

**Fig. 1 Modification to cylinder head gasket**

Cylinder head gasket shown with the top uppermost

A—Dotted line shows  $\frac{1}{8}$  in. (3 mm) hole size on earlier gaskets  
 B—Bold line shows  $\frac{3}{8}$  in. (9,5 mm) hole size on later gaskets

**REMARKS:**

To cater for vehicles operating under high ambient temperatures the cylinder head gasket has been modified as shown at Fig. 1.

It will be seen that the hole size in the indentations have been increased from  $\frac{1}{8}$  in. (3 mm) to  $\frac{3}{8}$  in. (9,5 mm).

Where it is considered necessary, stocks of the earlier type gaskets can be easily modified by punching the larger diameter hole in the centre of the three indentations as shown at the illustration.

**Item 10 SUBJECT: INLET MANIFOLD**

**MODELS:**

Land-Rover  $2\frac{1}{4}$  litre Diesel, Bonneted Control models.

**MODIFICATION:**

Introduction of inlet manifold with engine breather connection transferred from the elbow at the front of the inlet manifold to the rear end of the inlet manifold. This modification eliminates the possibility of oil that is blown out through the breather, being sucked into the combustion chambers and causing the engine to run on.

At the same time a modified engine breather with two diametrically opposed locating holes has been introduced, to suit early and late type manifolds, and to commonise parts with  $2\frac{1}{4}$  litre Diesel Forward Control models.

**LITERATURE**

**AFFECTED:**

Land-Rover Series II and 11A Parts Catalogue, Part No. 4656, Page 155.

**PART NUMBERS:**

Inlet manifold .. .. .	1	574661
Tube and plug assembly .. .. .	1	574656
Breather hose .. .. .	1	574655
Clip, fixing breather hose to manifold clamp .. .. .	1	574654
Engine breather .. .. .	1	574658
Hose clip, fixing breather hose to tube and breather .. .. .	2	554260

**REMARKS:**

When stocks of the early parts are exhausted, the latest components will be supplied for all Service replacements.

If necessary, early type manifolds can be converted as follows:

1. Remove tube from manifold elbow and replace with plug, Part No. 576446.
2. Remove core plug from end of manifold and replace with tube and plug assembly.
3. Replace 7 in. (178 mm) long breather hose with a 16 in. (400 mm) long hose.
4. Drill  $\frac{13}{64}$  in. (5 mm) hole opposite the existing locating hole on engine breather, to suit the reverse position.
5. Assemble, using hose clips listed above.

- Item 11** SUBJECT: **GEARBOX**
- MODELS: Land-Rover Bonneted and Forward Control.
- MODIFICATION: In order to reduce the passage of oil from the main gearbox to the transfer gearbox when the Land-Rover is used on gradients, the peg locating the mainshaft bearing housing in the gearbox casing, the hole for the peg in the housing and the groove for the peg in the gearbox casing are deleted. To prevent the mainshaft bearing housing from turning Loctite must be applied on assembly.
- LITERATURE AFFECTED: Land-Rover Parts Catalogue, Bonneted Control Models, Part No. 4656, Page 184.  
Land-Rover Parts Catalogue, Forward Control Models, Part No. 4862, Page 139.  
Land-Rover Workshop Manual, Part No. 4611, Section C.
- PART NUMBERS: Mainshaft bearing housing, rear . . . . . 1 561877  
Please note all future supplies of the existing gearbox casing complete, Part No. 605933, will be to the latest specification.
- COMMENCING NUMBERS: Gearbox serial numbers:  
Bonneted Control models from 25378396E onwards.  
Forward Control 4-cylinder models from 32500567B onwards.  
Forward Control 6-cylinder models from 33000584B
- REMARKS: Both early and late type mainshaft bearing houses must be stocked as required. The early type bearing housing, Part No. 217811 can be fitted to the latest gearbox casing because the peg hole in the housing will be blanked off by the casing. The peg of course must be discarded.
- When fitting either early or late type mainshaft bearing housing to the later type gearbox casing apply Loctite Grade AAV which is obtainable in 10 cc bottles from our Parts Department under Part No. 606146 and allow the appropriate time to cure.
- The late type bearing housing may be fitted to the early gearbox casing provided the following action is taken.
- This method can also be used to cure oil leaks in service. It does of course assume that the rear mainshaft bearing housing, mainshaft output gear, distance piece, oil thrower and housing circlip have been removed.
1. Thoroughly degrease the peg slot using cellulose thinners, trichlorethylene, carbon tetrachloride or methylated spirits and blow dry. The usual precautions for the fire and toxic hazards must be observed.
  2. Mix a small amount of IsoPON or similar plastic metal material working strictly to the manufacturers directions and press this into the slot. Ensure that the outer surface is flush with, or below, the surface of the casting and there is no IsoPON in the circlip groove. IsoPON is obtainable from any Halford Stores or direct from W. David and Sons Ltd., Derbyshire House, St. Chads Street, London WC1.
  3. Allow the IsoPON to harden then lightly smear Hylomar on the circlip slot, the gearbox face adjacent to the slot and the mating face of the circlip.
  4. Assemble.

