TRUCK UTILITY LT GS SERIES 3 LANDROVER, ALL TYPES
STRENGTHENING OF THE REAR CHASSIS CROSSMEMBER
MODIFICATION INSTRUCTION

Issue of this instruction is authorized by the CONMEA

Introduction

1. This instruction details the strengthening of the rear chassis crossmember to prevent it bending adjacent to the pintle hook. The instruction also details the strengthening of the jerrycan mounting to prevent the bolts pulling through the crossmember.

General

2. **Estimated Manhours to Perform.** 10.0 (initial planning only).

3. **Priority.** Group 2.

4. **Modification to be Applied to.** All subject vehicles.

5. **Items Affected.**

   a. Rear chassis crossmember and pintle hook assembly.

   b. Jerry can mounting brackets.

6. **Action Required.** By RAEME workshops authorized to carry out field and base repairs in accordance with WKSP A 850.

TABLE 1 — STORES REQUIRED (To be demanded through normal supply channels)

Item	DSN	Designation	Qty per Equip
1.	5306–66–019–3795	BOLT, MACHINE UNF, 2A, SAE grade 5 steel, hex hd, zinc coated, 3/8 in dia by 4-1/2 in lg	4
2.	5306–66–019–3880	BOLT, MACHINE UNF, 2A, SAE grade 5 steel, hex hd, zinc coated, 7/16 in dia by 1-3/8 in lg	6
3.	5310–66–010–7825	NUT, SELF-LOCKING, HEXAGON, UNF, 2B P steel, type P, cad plated, with nylon insert, 3/8 in	8
4.	5310–66–010–7826	NUT, SELF-LOCKING, HEXAGON, UNF, 2B P steel, type P, cad plated, with nylon insert, 7/16 in	6
5.	5310–66–016–8929	WASHER, FLAT, rd steel, cad plated, 7/16 in	6
6.	5310–66–016–8930	WASHER, FLAT, rd steel, cad plated, 3/8 in	8
7.	9515–66–097–0421	STEEL PLATE, CARBON, mild, grade 180, 10 mm thk	As required

Detail

7. **Rear Chassis Crossmember.**

   a. Manufacture the strengthening plates A, B and C as shown in Figs 1, 2 and 3, using item 7 from Table 1.

   b. Paint both sides of the plates black, in accordance with WKSP B 700.

   c. Remove the pintle hook from the rear chassis crossmember, retain the mounting bolts.

   d. Remove the two small gussetts from the front side of the rear chassis crossmember as shown in Fig 4. This will allow plate B to be positioned on the front side of the rear chassis crossmember.

   e. Using the original pintle hook bolts, fit the pintle hook assembly, strengthening plates A and B, self locking nuts and flat washers, items 3 and 6 from Table 1, to the rear chassis crossmember as shown in Figs 4 and 7. Torque the nuts to 40 Nm.

   Note:

   1. Do not use the four original 30 by 130 by 6 mm strengthening plates that were removed with the pintle hook assembly vide sub-paragraph 7c.

   f. Using strengthening plate A as a template, drill four 11 mm holes through both sides of the rear chassis crossmember.

   g. Using items 1, 3 and 6 from Table 1, fit strengthening plates C to the rear chassis crossmember as shown in Fig 4. Torque the nuts to 40 Nm.

8. **Jerry Can Mounting Bracket.**

   a. Rework two of the 30 by 130 by 6 mm strengthening plates, removed vide sub-paragraph 7c, as shown in Fig 5.

   b. Paint both sides of the plates black, in accordance with WKSP B 700.

