

W02 HEIGHT
ALL 6x6 ACTIONED
GROUP NB 023
OCT 90

TRUCK, CARGO, LIGHT, MC2 LAND ROVER (110) - ALL TYPES
PLATE 'U' BOLT AND FITTING OF MODIFICATION RECORD PLATE

MODIFICATION INSTRUCTION

Issue of this instruction is authorised by CONMEA

Introduction

1. This instruction details the reworking of the plate 'U' bolt, fitted to the intermediate and rear axle assemblies, to prevent fouling and breakage of axle rebound straps.

Note:

1. NSN and Designation used in this instruction were current at the date of issue. If twelve months or more have expired since issue, the NSN should be checked for supersession.

General

2. Estimated Modification Time. 2.0 hrs.
3. Priority. Group 2.
4. Modification to be Applied to. All subject vehicles.
5. Items Affected. Plate 'U' bolt, intermediate and rear axle.
6. Action Required. By RAEME units authorised to carry out unit, field and base repairs.

TABLE 1 - STORES REQUIRED (To be demanded through normal supply channels). Only demand the plate 'U' bolt, if the one fitted is found to be defective on inspection)

Item	NSN	Designation	Qty per Equip
(a)	(b)	(c)	(d)
1.	AYG 7322	PLATE 'U' BOLT NB 022	4
2.	9905-66-039-2341	PLATE MODIFICATION, RECORD	1

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Detail

7. The modification is to be carried out as described below:
 - a. Remove the spare wheel.
 - b. Using a suitable jack, raise the rear of the vehicle and position the vehicle safety stands as follows:
 - (1) Underneath each chassis rail, in front of the intermediate spring to chassis mount, and
 - (2) Under each of the rear axle 'U' bolt plates.
 - c. Lower the vehicle onto the safety stands. Remove the intermediate wheels (rear wheels as required).

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CAUTION:

1. Due to the position of grinding, personnel are to wear a full face grinding mask.

- e. Using a wheel type grinder, (disc type grinder can be used in lieu) grind the two corners of each 'U' bolt plate which interface with the rebound straps to the dimensions shown at Fig 1. A modified 'U' bolt plate is shown at Fig 2.

Note:

1. Oxy-acetylene cutting equipment is not to be used.

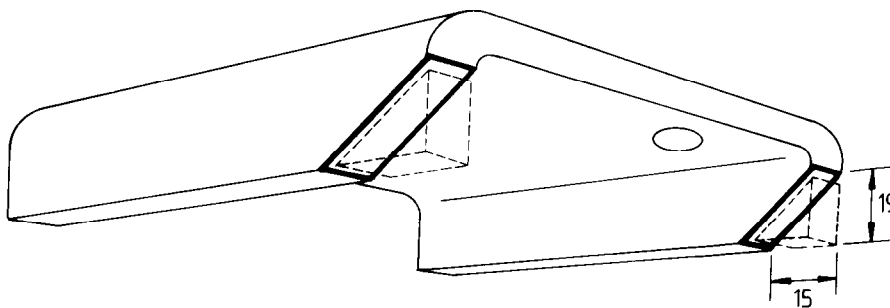


FIG 1 - DIMENSIONS OF REWORK REQUIRED

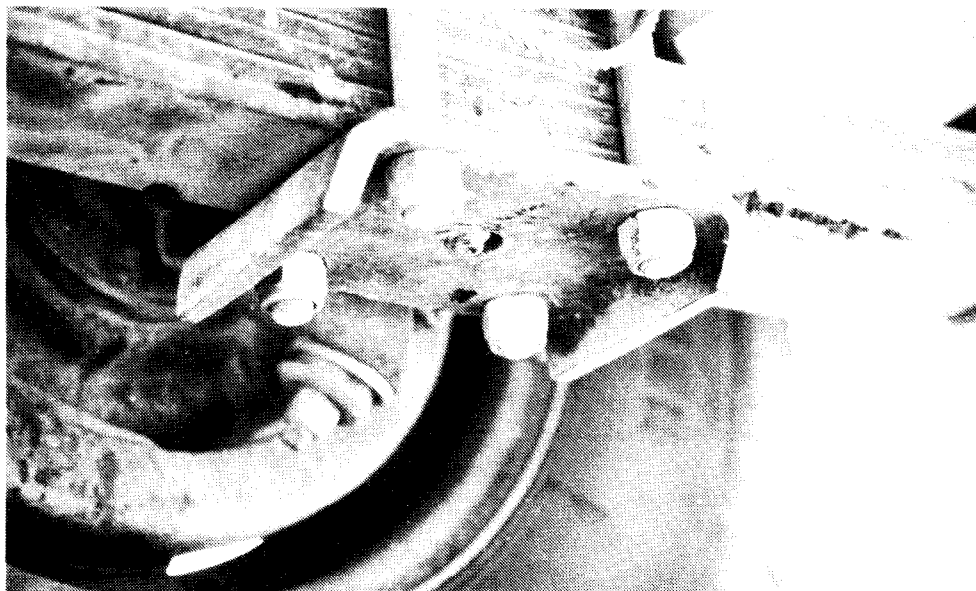


FIG 2 - COMPLETED MODIFICATION

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- f. Remove all sharp edges and paint in accordance with WKSP D 700.
- g. Refit all wheels.
- h. Tension wheel nuts to 110-115 Nm (75 - 85 lb ft).
- i. Replace spare wheel.
- j. The modification record plate, (item 1 from Table 1) can be fitted in either position, adjacent to the existing plate as shown in Fig 3.

CAUTION:

1. Exercise extreme caution when drilling the holes in the seat base side panel to ensure the drill does not penetrate into the fuel tank directly behind the seat base panel.

- k. Drill four 1/8 inch diameter holes through the modification record plate and the drivers seat base.
- l. Using suitable 1/8 inch diameter pop rivets, secure the record plate in position.

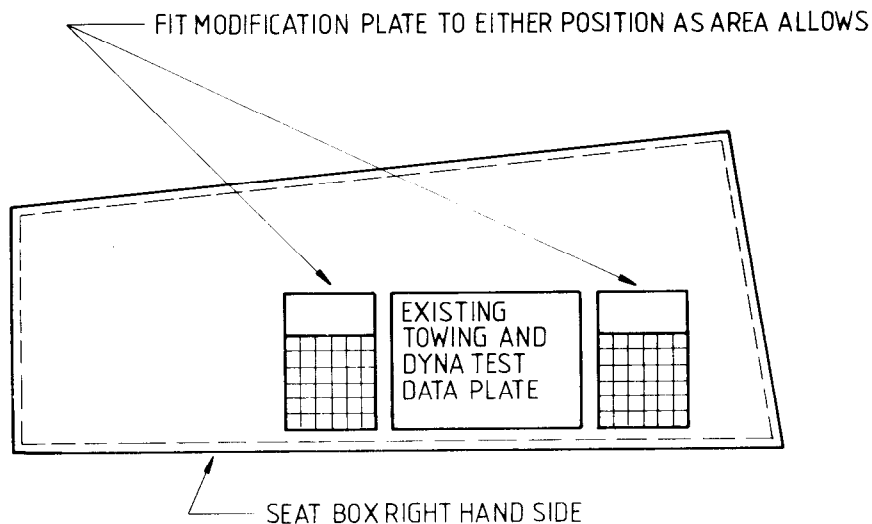


FIG 3 - LOCATION OF MODIFICATION PLATE

8. Modification Record Plate. Deface the numeral 1 on the modification record plate.

Note:

1. Deface the numeral 1 on the modification record plate on vehicles that have the modification already completed ex-production line.

9. Documentation. Details of the modification are to be entered in the TGM 120 Record Book for Service Equipment.

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