# Section R
# BODY — ALL MODELS

## INDEX



## LIST OF ILLUSTRATIONS



### General body repairs

With the exception of the dash panel, which is steel, the body panels are constructed throughout from Birmabright, with steel cappings and corner brackets; all steel parts are galvanised.

### Riveting

Three types of rivet are used on the body:—

1. Aluminium pop or "blind" rivets are used only on box sections or where it is difficult or impossible to use any other type because of limited working space; these rivets are "snapped-up" from one side only. The setting is controlled by the breaking of a headed steel mandrel which passes through the tubular rivet; the mandrel break occurs only when the thicknesses being riveted have been pulled together tightly and the rivet head on the blind side fully formed. The mandrels are either of the break stem or break head type, the latter being used in positions where the mandrel head is free to fall away after the rivet head is set. Where it is required to retain the broken-off portion of the mandrel within the headed-up part of the rivet, as for example in box sections (where a loose mandrel head would rattle) or for sealing the rivet with filler or stopper, the break stem type is used. Either a mechanical or pneumatic hand tool can be used for fixing pop rivets.
2. Bifurcated or "split" rivets are used for securing rubber and canvas together or to metal. The rivet is passed through the materials to be joined, a boss cap is placed over the tongues of the rivet, and these tongues then spread with a suitable drift.
3. Various sizes and lengths of round head rivets are used, and for these a suitably indented dolly is needed for the rivet head, while the tail of the rivet is peened over with a hammer, operated manually, electrically, or by compressed air.

