

SUBJECT: ANCHORAGE KIT FOR FRONT SEAT SAFETY HARNESS

MODELS: LAND-ROVER

- 88" Basic and Station Wagons. See page 1.
- 88" Cab. See page 3.
- 109" Full-length Hood. See page 4.
- 109" Cab. See page 6.
- 109" Station Wagon. See page 8.
- Stowage hook, all models. See page 9.

Each part number represents a complete set of anchorage fixings for one person, R.H. or L.H. side. They are for use with front seat safety harness Part No. 348776.

Full details of harness fitting to the anchorage points will be found in the fitting instructions supplied with the safety harness.

88" REGULAR AND STATION WAGON

PARTS REQUIRED:

									Qty.	Part No.
Anchorage kit, R.H.	1	320631
Anchorage kit, L.H.	1	320632

TOOLS REQUIRED:

- Spanner sizes: $\frac{1}{2}$ in AF, $\frac{7}{16}$ in AF
- Screwdriver, medium Screwdriver, Phillips
- Hammer Hacksaw Pop rivet tool

Procedure—One side only

1. Remove the two corner bolts, securing seat base to body floor and sill panel, R.H. or L.H. as required.
2. Indent the side panel of seat, using a ball-pein hammer, to suit the harness fixing nut of sill gusset.
3. Secure the sill gusset into the corner position, with the original body fixing bolts as shown in Fig. 1.

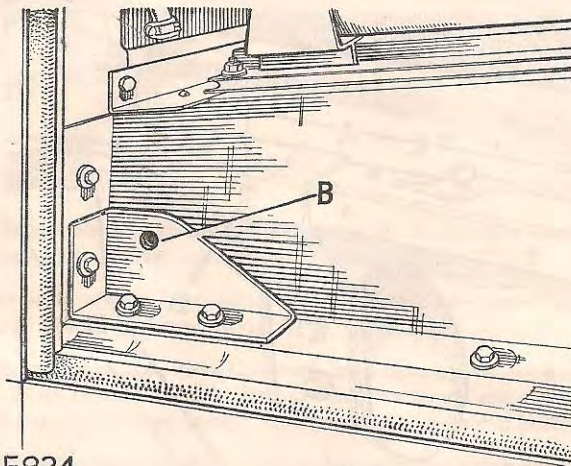


Fig. 1. Sill gusset in position. R.H. illustrated.
 B—Harness, tapped fixing hole.

E824.

4. Drill the remaining gusset fixing hole through sill and body panel $\frac{3}{32}$ in. (7 mm) diameter and secure gusset, using bolt ($\frac{1}{4}$ in. UNF x $\frac{1}{2}$ in. long), plain washer, spring washer and nut ($\frac{1}{4}$ in. UNF).
5. Mark off a centre line of vehicle on body floor, adjacent to seat bulkhead—then mark a position $10\frac{1}{4}$ in. (260 mm) from the centre line toward body side, as shown in Fig. 2.

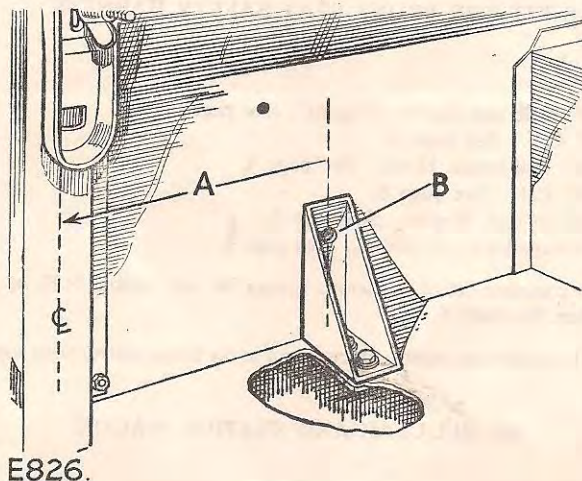


Fig. 2. Bulkhead gusset in position. R.H. illustrated.

A— $10\frac{1}{4}$ in. (260 mm) to centre line of body.
B—Harness, tapped fixing hole.

