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INTER-OFFICE MEMO

Date 15th October 1981  
 To B. Walker  
 From R.J. Donnell  
 Subject RHD CONVERSION PROGRAM

Attached is a listing of the TSA/ECR's along with the retrofit listing prepared by Quality Control which you have agreed is the Engineering Specification for the Conversion Program. It is on this Bill of Material that Supply will proceed to provide any additional material to Wooler Hodec for 20 units.

The necessary copies of TSA/ECR's and drawings are to be provided by you for receipt at Wooler Hodec by Monday 19th October.

This memo advises that the number of units to be converted is 20 units and the mix is 16 manuals and 4 automatics.

By copy of this memo the following actions are requested to support the earliest start of this program :-

1. Inspect/select units at Wooler Hodec to pick best bodies for conversion by 23rd October. Identify by VIN number - L. Nelson
2. Material to be identified, picked, despatched. Receipt at Wooler Hodec by 24th October. (Note 20 sets to rear brake calipers to be supplied in addition). - M. Graham
3. Provide introduction VIN numbers where not shown on listing - M. Graham
4. Provide process sheets to cover TSA/ECR's to R.J. Donnell by 21st October. - L. Swannell.

*R. J. Donnell*  
 R. J. Donnell  
 Director of Programming & Distribution

CHUCK. SEWINGTON

STEWART

- c.c. S. Craven  
 C.H.P. Dunn  
 B. Dutton  
 G.A. Lacy  
 M. Graham  
 H. Le Duc  
 L. Nelson  
 C. Pinn  
 B.G. Wills

SARY



# RETROFIT ITEMS R1 DRIVE CONVERSIONS

TSA No	TSA DESCRIPTION	VIN INTRO	PART DESCRIPTION REQD.	PART No
331	CRACK GATE CABLE BRKT STIFFENER	728	BRACKET (MANUALS ONLY)	1026597
420	DELETES WASHERS	778		
414	DIPSTICK AND TUBE	763	DIPSTICK AND TUBE (AUTS)	106771 106770 SP 102630
236	CLIP TO FUEL RETURN PIPE	683	CLIP	106977
2407	COPPER BAND WASHER TO FUEL PUMP	600	COPPER BAND WASHER	106977
448	SPRING CLIP TO FUEL TANK ASSY	840	SPRING CLIP + WASHER (SP 102670)	
155	MODIFIED FUEL RAFFLE + SPRING	1903	RETAINER SPRING (106906) AND RAFFLE	106741
350	LOCKTITE ON REAR HUB NUTS	715	LOCKTITE 270	
CR 2166	SHOCK ABSORBERS (FRONT)		GIRLING PT NO 70056602 SHOCK ABSORBERS	100404 1062
178	WISHBONES	585	WISHBONES WITH PAULSTRA BUSHES	
1036	FRONT SUSPENSION BALL JOINTS	740	BALL JOINTS + GREASE (LOWER)	100407
CR 2107	INCREASE DIA. OF 'D' WASHER		WASHER	101287
343	CASE HARDENING OF 'D' WASHER	343	"	
CA 3015				
1301	NEW RETAINING SPRING TO FAN SWITCH		SPRING CLIP	
CA 2157				
140 175 257 258 387	PROTECTION OF AND CHANGES TO WATER COOLANT RAIL	765	PIPE 106711 PADDING  FROM RUMOR RAD PIPE SP 10299 CABLE TIE	105977 1064 106711  106771 (off) 1064 SP 10449
1292 1206	HANDBRAKE ADJUSTMENT	3436		
515 157	MODIFIED ENGINE HARNESS	930	JUMP HARNESS RELAY DRIVE SCREW SCREW M5X12	1026443 106361 1062 SP 102681 SP 10440
516	DIODE TO COOLING FAN CIRCUIT	700	DIODE POSILOK POSILOK COVER 106771	A75-296 51101597 21152093 22957262