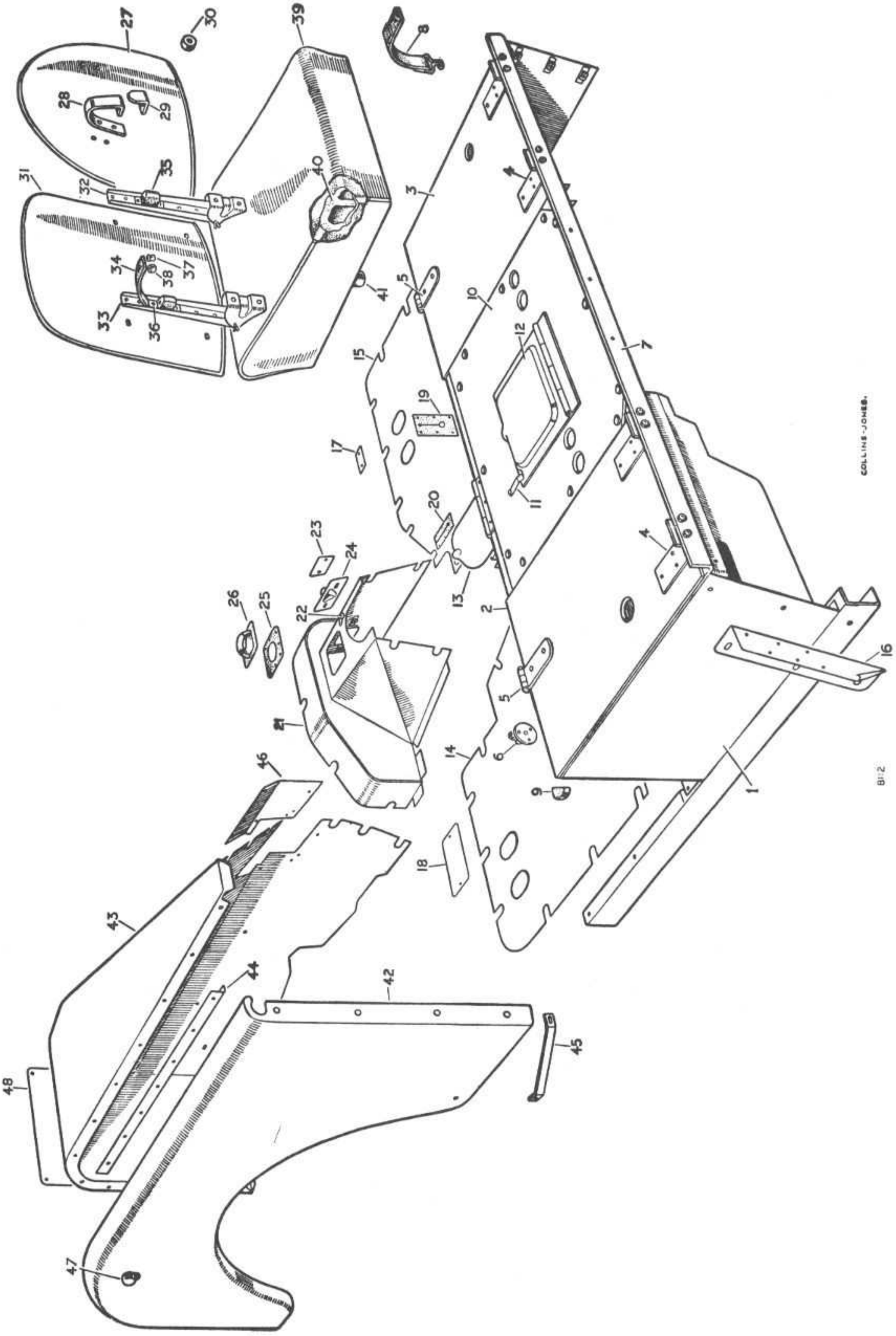


**Fig. R-1—Layout of seat base, toe plates and front wings, 1948-53**

## Key to Fig. R-1

1 Seat base assembly
2 Lid for tool locker
3 Lid for petrol tank access
4 Hinges for lids
5 Hasps for lids
6 Turnbuckle for lid hasp
7 Angle plate, seat base to rear body
8 Retaining strap for locker lid
9 Rubber corner piece for lid (extra equipment)
10 Centre cover panel
11 Spring clip for power take-off access cover
12 Access cover for power take-off
13 Inspection cover for gearbox
14 Toe plate, left hand
15 Toe plate, right hand
16 Corner fixing angle
17 Cover plate for pedal adjuster (early vehicles)
18 Cover plate for pedal holes
19 Rubber cover for handbrake slot
20 Rubber cover for transfer lever slot
21 Gearbox cover
22 Spring clip for gearbox cover
23–24 Cover plate for gearbox cover (alternatives)
25–26 Rubber seal for gear lever (alternatives)
27 Seat back rest
28 Bracket for back rest
29 Reinforcing bracket for bracket
30 Rubber buffer for back rest
31 Seat back rest
32–33 Hinges for back rest
34 Retaining strap for back rest
35 Rubber buffer
36 Securing plate for buffer
37–38 Fixings for strap
39 Seat cushion
40 Rubber interior for cushion
41 Rubber dowel locating seat
42 Front wing side
43 Front wing top and valance
44 Seal for wing joint
45 Stay for wing
46 Cover plate for wing valance
47 Rubber buffer (door stop)
48 Registration plate

* Vehicles numbered prior to 06110305 and 06300031.

† Vehicles numbered 06110305 and 06300031 onwards.