6. Position the bulkhead gusset central on the $10\frac{1}{4}$ in. (260 mm) line marking and, using the gusset as a template, drill the two gusset fixing holes $\frac{3}{32}$ in. (7 mm) diameter through the floor panel, and a pilot hole through the bulkhead panel from the tapped hole position, harness fixing. Open out the pilot hole in bulkhead to $\frac{11}{32}$ in. (12 mm).
7. Secure the gusset in position, with washer plate assembly underneath floor panel, using two bolts ($\frac{1}{4}$ in. UNF x $\frac{7}{8}$ in. long), plain washers and spring washers.

On the seat bulkhead top capping, mark off a centre position of vehicle—then mark off a position outboard $24\frac{5}{16}$ in. (617 mm) for R.H. or L.H. harness fixing as required, as shown in Fig. 3.

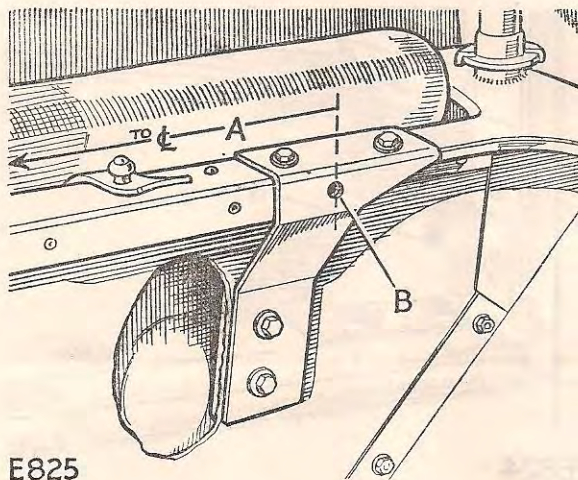


Fig. 3. Shoulder bracket in position. R.H. illustrated.

A— $24\frac{5}{16}$ in. (617 mm) to centre line of body
B—Harness, tapped fixing hole.

9. Remove the four rivets securing capping to bulkhead at this position.
10. Cut a suitable clearance hole in the bulkhead top capping, for the harness fixing nut on shoulder bracket, on the $24\frac{1}{8}$ in. (617 mm) marking.
11. Secure the shoulder bracket to capping, using two bolts ($\frac{1}{4}$ in. U.N.F. x $\frac{7}{8}$ in. long), spring washers and nuts ($\frac{1}{4}$ in. UNF).
12. Using the shoulder bracket as a template, drill the two fixing holes in bulkhead panel $\frac{3}{4}$ in. (8 mm) diameter and secure bracket in position, with washer plate inside bulkhead panel, using two bolts ($\frac{5}{16}$ in. UNF x $\frac{7}{8}$ in. long), spring washers, nuts ($\frac{5}{16}$ in. UNF).

88" WITH CAB

PARTS REQUIRED

									Qty.	Part No.
Anchorage kit, R.H.	1	320633
Anchorage kit, L.H.	1	320634

Procedure—one side only

1. Remove the two corner bolts, securing seat base to body floor and sill panel, R.H. or L.H. as required.
2. Indent the side panel of seat, using a ball-pein hammer, to suit the harness fixing nut of sill gusset.
3. Secure the sill gusset into the corner position, with the original body fixing bolts as shown in Fig. 4.

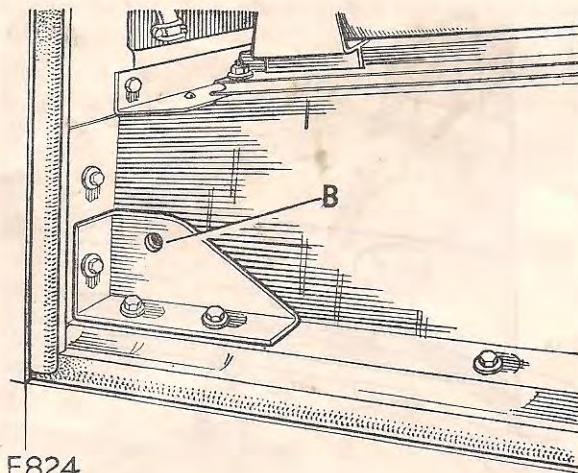


Fig. 4. Sill gusset in position. R.H. illustrated.

