



Factory Five Racing, Inc.

Part Number:	Revision: <u>D</u>	Effective Date: <u>5/24/22</u>	By: <u>J. Ingerslev</u>
Document Type (indicate):	<input type="radio"/> Bill of Material	<input type="radio"/> Drawing (may be attached)	<input type="radio"/> Specification
	<input checked="" type="radio"/> Assembly Instructions	<input type="radio"/> Operating Procedure	<input type="radio"/> Other

Door Latches

Installation instructions



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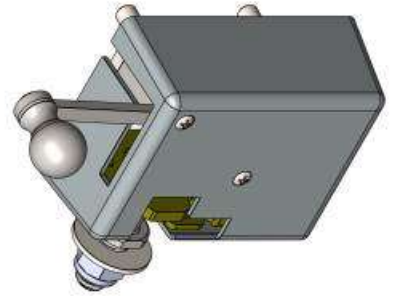
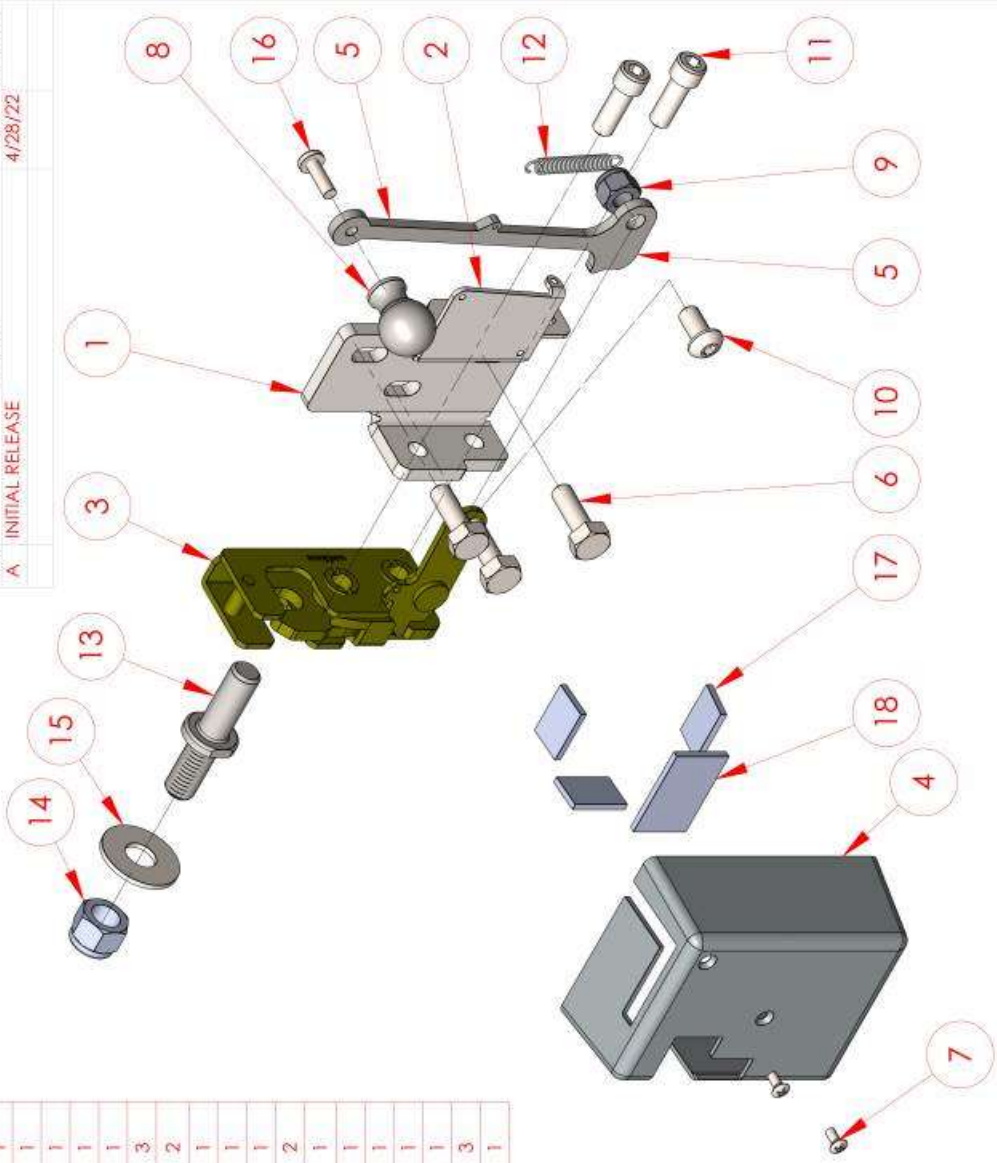
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- ✂ Drill, $\frac{3}{16}$ " , $\frac{25}{64}$ " drill bits, $\frac{3}{8}$ " , $\frac{7}{16}$ " , $\frac{1}{2}$ " , $\frac{9}{16}$ " , $\frac{5}{8}$ " wrenches, pliers, ruler, marker, small Philips head screwdriver, masking tape, $\frac{5}{32}$ " , $\frac{3}{16}$ " Hex keys, Blue Loctite, razor knife.
- 🔧 Door Latch assembly, Paint
- 👤 Do not Loctite the fasteners until told to do so, they will get assembled and disassembled a couple times.

