SEAT SPORT

SEAT LEON CUP RACER 2016
BODY-SHELL MODIFICATIONS

TECHNOLOGY TO ENJOY

Body-shell modifications
SEAT LCR 2016

01 **KIT 1 – AERO PACKAGE + COOLING PACKAGE**

02 **KIT 2 – FIA FT3 FUEL TANK**

03 **KIT 3 – SEQUENTIAL GEARBOX**

This document resumes the body-shell modifications to adapt a 2014 or 2015 car to the 2016 specs depending on the kit(s) that is/are going to be installed. Even if only a single kit is bought, it is strongly recommended to read the complete document and perform as much modifications as possible to advance future updates.

Body-shell modifications
SEAT LCR 2016

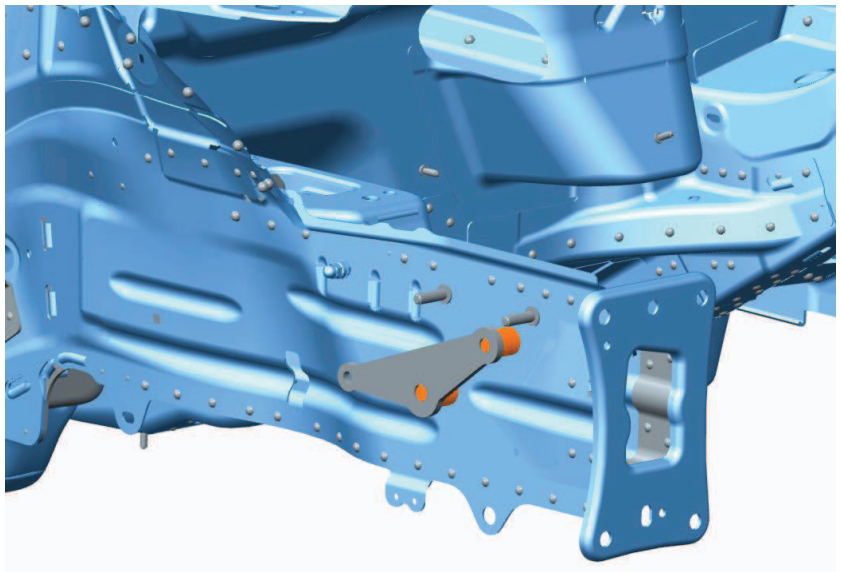
01 KIT 1 – AERO PACKAGE + COOLING PACKAGE

- 01.01 Threaded bushings for splitter tie rods
- 01.02 Cut for side door sills
- 01.03 Cut for rear beam
- 01.04 Bonnet cut for new intercooler placement

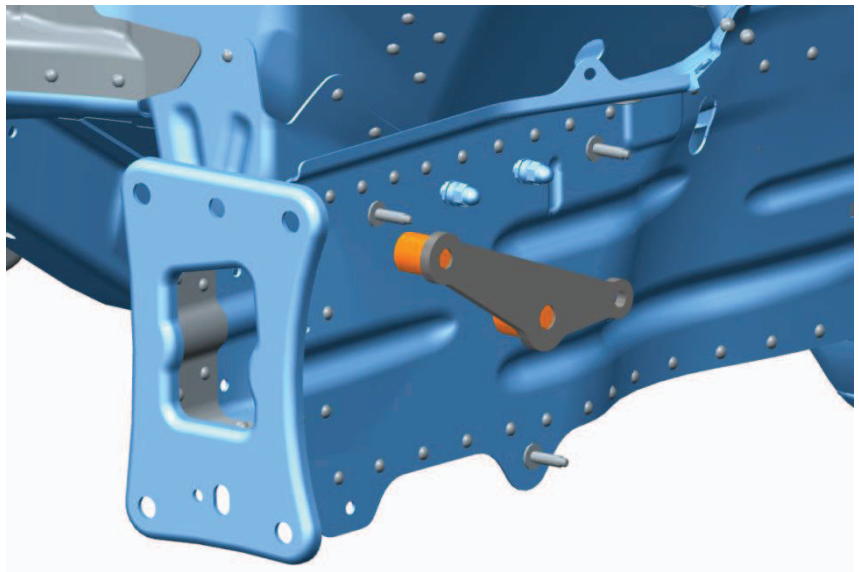
01.01 Threaded bushings for splitter tie rods

Use the bushing positioning tools U5F6825006 and U5F6825007 centering them with the holes that already are on the body-shell. Sand the original paint in the area where the bushings are going to be welded.

Right side member - U5F6825007



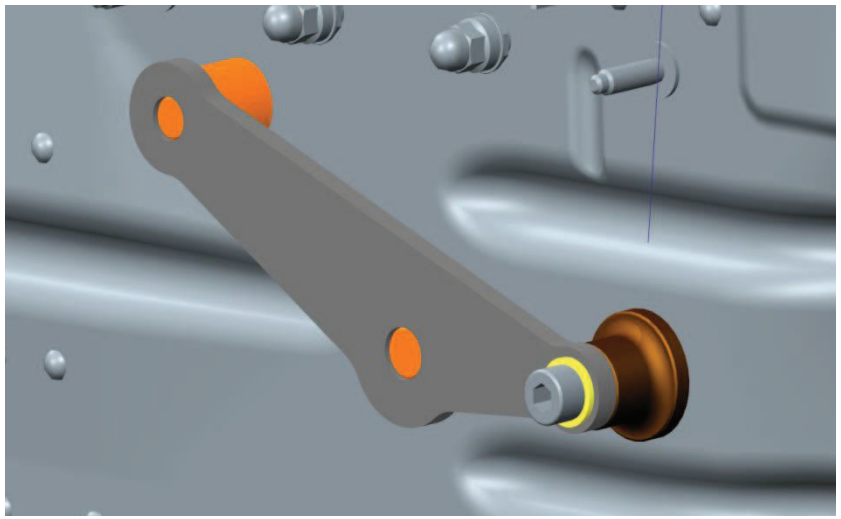
Left side member - U5F6825006



01.01 Threaded bushings for splitter tie rods

Using the tool, present the threaded bushing (5F6825416A) on its position and fix it with some welding points. Disassemble the tool and proceed with the contour welding. Finally paint again the area to prevent from corrosion.