B—Harness, tapped fixing hole.

4. Drill the remaining gusset fixing hole through sill and body panel $\frac{3}{8}$ in. (7 mm) diameter and secure gusset, using bolt ($\frac{1}{4}$ in. UNF x $\frac{7}{8}$ in. long), plain washer, spring washer and nut ($\frac{1}{4}$ in. UNF).
5. Mark off a centre line of vehicle on body floor, adjacent to seat bulkhead—then mark a position $10\frac{1}{4}$ in. (260 mm) from the centre line toward body side, as shown in Fig. 5.
6. Position the bulkhead gusset central on the $10\frac{1}{4}$ in. (260 mm) line marking and, using the gusset as a template, drill the two gusset fixing holes $\frac{3}{8}$ in. (7 mm) diameter through the floor panel, and a pilot hole through the bulkhead panel, from the tapped hole position, harness fixing. Open out the pilot hole in bulkhead to $\frac{1}{2}$ in. (12 mm).
7. Secure the gusset in position, with washer plate assembly underneath floor panel, using two bolts ($\frac{1}{4}$ in. UNF x $\frac{7}{8}$ in. long) plain washers and spring washers.

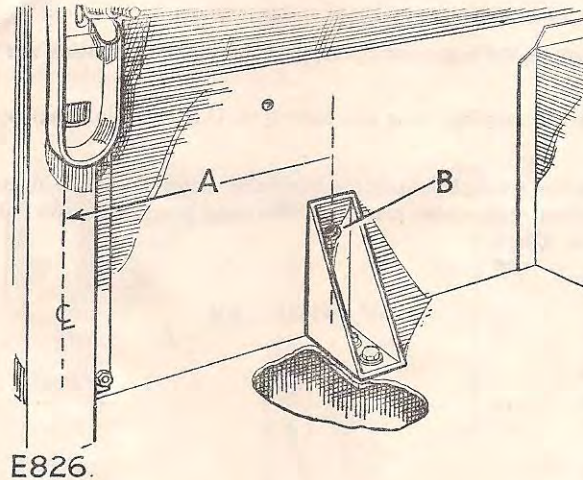


Fig. 5. Bulkhead gusset in position. R.H. illustrated.

A—10 1/4 in. (260 mm).

B—Harness, tapped fixing hole.

8. On the seat bulkhead top capping, mark off a centre position of vehicle.
9. Measure a distance of 25 3/8 in. (671 mm) outboard, which should be to a 1/4 in. bolt securing cab to seat bulkhead, for R.H. or L.H. harness fixing as required, shown in Fig. 6.

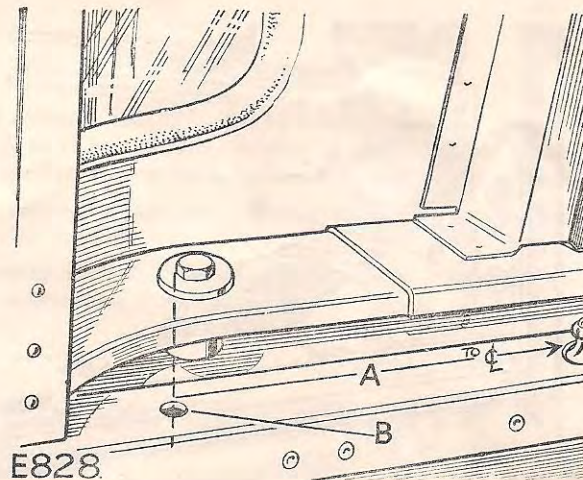


Fig. 6. Showing position of safety harness fixing hole. R.H. illustrated.

A—25 3/8 in. (671 mm) to centre line of body.

B—Harness, fixing hole.

10. Remove the 1/4 in. bolt, open out the hole in both cab and top of seat bulkhead to 15/32 in. (12 mm) for safety harness fixing.