ITEM NO.	PART NUMBER	DESCRIPTION	LEFT/QTY.
1	16166	16165 - LEFT LATCH BASE	1
2	16305	16306 - LEFT COVER MOUNT	1
3	16309	LEFT LATCH	1
4		latch cover	1
5	16172	HANDLE	1
6	80539	1/4"-20 x 0.75" BOLT	3
7	16475	#4-40 x 0.25" OVAL HEAD	2
8	16173	DOOR LATCH KNOB	1
9	10802	1/4" NYLON INSERT LOCKNUT	1
10	33688	1/4"-20 x 1/2" FLNG BUTTON HD	1
11	12335	1/4"-20 x 0.75" SOCKET HEAD	2
12	16474	EXTENSION SPRING	1
13	17088	LATCH STRIKER	1
14	13964	3/8-16 NYLON INSERT LOCKNUT	1
15	13977	3/8" WASHER	1
16	17087	M4-0.7 x 12MM PAN HEAD	1
17	17173	0.50" SOUND DAMPING	3
18	17173	1.25" SOUND DAMPING	1

REV.	DESCRIPTION	DATE	APPROVED
A	INITIAL RELEASE	4/28/22	



UNLESS OTHERWISE SPECIFIED:
 DIMENSIONS ARE IN INCHES
 TOLERANCES:
 TWO PLACE DECIMAL ±0.01
 THREE PLACE DECIMAL ±0.005
 FOUR PLACE DECIMAL ±0.001

DRAWN: JI DATE: 7/29/16
 NAME: JI DATE: 7/29/16

COMMENTS:

MATERIAL: _____
 FINISH: _____

USED ON: _____
 APPLICATION: _____

PRINTED: 5/5/2022

SCALE: 1:2 WEIGHT: _____

SHEET 1 OF 1

Factory Five Racing, Inc.

TITLE: DOOR LATCH COMPONENTS
 REV: A
 SIZE: A DWG. NO.: 16164

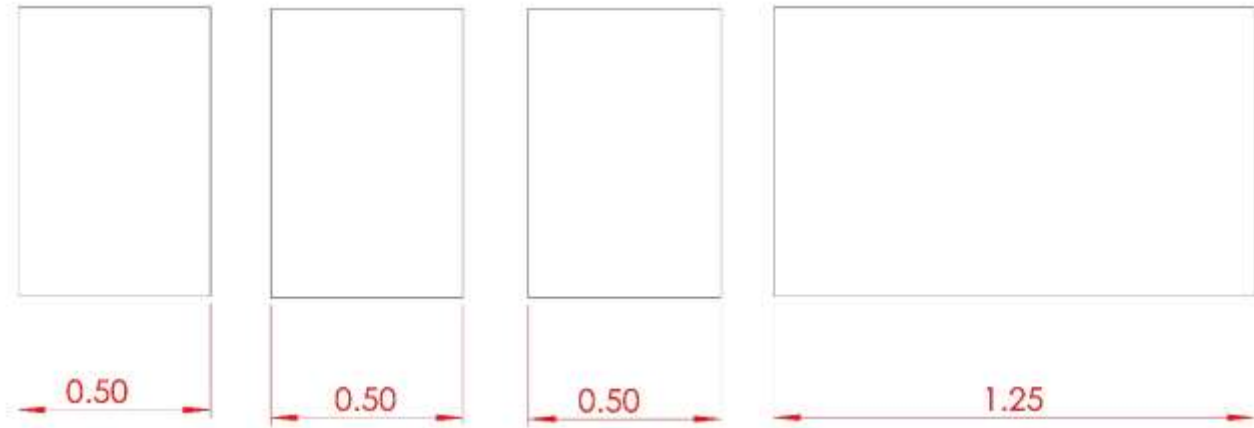
PROPRIETARY AND CONFIDENTIAL
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Parts Prep

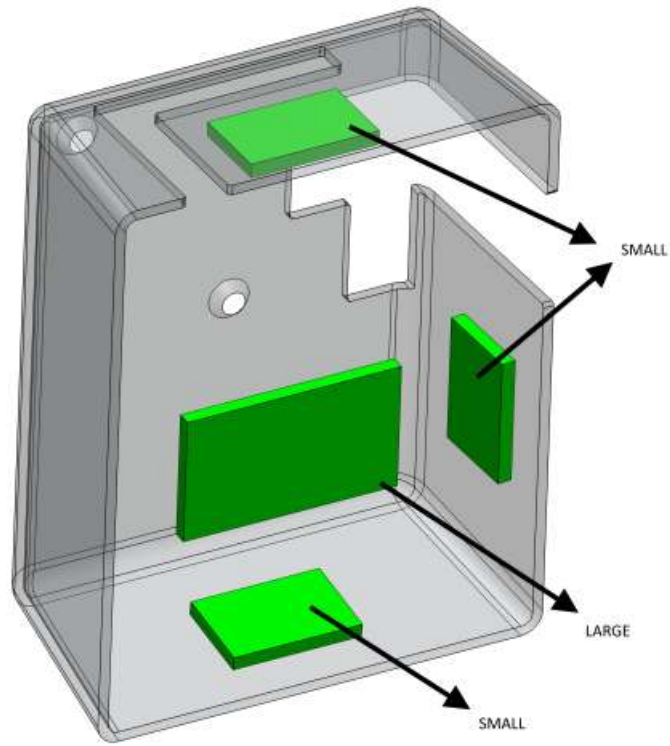
Paint the cover mounts and latch bases.