- Item 12** SUBJECT: **HAND BRAKE MAINTENANCE ATTENTION**
- MODELS: Land-Rover, Bonneted and Forward Control models.
- REMARKS: Experience in the field has shown that very often the hand brake relay lever spindle and lever assembly is not included in the lubrication of general items, such as throttle linkage, door locks, hinges and bonnet prop rod etc., at the specified 12,000 miles (18,000 km) intervals.
- Consequently, this lack of maintenance causes the hand brake relay lever to seize on its spindle.
- Distributors and Dealers are requested to bring this point to the attention of those responsible for the vehicle lubrication.
- The literature affected will be amended to emphasise this at the next available reprint.

**Item 13 SUBJECT: SILL PANELS**

MODELS: Land-Rover 88 and 109 Bonneted Control models.

MODIFICATION: Introduction of narrow type sill panels.

## LITERATURE

AFFECTED: Land-Rover Parts Catalogue, Bonneted Control models, Part No. 4656, Pages 325 and 333.

PART NUMBERS:	Sill panel, front RH	.. .. .	1	337942	} 88
	Sill panel, front LH	.. .. .	1	337943	
	Sill panel, rear RH	.. .. .	1	337938	
	Sill panel, rear LH	.. .. .	1	337939	} 109
	Sill panel, rear RH	.. .. .	1	337932	
	Sill panel, rear LH	.. .. .	1	337933	
	Stay for body panel and sill panel, rear RH	.. .. .	1	337771	} 109 Station Wagon
	Stay for body panel and sill panel, rear LH	.. .. .	1	337772	
	Sill panel, rear RH	.. .. .	1	337710	
	Sill panel, rear LH	.. .. .	1	337711	

IDENTIFICATION: The early and late type sill panels can be identified by their width:

Early type:  $4\frac{1}{8}$  in. (125 mm) wide.

Late type:  $2\frac{3}{4}$  in. (72 mm) wide.

REMARKS: Narrow and wide type panels are not interchangeable due to the dimensional differences; both types must therefore be stocked for all Service replacements.

**Item 14 SUBJECT: DASH**

MODELS: Land-Rover Bonneted Control.

MODIFICATION: Introduction of two composite dashes covering all Land-Rover Series II and IIA models.

## LITERATURE

AFFECTED: Land-Rover Parts Catalogue, Part No. 4656, Page 343.

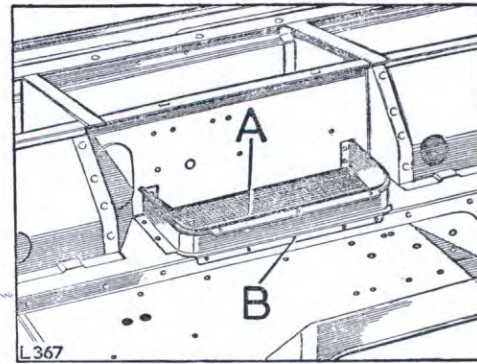
PART NUMBERS:	Dash complete	.. .. .	1	345879	4 cylinder models	} Part of Dash 345879
	Dash complete	.. .. .	1	345611	6 cylinder models	
	Mounting bracket for control panel		1	345882	Series II and IIA up to and including Suffix 'C'	
	Blanking plate for control panel aperture	.. .. .	1	345883	Series IIA from Suffix 'D' onwards	
	Plate for brake and clutch pedals, RH		1	338086		
	Plate for brake and clutch pedals, LH		1	338085		
	Cover plate for toe panel, LH	.. .. .	1	338091		
	Cover plate for toe panel, RH	.. .. .	1	338088		
	Rivet, fixing plates	.. .. .	26	78697		
	Rubber finisher, outer	} For dash top rail	2	348370	} 4 cylinder. Up to and including Suffix 'C'	
	Rubber finisher, centre		1	348371		