109" WITH FULL-LENGTH HOOD

PARTS REQUIRED

	Qty.	Part No.
Anchorage kit, R.H.	1	320635
Anchorage kit, L.H.	1	320636

Procedure—One side only.

1. Remove the two corner bolts, securing seat base to body floor and sill panel, R.H. or L.H. as required.
2. Indent the side panel of seat, using a ball-pein hammer, to suit the harness fixing nut of sill gusset.
3. Secure the sill gusset into the corner position, with the original body fixing bolts as shown in Fig. 7.

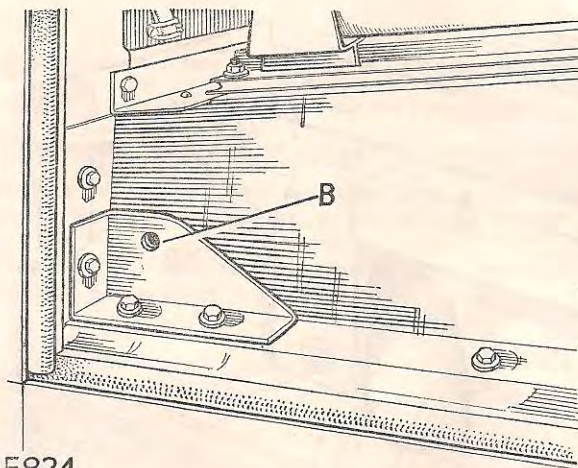


Fig. 7. Sill gusset in position. R.H. illustrated.

B—Harness, tapped fixing hole.

E824.

4. Drill the remaining gusset fixing hole through sill and body panel $\frac{3}{32}$ in. (7 mm) diameter and secure gusset, using bolt ($\frac{1}{4}$ in. UNF x $\frac{7}{8}$ in. long), plain washer, spring washer and nut ($\frac{1}{4}$ in. UNF).
5. Mark off a centre line of vehicle on body floor, adjacent to seat bulkhead—then mark a position $10\frac{1}{4}$ in. (260 mm) from the centre toward body side, as shown in Fig. 8.

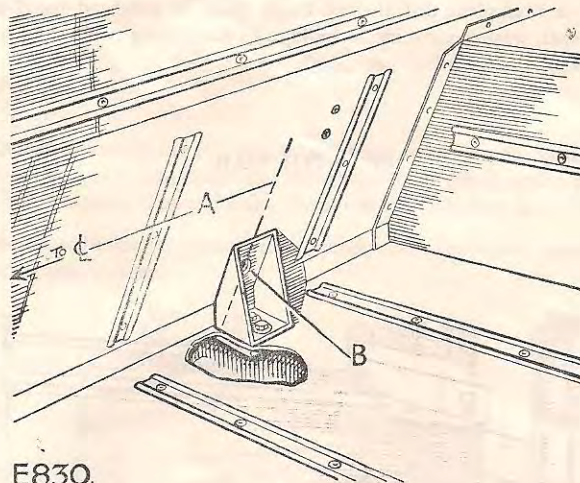


Fig. 8. Bulkhead gusset in position. R.H. illustrated.

A— $10\frac{1}{4}$ in. (260 mm) to centre line of body.

B—Harness, tapped fixing hole.

E830.

6. Position the bulkhead gusset central on the $10\frac{1}{4}$ in. (260 mm) line marking and, using the gusset as a template, drill the two gusset fixing holes $\frac{3}{16}$ in. (8 mm) diameter through the floor panel, and a pilot hole through the bulkhead panel, from the tapped hole position, harness fixing. Open out the pilot hole to $\frac{15}{32}$ in. (12 mm).
7. Secure the gusset in position, with washer plate assembly underneath floor panel, using two bolts ($\frac{5}{16}$ in. UNF x 1 in. long), plain washers and spring washers.
8. On the seat bulkhead top capping, mark off a centre position of vehicle—then mark off a position outboard $24\frac{5}{16}$ in. (617 mm), for R.H. or L.H. harness fixing as required, shown in Fig. 9.

