

**TRUCK, CARRYALL, LIGHTWEIGHT, PERSONNEL CARRIER, MC2 —  
LAND ROVER 110**

**LIGHT GRADE REPAIR**

This instruction is authorised for use by command of the Chief of Army. It provides direction, mandatory controls and procedures for the operation, maintenance and support of equipment. Personnel are to carry out any action required by this instruction in accordance with EMEI General A 001.

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## **INTRODUCTION**

1. This EMEI contains procedures for removing, dismantling, repairing, assembling and installing various components of the Truck, Carryall, Lightweight, Personnel Carrier. Where applicable, instructions for the adjustment, lubrication and minor servicing of these items are included.



**Do not use adhesive tapes to seal fuel or oil openings. The adhesive tape is soluble in fuel or oil and can cause contamination. Remove temporary covers before assembling.**

2. Prevent dirt and foreign objects from entering any component by placing clean temporary coverings over all exposed openings, including hoses, tubes and lines.



**Before removing any electrical system components, disconnect the battery leads.**

3. When disconnecting electrical connectors, hoses and fittings, remove clamps as required, to gain slack and avoid damage to connectors and fittings.

4. Discard all used gaskets, seals, cotter pins, tab washers, lock pins, key washers and lock washers. Discard all contaminated fuel and lubricants drained from the truck.

5. Use only those fuels and lubricants specified in the Servicing Instruction, EMEI Vehicle G 109, the User Handbook and this EMEI when replenishing fuel or lubricants.

6. Any fastenings or fittings being tightened to prescribed torques are to have dry, clean threads unless otherwise specified. When specified, thread sealants are to be applied to dry, clean, oil free threads.

7. The engine cooling system contains Nalcool corrosion inhibitor in water at a ratio of 1:12.



**Precautions should be taken prior to carrying out repairs which include painting, sanding, scraping or welding. Refer to EMEI Workshop D 701 – Repair Policy for Equipment Painted in Polyurethane Paint.**

8. This vehicle is painted in polyurethane paint.

### **Associated Publications**

9. Reference may be necessary to the latest issue of the following documents:

- a. Defence Road Traffic Instructions;
- b. Complete Equipment Schedules (CES):
  - (1) SCES 12043, and
  - (2) Equipment Kit SCES 12036.
- c. Block Scale 2406/31 – Special Tools for RAEME- B Vehicles – Truck, Utility and Trucks, Light, MC2 (Land Rover Model 110);
- d. EMEI Vehicle A 029 – Vehicles General – Servicing of B Vehicles, Trailers, Motorcycles, Stationary Equipment, Auxillary and Small Engines;
- e. EMEI Vehicle A 291-5 – General Service B Vehicles Tyre Guide – Operating Instructions;
- f. EMEI Vehicle G 008-1 – Truck, Lightweight, MC2, All Types – Inspection of Towing Pintle Assembly;

- g. EMEI Vehicle G 103 – Truck, Utility, Lightweight , MC2, Land Rover 110 and Truck, Utility, Lightweight , W/Winch, MC2, Land Rover 110 – Light Grade Repair;
- h. EMEI Vehicle G 109 – Truck, Lightweight, MC2, Land Rover 110 4X4, All Types – Servicing Instruction;
- i. EMEI Vehicle G 150 – Truck, Carryall, Lightweight, Personnel Carrier, MC2, Land Rover 110 – Data Summary;
- j. EMEI Vehicle G 152 – Truck, Carryall, Lightweight, Personnel Carrier, MC2, Land Rover 110 – Technical Description;
- k. EMEI Vehicle G 154-1 – Truck, Carryall, Lightweight, Personnel Carrier, MC2, Land Rover 110 – Medium and Heavy Grade Repair;
- l. EMEI Workshop D 701 – Repair Policy for Equipment Painted in Polyurethane Paint; and
- m. RPS 02195.

**WARNING**

All industrial safety, work practices and equipment operating and maintenance instructions pertaining to this EMEI are to be adhered to.

The handling, storage and use of chemical substances are to be in accordance with MOHS, MSDS and EMEI Workshop series requirements.

**Location of Identification Numbers**

- 10. The location of identification numbers on components of the vehicle are described in Table 1.

**Table 1 Location of Identification Numbers**

Serial	Identification Number	Location
1	Chassis number	Right hand side of the chassis, forward of the spring mounting turret
2	Chassis nameplate	Left hand seat box, in the cab
3	Engine number	Left hand side of the engine block
4	Injection pump identification	Side of the pump
5	Transmission and transfer case	Rear of the transfer case
6	Front axle number	Adjacent to the axle breather
7	Rear axle number	Adjacent to the axle breather

**NOTE**

NSN and Manufacturers part numbers and designations used in this EMEI were current at the date of issue. If twelve months or more have expired since issue, the NSN and Manufacturers part number should be checked for supersession.