U5F6825006 with 5F6825416A bushing

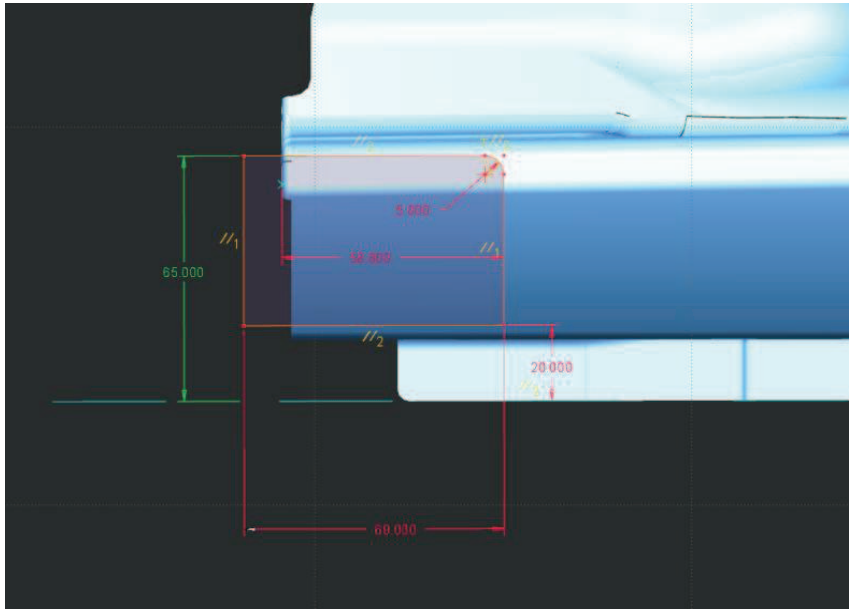


Final result

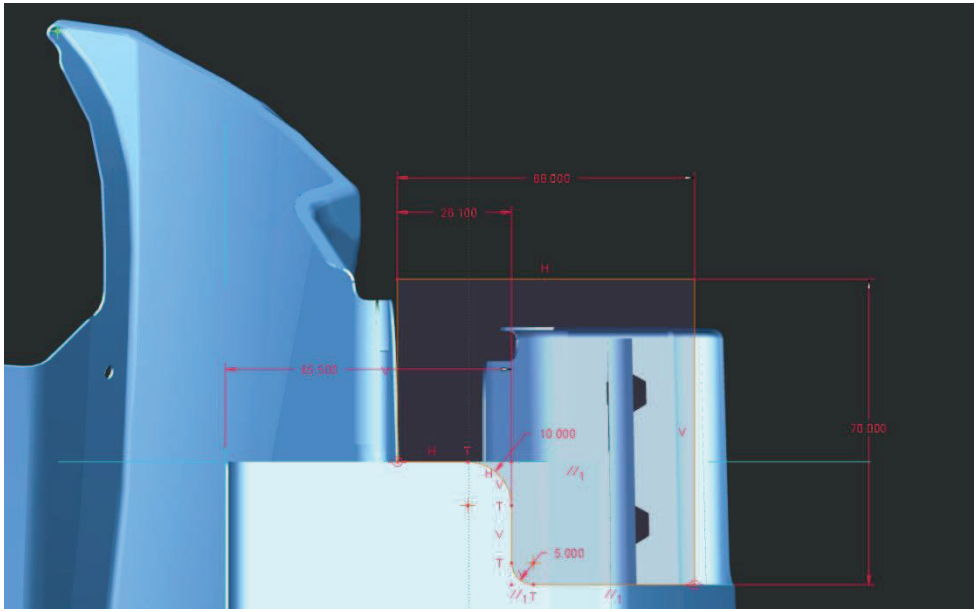
01.02 Cut for side door sills

Mark the cut on the body-shell side trims in the front wheel arc area following the drawings bellow. Do it symmetrically on the right side.

Left side trim seen from lateral



Left side trim seen from bellow



01.02 Cut for side door sills

Cut the body-shell and paint it to prevent from corrosion.

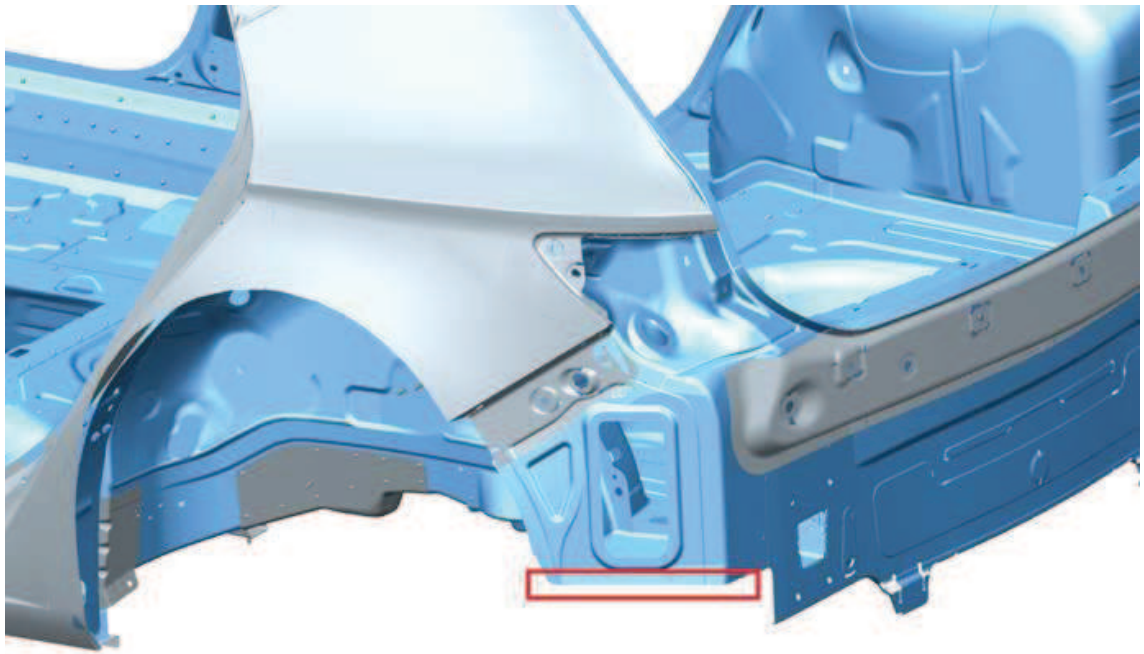
Right side trim cut finished

Left side trim cut finished

01.03 Cut for rear beam

Cut the body-shell 15 mm over and in parallel the highlighted edge in both sides.