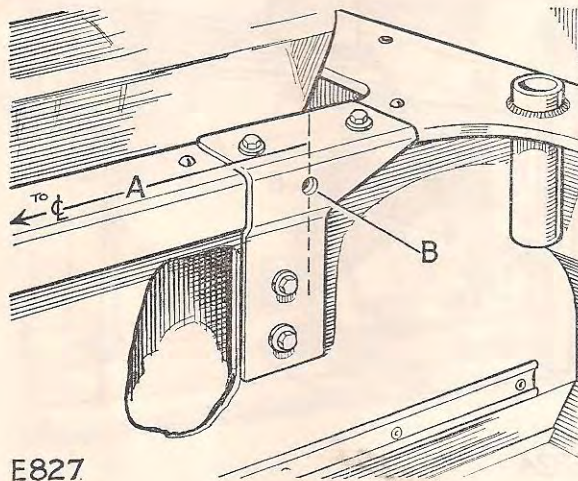


Fig. 9. Shoulder bracket in position. R.H. illustrated.

A—24 $\frac{5}{8}$ in. (617 mm) to centre line of body.

B—Harness, tapped fixing hole.

9. Remove the four rivets securing capping at this position.
10. Cut a suitable clearance hole in the bulkhead top capping, for the harness fixing nut on shoulder bracket, on the 24 $\frac{5}{8}$ in. (617 mm) marking.
11. Secure the shoulder bracket to capping, using two bolts ($\frac{1}{4}$ in. UNF x $\frac{7}{8}$ in. long) spring washers and nuts ($\frac{1}{4}$ in. UNF).
12. Using the shoulder bracket as a template, drill the two fixing holes in bulkhead panel $\frac{3}{4}$ in. (8 mm) diameter and secure bracket in position, with washer plate inside bulkhead panel, using two bolts ($\frac{5}{16}$ in. UNF x $\frac{7}{8}$ in. long), spring washer and nuts ($\frac{5}{16}$ in. UNF).

PARTS REQUIRED

109" WITH CAB

										Qty.	Part No.
Anchorage kit, R.H.	1	320637
Anchorage kit, L.H.	1	320638

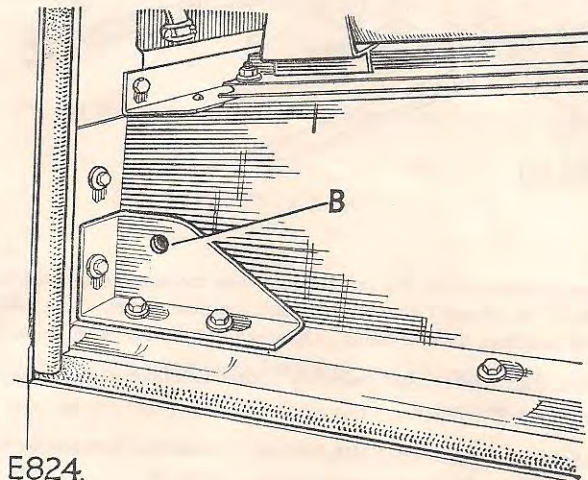


Fig. 10. Sill gusset in position. R.H. illustrate.

B—Harness, tapped fixing hole.

Procedure—One side only

1. Remove the two corner bolts, securing seat base to body floor and sill panel, R.H. or L.H. as required.
2. Indent the side panel of seat, using a ball-pein hammer, to suit the harness fixing nut of sill gusset.
3. Secure the sill gusset into the corner position, with the original body fixing bolts as shown in Fig. 10.
4. Drill the remaining gusset fixing hole through sill and body panel $\frac{3}{8}$ in. (7 mm) diameter and secure gusset, using bolt ($\frac{1}{4}$ in. UNF x $\frac{3}{8}$ in. long), plain washer, spring washer and nut ($\frac{1}{4}$ in. UNF).
5. Mark off a centre line of vehicle on body floor, adjacent to seat bulkhead—then mark off a position $10\frac{1}{4}$ in. (260 mm) from the centre line toward body side, as shown in Fig. 11.

