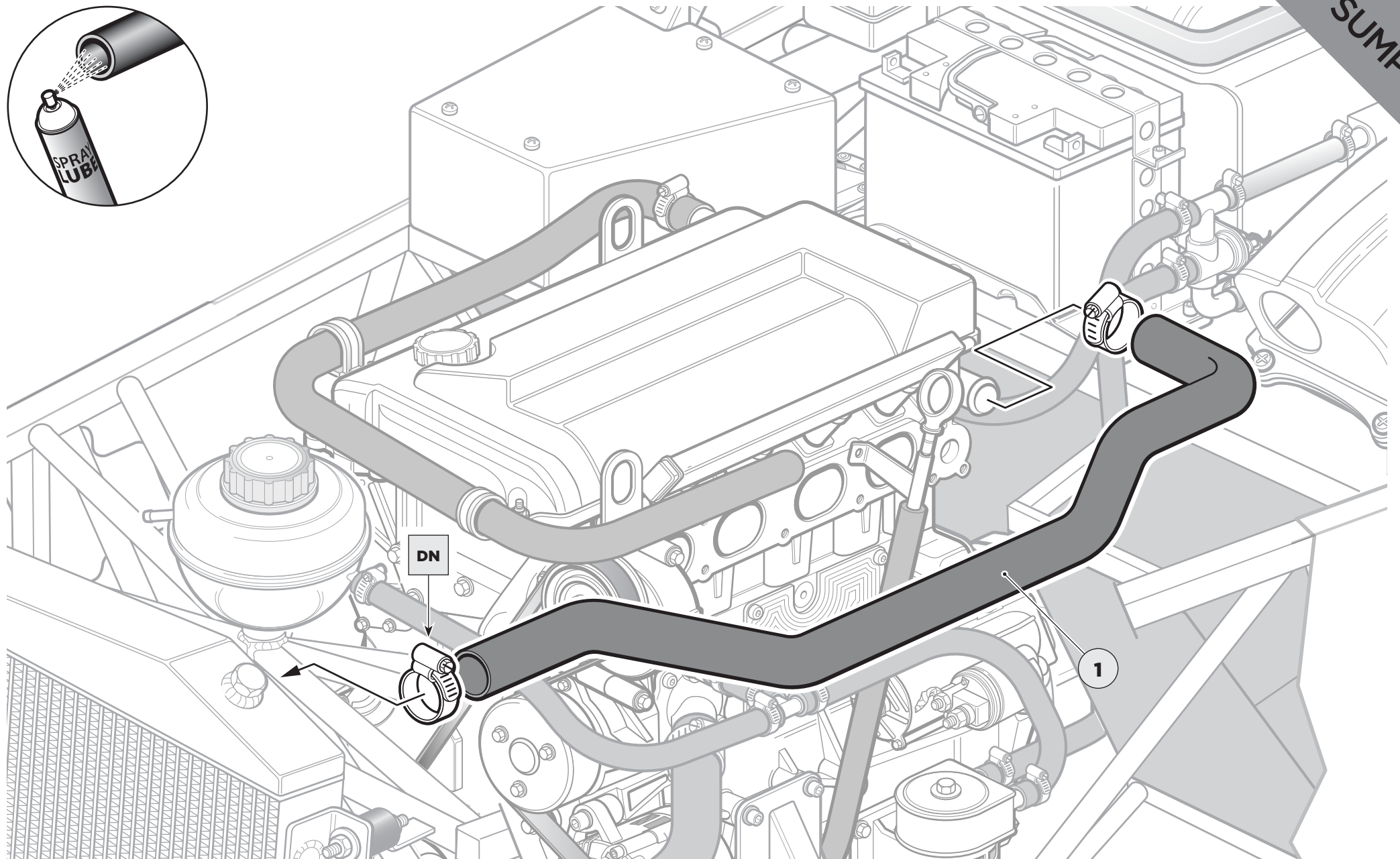
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TIPS

Reminder for later on – nip up once the car has been run.
Mick F

WET SUMP UPPER RADIATOR HOSE

WET SUMP

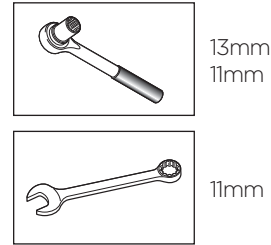


WET SUMP EXPANSION BOTTLE

PARTS

- 1 Expansion bottle
- 2 Expansion bottle cap
- 3 Expansion bottle bracket

TOOLS



FIXINGS

Pack D		CATERHAM		44	
		PACK NUMBER		3002478	
COOLING SIGMA					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	DA Bolt M6 x 20 Coarse thread	BMB030	1	Expansion tank bracket to chassis	
2	DB Self-cw. 1/4" x 3/4"	SF14234	1	Expansion tank to bracket	
3	DC Self-cw. M6 x 20 Coarse thread	BMB020	4	SV radiator bracket	
4	DD Bolt M6 x 16 with square neck	SD12024	4	Fan brackets to fan	
5	DE Self-cw. M6 x 20 Fine thread	SF06010	4	Fan to radiator cooling - SV only	
6	DF Hex. Nut M6	M0006	8	4 x Fan to radiator 4 x SV radiator bracket	
7	DG Plain Nut M6	N0006	8	Radiator bobbin	
8	DH Metric Nut 1/4"	NF0114	1	Expansion tank bracket	
9	DI Plain Washer 1/4" Heavy duty	WF0114	13	8 x SV rad bracket 4 x Fan Brings 1 x Expansion tank bracket	
10	DJ Plain Washer 1/4" Heavy duty	WF0114	4	Radiator bobbin back	
11	DK Plain Washer 1/4" Heavy duty	SF021102	4	Radiator bobbin back	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

x1

x1

x1

x1

Pack D		CATERHAM		44	
		PACK NUMBER		3002478	
COOLING SIGMA					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
12	DL Plain Washer 1/4" x 3/4" Heavy duty	WF01020	1	Expansion tank bracket	
13	DM Spring Washer 5/16" Heavy duty	WSP0111	9	8 x Radiator bobbin 1 x Expansion tank	
14	DN Hex. Cap 1/4" Coarse	SC0720-40	6	2 x 4 Wheel Hanger 2 x 4 Wheel Hanger 2 x Radiator bobbin	
15	DO Hex. Cap 1/4" Coarse	SC0720-30	2	1 x Engine outlet to top 1 x Engine outlet to bottom	
16	DP Hex. Cap 1/4" Coarse	SC0710-20	18	6 Wheel Hanger 6 Wheel Hanger 6 Wheel Hanger 6 Wheel Hanger	
17	EO Hex. Cap 1/4" Coarse	SC0700-10	6	Expansion tank small E-piece	
18	ER Bolt - Black 1/2" x 3/4"	SB09-01010	12	Cooling fan	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

x1

x1

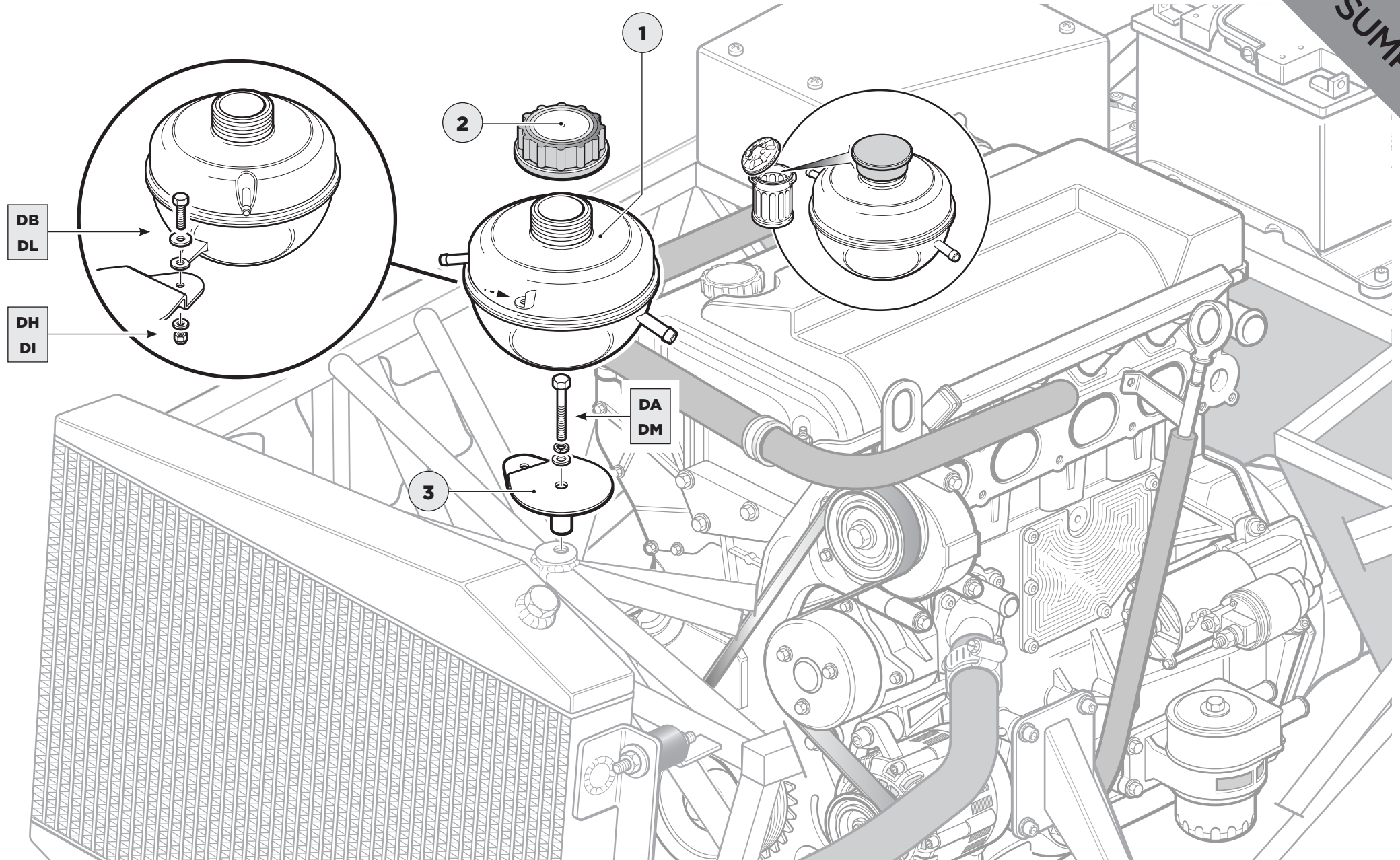
TIPS

Throw away the red cap that came on the expansion bottle.

Lloyd D

WET SUMP EXPANSION BOTTLE

WET SUMP

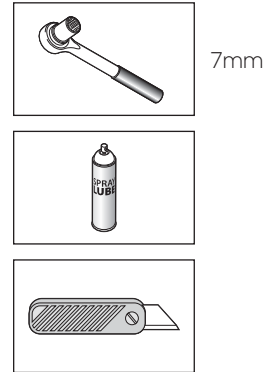


WET SUMP HOSES

PARTS

- 1** T-piece
- 2** Hose roll
- 3** Reducer hose

TOOLS



FIXINGS

Pack D		CATERHAM		44	
		PACK NUMBER		SECURITY	
COOLING SIGMA					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Ball Nut 2.25 Hex 2.8	888440	1	Expansion tank bracket to chassis	
2	Ball Nut 2.25 Hex 2.8	888440	1	Expansion tank to bracket	
3	Ball Nut 2.25 Hex 2.8	888440	4	SM radiator bracket	
4	Ball Nut 2.25 Hex 2.8	888440	4	Fan brackets to fan	
5	Ball Nut 2.25 Hex 2.8	888440	4	Fan to radiator	
6	Ball Nut 2.25 Hex 2.8	888440	8	Ball Nut to radiator	
7	Ball Nut 2.25 Hex 2.8	888440	8	Radiator bobbin	
8	Ball Nut 2.25 Hex 2.8	888440	1	Expansion tank bracket	
9	Ball Nut 2.25 Hex 2.8	888440	13	Ball Nut to radiator	
10	Ball Nut 2.25 Hex 2.8	888440	4	Radiator bobbin back	
11	Ball Nut 2.25 Hex 2.8	888440	4	Radiator bobbin front	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

Pack D		CATERHAM		44	
		PACK NUMBER		SECURITY	
COOLING SIGMA					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
12	Expansion tank bracket	888440	1	Expansion tank bracket	
13	Expansion tank bracket	888440	1	Expansion tank bracket	
14	Expansion tank bracket	888440	1	Expansion tank bracket	
15	Expansion tank bracket	888440	1	Expansion tank bracket	
16	Expansion tank bracket	888440	1	Expansion tank bracket	
17	Expansion tank bracket	888440	1	Expansion tank bracket	
18	Expansion tank bracket	888440	1	Expansion tank bracket	
19	Expansion tank bracket	888440	1	Expansion tank bracket	
20	Expansion tank bracket	888440	1	Expansion tank bracket	
21	Expansion tank bracket	888440	1	Expansion tank bracket	
22	Expansion tank bracket	888440	1	Expansion tank bracket	
23	Expansion tank bracket	888440	1	Expansion tank bracket	
24	Expansion tank bracket	888440	1	Expansion tank bracket	
25	Expansion tank bracket	888440	1	Expansion tank bracket	
26	Expansion tank bracket	888440	1	Expansion tank bracket	
27	Expansion tank bracket	888440	1	Expansion tank bracket	
28	Expansion tank bracket	888440	1	Expansion tank bracket	
29	Expansion tank bracket	888440	1	Expansion tank bracket	
30	Expansion tank bracket	888440	1	Expansion tank bracket	
31	Expansion tank bracket	888440	1	Expansion tank bracket	
32	Expansion tank bracket	888440	1	Expansion tank bracket	
33	Expansion tank bracket	888440	1	Expansion tank bracket	
34	Expansion tank bracket	888440	1	Expansion tank bracket	
35	Expansion tank bracket	888440	1	Expansion tank bracket	
36	Expansion tank bracket	888440	1	Expansion tank bracket	
37	Expansion tank bracket	888440	1	Expansion tank bracket	
38	Expansion tank bracket	888440	1	Expansion tank bracket	
39	Expansion tank bracket	888440	1	Expansion tank bracket	
40	Expansion tank bracket	888440	1	Expansion tank bracket	
41	Expansion tank bracket	888440	1	Expansion tank bracket	
42	Expansion tank bracket	888440	1	Expansion tank bracket	
43	Expansion tank bracket	888440	1	Expansion tank bracket	
44	Expansion tank bracket	888440	1	Expansion tank bracket	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

x1
x7

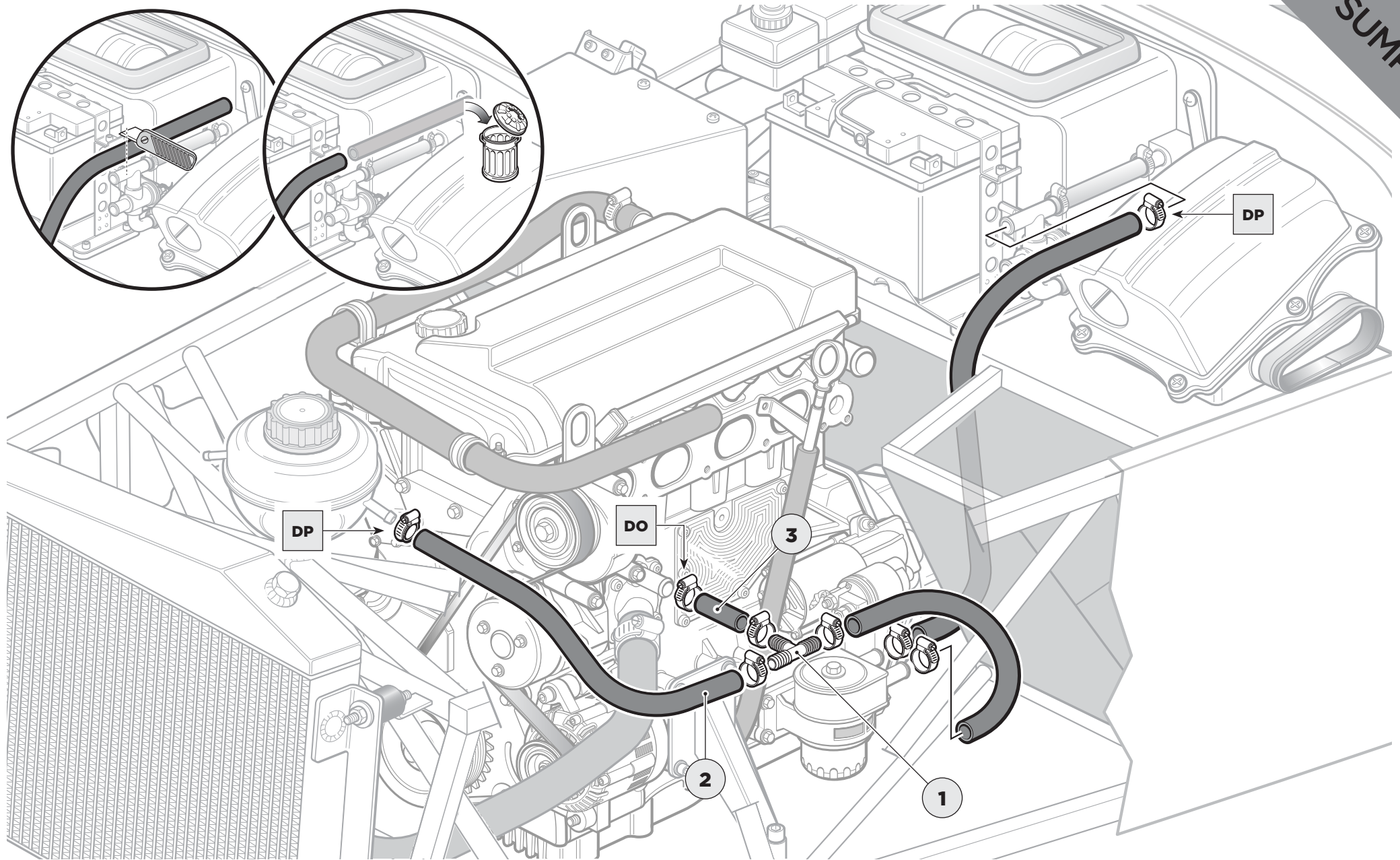
TIPS

You will need to cut hoses to size.
John S

The hose that comes from the engine reduces in diameter to the T-piece.
Chris N

WET SUMP HOSES

WET SUMP

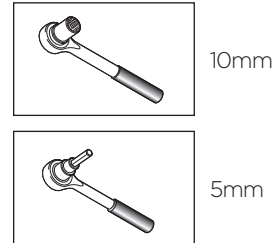


DRY SUMP FIXING THE TANK

PARTS

- 1 Dry sump tank
- 2 Temperature sender
- 3 P-clips

TOOLS



FIXINGS

Unmarked bag:

- M8 x 20 caphead
- M8 spring and plain head washer
- M6 x 20 bolts (x2)
- M6 Nyloc (x2)
- 1/4" washers (x2)

TIPS

The M8 caphead fits the tab on the tank to the chassis.

John K

The bottom P-clips fix on to the lower chassis rails.

Grant P

The tab on the tank may need to be spaced out. Use M8 washers.

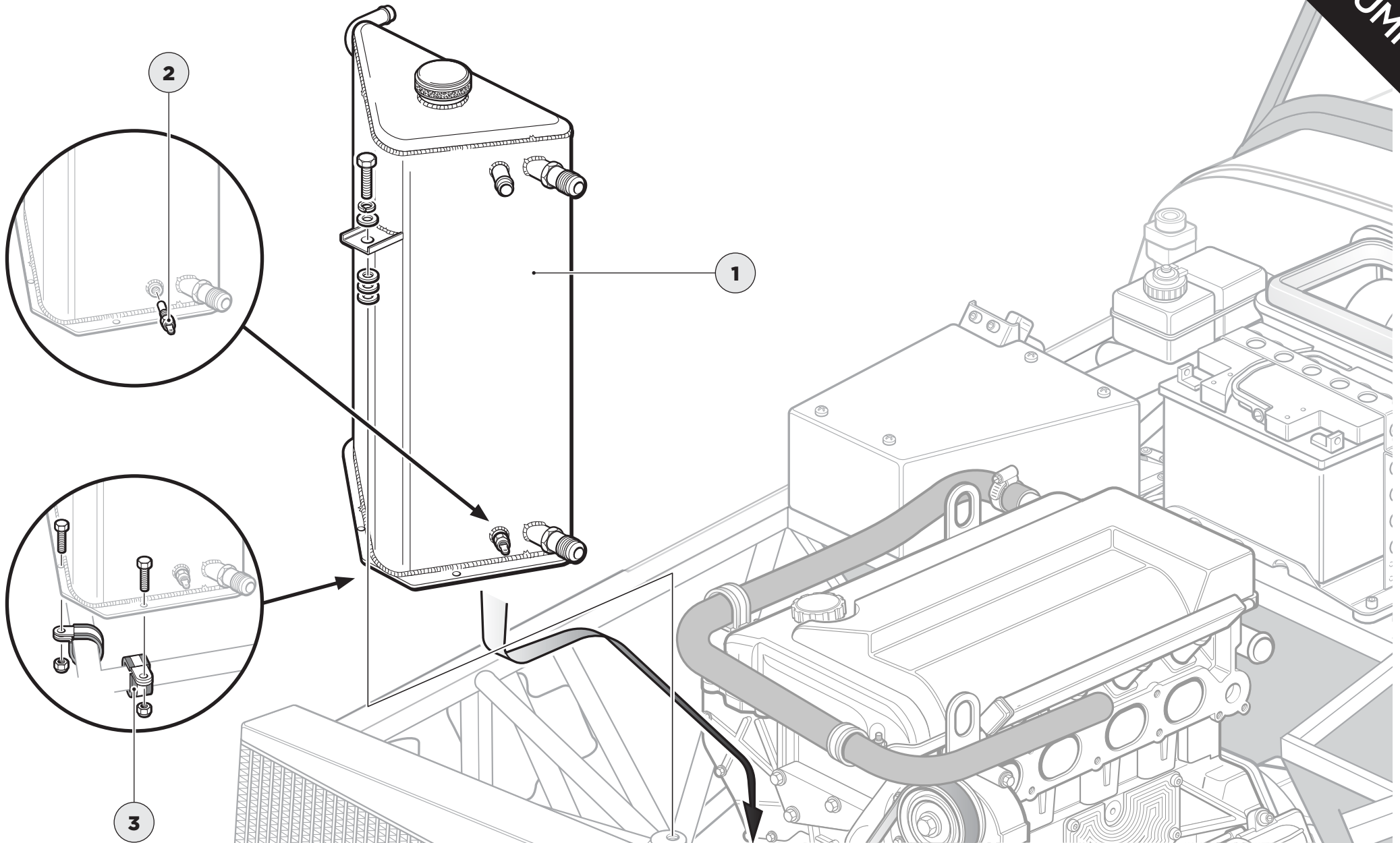
Jamie A

Put PTFE tape in the temperature sensor.

Chris N

DRY SUMP FIXING THE TANK

DRY SUMP

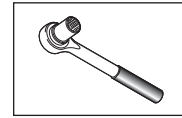


DRY SUMP FITTING THE EXPANSION BOTTLE

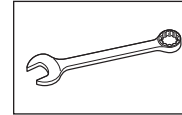
PARTS

- 1 Expansion bottle
- 2 Expansion bottle cap
- 3 Expansion bottle bracket
- 4 Expansion bottle plate

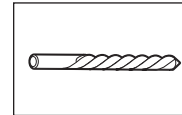
TOOLS



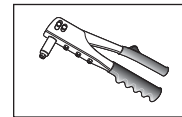
13mm
11mm



11mm



5/32



FIXINGS

Pack D		CATERHAM		44	
		PACK NUMBER		SICCATB	
COOLING SIGMA					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Bolt M6 x 20 Coarse thread	BMS030	1	Expansion tank bracket to chassis	
2	Self-cw. 1/4" x 3/4"	SF14234	1	Expansion tank to bracket	
3	Expansion bracket	BMS020	4	3V radiator bracket	
4	Bolt M6 x 16 with square neck	SF12024	4	Fan brackets to fan	
5	Expansion bracket	SFMS010	4	Fan to radiator cooling - 3D 100g	
6	Expansion bracket	MSP070	8	4x Fan to radiator 4x 3V radiator bracket	
7	Plain Nut M6	MSP070	8	Radiator bobbin	
8	Hex Nut 1/4"	WYV114	1	Expansion tank bracket	
9	Plain Washer 1/4" Heavy duty	WPH114	13	8 x 3V rad bracket 4 x Fan bearings 1 x Expansion tank bracket	
10	Plain Washer 1/4" Heavy duty	WPH114	4	Radiator bobbin back	
11	Plain Washer 1/4" Heavy duty	SFMS11020	4	Radiator bobbin front	

x1

x1

x1

x1

Pack D		CATERHAM		44	
		PACK NUMBER		SICCATB	
COOLING SIGMA					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
12	Plain Washer 1/4" x 3/4" Heavy duty	WPH14234	1	Expansion tank bracket	
13	Spring Washer 3/16" Heavy duty	WSP0117	9	8 x Radiator bobbin 1 x Expansion tank	
14	Wash Clip 1/4" Heavy duty	SF17040	6	2 x 3V rad bracket 2 x 4x Fan radiator cap 2 x Radiator bobbin front	
15	Wash Clip 3/16" Heavy duty	SF17030	2	1 x Engine outlet to top 1 engine 1 x Engine outlet to bottom 1 engine	
16	Wash Clip 1/4" Heavy duty	SF17020	18	8 Radiator bobbin 10 Fan Springs 2 Expansion tank 2 Fan bearings 2 3V rad Springs	
17	Wash Clip 3/16" Heavy duty	SF17010	6	Expansion tank small 1 piece	
18	Wash - Black 1/2" x 3/4" x 1/4"	W10-01015	12	Cowling flap	

x1

x1

x4

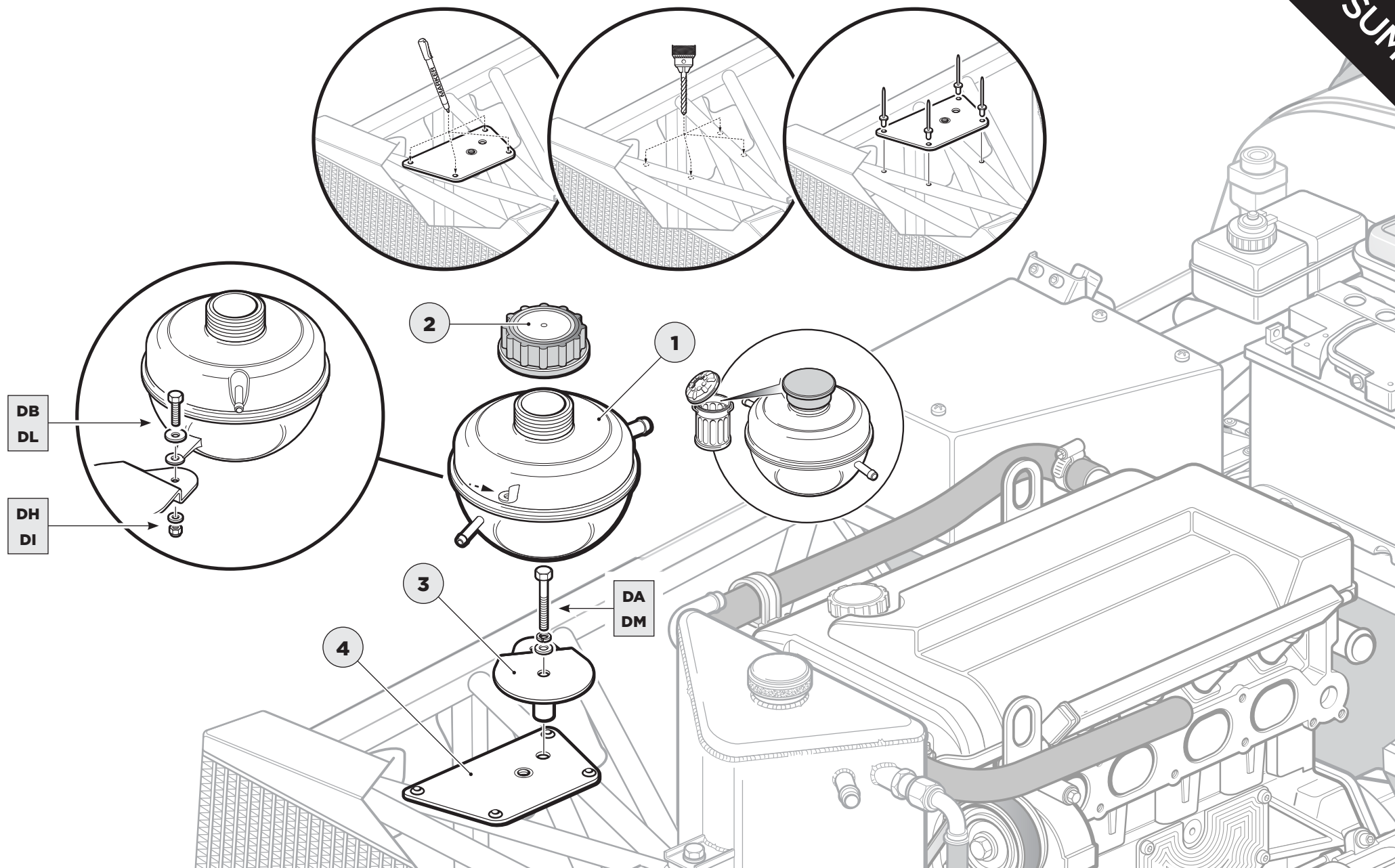
TIPS

Lay the plate over the top of the chassis until the hole sits in the middle of the tube; mark and drill.
Vincent M

Throw away the red cap that came on the expansion bottle.
Lloyd D

DRY SUMP FITTING THE EXPANSION BOTTLE

DRY SUMP

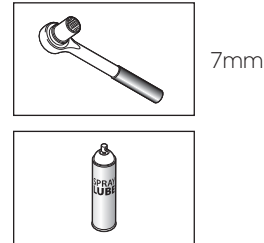


DRY SUMP LOWER RADIATOR HOSE

PARTS

- 1 Lower radiator hose

TOOLS



FIXINGS

Pack D		CATERHAM		44		
ITEM		BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	DA	Rail Kit 2.0 (Lower Rail)	888440	1	Expansion tank bracket to chassis	
2	DB	Expansion Tank 3.0"	887142/4	1	Expansion tank to bracket	
3	DC	Subframe BR200 (Lower Rail)	888420	4	SM radiator bracket	
4	DD	Rail Kit 2.0 with Square Section	887102/4	4	Fan brackets to fan	
5	DE	Subframe BR200 (Frontal Rail)	888440/10	4	Fan to radiator mounting - 20" long	
6	DF	Plan Nut M8	888770	8	4x Fan to radiator and 4x radiator bracket	
7	DG	Plan Nut M8	888770	8	Radiator bobbin	
8	DH	Plan Nut M8	887114	1	Expansion tank bracket	
9	DI	Plan Washer 10 (Hex Head)	888414	13	10 x 10V fan bracket 4 x 4 Fan Brackets 1 x Expansion tank bracket	
10	DJ	Plan Washer 10 (Hex Head)	888414	4	Radiator bobbin back	
11	DK	Plan Washer 10 (Hex Head)	888414/10	4	Radiator bobbin front	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

Pack D		CATERHAM		44		
ITEM		BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
12	EL	Plan Washer 10 (Hex Head)	888414/10	1	Expansion tank bracket	
13	EM	Spring Washer 10 (Hex Head)	888410/10	8	8 x Radiator bobbin 1 x Expansion tank	
14	DN	Hose Clip 20 - 40mm	SOT25-40	6	2 x U shape hose to under rail 2 x Fan radiator hose 2 x Bottom radiator hose	
15	DO	Hose Clip 20 - 25mm	SOT23-20	2	1 x Engine outlet to top 1 engine 1 x Engine outlet to lower 1 engine	
16	DP	Hose Clip 17 - 20mm	SOT16-20	18	6 x Radiator bobbin 1 x Expansion tank 4 x Fan 1 x Dry Sump	
17	DD	Hose Clip 8 - 10mm	SOT8-10	6	Expansion tank small T piece	
18	DR	Plan - Blank 10 (Hex Head)	8870-01010	12	Coupling cap	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

x2

TIPS

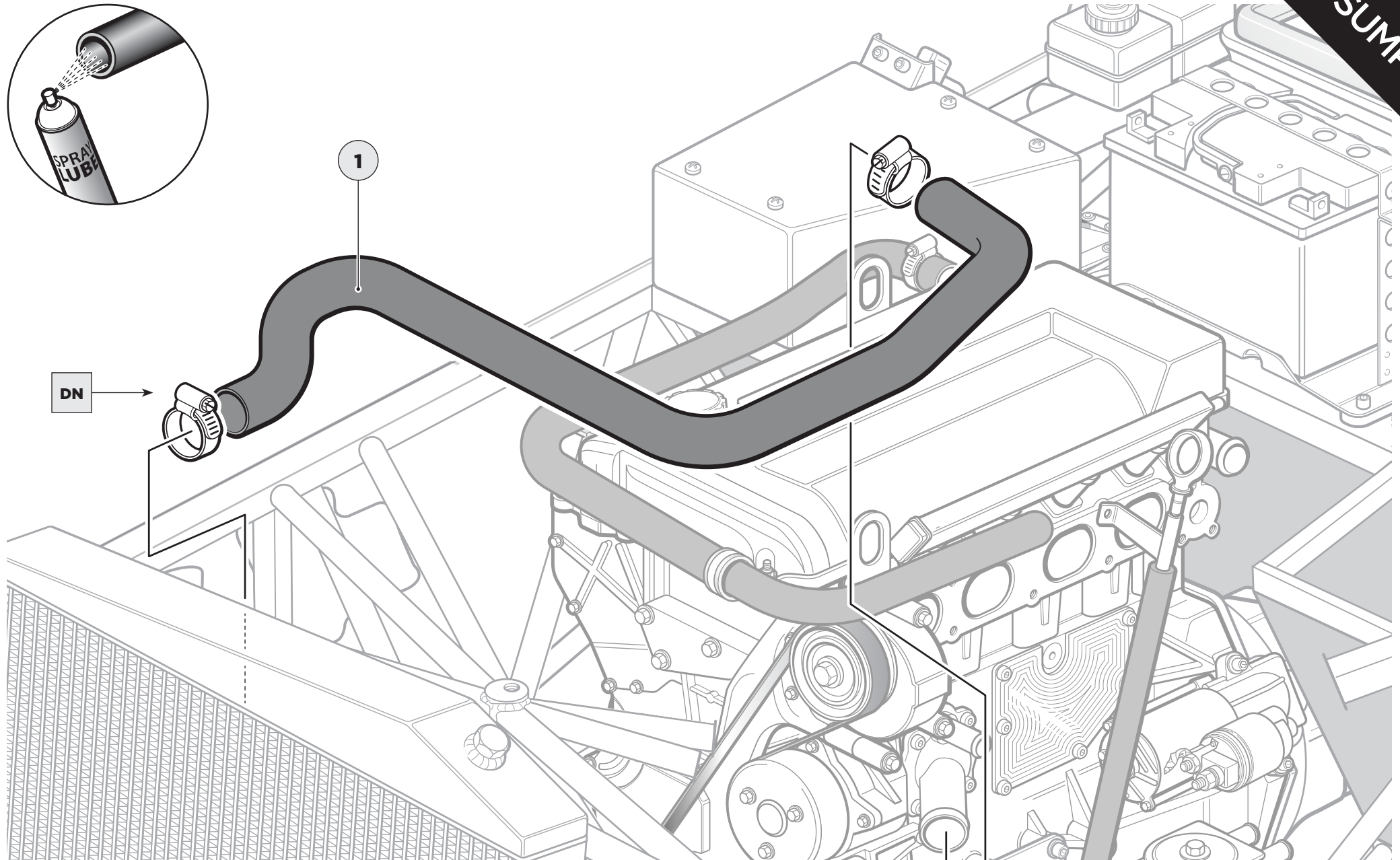
Reminder for later on – nip up once the car has been run.
Mick F

Support hose by cable tying to chassis rails. Make sure they are clear of the steering rack.
Grant P

Fit the hose to the larger outlet on the engine.
Dan D

DRY SUMP LOWER RADIATOR HOSE

DRY SUMP

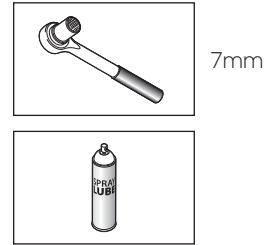


DRY SUMP UPPER RADIATOR HOSE

PARTS

- 1 Upper radiator hose

TOOLS



FIXINGS

Pack D		CATERHAM		44	
		PACK NUMBER		3002478	
COOLING SIGMA					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	DN Rail Kit 2.0 2.0 2.0	888440	1	Expansion tank bracket to chassis	
2	DB Rail Kit 2.0 2.0 2.0	888440	1	Expansion tank to bracket	
3	DC Rail Kit 2.0 2.0 2.0	888440	4	SM radiator bracket	
4	DD Rail Kit 2.0 2.0 2.0	888440	4	Fan brackets to fan	
5	DE Rail Kit 2.0 2.0 2.0	888440	4	Fan to radiator mounting - 20 100g	
6	DF Rail Kit 2.0 2.0 2.0	888440	8	40 Fan to radiator 40 100g radiator bracket	
7	DG Rail Kit 2.0 2.0 2.0	888440	8	Radiator bobbin	
8	DH Rail Kit 2.0 2.0 2.0	888440	1	Expansion tank bracket	
9	DI Rail Kit 2.0 2.0 2.0	888440	13	18 x 100 Fan bracket 18 x 100 Fan bracket 18 x 100 Fan bracket	
10	DJ Rail Kit 2.0 2.0 2.0	888440	4	Radiator bobbin back	
11	DK Rail Kit 2.0 2.0 2.0	888440	4	Radiator bobbin front	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

Pack D		CATERHAM		44	
		PACK NUMBER		3002478	
COOLING SIGMA					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
12	DL Rail Kit 2.0 2.0 2.0	888440	1	Expansion tank bracket	
13	DM Rail Kit 2.0 2.0 2.0	888440	8	8 x Radiator bobbin 1 x Expansion tank	
14	DN Hose Clip 20 100g	50725-40	6	12 x 18 shape hose to water rail 12 x 18 radiator hose 2 x 8 bottom radiator hose	
15	DD Hose Clip 20 100g	50723-30	2	1 x Engine outlet to top 1 100g 1 x Engine outlet to bottom 100g	
16	DE Hose Clip 17 100g	50719-25	18	18 x 100 Fan bracket 18 x 100 Fan bracket 18 x 100 Fan bracket	
17	DD Hose Clip 8 100g	50719-16	6	Expansion tank small 1 piece	
18	DR Rail - Black 17 100g	1076-01015	12	Coupling cap	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

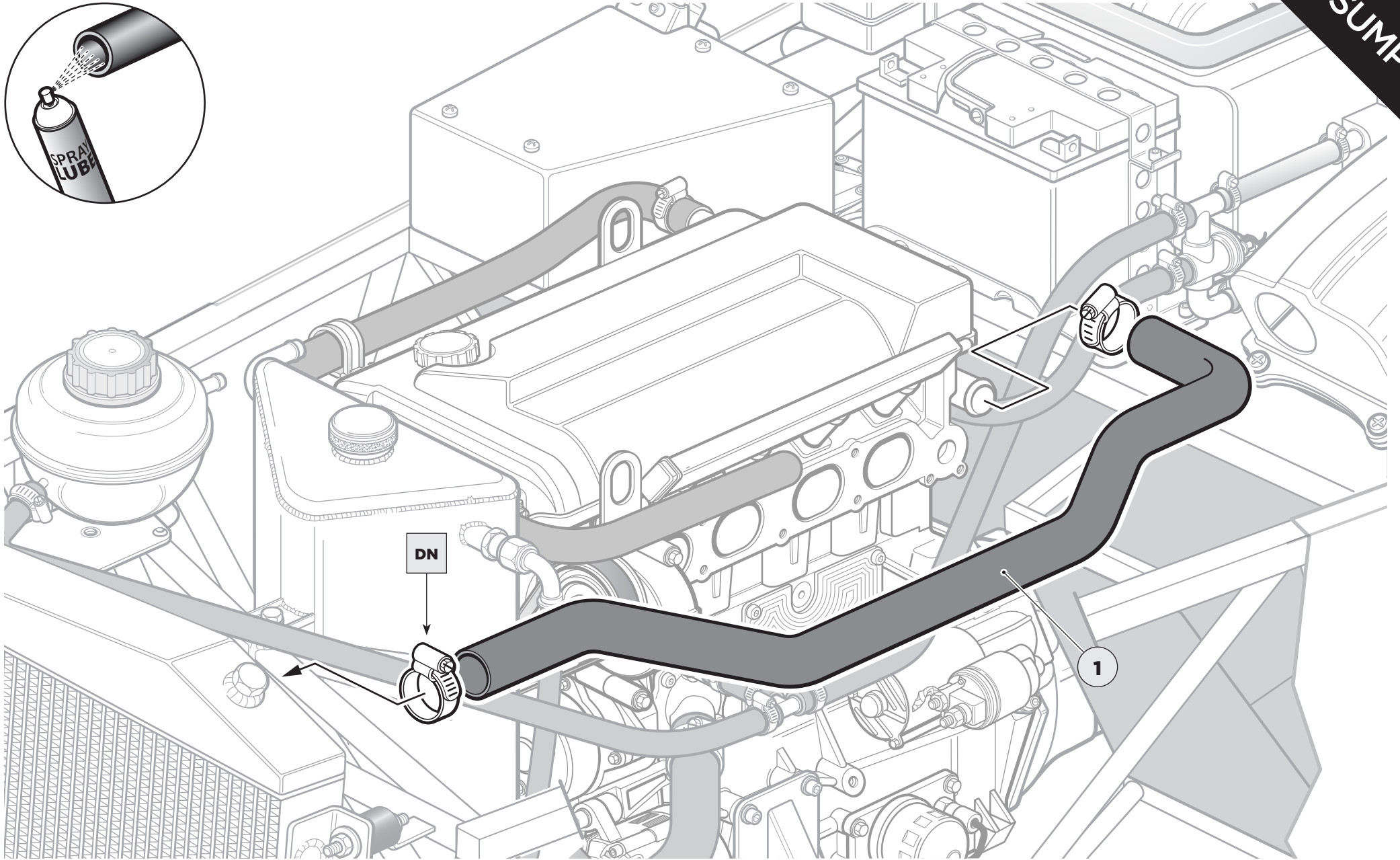
x2

TIPS

Reminder for later on – nip up once the car has been run.
Mick F

DRY SUMP UPPER RADIATOR HOSE

DRY SUMP

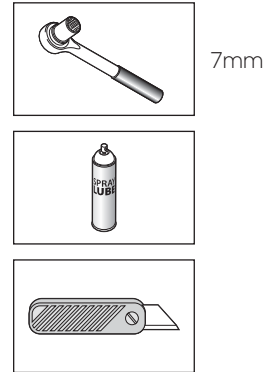


DRY SUMP HOSES

PARTS

- 1 T-piece
- 2 Hose roll
- 3 Reducer hose

TOOLS



FIXINGS

Pack D		CATERHAM		44	
		PACK NUMBER		SECURITY	
COOLING SIGMA					
<i>This pack may include extra fasteners to cover different options</i>					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Roll Mat 2.25" (57mm) x 2.5"	888440	1	Expansion tank bracket to chassis	
2	Roll Mat 2.5" x 3"	888441	1	Expansion tank to bracket	
3	Roll Mat 2.5" x 3"	888442	4	SM radiator bracket	
4	Roll Mat 2" x 18 mm Square Section	887102A	4	Fan brackets to fan	
5	Roll Mat 2.5" x 3"	888443	4	Fan to radiator bracket	
6	Roll Mat 2.5" x 3"	888444	5	4th Fan to radiator and SM radiator bracket	
7	Roll Mat 2.5" x 3"	888445	8	Radiator bobbin	
8	Roll Mat 2.5" x 3"	887103	1	Expansion tank bracket	
9	Roll Mat 2.5" x 3"	888446	13	18 x 50V Fan Bracket 4 x 2 Fan Brackets 1 x Expansion tank bracket	
10	Roll Mat 2.5" x 3"	888447	4	Radiator bobbin back	
11	Roll Mat 2.5" x 3"	888448	4	Radiator bobbin front	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

Pack D		CATERHAM		44	
		PACK NUMBER		SECURITY	
COOLING SIGMA					
<i>This pack may include extra fasteners to cover different options</i>					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
12	Roll Mat 2.5" x 3"	888449	1	Expansion tank bracket	
13	Roll Mat 2.5" x 3"	888450	5	8 x Radiator bobbin 1 x Expansion tank	
14	Roll Mat 2.5" x 3"	887104	6	2 x 18 x 50V Fan Bracket 2 x Expansion tank 2 x Expansion tank	
15	Hose Clip 22 - 35mm	80723-26	2	1 x Engine outlet to big T-piece 1 x Engine outlet to radiator inlet	
16	Hose Clip 17 - 25mm	80716-25	18	8 x Radiator bobbin 1 x Expansion tank 1 x Dip Sump 1 x Radiator	
17	Hose Clip 17 - 25mm	80716-25	5	Expansion tank small T-piece	
18	Roll - Black 12.5" x 12.5"	1076-0101	12	Covering cap	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

x1
x7

TIPS

You will need to cut hoses to size.

