

TRUCK, LIGHTWEIGHT AND TRUCK, LIGHT, MC2 -
LAND ROVER 110 4X4 AND 6X6 - ALL TYPES

STRENGTHENING OF BONNET STAY

MODIFICATION INSTRUCTION

This instruction is authorised for use by command of the Chief of Army. It provides direction, mandatory controls and procedures for the operation, maintenance and support of equipment. Personnel are to carry out any action required by this instruction in accordance with EMEI GENERAL A 001.

Introduction

1. This instruction details the procedure to strengthen the bonnet stay on all Land Rover 110 4x4 and 6x6 variants. The reason for strengthening the stay is to reduce damage to the stay and mounts and instances of the bonnet collapsing.

2. **Associated Publications.** Reference may be necessary to the latest issue of the following documents:

- a. EMEI Workshop A 850 - Modifications, Trial Modifications and Local Modifications to Equipment;
- b. EMEI Workshop A 851 - Recording Modifications to Equipment - Use of Modification Record Plates and Documentary Requirements;
- c. EMEI Workshop D 700 - Painting of Army Equipment;
- d. EMEI Workshop J 002 - The Procedure Handbook of Arc Welding;
- e. Rover Australia Engineering Change (EC) No 2438 Bonnet Stay - HYG7593; and
- f. EMEI General P section - Stores Procedure.

3. **Authority.** Rover Australia EC 2438 is the authority to carry out this modification.

General

4. **Modification Application.** This modification is to be applied to all Land Rover 110 4x4 and 6x6 variants.

5. **Items Affected.** This modification alters the bonnet stay.

6. **Priority - Group 2.** All applicable equipment is to be modified:

- a. when next in a workshop for repair or service, or
- b. prior to issue from depot or pool stock.

NOTE

Where modification would delay priority issues of depot or pool stock, equipment may be issued unmodified providing the equipment record book is endorsed appropriately.

7. **Action Required.** Actions detailed in this instruction are to be performed by units authorised to carry out Light, Medium or Heavy grade repairs.

NOTE

On receipt of this instruction, enter all relevant information other than date completed in the modifications section of the Record Book for Service Equipment (GM 120).

8. **Estimated Manhours.** For initial planning purposes only, it is estimated that this modification will take 0.5 manhours to perform.

9. **Stores Required.** The stores required are listed in Table 1. All stores are to be demanded through normal supply channels.

Detail

10. **Modification of Bonnet Stay.** The procedure is as follows:

- a. Inspect bonnet stay and mountings for serviceability, and replace as required.
- b. Manufacture strengthening strap, using Item 1 of Table 1, as detailed in Figure 1.
- c. Remove bonnet stay from vehicle.

CAUTION

**USE BACK STEP METHOD OF WELDING
TO PREVENT EXCESSIVE DISTORTION.**

- d. Using GP electrodes or LW1 welding wire, weld the strengthening strap to the back of the bonnet stay, as detailed in Figure 2.

UNCONTROLLED WHEN PRINTED

- e. Paint worked area.
- f. Refit bonnet stay.
- g. Test operation.

- a. Deface the number '32' on the 4x4 modification record plate and number '38' on the 6x6 modification record plate.
- b. Complete the modification details in the Record Book for Service Equipment (GM 120).

11. **Recording Action.** On completion of the modification, the following action is to be taken:

Table 1 - Stores Required

Item	NSN	Mfr Part No	Designation or Description	Unit of Issue	Qty per Equip
1	9515-66-097-0446	-	Steel Strap, 25 mm x 3 mm	m	320 mm
2		HYG7593	Bonnet Stay (modified)	ea	1 (if required)