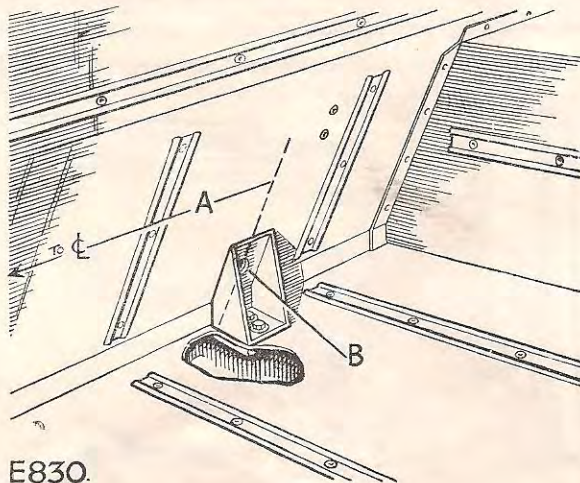


Fig. 11. Bulkhead gusset in position. R.H. illustrated.

A— $10\frac{1}{4}$ in. (260 mm) to centre line of body.

B—Harness, tapped fixing hole.

E830.

6. Position the bulkhead gusset central on the $10\frac{1}{4}$ in. (260 mm) line marking and, using the gusset as a template, drill the two gusset fixing holes $\frac{3}{4}$ in. (8 mm) diameter through the floor panel, and a pilot hole through the bulkhead panel, from the tapped hole position, harness fixing. Open out the pilot hole in bulkhead to $\frac{11}{8}$ in. (12 mm).
7. Secure the gusset in position, with washer plate assembly underneath floor panel, using two bolts ($\frac{5}{16}$ in. UNF x 1 in. long), plain washers and spring washers.

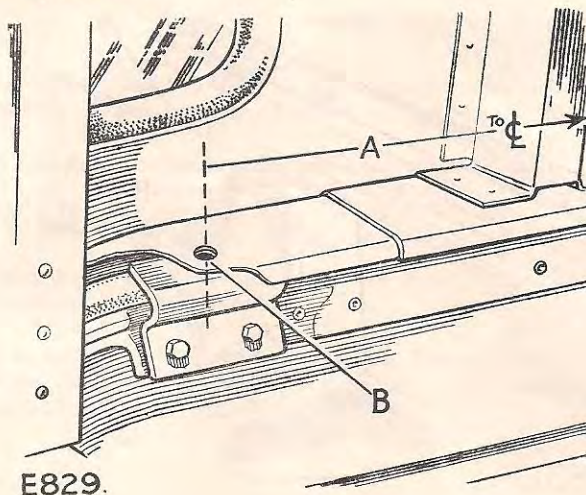


Fig. 12. Cab mounting assembly in position. R.H. illustrated.

A— $24\frac{11}{8}$ in. (631 mm) to centre line of body.

B—Harness, tapped fixing hole.

E829.

8. Remove the outboard distance piece, securing cab to the bulkhead capping, a distance of $24\frac{3}{4}$ in. (631 mm) from the centre position of vehicle, as shown in Fig. 12.
9. Fit in place, cab mounting assembly for safety harness fitting, using the original fixings.

109" STATION WAGON

PARTS REQUIRED

	Qty.	Part No.
Anchorage kit, R.H.	1	320639
Anchorage kit, L.H.	1	320640

Procedure—One side only

1. Remove the two corner bolts, securing seat base to body floor and sill panel, R.H. or L.H. as required.
2. Indent the side panel of seat, using a ball-pein hammer, to suit the harness fixing nut of sill gusset.
3. Secure the sill gusset into the corner position, with the original body fixing bolts as shown in Fig. 13.