R.H.D. CONVERSION PROGRAMME

T.S.A./E.C.R's TO BE INCORPORATED

1. T.S.A. 154 Pedal Box Fitting Drawing 108182 Issue 5.  
Notes:- Torque for fixing bolts to pedal box 15 N.M. added at item 7 E.C. 2467.  
See attached sketch Process Sheets 26, 27A.
2. T.S.A. Assembly Steering Column Complete 108181 Issue 7.  
Item 10 on above showing torqued to 27.5 Nm as per attached sketch. Process Sheet 37 op 800.
3. T.S.A. 229 Superseded by T.S.A. 415 See item 6.
4. T.S.A. 254 Fuel Pump and Tank Installation 106307.  
Note: Ref: E.C.R. 2540 Process Sheets S/A 34-03 BA.  
Ops 10, 20, & 30.
5. T.S.A. 350 Rear Hub Nuts.  
Superseded by T.S.A. 1041.  
Process Sheets S/A 26-01  
Sheet 6.07  
Ops 144, 146 & 148.
6. T.S.A. 415 Routing - Fuel Feed Pipe Station 9 Sheet 7.  
Ops 180 & 190.
7. T.S.A. 1123 Attachment of Lever Ball Joint.  
Superseded by T.S.A. 1258.  
Ops 23.60, 70, 80, 90  
Plus 2 sketches.
8. T.S.A. 1139 Fuel Pipe - Foul.  
new process sheet Issued
9. T.S.A. 1245 Rear Hub Carrier S/A 26-01.  
Sheet 2.05.
10. T.S.A. 1273 Fuel Hose Assembly.  
Superseded by T.S.A. 1313 S/A 34-02 Sheet 3 T.  
New Banjo fitted to Filter S/A 34-02 Sheet 7 T.



- 2.
11. T.S.A. 1279 Adapter - Road Wheel R.R.  
OP 26. 170.  
26. 180.
  12. T.S.A. 2219 Fuel Return Pipe Upper  
No process sheet required rework.
  13. E.C. 2486 Chassis Harness.  
No process sheet required.
  14. E.C. 3071 Anti Roll Bar Bush Clamp.  
Op 23. 130 T.

Not yet completed by Engineering.  
T.S.A. 1183 is current authority Ops 23. 130.

W MURRAY  
CONSULTANT- PRODUCTION ENGINEERING





# TEMPORARY SUBSTITUTION AUTHORITY

TSA NO. **T 397**  
 SHEET 1 OF 2  
 ISSUE DATE **4/3/81**  
 EFFECTIVE DATE

MODELS AFFECTED  
**12000**

QUANTITY OR TIME REQUESTED  
 UNTIL NEW WATER  
 PIPE SYSTEM IMPLEMENTED

DESCRIPTION OF TSA: THIS TSA SUPERSEDES TSA NO T357 TO ADD TO ALUMINIUM WATER RAILS 10544 + 101943 PROTECTIVE RUBBER PIPE (OFF CUTS) IN ORDER TO STOP ALUMINIUM WATER RAILS WEARING THRU AGAINST ROCKER COVER ON ONE SIDE & UPPER SILENKER MOUNT BRKT ON THE OTHER. USE THE OFF CUTS FROM MODIFIED PRT NO 106031 WHICH ARE APPX 80mm LONG & SLICE THEM ONCE & FIT TO APES AS PER SKETCH THEN WRAP TWO OFF CABLE TIE CLIPS (SP 10399) PER HOSE AND CUT OFF CLIP TAIL END. POSITION AT SIDE OF APE & CLIP HEADS OUT OF SIGHT WHERE POSSIBLE. **RETROFIT TO ALL CARS**

- TSA EFFECTS IN
- BU
  - SERVICE
  - QUALITY
  - PERFORMANCE
  - APPEARANCE
  - INTER-CHANGEABILITY
  - COST
  - EMISSIONS