The handle is stainless and can be polished or painted.

SOUND DAMPING



Use a ruler and marker to mark two sets of the damping then cut the pieces using a razor knife.



Sound damping locations.



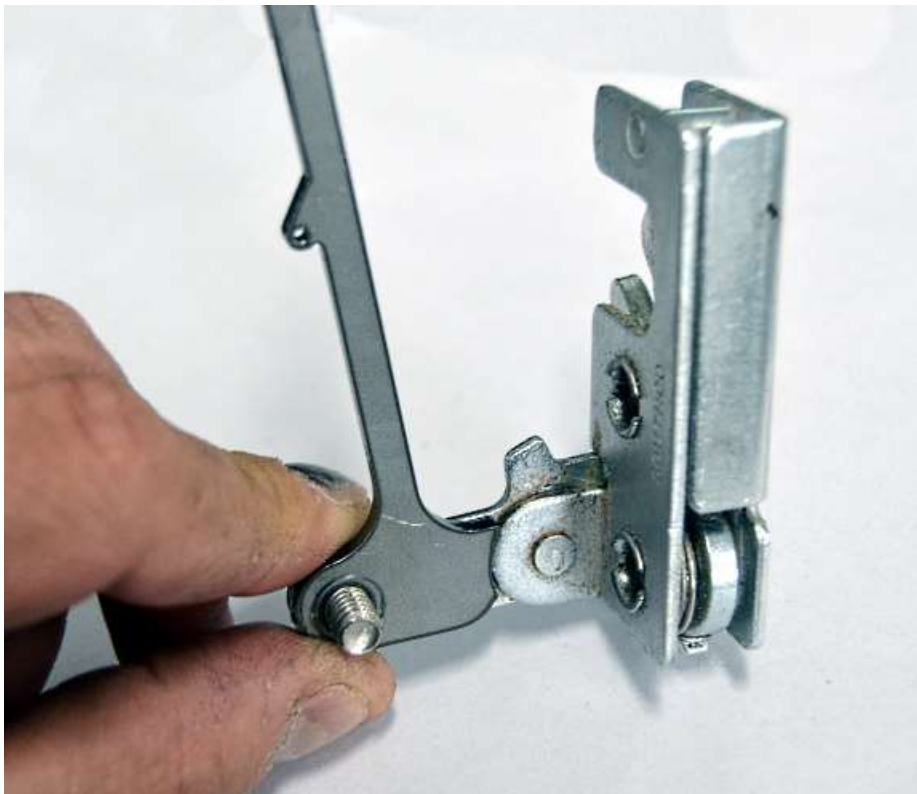


Peel and stick the sound damper in the locations shown. Do not place them in other locations, they will hit the latch parts.

Repeat for the opposite side.

Assembly

HANDLE



Run the 1/4" x 0.50" Button washer head bolt through the latch lever then the handle followed by a locknut.



Use a $\frac{5}{32}$ " Hex key and $\frac{7}{16}$ " wrench to tighten the handle to the latch.