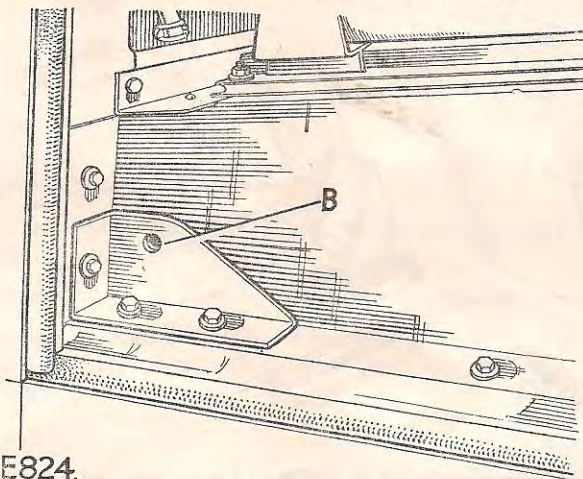


Fig. 13.
Sill gusset in position.
R.H. illustrated.
B—Harness, tapped fixing hole.

E824.

4. Drill the remaining gusset fixing hole through sill and body panel $\frac{3}{8}$ in. (7 mm) diameter and secure gusset, using bolt ($\frac{1}{4}$ in. UNF x $\frac{7}{8}$ in. long), plain washer, spring washer and nut ($\frac{1}{4}$ in. UNF).
5. Mark off a centre line of vehicle on body floor adjacent to seat bulkhead—then mark off a position 8 in. (203 mm) from the centre line toward body side, as shown in Fig. 14.

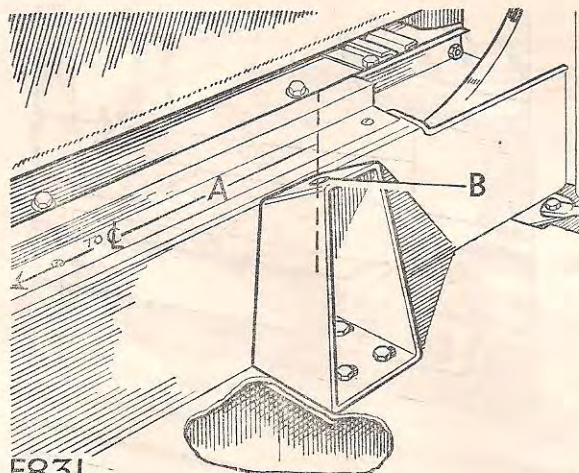


Fig. 14.
Toe panel gusset in position.
R.H. illustrated.
A—8 in. (203 mm) to centre line of body.
B—Harness, tapped fixing hole.

E831.

6. Position the toe panel gusset central on the 8 in. (203 mm) line marking and, using the gusset as a template, drill the four holes through floor panel $\frac{3}{32}$ in. (7,0 mm) diameter in line with spot welds.
7. Secure the gusset in position with two washer plates underneath body floor, using four bolts ($\frac{1}{4}$ in. UNF x $\frac{3}{8}$ in. long), spring washers and nuts ($\frac{1}{4}$ in. UNF).
8. Remove the roll trim, front fixing, from cant rail, secured with four drive screws.
9. Remove the $\frac{1}{4}$ in. bolt, a distance of $\frac{3}{4}$ in. (19 mm) from top corner, securing cant rail to B.C. post—then open out the hole to $\frac{3}{16}$ in. (8 mm) diameter.
10. Secure the shoulder bracket R.H. or L.H. as required to the top corner of B.C. post, with the bracket web facing inboard, using bolt ($\frac{5}{16}$ in. UNF x 1 in. long), spring washer and nut ($\frac{5}{16}$ in. UNF) as shown in Fig. 15.
11. Using the remaining hole in bracket as a template drill a $\frac{3}{16}$ in. (8 mm) diameter hole in cant rail and secure bracket, using bolt ($\frac{5}{16}$ in. UNF x 1 in. long), spring washer, nut ($\frac{5}{16}$ in. UNF).