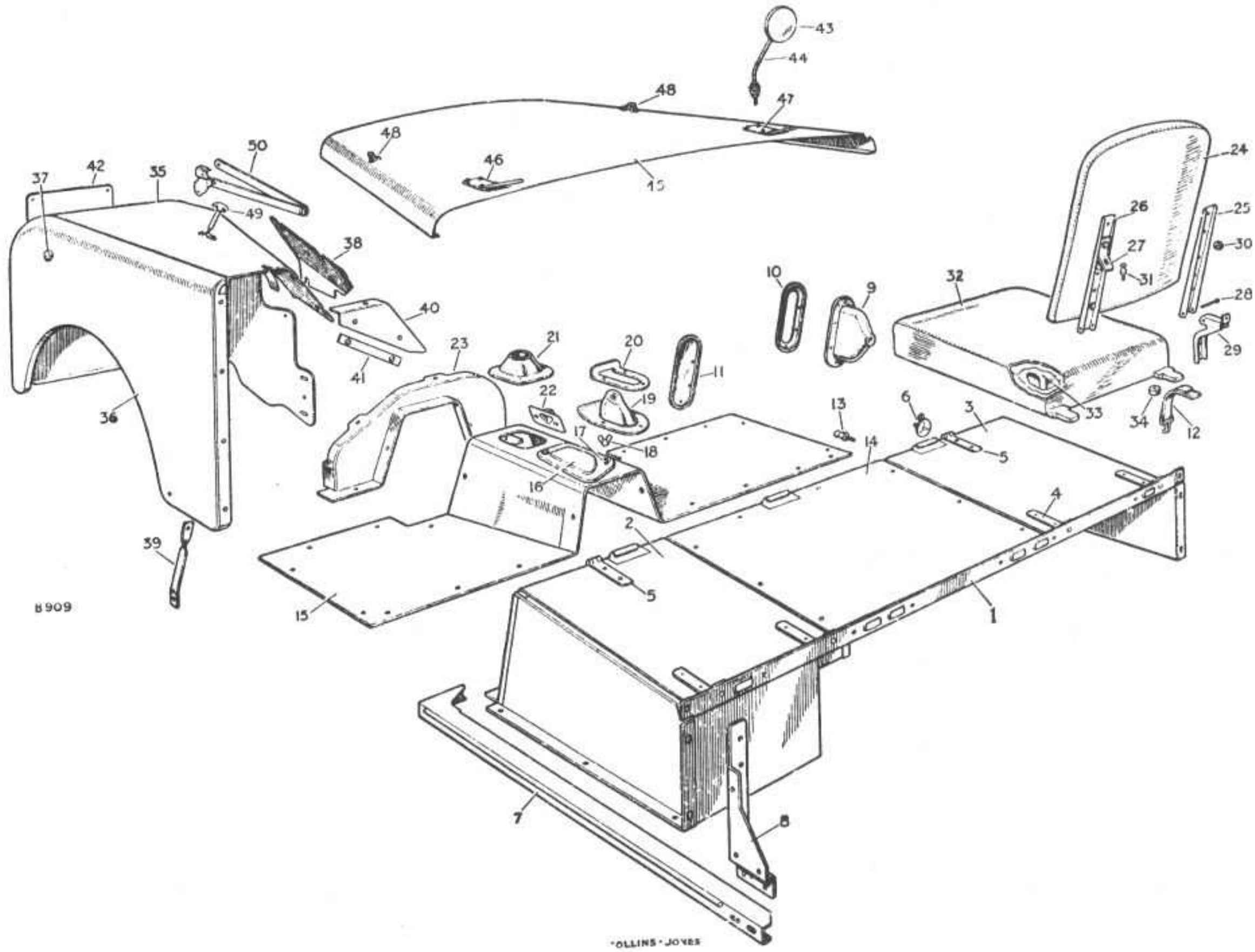


Fig. R-2—Layout of seat base, seats, front floor, wings and bonnet, 1954-58

1 Seat base and floor assembly
2 Lid for tool locker
3 Lid for petrol tank
4 Hinge for lids
5 Hasp for locker lids
6 Turnbuckle for locker lids
7 Sill panel, L.H.
8 Corner bracket, L.H.
9 Rubber cover for hand brake
10 Retainer for rubber cover
11 Cover plate for hand brake slot
12 Access cover for P.T.O.
13 Stud for cushion retaining strap
14 Centre cover panel complete
15 Front floor complete
16 Inspection cover for front floor
17 Stud plate for inspection cover wing nut
18 Wing nut
19 Seal for transfer gear lever
20 Retainer for transfer lever seal
21 Rubber seal for gear lever
22 Cover plate for operating rod
23 Gearbox cover complete
24 Seat back rest, trimmed
25 Hinge complete for seat back rest, R.H.
26 Hinge complete for seat back rest, L.H.
27 Retaining strap for seat back rest
28 Split pin
29 Support bracket for front seat back rest
30 Buffer for seat back rest
31 Stud for retaining strap
32 Seat cushion complete
33 Rubber interior for seat
34 Rubber dowel locating seat
35 Front wing, top, L.H.
Front wing, side, R.H.
36 Front wing, side, L.H.
37 Rubber buffer in wing for door
38 Cover plate for wing valance, L.H.
39 Stay for front wing
40 Bracket, L.H.
41 Bolt plate
42 Number plate, L.H.
43 Mirror only
44 Arm for mirror
45 Bonnet top panel
46 Hinge for bonnet, L.H.
47 Hinge for bonnet, R.H.
48 Staple for bonnet and windscreen fastener
49 Bonnet fastener
50 Prop rod for bonnet

### Paint touching-up process for body panels

Body panels are finished in stoving synthetic enamel and a special technique, detailed below, must be followed when touching up the paint finish after repair work.

### Preparatory work

Thoroughly clean the damaged portion; all traces of wax polish, etc., should be removed with a suitable solvent such as White Spirit.

The surrounding edges of the paint film must be correctly feather edges, using a wooden block and suitable paper.

### Colour

(*a*) Small damaged areas:

Prepare the correct colour finish by thinning to 40 parts finish to 60 parts thinner by volume.

Apply a built-up coat by spray and allow to air dry for four to six hours.

(*b*) Large damaged areas (complete wings or panels): Prepare the correct colour finish by thinning 50/50 with thinner.

Apply one or two full spray coats; allow 15 to 30 minutes between coats and four to six hours (or preferably overnight) after the final application.

Half-hour air drying colour finish and thinners are obtainable from our Spares Department.

### Polishing

After the recommended drying period, lightly polish with any good smooth polishing compound and finally clear, if necessary, with any good quality wax polish.

*Notes*

1. When spraying in small areas and in order to minimise dry spray, it is recommended that the air pressure for spraying be reduced to 30-40 lb/sq.in. (2,1-2,8 kg/cm$^2$).
2. When touching up stoved synthetic finishes, no advantage is to be gained by mist-coating the patch. Instead, the edges of the patch should be faded out during application and any resultant dry spray removed during polishing with any good polishing compound.
3. It is not always easy to blend a patch or touch-up; to do so successfully and lose the edges requires practice by a skilled operator. In cases where the damage is on a conspicuous part of the vehicle, it is recommended that the operator sprays out the entire damaged part, e.g., door panel, wing, etc.
4. In certain instances, the materials listed are available locally. We can furnish additional information in this respect on demand, providing the serial numbers of vehicles concerned are quoted.

## Bonnet

**To remove** **Operation R/2**

1. If fitted, remove the spare wheel from the bonnet.
2. Unhook the bonnet fasteners, disconnect the bonnet prop rod, if fitted, lift the bonnet to its highest position and slide it out to the left, from its hinges.
3. Remove the hinges from the bonnet panel.
4. Remove the bonnet fasteners and the staples.
5. Place the new bonnet panel in position on the vehicle and the hinges in position in the brackets on the dash.
6. Using the hinges as templates, drill the eight holes in the panel, and secure the panel to the hinges.
7. Complete the assembly by reversing the removal procedure.

## Radiator grille panel

**To renew** **Operation R/4**

1. Lift off the grille and nameplate and, if fitted, the chaff guard. Remove the cover from the junction box on the dash panel and disconnect the horn and headlamp harness; unclip the harness from the wing.
2. Remove the bolts, spring washers, nuts, rubber packing pieces and plain washers securing the grille panel to the second chassis cross-member.
3. Remove the bolts, spring washers and nuts securing the radiator block to the grille panel and to the wings; disconnect the wiring from the horn and lift off the grille panel complete with headlamps and wiring.
4. Remove the headlamps.
5. Remove the bonnet rest strip from the grille panel.
6. Remove the headlamp and horn harness from the panel, together with the rubber grommets and cable clips.
7. Assemble and replace the new grille panel by reversing the sequence of Items 1-6.