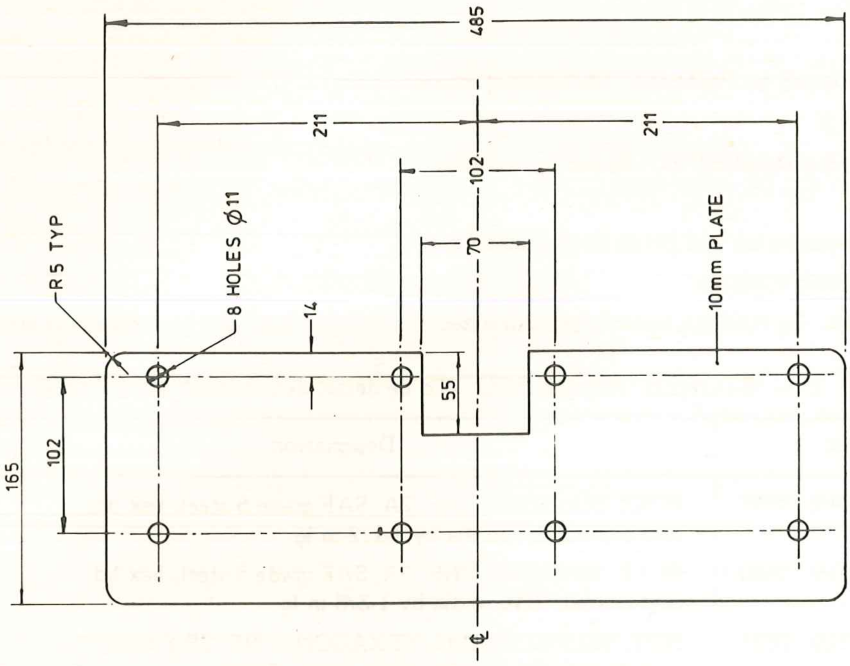
   c. Remove two adjacent mounting bolts from inside a jerry can mounting bracket. Fit the new bolts, nuts and washers, items 2, 4 and 5 from Table 1, plus one of the larger strengthening plates, reworked vide sub-paragraph 8a, as shown in Fig 6. Torque the nuts to 40 Nm.

d. Carry out the same action detailed in sub-paragraph 8c to the remaining mounting bolt inside the jerry can mounting bracket, using one of the smaller strengthening plates reworked vide sub-paragraph 8a.

e. Carry out the actions detailed in sub-paragraphs 8c and 8d to the other jerry can mounting bracket.

f. Paint all new bolt heads black, in accordance with WKSP B 700.

9. **Modification Record Plate.** Deface the numeral 2 on the modification record plate situated on the side of the front passenger seat base, adjacent to the vehicle specification plate.



