

Issue 1

Date 8.10.53

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MODELS AFFECTED

LAND-ROVER 1948-53

UNIT AFFECTED

BODY

Complaint: SIDESCREEN HINGE BRACKET FRACTURE

Remedy: Fit a modified hinge plate bracket.

Parts required.

Description	Qty.	Part No.
Sidescreen hinge plate bracket R.H.	1	306011
Sidescreen hinge plate bracket L.H.	1	306012
Tubular packing piece	6	306015
Bolt ( $\frac{1}{4}$ in. x $1\frac{1}{2}$ in. long)	6	235570
Nut ( $\frac{1}{4}$ in.)	6	2823
Plain washer	12	2213
} Fixing bracket to sidescreen frame		

Additional parts required for vehicles numbered:

860001 to 16103310, 16135970, 16162550, 16300003, 16330006, 16360008, 16630077 and 16661973 ONLY.

Hinge plate R.H.	1	304100
Hinge plate L.H.	1	304101
Bolt ( $\frac{1}{4}$ in. x $\frac{3}{4}$ in. long)	4	237141
Plain washer	4	2213
Spring washer	4	3074
Nut ( $\frac{1}{4}$ in.)	4	2823
} Fixing hinge plate to bracket		

1. Remove the door complete with sidescreen.
2. Remove the sidescreen from the door panel.
3. If the bracket has not been completely torn away from the frame, carefully remove it and file away the remaining weld, flush with the frame.
4. Retain the sidescreen hinge plate on vehicles numbered 16103311, 16135971, 16162551, 16300004, 16330007, 16360009, 16630078 and 16661974 onwards.
5. Select the correct hinge plate bracket to suit the frame under repair (R.H. or L.H. sidescreen).
6. Position the modified hinge plate bracket (306011/2) upon the sidescreen and clamp it in the centre with a "G" clamp.

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7. Drill two  $\frac{3}{8}$  in. diameter holes straight through the box section frame, rubber excluder and retainer, using the hinge plate bracket as a template.
8. Bolt the hinge plate bracket to the frame and remove the "G" clamp.
9. Drill the remaining  $\frac{3}{8}$  in. diameter hole through the centre, again using the bracket as a template.
10. Remove the two bolts and hinge plate bracket.
11. Enlarge the three  $\frac{3}{8}$  in. diameter holes drilled through the inside of the frame, draught excluder and retainer to  $\frac{5}{8}$  in. diameter in order to allow the tubular packing pieces (306015) to be inserted.  
IMPORTANT—Drill the  $\frac{5}{8}$  in. diameter holes only through the inside of the box section of the side screen frame member.
12. Insert the three tubular packing pieces into the frame.
13. Secure the hinge plate bracket to the frame using the three bolts (235570), plain washers (2213) and nuts (2823).
14. Refit the sidescreen to the door panel.
15. Refit the door complete to the vehicle.
16. Fit, adjust and tighten the hinge plate to ensure that the door will open and close quite freely without strain to either the hinge plate or bracket.

TOOLS REQUIRED

- 1 Hack saw
- 1 10 in. Flat file
- 1 "G" clamp
- 1 Hand drill
- 1 Drill  $\frac{3}{8}$  in. dia.
- 1 Drill  $\frac{5}{8}$  in. dia.
- 2 Spanners  $\frac{1}{2}$  in. B.S.F. open end.

TIME REQUIRED

1½ hours for each door.