## Front wings

**To remove** **Operation R/6**

1. Remove the bonnet.
2. Disconnect the side lamp harness at the snap connectors in the engine compartment.
3. On R.H.D. vehicles, remove the valance cover plate near the exhaust pipe.
4. Remove the wing stay from the dash.

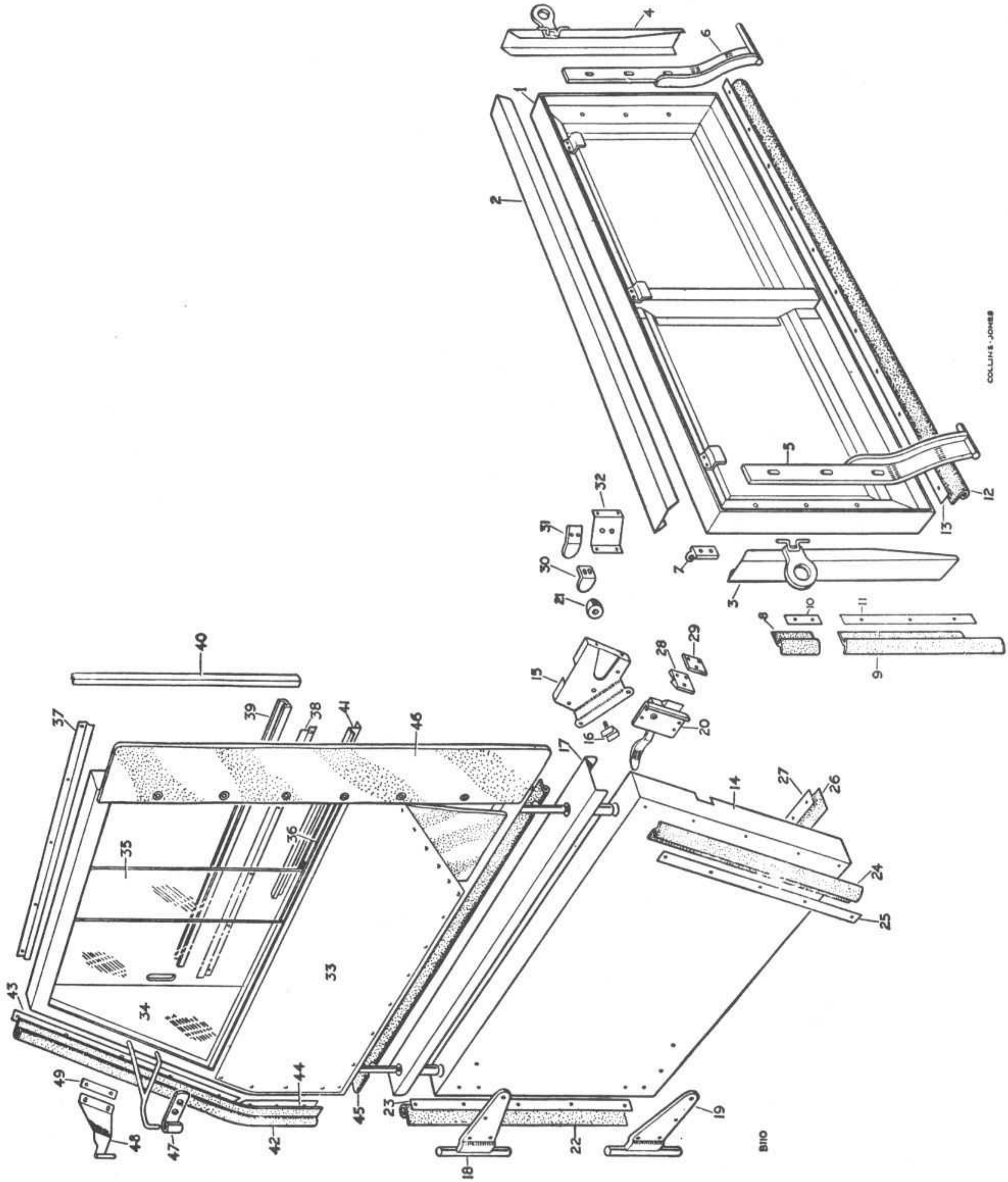


**Fig. R-3—Layout of tailboard, doors and sidescreens, 1948-53**

## Key to Fig. R-3

1 Tailboard
2 Top capping for tailboard
3–4 Side cappings for tailboard
5–6 Hinges for tailboard
7 Hook for tailboard chain
8–9 Weather strips for tailboard, sides
10–11 Retainers for weather strips
12 Weather strip for tailboard, bottom
13 Retainer for weather strip
14 Front door
15 Gusset plate for door
16 Bolt and plate for gusset plate
17 Top capping for door
18–19 Hinges for door
20 Door lock
21 Rubber buffer for door
22 Weather strip for door, front
23 Retainer for weather strip
24 Weather strip for door, rear
25 Retainer for weather strip
26 Weather strip for door, bottom
27 Retainer for weather strip
28 Striking plate for door
29 Tapped plate fixing plate
30–31 Stops for door buffer (alternatives)
32 Reinforcement for stop
33 Side screen
34 Fixed window
35 Sliding window
36 Channel for windows } *
37–38 Retainers for channel }
39 Channel for windows, bottom }
40 Channel for windows, rear } †
41 Filler for fixed window }
42 Rubber draught strip at front edge
43–44 Retainers for draught strip
45 Rubber draught strip at lower edge
46 Rear flap
47 Hinge for sidescreen
48 Hinge plate } Service modification
49 Back plate } for sidescreen hinge

*—Vehicles numbered prior to 8666250.