**List of Lubricants**

- 11. A list of lubricants used with the vehicle is detailed in Table 2.

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**Table 2 List of Lubricants**

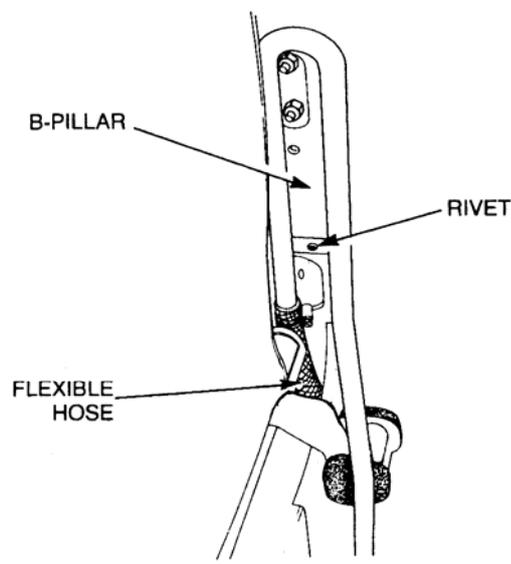
Serial	Equipment	Lubricant	Capacity (litres)
1	Engine (including filter)	OMD-115	8.5
2	Transmission	OMD-115	2.7
4	Transfer case (with PTO)	OMD-115	5.8
5	Front differential	OEP-220	1.7
6	Rear differential	OEP-220	2.3
7	Swivel pin housings	Molytex Grease	EP00 Sachet
8	Brake master cylinder	OX (Aust) 8	Fill to level
9	Clutch master cylinder	OX (Aust) 8	Fill to level
10	Steering box	OEP-220	0.45
11	Wheel bearings	XG-274	As required
12	Radiator inhibitor	Nalcool	As required (1:12 ratio)
13	Clutch pedal trunnion	XG-274	As required
14	Speedometer cable	XG-274	As required
15	Propeller shaft	XG-274	As required
16	Parking brake adjuster	XG-274	As required
17	Windscreen wiper drive cable	XG-274	As required

**FUEL – GROUP 4**

**Fuel Tank Breather Pipe**

**12. Removal.** Remove the fuel tank breather pipe as follows:

- a. Using a suitable drill, remove the rivet securing the breather pipe to the B pillar (refer Figure 1).



**Figure 1 Fuel Tank Breather Pipe Removal**

- b. Slacken the hose clamp securing the flexible hose to the breather pipe.
- c. Withdraw the pipe.

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13. **Installation.** Fit the breather pipe as follows:
- Fit the breather pipe in the flexible hose.
  - Align the mounting hole and secure the breather pipe with a new rivet.
  - Tighten the hose clamp securely.

### Fuel Tank

14. **Removal.** Remove the fuel tank as follows:

#### NOTE

When fuel lines / pipes are disconnected they must be plugged to prevent the ingress of dirt.

- Clean the areas around the fuel pipes and blow dry with compressed air.
- Remove the hexagonal head drain plug from the fuel tank (refer Figure 2).
- Drain the fuel into a suitable container.
- Place a suitable support under the fuel tank.
- Remove the driver's side rubber mat and floor panel.
- Remove the bolt securing the front of the fuel tank to chassis bracket.
- Loosen the bolts securing the fuel tank mounting bracket to the chassis.
- Move the bracket clear of the fuel tank.
- Loosen the hose clamp securing the breather pipe to the tank.
- Remove the hose from the fuel tank.
- Tag and remove the supply and return hoses from the tank sender unit and pick up pipe.
- Loosen the hose clamp securing the filler pipe to the tank.
- Remove the hose from the fuel tank.
- Disconnect the wiring harness from the tank sender unit.
- Remove the bolts securing the tank to the rear chassis bracket.
- Lower the tank from under the vehicle, carefully withdrawing the filler hose through the mounting brackets.