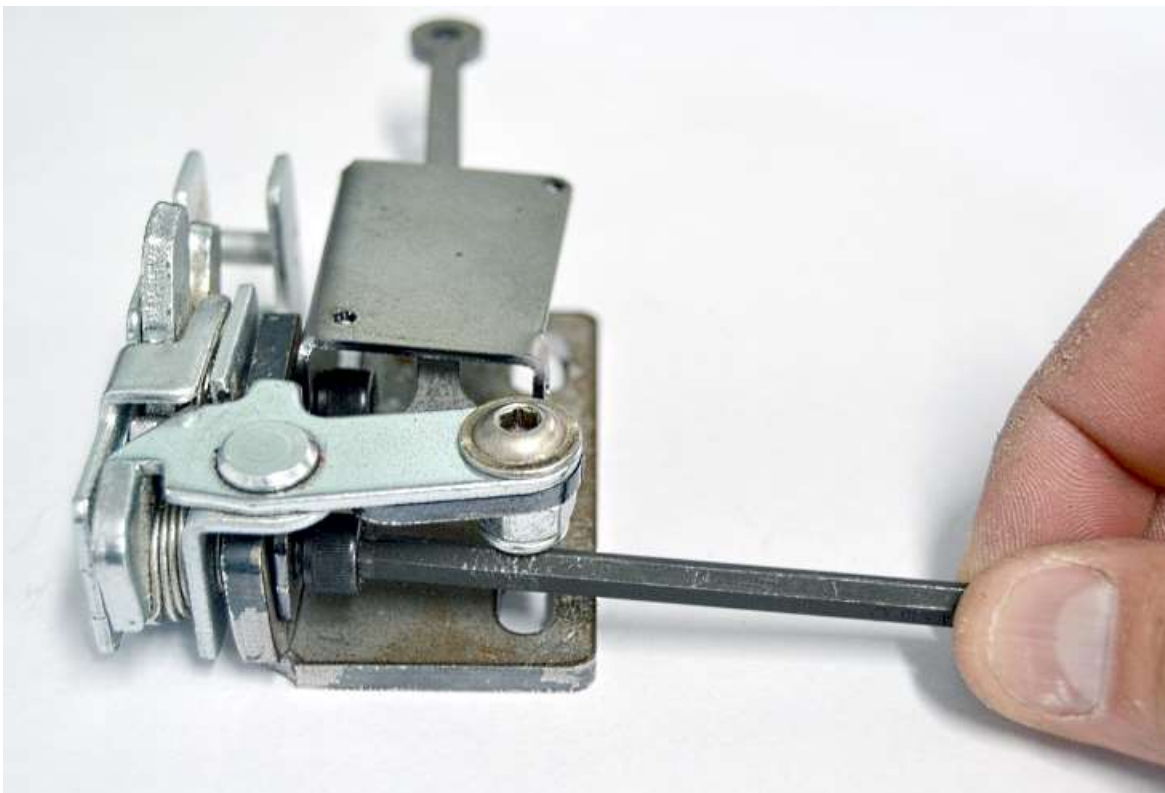
LATCH



Run the $\frac{1}{4}$ "x 0.75" socket head bolts through the cover mount and latch base.



Pass the handle under the cover mount and line up the threaded holes in the latch.

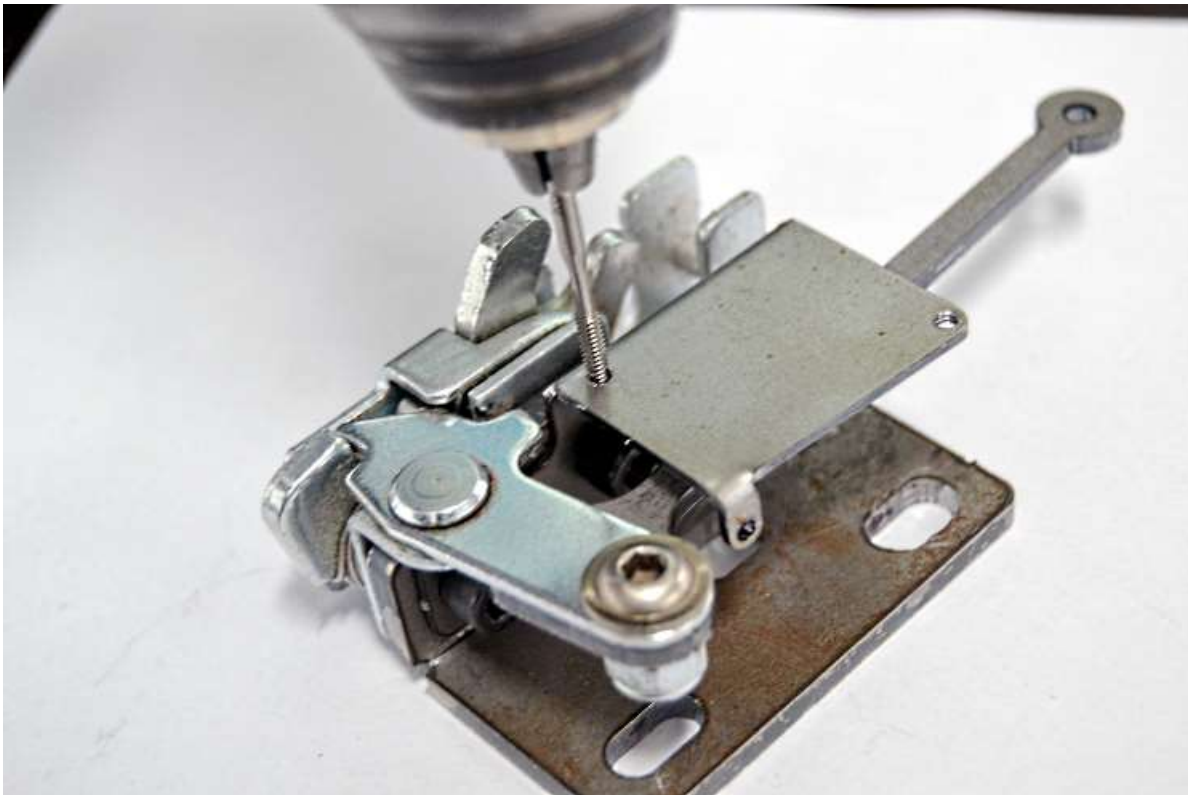


Tighten the latch base to the latch using a $\frac{3}{16}$ " Hex key.