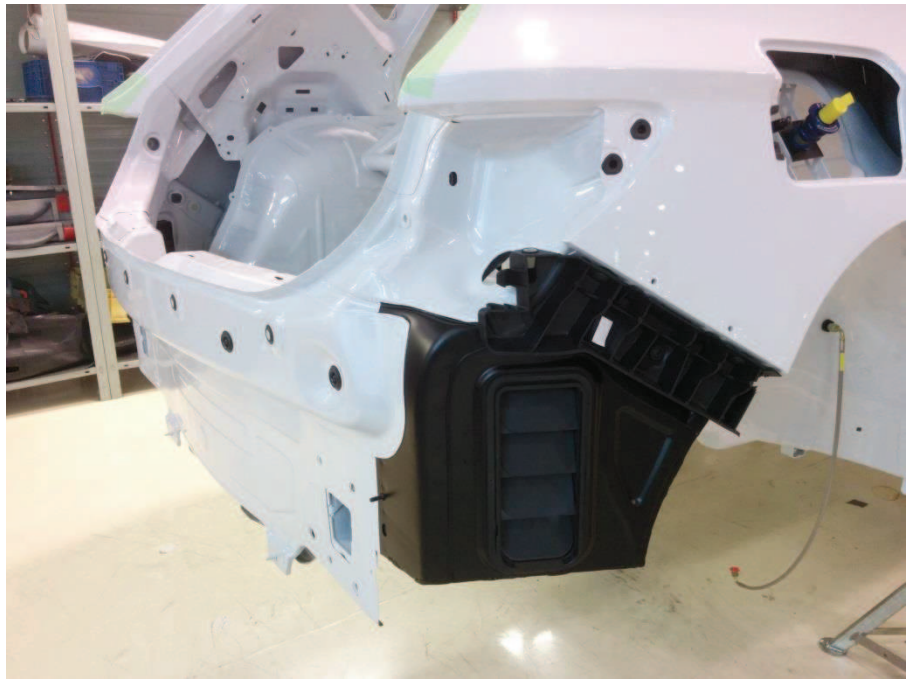
Rear side cut for rear beam



01.03 Cut for rear beam

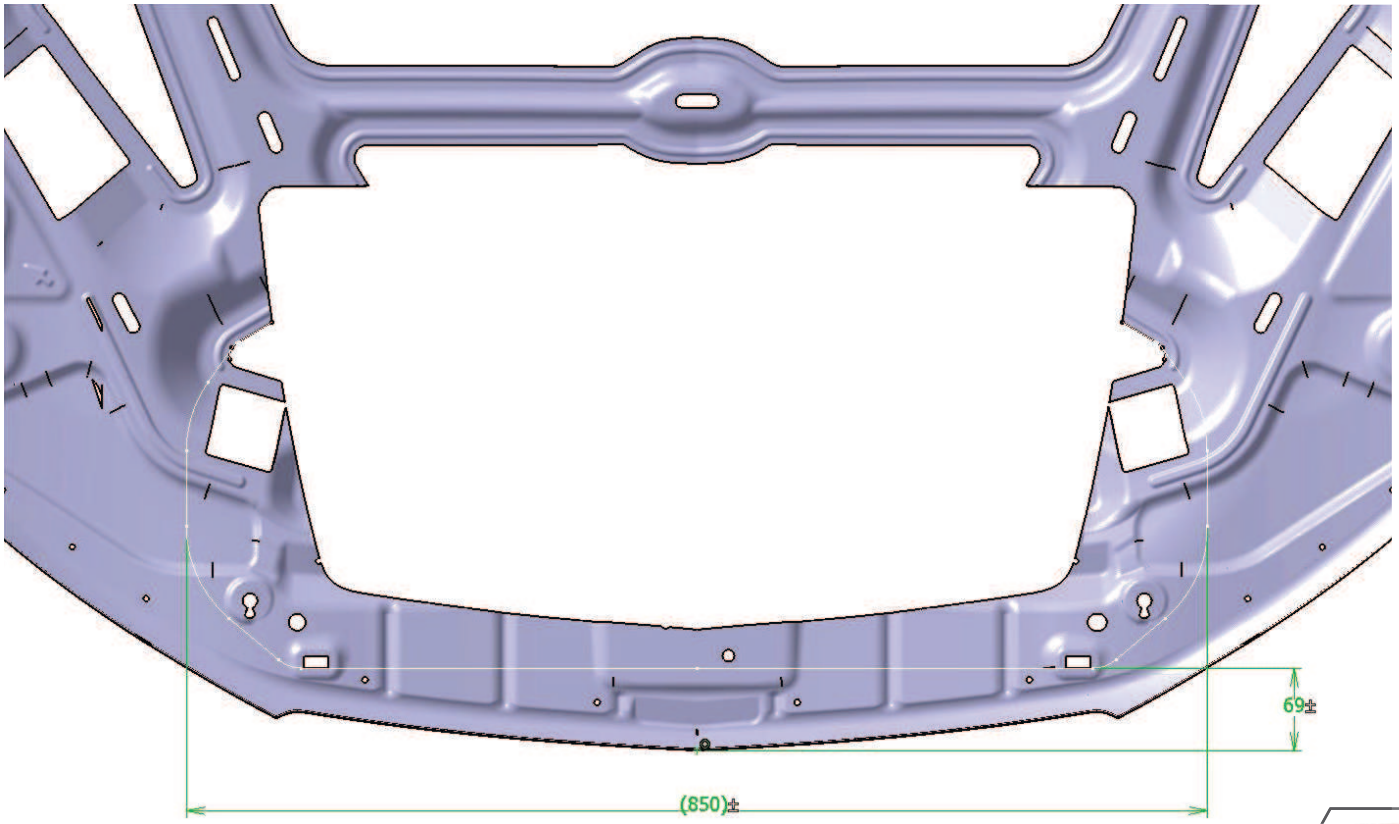
Paint the cut area to prevent from corrosion.

Rear cuts finished



01.04 Bonnet reinforcement cut for intercooler placement

Cut only the inner bonnet reinforcement as shown in the next drawing.



01.04 Bonnet reinforcement cut for intercooler placement

Paint the cut area to prevent from corrosion.

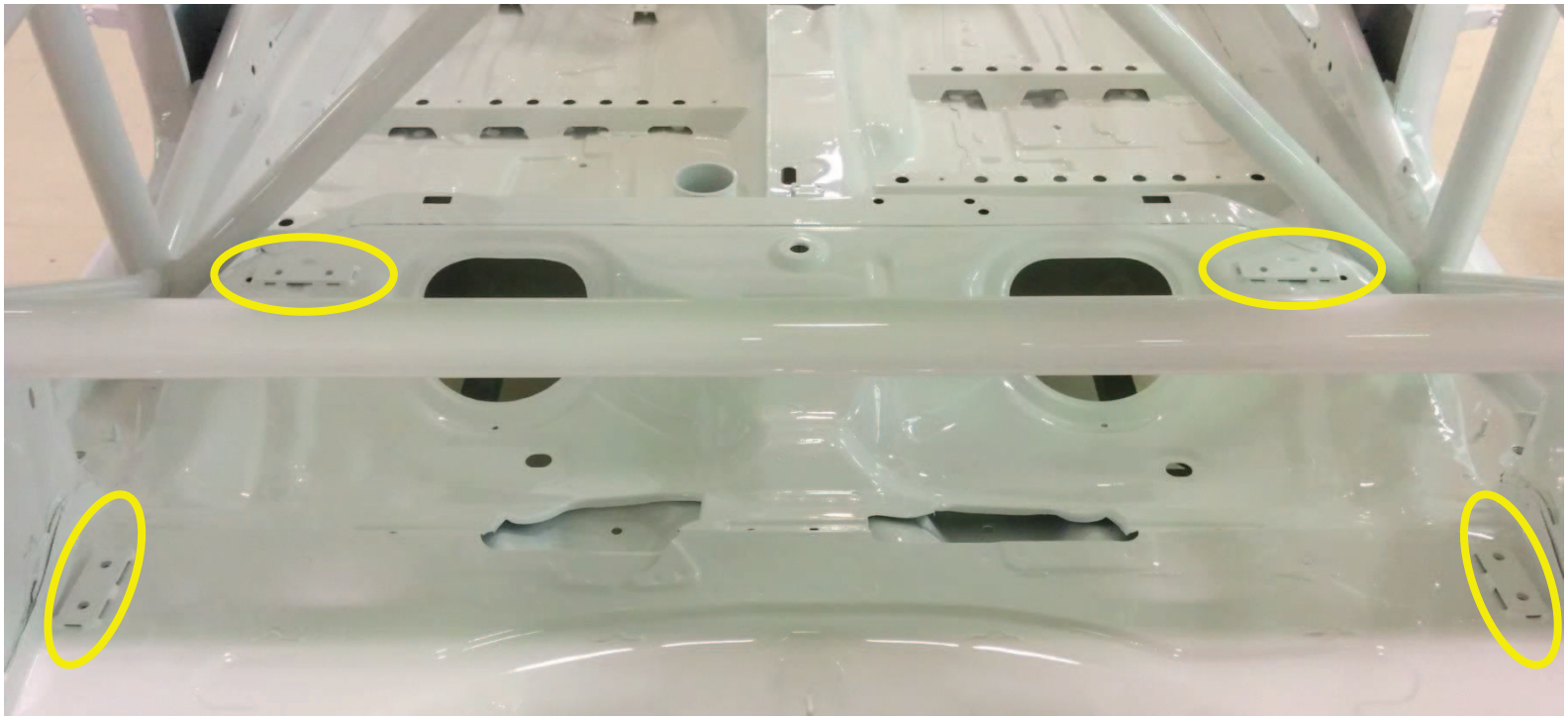
Body-shell modifications
SEAT LCR 2016

02 KIT 2 – FIA FT3 FUEL TANK

- 02.01 Cut for fuel tank housing
- 02.02 New fuel tank supports welding
- 02.03 Hole for fuel line
- 02.04 Hole for ventilation hose

02.01 Cut for fuel tank housing

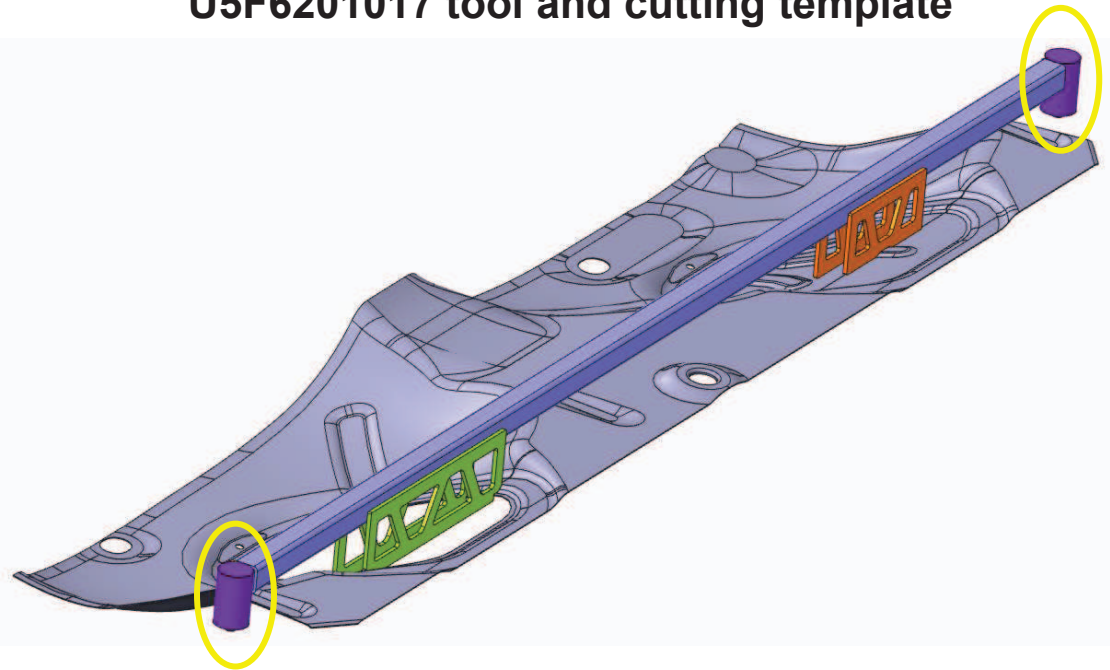
First of all remove carefully the 4 threaded supports already welded to the body-shell that were used to fix the additional fuel tank, highlighted bellow.