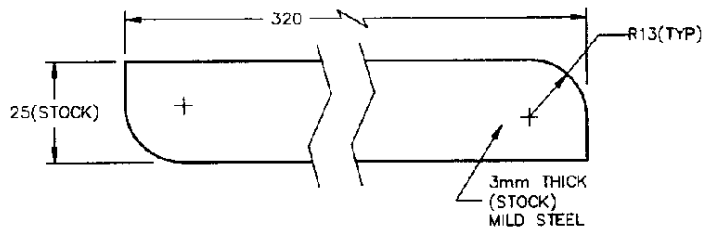


Figure 1 – Strengthening Strap

UNCONTROLLED WHEN PRINTED

UNCONTROLLED WHEN PRINTED

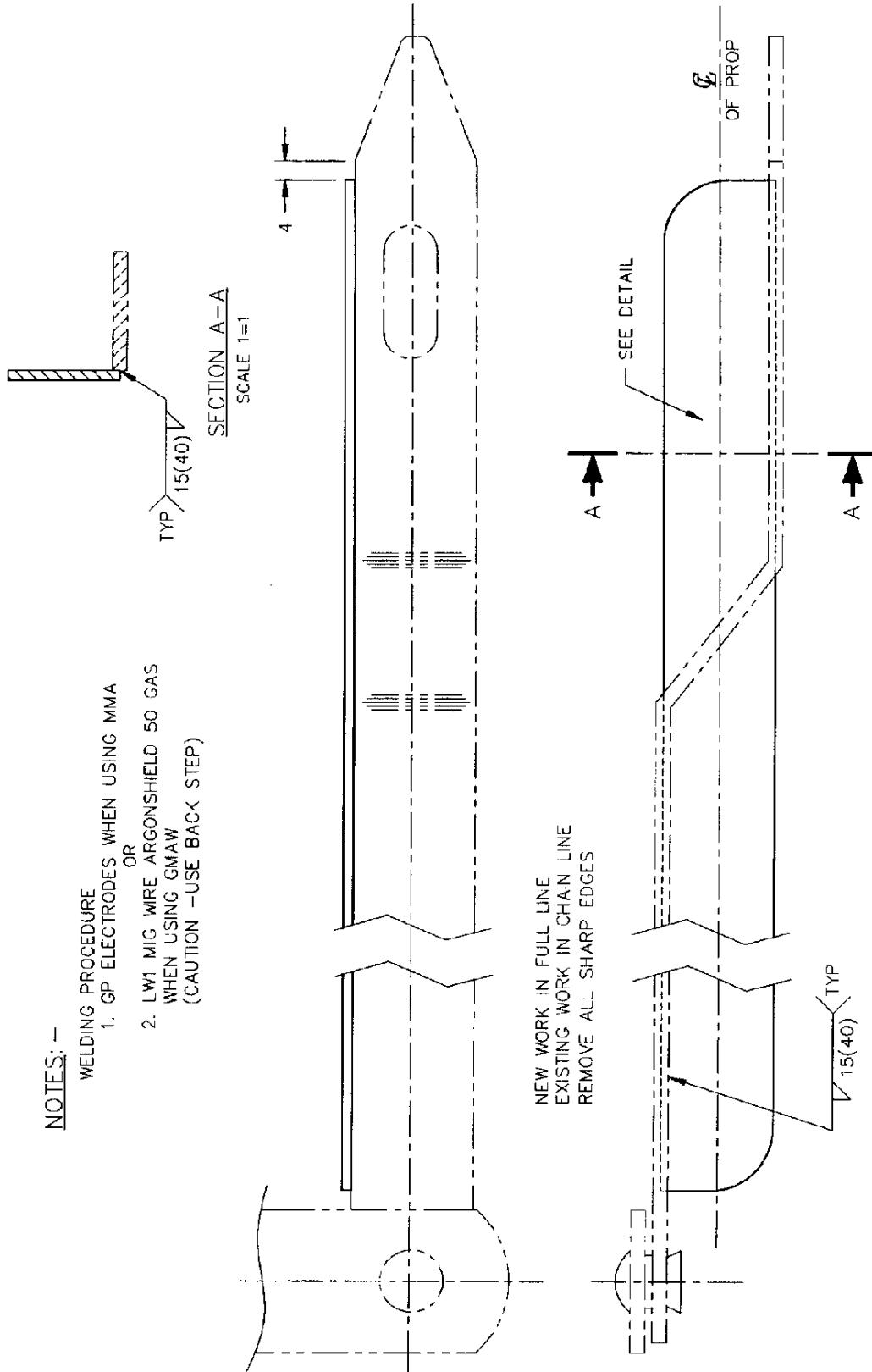


Figure 2 – Modified Bonnet Stay

END

List VEH G 01.1 - Code 1 (Job No 9800494)