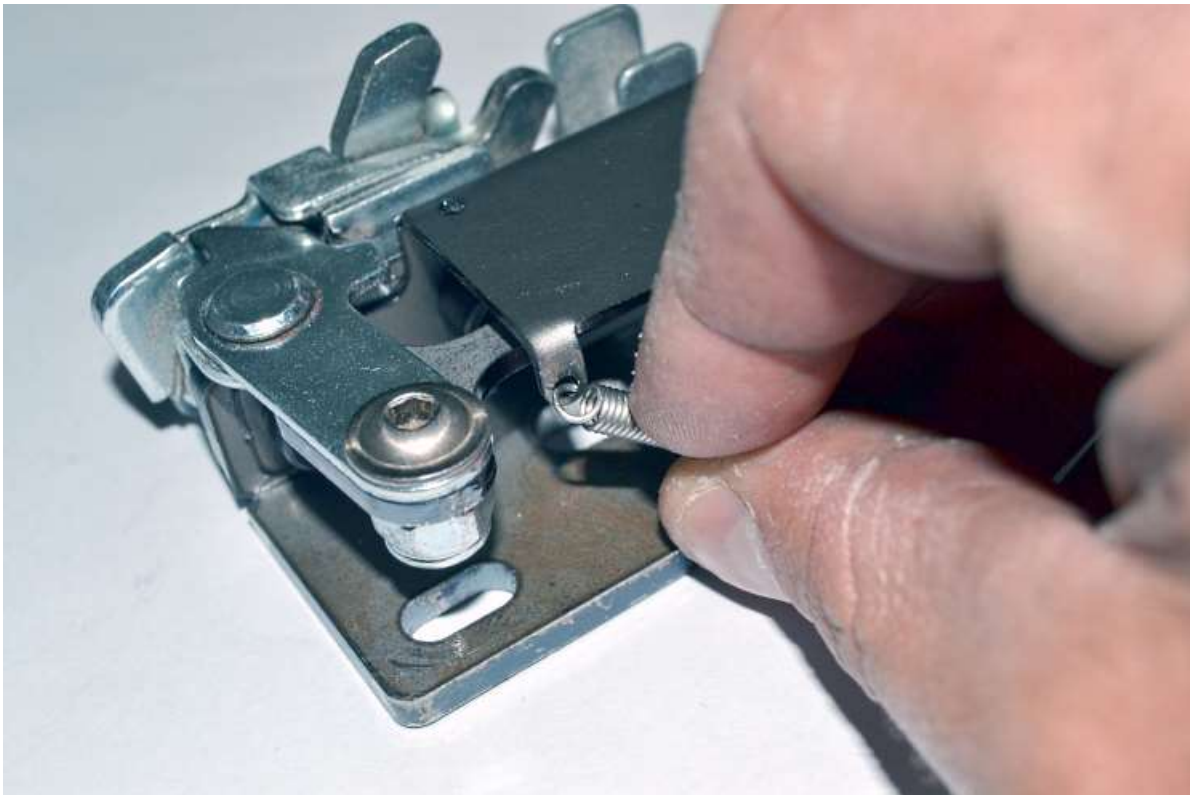


Put the #4 thread tap into a drill.

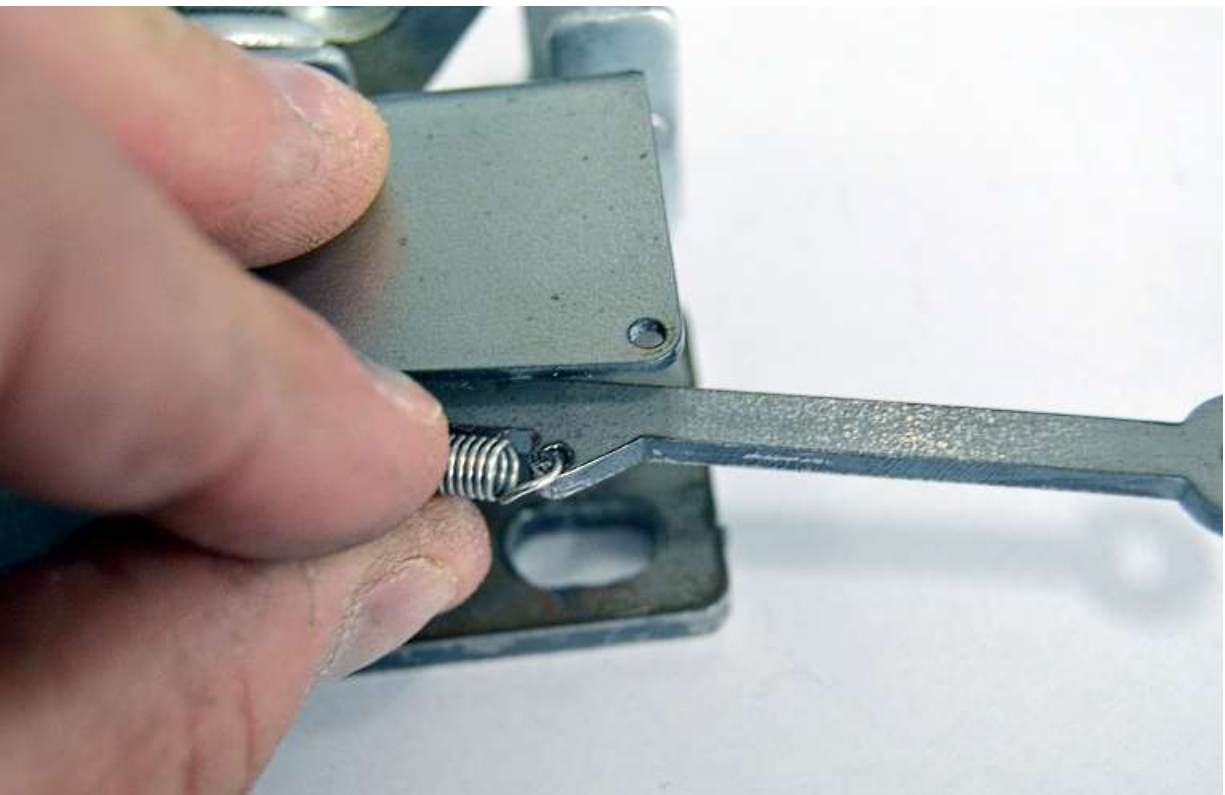
👉 Put the drill into low speed.