REMARKS: **4 cylinder models**

When using the composite dash on 4 cylinder models, it is necessary to order and fit, as applicable, the following:

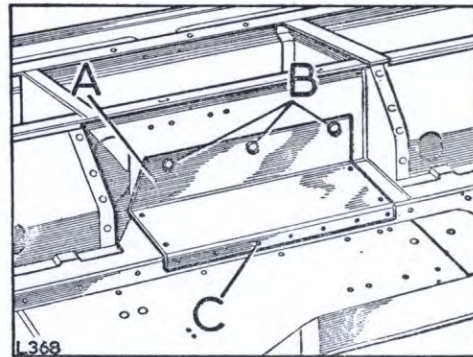
- (a) Plate for brake and clutch pedal.
- (b) Cover plate for toe panel.
- (c) Rubber finishers for dash top rail.

Each 4 cylinder dash is supplied with a mounting bracket for control panel and a blanking plate for control panel aperture. One or the other of these must be fitted to suit model applicability. See Fig. 2 and Fig. 3.



**Fig. 2 Location of mounting bracket for control panel**

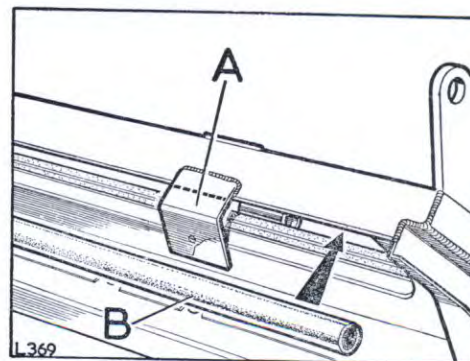
- A—Mounting bracket for control panel
- B—Retain with rivets, Part No. 78697, as indicated



**Fig. 3 Location of blanking plate for control panel aperture**

- A—Blanking plate for control panel aperture
- B—Retain with bolts  $\frac{1}{2}$  in. UNF x  $\frac{1}{2}$  in. long, spring washers and nuts
- C—Secure with rivets, Part No. 78697, as indicated

On all vehicles up to and including suffix 'C' remove outer bracket for dash rail finisher and fit rubber finisher for dash top rail. See Fig. 4.



**Fig. 4 Bracket for finisher and rubber finishers for dash rail**

- A—Remove bracket as indicated by dotted line
- B—Fit rubber finisher to edge of rail

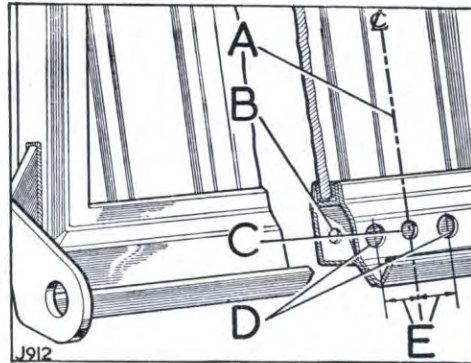
**6 cylinder models**

The latest type dash can be used without modification on all early 6 cylinder models.

**All models**

It will be necessary to plug various additional holes depending on model applicability and type of optional equipment fitted. Part numbers of suitable rubber plugs will be found in the Land-Rover Parts Catalogue.

<b>Item 15</b>	<b>SUBJECT:</b>	<b>WINDSCREEN</b>
	<b>MODEL:</b>	Land-Rover Series II, IIA and IIB.
	<b>PART NUMBER:</b>	Windscreen complete assembly . . . . . 1 338266
	<b>REMARKS:</b>	Stocks of the early type windscreen, Part No. 330665, which were suitable for the early type windscreen wipers attached to the windscreen have now been completely exhausted. It is our intention to supply the later type windscreen, Part No. 338266, as a replacement for the early type, this can be used but it will be necessary to drill the windscreen frame as shown at Fig. 5 to enable the windscreen wipers to be fitted.



**Fig. 5 Position of holes for windscreen wiper**

- A—Centre line of windscreen glass
- B—Drill two outer holes  $\frac{7}{32}$  in. (5,5 mm) in inner bottom rail of windscreen
- C—Drill centre hole  $\frac{1}{2}$  in. (9 mm) in both inner and outer bottom rails of windscreen
- D—Drill two outer holes  $\frac{7}{16}$  in. (11 mm) in outer bottom rail of windscreen
- E— $\frac{3}{4}$  in. (19 mm)