†—Vehicles numbered 8666250 onwards

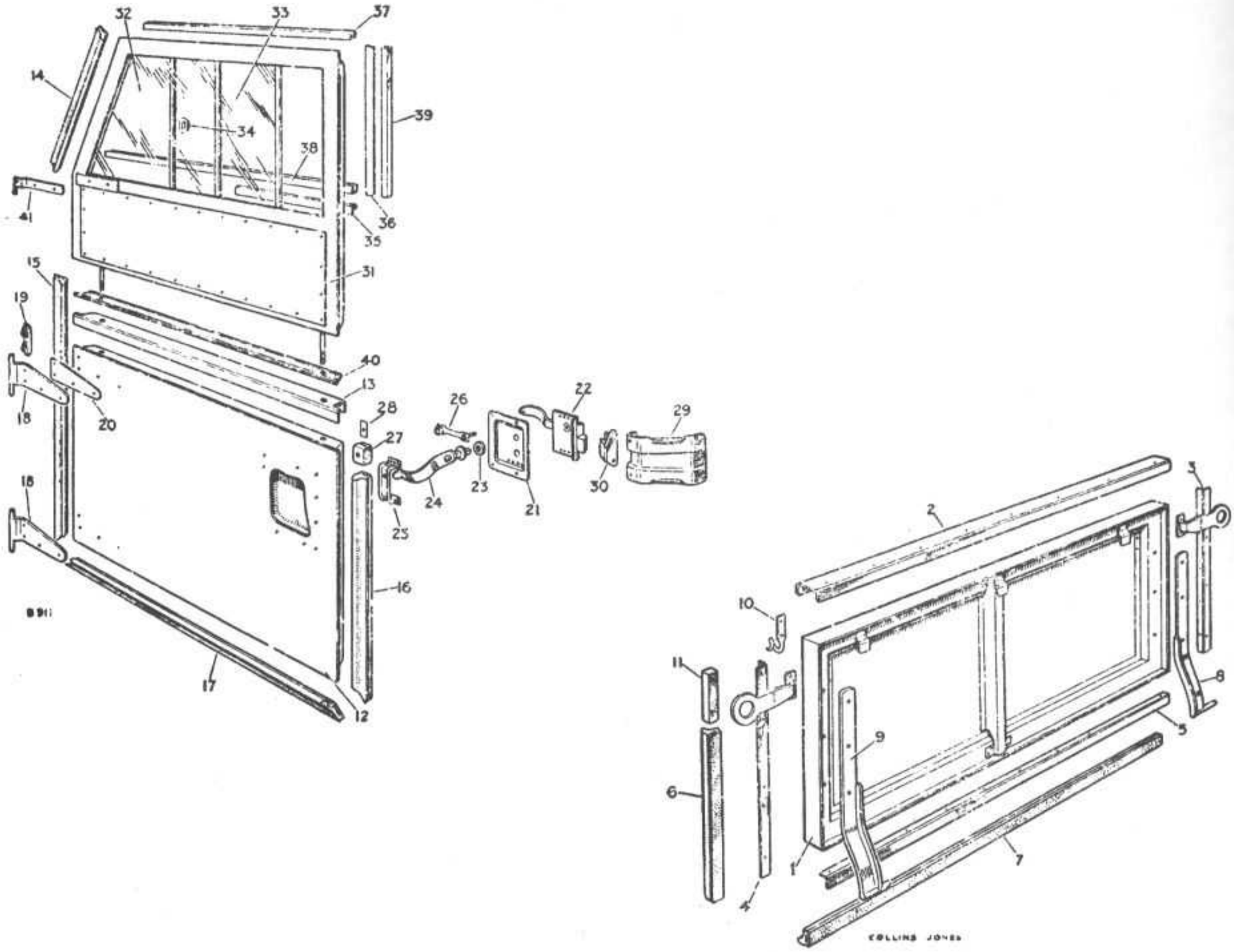


**Fig. R-4—Layout of tailboard, doors and sidescreens, 1954-58**

1 Tailboard assembly
2 Top capping for tailboard
3 Angle for rubber seal, R.H. side
4 Angle for rubber seal, L.H. side
5 Angle for rubber seal, bottom
6 Sealing rubber, side
7 Sealing rubber, bottom
8 Hinge for tailboard, R.H.
9 Hinge for tailboard, L.H.
10 Hook for tailboard chain, L.H.
11 Rubber buffer for tailboard
12 Front door assembly, L.H.
13 Top capping for door
14 Seal for door, front upper, L.H.
15 Seal for door, rear lower, body
16 Seal for door, front lower, dash
17 Seal for door, bottom, sill
18 Hinge complete, L.H.
19 Nut plate for hinge
20 Packing plate for hinge
21 Mounting plate for door lock
22 Door lock, L.H.
23 Washer, handle to cover
24 Handle, L.H.
25 Bracket for door handle
26 Captive plate
27 Rubber buffer for doors
28 Fixing plate
29 Support bracket for door striking plate
30 Striking plate for door lock
31 Sidescreen assembly, L.H.
32 Fixed window, front
33 Sliding window, rear
34 Knob for sliding window
35 Filler, top and bottom } For
36 Filler, rear } windows
37 Channel, top
38 Channel, bottom
39 Channel, rear
40 Sealing strip for sidescreen
41 Hinge plate, L.H.

5. Withdraw the bolt, spring and plain washers and nuts securing the wing to the dash pillar, to the dash and radiator grille frame; lift off the wing complete.

6. If necessary:—
   (*a*) Remove the driving mirror.
   (*b*) Remove the sidelamp, harness and grommet from the wing.
   (*c*) Remove the bonnet fastener.
   (*d*) L.H. wing only. Remove the bonnet prop rod.
   (*e*) Remove the R.H. wing valance plate.
   (*f*) Remove the wing stay.
   (*g*) Remove the registration plate.
   (*h*) Separate the wing top and valance from the wing side.

**To refit** **Operation R/8**

1. Reverse the removal procedure.

## Sidescreen windows

### Sliding window

**To renew** **Operation R/10**

1. Move the sliding window to allow access to the screws securing glass run channel—top and bottom—then remove the screws from inside channel.
2. Withdraw the top run channel and sliding window.
3. Renew the bottom run channel if necessary.
4. Fit new parts as necessary and assemble by reversing the removal procedure.

### Fixed window

**To renew** **Operation R/12**

1. See Operation R/10, items 1-3 inclusive.
2. Ease the fixed glass clear of frame, after removing the screws securing front retainer on 1954-58 models.
3. Apply new Prestik sealing strip to window frame, renewing parts as necessary and assemble by reversing the removal procedure.