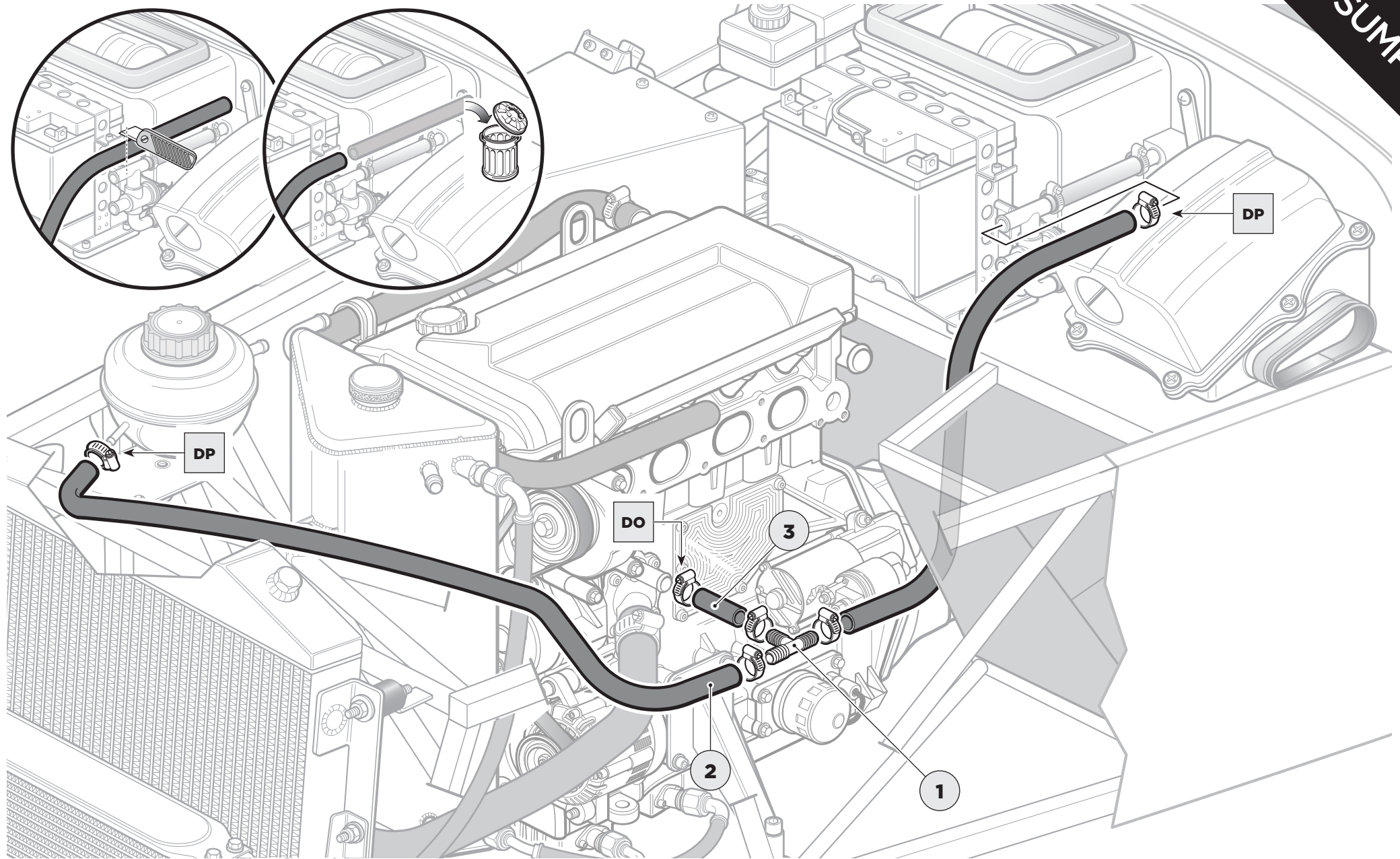
John S

The hose that comes from the engine reduces in diameter to the T-piece.

Chris N

DRY SUMP HOSES

DRY SUMP

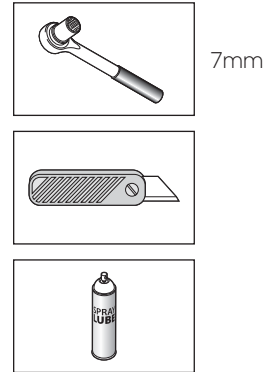


DRY SUMP CATCH TANK

PARTS

- 1 Silicone hose 90°

TOOLS



FIXINGS

Pack D		CATERHAM		44	
		PACK NUMBER		QUANTITY	
COOLING SIGMA					
<i>This pack may include extra fasteners to cover different options</i>					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Expansion tank bracket	888440	1	Expansion tank	
2	Expansion tank to bracket	887142/4	1	Expansion tank to bracket	
3	SM radiator bracket	888420	4	SM radiator	
4	Fan brackets to fan	887107/4	4	Fan brackets to fan	
5	Fan to radiator	888410/2	4	Fan to radiator	
6	Rad Fan to radiator	888474	8	Rad Fan to radiator	
7	Radiator bobbin	888474	8	Radiator bobbin	
8	Expansion tank bracket	887114	1	Expansion tank bracket	
9	18 x 10V rad bracket	888414	13	18 x 10V rad bracket	
10	Radiator bobbin back	888474	4	Radiator bobbin back	
11	Radiator bobbin front	888474	4	Radiator bobbin front	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

Pack D		CATERHAM		44	
		PACK NUMBER		QUANTITY	
COOLING SIGMA					
<i>This pack may include extra fasteners to cover different options</i>					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
12	Expansion tank bracket	888440	1	Expansion tank bracket	
13	SM radiator bracket	888420	4	SM radiator bracket	
14	Expansion tank to bracket	887107/4	4	Expansion tank to bracket	
15	Fan brackets to fan	887107/4	4	Fan brackets to fan	
16	Fan to radiator	888410/2	4	Fan to radiator	
17	Rad Fan to radiator	888474	8	Rad Fan to radiator	
18	Radiator bobbin	888474	8	Radiator bobbin	
19	Expansion tank bracket	887114	1	Expansion tank bracket	
20	18 x 10V rad bracket	888414	13	18 x 10V rad bracket	
21	Radiator bobbin back	888474	4	Radiator bobbin back	
22	Radiator bobbin front	888474	4	Radiator bobbin front	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

x3

TIPS

The silicone hose you are looking for has a 90° one end and then a long piece.

Chris B

The hose itself should have a grey lining.

James S

Put hose through P-Clip and attach to tank.

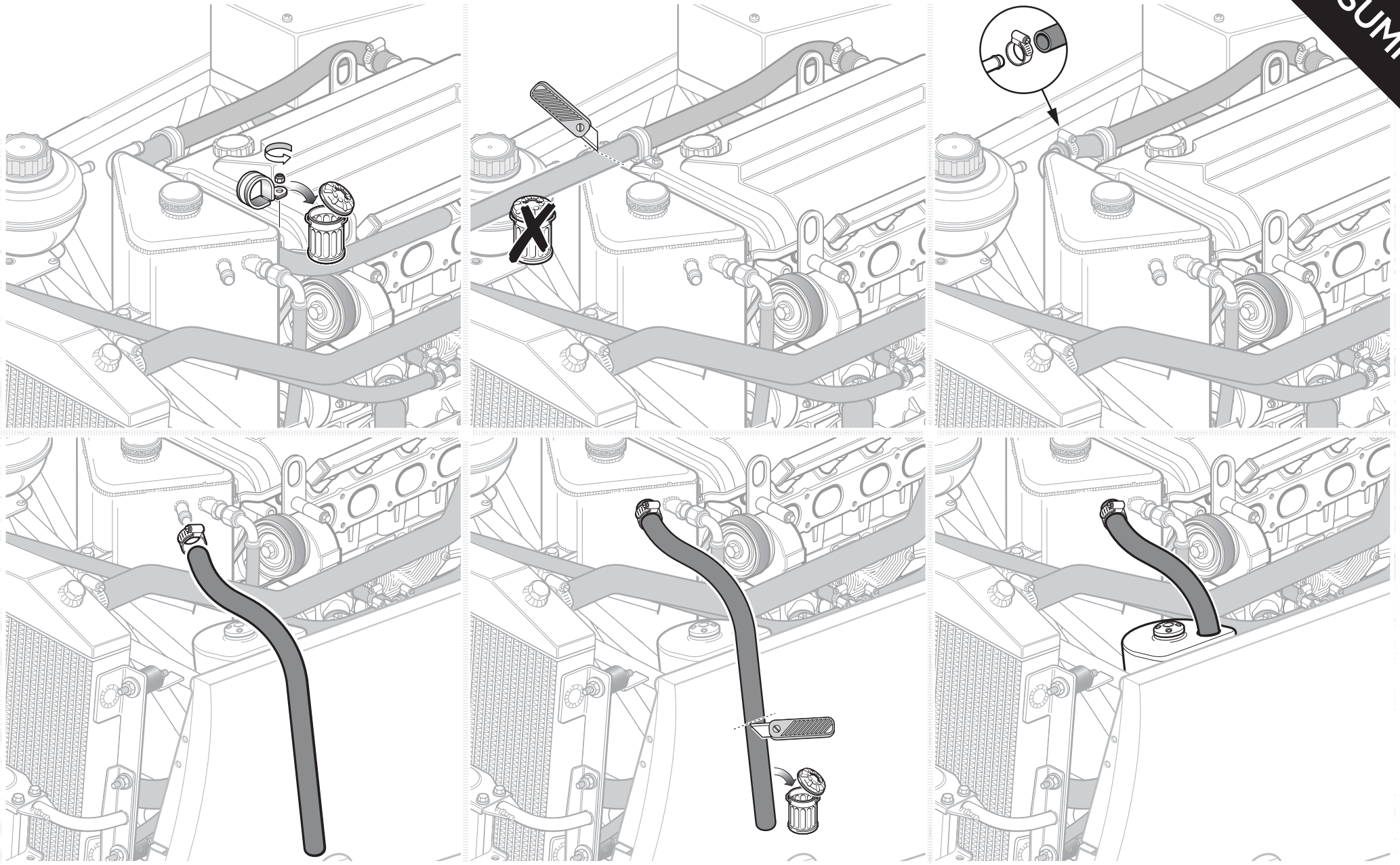
Grant P

Use the excess to run from tank to D-Bottle.

Vincent M

DRY SUMP CATCH TANK

DRY SUMP

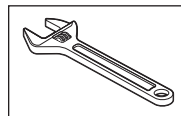


DRY SUMP OIL PIPE - 1 OF 3

PARTS

- 1 Oil pipe - 39C059

TOOLS



FIXINGS

TIPS

The pipe will fit both ways but you don't want any kinks in the pipe itself – one way will fit better.

Tiago O

Put copper slip on the threads.

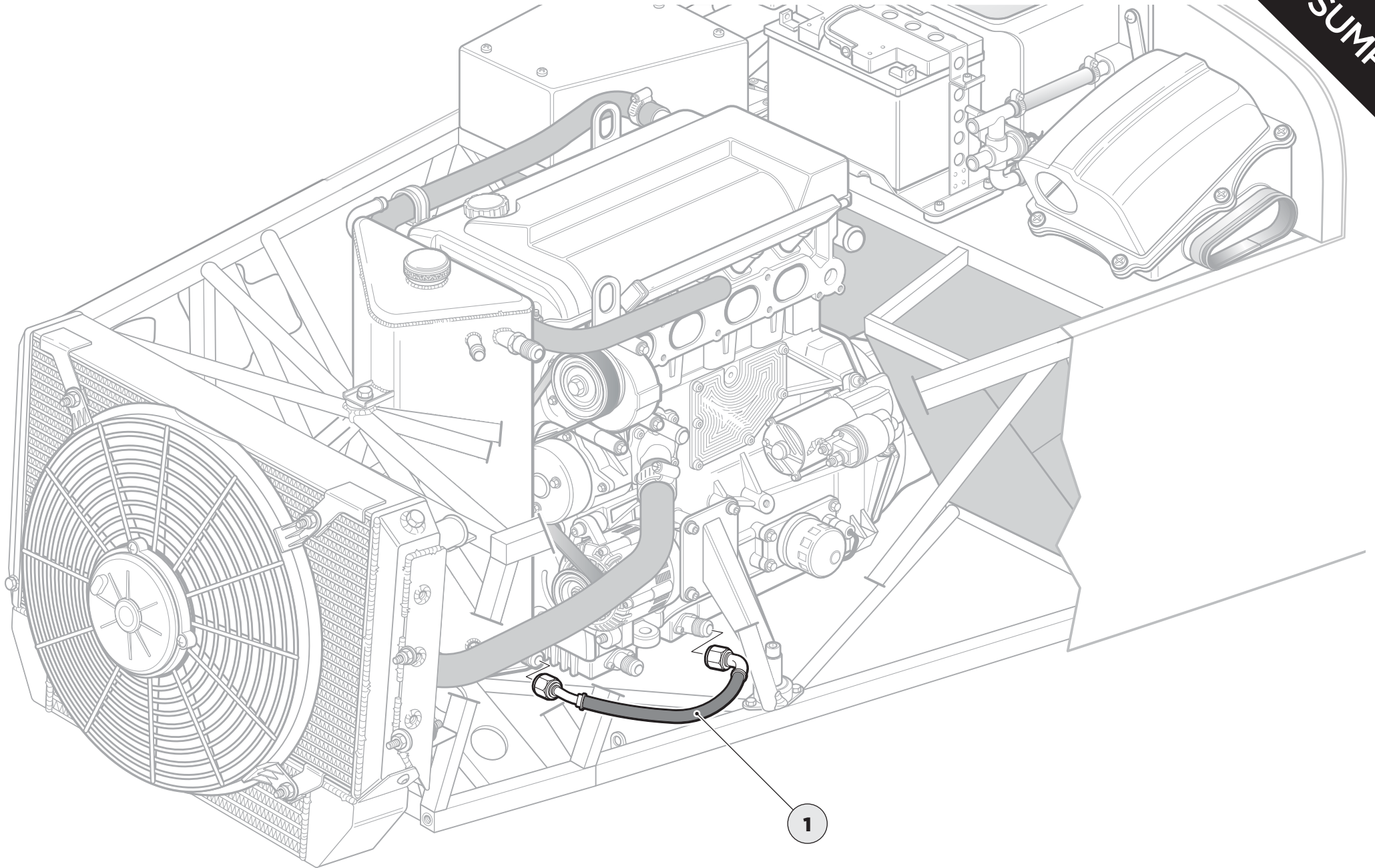
Rich T

Tighten by hand slowly and give a small 'nip' up.

Chris B

Take care not to cross thread.

Anthony L

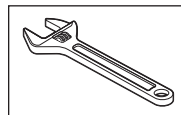


DRY SUMP OIL PIPE - 2 OF 3

PARTS

1 Oil pipe - 39C060

TOOLS



FIXINGS

TIPS

The pipe will fit both ways but you don't want any kinks in the pipe itself – one way will fit better.

Tiago O

Put copper slip on the threads.

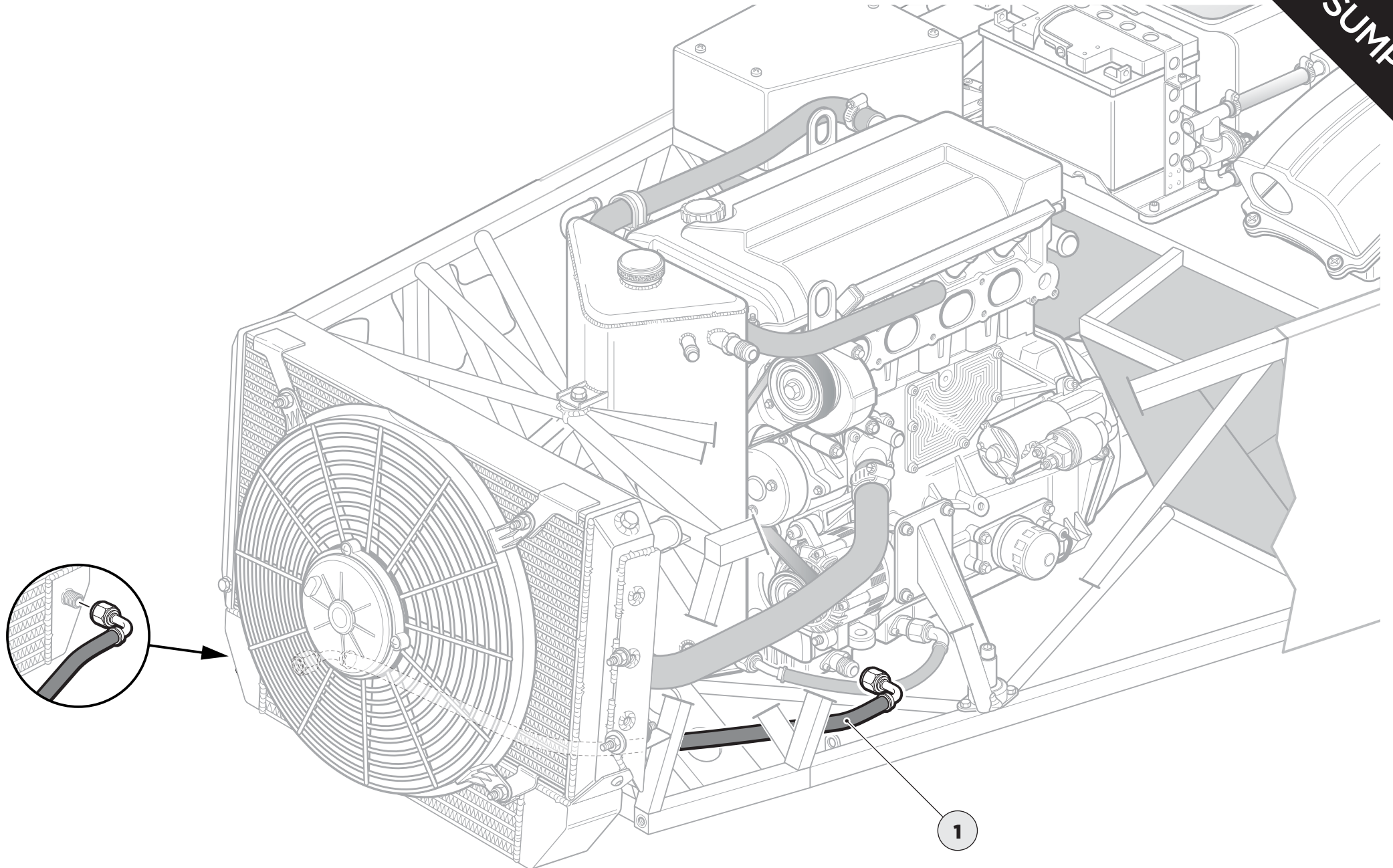
Rich T

Tighten by hand slowly and give a small 'nip' up.

Chris B

Take care not to cross thread.

Anthony L

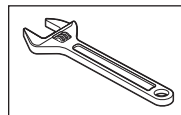


DRY SUMP OIL PIPE - 3 OF 3

PARTS

- 1** Oil pipe -

TOOLS



FIXINGS

TIPS

The pipe will fit both ways but you don't want any kinks in the pipe itself – one way will fit better.

Tiago O

Put copper slip on the threads.

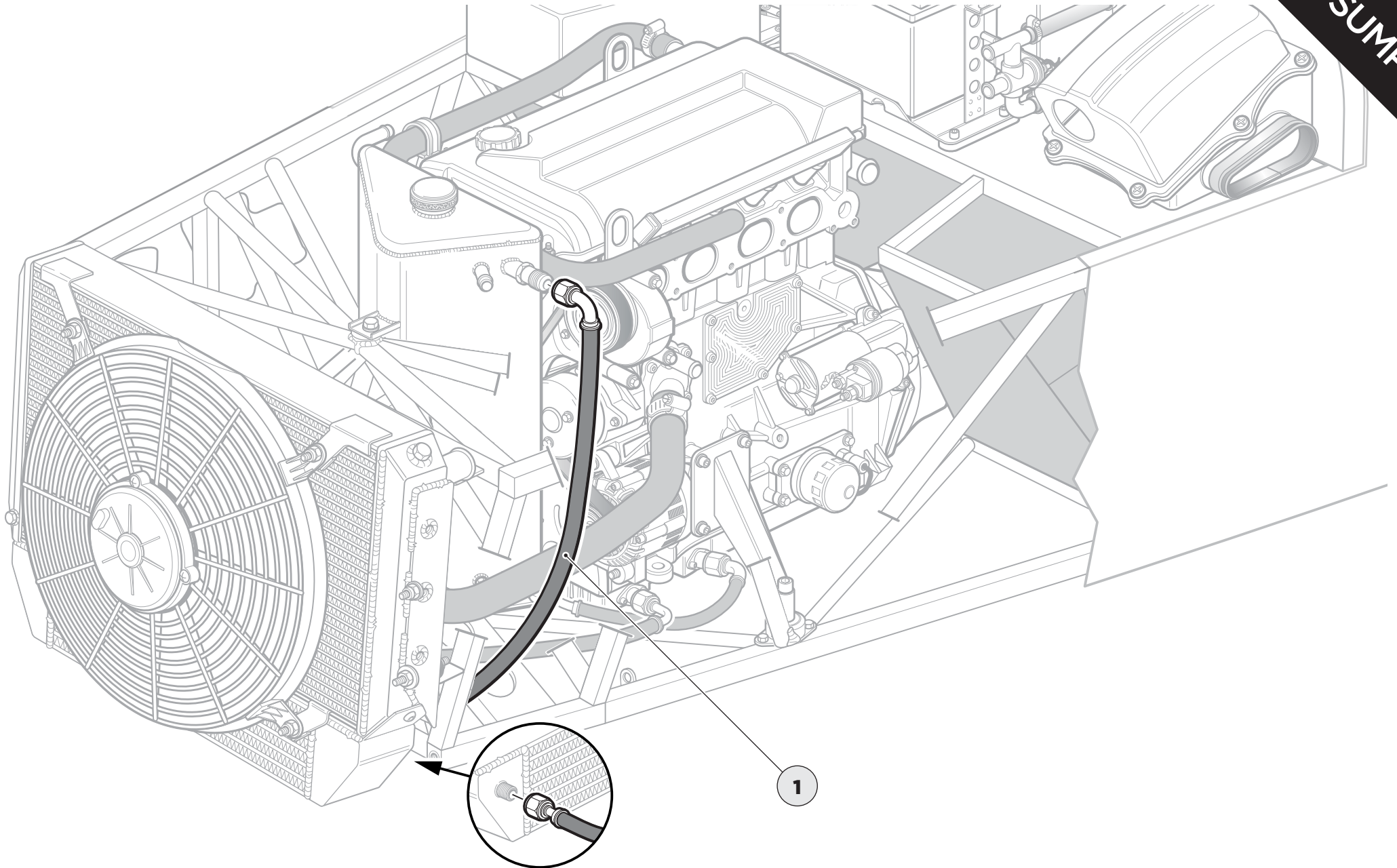
Rich T

Tighten by hand slowly and give a small 'nip' up.

Chris B

Take care not to cross thread.

Anthony L

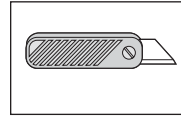


WET / DRY SUMP - A BIT OF SUB-ASSEMBLY (SOME HOSES NEED MODIFYING)

PARTS

- 1 Silicone hoses

TOOLS



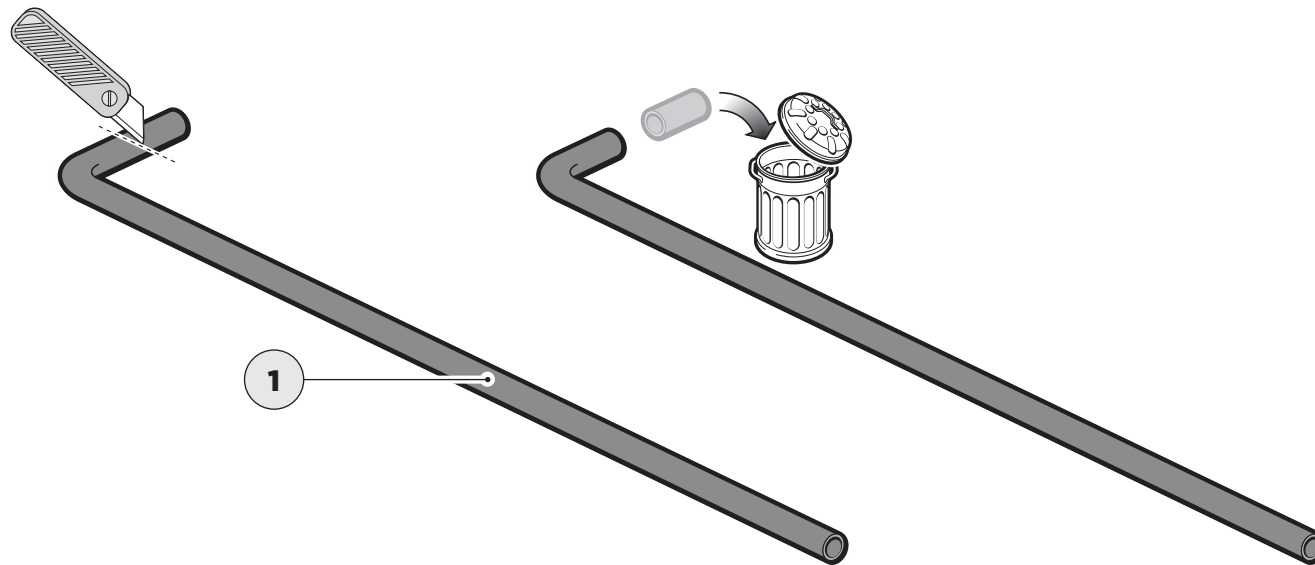
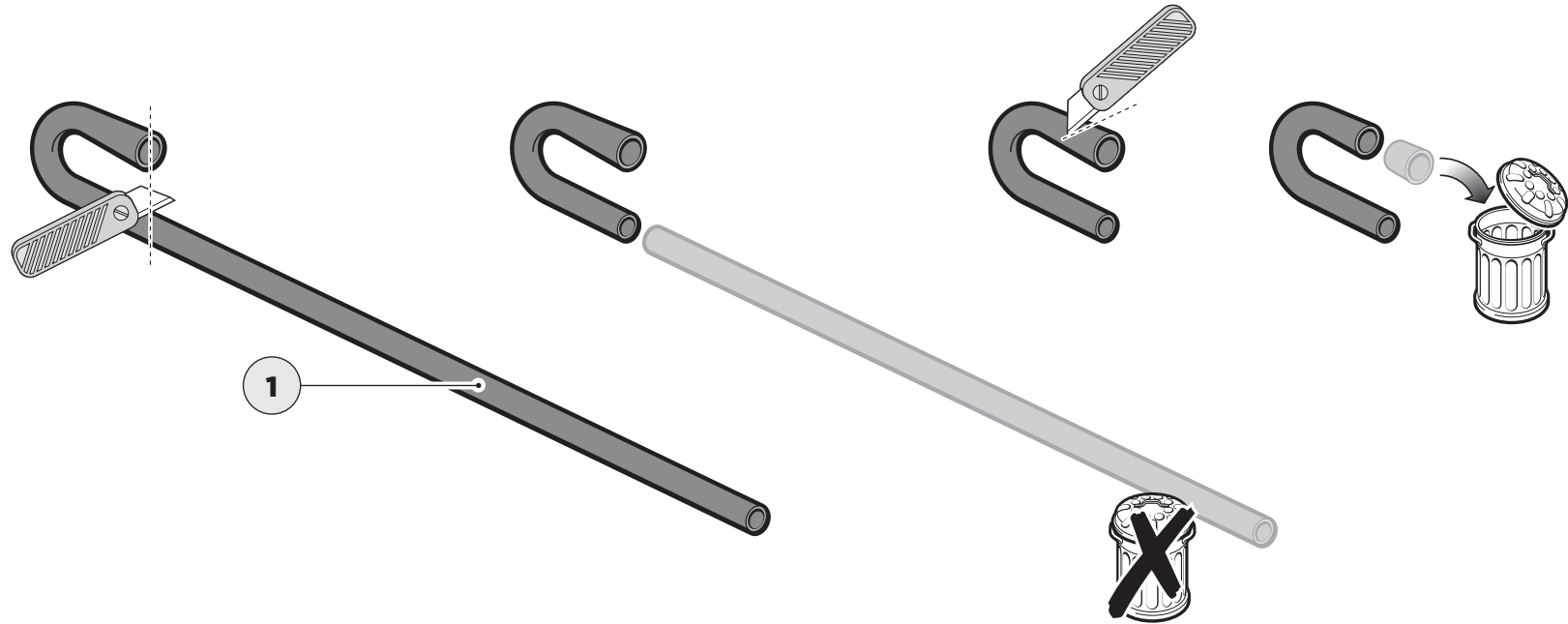
FIXINGS

TIPS

Don't throw away the long piece of hose after cutting.

Rich T

WET / DRY SUMP - A BIT OF SUB-ASSEMBLY (SOME HOSES NEED MODIFYING)

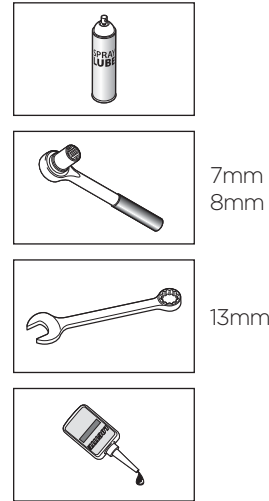


WET / DRY SUMP SUB-ASSEMBLY - TEMPERATURE SENSOR

PARTS

- 1** Temperature sender
- 2** Earth tag
- 3** Cooling submarine

TOOLS



FIXINGS

Pack D		CATERHAM		44	
		PACK NUMBER		SICCATB	
COOLING SIGMA					
<i>This pack may include extra fasteners to cover different options</i>					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	DA Bolt M6 x 20 Hex Hd	888440	1	Expansion tank bracket to chassis	
2	DB Washer 1.6 x 5.4	887142/4	1	Expansion tank to bracket	
3	DC Submarine 88520 Hex Hd	888420	4	SM radiator bracket	
4	DD Bolt M6 x 16 with Square neck	882102/4	4	Fan brackets to fan	
5	DE Submarine 88510 Hex Hd	888410/4	4	Fan to radiator mounting - 20 (10)	
6	DF Hex Nut M6	88317/4	8	4x Fan to radiator 4x SM radiator bracket	
7	DG Plain Nut M6	88317/4	8	Radiator bobbin	
8	DH Bolt M6 x 14	88711/4	1	Expansion tank bracket	
9	DI Plain Washer 16 Hex Hd	88311/4	13	13 x DV rad bracket 4 x Fan brackets 1 x Expansion tank bracket	
10	DJ Plain Washer 16 Hex Hd	88311/4	4	Radiator bobbin back	
11	DK Plain Washer 16 Hex Hd	88311/4	4	Radiator bobbin front	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

Pack D		CATERHAM		44	
		PACK NUMBER		SICCATB	
COOLING SIGMA					
<i>This pack may include extra fasteners to cover different options</i>					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
12	DL Plain Washer 16 Hex Hd	88311/4	1	Expansion tank bracket	
13	DM Spring Washer 16 Hex Hd	88310/12	8	8 x Radiator bobbin 1 x Expansion tank	
14	DN Hex Clip 20 Hex	88720/40	6	2 x 11 where hoses connect 2 x 11 on radiator hose 2 x 11 when radiator hose	
15	DO Hex Clip 20 Hex	88720/30	2	1 x Engine outlet to top 1 frame 1 x Engine outlet to lower frame	
16	DP Hex Clip 17 Hex	88716/25	18	6 x Radiator bracket 1 x Engine tank 1 x Expansion tank 4 x Dry Sump 4 x Radiator	
17	DI Hex Clip 16 Hex	88716/16	6	Expansion tank small 1 piece	
18	DR Bolt - Black 12.9 x 10	88716/10/12	12	Cooling fan	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

x2

TIPS

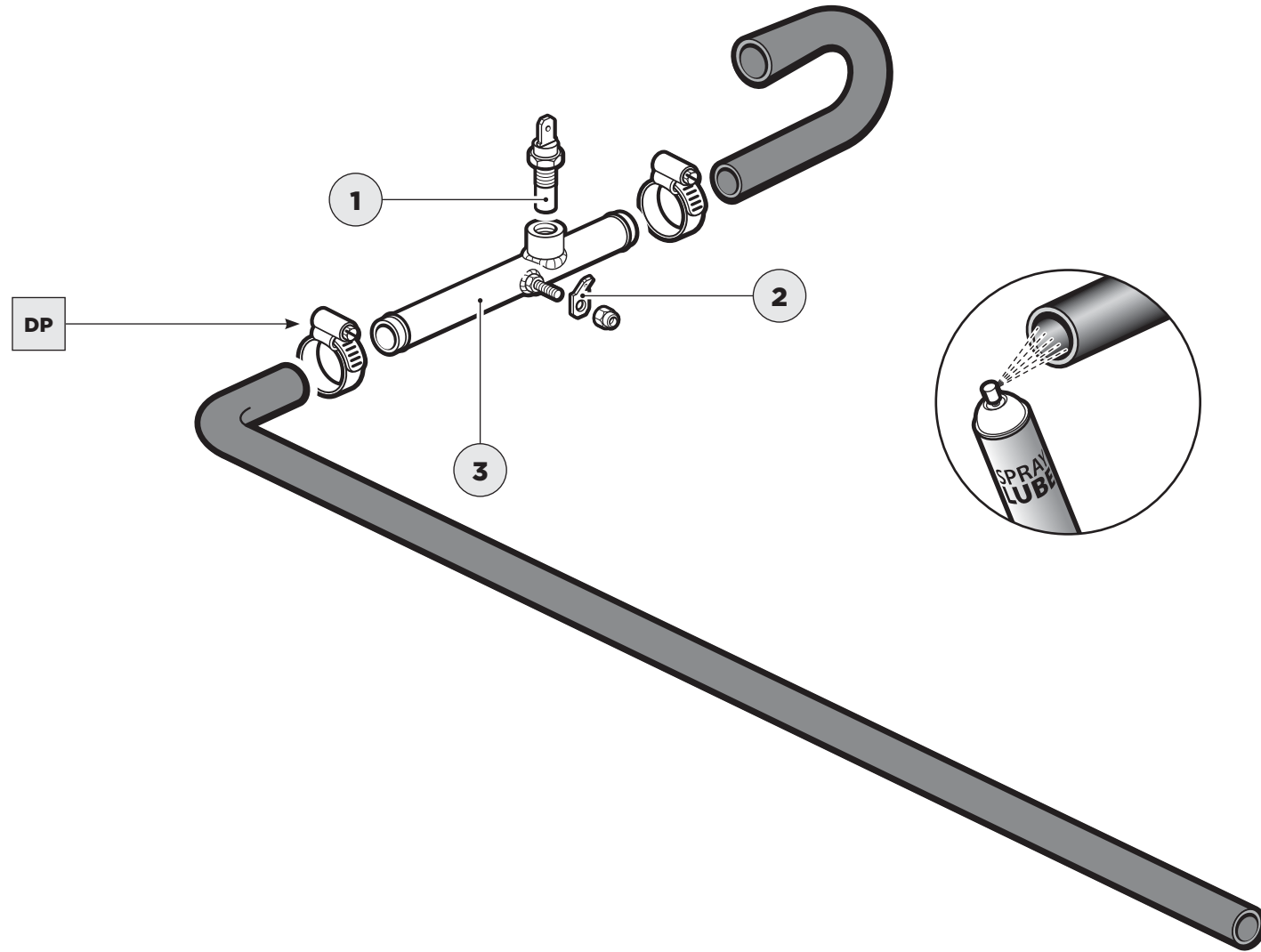
Use a drop of Loctite on the sender.

Tiago O

Be careful not to over-tighten the sender.

Jamie A

WET / DRY SUMP SUB-ASSEMBLY - TEMPERATURE SENSOR

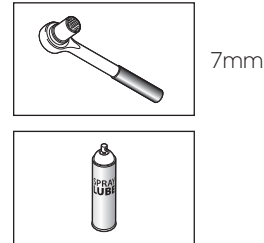


WET / DRY SUMP SUBMARINE

PARTS

1 Submarine assembly

TOOLS



FIXINGS

Pack D		CATERHAM		44	
		PACK NUMBER		SICCATB	
COOLING SIGMA					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	DA Bolt M8 x 20 Hex Hd A	888440	1	Expansion tank bracket to chassis	
2	DB Washer 1.6 x 5.4 Hex Hd	887142/4	1	Expansion tank to bracket	
3	DC Submarine 888200 Hex Hd A	888420	4	SM radiator bracket	
4	DD Bolt M8 x 18 with Square necked	887107/4	4	Fan brackets to fan	
5	DE Submarine 888210 Fan Mounting	888421/2	4	Fan to radiator mounting - 20 (1/2)	
6	DF Flare Nut M8	888774	8	4 x Fan to radiator and 4 x radiator bracket	
7	DG Flare Nut M8	888774	8	Radiator bobbin	
8	DH Flare Nut 1/4"	887114	1	Expansion tank bracket	
9	DI Flare Washer 1.6 x 5.4 Hex Hd A	888214	13	8 x 1/4" nut bracket 4 x Fan Brackets 1 x Expansion tank bracket	
10	DJ Flare Washer 1.6 x 5.4 Hex Hd A	888214	4	Radiator bobbin back	
11	DK Flare Washer 1.6 x 5.4 Hex Hd A	888214/2	4	Radiator bobbin front	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

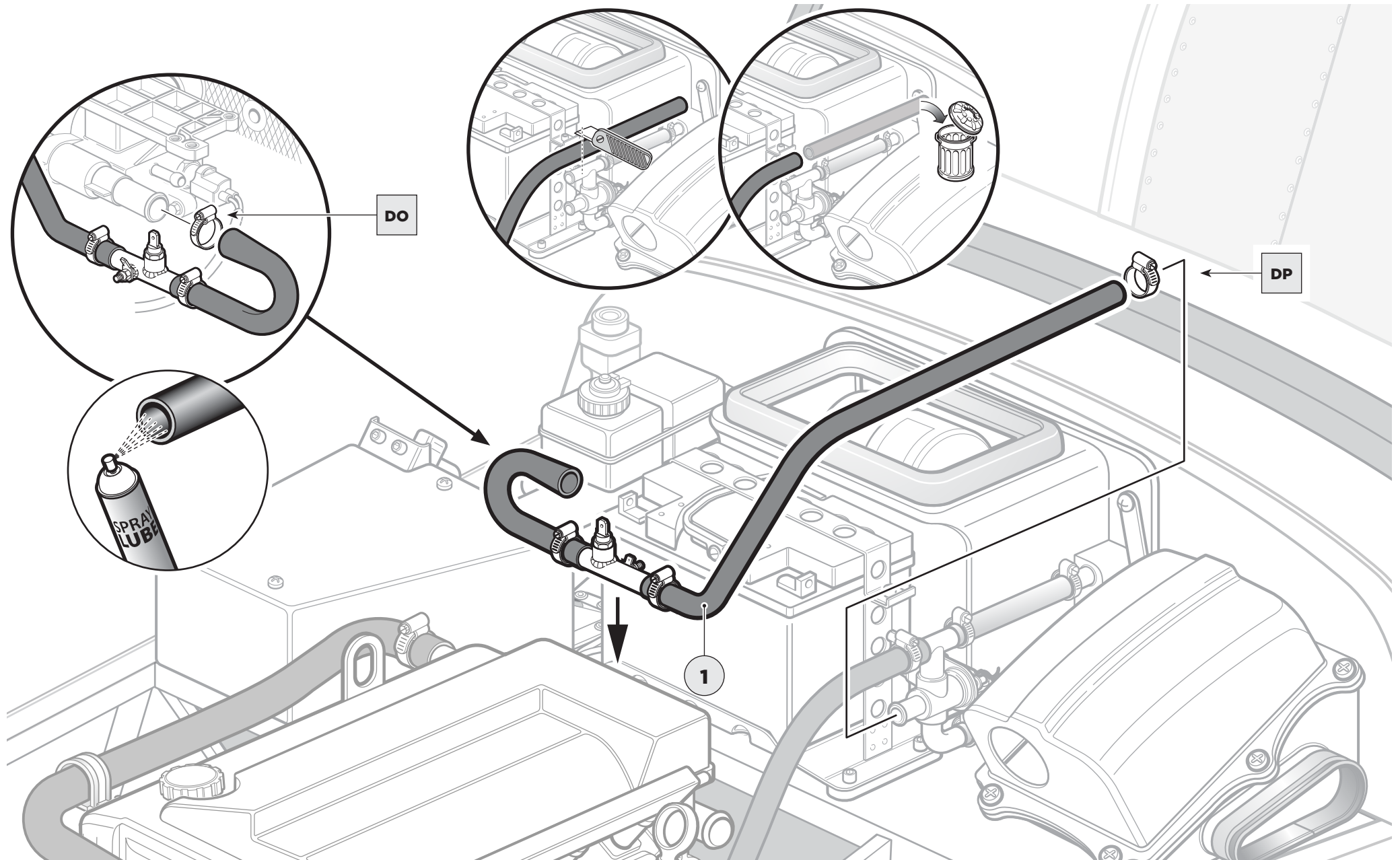
Pack D		CATERHAM		44	
		PACK NUMBER		SICCATB	
COOLING SIGMA					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
12	DL Flare Washer 1.6 x 5.4 Hex Hd A	888214/2	1	Expansion tank bracket	
13	DM Spring Washer 4.8 Hex Hd A	888401/2	8	8 x Radiator bobbin 1 x Expansion tank	
14	DN Hose Clip 22 - 35mm	88720-40	6	2 x 1 x where hoses connect to 2 x 2 x radiator hose 2 x 2 x radiator tank	
15	DO Hose Clip 22 - 35mm	88720-38	2	1 x Engine outlet to big 1 piece 1 x Engine outlet to heater inlet	
16	DP Hose Clip 17 - 25mm	88716-25	18	8 x Heater brackets 1 x Expansion tank 4 x Dry Sump 4 x Radiator	
17	DQ Hose Clip 8 - 10mm	88716-16	6	Expansion tank small 1 piece	
18	DR Bolt - Black 1/2" x 3.5"	88710-11/2	12	Cooling fan	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

x1
x1

TIPS

WET / DRY SUMP SUBMARINE

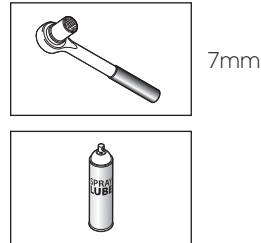


WET SUMP LAST BIT OF PLUMBING

PARTS

1 5/16" hose

TOOLS



FIXINGS

Pack D		CATERHAM		44	
		PACK NUMBER		QUANTITY	
COOLING SIGMA					
<i>This pack may include extra fasteners to cover different options</i>					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Ball Nut 2-20 Thread 2.8	888440	1	Expansion tank bracket to chassis	
2	Ball Nut 1/8" 2-20 Thread 2.8	888440	1	Expansion tank to bracket	
3	Ball Nut 1/8" 2-20 Thread 2.8	888440	4	SM radiator bracket	
4	Ball Nut 1/8" 2-20 Thread 2.8	888440	4	Fan brackets to fan	
5	Ball Nut 1/8" 2-20 Thread 2.8	888440	4	Fan to radiator mounting - 20 100g	
6	Ball Nut 1/8" 2-20 Thread 2.8	888440	8	40 Fan to radiator and 20 radiator bracket	
7	Ball Nut 1/8" 2-20 Thread 2.8	888440	8	Radiator bobbin	
8	Ball Nut 1/8" 2-20 Thread 2.8	888440	1	Expansion tank bracket	
9	Ball Nut 1/8" 2-20 Thread 2.8	888440	13	18 x 20 Fan bracket 4 x 2 Fan bracket 1 x Expansion tank bracket	
10	Ball Nut 1/8" 2-20 Thread 2.8	888440	4	Radiator bobbin back	
11	Ball Nut 1/8" 2-20 Thread 2.8	888440	4	Radiator bobbin front	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

Pack D		CATERHAM		44	
		PACK NUMBER		QUANTITY	
COOLING SIGMA					
<i>This pack may include extra fasteners to cover different options</i>					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
12	Expansion tank bracket	888440	1	Expansion tank bracket	
13	Spring Washer 1/8" Thread 2.8	888440	8	8 x Radiator bobbin 1 x Expansion tank	
14	Washers 1/8" 2-20 Thread 2.8	888440	6	2 x 18 x 20 Fan bracket 4 x 2 Fan bracket 1 x Expansion tank	
15	Washers 1/8" 2-20 Thread 2.8	888440	2	1 x Engine outlet to top T-piece 1 x Engine outlet to bottom T-piece	
16	Washers 1/8" 2-20 Thread 2.8	888440	18	8 Radiator bobbin 10 Fan bobbin 1 Expansion tank 4 Fan bobbin	
17	Washers 1/8" 2-20 Thread 2.8	888440	5	Expansion tank small T-piece	
18	Washers 1/8" 2-20 Thread 2.8	888440	12	Coupling cap	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

x2

TIPS

Run hose through spare P-Clip.