DIMENSIONS IN MM

FIG 1 – PLATE A

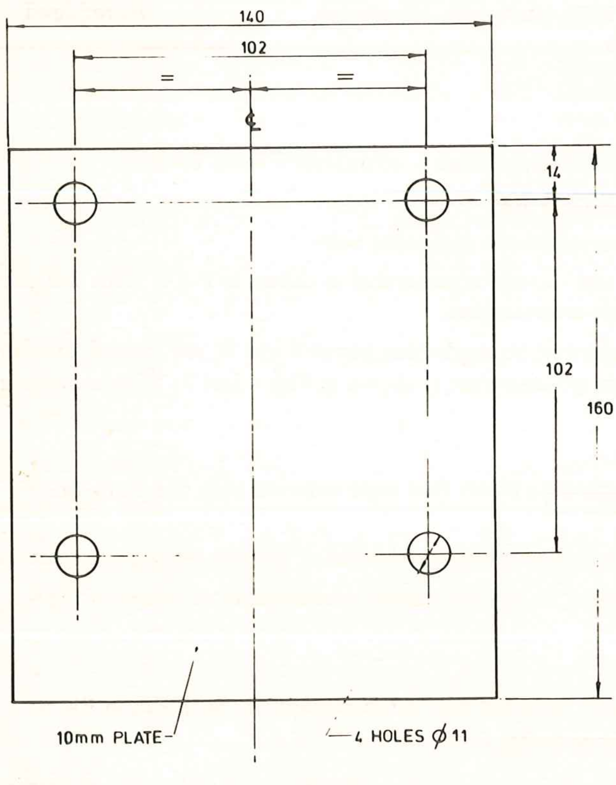


FIG 2 – PLATE B

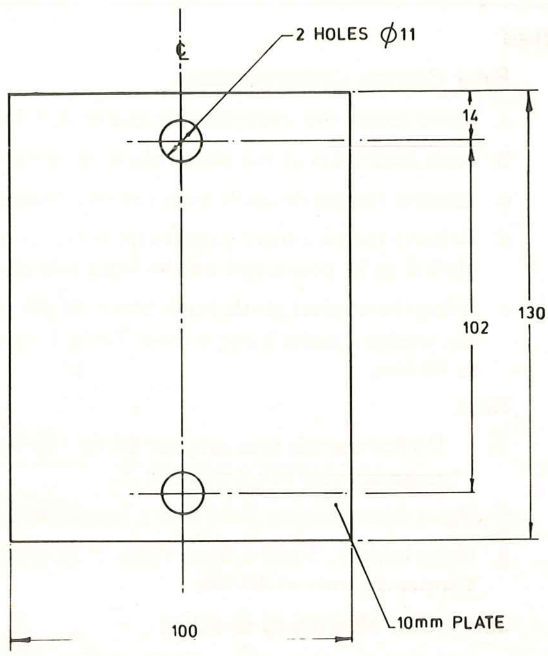


FIG 3 – PLATE C (Quantity 2)