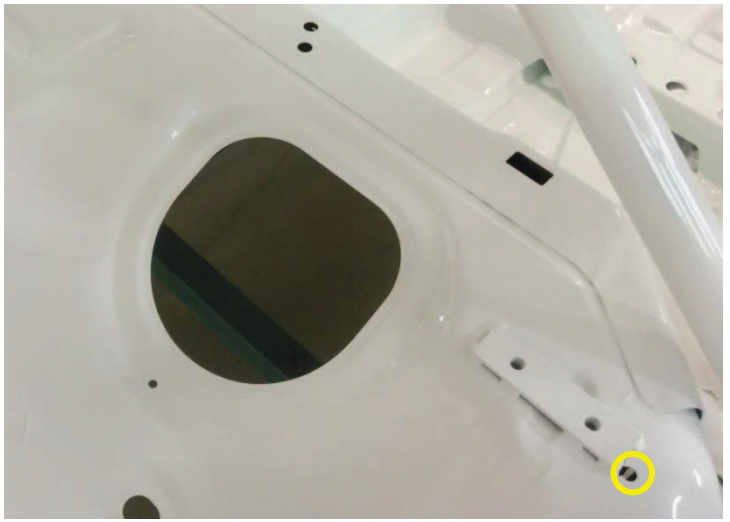
02.01 Cut for fuel tank housing

Use the U5F6201017 tool to place the template used to mark the cutting area as shown below. Fix the tool using the two existing holes near rear doors.

U5F6201017 tool and cutting template

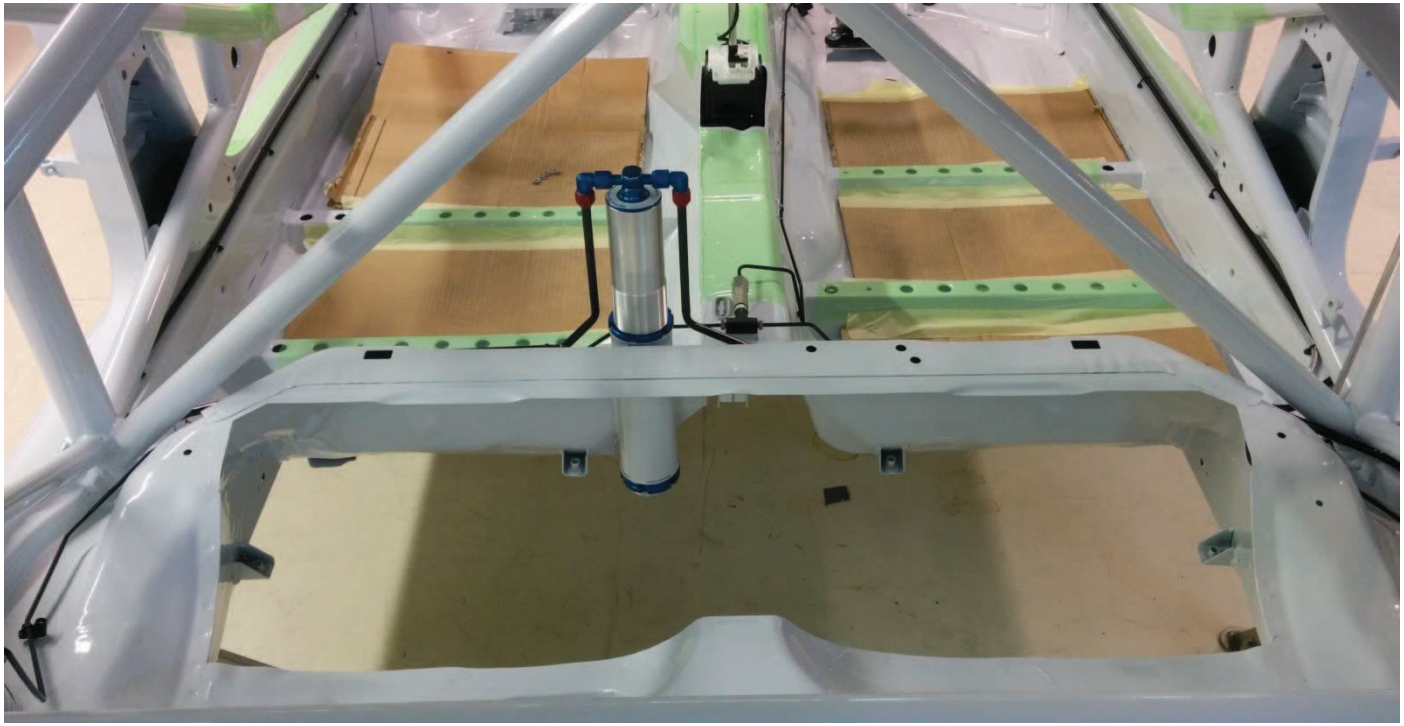


Hole to fix the tool



02.01 Cut for fuel tank housing

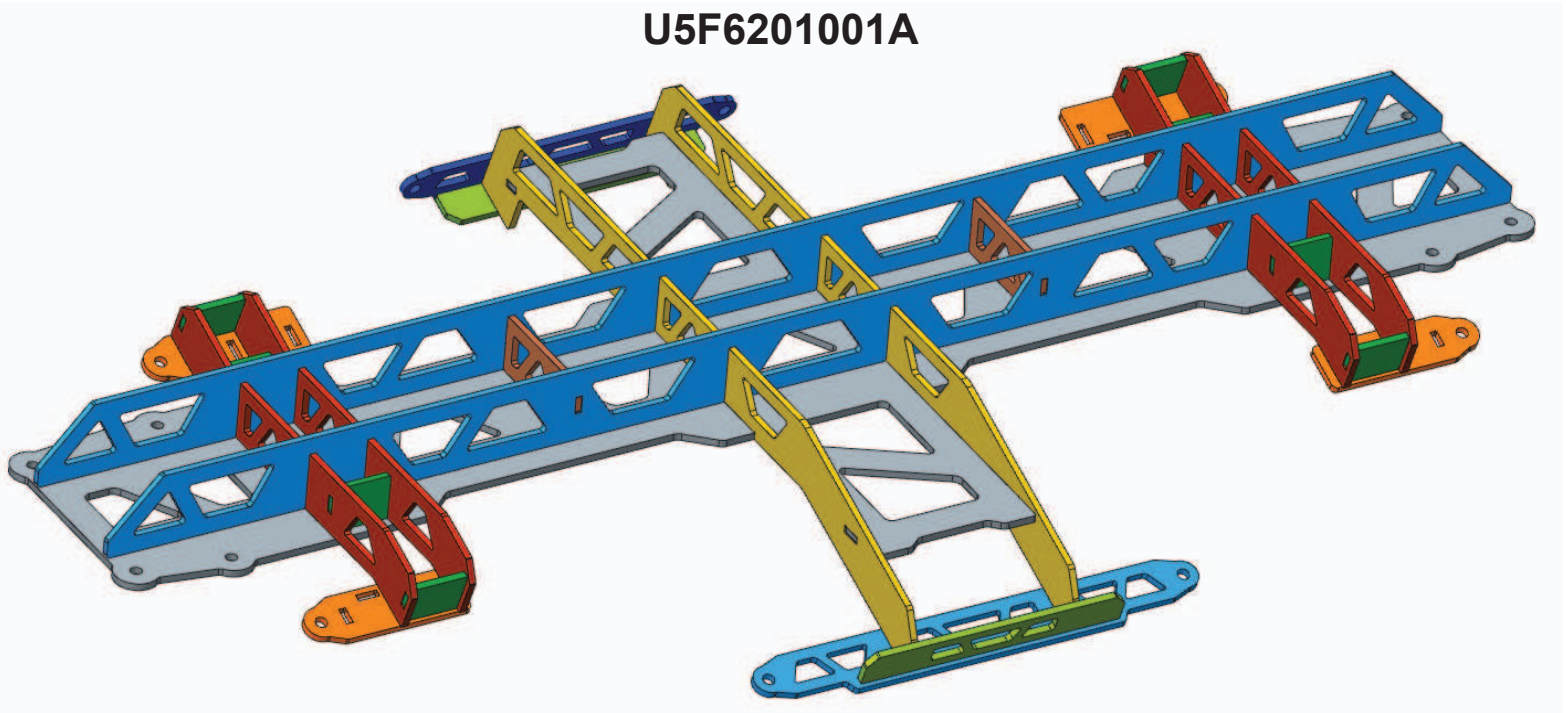
Mark the cut all around the template and then remove the tool. Now cut the body-shell from the inner part of the mark.