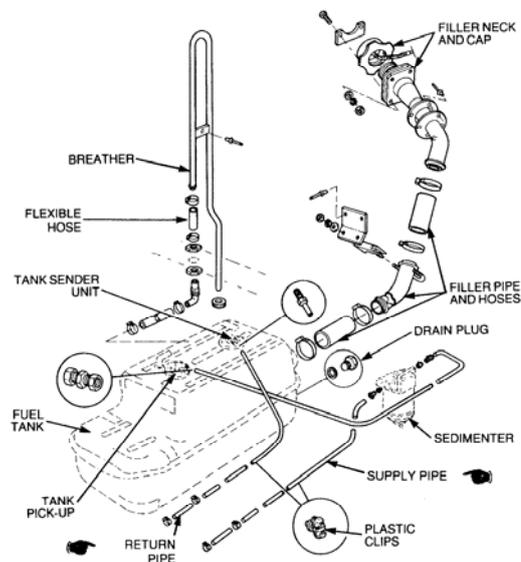


Figure 2 Fuel Tank Exploded View

- 15. Installation.** Install the fuel tank as follows:
- a. Raise the fuel tank into position.
  - b. Install the tank front mounting bracket, the mounting bolts, nuts and new lock washers and tighten securely.
  - c. Install the supply and return fuel hoses onto the tank sender unit and pick up pipe and tighten the connectors securely.
  - d. Install the filler pipe and breather pipe hoses and tighten the hose clamps securely.
  - e. Install the bolts securing the tank to the rear chassis bracket and tighten securely.
  - f. Reconnect the wiring harness to the tank sender unit.
  - g. Install the driver's side rubber mat and floor panel.
  - h. Ensure the drain plug is tight and refill the fuel tank with clean fuel.
  - i. Bleed the fuel system as detailed in EMEI Vehicle G 103 – Group 4.

**FRAME – GROUP 16**

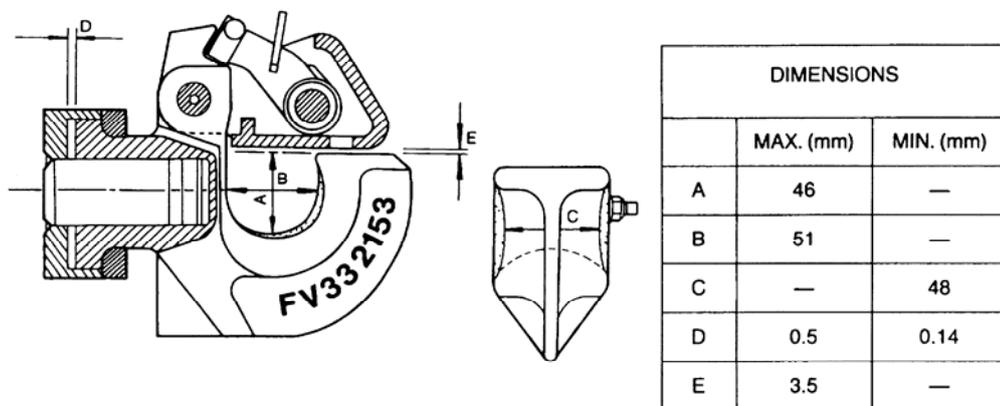
**Towing Pintle**

- 16. Replacement.** Replace the towing pintle as follows:
- a. Support the weight of the towing pintle.
  - b. Remove and discard the nuts, washers and bolts securing the towing pintle to the rear crossmember.
  - c. Remove the towing pintle.
  - d. Position the towing pintle on the rear crossmember.
  - e. Install the new bolts, washers and nuts.
  - f. Torque to 61 Nm (44 lb.ft).

**WARNING**

The wear limits shown in Figure 3 are only to be used in conjunction with tow coupling Part No. FV332153. For the wear limits of all other towing pintles refer to EMEI Vehicle G 008-1.

- 17. Cleaning and Inspection.** Clean all parts in a suitable cleaning agent and inspect for excessive wear. Replace worn parts as necessary.



**Figure 3 Tow Pintle Wear Limits**

## BODY – GROUP 17

### Central Passenger Seat

18. **Removal.** Remove the central passenger seat as follows:
- Remove the bolts, washers and nuts retaining the lower section of the seat hinges to the body floor.
  - Release the seat locking mechanism.
  - Remove the seat assembly.
19. **Installation.** Install the central passenger seat as follows:
- Position the seat assembly in the vehicle and align the bolt holes.
  - Install the bolts, washers and nuts that retain the seat hinges and tighten securely.

### Rear Inward Facing Seats (Left or Right)

20. **Removal.** Remove the rear inward facing seats as follows:
- Remove the bolts, washers and nuts retaining the seat base to the wheel arch (refer Figure 4).
  - Slide the seat base towards the centre of the vehicle, until the upper locating dowels on the frame are clear of the upper body capping.
  - Remove the seat.

