

STEP-BY-STEP INSTRUCTIONS ON “HOW TO MAKE A SEAT PAN”

ITEMS NEEDED

- Latex gloves
- 2” masking tape
- Permanent marker
- Shop rag
- 3 or 4 wooden sticks (paint stirrers)
- 2” disposable brush
- Modeling clay
- 2 qt mixing cup
- Automotive paste wax
- Newspaper or plastic trash bags
- Cardboard
- 4oz marine fiberglass matting (2 pks of 2oz)
- 1 layer cloth (6-8oz)
- 1 qt marine resin
- Band saw or skill saw
- Sand paper
- Hardware to attach your seat to your bike (back chrome bracket if not using Velcro system and front tongue)

STEP 1 - PREPARING THE BIKE FOR TAPING



Using a small cloth, cover battery and base of bike where seat pan is to be made to allow for ample tolerances. Be sure to tuck in rag around frame (inside struts and frame rails).

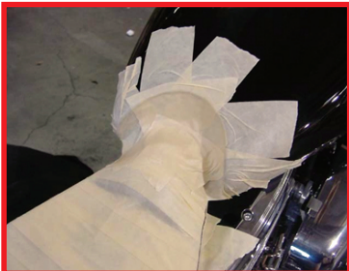
STEPS 2, 3 & 4 - TAPING OFF THE BIKE



Using 2” wide automotive masking tape, completely tape off bike by overlapping tape 1” from front to rear as tightly as possible (avoid air bubbles and ripples under tape). Two layers of tape is recommended to avoid damage to paint finish.



Make necessary allowances for mounting brackets for front and rear (use clay or similar material to make transitions smooth).



Tape thoroughly into nose area if seat is to fit into stretched tanks.

STEP 5 - LAYING OUT THE PAN



Using a permanent marker, mark on the tape where the pan is to be trimmed. This will release onto the fiberglass for a trim line.

STEP 6 - PREPARING FOR FIBERGLASS

Next, using an automotive paste wax, wax the tape thoroughly where the fiberglass is to be laid so the fiberglass will release off of the tape easily when you are finished.

Using plastic trash bag or similar product, cover and tape down the rest of your bike to avoid any spills from the resin landing on your bike.

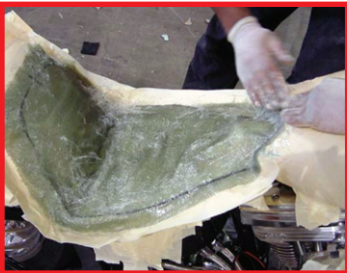
With gloves on, you will need to cut the marine fiberglass mat. Lay the dry fiberglass cloth down across the taped off portion of your seat and trace around your pen markings, but when cutting, be sure to give yourself an extra ½ inch more than you originally marked for your seat. After cutting cloth pattern, lay the cloth down on the fiberglass matting and cut out matting (two layers).

STEPS 7 & 8 LAYING OUT THE FIBERGLASS **(DO NOT TRY TO RUSH THIS PART OF THE OPERATION)**



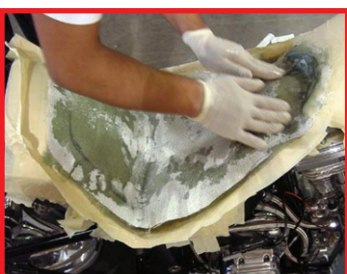
Combine the resin and catalyst as per the manufacturers' instructions and mix thoroughly.

For best results first apply the resin to the mats individually on a large piece of cardboard before laying them on the bike. Wet the mat until it becomes nearly transparent, carry the cardboard over to your bike and carefully lay the wet fiberglass matting across your seat bed.



Work mat with paint brush until most of the air bubbles are out.

After you have placed down the two layers of matting, lay the dry cloth on top of the matting, working very quickly (as you do not have much time during this phase) be sure to work out all of the air bubbles using the brush and your hands, working from the center out (once resin has changed from a greenish color to a brownish color, you are nearly out of time [about 3-5 minutes] left before it is no longer workable).



STEPS 9 & 10 - TRIMMING THE PAN



After allowing plenty of time for the pan to dry (usually overnight) carefully pry it off the frame, remove all clay, tape and cloth from your bike.

Trim the pan at the trim line (previously marked off the on the tape) with a band saw or skill saw. Allow 1/8" for the leather to wrap at the nose of the seat.



Please be sure to sand the sharp edges (as they may cut through the leather) and then try setting the pan back on the bike. It is very important that your pan fits properly.

Next, attach any hardware to the pan, as it is a "must" that the hardware system is in place before we cover your seat. Be sure that the pan fits properly with the hardware attached, as it cannot be changed after the seat is covered.

HELPFUL TIPS

It is always best to include photos and/or drawings of how you are attaching the pan to the bike if you have made your own custom attachment system.

Measure the height you want the foam to be in the tank area and the rear area if you are doing a 2-up seat. Include any other instructions that will be useful in making the seat.

When sending in your seat pan, include detailed drawings of how you want the foam to be shaped and include photos of the bike if possible.

CONGRATULATIONS ON SUCCESSFULLY MAKING YOUR OWN SEAT PAN

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