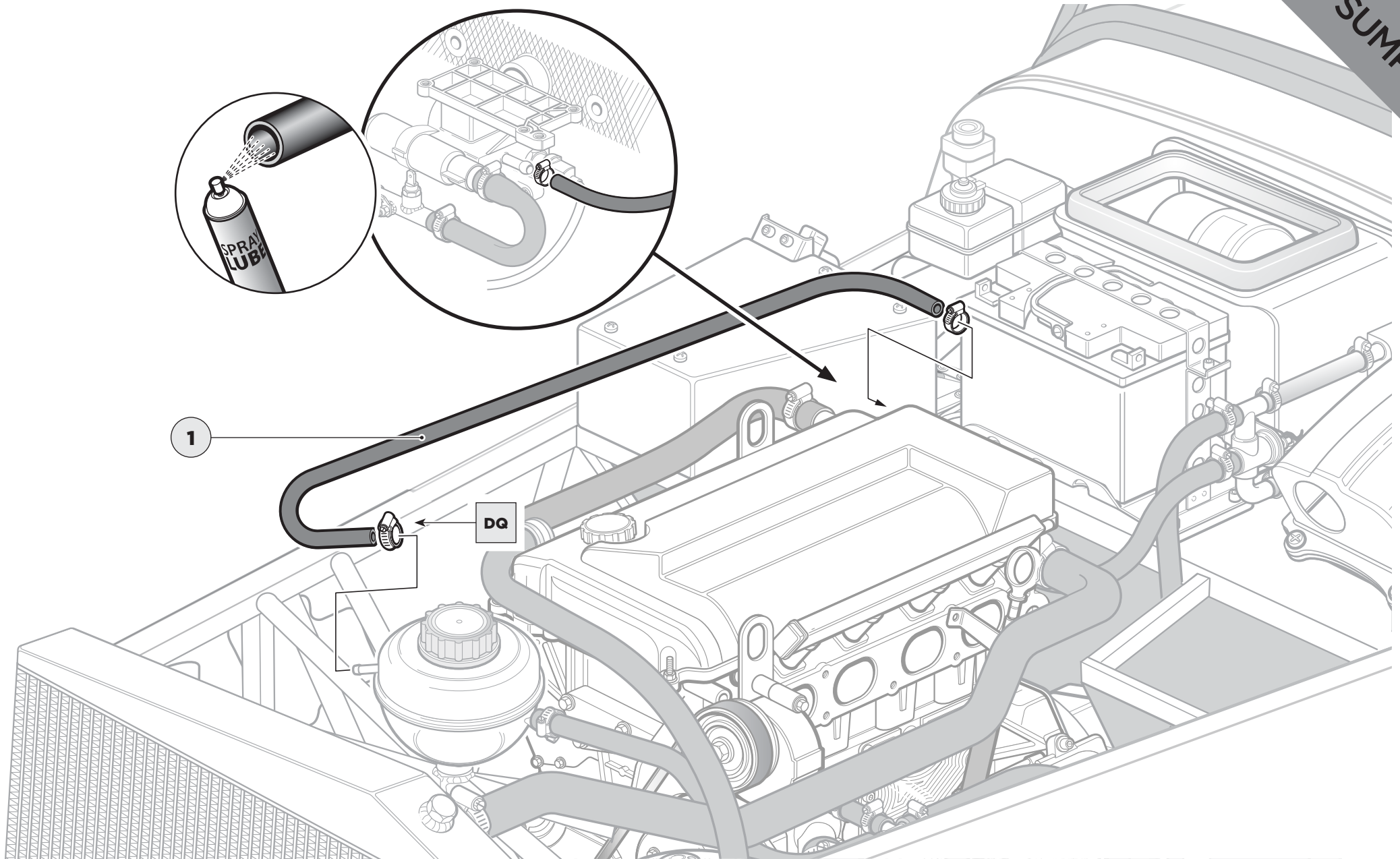
Dan P

Cut hose to length.

Lee A

WET SUMP LAST BIT OF PLUMBING

WET SUMP

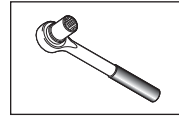


DRY SUMP LAST BIT OF PLUMBING

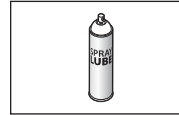
PARTS

1 5/16" hose

TOOLS



7mm



FIXINGS

Pack D		CATERHAM		44	
		PACK NUMBER		SIZES/TS	
COOLING SIGMA					
<i>This pack may include extra fasteners to cover different options</i>					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Ball Mt 2-20 Hex Hd	888440	1	Expansion tank bracket to chassis	
2	Ball Mount 1/2" x 3/4"	88714424	1	Expansion tank to bracket	
3	Ball Mount 1/2" x 3/4" Hex Hd	888420	4	SM radiator bracket	
4	Ball Mt 1/2" x 3/4" Hex Hd Square Neck	88710724	4	Fan brackets to fan	
5	Ball Mount 1/2" x 3/4" Hex Hd	888420	4	Fan to radiator mounting - 20 1/2"	
6	Hex Nut M8	888776	8	4x Fan to radiator 4x 20 radiator bracket	
7	Plan Nut M8	888776	8	Radiator bobbin	
8	Hex Nut 1/4"	887114	1	Expansion tank bracket	
9	Plan Washer 1/4" Hex Hd	888114	13	8 x 20 Fan bracket 4 x 20 Fan bracket 1 x Expansion tank bracket	
10	Plan Washer 1/4" Hex Hd	888114	4	Radiator bobbin back	
11	Plan Washer 1/4" Hex Hd	888114	4	Radiator bobbin front	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

Pack D		CATERHAM		44	
		PACK NUMBER		SIZES/TS	
COOLING SIGMA					
<i>This pack may include extra fasteners to cover different options</i>					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
12	Plan Washer 1/4" Hex Hd	888114	1	Expansion tank bracket	
13	Spring Washer 1/4" Hex Hd	888114	8	8 x Radiator bobbin 1 x Expansion tank	
14	Hex Cap 20 1/2"	8872040	6	2 x 14 where hex cap used 4 x 20 radiator hose 2 x Radiator bobbin hose	
15	Hex Cap 20 1/2"	8872038	2	1 x Engine outlet to top 1 frame 1 x Engine outlet to bottom frame	
16	Hex Cap 17 1/2"	8871628	18	6 where attached to the frame 2 Expansion tank 2 Radiator bobbin 6 Radiator bobbin	
17	Hex Cap 8 - 10mm	887816	5	Expansion tank small T-piece	
18	Hex - Bolt 1/2" x 1 1/2"	88761010	12	Crossing flap	

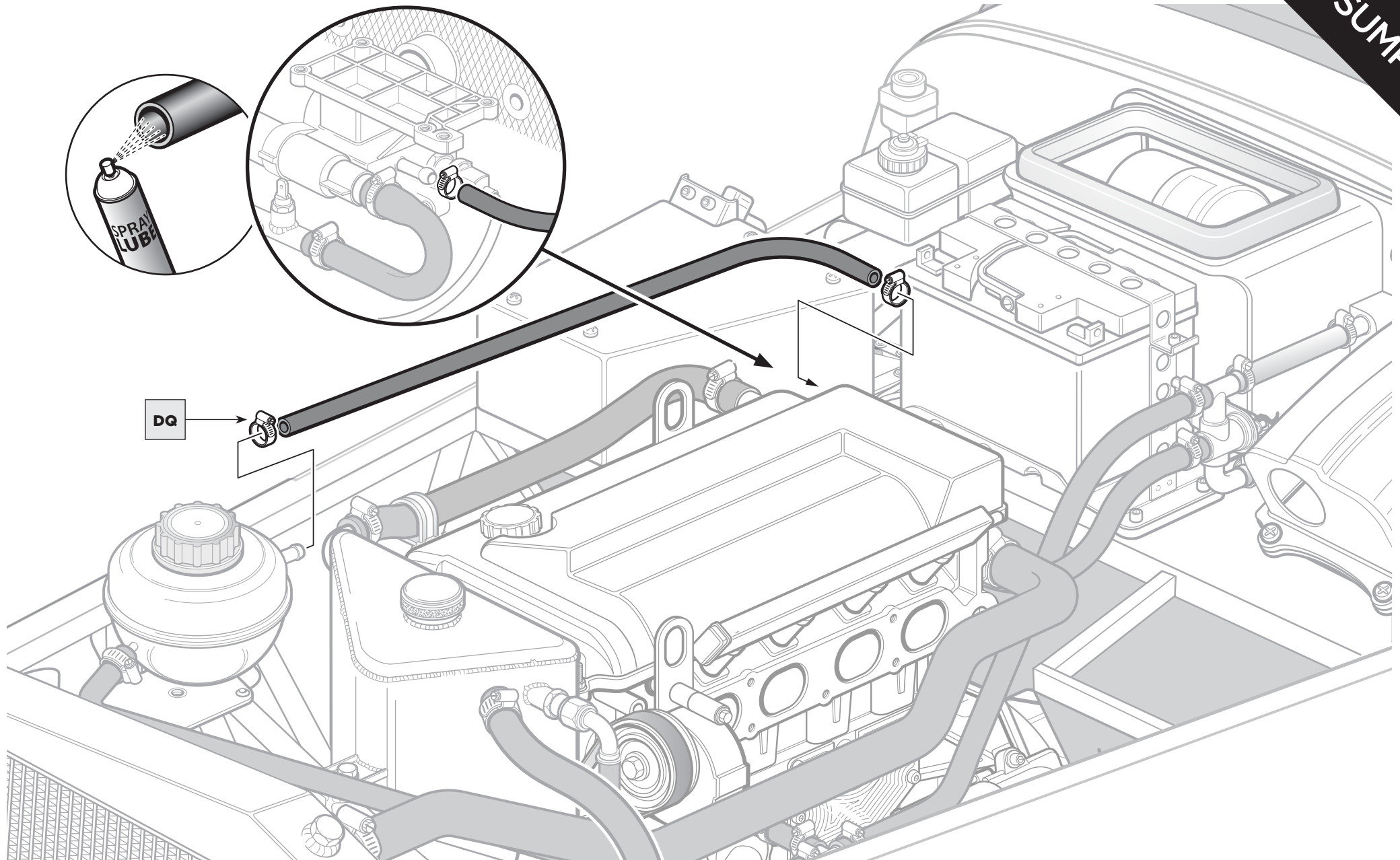
Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

x2

TIPS

DRY SUMP LAST BIT OF PLUMBING

DRY SUMP

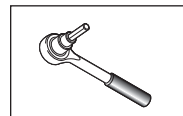


WET / DRY SUMP PLENUM

PARTS

1 Plenum

TOOLS



5mm

FIXINGS

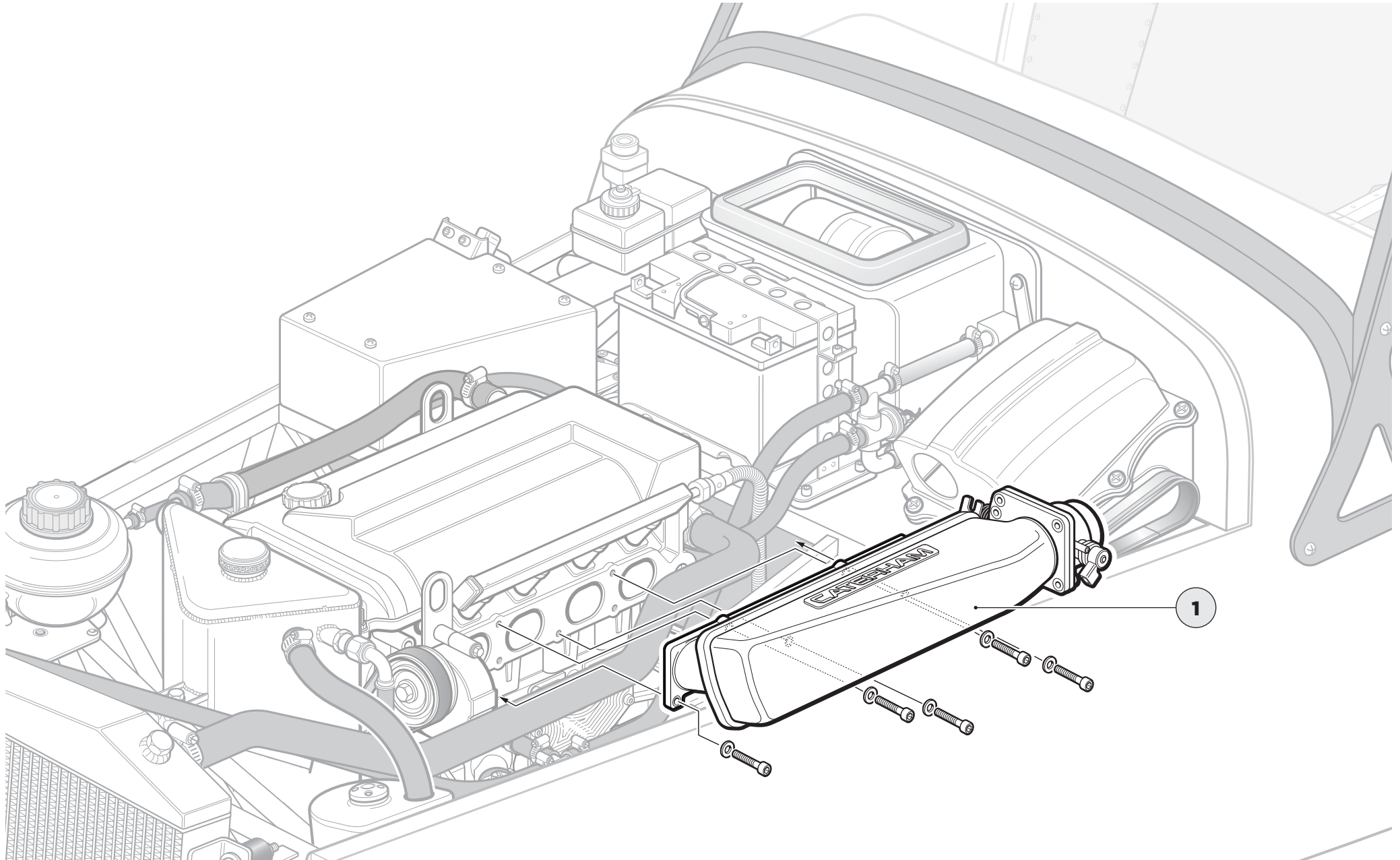
Those removed earlier

TIPS

Refit the plenum.

Dan P

WET / DRY SUMP PLENUM



WET / DRY SUMP AIR BOX HOSE

PARTS

- 1 Airbox hose
- 2 Hose clip

TOOLS



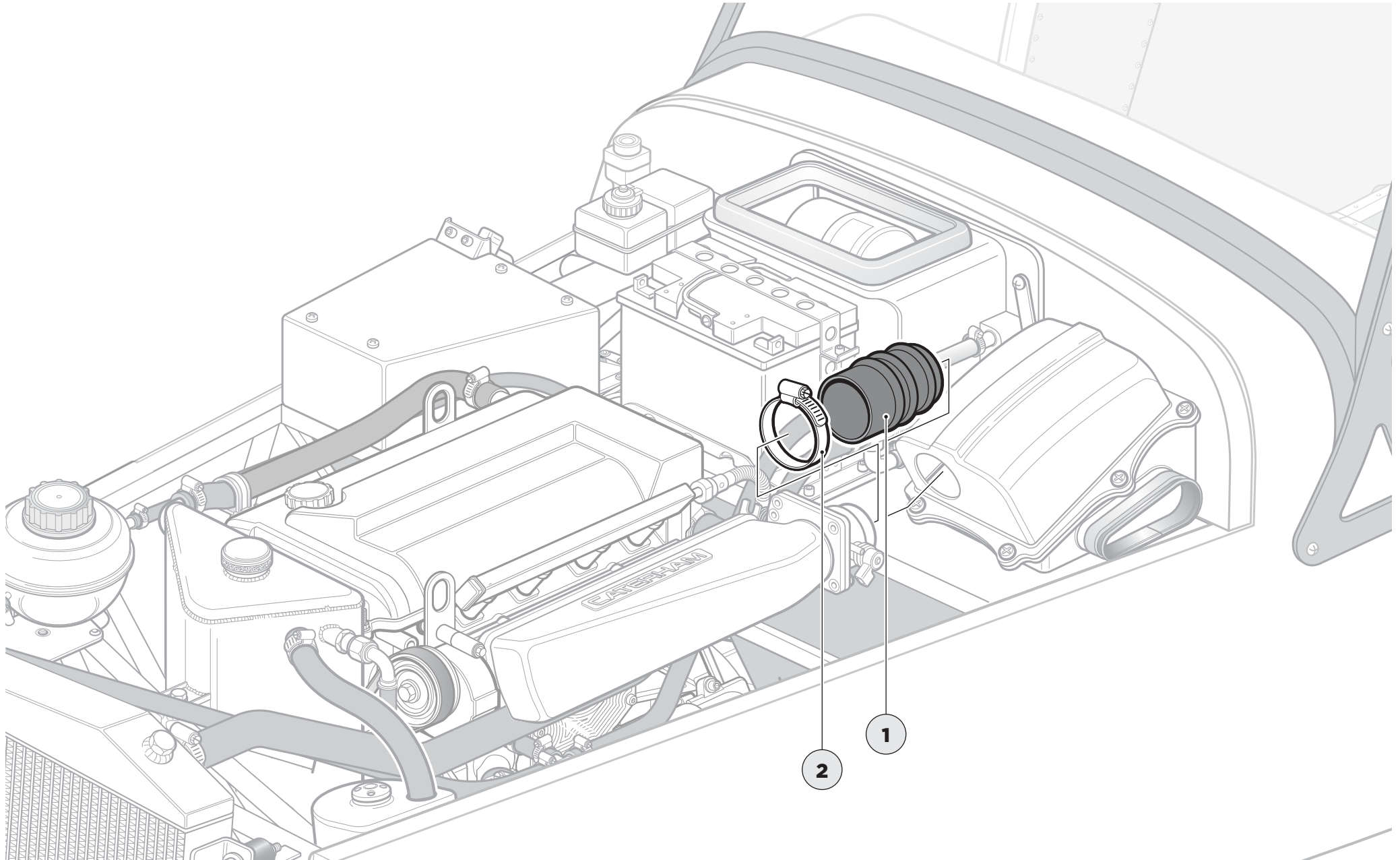
7mm

FIXINGS

All the fixings for this step should be supplied in the airbox.

TIPS

WET / DRY SUMP AIR BOX HOSE



CONNECTING THE FUEL LINE

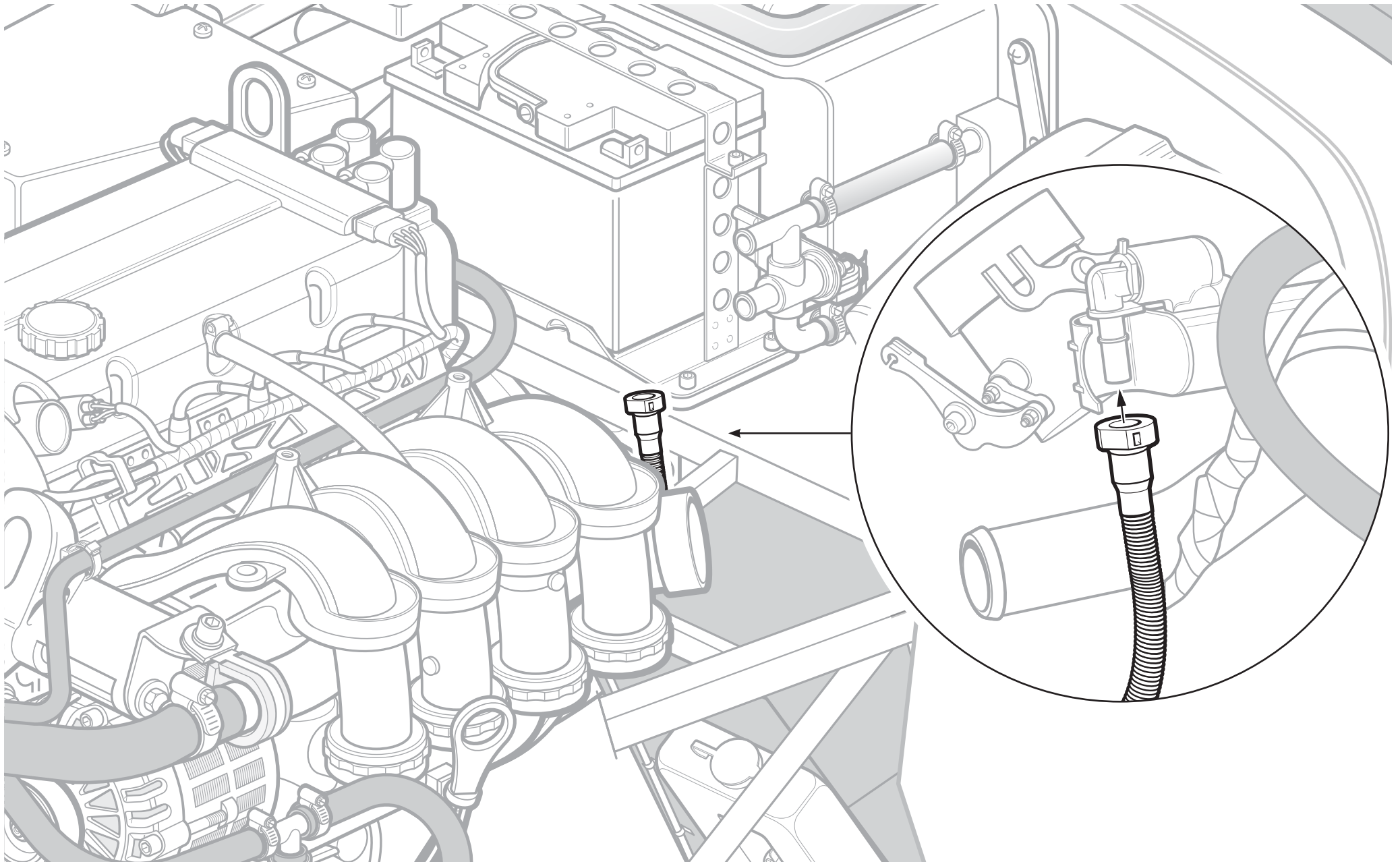
P A R T S

T O O L S

F I X I N G S

T I P S

CONNECTING THE FUEL LINE

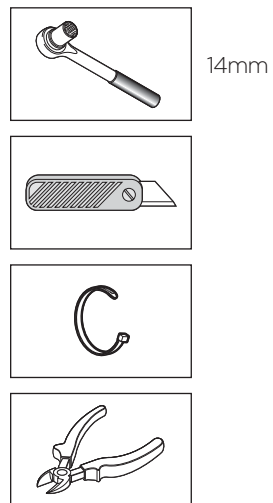


PROTECTING & ATTACHING THE CLUTCH HOSE

PARTS

- 1 8mm water hose

TOOLS



FIXINGS

TIPS

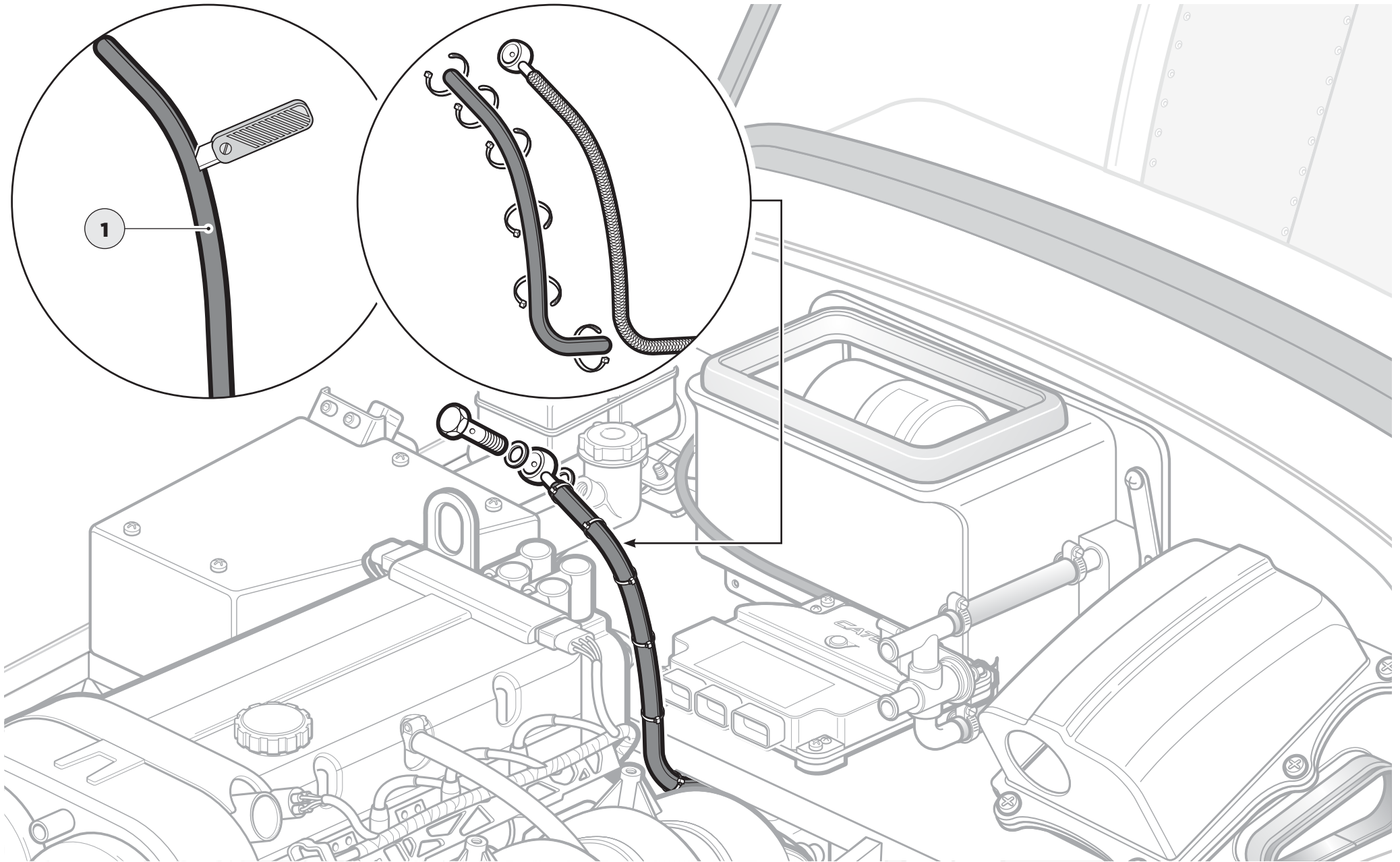
Nip up the banjo bolt.

John K

The hose is used to stop chaffing.

James A

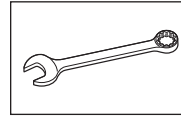
PROTECTING & ATTACHING THE CLUTCH HOSE



CONNECTING THE BATTERY (POSITIVE / RED FIRST)

PARTS

TOOLS



10mm (x2)

FIXINGS

TIPS

Always connect live side of battery first (red wire).

Chris B

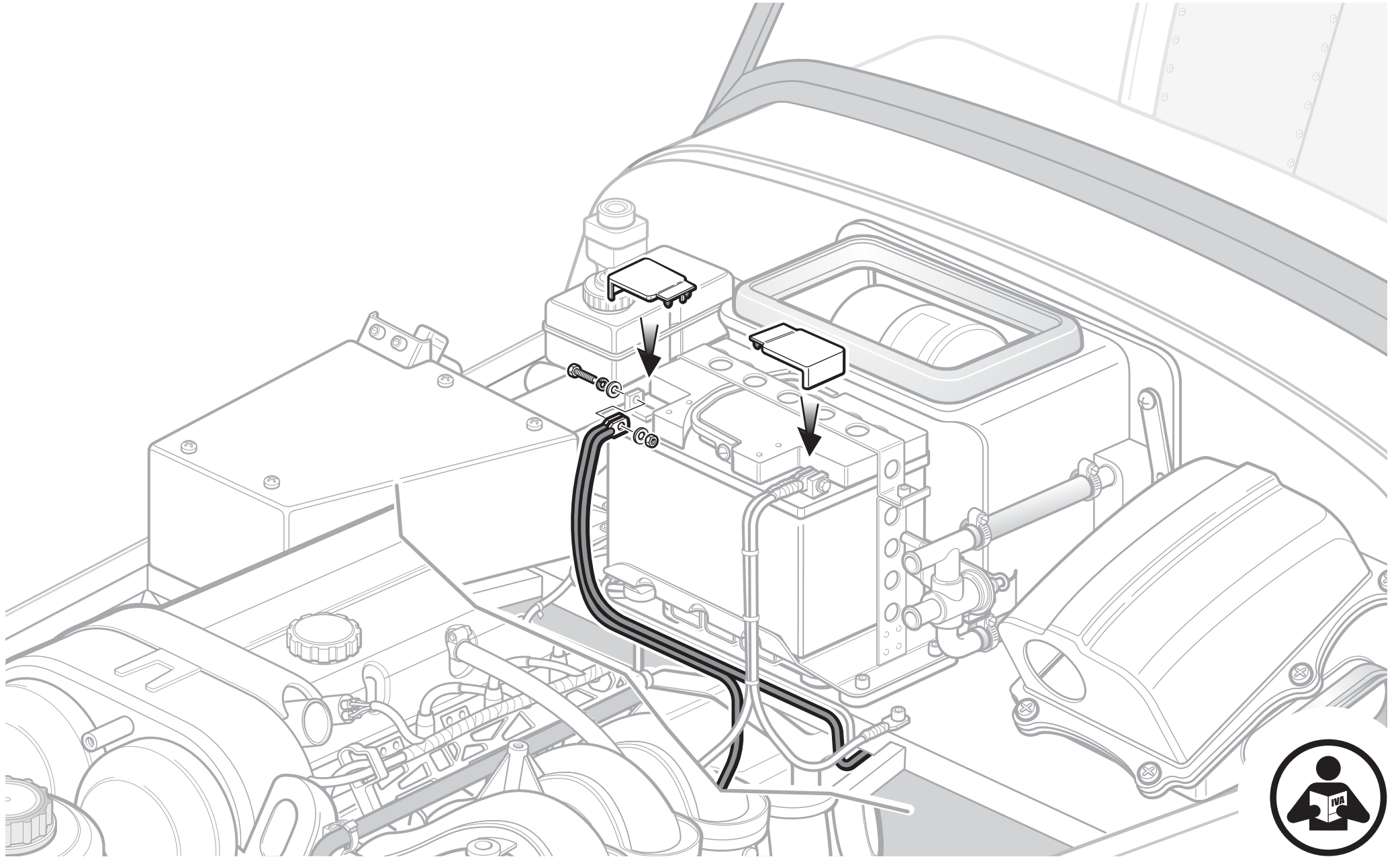
Make the battery the last thing you connect.

Jamie A

Be careful to ensure that the red leads go to the + side and the black wires to the - side.

Dan D

CONNECTING THE BATTERY (POSITIVE / RED FIRST)



PARTS

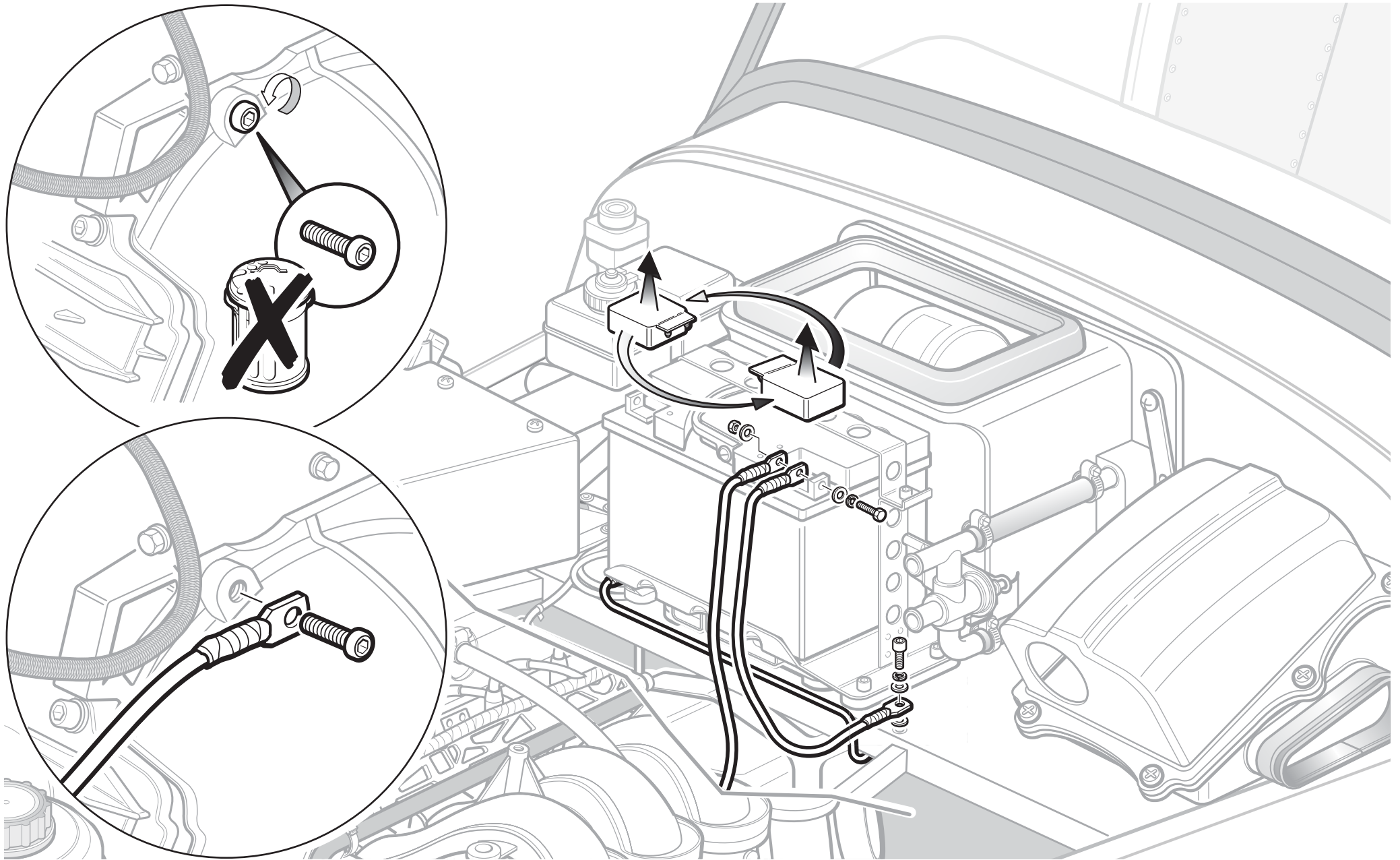
TOOLS

FIXINGS

TIPS

Add a plain M8 or $\frac{5}{16}$ washer underneath the earth lead to chassis.

Dan P

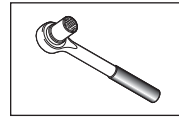


ONE LAST BIT OF PLUMBING...

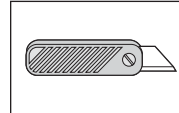
PARTS

1 Hose

TOOLS



7mm



FIXINGS

Pack D		CATERHAM		44	
		PACK NUMBER		SICCATS	
COOLING SIGMA					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	EA Radiator 2.50 (Front 2.5)	888440	1	Expansion tank bracket to chassis	
2	EB Radiator 2.50 (Front 2.5)	888440	1	Expansion tank to bracket	
3	EC Radiator 2.50 (Front 2.5)	888440	4	SM radiator bracket	
4	ED Radiator 2.50 (Front 2.5)	888440	4	Fan brackets to fan	
5	EE Radiator 2.50 (Front 2.5)	888440	4	Fan to radiator mounting - 20 (top)	
6	EF Radiator 2.50 (Front 2.5)	888440	8	40 Fan to radiator and 20 radiator bracket	
7	EG Radiator 2.50 (Front 2.5)	888440	8	Radiator bobbin	
8	DH Radiator 2.50 (Front 2.5)	888440	1	Expansion tank bracket	
9	DI Radiator 2.50 (Front 2.5)	888440	13	18 x 50 Fan bracket 18 x Fan bracket 18 x Expansion tank bracket	
10	DJ Radiator 2.50 (Front 2.5)	888440	4	Radiator bobbin back	
11	DK Radiator 2.50 (Front 2.5)	888440	4	Radiator bobbin front	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

Pack D		CATERHAM		44	
		PACK NUMBER		SICCATS	
COOLING SIGMA					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
12	EL Radiator 2.50 (Front 2.5)	888440	1	Expansion tank bracket	
13	EM Radiator 2.50 (Front 2.5)	888440	8	8 x Radiator bobbin 1 x Expansion tank	
14	EN Radiator 2.50 (Front 2.5)	888440	6	2 x 18 Radiator bobbin 2 x 18 Radiator bobbin 2 x 18 Radiator bobbin	
15	EO Radiator 2.50 (Front 2.5)	888440	2	1 x Expansion tank to top 1 x Expansion tank to bottom	
16	EP Radiator 2.50 (Front 2.5)	888440	18	18 x Radiator bobbin 18 x Expansion tank 18 x Dip Switch 18 x Dip Switch	
17	EQ Radiator 2.50 (Front 2.5)	888440	6	Expansion tank small 2 pieces	
18	ER Radiator 2.50 (Front 2.5)	888440	12	Crossing dip	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

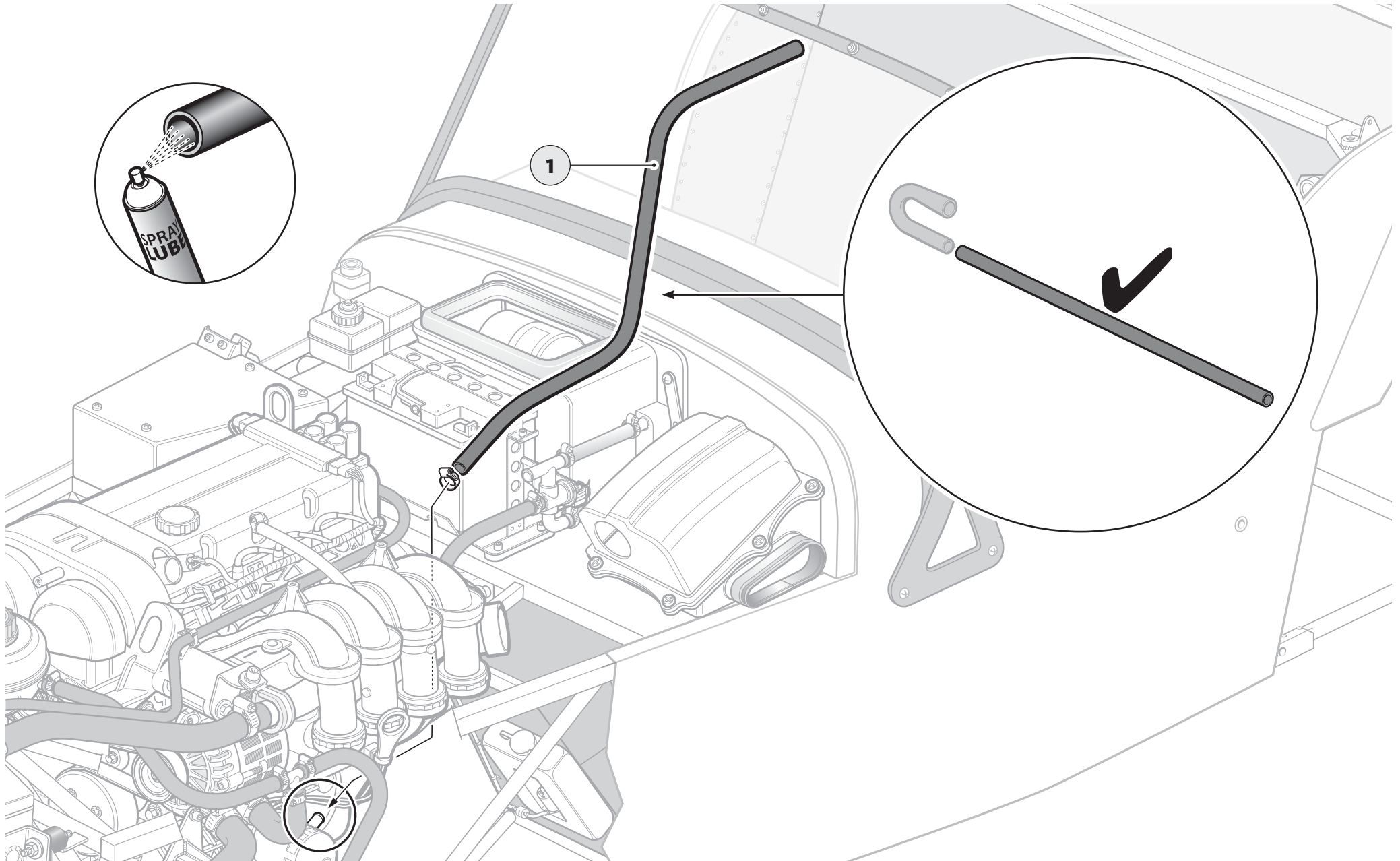
x1

TIPS

Cut off hook and trim if required.

Grant P

ONE LAST BIT OF PLUMBING...



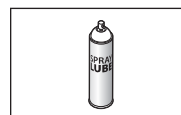
...TO CONNECT THE HEATER

PARTS

TOOLS



7mm



FIXINGS

TIPS

Pack D		CATERHAM		44	
		PACK NUMBER		SICCATB	
COOLING SIGMA					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	EA Rad MB 2 20 Hex 2.0	888440	1	Expansion tank bracket to chassis	
2	DB Radiator 1.8 X 3.4"	881442/4	1	Expansion tank to bracket	
3	DC Radiator MB20 Hex 2.0	888420	4	SM radiator bracket	
4	DD Rad MB 2 18 with Square bracket	881102/4	4	Fan brackets to fan	
5	DE Radiator MB20 Fanless Hex	888442/2	4	Fan to radiator mounting - 20 1/2"	
6	DF Hex Nut M8	880776	8	4" Fan to radiator 4" DV radiator bracket	
7	DG Plain Nut M8	880776	8	Radiator bobbin	
8	DH Hex Nut 1/4"	881714	1	Expansion tank bracket	
9	DI Plain Washer 1/4" Hex 1/4"	881714	13	18 x DV Rad Bracket 4" Fan Brackets 1 x Expansion tank bracket	
10	DJ Plain Washer 1/4" Hex 1/4"	881714	4	Radiator bobbin back	
11	DK Plain Washer 1/4" Hex 1/4"	881714/2	4	Radiator bobbin front	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

Pack D		CATERHAM		44	
		PACK NUMBER		SICCATB	
COOLING SIGMA					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
12	EL Plain Washer 1/4" Hex 1/4"	881714/2	1	Expansion tank bracket	
13	EM Spring Washer 1/4" Hex 1/4"	881691/2	8	8 x Radiator bobbin 1 x Expansion tank	
14	EN Hose Clip 1/2" Hex	881720-40	6	2 x 1/2" where hoses connect 2 x 1/2" on radiator hose 2 x Radiator bobbin hose	
15	EO Hose Clip 1/2" Hex	881720-20	2	1 x Engine outlet to Radiator 1/2" Hose 1 x Engine outlet to Radiator Hose	
16	EP Hose Clip 1/2" Hex	881716-25	18	8 x Heater brackets 16 x 8" Fan 1 x Expansion tank 1 x Dip Switch 1 x Dip Switch	
17	EQ Hose Clip 1/2" Hex	881716	6	Expansion tank small T piece	
18	ER Hex - Blank 1/4" X 1/4"	881610/10	12	Coupling cap	

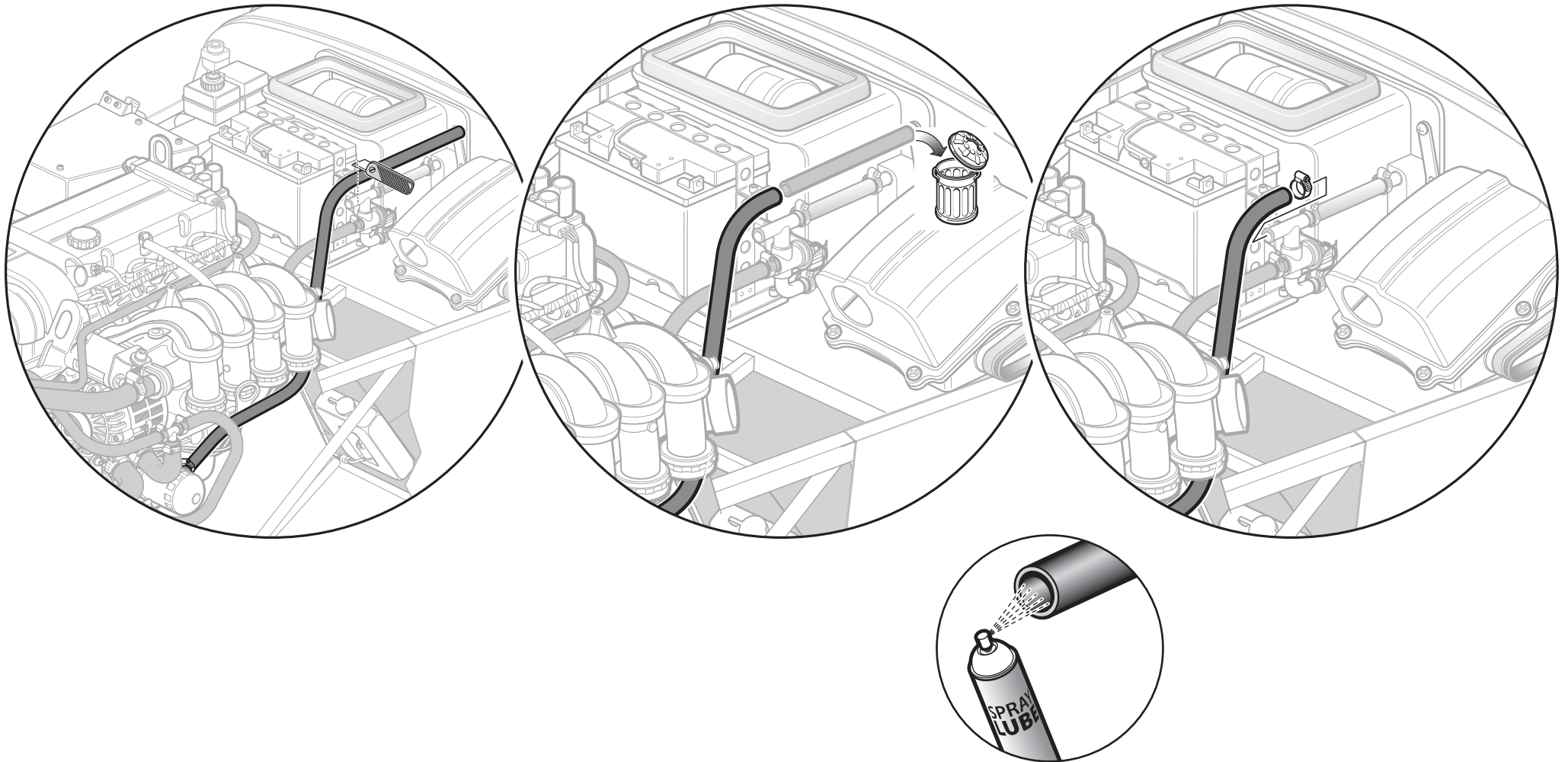
Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

x1

The coolant concentrate should be diluted 50/50 with water. It does not need to be exact!