02.02 New fuel tank supports welding

For this job is necessary the tool U5F6201001A and the eight supports that have to be welded to the body-shell.

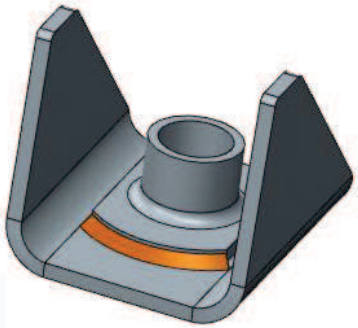
U5F6201001A



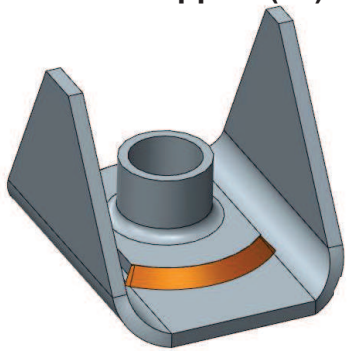
02 KIT 2 – FIA FT3 FUEL TANK
SEAT LCR 2016

02.02 New fuel tank supports welding

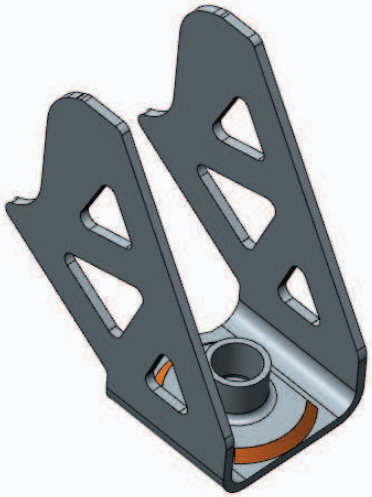
5F6 804 865 B
Lateral front support (x2)



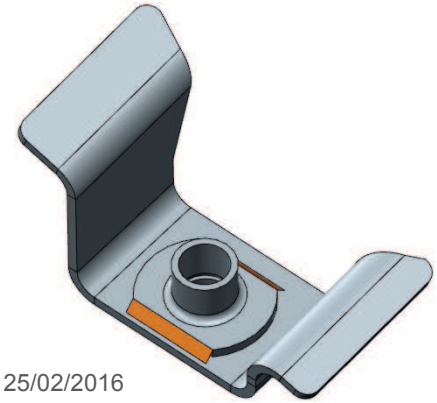
5F6 804 866 B
Front support (x2)



5F6 201 870
Rear left support (x1)



5F6 804 879 B / 880 B
Lateral rear support (x1 / x1)



5F6 201 872
Rear right support (x1)

02 KIT 2 – FIA FT3 FUEL TANK
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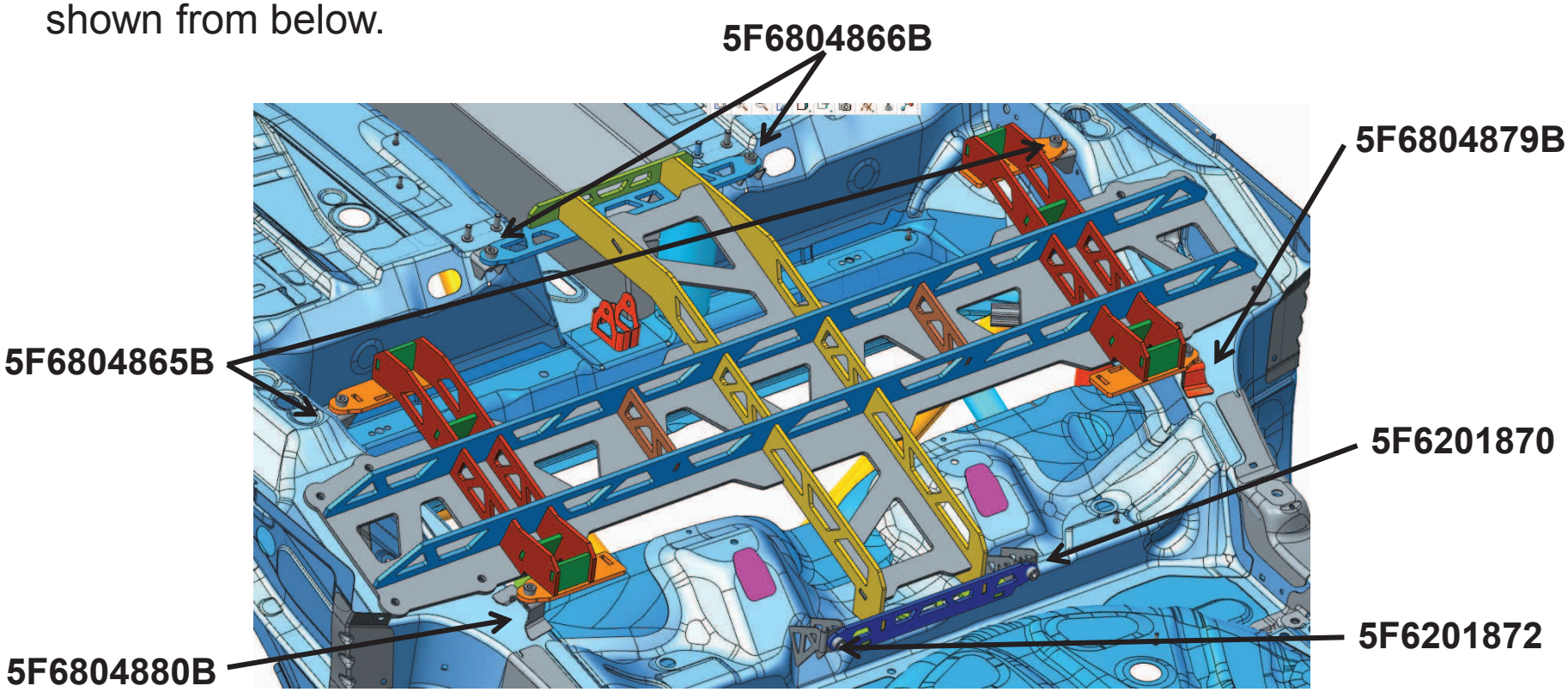
02.02 New fuel tank supports welding