With a bit of oil or other lubricant on the tap, **slowly** run the tap through the small holes in the cover mount plate.



Attach one end of a spring to the latch cover mount.



Attach the other end of the spring to the small hole in the handle.



Installed spring.

STRIKER



Put a $\frac{3}{8}$ " washer on the striker then pass the striker through the mount on the frame next to the seat followed by a $\frac{3}{8}$ " nylon locknut.



Snug up the locknut so that the striker can just move in the slot but stay in place using $\frac{9}{16}$ " and $\frac{5}{8}$ " wrenches.

LATCH



Attach the latch assembly to the striker.



Cover the latch location on the door with masking tape.



Put the rivnut tool between the latch and the latch base so that the flat end of the striker will touch the tool. This will allow the latch to get mounted 90 degrees to the striker and to get spaced correctly.

👉 Before continuing, make sure the door is gapped correctly in the opening. This will prevent having to relocate the latch later.



Close the door so that it contacts the latch base then, holding the latch against the rivnut tool so the latch is 90 degrees to the striker, mark around the latch base on at least 2 sides.



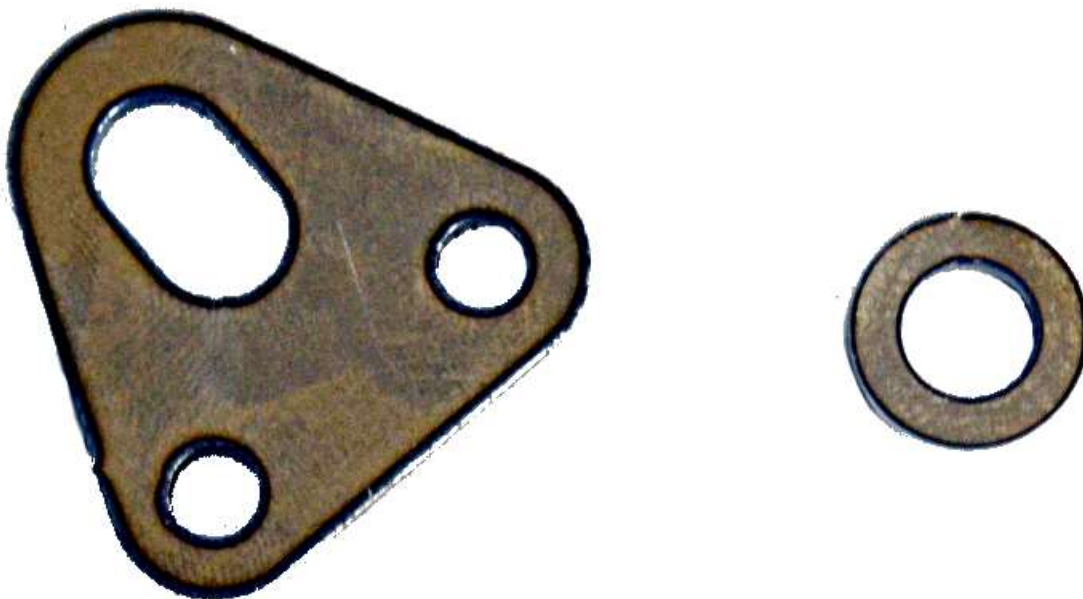
With the latch touching the door and attached to the striker, check the alignment and fitment of the door to the body.

Loosen and move the striker in or out as needed so that the door fits well.

ADJUSTMENT ADAPTER INSTALL (OPTIONAL IF NEEDED)

✂ Pliers or clamp, saw, marker, 1/4" drill bit, drill, 7/16", 9/16", 5/8" wrenches

👉 This is only necessary if extra adjustment towards the inside of the car is needed.



If more adjustment towards the inside is needed, use the included adapter.



Hold the adapter behind the frame tab with the slot at the same height as the frame slot and the outer edge touching the frame weld then mark around the frame tab on the adapter.



Move the adapter to the front of the frame tab and align the marks made with edge of the frame tab and clamp in place.



Using the holes as a template, drill one mounting hole, insert a bolt then drill the other mounting hole.

Remove and paint the adapter and spacer if desired.



Cut the frame mount through the slot so that it will not interfere with striker adjustment.



Frame tab cut.



Attach the adapter to the back side of the frame tab using the $\frac{1}{4}$ "x $\frac{3}{4}$ " bolts and locknuts.



Put the adapter spacer on the striker followed by $\frac{3}{8}$ " washer.