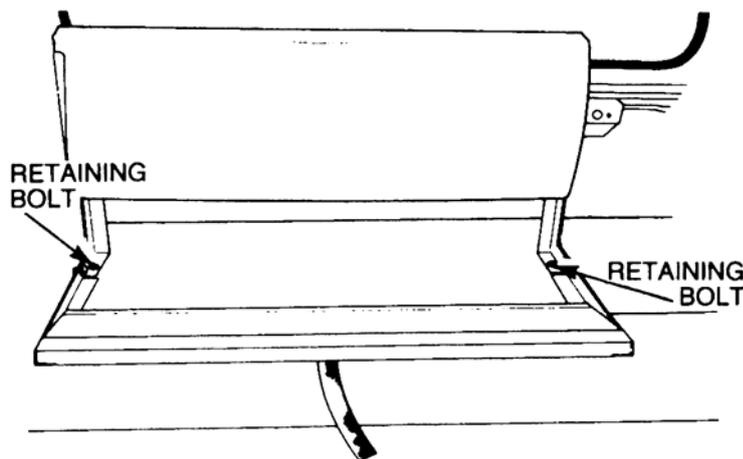


Figure 4 Left Side Rear Inward Facing Seat Removal

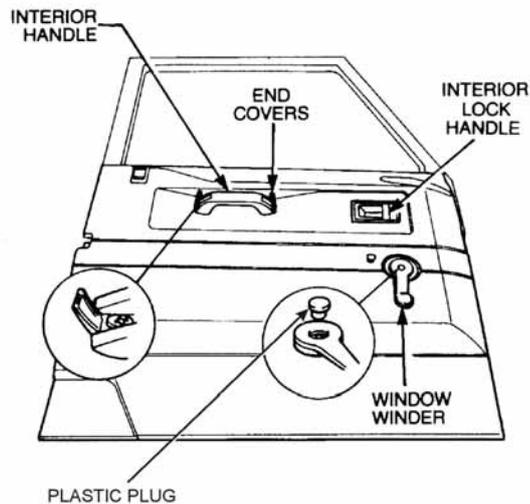
21. **Installation.** Install the rear inward facing seat as follows:
- Position the seat base so that the locating dowels are engaged in the upper body capping.
  - Slide the seat towards the outside until the holes align with the securing holes in the wheel arch.
  - Install the bolts, washers and nuts.
  - Tighten the nuts securely.

### Front Door

22. **Removal.** Remove the front door as follows:
- Remove the split pin and clevis pin securing the door check link.
  - Support the door and remove the lock nuts, special plastic washers and bolts that secure the door to the A post.
  - Remove the door.
  - Place the door on a clean workbench with a soft protective covering to prevent damage to the door surface.

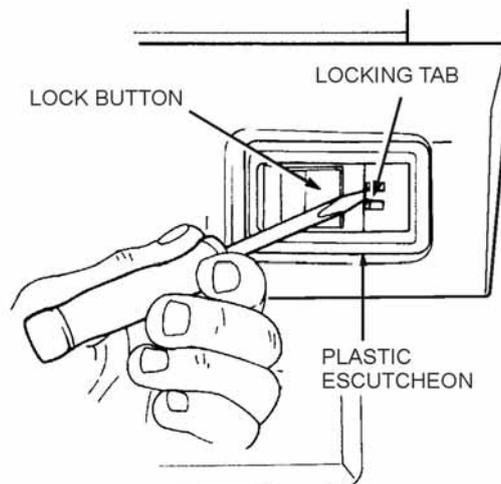
23. **Disassembly.** Disassemble the front door as follows:

- a. Prise the plastic cover (refer Figure 5) from the window winder handle.



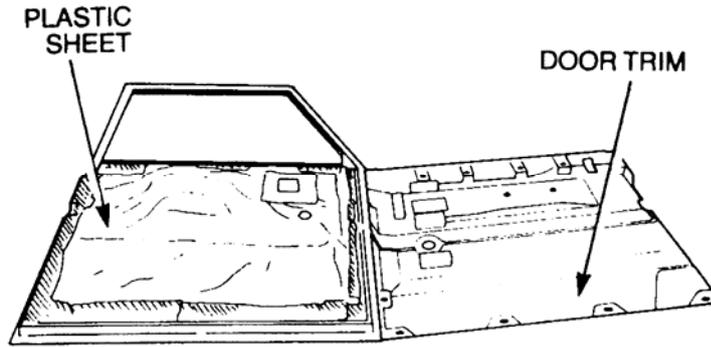
**Figure 5 Window Winder Handle Removal**

- b. Remove the securing screw.  
c. Remove the handle.  
d. Using a small screwdriver, prise the end covers from the interior handle (refer Figure 5).  
e. Remove the screws.  
f. Remove the handle from the door.  
g. Remove the plastic escutcheon from the lock button by depressing the locking tab with a small screwdriver (refer Figure 6).