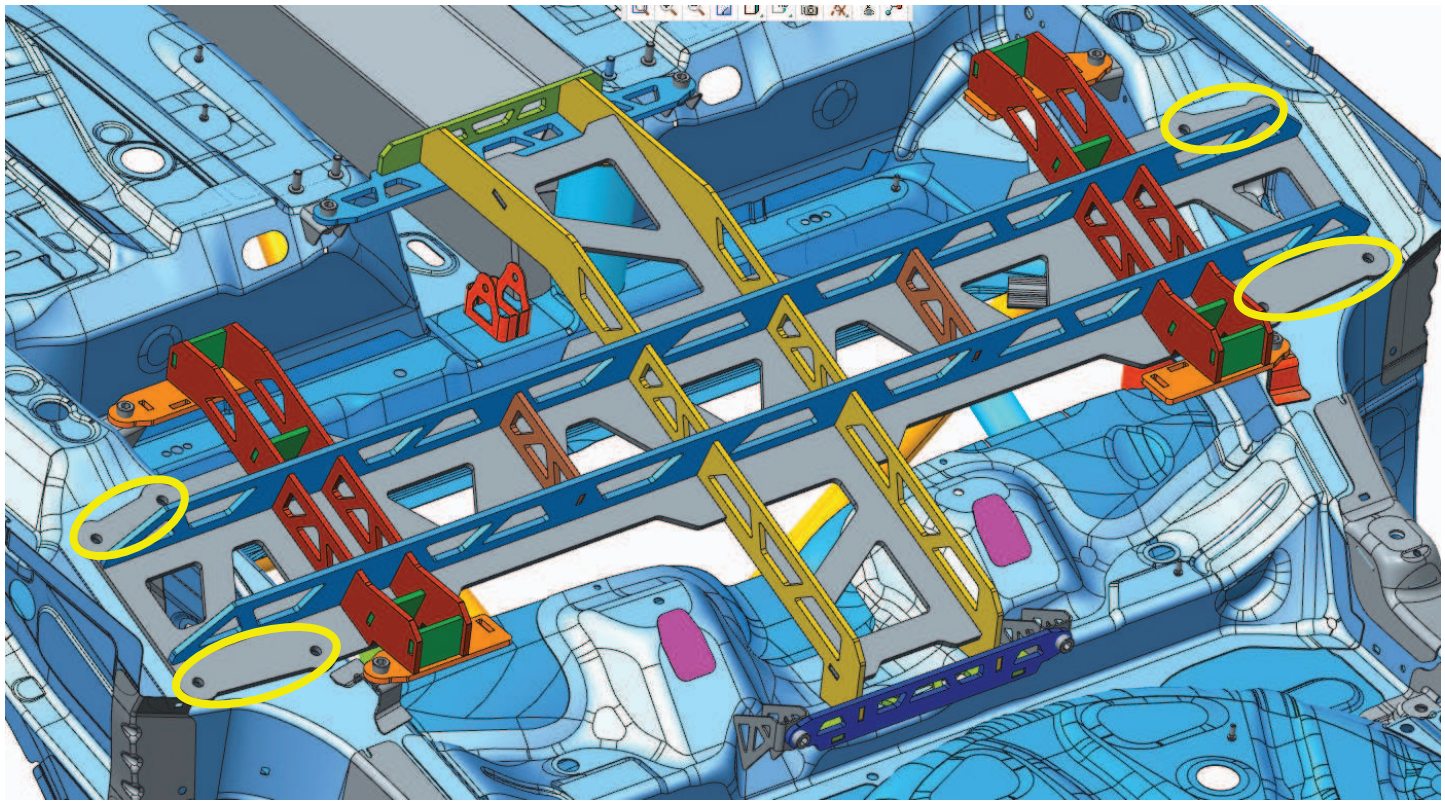
Fix all the supports to the tool and present it on the body-shell. Then sand the areas were the supports touch the body-shell. In the drawing the body-shell is shown from below.



02 **KIT 2 – FIA FT3 FUEL TANK**
SEAT LCR 2016

02.02 New fuel tank supports welding

Once sanded, fix the tool to the body-shell using eight bolts in the highlighted areas. Use the threads already existing in all body-shells.



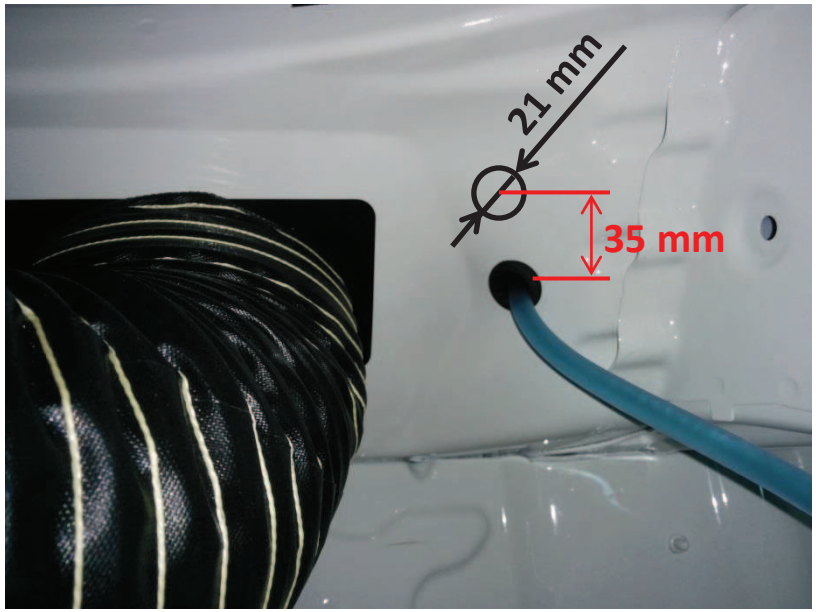
02.02 New fuel tank supports welding

Once the welding is finished remove the tool and paint to prevent from corrosion.

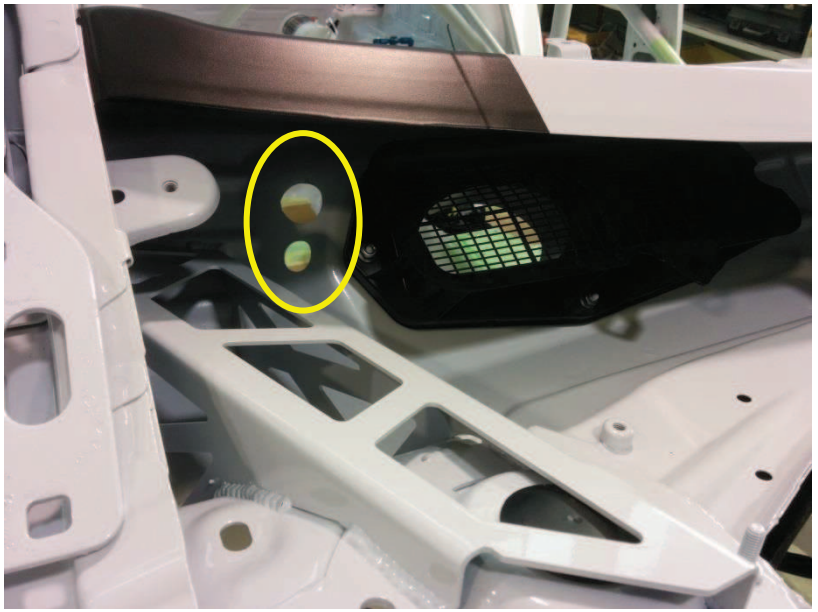
02.03 Hole for fuel line

A Ø21 mm hole has to be done 35 mm above the already existing hole for the windscreen washer fluid hose under the dashboard next to the co-driver door.

Inside view



Outside view

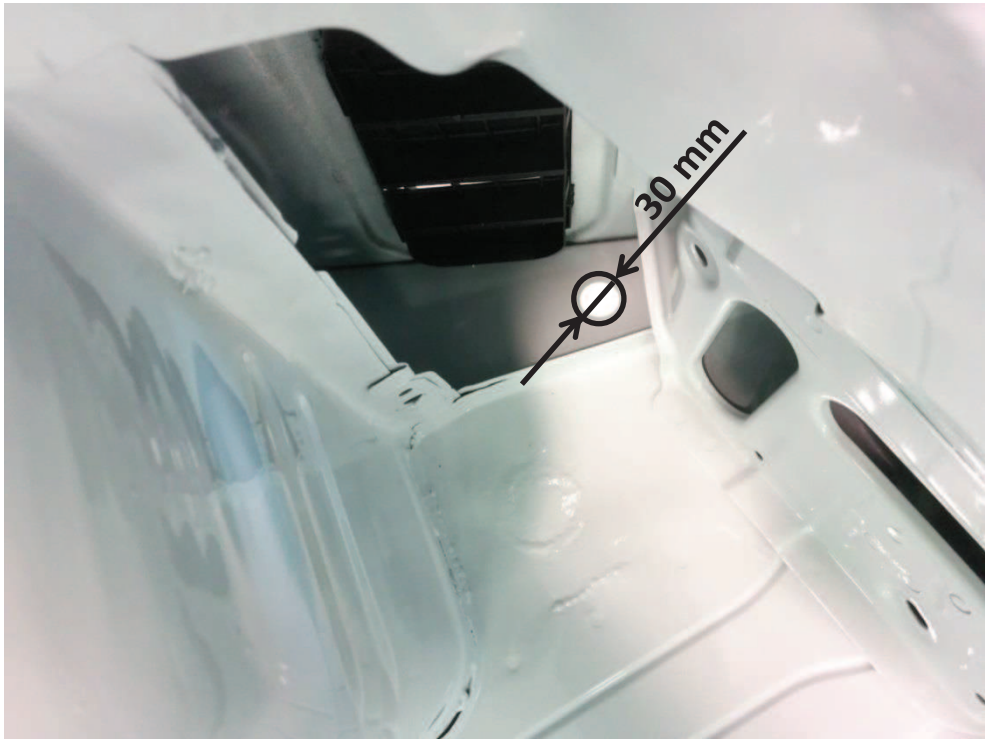


02.03 Hole for fuel line

Once the hole is done paint the area to prevent from corrosion. It is recommended to make the windscreen washer fluid hose go through the upper hole and the fuel line through the lower one.