NEW OR MODIFIED PARTS			SUPERSEDED PART			DOS		
PART NO	ISS	QTY	PART NO	ISS	QTY	DESCRIPTION	MODEL APPLIC	DOS

DOS  
 O = Use elsewhere  
 R = Rework  
 U = Use S = Scrap

SAFETY CRITICAL  
 OK *[Signature]*

REQUESTED BY  
 NAME **J. ROUTER** DEPT. **LOTUS ENG** TEL. **3337**

TSA COST  
 PIECE PART  
 RE-WORK  
 OTHER  
 CHARGE COST TO:

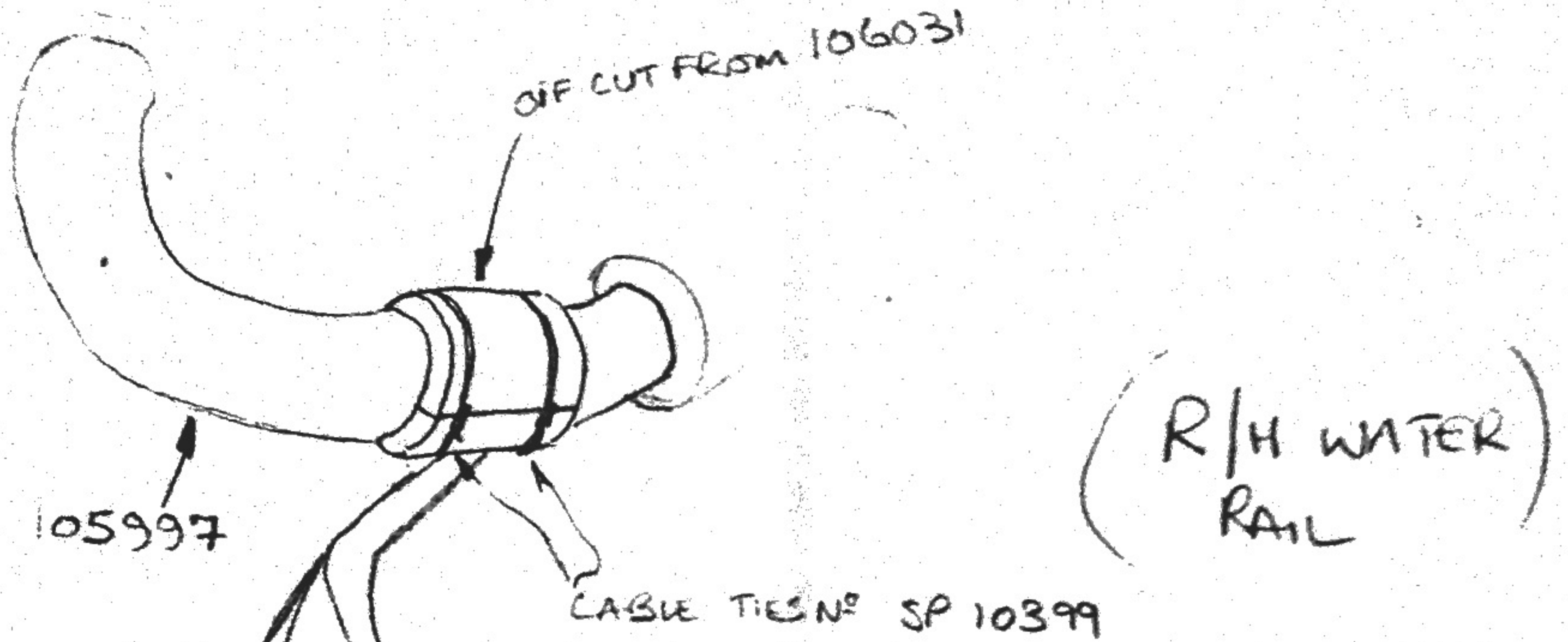
APPROVAL SIGNATURES

Res. Eng	Finance	Quality Control	Production Control	Service Parts	Prod. Eng	Purchase
<i>[Signature]</i>						