*Note:* Two-piece door only—if necessary, the complete assembly can be removed by removing the nuts, plain washers and spring washers securing the assembly to the door.

### Sidescreen hinge, to modify, 1948-53

1. A special hinge plate has been designed as a Service replacement in cases where the fabricated wire hinge on the sidescreen has fractured.
2. The hinge plates and fittings are available from our Parts Department under the following part numbers:—

| Description | | Qty. | Part Number |
|---|---|---|---|
| Hinge plate, right hand | .... | 1 | 301916 |
| Hinge plate, left hand | .... | 1 | 301917 |
| Backing plate for hinge | .... | 2 | 301918 |
| Bolt ($\frac{1}{4}$ in. x $1\frac{3}{4}$ in.) | Fixing | 4 | 250518 |
| Spring washer | hinge plate | 4 | 3074 |
| Nut ($\frac{1}{4}$ in.) | to sidescreen | 4 | 2823 |

3. Remove the door complete with sidescreen from the vehicle.
4. Mark off and drill the two $\frac{1}{4}$ in. (6,5 mm) clearance fixing holes for the new hinge plate in the sidescreen frame. The plate, which has slotted fixing holes, must be so positioned that its hinge pin is accurately in line with the two door hinge pins; the use of a straight edge is essential for this operation.
5. Secure the hinge plate on the outer side of the sidescreen, with a backing plate on the inside, by means of the two bolts, spring washers and nuts.
6. Replace the door and sidescreen and adjust the hinge bracket on the windscreen so that there is no strain on the new hinge.

## Front door

**To remove and refit** **Operation R/14**

1. Remove the sidescreen.
2. Swing the door panel forward until parallel with the front wing and lift from its hinges.
3. If necessary, remove the door hinges.
4. Replace the door by reversing the removal procedure, renewing the sealing rubbers as necessary.

### Door gusset plate, to fit, 1948-53

1. On early vehicles it may be found that the upper rear corner of the door panel is fractured, owing to vibration of the rear edge of the sidescreen placing an excessive strain on the door capping. A gusset plate is now fitted to strengthen the door.
2. If required, these plates can be obtained from our Parts Department under Part Numbers 302335—left hand and 302334—right hand.
3. Remove the sidescreen.
4. Remove the door from the vehicle.
5. Remove the upper buffer from the door.
6. Shear the two rearmost rivets securing the top capping.
7. Secure the free end of the clip to the gusset plate by means of the bolt and plate, spring and plain washers and nut provided.
8. Fit the gusset plate in position as shown at Fig. R-7.