02.04 Hole for ventilation hose

Enlarge the Ø20 mm hole shown bellow into Ø30 mm. This hole can be found inside the cockpit under the right tail light. Once finished, paint it to prevent from corrosion.



03 KIT 3 – SEQUENTIAL GEARBOX

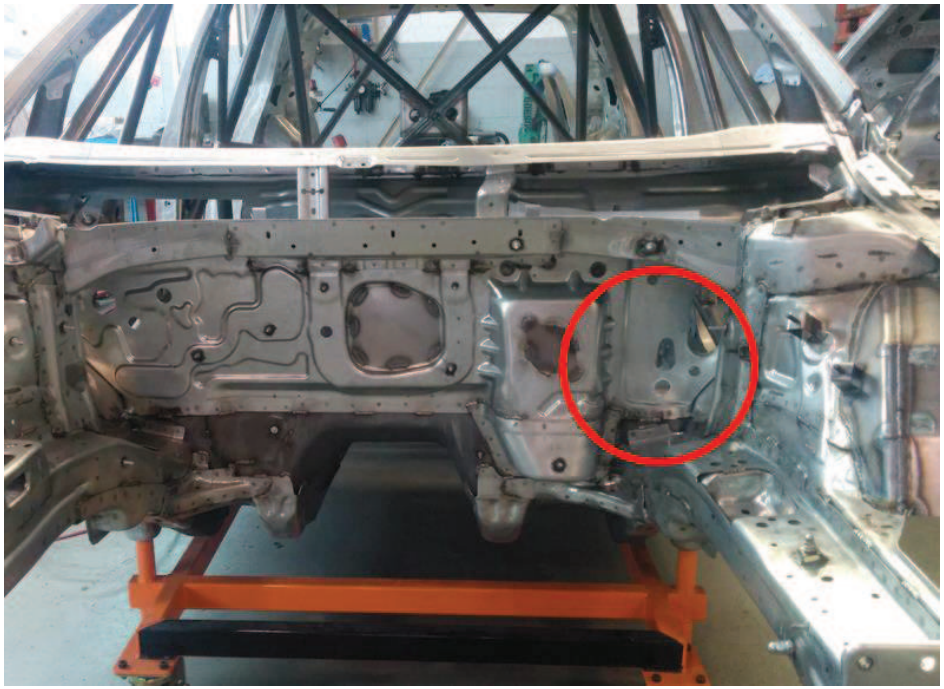
03.01 Hole for clutch pipe

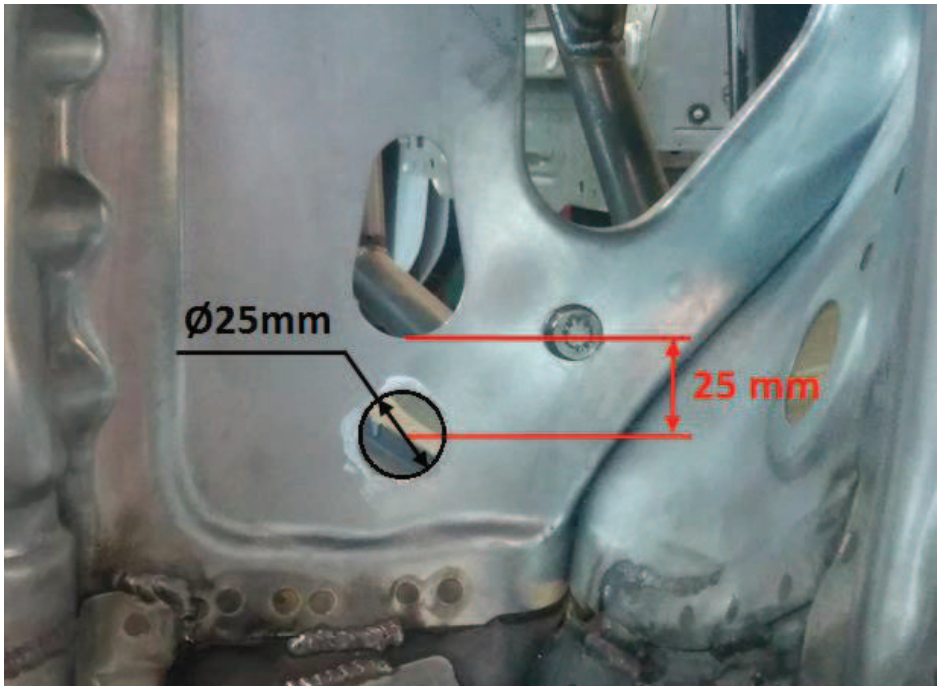
03.02 Holes for hand brake support

03.03 Front sub-frame modification

03.01 Hole for clutch pipe

Do a Ø25 mm hole between the engine bay and the cockpit in the pedal box area following the drawings bellow.





03 KIT 3 – SEQUENTIAL GEARBOX
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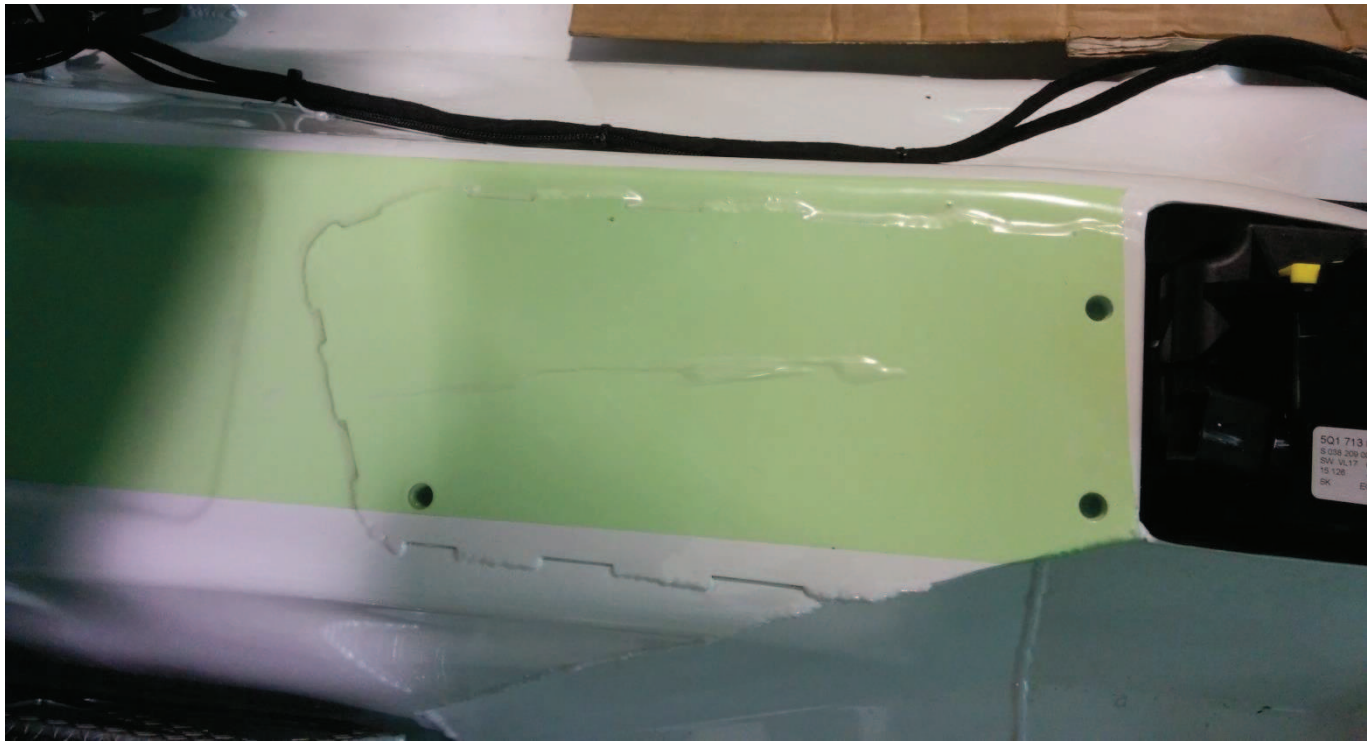
03.02 Holes for hand brake support

Disassembly the control console and use the three existing holes as reference to do the three extra holes needed.