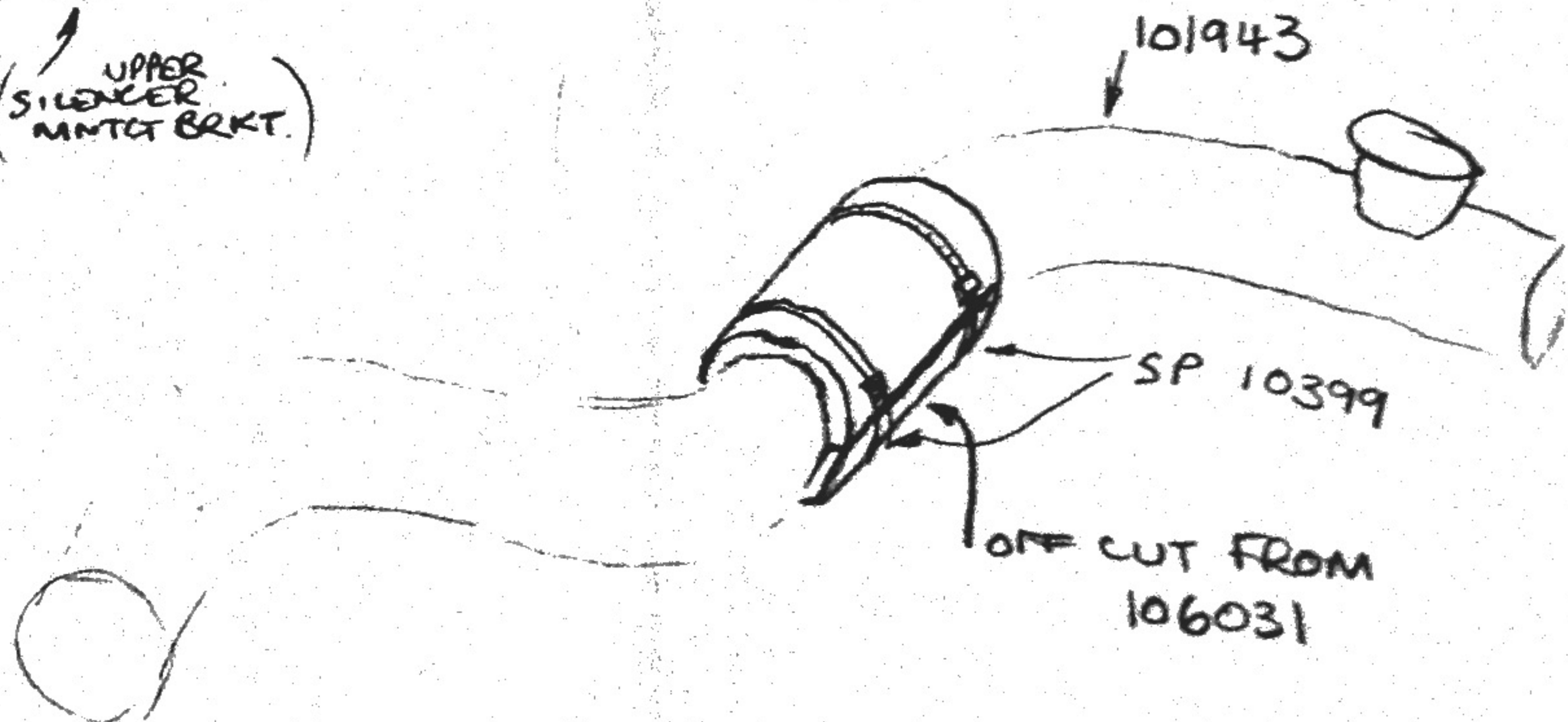
REJECTION OR INSTRUCTIONS FOR INCORPORATING TSA.

RELEVANT CTR'S  
 RELEVANT ECR'S  
**ECR TO BE RAISED FOR NEW WATER PIPE SYSTEM**





UPPER  
SILENCER  
MOUNT BRKT.



(L/H WATER RAIL)