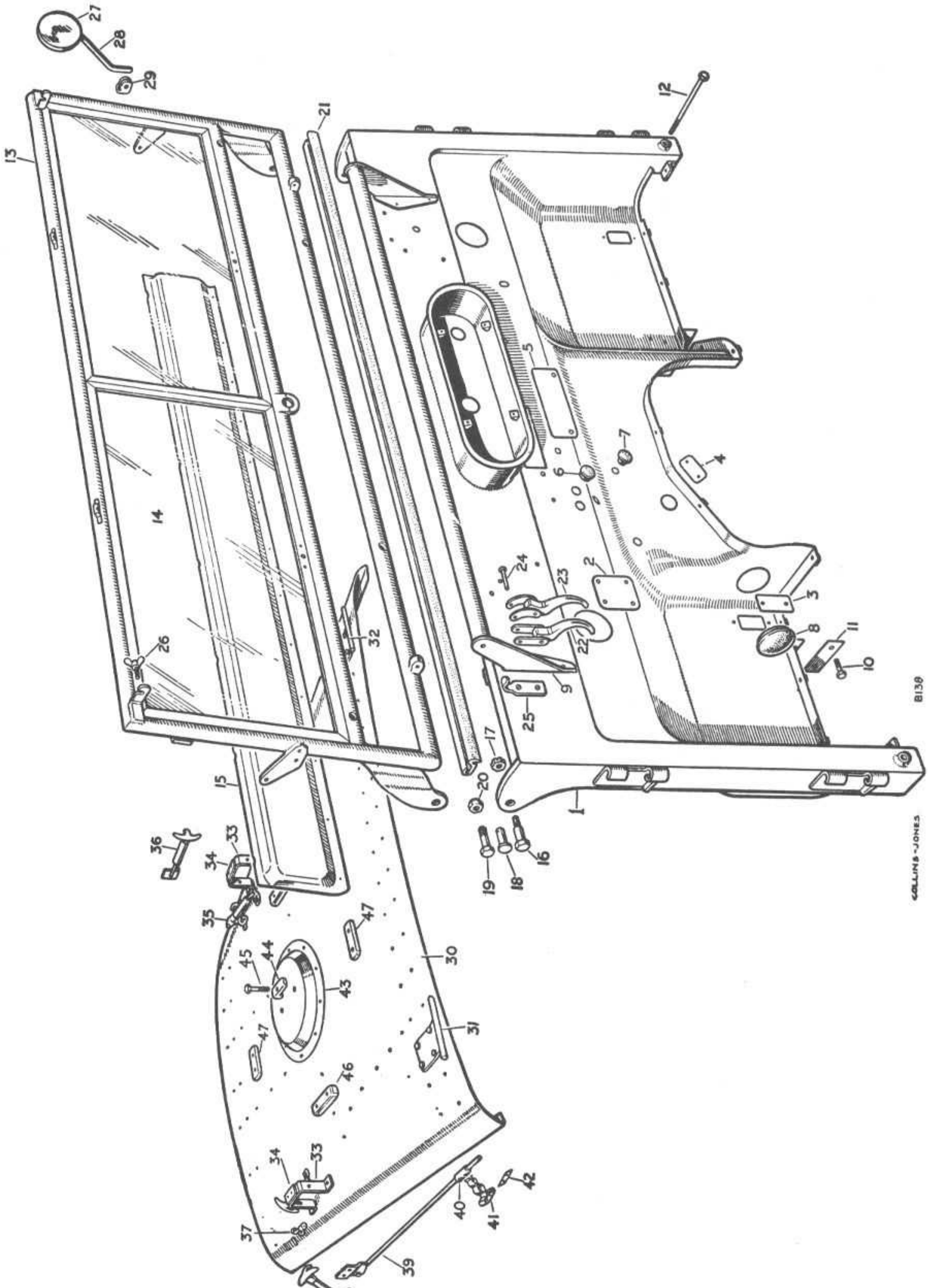


Fig. R-5—Layout of dash panel, 1948-53

**Key to Fig R-5**

1 Dash panel
2 Cover panel for steering cut-out
3 Cover plate for accelerator pedal hole
4 Access plate for exhaust rocker shaft
5 Cover plate for governor quadrant hole
6–7 Rubber blanking plugs for heater holes
8 Rubber blancking plug for starter access hole
9 Hand rail
10–12 Fixings, dash to chassis
13 Windscreen
14 Glass for windscreen
15 Bottom panel for windscreen
16–20 Pivot bolts for windscreen (alternatives)
21 Rubber sealing strip for windscreen
22–23 Fasteners for windscreen (alternatives)
24 Joint pin fixing fastener
25 Catch for fastener
26 Wing bolt in windscreen for hood
27 Driving mirror
28 Arm for mirror
29 Clip for arm
30 Bonnet panel
31–32 Hinges for bonnet
33 Support for windscreen
34 Tape for support
35–36 Clamps for windscreen (alternatives)
37 Staple for bonnet and windscreen clamp
38 Bonnet fastener
39 Prop rod for bonnet
40 Rubber tube for rod
41 Spring clip for rod
42 Tapped plate fixing clip
43 Support for spare wheel
44 Clamp for spare wheel
45 Bolt for clamp
46–47 Rubber support blocks for wheel