Anthony L

...TO CONNECT THE HEATER

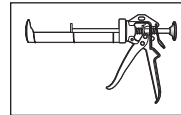
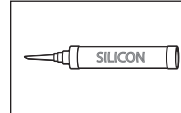
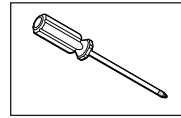


WET / DRY SUMP THROTTLE CABLE

PARTS

- 1** Throttle cable

TOOLS



FIXINGS

TIPS

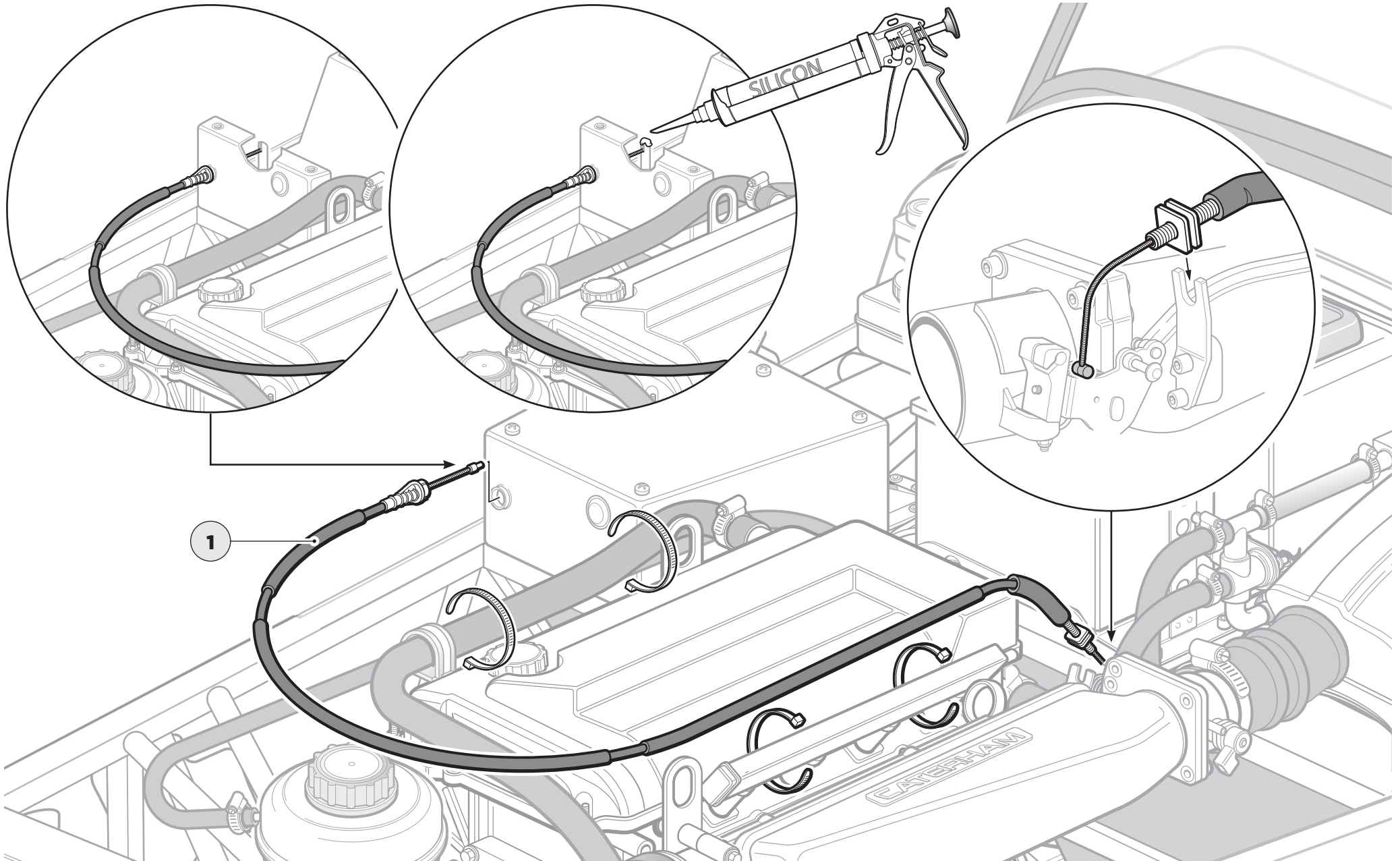
The silicone goes in the top of the pedal to prevent the cable coming out.

Rich T

Cable tie the throttle cable to engine hoist eyelet.

Anthony L

WET / DRY SUMP THROTTLE CABLE

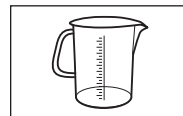


FILL WITH COOLANT

PARTS

Coolant concentrate

TOOLS



FIXINGS

TIPS



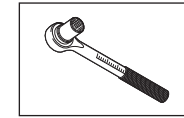
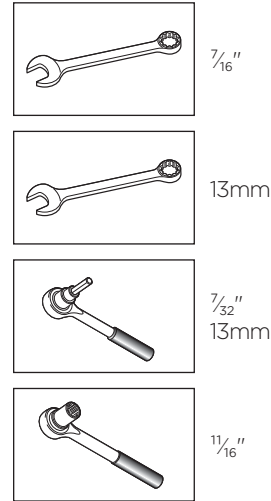
Fill expansion bottle to max mark

GIVING IT SOME DIRECTION

PARTS

- 1 Lower steering column
- 2 Upper steering column
- 3 Steering column clamp
- 4 Steering column clamp plate
- 5 Grub screw
- 6 Steering column bush

TOOLS



FIXINGS

Pack B		CATERHAM		55	
		PACK NUMBER		MARCH 2021	
		RELEASED NOV-19			
STEERING DeDION CARS (METRIC)					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	BA Rack clamp bolt 1/2" x 1/2" x 1/2"	BMX4070	4	Rack clamps	
2	BE Rack 1/2" x 1/2"	BF1443	2	Column clamp	
3	BC Ball Nut 40 Dia 10.5	BMX440	2	Column to rack universal joint	
4	BD Nylon Nut 1/2" height	NF1112	1	Steering wheel boss	
5	BE Plain Nut 1/2"	NF1112	2	Track rod lock out	
6	BE Plain Nut 1/2" lock type	NF1112	1	Column clamp grub screw bracket	
7	BG Nyloc Nut M8	NF1119	2	Column to rack universal joint	
8	BD Nylon Nut M8	NF1119	4	Steering rack clamps	
9	BJ Plain Washer 1/2" x 1/2" Dia 1mm	WF1112	1	Steering wheel boss	
10	BA Plain Washer 1/2" x 1/2" Dia 1mm	WF1114	6	Rack clamps and column clamp	
11	BE Spring Washer 1/2" x 1/2" Dia 1mm	WF1114	2	Column clamp	

x2

x1

x2

x1

TIPS

Check clearance between steering column & Aux belt tensioner once engine is installed. If necessary, rotate steering rack.

Dan P

Put the clamp in the middle of column with the grooved face of the clamp plate ④ against the column.

Jamie A

Steering rack to be rotated to fit column – don't forget to tighten rack brackets!

Harrison P

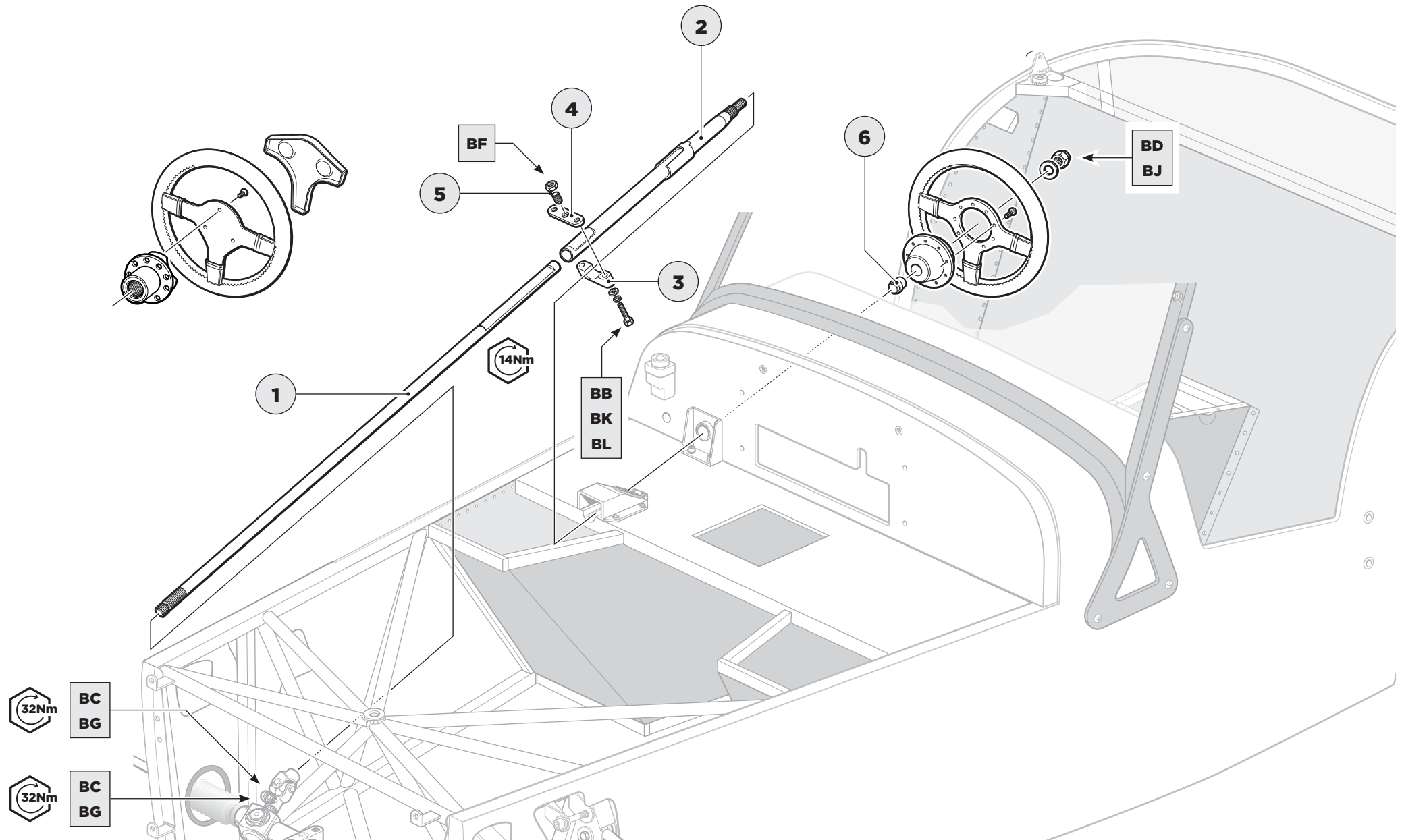
Grease the steering bushes.

Lee A

Fit the clamp bolts first, then grub screw & finish with the locking nut.

Tiago O

GIVING IT SOME DIRECTION

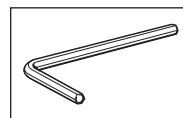


THIS IS EXHAUSTING

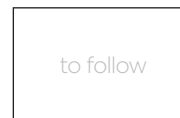
PARTS

- 1 Exhaust manifold gasket
- 2 Exhaust primary pipes
- 3 Cat / Collector
- 4 Exhaust collector springs

TOOLS

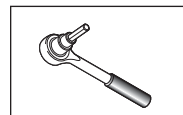


8mm



to follow

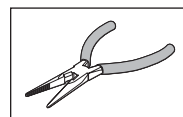
Extension



8mm



17mm
(270 & 310 only)



FIXINGS

Fixings are supplied loosely attached to the engine in place

TIPS

Use cable ties to compress exhaust spring.

Mick F

A pair of pliers are best to help hook over.

James A

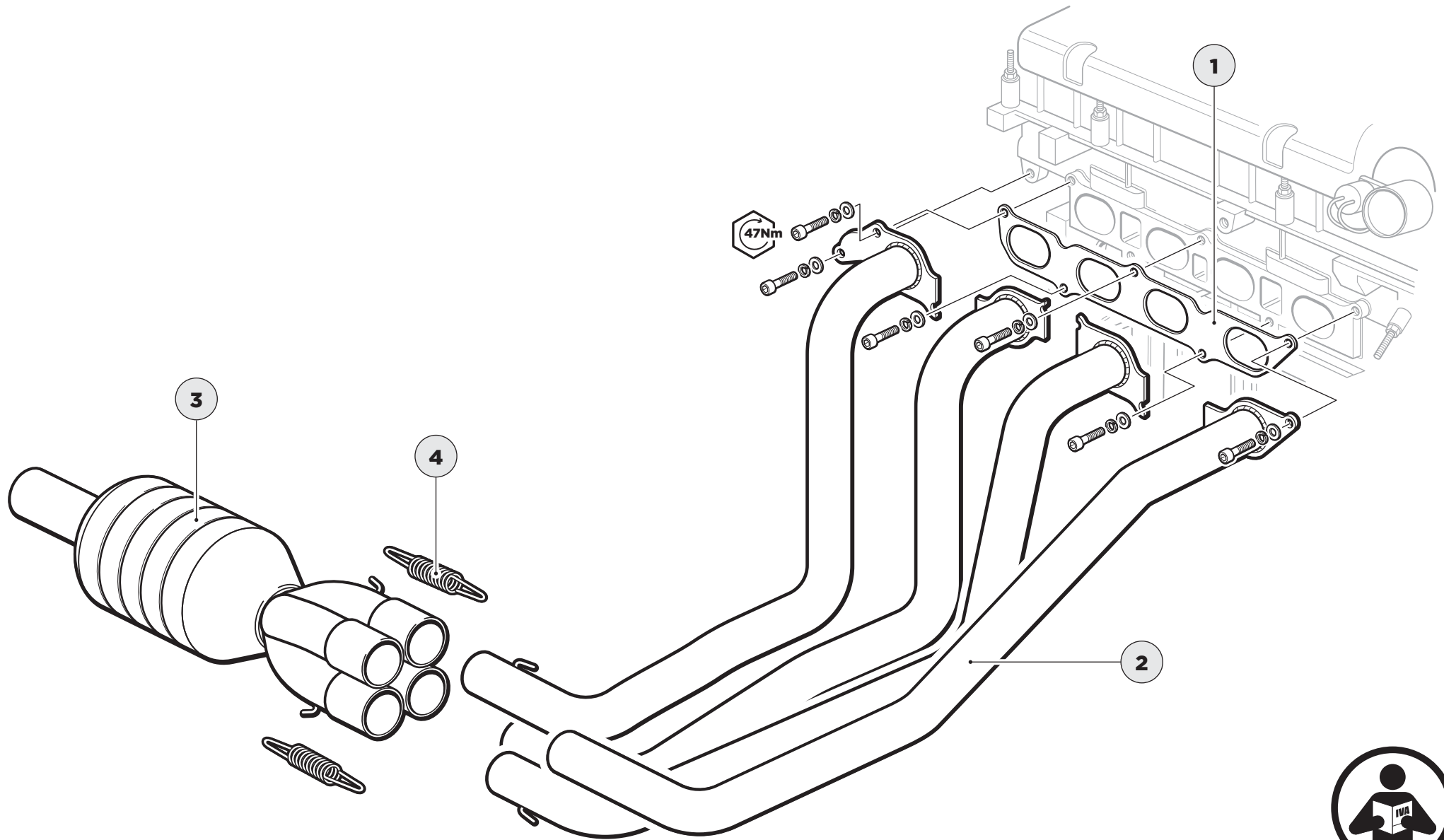
Put masking tape round exhaust hole to prevent scratches.

Chris B

Work out which primary pipe goes where, individually then put all four in plane, starting with the front one & working back. Take care with the hooks on your paintwork.

Chris N

THIS IS EXHAUSTING

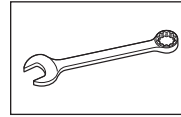


FITTING THE HANDBRAKE

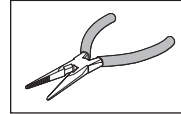
PARTS

- 1 Handbrake assembly
- 2 Handbrake pulley
- 3 Handbrake clevis
- 4 Pulley clevis pin
- 5 Handbrake clevis pin
- 6 Handbrake cable

TOOLS



13mm (x2)



FIXINGS

Miscellaneous pack

- Setscrew 8 (x25)
- Washer M8
- Washer M6

TIPS

Remember to put a loop in inner cable around pulley.

Grant P

Cable tie adjuster end of cable to diff.

Dan D

Use pliers to bend the legs of the split-pins once in place, which then holds them loosely in the clevis pins.

Chris B

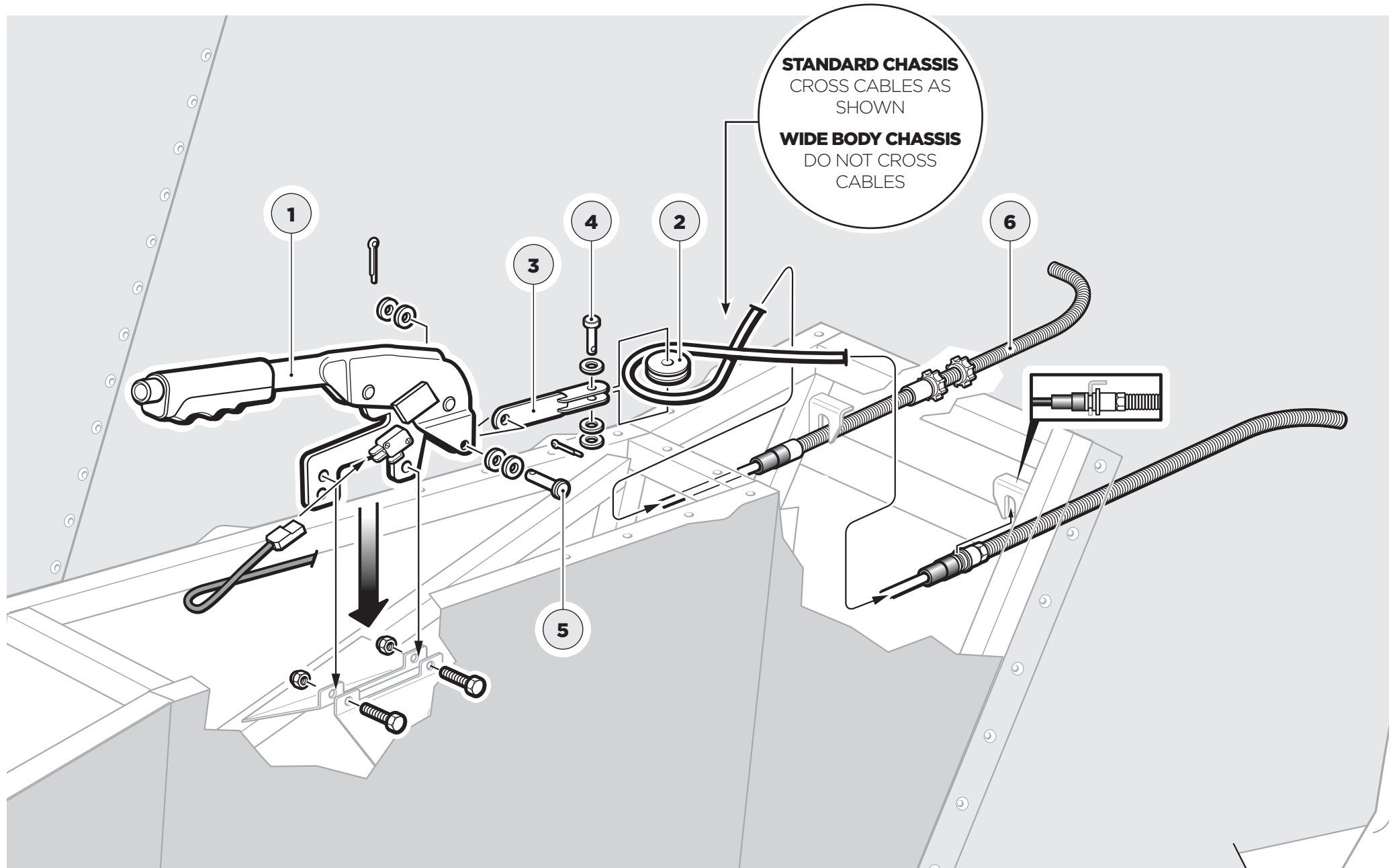
Handbrake wire connector goes to top of terminal & ties up.

Jamie A

After plugging in connector, cable tie and secure any excess wiring.

Dan P

FITTING THE HANDBRAKE



SLIDE IN THE PROPSHAFT

PARTS

- 1 Propshaft

TOOLS



FIXINGS

TIPS

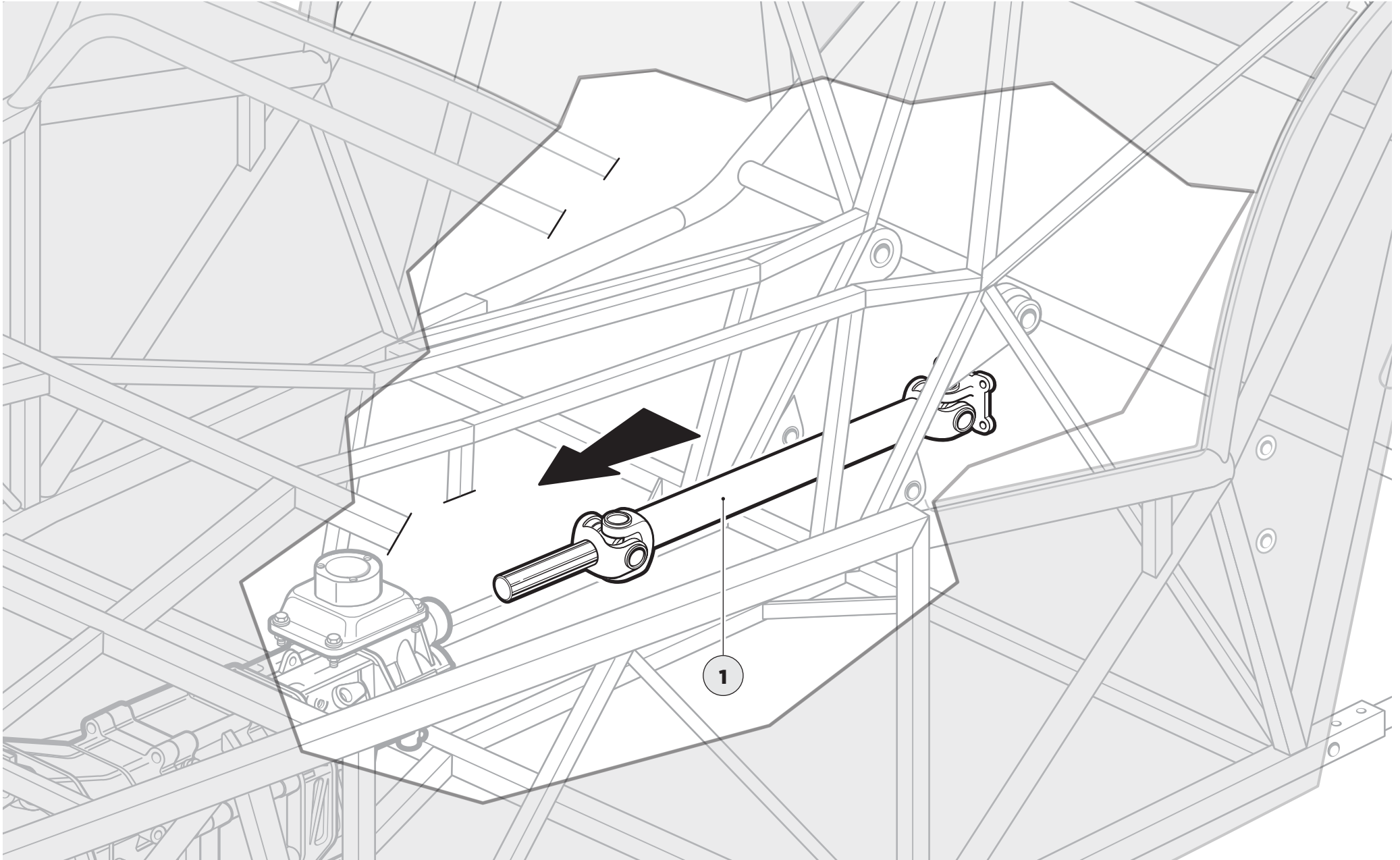
Line the splines in the propshaft to the gearbox.

Anthony L

Grease prop if necessary, it will have a grease nipple.

John S

SLIDE IN THE PROPSHAFT

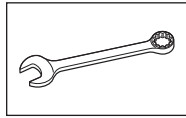
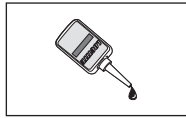
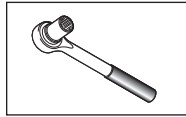
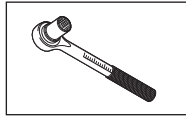
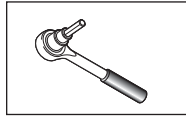




HEAVY STUFF: FITTING THE DIFF












PARTS



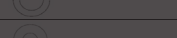



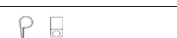
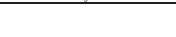

1 Differential

TOOLS

	19mm		
	19mm		
	10mm 8mm		Extension
			

FIXINGS

ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Bolt 1/2" x 11" LNF	BP12X11	1	Upper diff mounting bolt	
2	Caphead Bolt M12 x 55 Grade 10.9	BMCH12X55	2	Lower diff mounting bolt	
3	Bolt M10 x 55 Grade 10.9	BM10X55	4	Rear hub through axle to front DeDion	
4	Bolt M10 x 55 Grade 10.9	BM10X55	8	3 x 4 Front hub through ear x 4 Caliper carrier bolts	
5	Bolt M10 x 55 Grade 10.9	BM10X55	4	Through rear of axle into reversed DeDion tubes	
6	Caphead Bolt M12 x 25 Grade 12.9	BMCH12X25	4	Propshaft bolts	
7	Caphead Bolt M12 x 25 Grade 12.9	BMCH12X25	2	Diff cage	
8	Half Nuts 1/2" Type	NFY1/2	1	Upper diff bolt	
9	Nut M10	NM10	8	Hub through axle to DeDion	
10	1/2" x 5/8" Nut	NM1/2	4	Rear axle roll bar brackets	
11	Plain washer 1/2" x 3/4"	W1/2X3/4	2	Brake pipe	

ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
12	Plain washer 1/2" x 3/4" Thin	W1/2X3/4	16	Flats behind diff shells	
13	Plain washer 1/2" x 3/4" Thin	W1/2X3/4	8	Free play on diff	
14	Plain washer 1/2" x 3/4" x 1/16" Thick	W1/2X3/4	16	Diff shim washers	
15	Washer M12	W12X12	16	Rear DeDion Carrier Carrier Hub	
16	Spring Washer M12	WS12X12	16	Rear DeDion Tube Carrier Carrier	
17	Softener washer M12	WS12	4	Behind bolt heads on diff	
18	Reinforced washer 1/2"	W1/2X1/2	1	Braked brake hose	
19	Rear 1/2" x 5/16"	1/2X5/16	5	P-clips on DeDion for brake pipe	
20	P-Clip	PK1	5	Brake pipe on DeDion	

* Use as required for spacing

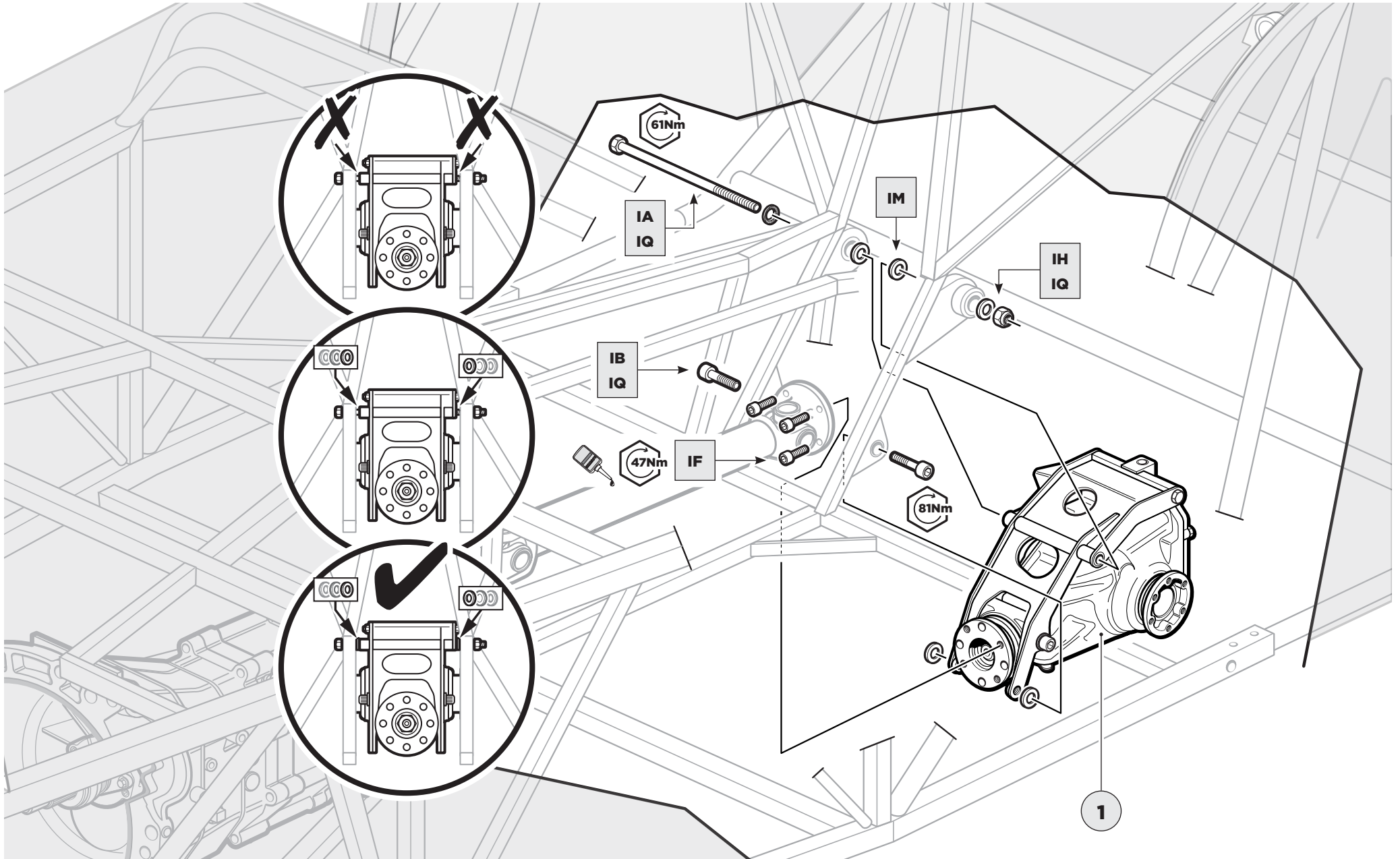
TIPS

Start at bottom right with spanner & work your way around.
Chris B

Make sure propshaft is in first!
Harry P

Lower diff bolts may require more than one washer – try to keep them even.
Tiago O

HEAVY STUFF: FITTING THE DIFF



FILL THE DIFFERENTIAL WITH OIL

P A R T S

T O O L S

Differential oil

F I X I N G S

T I P S



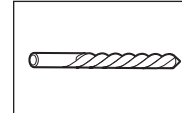
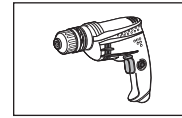
Differential = 0.8L

PREPARING THE DEDION TUBE

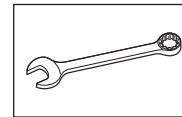
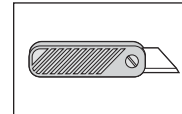
PARTS

- 1 DeDion tube
- 2 LHS brake pipe
- 3 RHS brake pipe
- 4 3 way union
- 5 Brake hose

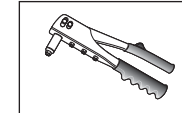
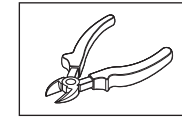
TOOLS



1/8"



11mm
13mm
14mm



FIXINGS

Pack H		CATERHAM		53
				PACK NUMBER
				30R01TD
REAR SUSPENSION DEDION METRIC				
This pack may include extra fasteners to cover different options				
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON
1	Roller Ball 1/2" Dia. (Check 10.9)	SM124100	2	A-frame front mountings
2	Caphead Bolt M10 x 6.0	SM121000	2	Front radius arm (through cockpit)
3	Nut 1/2" x 2.25" (Check 10.9)	SM123012	4	x 2 Lower Race Damper x 2 Rear Radius Arm
4	Roller Ball M8 x 6.0 (Check 10.9)	SM123010	4	Rear Axle Roll Bar Mounting Blocks
5	Roller Ball 1/2" x 2.25" (Check 10.9)	SM123012	4	A-frame to DeDion
6	Roller Ball 1/2" Dia.	SM121000	3	x 2 Rear Radius Arm x 1 A-frame to DeDion
7	Roller Ball M12	SM121012	2	A-frame front mountings
8	Roller Ball M10	SM121010	2	Front radius arm (through cockpit)
9	Roller Ball M8	SM121008	2	Rear Axle Roll Bar Drop Link
10	Roller Ball M8	SM121008	4	Rear Axle Roll Bar Mounting Blocks
11	HK Metric Nut M4	SM121004	1	3-way union on DeDion tube

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

x1

Pack I		CATERHAM		44
				PACK NUMBER
				30Z1067B
AXLE DEDION METRIC				
This pack may include extra fasteners to cover different options				
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON
1	Roller Ball 1/2" Dia. (Check 10.9)	SM124100	1	Upper roll mounting bush
2	Caphead Bolt M10 x 6.0 (Check 10.9)	SM121000	2	Lower roll mounting bush
3	Roller Ball M10 x 6.0 (Check 10.9)	SM123010	4	Rear roll through ear to front DeDion
4	Roller Ball M10 x 6.0 (Check 10.9)	SM123010	8	x 4 Front roll through ear x 4 Caphead capnut bush
5	Roller Ball M10 x 6.0 (Check 10.9)	SM123010	4	Through rear of upper threaded DeDion tubes
6	Caphead Bolt M10 x 6.0 (Check 10.9)	SM121000	4	Frontroll bush
7	Caphead Bolt M10 x 6.0 (Check 10.9)	SM121000	2	Off rafter
8	Roller Ball 1/2" Dia. (Check 10.9)	SM124100	1	Upper roll bush
9	Roller Ball M10	SM121010	8	Hub through ear to DeDion
10	1/2" Roller Ball M8	SM121008	4	Rear axle roll bar dropnut
11	HK Plain washer 3/8" x 7/8"	SM121003	2	Brake pipe

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

x2

Pack I		CATERHAM		44
				PACK NUMBER
				30Z1067B
AXLE DEDION METRIC				
This pack may include extra fasteners to cover different options				
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON
12	Flare washer 1/2" x 7/8"	SM122010	10	Flare locking off nut
13	Flare washer 1/2" x 3/4"	SM121010	8	Flare plug on off
14	Flare washer 1/2" x 3/4" x 1/4" Thick	SM122010	14	Off shim washers
15	Washer M10	SM121010	10	Rear DeDion Caliper Carrier Hub
16	Spring Washer M10	SM122010	10	Rear DeDion Taper Caliper Carrier
17	Spring Washer M10	SM122010	4	Behind ball tracks on off
18	Shakespeare 3/8"	WES38	1	Braided brake hose
19	Roller 1/8" x 3/8"	1661-0414	3	P-clips on DeDion for brake pipe
20	P-clip	NX1	5	Brake pipe on DeDion

Drawings are for illustrative purposes only and are not to scale. Page 2 of 2

x1
x5
x5

Brake pipe washers and nuts are included with the hose

TIPS

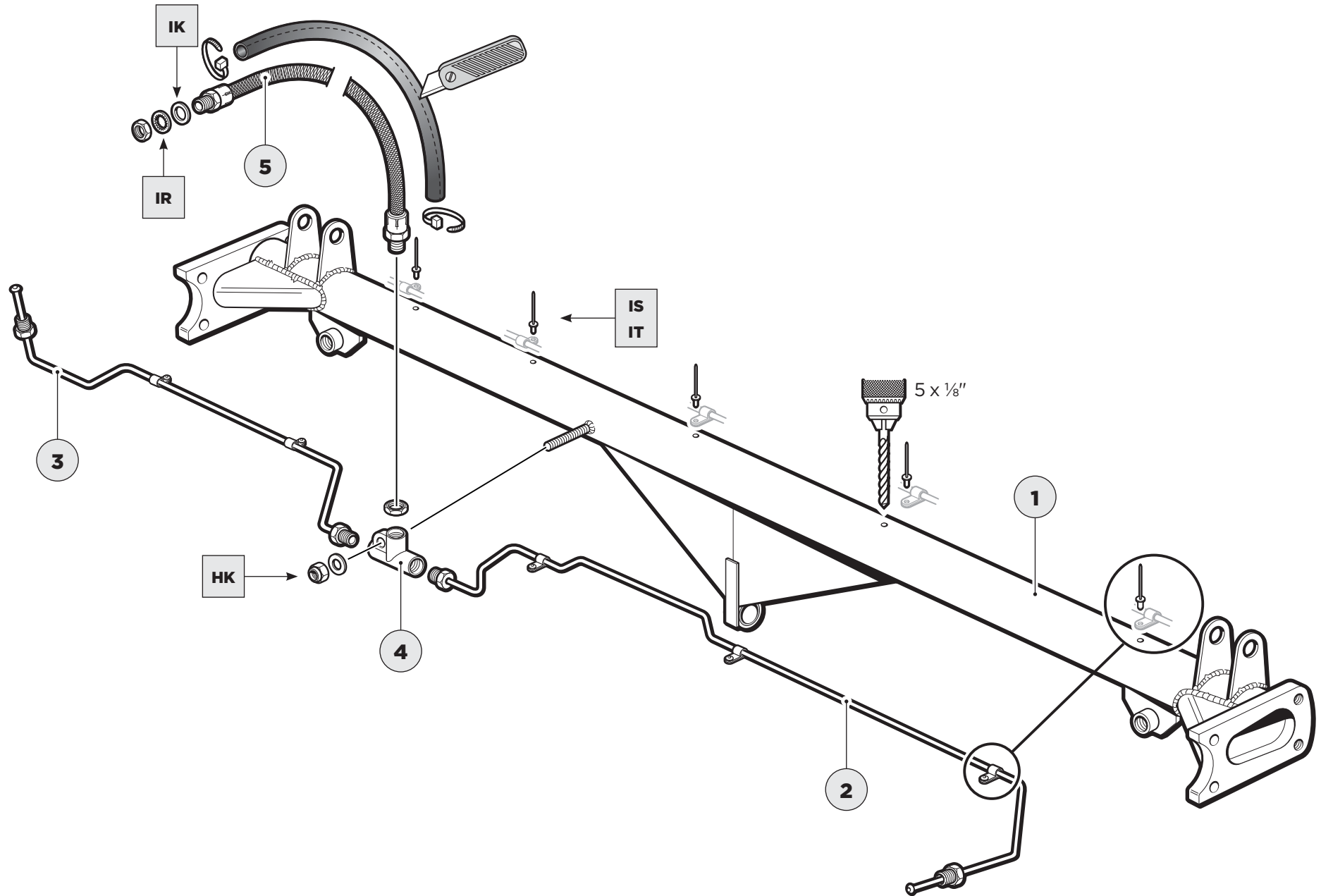
The upper brake hose fittings will become self explanatory on the rear damper installation page.

John K

Tighten the braided pipe 5 into the union before nipping up the locknut.

