

**TRUCK UTILITY LT GS FFR LANDROVER SERIES 3  
STRENGTHENING OF SPOT WELDED SEAMS – STOWAGE BINS  
MODIFICATION INSTRUCTION**

Issue of this instruction is authorized by the CONMEA

**Introduction**

1. This instruction details the strengthening of the spot welded seams that support the floor of the stowage bins.

**General**

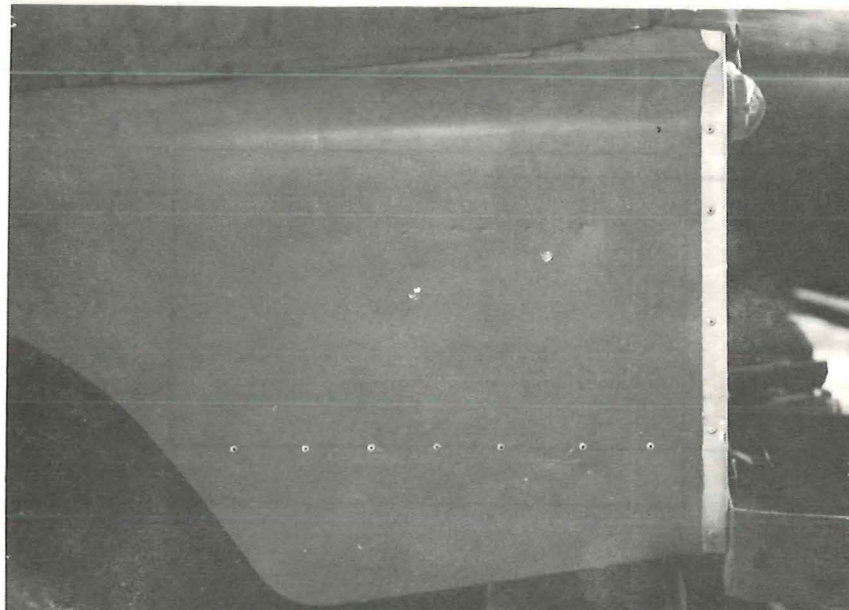
2. **Estimated Manhours to Perform.** 3.0 (initial planning only).
3. **Priority.** Group 2.
  - a. All vehicles on issue to units are to be modified when next in wksp for repair.
  - b. All vehicles held by Supply Units should normally be modified before issue. However, where this would delay priority issues, equipments may be released unmodified providing their record books are endorsed with details of outstanding modifications.
4. **Modification to be Applied to.** All subject vehicles.
5. **Item Affected.** Stowage bins, left and right side.
6. **Action Required.** By workshops and support elements authorized to carry out field and base repair in accordance with WKSP A 850.

**TABLE 1 – STORES REQUIRED** (To be demanded through normal supply channels).

Item	DSN	Designation	Qty per Equip
1.	5320-99-437-4027	RIVET, BLIND, monel, w/break stem mandrel, 3/16 in by 0.240 in	14
2.	5530-66-029-3289	PLYWOOD, exterior, waterproof, 2.440 m lg by 1.220 w by 13 mm thk	As Required

**Detail**

7. Modification procedure is as follows:
  - a. Refer to Fig 1 and drill seven 5 mm diameter holes equally spaced along the spot weld line of the floor of the stowage bin. Do not drill through the spot welds.
  - b. Rivet the drilled panels using item 1 from Table 1.
  - c. Paint the rivet heads in accordance with WKSP B 700.



**FIG 1 – LINE OF RIVETS (UNPAINTED)**

- d. Manufacture two sets of floor boards as shown in Fig 2 using item 2 from Table 1. Prime and paint black in accordance with WKSP B 700.
- e. Fit the boards in the stowage bins.

**Stowage of CES Items**

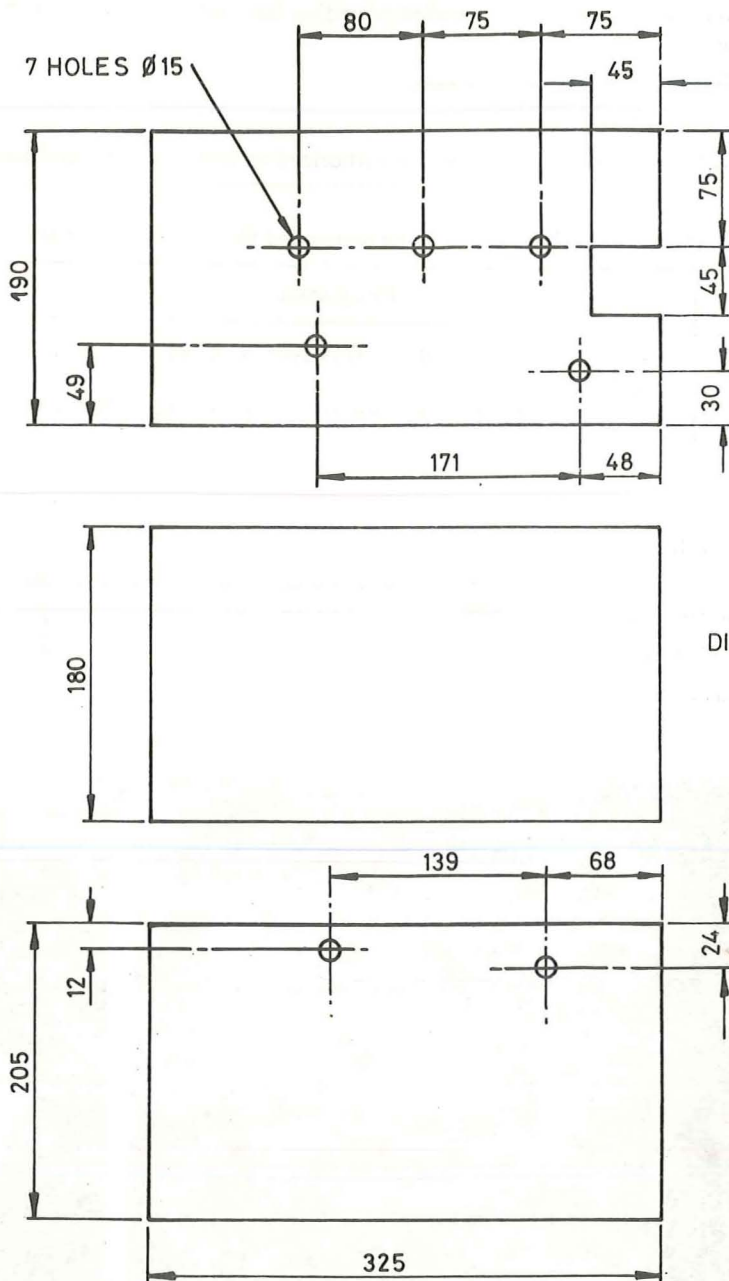
8. CES items are to be stowed in sandbags before being placed in the stowage bins. This action will reduce movement of the CES and thus reduce damage to the body side panels.

**Minor and Major Servicing**

9. Workshops and support elements are to ensure that at each minor and major service the floorboards are removed from the stowage bins. Cleaning of the bins is to be an additional drivers task to those detailed in VEH A 029.

**Modification Record Plate**

10. Deface the numeral 4 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 2 – FLOORBOARD SET**

**E N D**