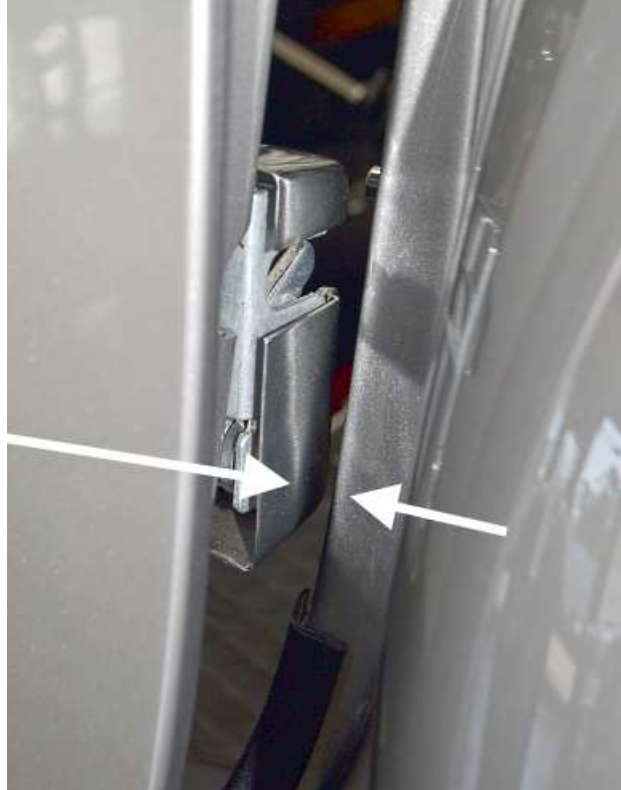
Attach the striker to the adapter plate using another $\frac{3}{8}$ " washer and locknut on the backside.

Check the door alignment and adjust the striker as needed.

LATCH DOOR INSTALL

Remove the rivnut tool and latch assembly.

Screw the chrome cover to the latch assembly.



Hold the latch assembly up to the location on the door and check clearance between the latch cover and door opening while closing the door.

If necessary move the latch slightly further towards the front of door shimming the striker out with washers the same amount or by moving the striker up in the slot and raising the latch.

DO NOT CONTINUE UNTIL THERE IS CLEARANCE. Once the rivnuts are in it is harder to fix this.

Retape and remark the door if necessary.

Remove the chrome cover and unscrew the socket head bolts attaching the latch to the base.



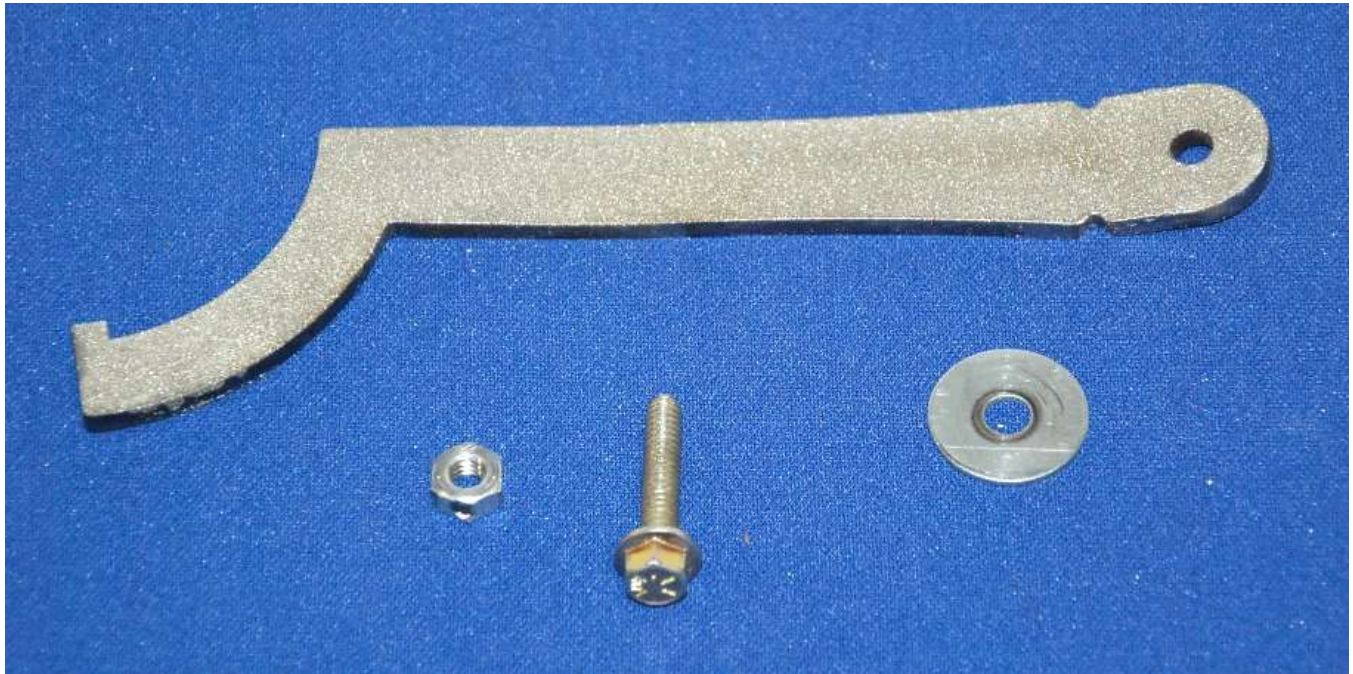
Align latch mount with the marks on the masking tape on the door and mark the center locations of the mounting slots.

- 👉 The door latches are designed to bolt-on attaching to the door using rivnuts. Please read the Rivnut install instructions below before attempting.



- 👉 If a more OEM rivnut tool is desired, Factory Five offers a Rivet/Rivnut combination tool.

RIVNUT TOOL INSTRUCTIONS



The rivnut installation tool also functions as a shock coil-over wrench.