Chris N

PREPARING THE DEDION TUBE



AND FITTING IT IN PLACE

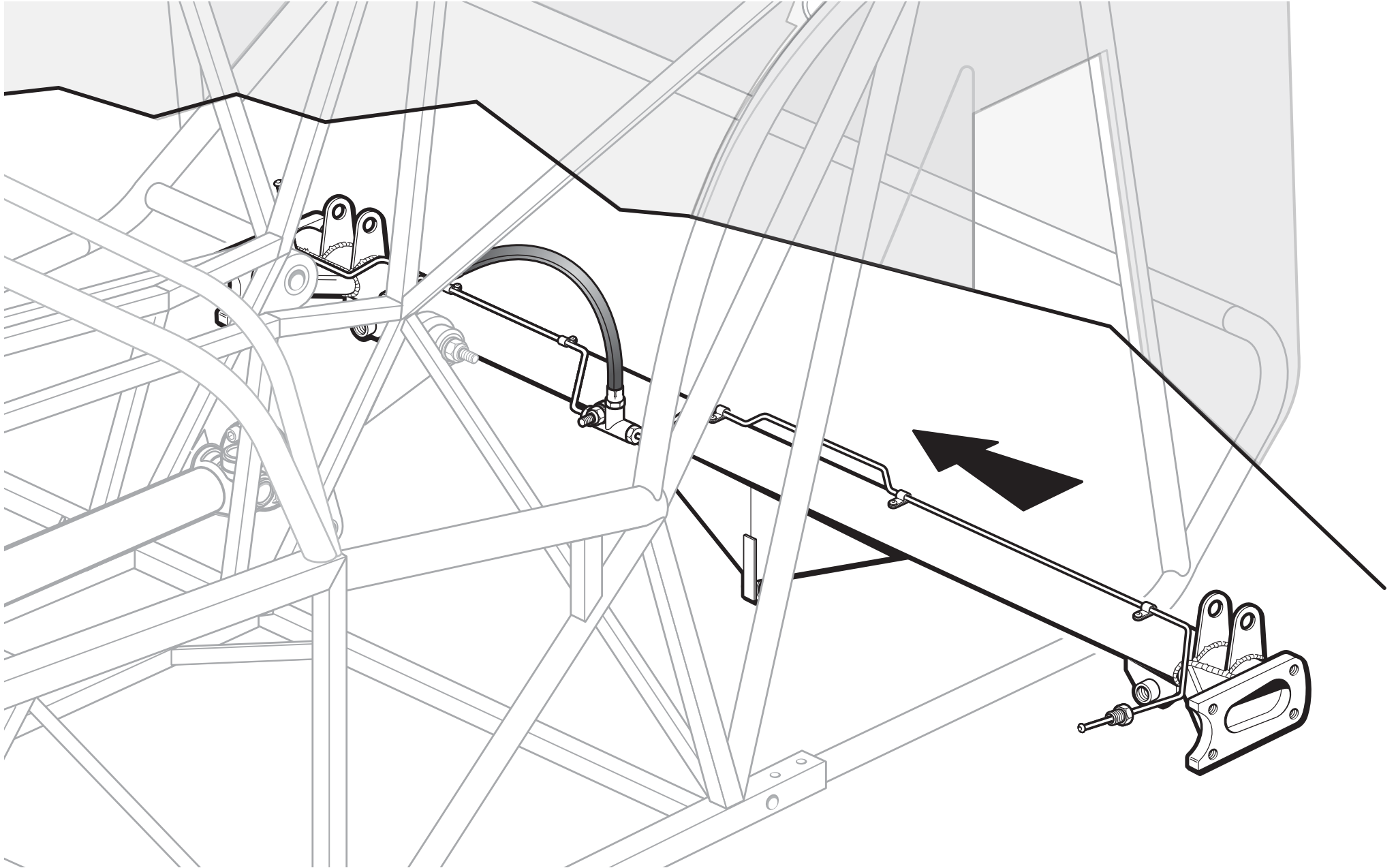
P A R T S

T O O L S

F I X I N G S

T I P S

AND FITTING IT IN PLACE

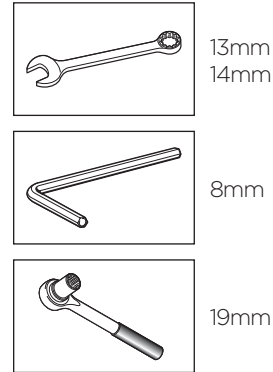


ATTACHING THE REAR DAMPERS

PARTS

- 1 Rear damper assembly
- 2 Rear damper sleeve

TOOLS



FIXINGS

ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Ball Joint 1.90 (Grade 10.9)	BM124100	2	A-frame front mountings	
2	Coilover Rod (10 x 1.5)	RC1211000	2	Front radius arm (through coilover)	
3	Bar 10" x 2.15" (Grade 10.9)	BF1202102	4	x 2 Lower Rear Damper x 2 Rear Radius Arm	
4	Roller 10 x 40 (Grade 10.9)	BAW100	4	Rear Anti Roll Bar Mounting Blocks	
5	Roll 10" x 2.25" (Grade 10.9)	BF1202104	1	A-frame to DeCleon	
6	Roller 10" x 40 (Grade 10.9)	BAW101	3	x 2 Rear Radius Arm x 1 A-frame to DeCleon	
7	Nuts 10 x 1.5	NAW101	2	A-frame front mountings	
8	Nuts 10 x 1.5	NAW102	2	Front radius arm (through coilover)	
9	Nuts 10 x 1.5	NAW100	2	Rear Anti Roll Bar Drop Link	
10	Nuts 10 x 1.5	NAW100	4	Rear Anti Roll Bar Mounting Blocks	
11	Nuts 10 x 1.5	NAW104	1	Roller 10" x 40 (Grade 10.9)	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

x2

ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
12	Roller	7620	10	Differential isolation	
13	Plain Washer 1/2" (Chamfered)	WFH1/2	20	x 2 Lower Damper x 10 A-frame washers x 4 Radius Arm	
14	Plain Washer 10" x 1.5"	WPH10X1.5	2	Front Radius Arm	
15	Plain Washer 10"	WPH10	4	Rear Anti Roll Bar Mounting Block	
16	Shim Washer M12	3021008A	2	Lower Damper	

Drawings are for illustrative purposes only and are not to scale. Page 2 of 2

x4

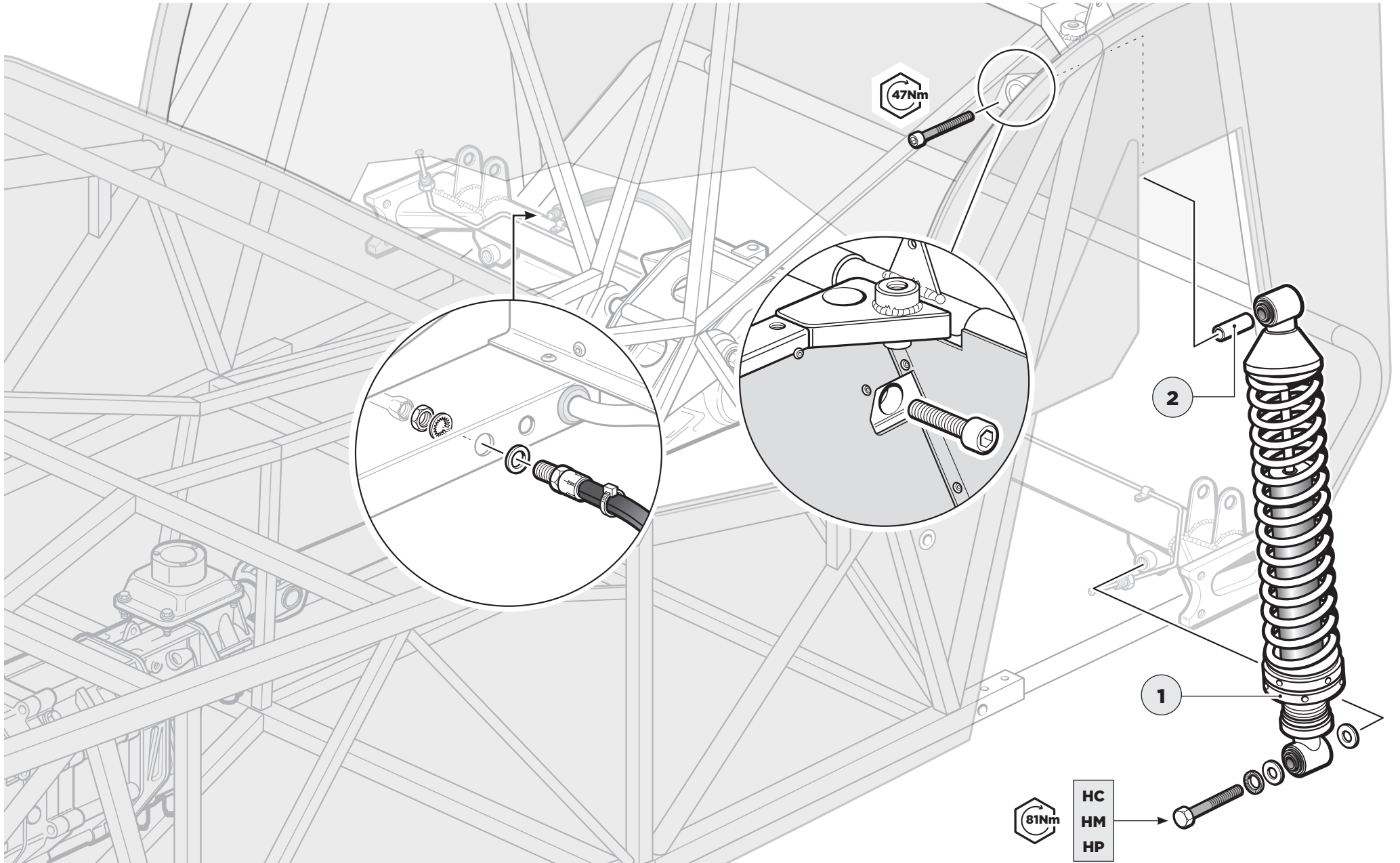
x2

TIPS

Although we show the fitting of the dampers here as part of the rear suspension, it is better to leave this step until you've fitted the roll over bar much later in the process.

Jamie A

ATTACHING THE REAR DAMPERS

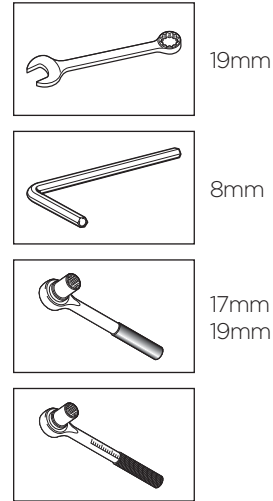


THEN THE RADIUS ARM

PARTS

1 Radius arm

TOOLS



FIXINGS

Pack H		CATERHAM		53	
		PACK NUMBER		30R011D	
REAR SUSPENSION DEDION METRIC					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Half Metric 1/2" (12.7mm) Grade 10.9	SM12X120	2	A-frame front mountings	
2	Caphead Bolt M10 X 65	RMCH10X65	2	Front radius arm (through cockpit)	
3	Bolt 1/2" x 2.125" Grade 10.9	BF12X2.125	4	x 2 Lower Rear Damper x 2 Rear Radius Arm	
4	Half Metric X-40 (Grade 10.9)	RMX40	4	Rear Axle Roll Bar Mounting Blocks	
5	Half 1/2" x 2.125" (Grade 10.9)	BF12X2.125	1	A-frame to DeDion	
6	Half Metric 1/2" (12.7mm)	NFY1212	3	x 2 Rear Radius Arm x 1 A-frame to DeDion	
7	Hex Nut M12	NM1212	2	A-frame front mountings	
8	Nylon Nut M10	NM1010	2	Front radius arm (through cockpit)	
9	Hex Nylon Nut	NM1010	2	Rear Axle Roll Bar Drop Link	
10	Hex Nut M8	NM808	4	Rear Axle Roll Bar Mounting Blocks	
11	Hex Nut M10	NM1010	1	1/2" (12.7mm) nylon on DeDion tube	

x2

x2

x2

x2

Pack H		CATERHAM		53	
		PACK NUMBER		30R011D	
REAR SUSPENSION DEDION METRIC					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
12	Washer	7620	10	Differential Isolation	
13	Plain Washer 1/2" (12.7mm)	WPH12	20	x 2 Lower Damper x 10 A-frame washers x 6 Radius Arm	
14	Plain Washer 3/8" x 1/8"	WPH3/8X1/8	2	Front Radius Arm	
15	Plain Washer 1/4"	WPH1/4	4	Rear Axle Roll Bar Mounting Block	
16	Conical Washer M10	SW1010A	2	Lower Damper	

x4

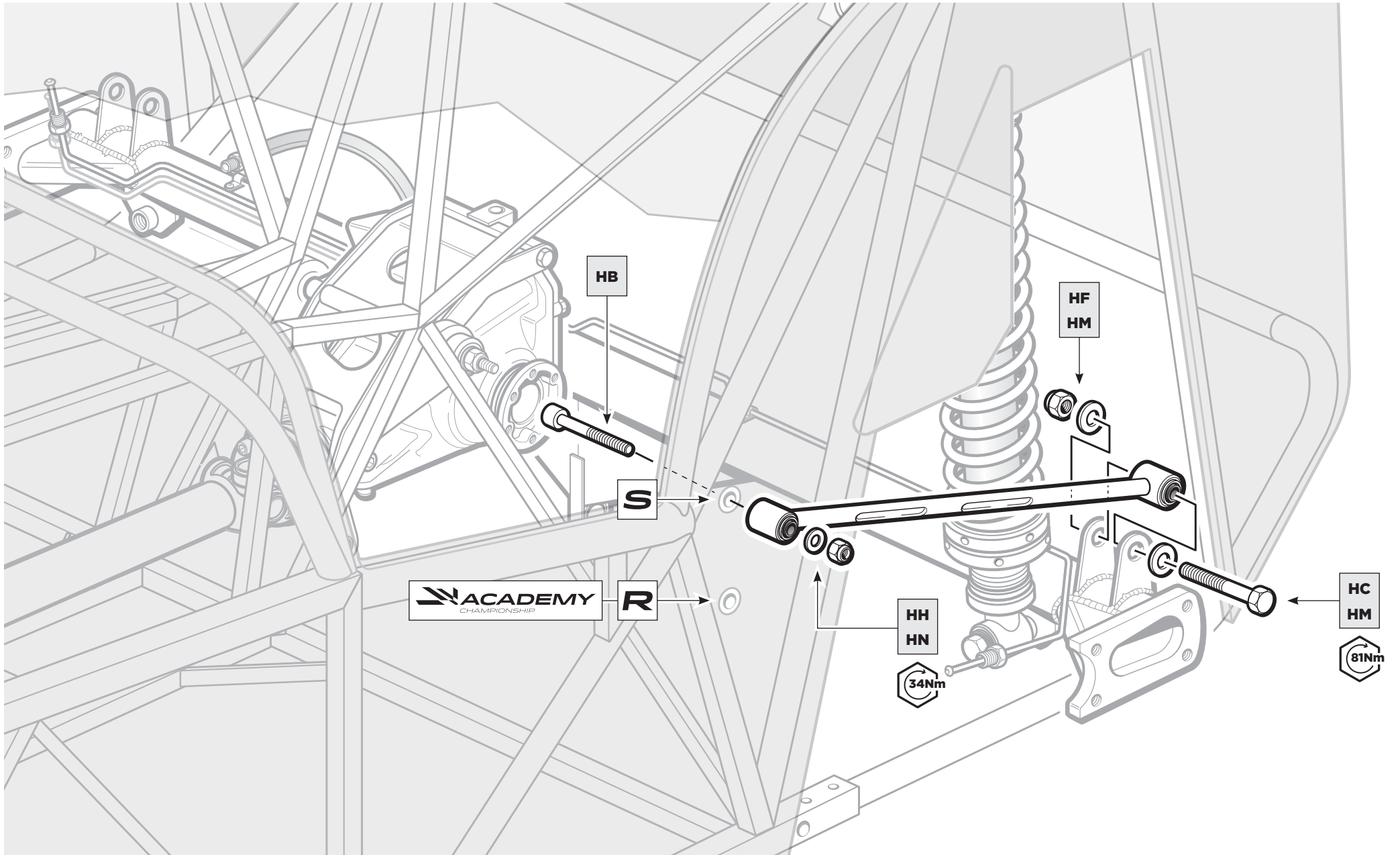
x2

TIPS

Before torquing up these bolts, reposition the axle stands to under the DeDion tube (to hold up the suspension). Make sure front has two axle stands so it is steady when jacking up the rear!

Mick F

THEN THE RADIUS ARM

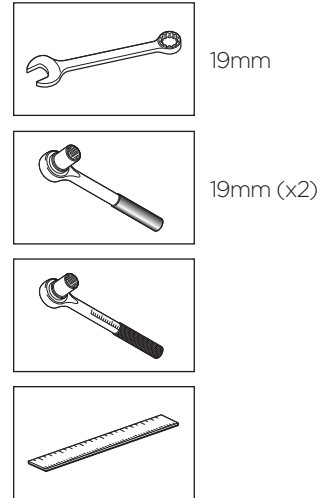


AND NOW THE (CAREFULLY SPACED) A-FRAME

PARTS

- 1 A-frame
- 2 White nylon anti-squeak washers

TOOLS



FIXINGS

Pack H		CATERHAM		53	
		PART NUMBER		30R01TD	
REAR SUSPENSION DEDION METRIC					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Ball B12 X 100 Grade 10.9	BM12X100	2	A-frame front mountings	
2	Cuphead Bolt M12 x 100	BM12X100	2	Front radius arm through cuphead	
3	Bush 12x12 x 2.2" Grade 10.9	BF12X2.2	4	x 2 Lower Rear Champs x 2 Rear Radius Arm	
4	Roller M6 x 40 Grade 10.9	BM6X40	4	Rear Anti Roll Bar Mounting Blocks	
5	Ball 12" X 2.2 3rd Grade 10.9	BF12X2.2A	1	A-frame to DeDion	
6	Half Nylon 12" Tube	NFY12	3	x 2 Rear Radius Arm x 1 A-frame to DeDion	
7	Nylon Nut M12	NMY12	2	A-frame front mounts	
8	Nylon Nut 10.9	NMY10.9	2	Front radius arm through cuphead	
9	Half Nylon 10.9	NFY10.9	2	Rear Anti Roll Bar Drop Link	
10	Nylon Nut 10.9	NMY10.9	4	Rear Anti Roll Bar Mounting Blocks	
11	Nylon Nut 10.9	NMY10.9	1	x 1 Nylon union on DeDion tube	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 2

x2

x1

x1

x2

Pack H		CATERHAM		53	
		PART NUMBER		30R01TD	
REAR SUSPENSION DEDION METRIC					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
12	Washer	W020	10	Differential Isolation	
13	Plain Washer 1/2" Chamfered	WFH1/2	20	x 2 Lower Champs x 10 A-frame washers x 4 Radius Arm	
14	Plain Washer 3/4" x 3/4"	WFH3/4	2	Front Radius Arm	
15	Plain Washer 1/2"	WFH1/2	4	Rear Anti Roll Bar Mounting Block	
16	Lower Washer M12	SW12016A	2	Lower Champs	

Drawings are for illustrative purposes only and are not to scale. Page 2 of 2

*

* Use as required for spacing

TIPS

Make sure the DeDion tube is equal on both sides.

Tiago O

Use as many HM washers as required to space A-frame.

John K

The A-frame has a 'way up'. The arms should be offset downwards in relation to the front bushes.

Chris N

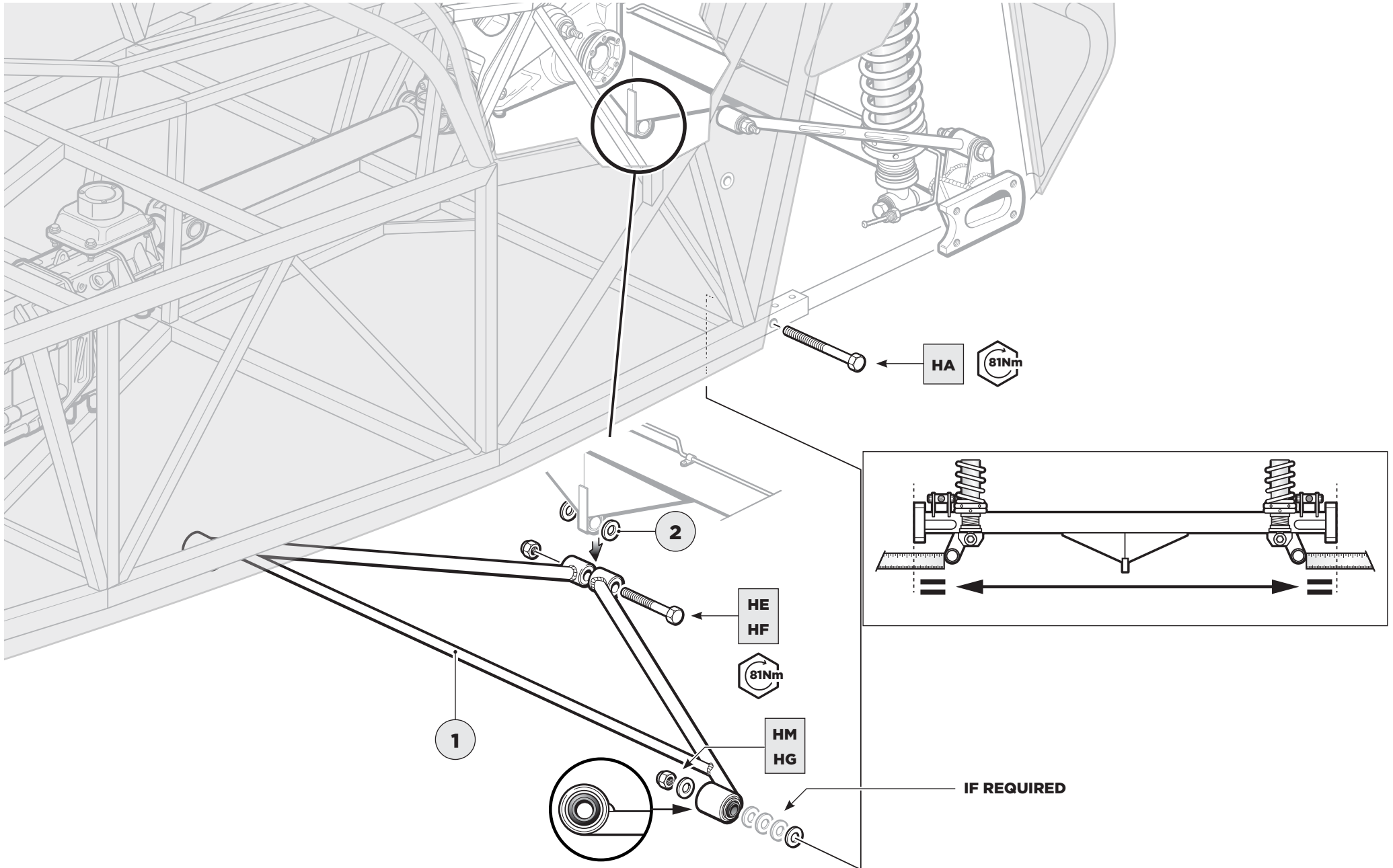
Take care to use the correct nuts as there is a mixture of metric and imperial here.

Lee A

Torque up as before on axle stands.

Rich T

AND NOW THE (CAREFULLY SPACED) A-FRAME

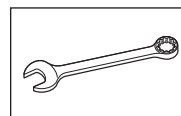
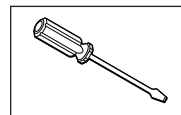
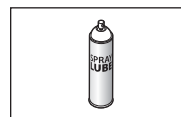


IF YOU HAVE THE OPTIONAL REAR ANTI-ROLL BAR, IT GOES ON LIKE THIS

PARTS

- 1 Rear anti roll bar
- 2 Anti roll bar rubber
- 3 Rear anti roll bar clamp

TOOLS



10mm



10mm

FIXINGS

Pack H		CATERHAM		53	
		PART NUMBER		30R011D	
REAR SUSPENSION DEDION METRIC					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Roll Over 2.0" (50.8mm) Clutch 10.5"	BM724100	2	A-frame front mountings	
2	Clutch Bar 10" x 0.5"	BM721000	2	Front radius arm (through clutch)	
3	Roll Over 2.0" (50.8mm) Clutch 10.5"	BM724102	4	X 2 Lower Rear Clamps X 2 Rear Radius Arm	
4	Bolt M8 x 40 Clutch 10.5"	BM6X80	4	Rear Anti Roll Bar Mounting Blocks	
5	Roll Over 2.0" (50.8mm) Clutch 10.5"	BM724104	1	A-frame to DeClutch	
6	Roll Over 10" (254mm)	BM711012	3	X 2 Rear Radius Arm X 1 A-frame to DeClutch	
7	Nylon Nut M12	BM711012	2	A-frame front mountings	
8	Nylon Nut M10	BM711012	2	Front radius arm (through clutch)	
9	Roll Over 10" (254mm)	BM711016	2	Rear Anti Roll Bar Drop Link	
10	Nylon Nut M8	BM711016	4	Rear Anti Roll Bar Mounting Blocks	
11	Nylon Nut M10	BM711016	1	X 1 Nylon nut on DeClutch tube	

x4

x4

Pack H		CATERHAM		53	
		PART NUMBER		30R011D	
REAR SUSPENSION DEDION METRIC					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
12	Washer	W620	10	Differential isolation	
13	Plain Washer 10" (254mm)	W1010	20	X 2 Lower Clamps X 10 A-frame washers X Radius Arm	
14	Roll Over 10" (254mm)	W1010X10	2	Front Radius Arm	
15	Plain Washer M8	W1010	4	Rear Anti Roll Bar Mounting Block	
16	Lower Clamps M10	LC1010	2	Lower Clamps	

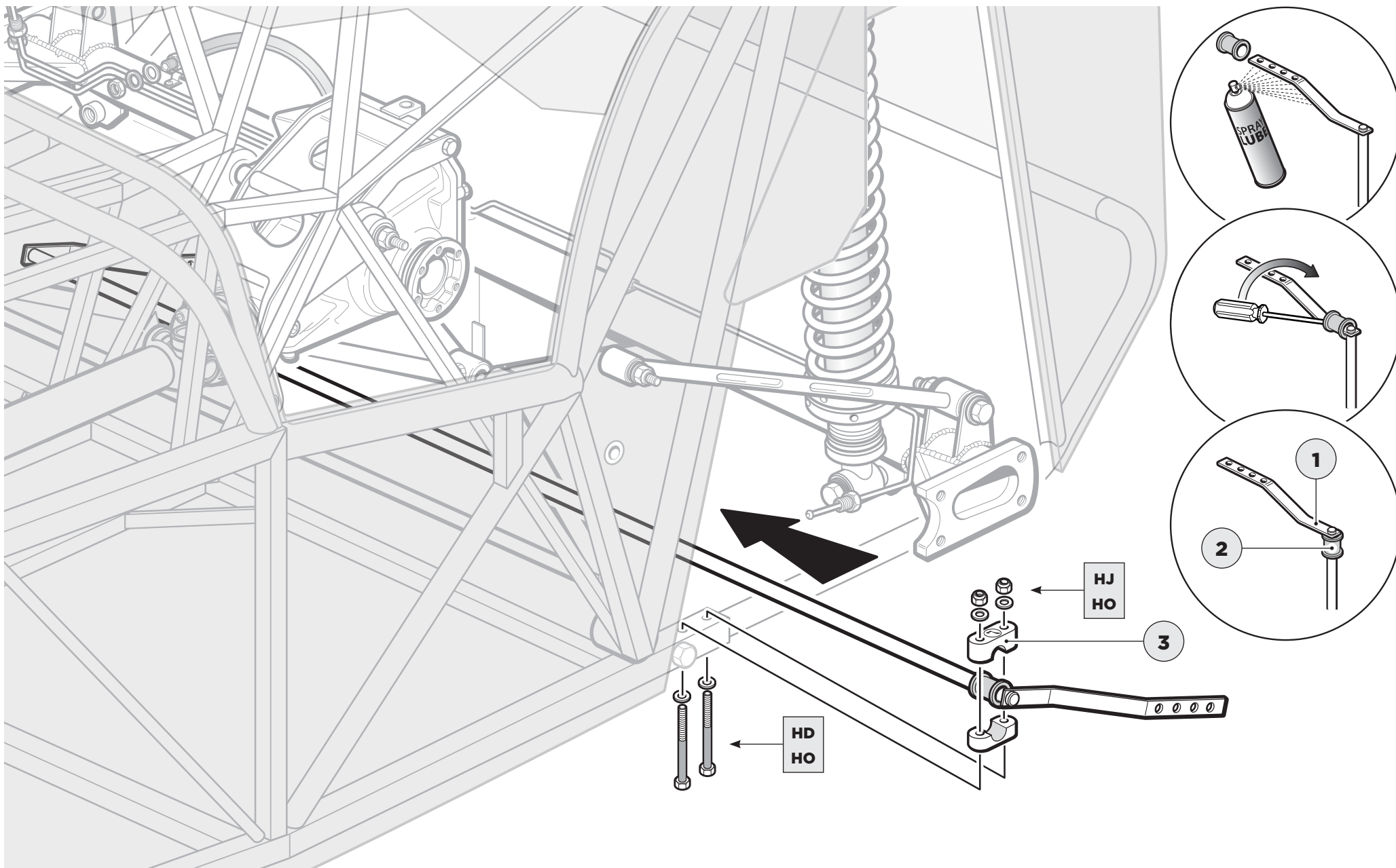
x8

TIPS

Be careful not to slip with the screwdriver!

John S

IF YOU HAVE THE OPTIONAL REAR ANTI-ROLL BAR, IT GOES ON LIKE THIS



INSERT THE DRIVESHAFTS

PARTS

- 1 Driveshaft
- 2 Driveshaft nut

TOOLS

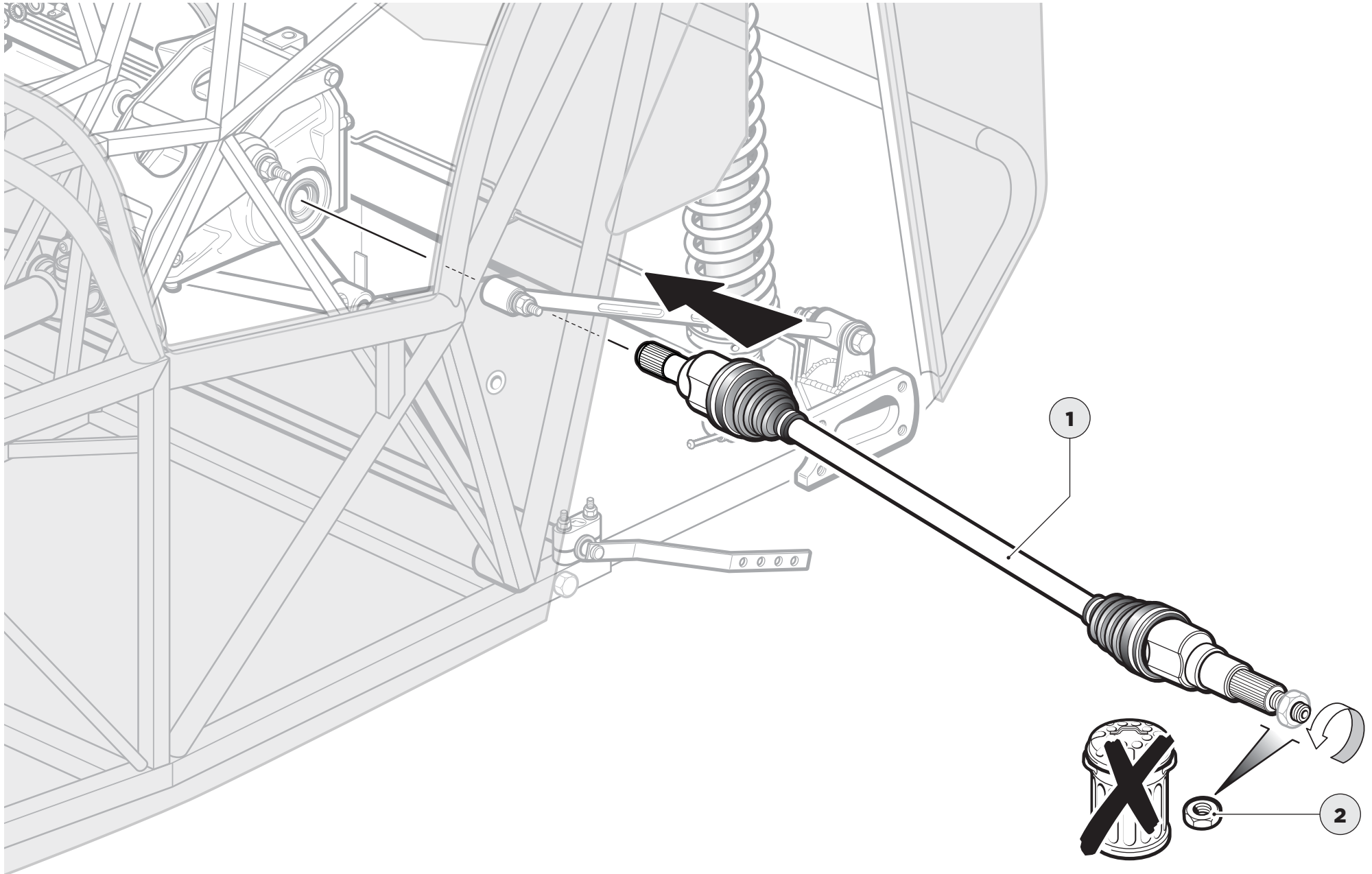
FIXINGS

TIPS

Driveshafts are handed, and so are the nuts, the left hand nut tightens anti-clockwise.

James A

INSERT THE DRIVESHAFTS

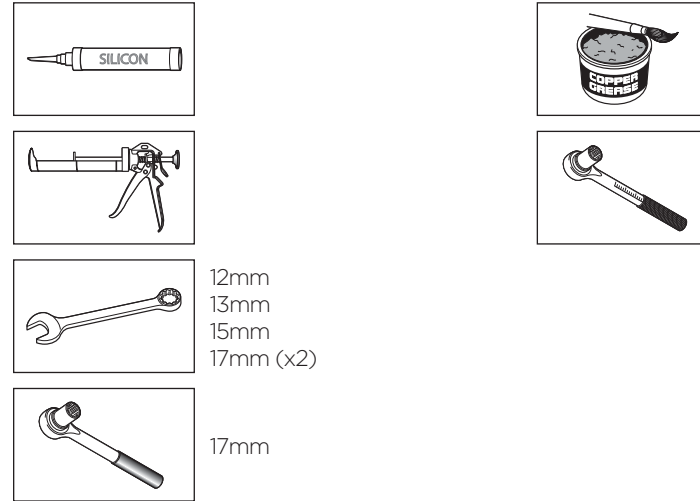


FITTING THE REAR HUB

PARTS

- 1** Rear brake disc / flange assembly
- 2** Rear hub
- 3** DeDion ear
- 4** Anti roll bar bracket
- 5** Anti roll bar drop link
- 6** Brake calliper
- 7** Brake calliper mount
- 8** Brake pads
- 9** Driveshaft nut
- 10** Driveshaft washer

TOOLS



FIXINGS

Pack 1		CATERHAM		44	
AXLE DEDION METRIC					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Hub 12" x 11" 404	BM12041	1	Upper roll mounting bolt	
2	Upper ear 12" x 11" 404	BM12042	2	Lower roll mounting bolt	
3	Bolt M10 x 55 Grade 10.9	BM10085	4	Rear hub through ear to front DeDion	
4	Bolt M10 x 55 Grade 10.9	BM10035	8	x 4 Front hub through ear x 4 Caliper carrier bolts	
5	Bolt M10 x 40 Grade 10.9	BM10040	4	Through rear of ear into threaded DeDion holes	
6	Upper ear 12" x 11" 404	BM12042	4	Proprietary bolts	
7	Upper ear 12" x 11" 404	BM12042	2	DR page	
8	Hub Nuts 12" x 11" 404	BM10112	1	Upper roll bolt	
9	Nylon Nut M10	NM1010	8	Hub through ear to DeDion	
10	1/2" Nylon Nut 180	NM1018	4	Rear anti roll bar droplink	
11	Hub washer 12" x 11" 404	BM10040	2	Brake pads	

x4
x8
x4
x8
x4

Pack 1		CATERHAM		44	
AXLE DEDION METRIC					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
12	Roller washer 12" x 11" 404	BM12047	16	Front bearing roll stops	
13	Roller washer 12" x 11" 404	BM12047	8	Front roller roll stops	
14	Roller washer 12" x 11" 404	BM12047	16	DR shims washers	
15	Washer M10	WM1010	16	Rear DeDion Caliper Carrier Hub	
16	Spring Washer M10	WSM1010	16	Rear DeDion Tube Caliper Carrier	
17	Ball joint bearing 12" x 11" 404	BM12047	4	Behind both hubs on DR	
18	Brake pad 12" x 11" 404	BM12047	1	Braked brake hose	
19	Roller 12" x 11" 404	BM12047	1	Roller on DeDion for brake pads	
20	Roller 12" x 11" 404	BM12047	5	Roller pins on DeDion	

x16
x8

TIPS

Swap the plain nuts on the droplinks for nylons.

Chris B

Remember the driveshaft nuts are handed.

Grant P

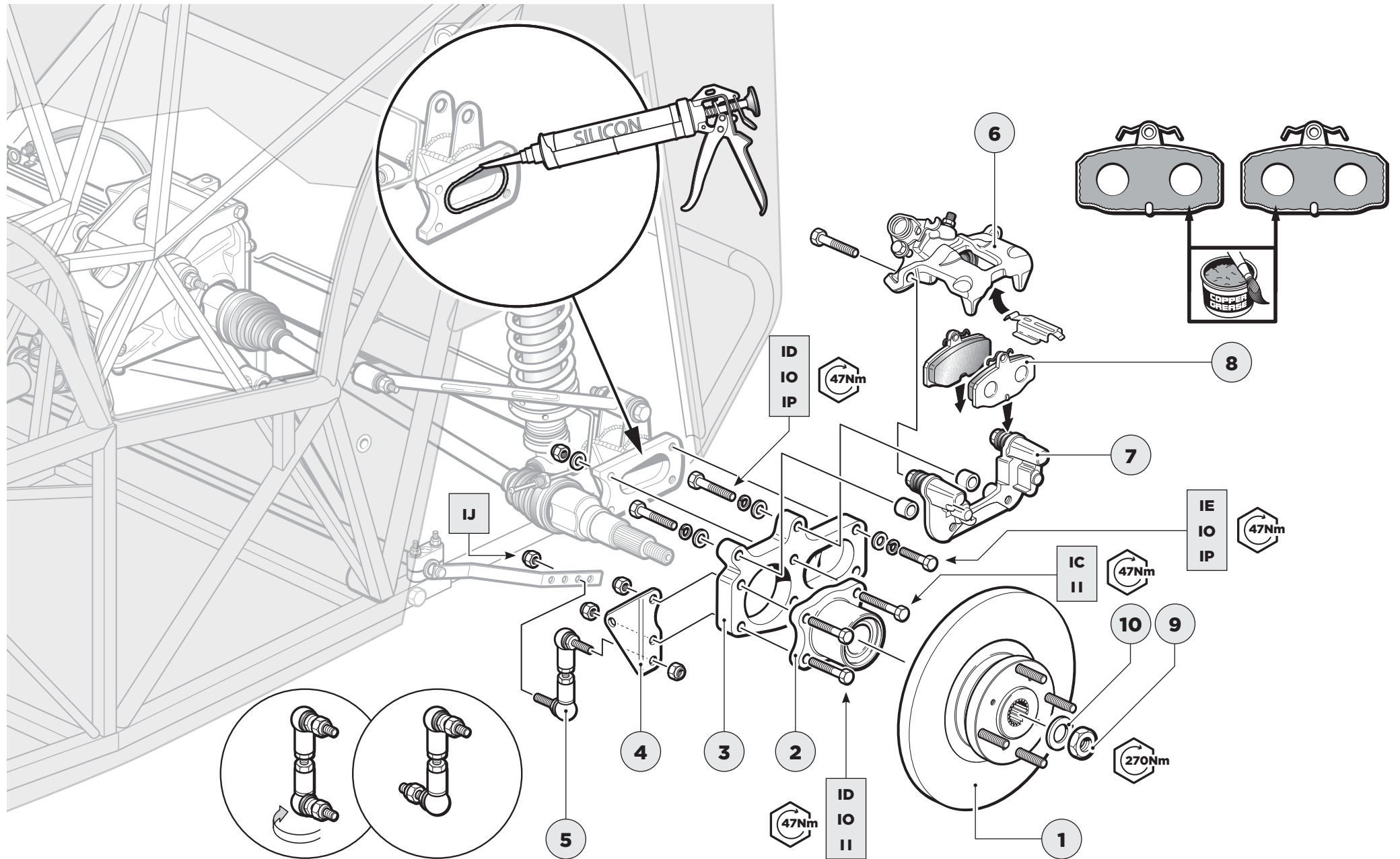
Torque up the bearing and ear before fitting the disc.

Dan D

If you don't have an anti roll bar you will only have one bracket (for the right hand side) which holds the speed sensor.

Rich T

FITTING THE REAR HUB

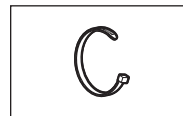


AND SPEED SENSOR (ONE SIDE ONLY)

PARTS

- 1 Speed sensor

TOOLS



FIXINGS

TIPS

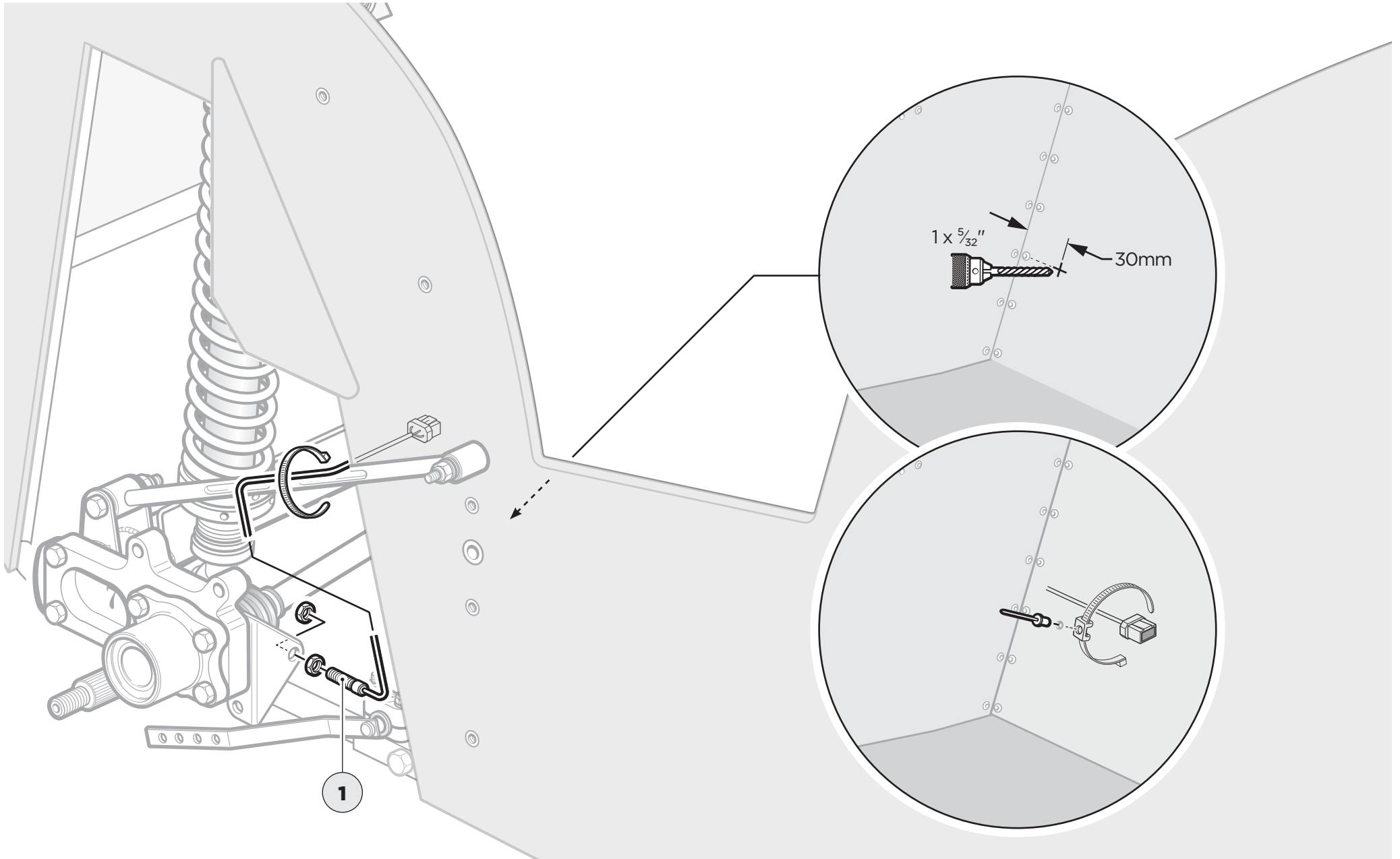
Ensure there is enough slack in the wire to allow for suspension travel.

Tiago O

Adjust sensor gap to approx. 0.8–0.9mm.

Lloyd D

AND SPEED SENSOR (ONE SIDE ONLY)





Now is a good time to take some photos



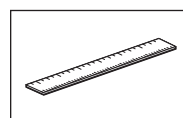
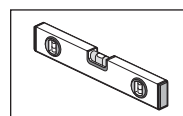
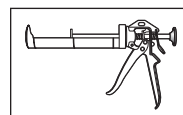
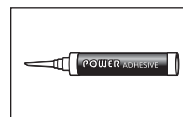
Have you applied for your IVA yet?

JUST WING IT

PARTS

- 1 Cycle wing
- 2 Wheel
- 3 Wheel nuts

TOOLS



FIXINGS

TIPS

Key the wing & wingstay before using adhesive.

John S

You may need to bend the arms of the wingstay to make the wing level.

Anthony L

The $\frac{1}{8}$ " hole you drilled earlier is for the indicator earth.

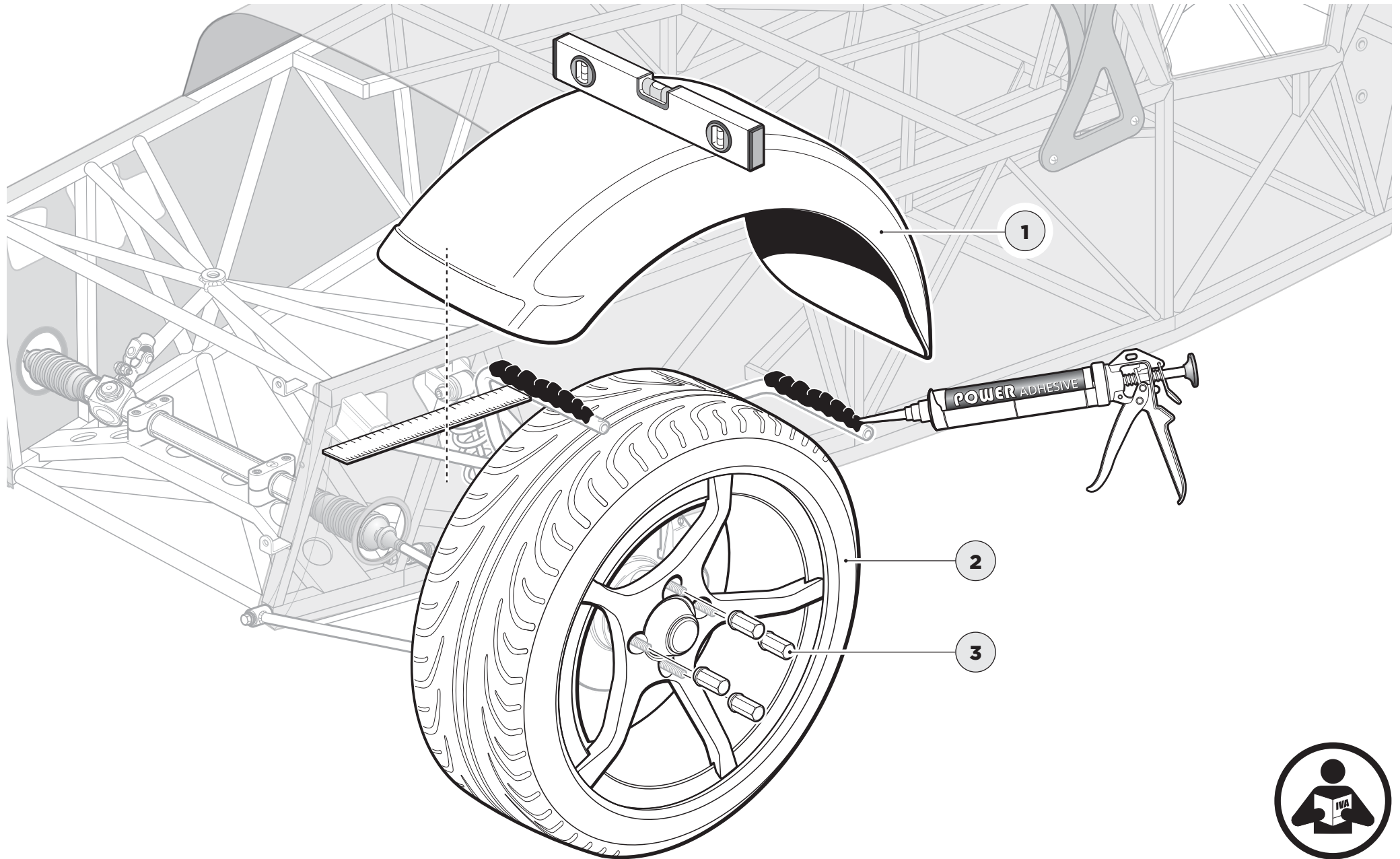
Harry P

The distance from the front edge of the wing to the wingstay should be 80mm.