} Extra equipment

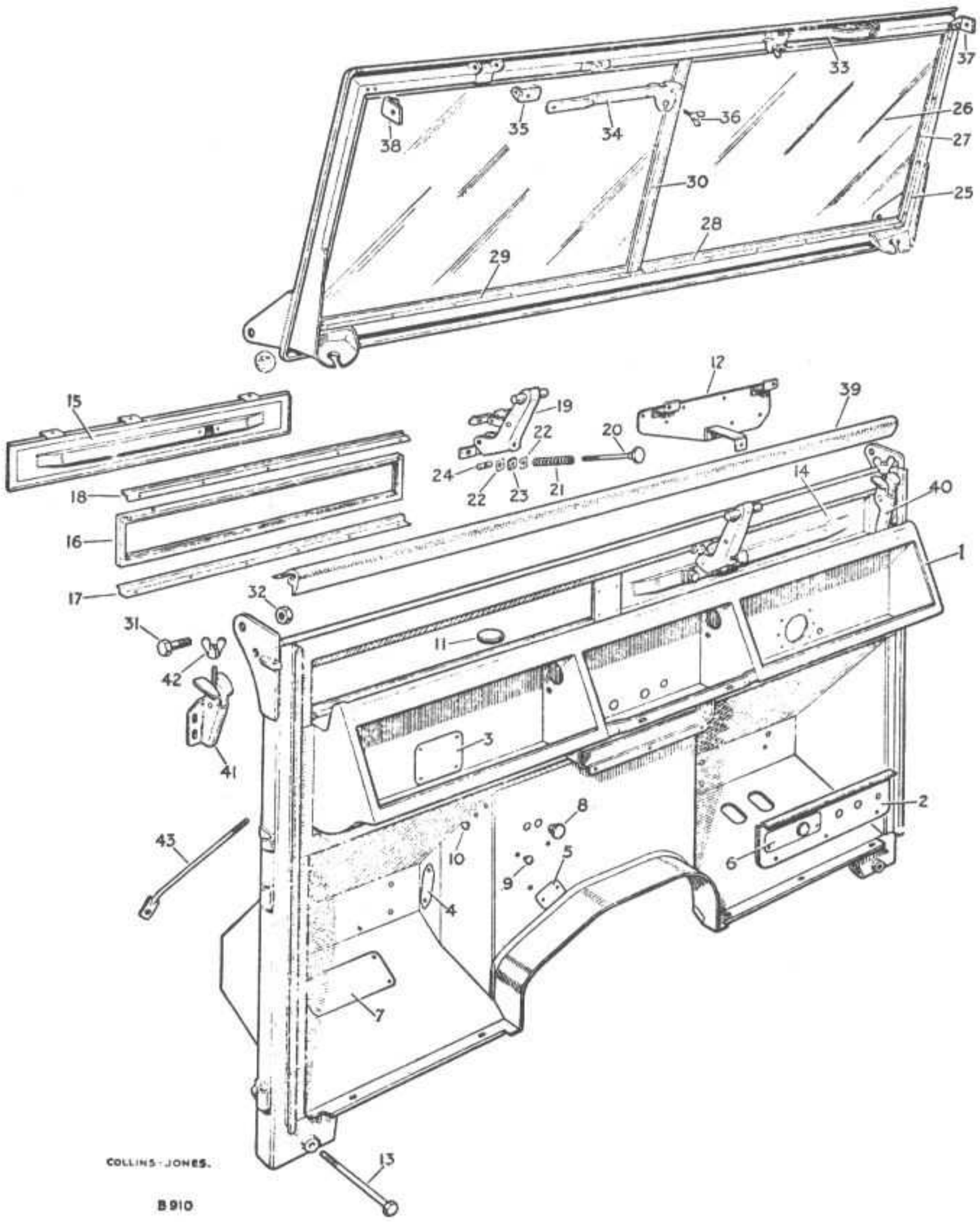


**Fig. R-6—Layout of dash panel, windscreen and ventilators, 1954-58**

1 Dash complete
2 Panel for controls
3 Cover panel for steering column
4 Cover plate for accelerator pedal hole
5 Access plate for bottom rocker shaft
6 Cover panel for governor cutout in dash
7 Cover plate for pedal holes
8 Rubber plugs, large, heater pipe holes
Rubber plug, medium, heater wiring holes
9 Rubber plug, small, heater bolt holes
10 Rubber plug, redundant accelerator holes
11 Rubber grommet for demister holes
12 Mounting plate for sump
13 Tie bolt
14 Ventilator lid for dash, R.H.
15 Ventilator lid for dash, L.H.
16 Seating rubber for ventilator lids
17 Retainer, bottom } For sealing
18 Retainer, top } rubber
19 Operating lever assembly for ventilator
20 Adjusting screw for ventilator
21 Spring
22 Square washer } For adjusting
23 Rubber washer } screw
24 Trunnion pin
25 Windscreen complete assembly
26 Glass for windscreen
27 Retainer for windscreen glass, vertical
28 Retainer for windscreen glass, R.H. } Upper and
29 Retainer for windscreen glass, L.H. } lower
30 Cover for centre strip
31–32 Fixings for windscreen
33 Pivot arm, R.H.
34 Pivot arm, L.H.
35 Pivot bracket, pivot arm to windscreen
36 Winged screw
37 Bracket, R.H. } For hood, cab and
38 Bracket, L.H. } hard top attachment
39 Rubber sealing strip for windscreen
40 Fastener for windscreen, R.H.
41 Fastener for windscreen, L.H.
42 Wing nut for fastener
43 Tie bar for dash support