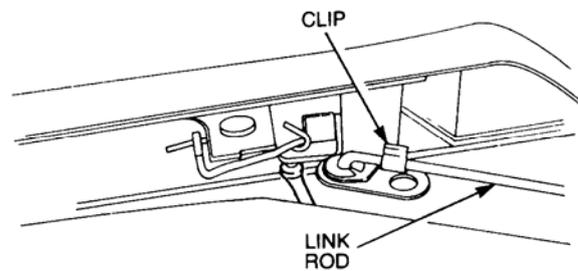
**Figure 6 Door Lock Button Escutcheon Removal**

- h. Remove the screws securing the interior lock handle bezel.  
i. Remove the bezel.  
j. Carefully prise the plastic trim fasteners from around the edge of the door trim, removing the corner fasteners first.  
k. Remove the trim (refer Figure 7).



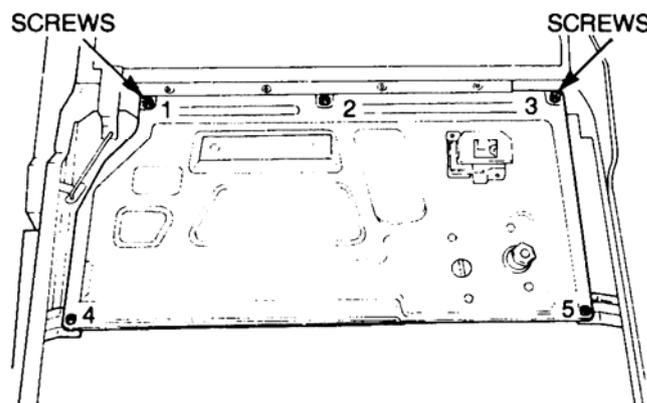
**Figure 7 Door Trim Removal**

- l. Remove the adhesive tape and plastic sheet from the door.
- m. Temporarily fit the window winder handle to allow the window to be lowered approximately half way.
- n. Disconnect the clip securing the lock handle rod to the door lock (refer Figure 8).
- o. Remove the screws securing the door lock to the door frame.



**Figure 8 Door Lock Handle Link Rod Removal**

- p. Raise the lock sufficiently to allow the link rod to be disconnected from the lock.
- q. Remove the screws securing the inner panel (refer Figure 9).



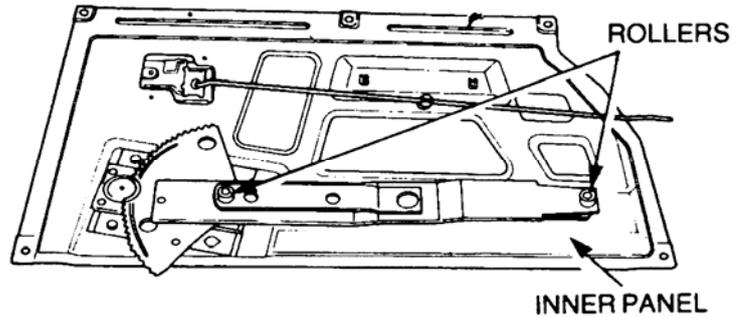
**Figure 9 Door Inner Panel Removal**

**NOTE**

It may be necessary to remove the screws and washers securing the interior lock handle and window regulator prior to removal of the inner panel.

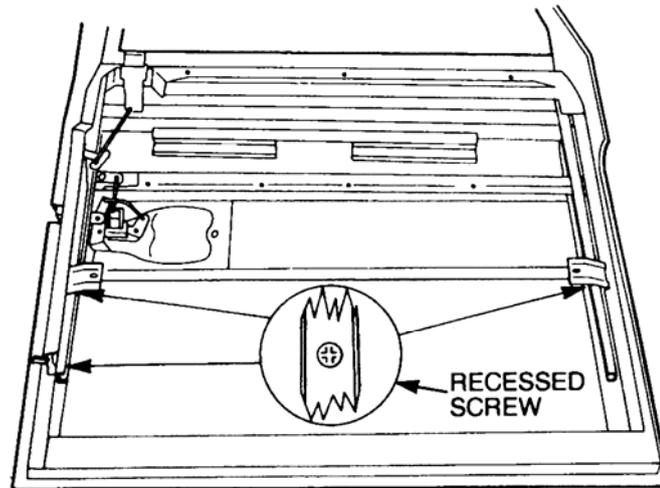
- r. Slide the inner panel down to disengage it from the door frame.
- s. Slide the panel towards the front edge of the door to disengage the regulator rollers from the window lift channel.
- t. Remove the inner panel from the door (refer Figure 10).