Thread the $\frac{1}{4}$ " nut about $\frac{3}{4}$ of the way onto the $\frac{1}{4}$ "x 1.25" flanged bolt.



Next slide the ¼" fender washer onto the bolt down to the nut.



Insert the bolt with the nut and washer through the small hole in the rivnut tool from the side where the handle angles up.



Thread the rivnut onto the bolt until it is snug against the tool. The bolt threads should just stick out of the bottom end of the rivnut. Adjust the bolt depth if needed.



Using a $\frac{3}{8}$ " closed end wrench hold the bolt from turning by clamping the wrench and the install tool in one hand.



Starting with a $\frac{3}{16}$ " drill bit then opening it up to $\frac{25}{64}$ ", drill a hole where you want to install the rivnut. Installed in tube for demo purpose.



Insert the rivnut in the hole holding onto both the tool handle and the wrench.

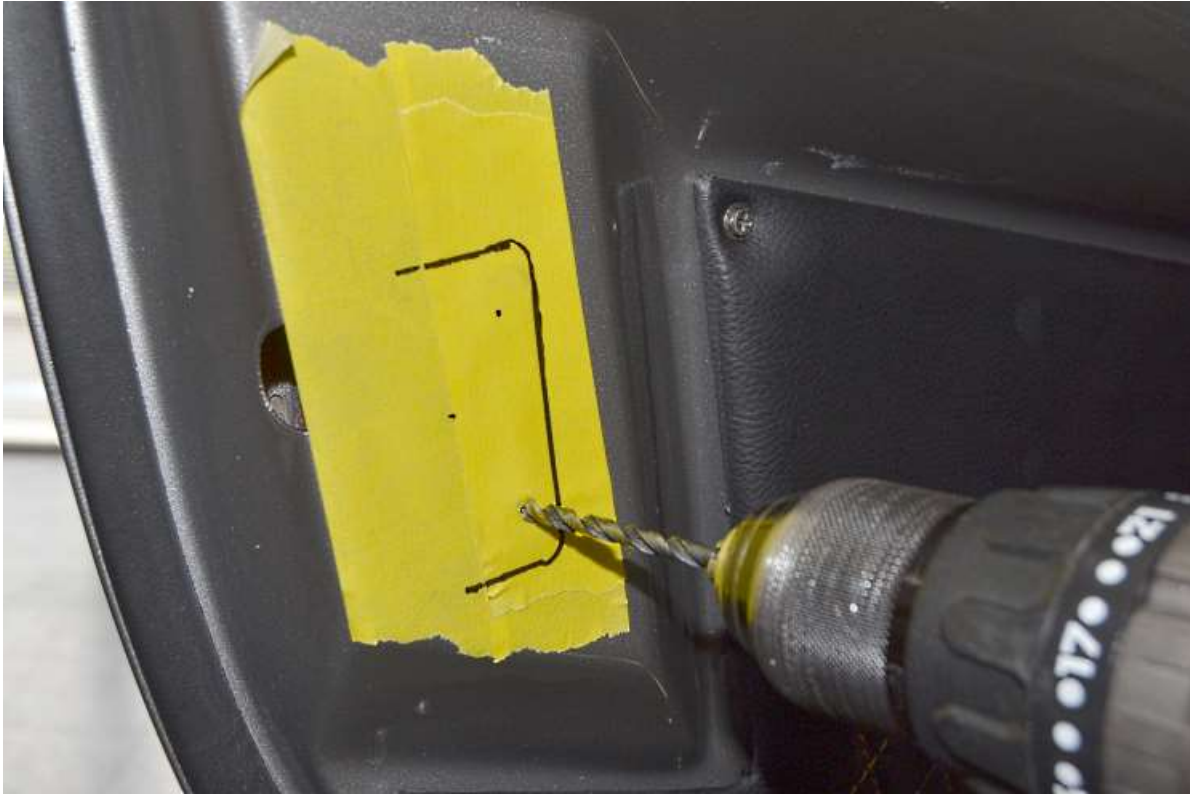


Tighten the clamping nut until the resistance changes as if it were a nut getting tight.



Unscrew the Bolt from the rivnut and you are done!

RIVNUT INSTALL



Starting with a $\frac{3}{16}$ " drill bit then opening it up to $\frac{25}{64}$ ", drill a hole where you want to install the rivnut.



Look at the holes and area drilled. If there is **1/8"** in total thickness or less including the fiberglass and steel use the **shorter** rivnuts. If the thickness is greater, use the longer rivnuts. Install the three rivnuts on the door.

Final assembly

👉 Use Loctite when installing all of the fasteners this time.



Attach the latch base to the door leaving the bolts just loose enough to allow for final adjustments using a $\frac{7}{16}$ " wrench.



Attach the knob to the handle using a Philips head screwdriver and M4 x 12mm Pan head screw.



Reattach the cover mount and latch to the latch base using the socket head bolts and $\frac{3}{16}$ " hex key.



Reattach the spring.



Close the door so the latch engages correctly then tighten the latch base using a $\frac{7}{16}$ " wrench.



Tighten the striker on the frame using $\frac{9}{16}$ " and $\frac{5}{8}$ " wrenches taking care not to move it.



Slide the chrome cover over the latch.



Attach the cover to the latch using a Philips heads screwdriver and the #4 x 0.188" oval head screws.

Repeat assembly for the opposite side of the car.