03 KIT 3 – SEQUENTIAL GEARBOX
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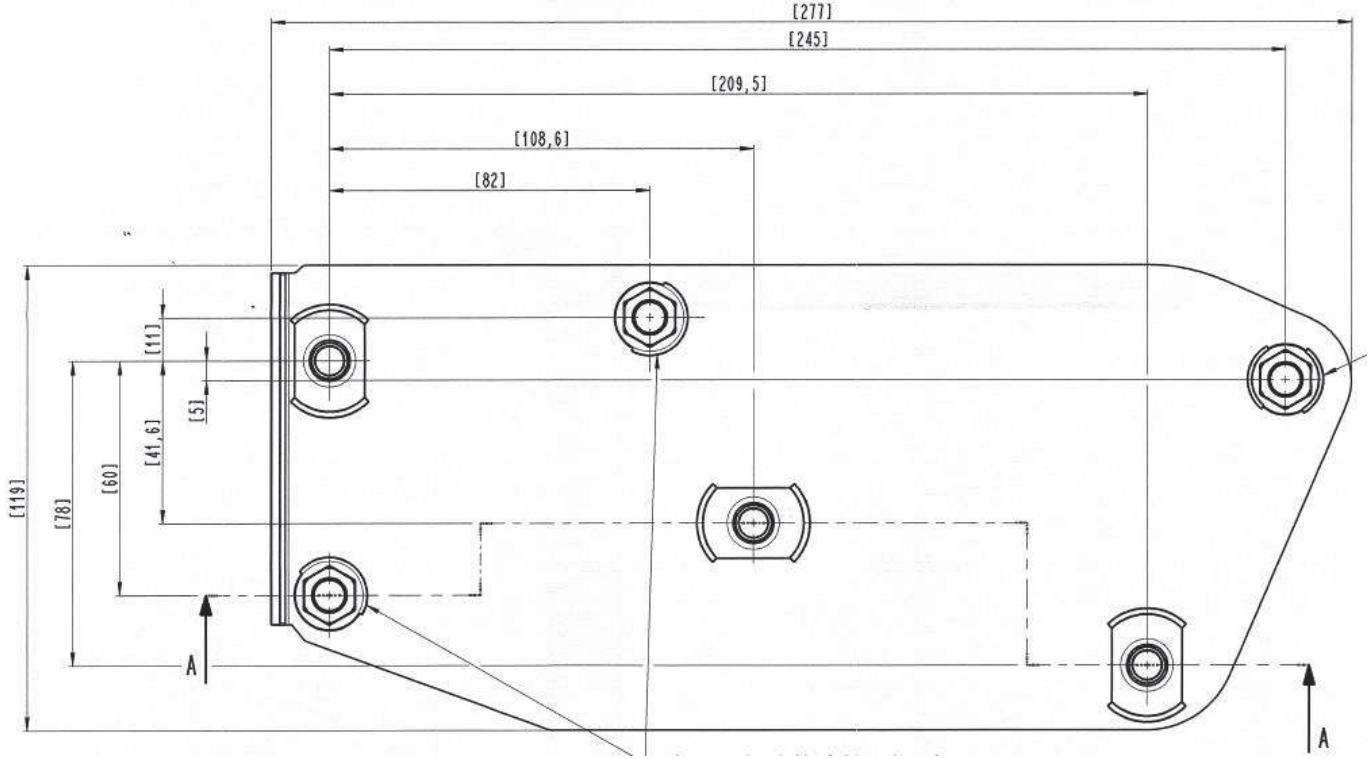
03.02 Holes for hand brake support

Use the following drawing to mark the three hole. If you already have the hand brake support is also possible to mark the holes in the desired place using the support. Once marked, drill and paint to prevent from corrosion.



03 KIT 3 – SEQUENTIAL GEARBOX
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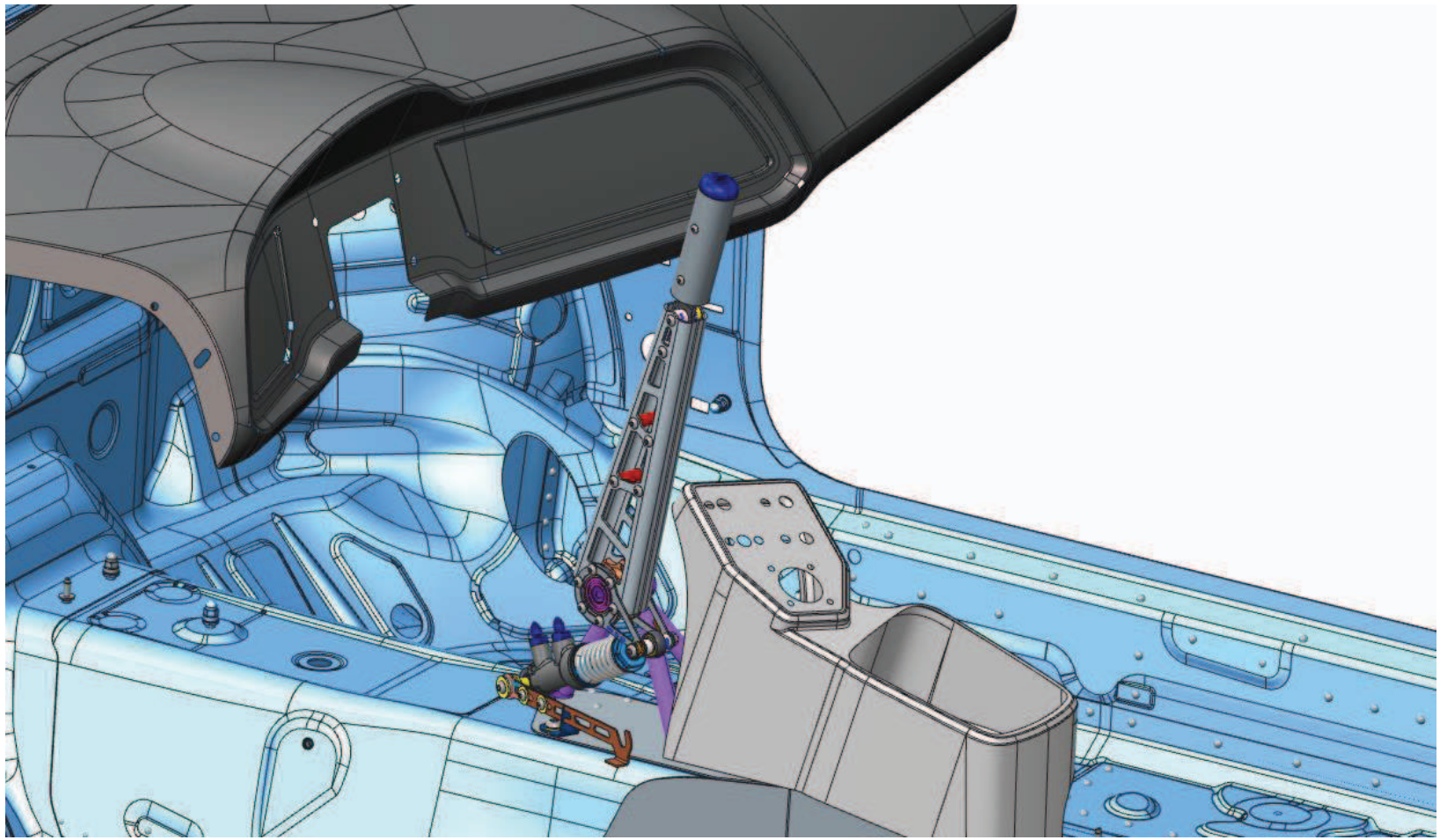
03.02 Holes for hand brake support

Result

03 KIT 3 – SEQUENTIAL GEARBOX
SEAT LCR 2016

03.02 Holes for hand brake support



03.03 Front sub-frame modification

To make easier the assembly and disassembly of the driveshafts and to prevent any interference between the driveshaft bolts and the subframe, you have to modify the subframe using the jig U5F6199002 and welding the covers 5F6199534 according to the next picture. Mark the cut with the tool and then remove it to cut, weld and paint. Cut 2 mm below the mark to do a bigger hole.
Another option is to buy a new sub-frame already modified (5F6199313).