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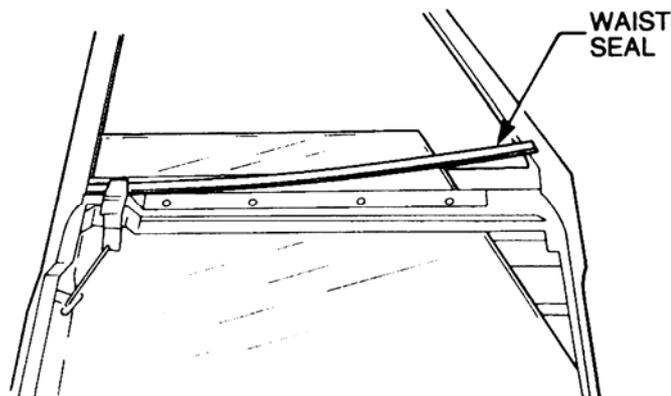
**Figure 10 Window Regulator Roller Location**

- u. Remove the recessed screws securing the lower end of the rear window channel (refer Figure 11).



**Figure 11 Window Channel Lower End Detachment**

- v. Remove the screw securing the front channel.
- w. Remove the inner and outer waist seals (refer Figure 12).



**Figure 12 Window Glass Removal**

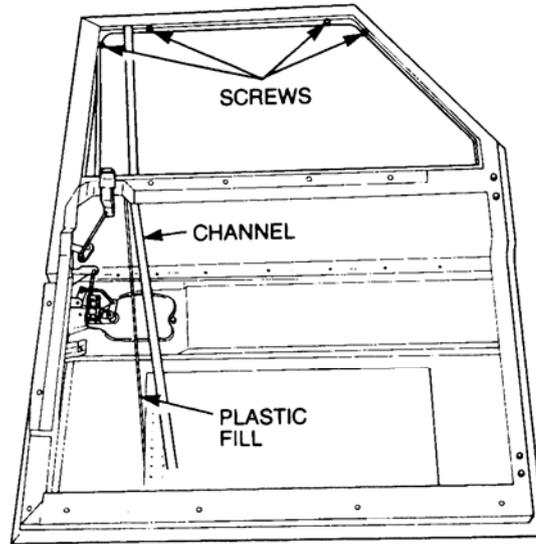
- x. Slide the window down to the bottom of the door.
- y. Lift the lower edge of the window to clear the door frame and slide the window from the channels.

**NOTE**

It may be necessary to bend back the two lower inner panel mounting brackets to allow the window to clear the door frame.

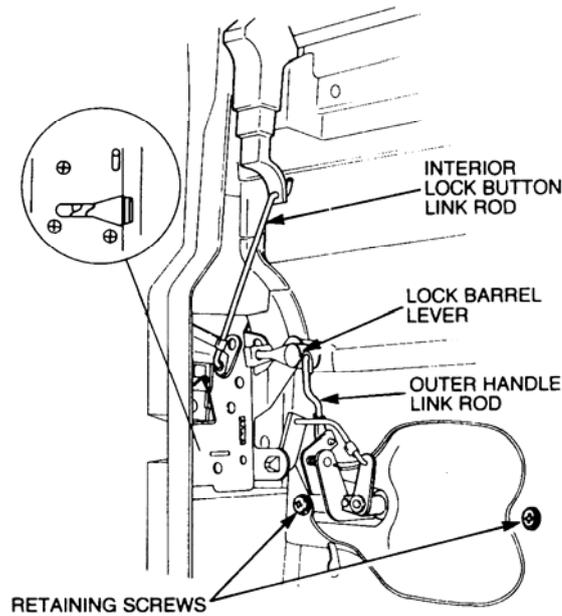
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- z. Remove the recessed screws securing the window channels (refer Figure 13).
- aa. Remove the channels, spacers and plastic fill channels.



**Figure 13 Window Channel Removal**

- bb. Disconnect the outer handle link rod from the lock assembly (refer Figure 14).