Lee A

Do a 'dry run' first to make sure the wings are level before using power adhesive.

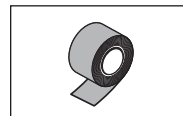
Chris N



TAPE IN PLACE FOR 24 HOURS

P A R T S

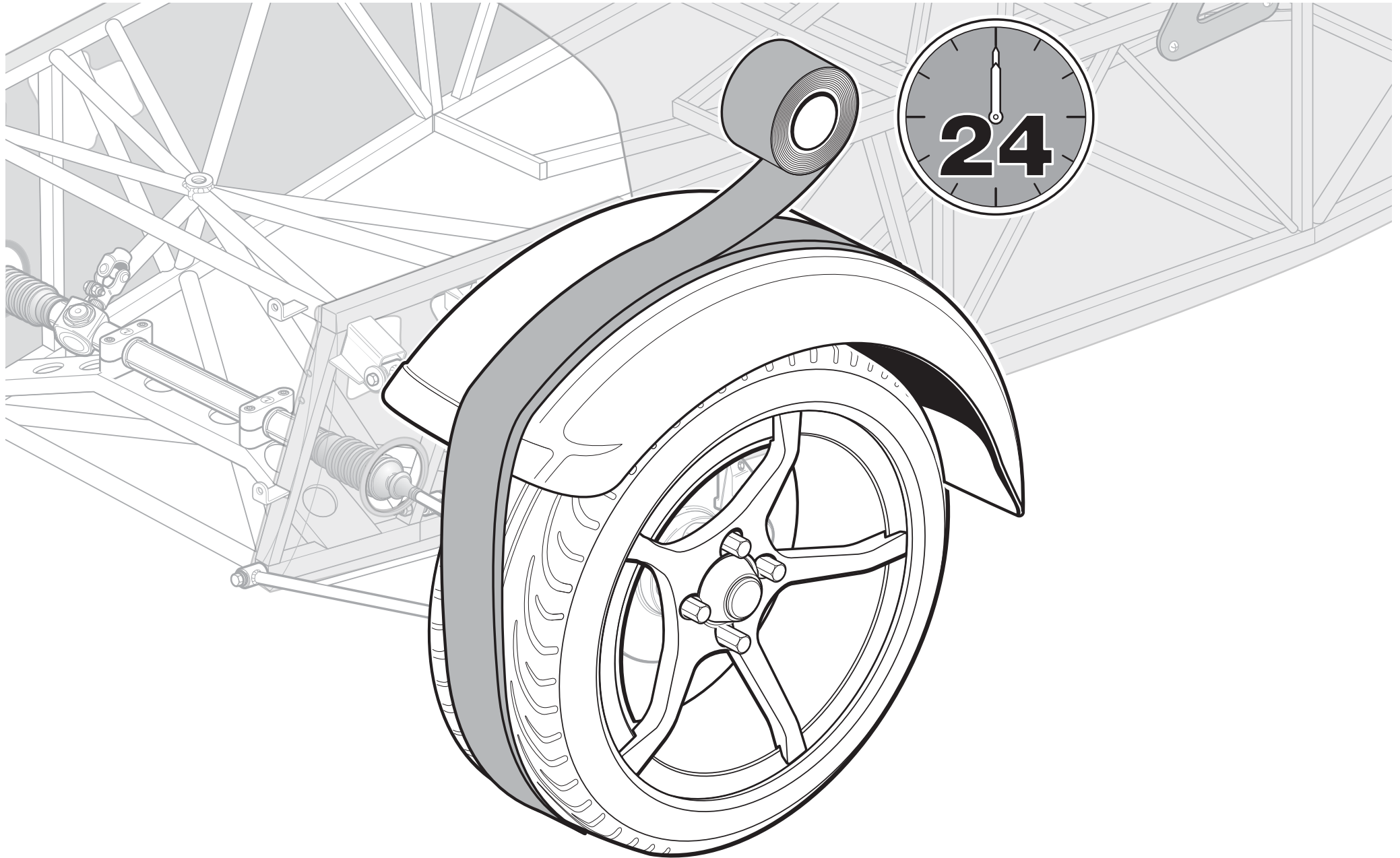
T O O L S



F I X I N G S

T I P S

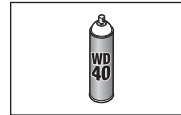
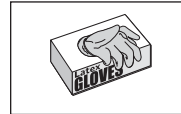
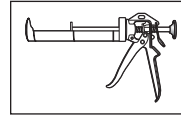
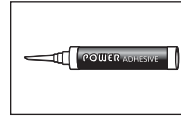
TAPE IN PLACE FOR 24 HOURS



SOME EXTRA ADHESIVE UNDERNEATH

PARTS

TOOLS



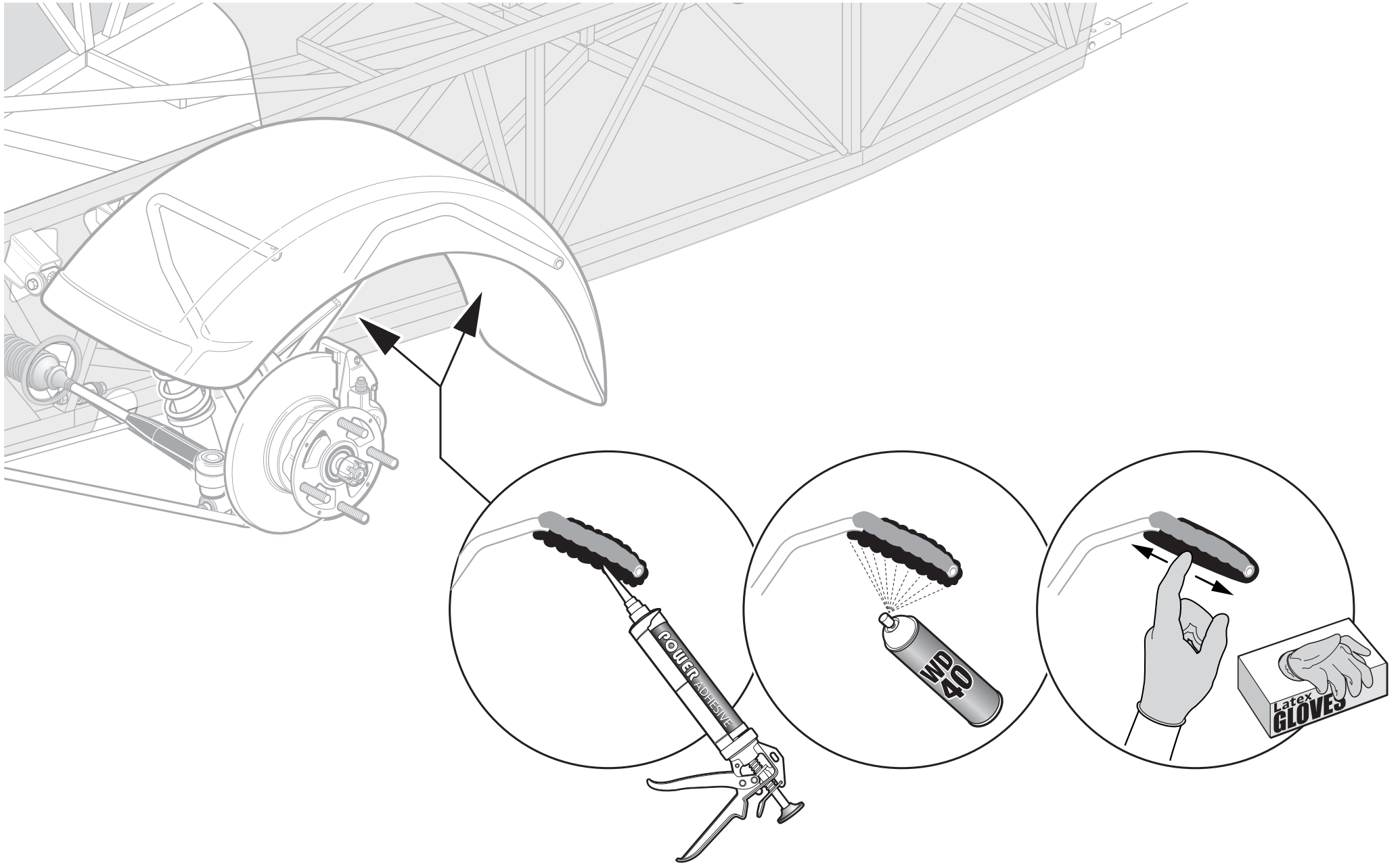
FIXINGS

TIPS

The WD40 will help spread the adhesive.

Mick F

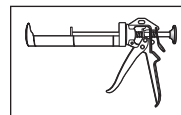
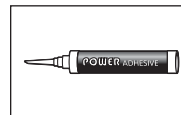
SOME EXTRA ADHESIVE UNDERNEATH



FINISH WITH TRIM

PARTS

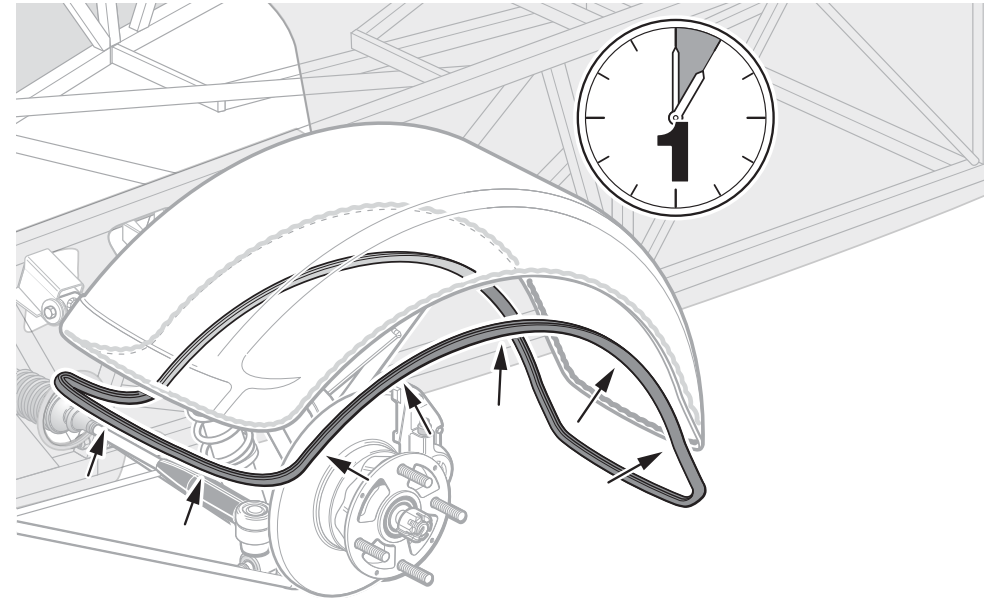
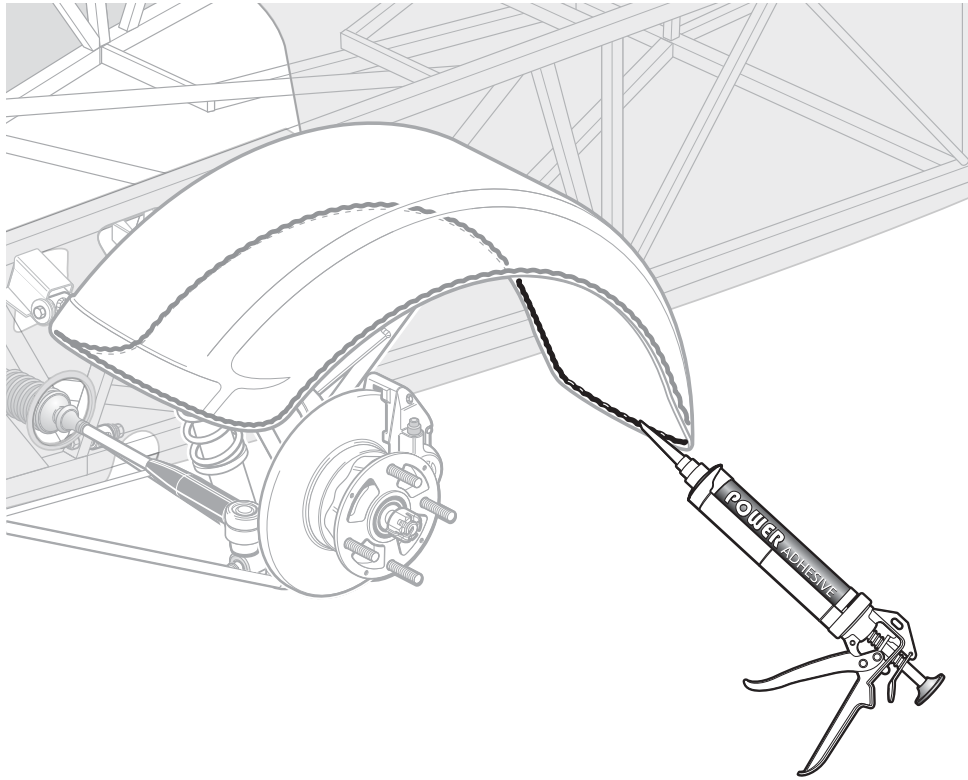
TOOLS



FIXINGS

TIPS

FINISH WITH TRIM

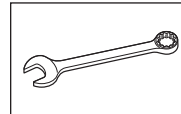
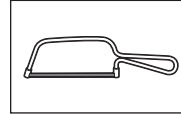
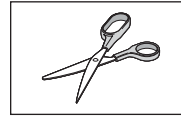


FITTING THE REAR WINGS

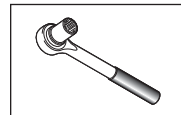
PARTS

1 Rear wing

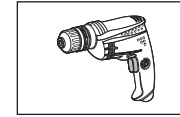
TOOLS



8mm



8mm



Sanding Drum

FIXINGS

Pack Q		CATERHAM		31		
		PART NUMBER		2FG12		
REAR WINGS						
This pack may include extra fasteners to cover different options						
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION	
1	OA	Self Drilling MS X 20	8MSX20	20	Rear Wings	
2	OB	Nylon Nut M5	N5NYS	10	Rear wings through boot	
3	OC	Flare Washer 3/16" X 3/4"	WPS16X3/4	30	Wing washers	
4	OD	Wing Pin 1/4" X 1"	7602	4	Between wing and body	

x20

x10

x30

x4

TIPS

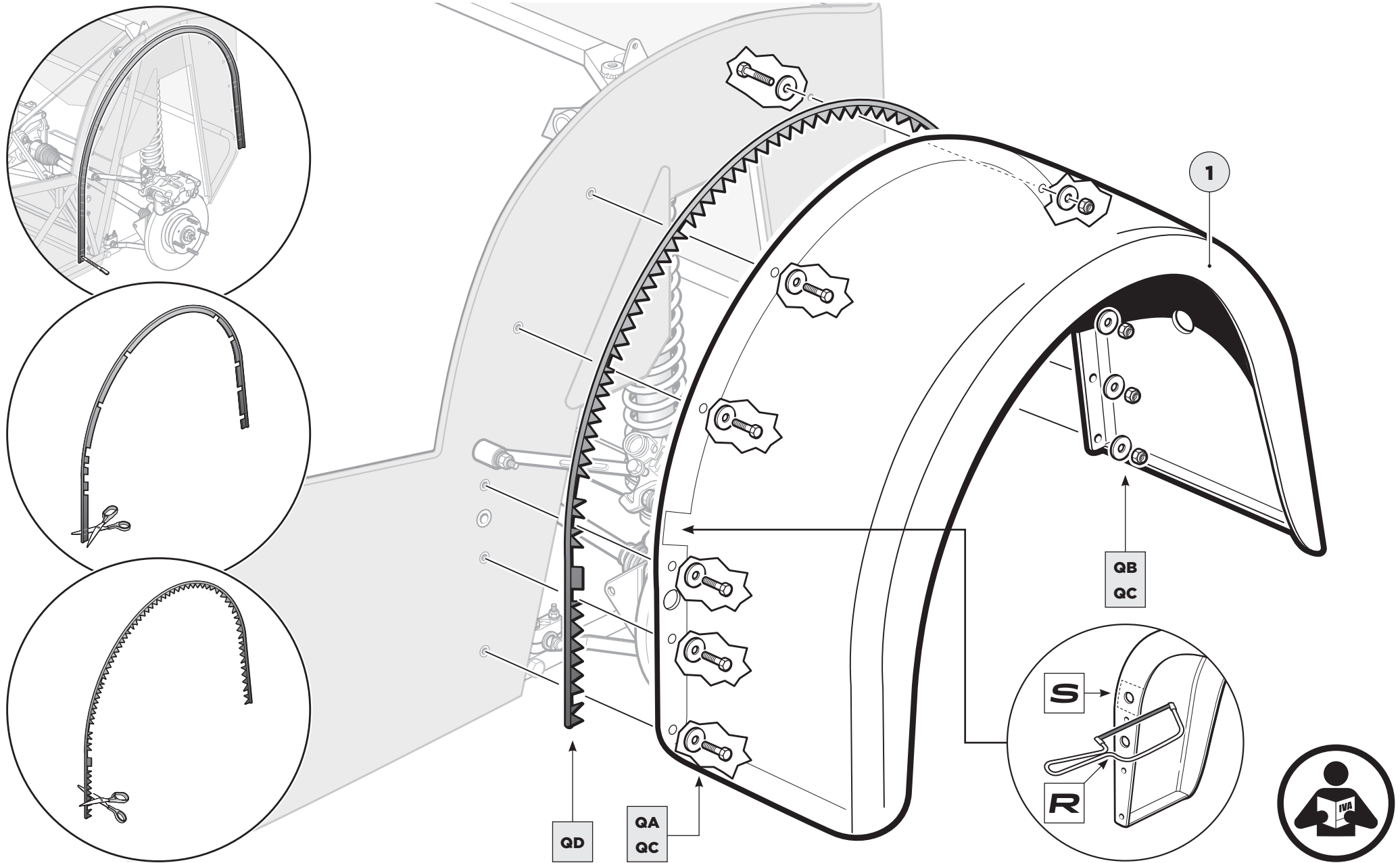
Cut the supplied piping in half and it will be enough for both wings.

Rich T

Don't forget the fuel tank earth strap gets bolted to the RH wing bolt.

Tiago O

FITTING THE REAR WINGS

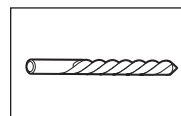
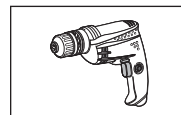
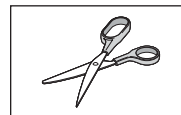


AND THE WING PROTECTORS

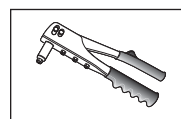
PARTS

- 1 Wing protector

TOOLS



1/8"



FIXINGS

For stainless steel protectors

Pack O		CATERHAM		<small>Part Number</small> ZWS01	
WING PROTECTORS STAINLESS STEEL					
<small>This pack may include extra fasteners to cover different options</small>					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	OA Reel 1/8" X 0.51"	1661-0414	30	Wing protector to wing	
2	OB Wing Plug	76901	2m	Between wing protector and wing	
<small>Drawings are for illustrative purposes only and are not to scale. Page 1 of 1</small>					

For carbon fibre protectors

Pack P		CATERHAM		<small>Part Number</small> ZWS02	
WING PROTECTORS CARBON FIBRE					
<small>This pack may include extra fasteners to cover different options</small>					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	PA Reel Black 1/8" X 0.51"	1610-01046	30	Wing protector to wing	
2	PB Wing Plug	76901	2m	Between wing protector and wing	
<small>Drawings are for illustrative purposes only and are not to scale. Page 1 of 1</small>					

TIPS

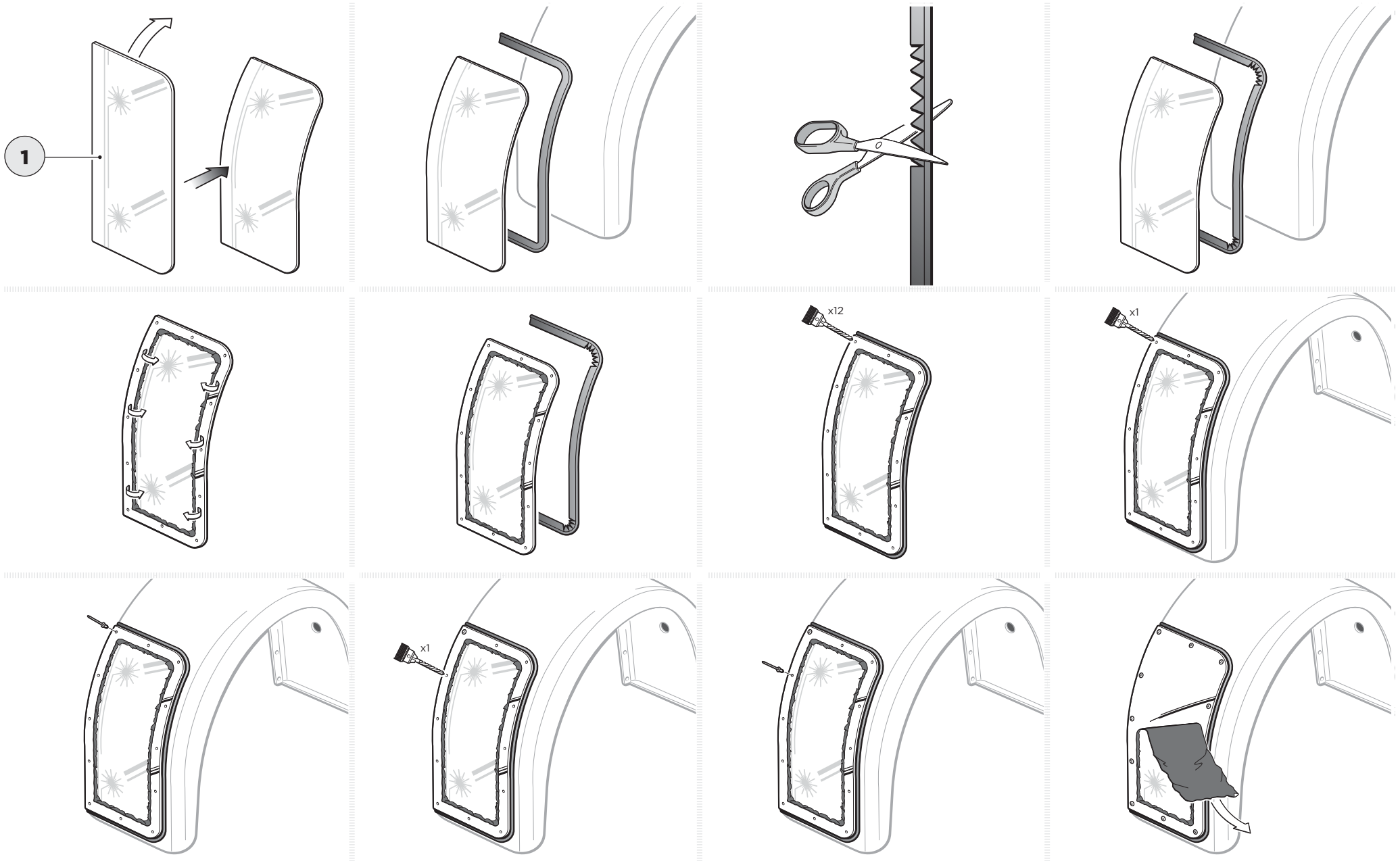
When drilling through protector start on the closest edge to the body. This will help the protector fit correctly.

Chris B

Carbon fibre protectors will not have the protective film shown.

Anthony L

AND THE WING PROTECTORS

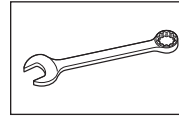


FITTING THE LIGHTS

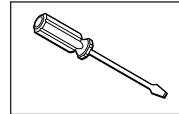
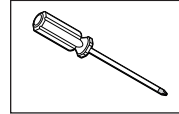
PARTS

- 1 Side repeater
- 2 Rear light
- 3 Numberplate lamp

TOOLS



8mm



FIXINGS

Pack C		CATERHAM		45	
				PACK NUMBER	
				30L002B	
FASTENER PACK - LIGHTING					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	CA Screw 10 x 37 Black Indicator	71060	6	Indicator assembly to indicator pod	
2	CB Screw 8 x 11 Black Indicator	71071	2	Side repeater parts on wingstay	
3	CC Screw 12 x 11* Self tapping	71070	4	Rear light cluster upper fixing	
4	CD Screw 12 x 11* Self tapping	71070	4	Rear light cluster lower fixing	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 1

x4

x4

TIPS

Use a cradle clip & cable tie to keep the rear light loom out of the way.

John S

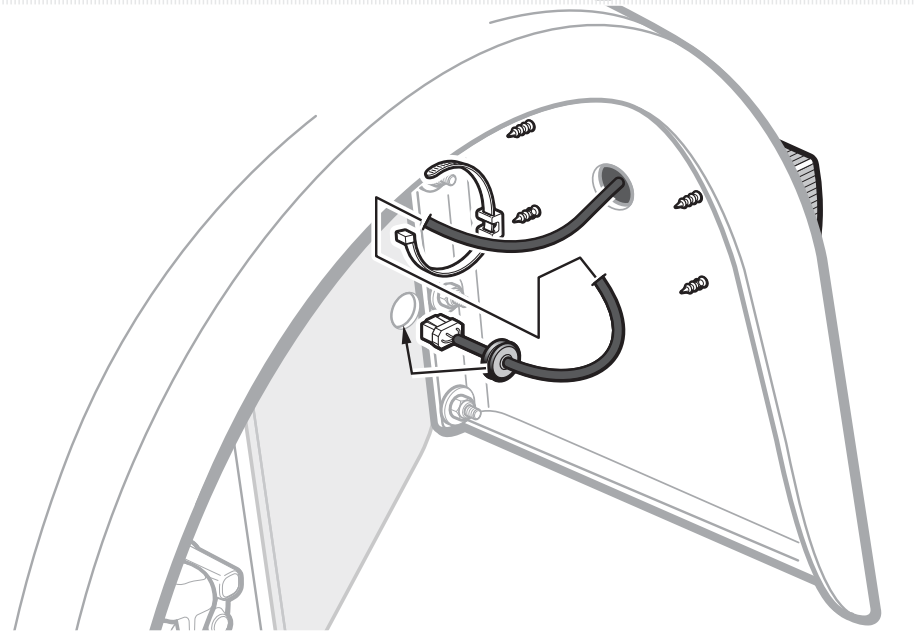
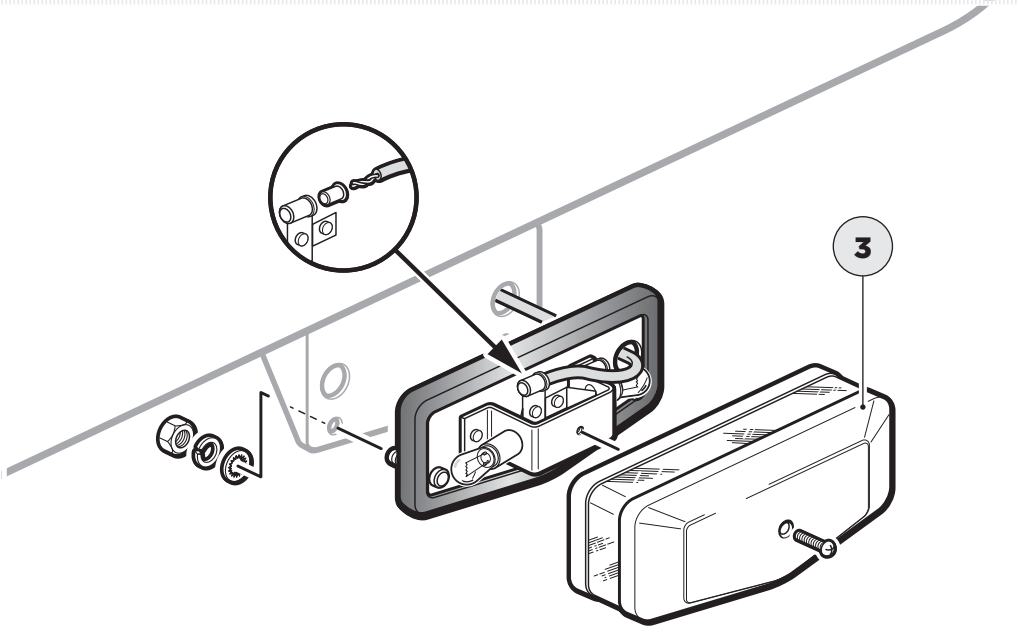
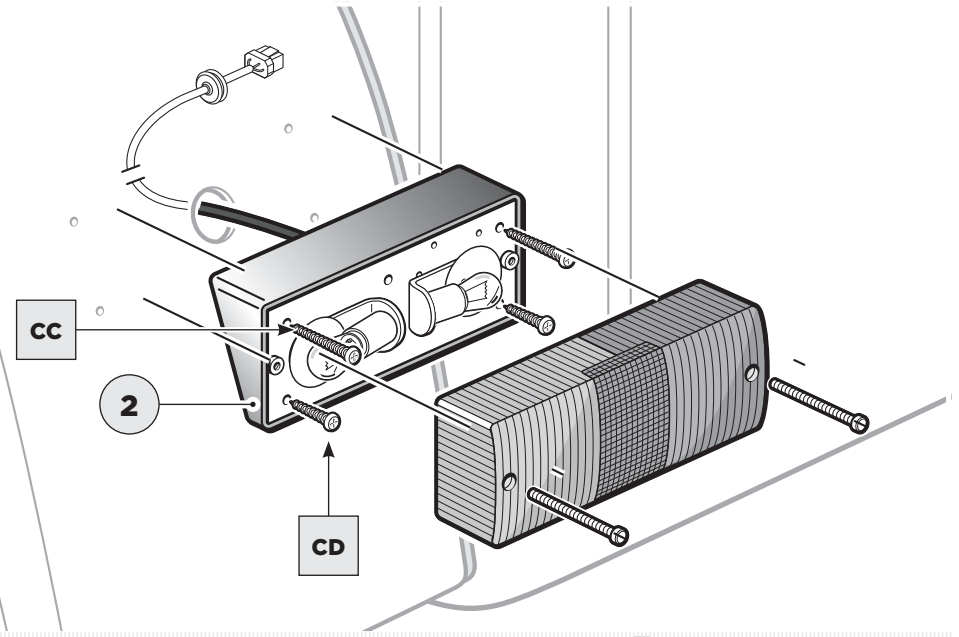
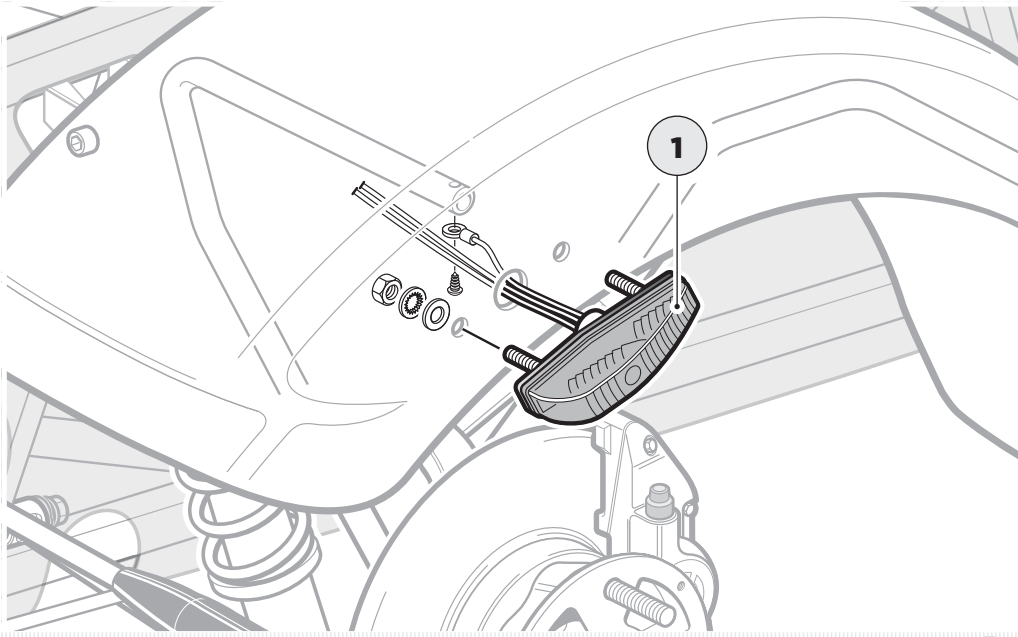
Rubber grommet on rear light goes in the body not the wing.

Jamie A

Indicator repeater wires go through the wingstay.

Chris B

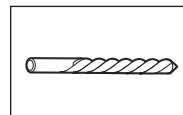
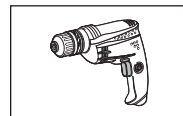
FITTING THE LIGHTS



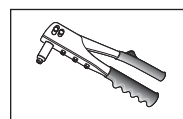
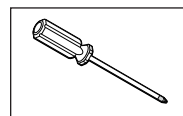
FUSE BOX COVER & KNEE TRIM PADS

PARTS

TOOLS



$\frac{5}{32}$ "



FIXINGS

Chassis fastener pack ZCH01 supplied loose:

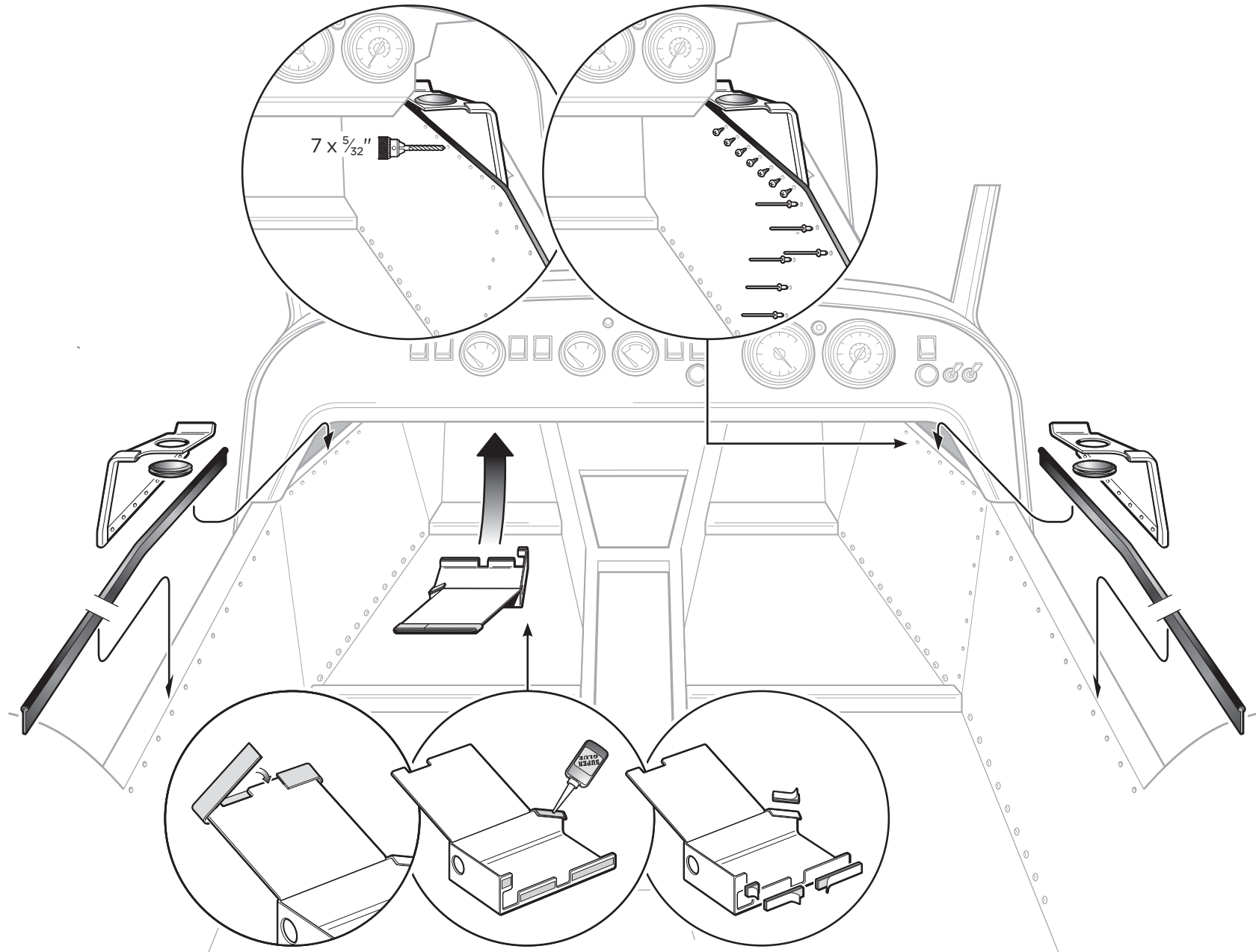
- Screw $\frac{3}{4}$ " x 10
- Rivet $\frac{5}{32}$ x 0.47"

TIPS

Building an Academy Car? If so you'll need to leave the riveting-in of the side panels until after you've fitted the roll cage (p154–155) as the front legs go behind the panel, not over the top of it.

John S

FUSE BOX COVER & KNEE TRIM PADS



FIT THE TUNNEL CARPET

PARTS

TOOLS



FIXINGS

TIPS

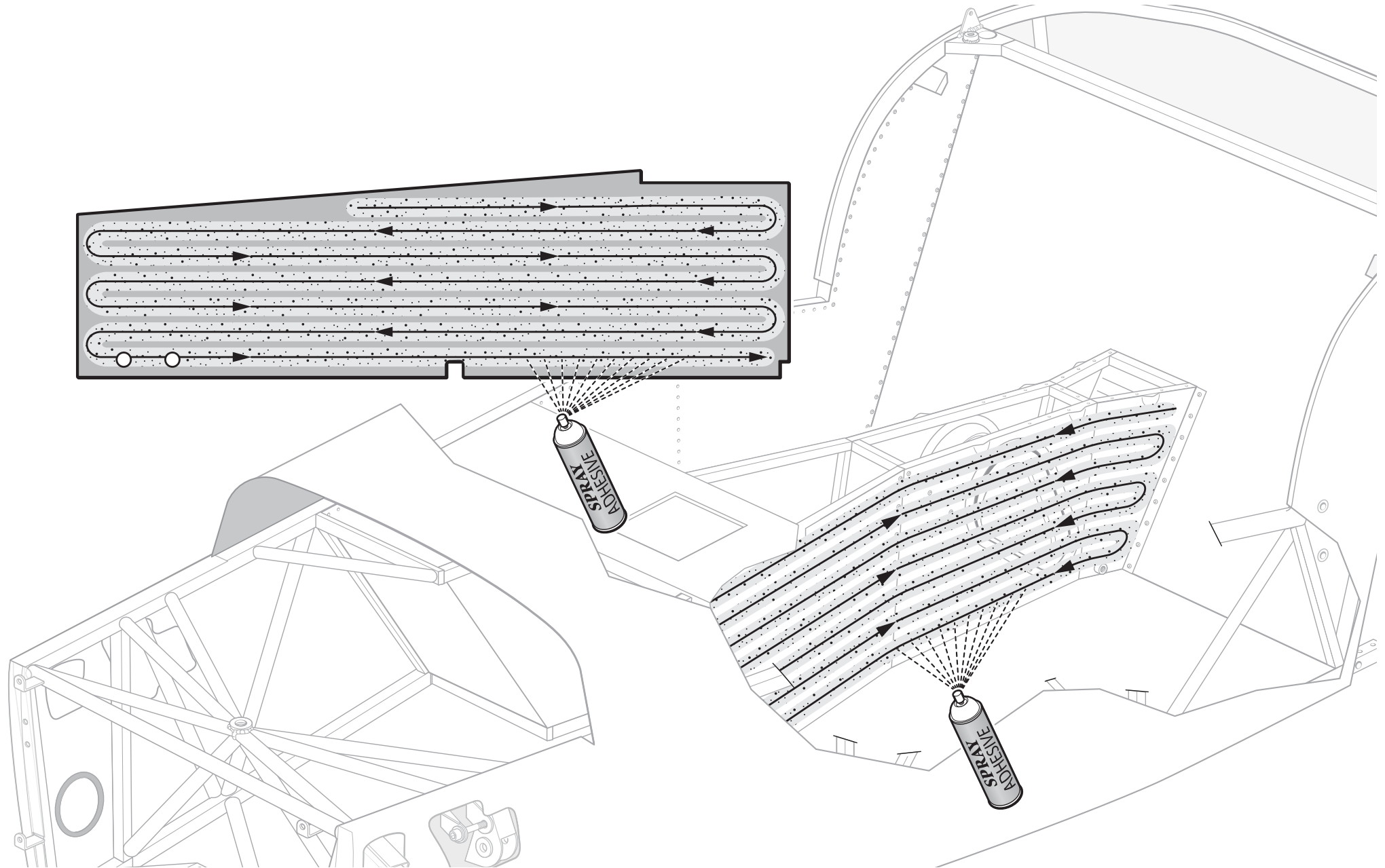
Spray on both tunnel panel and carpet.

John K

Allow the adhesive to go tacky before fitting.

Harry P

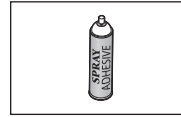
FIT THE TUNNEL CARPET



AND THE BOOT CARPET

PARTS

TOOLS



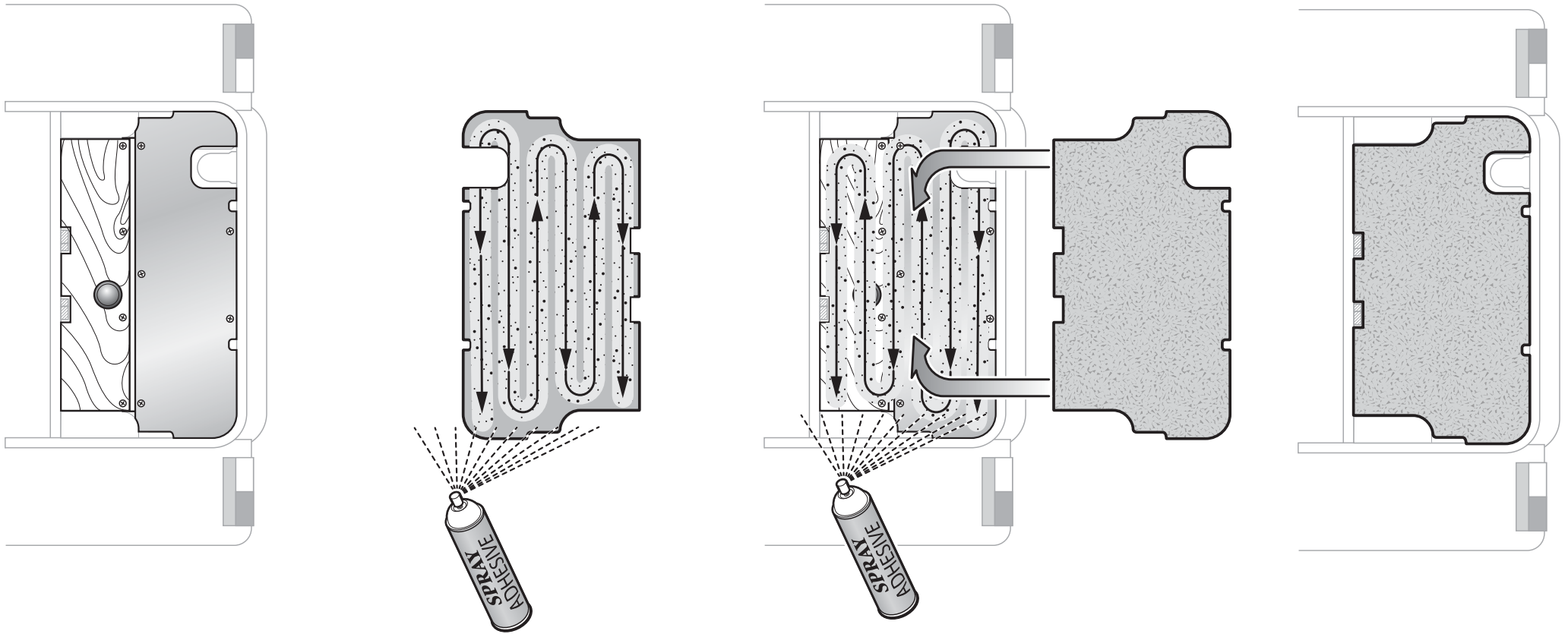
FIXINGS

TIPS

S-Pack cars have a fully carpeted boot. It's something of a jigsaw pattern, but the parts are simply glued in place like the bigger bits.