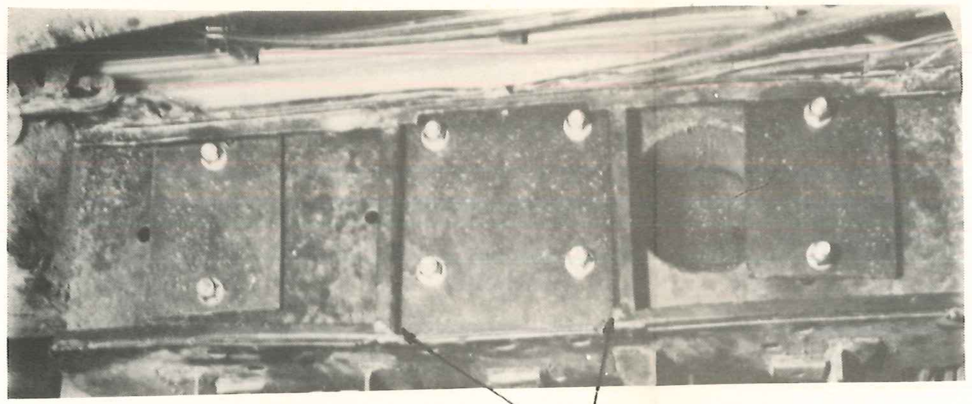


FIG 4 – PLATES B AND C IN POSITION

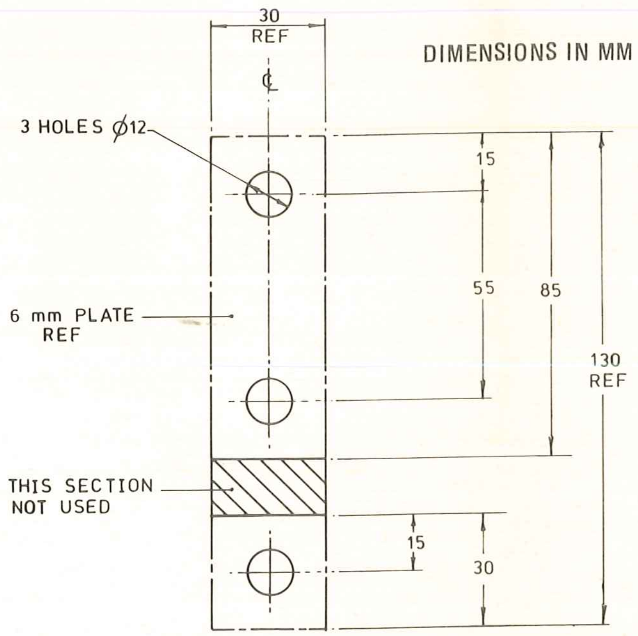


FIG 5 – PINTLE HOOK STRENGTHENING PLATE
TO BE REWORKED

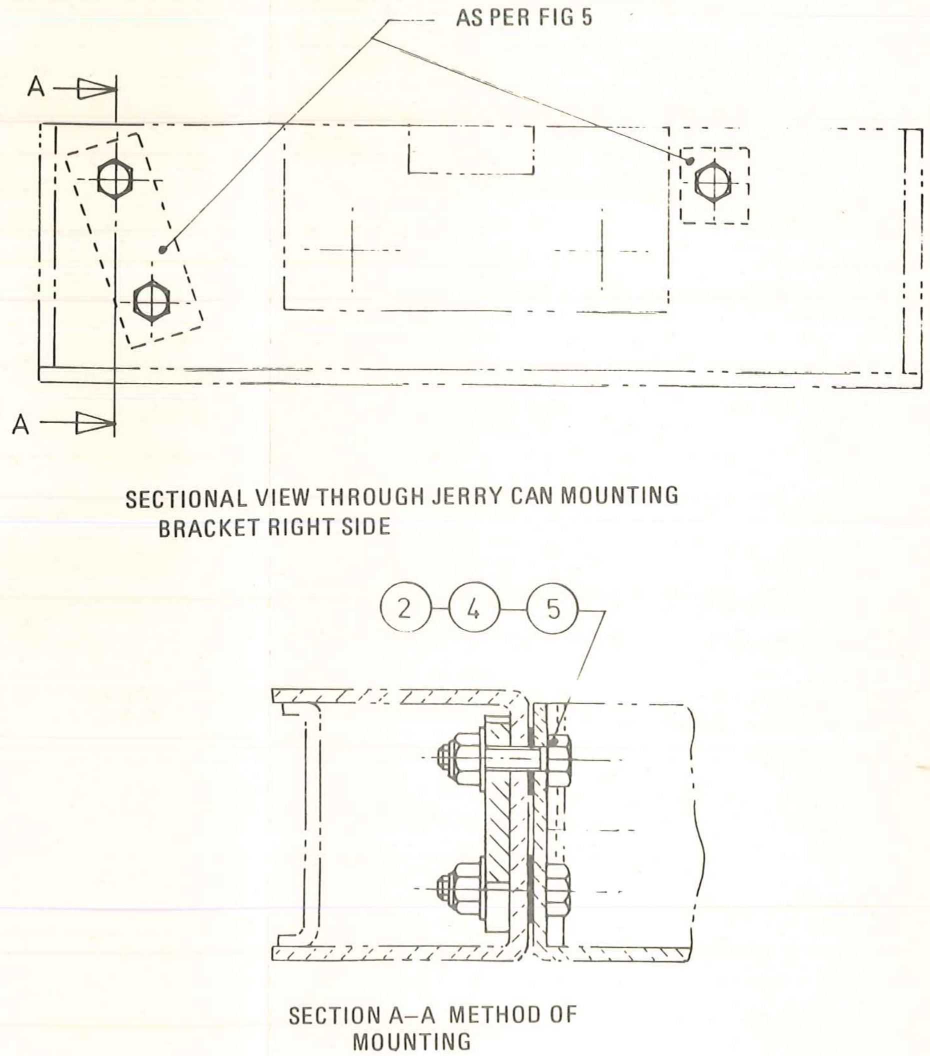


FIG 6 – DETAILS OF JERRY CAN MOUNTING

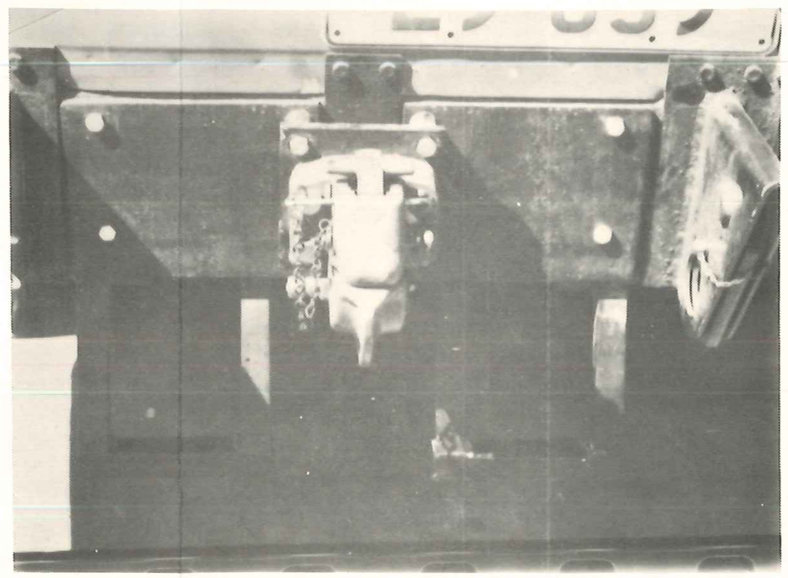


FIG 7 – VIEW OF PLATE A IN POSITION

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