**Figure 14 Door Lock Removal**

- cc. Disconnect the interior lock button link rod from the lock assembly.
- dd. Remove the countersunk screws securing the door lock to the door.
- ee. Remove the lock.
- ff. Remove the recessed screws securing the outer door handle to the door (refer Figure 14).
- gg. Remove the handle and plastic seals.
- hh. Remove the screws securing the lock barrel lever to the lock barrel (refer Figure 15).
- ii. Remove the shouldered spacer, lever, spacer washer and sleeve.
- jj. Remove the insert and barrel.

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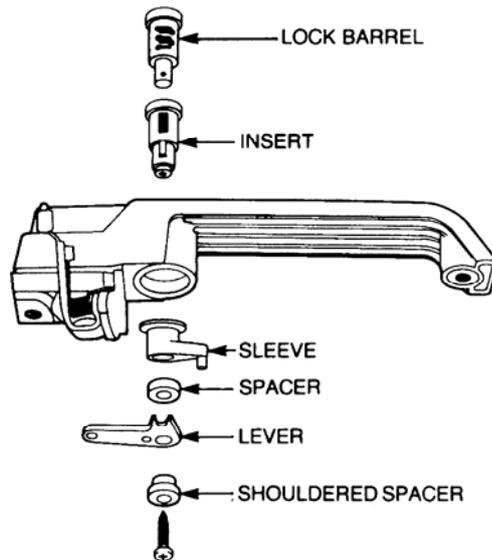


Figure 15 Lock Barrel Removal

- kk. Press the locking pin on the barrel (refer Figure 16).

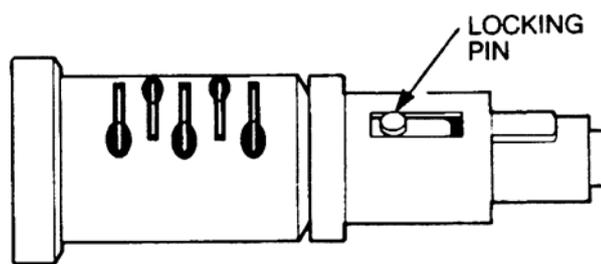


Figure 16 Lock Barrel Insert Removal

- ll. Remove the insert.
- mm. Remove the nuts, screws and nylon washers securing the door hinges to the door frame.
- nn. Remove the hinges.

24. **Reassembly.** Reassemble the front door as follows:

- a. Position the hinges on the door frame, then install the bolts.
- b. Fit the special plastic washers with the taper towards the door frame and install the lock nuts.
- c. Tighten the lock nuts securely.
- d. Fit the lock barrel into the insert.

**NOTE**

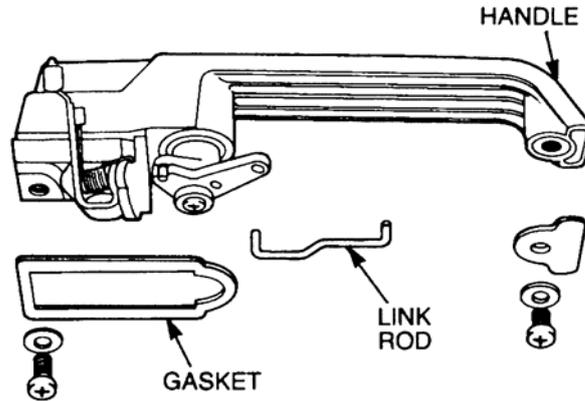
Ensure that the locking pin is correctly positioned as shown in Figure 16.

- e. Install the barrel and insert into the handle.
- f. Fit the sleeve, spacer washer, lever and shouldered washer, ensuring that the letter L or R stamped on the lever is installed away from the handle.

**NOTE**

The lock barrel lever is marked with an L or R to correspond with the left or right side door handles.

- g. Position the new plastic gaskets (refer Figure 17) on the door handle.



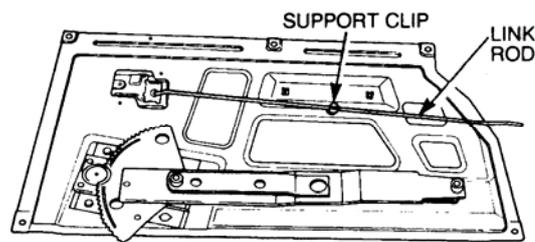
**Figure 17 Door Handle Gaskets Installation**

- h. Fit the handle to the door.
- i. Secure the handle with the screws and washers.
- j. Install the door lock assembly into the door frame and loosely fit the screws.
- k. Connect the link rods (refer Figure 14).
- l. Install the plastic fill channels and corner pieces on the door frame.
- m. Fit the window channels and spacers.
- n. Secure the channels with the recessed screws, except the two screws fitted to the bottom of the rear vertical channel (refer Figure 11).
- o. Insert the window glass into the channels and carefully slide the glass to the top of the door.