John S

AND THE BOOT CARPET

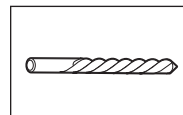
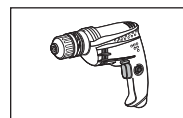


THIS IS A COVER UP

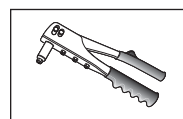
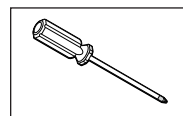
PARTS

- 1 Fuel filler cove
- 2 Tunnel closing panel

TOOLS



5/32"



FIXINGS

Supplied loose:

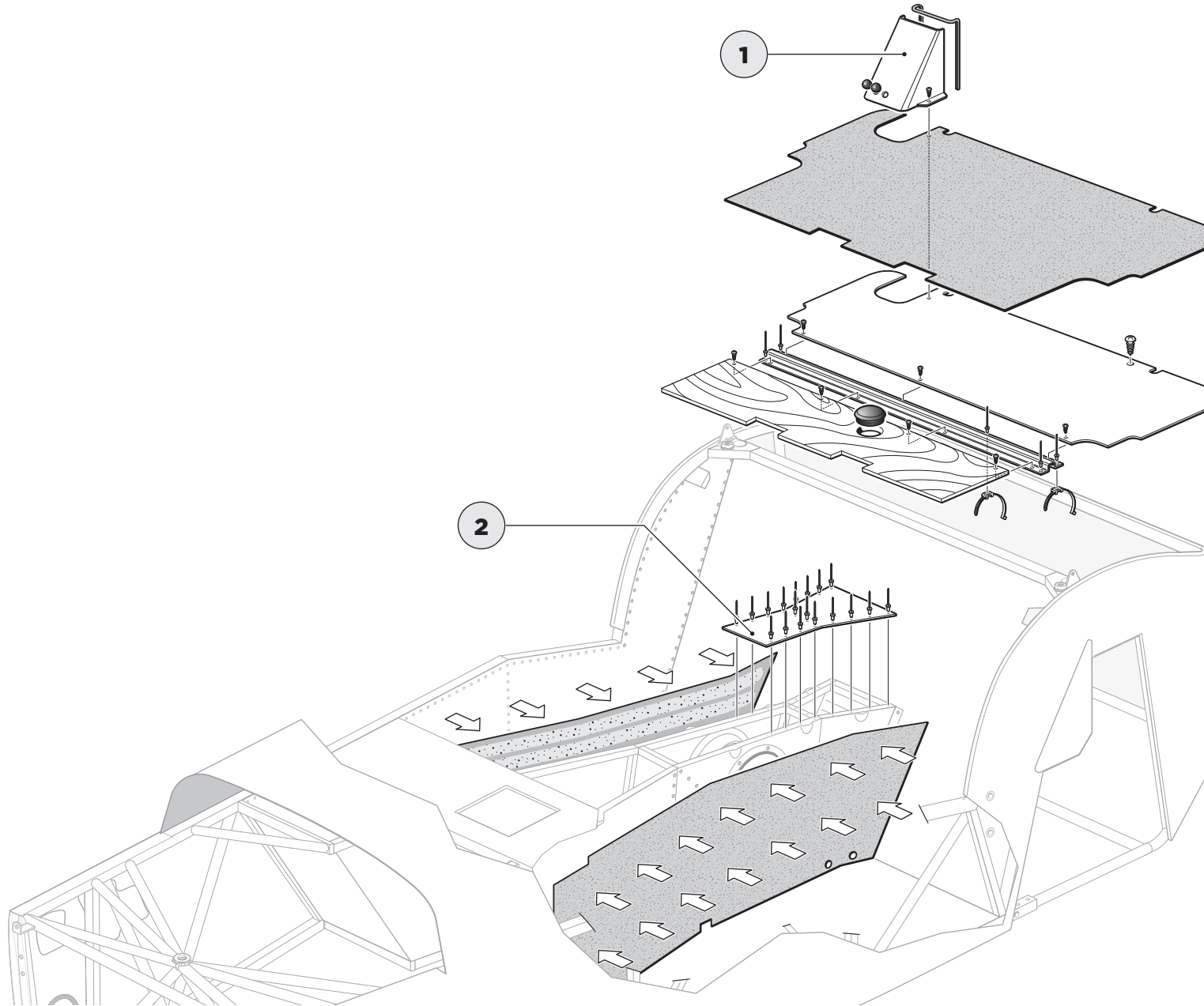
- Rivets
- Screws

TIPS

The fuel filler cover just screws to the boot floor. Drill two holes and use self tapping screws.

Rich T

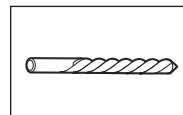
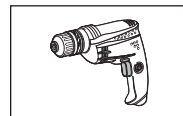
THIS IS A COVER UP



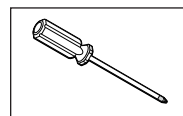
NOW FIT THE TUNNEL TOP

PARTS

TOOLS



1/8"



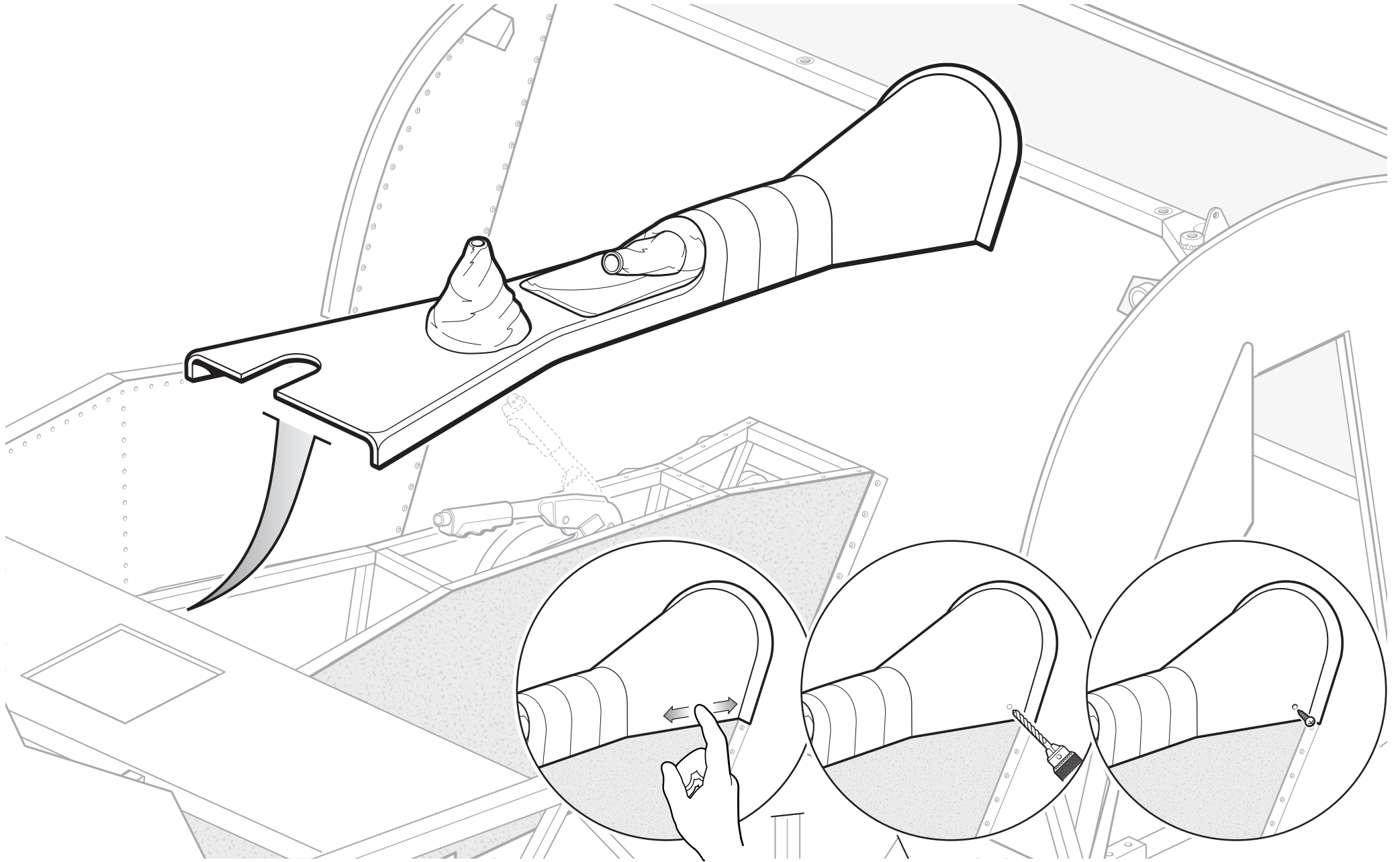
FIXINGS

TIPS

The hole can be seen if you flip the tunnel top over.

Mick F

NOW FIT THE TUNNEL TOP



BELT UP

PARTS

TOOLS



FIXINGS

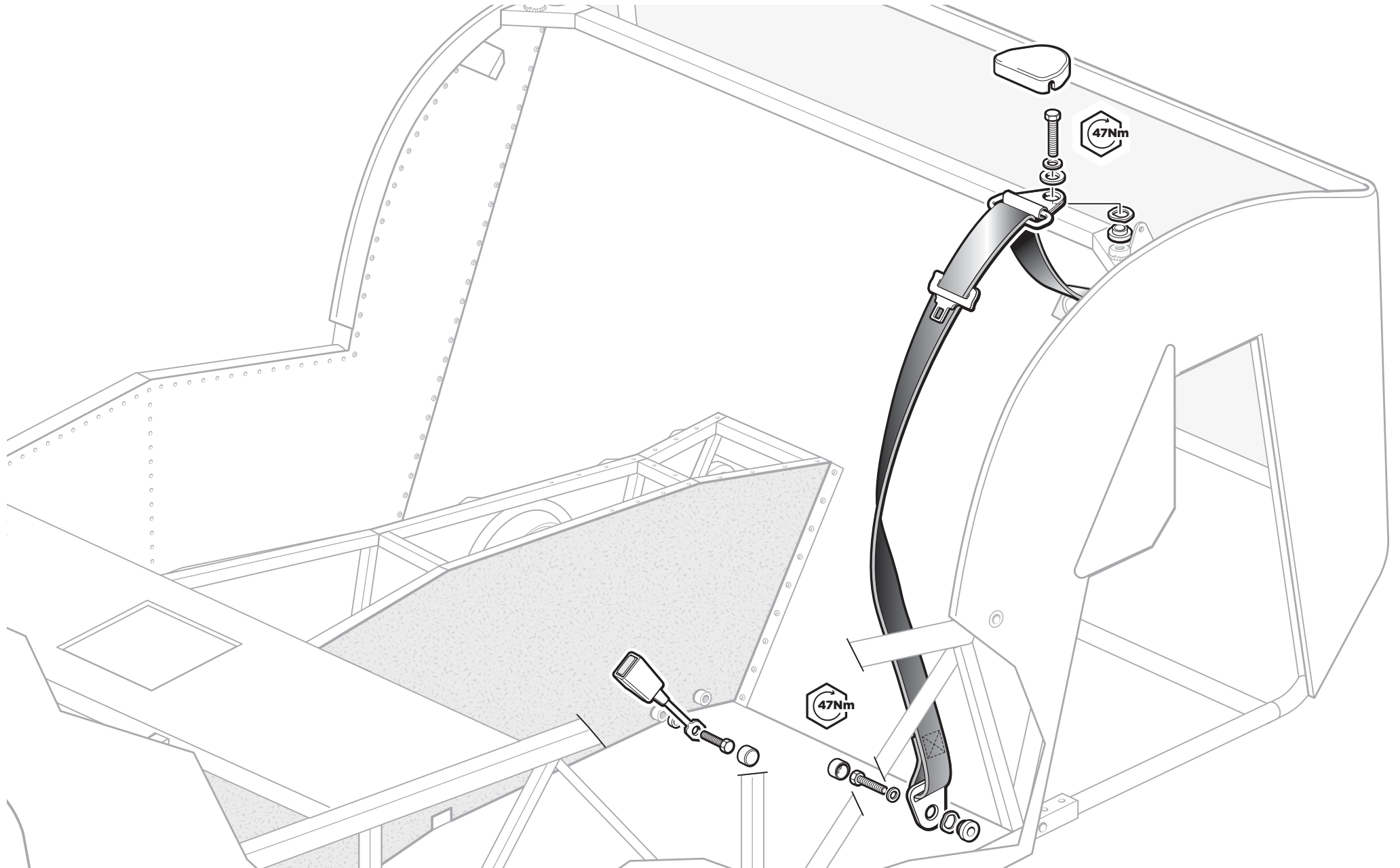
TIPS

Supplied with seat belts

These will be loosely fitted already – you'll need to tighten & torque.

Chris N

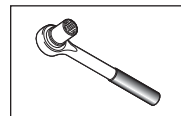
BELT UP



FITTING THE FOUR-POINT HARNESS

PARTS

TOOLS



17mm



FIXINGS

All fixings supplied with the harnesses

TIPS

The buckle is attached to a lap strap and this should be fitted to the tunnel side.

Chris N

For Academy cars with Schroth Harnesses see Page 148.

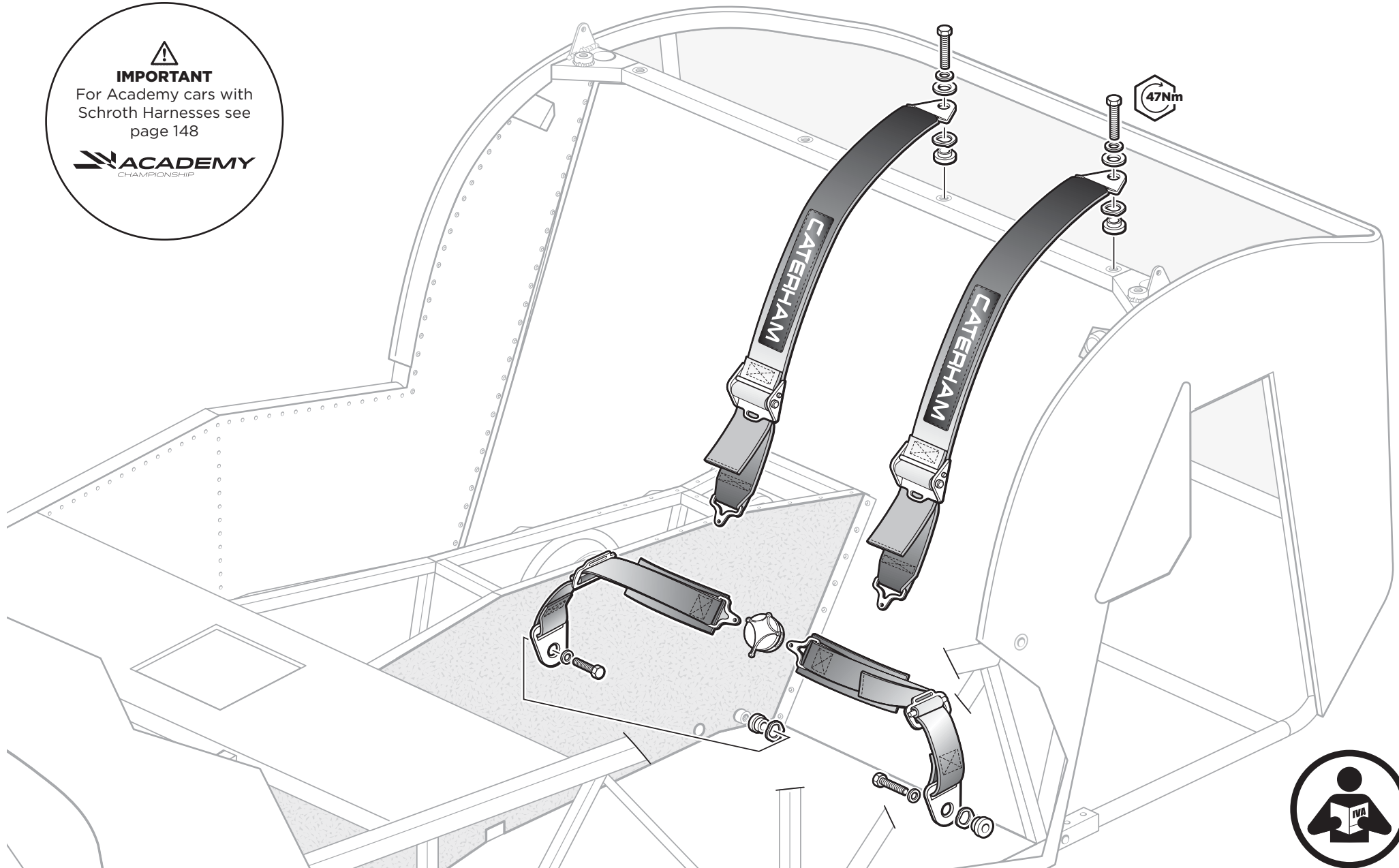
Dan P

FITTING THE FOUR-POINT HARNESS

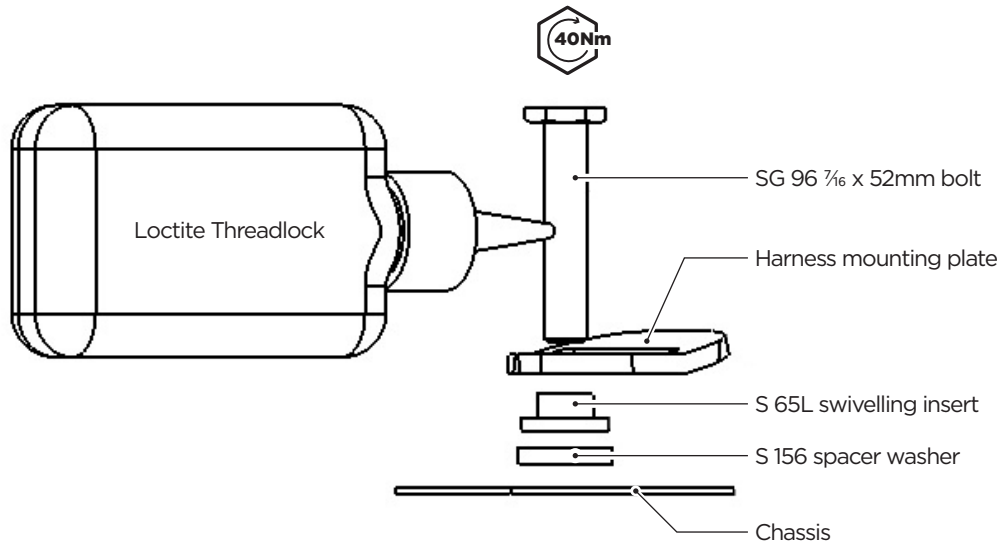


IMPORTANT

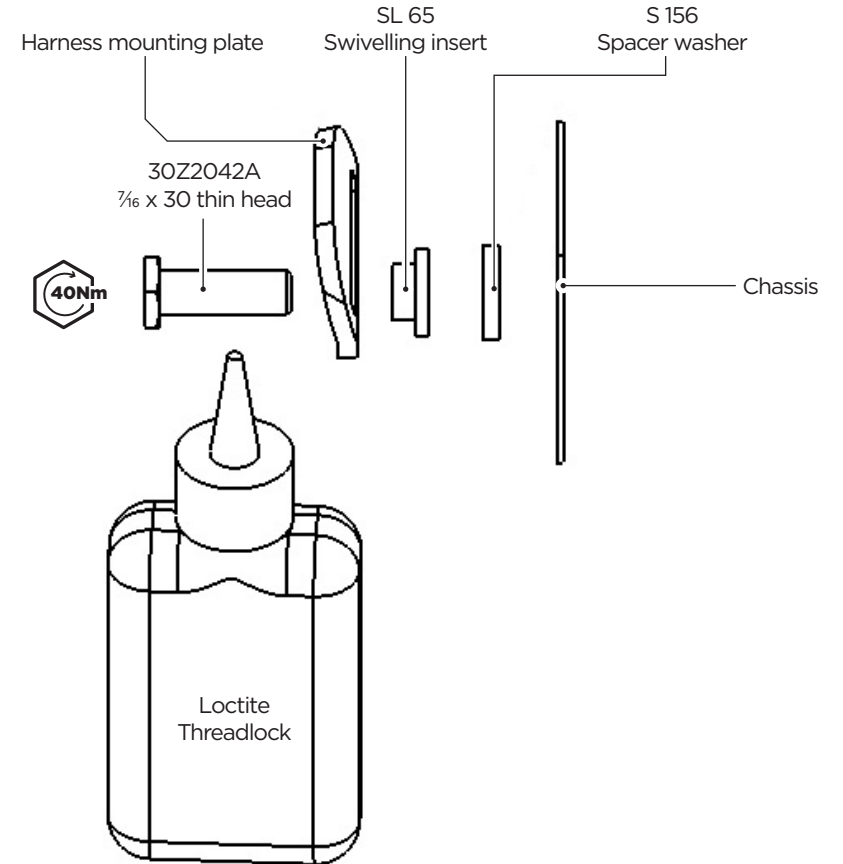
For Academy cars with Schroth Harnesses see page 148



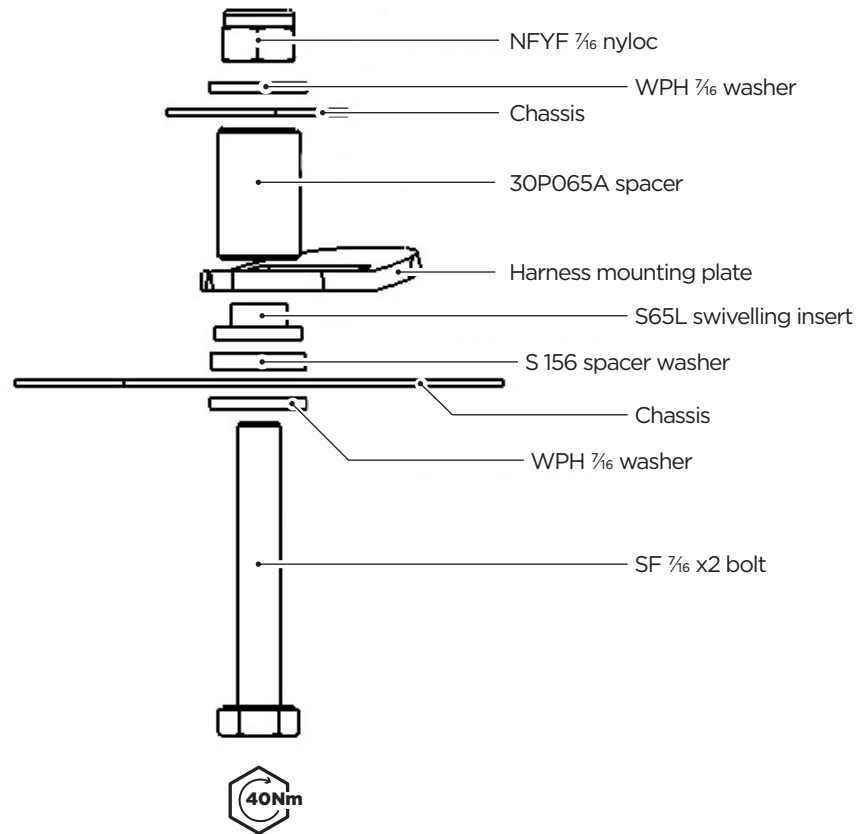
SHOULDER STRAP MOUNTING ORIENTATION



WAIST STRAP MOUNTING ORIENTATION



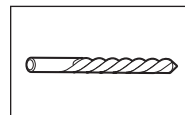
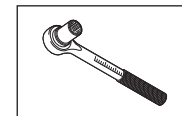
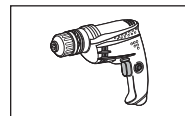
CRUTCH STRAP MOUNTING ORIENTATION



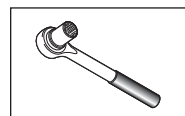
FITTING THE SIX-POINT HARNESS

PARTS

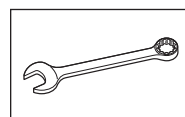
TOOLS



7/16"



16mm
17mm



16mm
17mm

FIXINGS

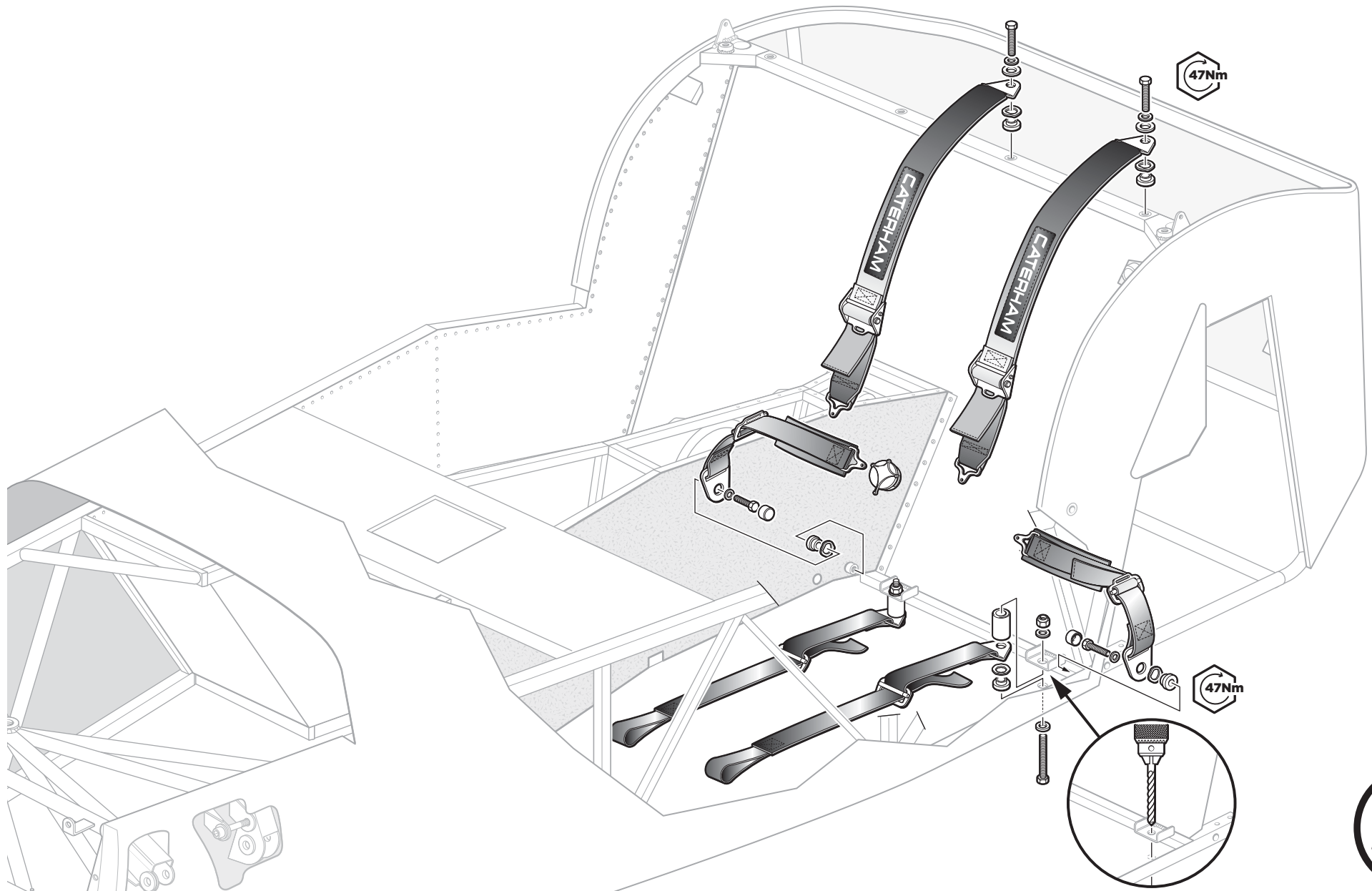
All fixings supplied with the harnesses

TIPS

The buckle is attached to a lap strap and this should be fitted to the tunnel side.

Lee A

FITTING THE SIX-POINT HARNESS

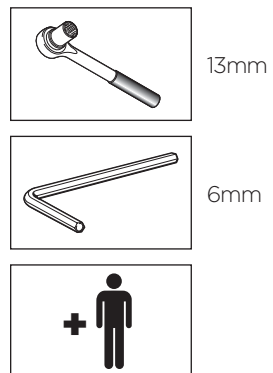


FITTING CLOTH OR LEATHER SEATS

PARTS

- 1** Seat
- 2** Seat base
- 3** Headrest

TOOLS



FIXINGS

Pack L		CATERHAM		62	
				302105B	
CLOTH/LEATHER SEATS ALL CARS					
<small>This pack may include extra fasteners to cover different options</small>					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	LA Cleat Bolt M8 X 20 Grade 12.9	SMCH002	4	Through seat runner & floor	
2	LB Nyloc Nut M8	N8N78	4	Under floor	
3	LC Plain Washer M8 X 30	WPH003	4	Under floor	

Drawings are for illustrative purposes only and are not to scale. Page 1 of 1

x4
x4
x4

TIPS

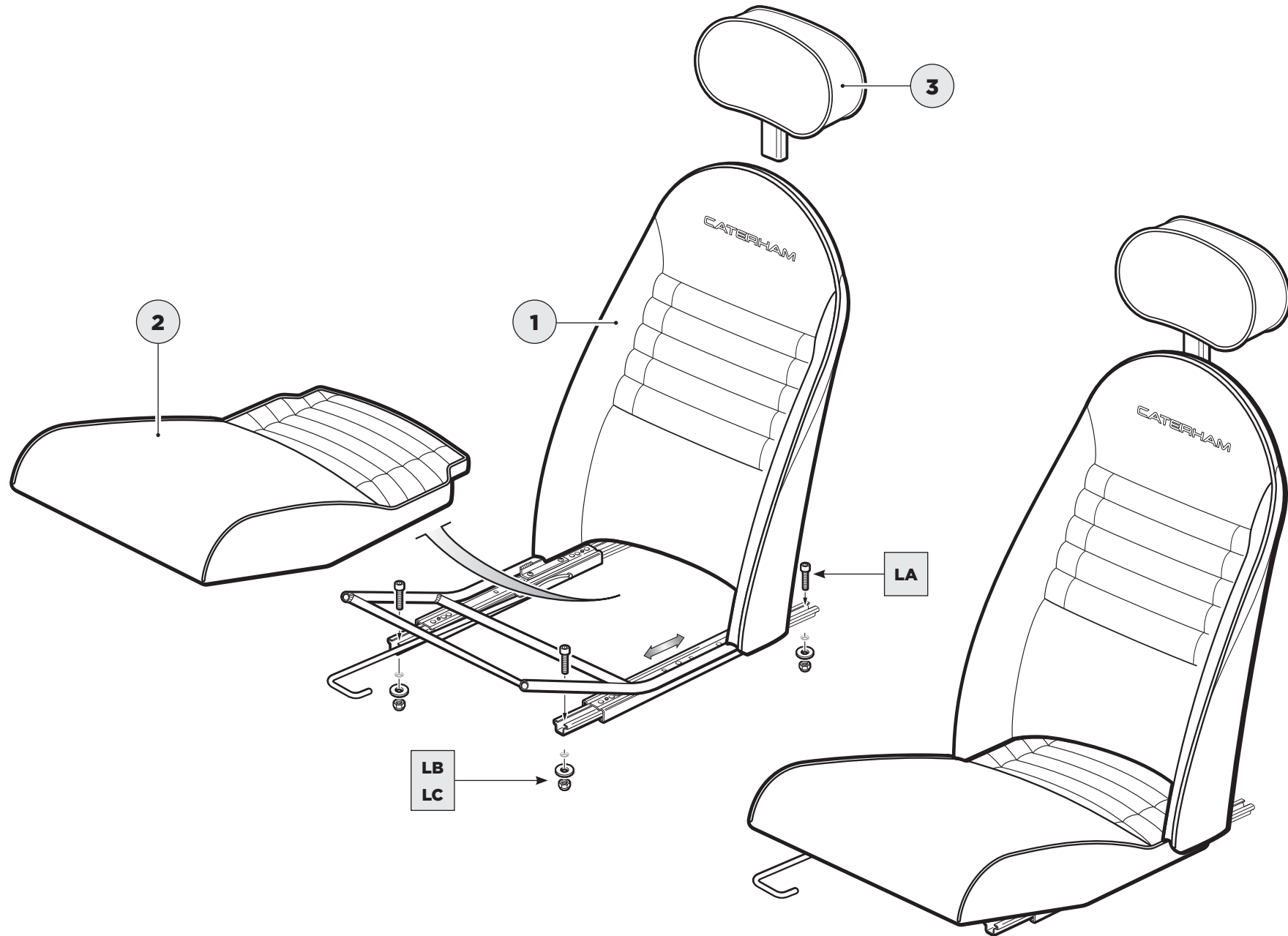
Loosely fit the rear bolts to help locate the front.

Dan D

Nip up all bolts once fitted.

Anthony L

FITTING CLOTH OR LEATHER SEATS

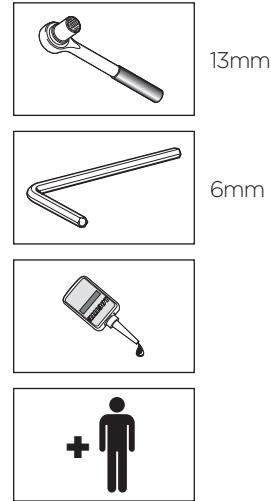


OR FITTING THE RACE SEATS

PARTS

- 1 Seat
- 2 Adjustable runner
- 3 Fixed seat spacer

TOOLS



FIXINGS

For fixed seats

ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Caphead Bolt M8 X 20	8MCH8X20	4	Spacer box section to seat	
2	Caphead Bolt M8 X 20	8MCH8X20	4	Floor to mount in spacer box section	
3	Spring Washer 5/16"	W5/16S16	8	Bolt heads	
4	Washer 5/16" X 1 1/4"	W5/16X1 1/4	4	Under floor	
5	Washer M8 X 18	W8M8X18E1	4	Spacer box section to seat	
7	Spacer Block Plastic	TW2	3	Seat spacer	
8	Spacer Block Plastic	TW3	5	Seat spacer	

Drawings are for illustrative purposes only and are not to scale.

For adjustable seats

ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Caphead Bolt M8 X 20	8MCH8X20	4	Runner to seat	
2	Caphead Bolt M8 X 20	8MCH8X20	4	Runner to floor	
3	Washer 5/16" X 1 1/4"	W5/16X1 1/4	4	Under floor	
4	Nylon Nut M8	N8NY8	4	Under floor	
5	Spacer Block Plastic	TW2	3	Seat spacer	
6	Spacer Block Plastic	TW3	5	Seat spacer	

Drawings are for illustrative purposes only and are not to scale.

TIPS

Put a bit of Loctite on bolts that go into the seat on the runner version.

Chris B

Runners / seat spacers can be fitted to seat before putting in car.

Mick F

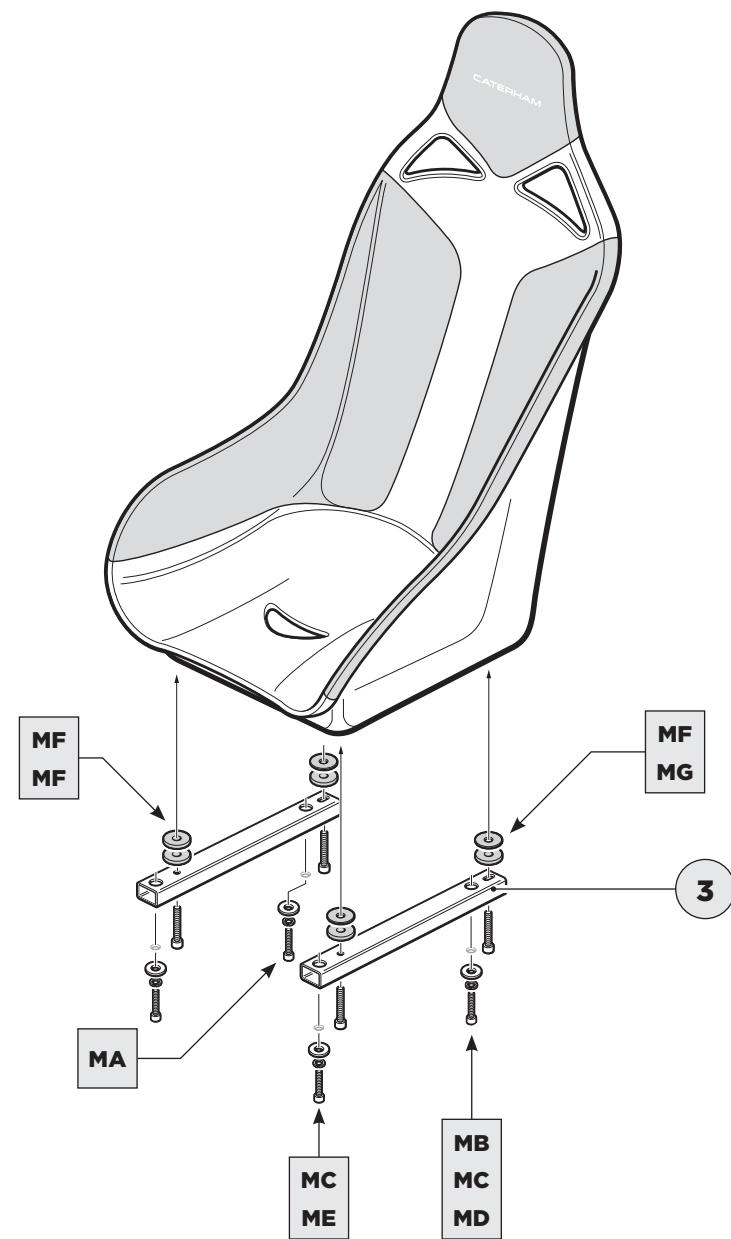
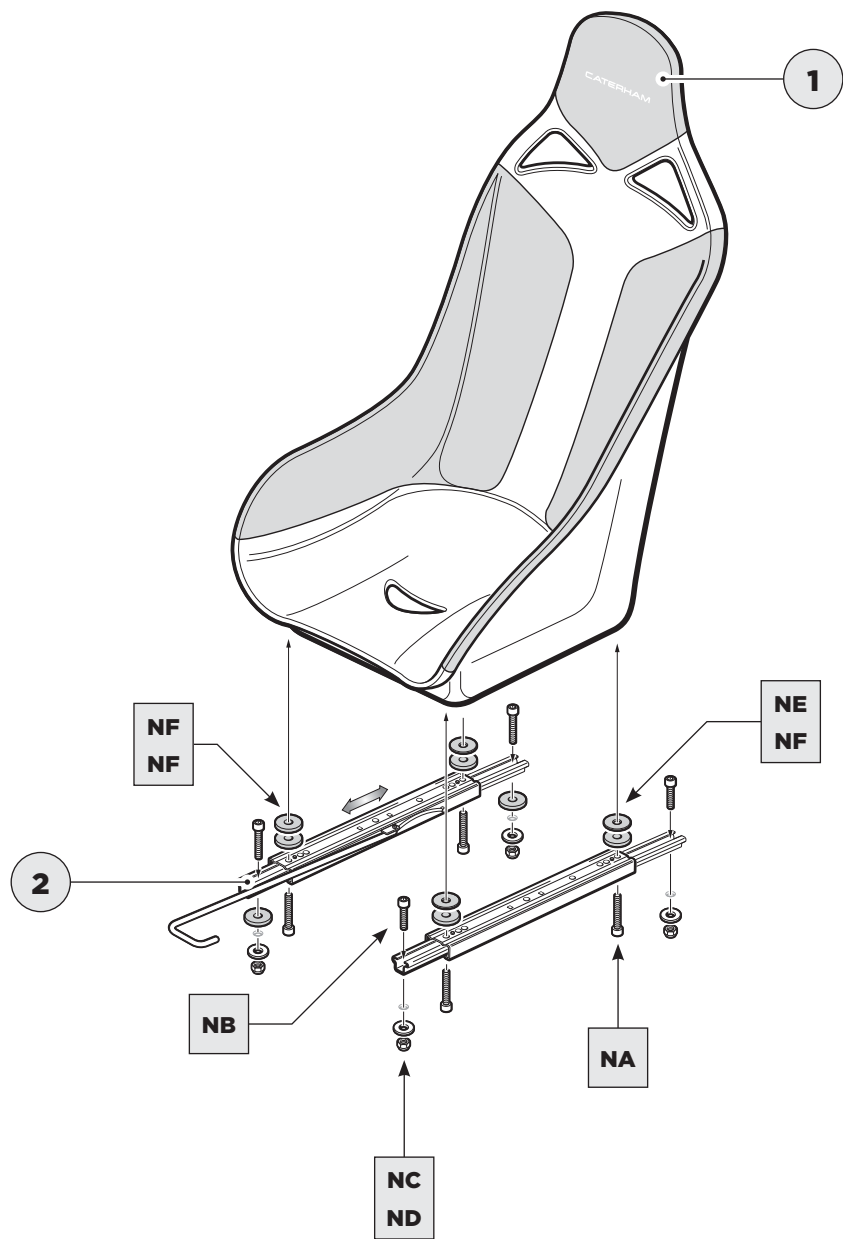
Loosely fit the rear bolts to help locate the front.

Harry P

The fixed position seat is for the passenger side!

Chris N

OR FITTING THE RACE SEATS

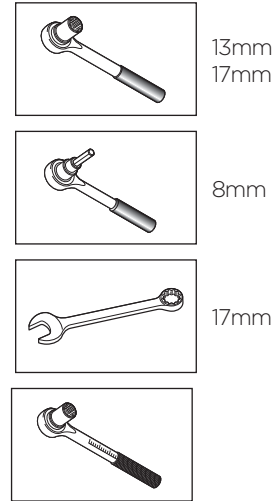


FITTING THE ROLL OVER BAR

PARTS

- 1 Roll over bar

TOOLS



FIXINGS

Pack J		CATERHAM		47	
		PACK NUMBER		30P010A	
ROLL OVER & TRACK DAY BAR SERIES 3 METRIC					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	Roll M10 x 80 Grade 8.8	BM10080	2	Rear diagonals of roll over bar to mounting brackets	
2	Set screw M8 x 20 Grade 8.8	SM8X20	2	Roll over bar bracket to chassis	
3	Clamp nut M10 x 20	SMCH10X20	2	Roll over bar boss	
4	Nyloc Nut M10	NMNF10	2	Rear diagonals of roll over bar to mounting brackets	
5	Flan Washer M8	WP8M8	2	Roll over bar bracket to chassis	
6	Spring Washer M8	WS8M8	2	Roll over bar bracket to chassis	
7	Flan Washer M10	WP8M10	4	Rear diagonals of roll over bar to mounting brackets	

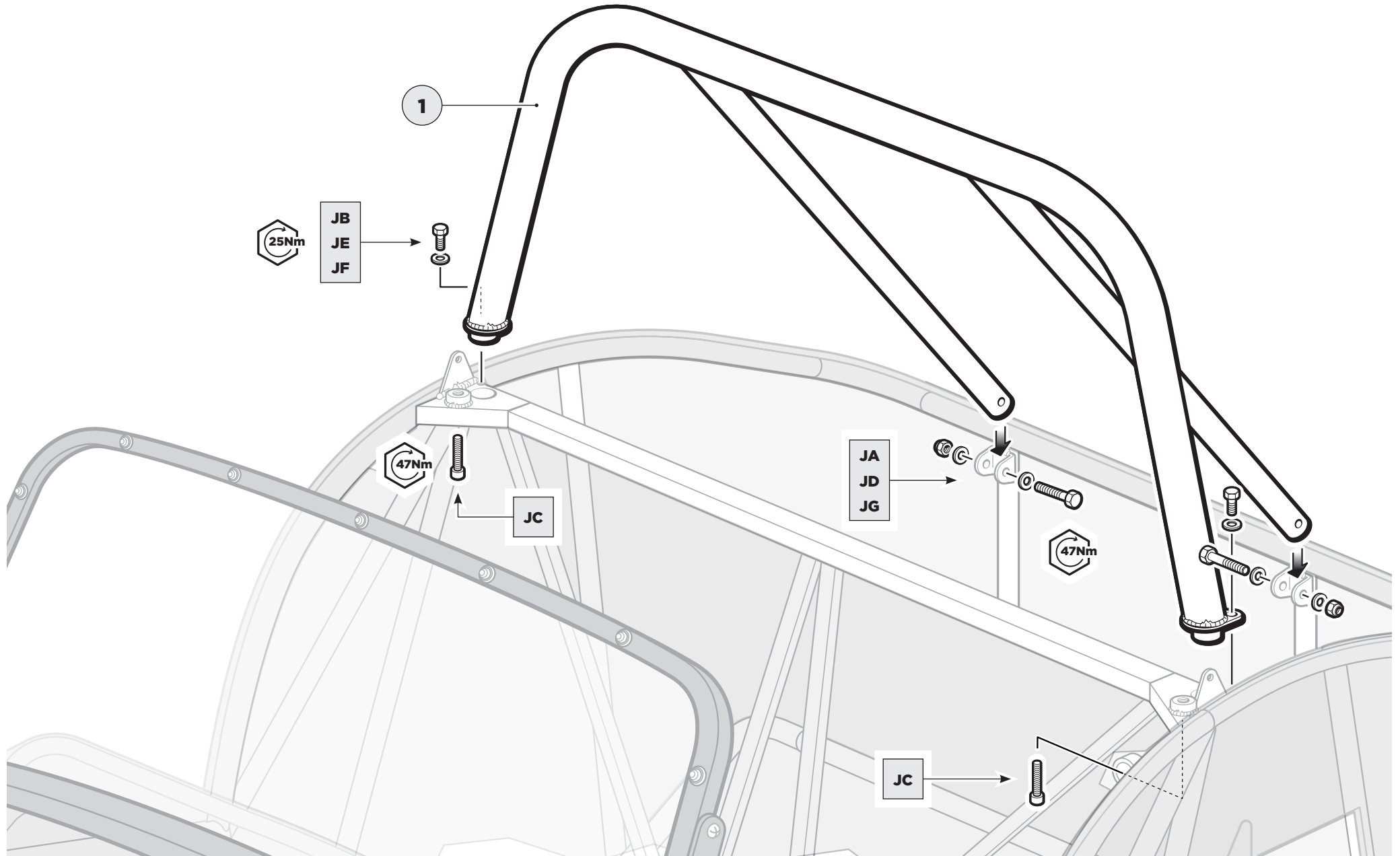
x2
x2
x2
x2
x2
x2
x4

TIPS

If you've fitted the rear dampers they'll need to come off again to do this properly.