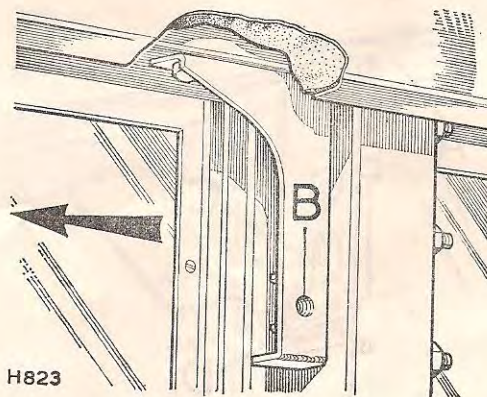


Fig. 15.
Shoulder bracket in
position B.C. post.
R.H. illustrated.
B—Harness, tapped
fixing hole.
Arrow points to the front
of the vehicle.

12. Using the bracket as a template, drill two $\frac{3}{16}$ in. (8 mm) diameter holes through B.C. post and secure bracket using two bolts ($\frac{5}{16}$ in. UNF x $2\frac{1}{2}$ in. long), spring washer and nut ($\frac{5}{16}$ in. UNF).
13. Replace the front roll trim panel, cutting away the trim panel where necessary.

STOWAGE HOOK, ALL MODELS

1. Position the stowage hook on the 'BC' post to the dimensions shown at Figs. 16, 17 or 18 as applicable for the model concerned. In each case R.H. side illustrated.
2. Use hook as a template and drill two holes .082 in. (2.0 mm) when drive screws are supplied in the kit; .140 in. (3,5 mm) when pop rivets are supplied in the kit. Use a stop on the drill to allow only $\frac{1}{2}$ in. (25 mm) of the drill through the panel to avoid damaging the pillar.

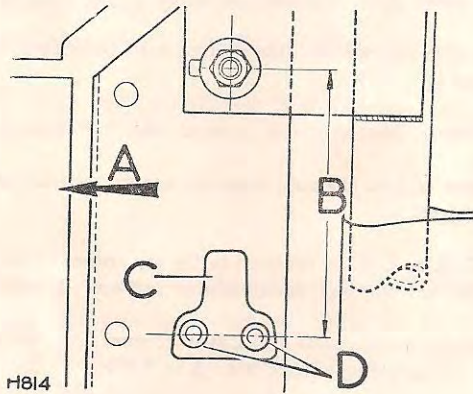


Fig. 16. Position of stowage hook on 'BC' post 88 and 109 with full length hood.

- A—To front of vehicle.
- B—3 in. (76 mm).
- C—Stowage hook.
- D—Pop rivets

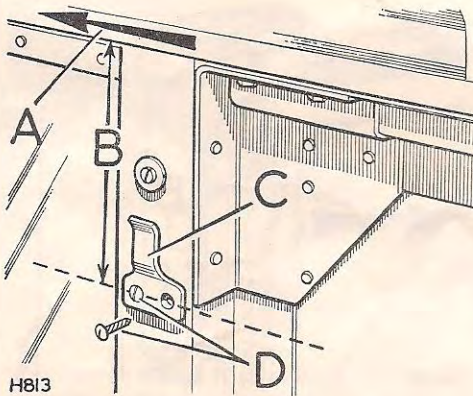


Fig. 17. Position of stowage hook on 'BC' post. 88 and 109 Hard Top and Station Wagon.

- A—To front of vehicle.
- B—4½ in. (103 mm).
- C—Stowage hook.
- D—Drive screws.

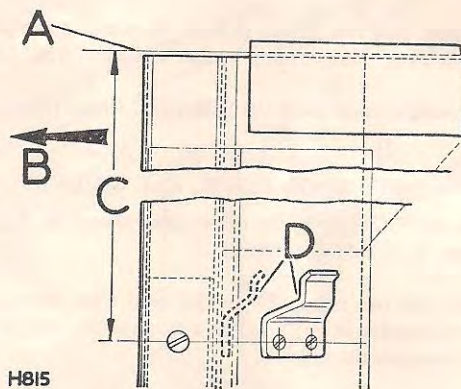


Fig. 18. Position of stowage hook on 'BC' post. 88 and 109 with cab, trimmed and untrimmed.

- A—Under-side of cab top rail.
- B—To front of vehicle.
- C—5½ in. (139 mm).
- D—Stowage hook. Full line, position on trimmed cab. Dotted line, position on untrimmed cab.