Chris B

FITTING THE ROLL OVER BAR



EVEN MORE EXHAUSTING

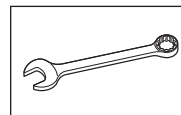
PARTS

- 1 Silencer
- 2 Exhaust clamp
- 3 Lambda sensor
- 4 Cat guard
- 5 Clip
- 6 Silencer mounting bracket
- 7 Exhaust mounting bobbin

TOOLS



7mm
10mm
13mm



7/8"

FIXINGS

Pack G		CATERHAM		56	
		PART NUMBER		30X020E	
EXHAUST					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	GA Silencer M8 X 25 Grade 8.8	8M8X25	1	Exhaust Mounting Bracket	
2	GB Plain Nut M8	NFF8	2	Exhaust Bobbin	
3	GC Spring Washer M8	WSP8	3	x 1 Exhaust Mounting Bracket x 2 Exhaust Bobbin	

x1

x2

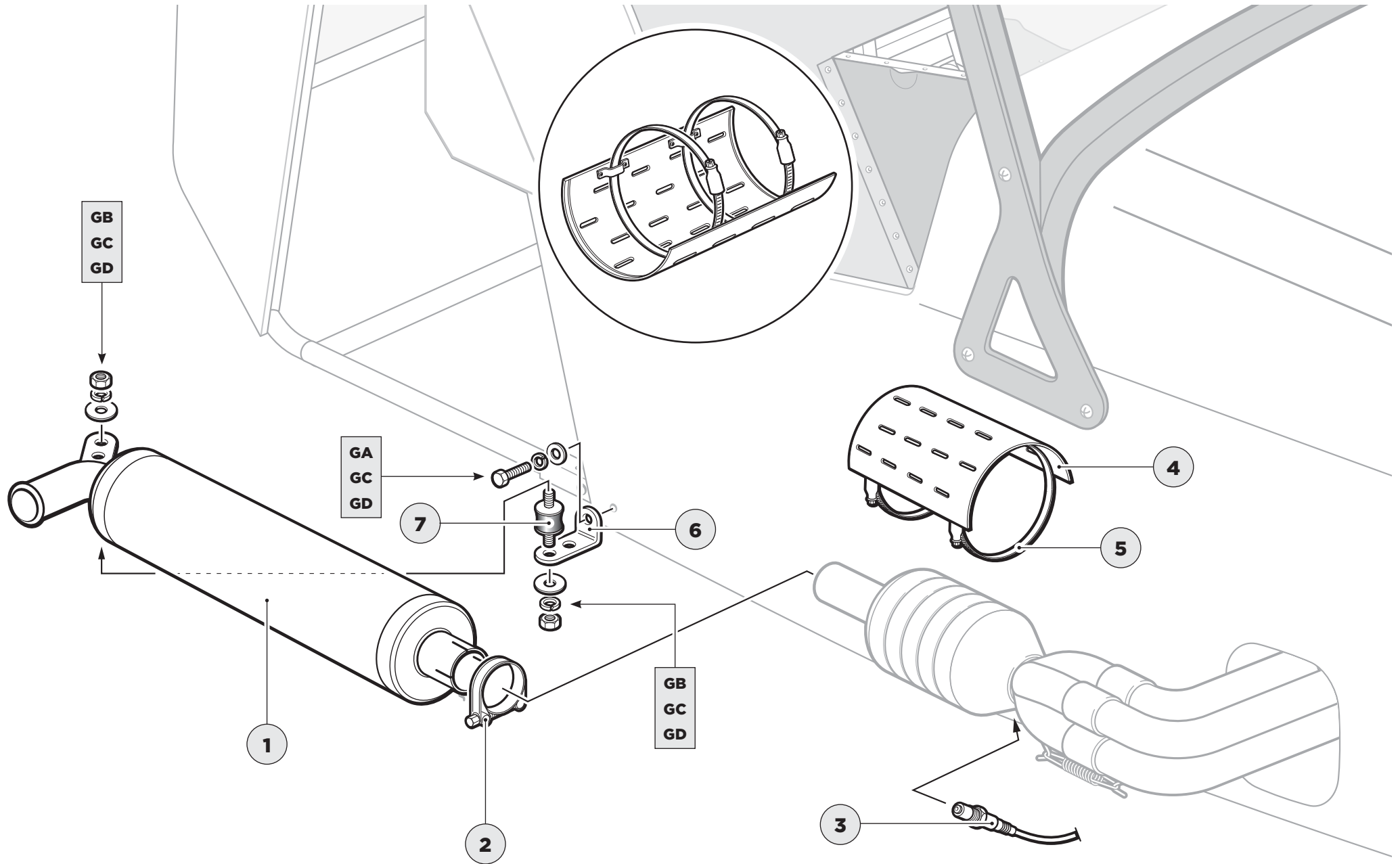
x3

TIPS

Cable tie the Lambda sensor lead neatly out of the way.

Lee A

EVEN MORE EXHAUSTING

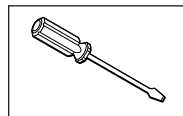


THE NOSE CONE BADGE

PARTS

- 1 Nose cone
- 2 Bonnet
- 3 Badge

TOOLS



FIXINGS

TIPS

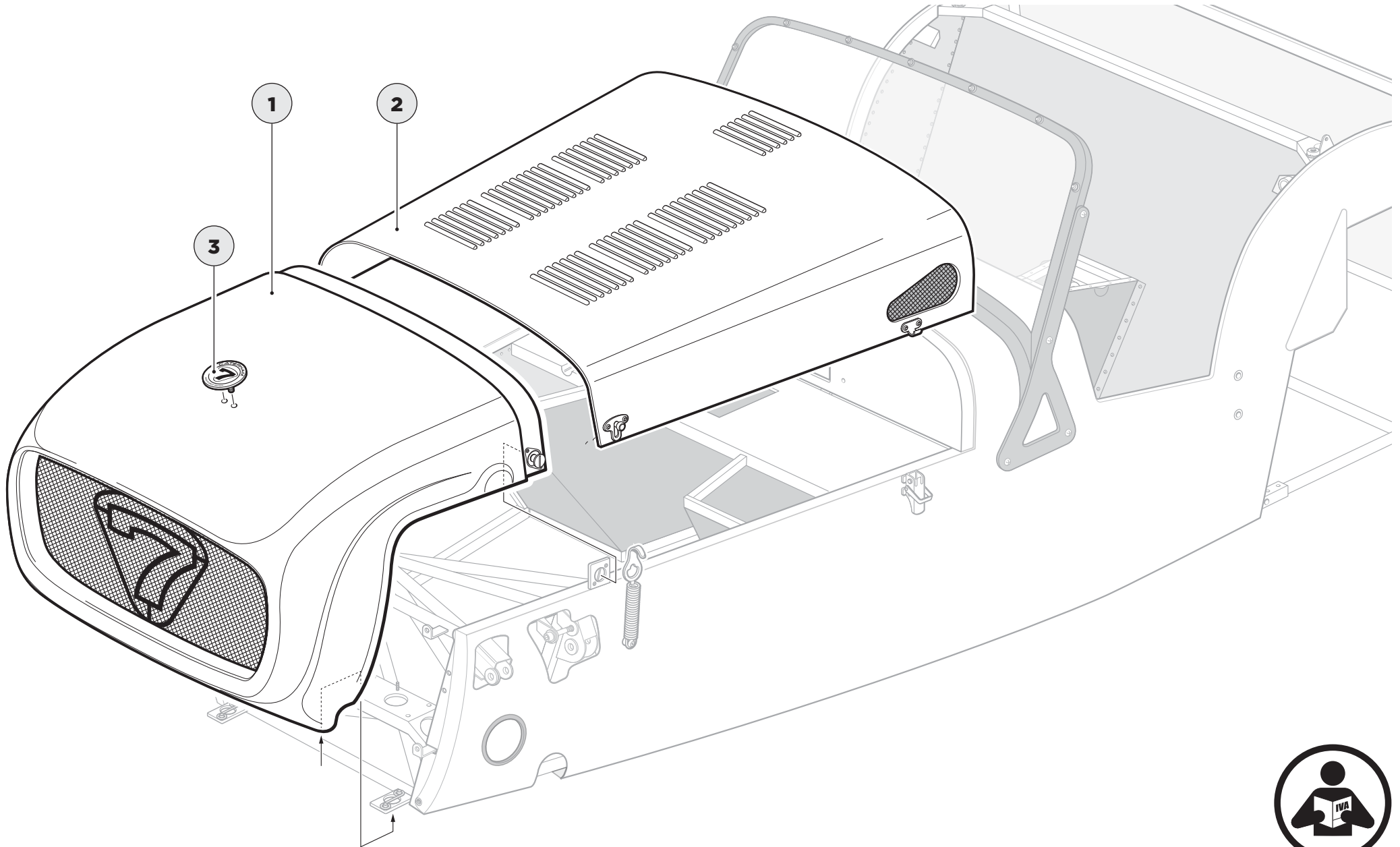
The nose cone goes on before the bonnet.

Anthony L

Stick the supplied foam around the edge of the nose and scuttle where the bonnet will sit (if you've not done already).

Harry P

THE NOSE CONE BADGE



FITTING THE WIPERS

PARTS

- 1 Wiper arm
- 2 Wiper blade

TOOLS

FIXINGS

TIPS

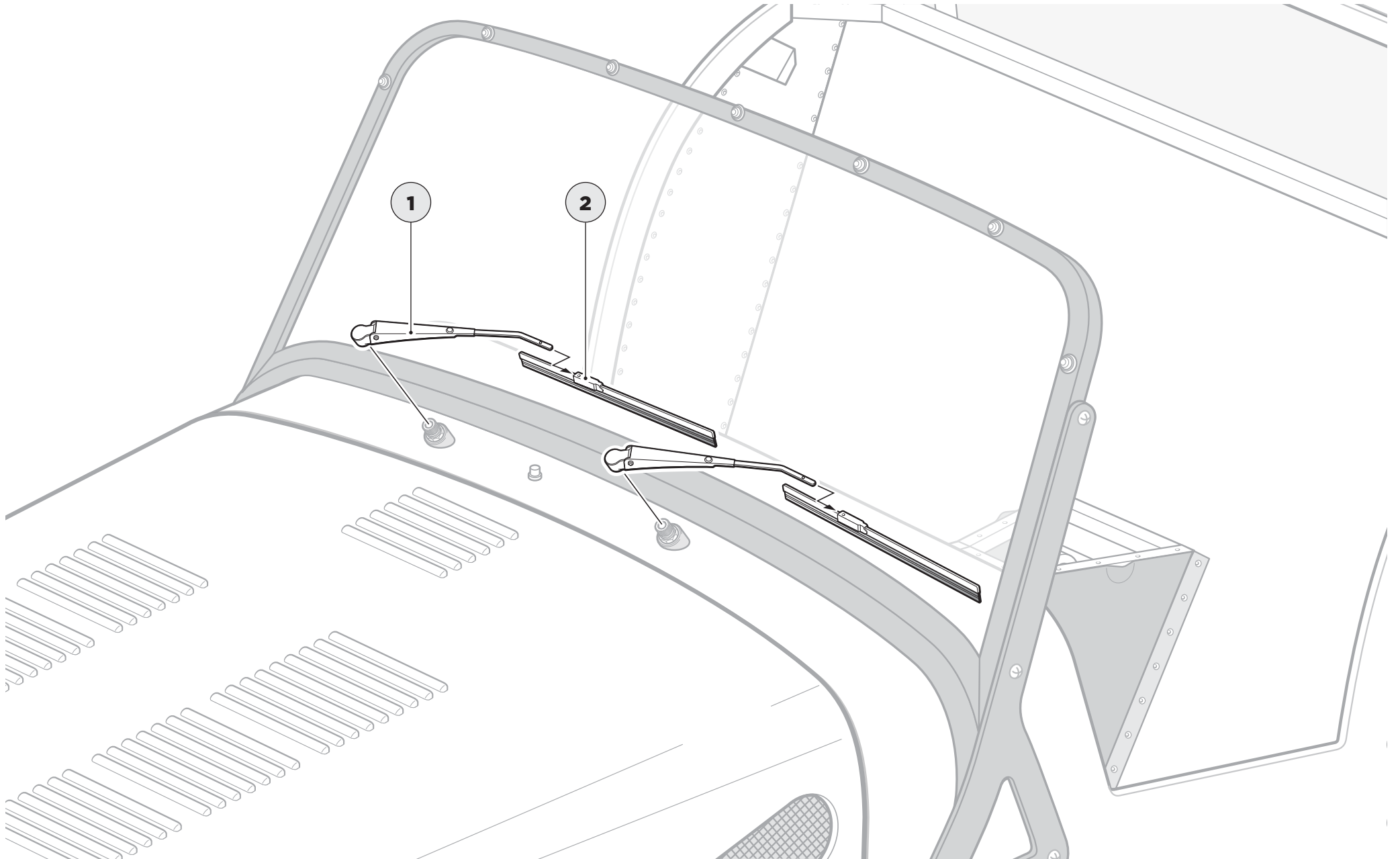
Ensure wipers are in *paused* position before fitting the wiper arms.

John S

Now would be a good time to fill the washer bottle with fluid and test the washers and wipers.

Chris B

FITTING THE WIPERS

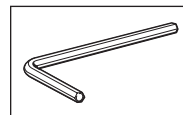
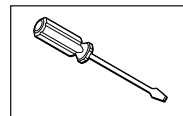


AND FINALLY, AT LAST, THE WING MIRRORS

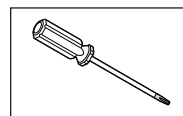
PARTS

- 1 Mirror head
- 2 Mirror mount
- 3 Mirror mount stud
- 4 Grub screw
- 5 Fibre washer

TOOLS



2.5mm



T20

FIXINGS

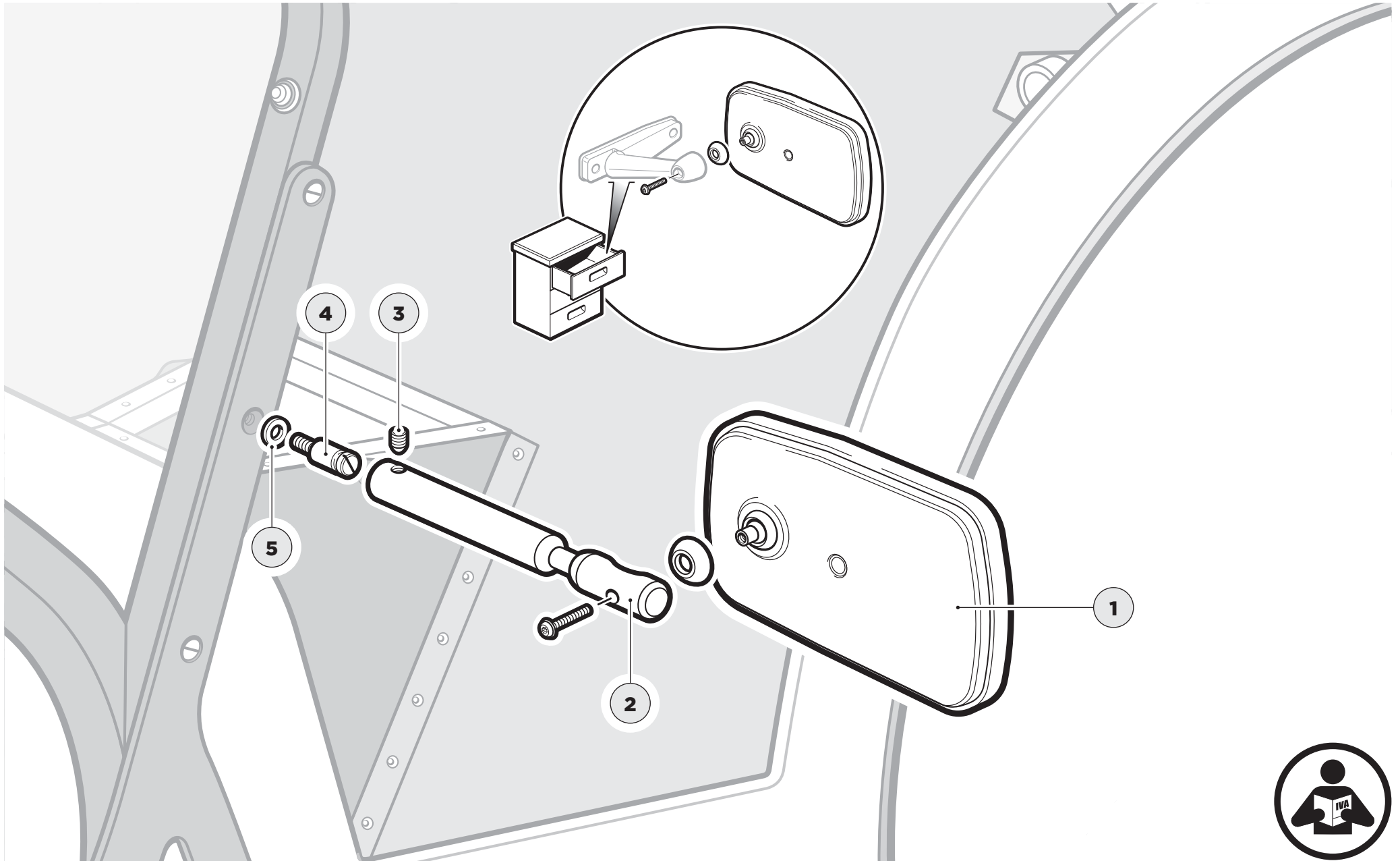
Wing mirror bag

TIPS

You may have to unclick the glass out to tighten up.

Mick F

AND FINALLY, AT LAST, THE WING MIRRORS



WIRING THE STARTER MOTOR

P A R T S

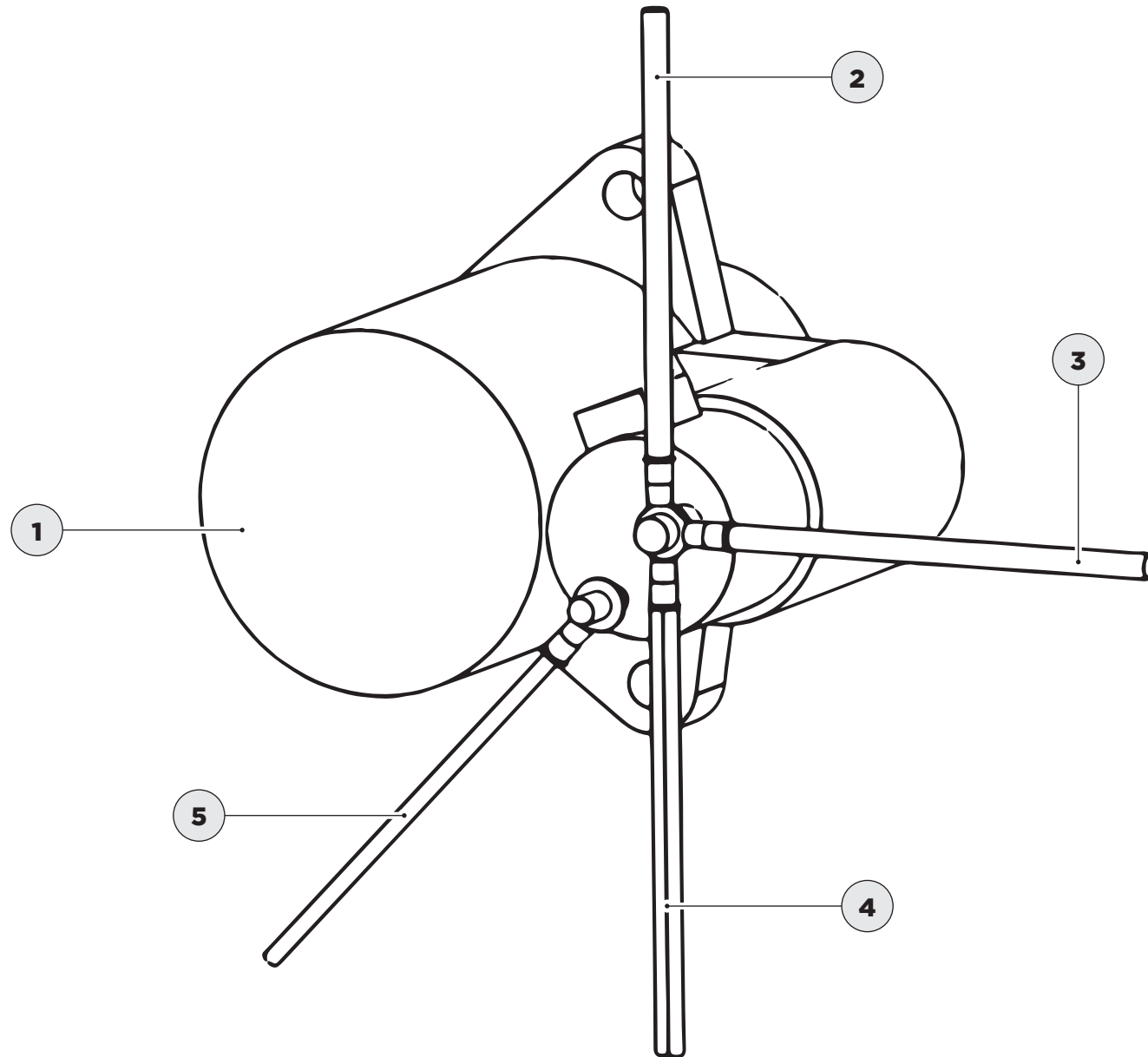
- 1** Starter motor
- 2** Cable from alternator
(brown wire with black sheath)
- 3** Cable from battery
(positive - red wire)
- 4** 2 cables from main loom
(2 brown wires joined)
- 5** Cable from engine loom
(white wire with red stripe)

T O O L S

F I X I N G S

T I P S

WIRING THE STARTER MOTOR



THE LAST FEW STEPS...

Your car is almost complete, but before you can drive triumphantly out of the garage (and legally, as far as the end of your driveway) there are a few important things that need to be done. These are, bleeding the brakes, preparing the engine for its first grand firing-up ceremony (it will feel like that, even if you are doing it on your own) and lastly torquing up the suspension.

So, on with bleeding the brakes which cannot be explained with a simple diagram unfortunately:

- 1** Assemble the things you'll need: Brake fluid, both a 10mm and an 11mm spanner, a length of washer hose (or similar clear plastic hose) and a waste fluid receptacle (some form of used bottle is ideal; you won't want to use it again after this)
- 2** Find a volunteer. They need to be able to reach and press the brake pedal, plus respond to your instructions, so whilst a child is fine for this job, someone's might be more inclined to listen to you.
- 3** Fill the brake master cylinder with fresh brake fluid and leave the cap off. **BE CAREFUL NOT TO SPILL ANY ONTO THE PAINTWORK**; if you do, wipe it off immediately. Brake fluid will react with the paintwork causing it to blister and peel.
- 4** Starting at the left rear corner, locate the bleed nipple on the caliper. It will have a rubber cap on it. Remove the cap, remember where you put it, and attach the washer hose to the nipple and put the other end in the waste bottle. This sometimes needs the hose warming up in a cup of hot water to allow it to stretch over the nipple.

- 5 Using the 10mm spanner, 'crack off' the nipple about half of a turn.
- 6 Ask your assistant to pump the pedal a few times. You should see bubbly fluid flowing through the pipe. When the bubbles die down, ask them to hold the pedal down, then tighten the nipple back up. Check and top of the fluid level in the reservoir as necessary.
- 7 Ask them to lift off, then pump it a couple of times, then press the pedal down and hold it down.
- 8 Crack off the nipple again and let the fluid and bubbles flow. It will stop flowing as soon as your assistant has run out of brake pedal travel. Tighten the nipple.
- 9 Repeat steps 8 and 9 until you get 100% bubble free fluid passing through the pipe, remembering to check and top up the reservoir. You will waste quite a lot of brake fluid during this process.
- 10 Once you are satisfied that there are no more bubbles (no more air in the caliper), then you can remove the washer hose and refit the dust cover.
- 11 Repeat steps 5 to 10 for the remaining brakes in this order, right rear next, then right front and lastly left front. The front brake nipples use an 11mm spanner.
- 12 Although tedious, getting all the air out of the braking system is important and will give you a good, firm brake pedal, which is what you need; not a soft spongy one like you have in a regular car. You may need to repeat the whole process after the first drive or two (or even after the car has had a ride on a trailer); air in the braking system is very good at hiding.

Brakes bled and we are ready to fire up the engine. Again, it's easier to explain in writing than draw a diagram. The only thing you'll need for this job is to ensure that you have put some fuel in the car. The shape of the Caterham fuel tank does not lend itself to making use of every last drop, so we recommend an absolute minimum of 10 litres in the tank before trying to start the car. With the tank filled, we are ready for initialisation.

But before anything else:

YOU DID REMEMBER TO PUT OIL IN THE ENGINE AND GEARBOX, RIGHT?

- 1 Reassure yourself the engine is full of oil.
- 2 Disconnect the inertia switch; it's the black thing attached to the engine bay bulkhead under the windscreen that has rubber cap on top and a plug with two wires connecting from underneath. By disconnecting the inertia switch, the fuel pump will not work, so intentionally, the engine will not fire.
- 3 Ensure the gearbox is in neutral, then turn the ignition key and press and hold the start button.
- 4 As the engine cranks over, watch the oil pressure gauge. Keep cranking until the needle starts to climb, then steadies out.
- 5 We now have oil pressure circulating in the engine, which means the engine is ready to be started.
- 6 Reconnect the inertia switch.
- 7 Take a deep breath, mutter 'this is it', cross your fingers and brace yourself.
- 8 Turn the ignition key, press and hold the start button. It will take a few moments for the fuel to get through, so do not expect an instant start.
- 9 All things willing, the engine will start. Hooray! If it stops straight away, don't worry. Try again and once it starts give it a little rev.

YOUR SEVEN *Adventure* AWAITS

That's it. Your car is complete! Well done – you have built a car; a real live car; not many people can say that. If you remembered to put in gearbox and differential oil, and fill the system with coolant, then a tentative edge out onto the driveway is in order. You'll need to pop the wheels on and lower it from the axle stands and just tighten the suspension first.

Let's just run through that quickly:

- i. Put a wheel on and do the nuts up a few turns by hand (to ensure they do not cross-thread).**
- ii. Tighten them up the best you can with the wheels off the ground.**
- iii. Lower the car from the axle stands, front first; taking care that it doesn't lean back on the axle stands at the back (a helper might be handy).**
- iv. Torque the wheel nuts to 65lbft (about 85Nm).**
- v. Flick back to the pages where we put the wishbones on and torque as shown**
- vi. That's it, you're ready to go!**

Take care and good luck with the IVA and registration process.

You will soon be experiencing the sheer pleasure of being a Caterham driver. Once again, enjoy!

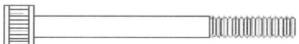
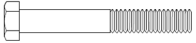
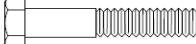








APPENDIX



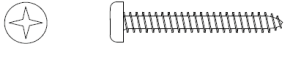
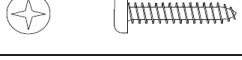


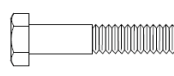


FIXING PACKS

Pack A		CATERHAM			SERIAL NUMBER 44	
					PACK NUMBER 30F015B	
FRONT SUSPENSION DeDION CARS (METRIC)						
<i>This pack may include extra fasteners to cover different options</i>						
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION	
1	AA Bolt M12 x 100 Grade 10.9	BM12X100	2	Lower wishbone rear		
2	AB Bolt M12 x 65 Grade 10.9	BM12X65	2	Lower wishbone front		
3	AC Bolt M10 x 65 Grade 10.9	BM10X65	2	Upper wishbone rear		
4	AD Bolt M10 x 60 Grade 10.9	BM10X60	2	Upper wishbone front		
5	AE Bolt M8 x 40 Grade 10.9	BM8X40	4	Anti-roll bar mounting brackets		
6	AF Plain Nut M14 x 1.5 thread	NMPH14	1	Temporary use to help lock upper wishbone ball joint		
7	AG Nyloc Nut M12	NMYF12	2	Lower wishbone rear		
8	AH Nyloc Nut M10	NMYF10	4	Upper wishbone		
9	AJ Plain Washer M12 Chamfered	WPCM12	18	Lower wishbone		
10	AK Plain Washer M8 Heavy duty	WPHM8	4	Anti-roll bar mounting brackets		
11	AL Plain Washer 3/4" x 3/4" Heavy duty	WPH3/8	2	Brake pipe		
Drawings are for illustrative purposes only and are not to scale.					Page 1 of 2	

Pack A		CATERHAM			SERIAL NUMBER 44	
					PACK NUMBER 30F015B	
FRONT SUSPENSION DeDION CARS (METRIC)						
<i>This pack may include extra fasteners to cover different options</i>						
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION	
12	AM Spring Washer M12	WSHM12	2	Lower wishbone front		
13	AN Spring Washer M8	WSHM8	6	Anti-roll bar mounting brackets & upper damper mount		
14	AP Washer 3/4" Shake-proof	WSS3/8	2	Brake pipe		
15	AR Nyloc Nut 1/2" Half height	NFYH1/2	2	Wing stay		
16	AS Nyloc Nut 1/2" Full height	NFYF1/2	2	Front brake, upright mounting (std track ONLY)		
Drawings are for illustrative purposes only and are not to scale.					Page 2 of 2	

FIXING PACKS

Pack B		CATERHAM		SERIAL NUMBER 55	
				PACK NUMBER 3ACZ0021	
		RELEASED NOV-19			
STEERING DeDION CARS (METRIC)					
<i>This pack may include extra fasteners to cover different options</i>					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	BA Caphead Bolt M6 x 70 DIN 912	BMCH6X70	4	Rack clamps	
2	BB Bolt 1/4" x 1 1/2"	BF1/4X1.1/2	2	Column clamp	
3	BC Bolt M8 x 40 Grade 10.9	BM8X40	2	Column to rack universal joint	
4	BD Nyloc Nut 1/2" Half height	NFYH1/2	1	Steering wheel boss	
5	BE Plain Nut 1/2"	NFPF1/2	2	Track rod lock nut	
6	BF Plain Nut 3/16" Half height	NFPFH7/16	1	Column clamp grubscrew locknut	
7	BG Nyloc Nut M8	NMYF8	2	Column to rack universal joint	
8	BH Nyloc Nut M6	NMYF6	4	Steering rack clamps	
9	BJ Plain Washer 1/2" x 1 1/4" Chamfered	WPH1/2	1	Steering wheel boss	
10	BK Plain Washer 3/4" Heavy duty	WPH1/4	6	Rack clamps and column clamp	
11	BL Spring Washer 3/4 Heavy duty	WSH1/4	2	Column clamp	
Drawings are for illustrative purposes only and are not to scale.					Page 1 of 1

Pack C		CATERHAM		SERIAL NUMBER 45	
				PACK NUMBER 30L002B	
		RELEASED NOV-19			
LIGHTING & HORNS					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	CA Screw 10 x 1/2" Black Supaflange	71080	6	Indicator assembly to indicator pod	
2	CB Screw 8 x 1/2" Black Supaflange	71077	2	Side repeater earth on wingstay	
3	CC Screw 12 x 1 1/4" Self tapping	71079	4	Rear light cluster upper fixing	
4	CD Screw 12 x 1" Self tapping	71078	4	Rear light cluster lower fixing	
5	CE Nyloc Nut M6	NMYF6	2	Horn bracket to steering rack platform (160/270/310)	
6	CF Plain Washer 3/4" Heavy duty	WPH1/4	2	Horn bracket to steering rack platform (160/270/310)	
7	CG Bolt M8 x 5 Grade 8.8	BM8X50	1	Through steering rack platform & spacer (420)	
8	CH Plain Washer 5/16"	WPH5/16	2	Bolt head/nut	
9	CI Nyloc Nut M8	NMYF8	1	Horn bolt	
Drawings are for illustrative purposes only and are not to scale.					Page 1 of 1

FIXING PACKS

Pack D		CATERHAM		SERIAL NUMBER	44
				PACK NUMBER	30C047B
COOLING SIGMA					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	DA Bolt M8 X 50 Grade 8.8	BM8X50	1	Expansion tank bracket to chassis	
2	DB Setscrew 1/4" X 3/4"	SF1/4X3/4	1	Expansion tank to bracket	
3	DC Setscrew M8X20 Grade 8.8	SM6X20	4	SV radiator bracket	
4	DD Bolt M6 X 16 with square section	30Z1072A	4	Fan brackets to fan	
5	DE Setscrew M6X16 Panhead Pozi	SPHM6X16	4	Fan to radiator cowling - SV only	
6	DF Nyloc Nut M6	NMYF6	8	x4 Fan to radiator x4 SV radiator bracket	
7	DG Plain Nut M8	NMPF8	8	Radiator bobbin	
8	DH Nyloc Nut 1/4"	NFYF1/4	1	Expansion tank bracket	
9	DI Plain Washer 1/4" Heavy duty	WPH1/4	13	8 x SV rad bracket 4 x Fan fixings 1 x Expansion tank bracket	
10	DJ Plain Washer 5/16" Heavy duty	WPH5/16	4	Radiator bobbin back	
11	DK Plain Washer 5/16" x 7/8" Heavy duty	WPH5/17X7/8	4	Radiator bobbin front	

Drawings are for illustrative purposes only and are not to scale.

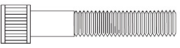





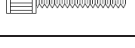
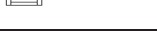
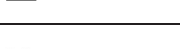
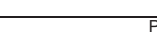
Page 1 of 2

Pack D		CATERHAM		SERIAL NUMBER	44
				PACK NUMBER	30C047B
COOLING SIGMA					
This pack may include extra fasteners to cover different options					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
12	DL Plain Washer 1/4" x 7/8" Heavy duty	WPH1/4X7/8	1	Expansion tank bracket	
13	DM Spring Washer 5/16" Heavy duty	WSH5/17	9	8 x Radiator bobbin 1 x Expansion tank	
14	DN Hose Clip 30 - 40mm	SGT25-40	6	2 x U shape hose to water rail 2 x Top radiator hose 2 x Bottom radiator hose	
15	DO Hose Clip 23 - 35mm	SGT23-35	2	1 x Engine outlet to big T piece 1 x Engine outlet to heater inlet	
16	DP Hose Clip 17 - 25mm	SGT16-25	18	6 x Heater inlet/outlet 3 x Big T-piece 1 x Expansion tank 2 x Modine 4 x Dry Sump 2 x Submarine	
17	DQ Hose Clip 8 - 16mm	SGT8-16	6	Expansion tank small T-piece	
18	DR Rivet - Black 5/32" X 0.47"	1610-01015	12	Cowling flap	

Drawings are for illustrative purposes only and are not to scale.









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FIXING PACKS

Pack E		CATERHAM		SERIAL NUMBER	66
				PACK NUMBER	3EZ1105F
SIGMA GEARBOX 5 SPEED					
<i>This pack may include extra fasteners to cover different options</i>					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	EA Bolt M14 X 40 Grade 12.9	3EZ1137A	2	AV Mount	
2	EB Caphead Bolt M8 X 40 Grade 12.9	30Z1076A	4	AV Mount	
3	EC Caphead Bolt M12 X 50 Grade 12.9 Coarse Thread	3EZ1142A	4	Gearbox	
4	ED Caphead Bolt M10 X 60 Grade 12.9	BMCH10X60	4	1 x Bellhousing 3 x Starter Motor	
5	EE Caphead Bolt M10 X 55 Grade 12.9	BMCH10X55	3	Bellhousing	
6	EF Caphead Bolt M10 X 40 Grade 12.9	BMCH10X40	3	Bellhousing	
7	EG Caphead Bolt M10 X 35 Grade 12.9	BMCH10X35	2	Engine Mount RHS Top	
8	EH Caphead Bolt M8 X 25 Grade 12.9	BMCH8X25	2	Engine Mount 1 x LHS Top 1 x LHS Bottom	
9	EI Caphead Bolt M8 X 30 Grade 12.9	BMCH8X30	1	Engine Mount LHS Bottom	
10	EJ Caphead Bolt M8 X 35 Grade 12.9	BMCH8X35	2	Engine Mount RHS Bottom	
11	EK Caphead Bolt M6 X 25 Grade 12.9	BMCH6X25	3	Clutch Slave Cylinder	

Drawings are for illustrative purposes only and are not to scale.


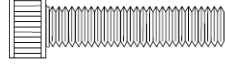




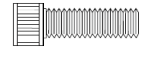




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Pack E		CATERHAM		SERIAL NUMBER	66
				PACK NUMBER	3EZ1105F
SIGMA GEARBOX 5 SPEED					
<i>This pack may include extra fasteners to cover different options</i>					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
12	EL Buttonhead Bolt M6 X 10 Grade 10.9 Internal Hex	3GZ1163A	3	Gear Lever	
13	EM Plain Washer M14	WPH14	2	AV Mount	
14	EN Plain Washer M12	30Z2031A	4	Gearbox	
15	EO Plain Washer M6	WPHM6	3	Gear Lever	
16	EP Plain Washer 5/16"	WPH5/16	8	AV Mount	
17	EQ Spring Washer M12	WSHM12	4	Gearbox	
18	ER Spring Washer M10	WSHM10	10	x 7 Bellhousing 3 Engine Mount	
19	ES Wire Spring Washer M10	WSHM10	3	Starter Motor	
20	ET Spring Washer M8	WSHM8	5	Engine Mount	
21	EU Spring Washer M6	WSHM6	3	Clutch Slave Cylinder	
22	EV Myloc Nut M8	NMYF8	4	AV Mount	
23	EW Spring Washer M14	30Z2030A	2	AV Mount	

Drawings are for illustrative purposes only and are not to scale.






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FIXING PACKS

Pack F		CATERHAM		SERIAL NUMBER 66	
				PACK NUMBER	
				3EZ2029B	
DURATEC GEARBOX 5 SPEED					
<i>This pack may include extra fasteners to cover different options</i>					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	FA Bolt M14 X 30 X 1.5 Grade 12.9	30Z2032A	2	AV Mount	
2	FB Caphead M12 X 40 X 1.75 Grade 12.9	BMCH12X40	4	Bellhousing	
3	FC Caphead Bolt M10 X 90 Grade 12.9	BMCH10X90	1	Bellhousing	
4	FD Caphead Bolt M10 X 55 Grade 12.9	BMCH10X55	3	Bellhousing	
5	FE Caphead Bolt M10 X 45 Grade 12.9	BMCH10X45	7	x 5 Bellhousing x 2 Starter Motor	
6	FF Caphead Bolt M8 X 40 Grade 12.9	30Z1076A	4	AV Mount	
7	FG Caphead Bolt M6 X 25 Grade 12.9	BMCH6X25	3	Clutch Release Bearing	
8	FH Buttonhead Bolt M6 X 10 Grade 10.9 Internal Hex	3GZ1163A	3	Gear Lever	
9	FI Nyloc Nut M8	NMYF8	4	AV Mount	
10	FJ Plain Washer M14	WPH14	2	AV Mount	
11	FK Plain Washer M12	30Z2031A	4	Bellhousing	

Drawings are for illustrative purposes only and are not to scale.

Page 1 of 2

Pack F		CATERHAM		SERIAL NUMBER 66	
				PACK NUMBER	
				3EZ2029B	
DURATEC GEARBOX 5 SPEED					
<i>This pack may include extra fasteners to cover different options</i>					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
12	FL Plain Washer M6	WPHM6	3	Gear Lever	
13	FM Spring Washer M14	30Z2030A	2	AV Mount	
14	FN Spring Washer M12	WSHM12	4	Gearbox	
15	FO Spring Washer M10	WSHM10	4	x 2 Starter Motor x 2 Front Bellhousing	
16	FP Spring Washer M6	WSHM6	3	Clutch Slave Cylinder	

Drawings are for illustrative purposes only and are not to scale.

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FIXING PACKS

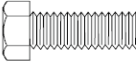


Pack **G**

CATERHAM

SERIAL NUMBER	56
PACK NUMBER	30X020B

EXHAUST

This pack may include extra fasteners to cover different options

ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	GA Setscrew M8 X 25 Grade 8.8	SM8X25	1	Exhaust Mounting Bracket	
2	GB Plain Nut M8	NFPF8	2	Exhaust Bobbin	
3	GC Spring Washer M8	WSHM8	3	x 1 Exhaust Mounting Bracket x 2 Exhaust Bobbin	

Drawings are for illustrative purposes only and are not to scale.

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FIXING PACKS

Pack H		CATERHAM		SERIAL NUMBER 53	
				PACK NUMBER	
				30R011D	
REAR SUSPENSION DEDION METRIC					
<i>This pack may include extra fasteners to cover different options</i>					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
1	HA Bolt M12 X 100 Grade 10.9	BM12X100	2	A-frame front mountings	
2	HB Caphead Bolt M10 X 65	BMCH10X65	2	Front radius arm (through cockpit)	
3	HC Bolt 1/2" X 2.1/2" Grade 10.9	BF1/2X2.1/2	4	x 2 Lower Rear Damper 2 Rear Radius Arm	
4	HD Bolt M6 X 80 Grade 10.9	BM6X80	4	Rear Anti Roll Bar Mounting Blocks	
5	HE Bolt 1/2" X 2.3/4" Grade 10.9	BF1/2X2.3/4	1	A-frame to DeDion	
6	HF Half Nyloc 1/2" UNF	NFYH1/2	3	x 2 Rear Radius Arm 1 A-frame to DeDion	
7	HG Nyloc Nut M12	NMYF12	2	A-frame front mounts	
8	HH Nyloc Nut M10	NMYF10	2	Front radius arm (through cockpit)	
9	HI Half Nyloc M8	NMYH8	2	Rear Anti Roll Bar Drop Link	
10	HJ Nyloc Nut M6	NMYF6	4	Rear Anti Roll Bar Mounting Blocks	
11	HK Nyloc Nut 1/4"	NFYF1/4	1	3 - way union on DeDion tube	

Drawings are for illustrative purposes only and are not to scale.

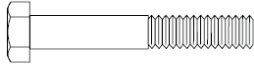

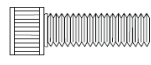




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Pack H		CATERHAM		SERIAL NUMBER 53	
				PACK NUMBER	
				30R011D	
REAR SUSPENSION DEDION METRIC					
<i>This pack may include extra fasteners to cover different options</i>					
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION
12	HL Washer	79029	10	Differential Isolation	
13	HM Plain Washer 1/2" Chamfered	WPH1/2	20	x 2 Lower Damper x 10 A-frame washers 4 Radius Arm	
14	HN Plain Washer 3/8" X 7/8"	WPH3/8X7/8	2	Front Radius Arm	
15	HO Plain Washer M6	WPHM6	4	Rear Anti Roll Bar Mounting Block	
16	HP Schnorr Washer M12	30Z1069A	2	Lower Damper	

Drawings are for illustrative purposes only and are not to scale.



Page 2 of 2





FIXING PACKS

Pack J		CATERHAM			SERIAL NUMBER		47	
					PACK NUMBER		30P010A	
ROLL OVER & TRACK DAY BAR SERIES 3 METRIC								
<i>This pack may include extra fasteners to cover different options</i>								
ITEM		BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION		
1	JA	Bolt M10 X 60 Grade 8.8	BM10X60	2	Rear diagonals of roll over bar to mounting brackets			
2	JB	Setscrew M8 X 20 Grade 8.8	SM8X20	2	Roll over bar bracket to chassis			
3	JC	Caphead Bolt M10 X 20	BMCH10X20	2	Roll over bar boss			
4	JD	Nyloc Nut M10	NMYF10	2	Rear diagonals of roll over bar to mounting brackets			
5	JE	Plain Washer M8	WPHM8	2	Roll over bar bracket to chassis			
6	JF	Spring Washer M8	WSHM8	2	Roll over bar bracket to chassis			
7	JG	Plain Washer M10	WPHM10	4	Rear diagonals of roll over bar to mounting brackets			
Drawings are for illustrative purposes only and are not to scale.						Page 1 of 1		

Pack O		CATERHAM			SERIAL NUMBER			
					PACK NUMBER		ZWS01	
WING PROTECTORS STAINLESS STEEL								
<i>This pack may include extra fasteners to cover different options</i>								
ITEM		BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION		
1	OA	Rivet 1/8" X 0.51"	1661-0414	30	Wing protector to wing			
2	OB	Wing Piping	76901	2m	Between wing protector and wing			
Drawings are for illustrative purposes only and are not to scale.						Page 1 of 1		

FIXING PACKS

Pack P		CATERHAM			SERIAL NUMBER PACK NUMBER ZWS02	
WING PROTECTORS CARBON FIBRE						
<i>This pack may include extra fasteners to cover different options</i>						
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION	
1	PA Rivet Black 1/8" X 0.51"	1610-01049	30	Wing protector to wing		
2	PB Wing Piping	76901	2m	Between wing protector and wing		
Drawings are for illustrative purposes only and are not to scale.					Page 1 of 1	

Pack Q		CATERHAM			SERIAL NUMBER 31 PACK NUMBER ZFG12	
REAR WINGS						
<i>This pack may include extra fasteners to cover different options</i>						
ITEM	BASIC DESCRIPTION	PART NUMBER	QTY	USED ON	ILLUSTRATION	
1	QA Set Screw M5 X 20	SM5X20	20	Rear Wings		
2	QB Nylc Nut M5	NMYF5	10	Rear wings through boot		
3	QC Plain Washer 3/16" X 3/4"	WP3/16X3/4	30	Wing washers		
4	QD Wing Piping 1/4" X 1"	76902	4m	Between wing and body		
Drawings are for illustrative purposes only and are not to scale.					Page 1 of 1	

CATERHAM®

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