**NOTE**

Ensure that the glass slides freely.

- p. Secure the bottom of the vertical channels.
- q. Install the window regulator and interior lock handle on the inner panel and secure with the screws.
- r. Press the link rod into the plastic support clip (refer Figure 18).



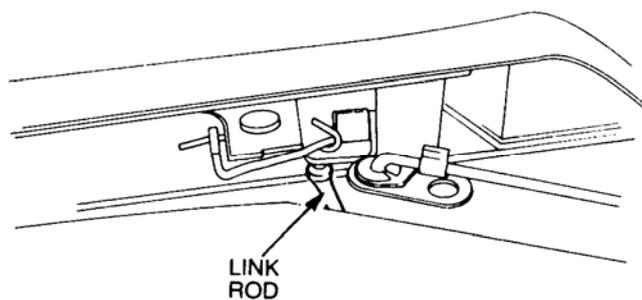
**Figure 18 Window Regulator Installation**

- s. Fit the inner panel into the door frame.

**NOTE**

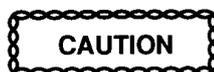
Ensure the regulator rollers engage in the window lift channel.

- t. Connect the interior lock link rod to the lock assembly (refer Figure 19).
- u. Secure the inner panel to the door with the screws and tighten the screws retaining the door lock assembly.



**Figure 19 Door Lock Handle Link Rod Connection**

- v. Lightly smear a suitable grease into the window lift channel.
- w. Install the plastic sheet onto the door, using new adhesive tape as required.
- x. Position the door trim on the door.
- y. Secure with the plastic trim fasteners.
- z. Install the interior lock handle trim and secure the screw.



**Do not over tighten the screw.**

- aa. Fit the lock button plastic escutcheon (refer Figure 6).
- bb. Install the window winder and escutcheon and secure with the screw.
- cc. Press in the plastic cover.
- dd. Fit the grab handle and secure with the screws.
- ee. Clip the end covers into place.

**25. Installation.** Install the front door as follows:

- a. Support the door and position the hinges.
- b. Install the bolts.
- c. Fit the special plastic washers towards the door frame and install the lock nuts.
- d. Tighten the lock nuts securely.
- e. Ensure that the door lock aligns with the striker plate and, if necessary, slacken the bolts that secure the hinges to the A post, then retighten.
- f. Instal the check link into the firewall bracket.
- g. Insert the clevis pin and flat washer.
- h. Secure the clevis pin with a new split pin.

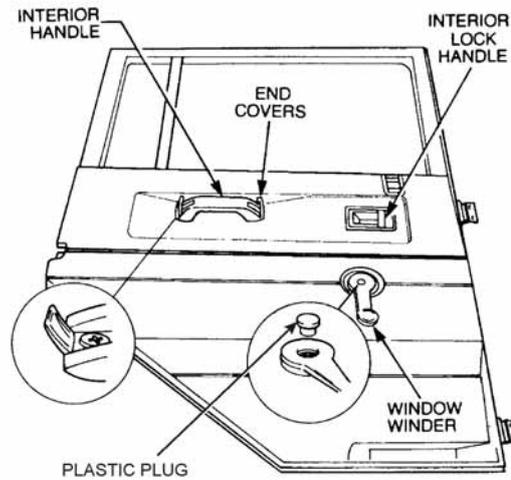
**Rear Side Door**

**26. Removal.** Remove the rear side door as follows:

- a. Remove the lock nut securing the door check link.
- b. Support the door and remove the lock nuts that secure the door to the B pillar.
- c. Remove the special plastic washers and bolts.
- d. Remove the door.
- e. Place the door on a clean workbench with a soft protective covering to prevent damage to the door surface.

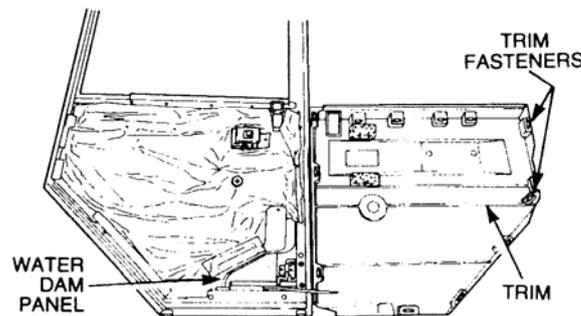
27. **Disassembly.** Disassemble the rear side door as follows:

- a. Prise the plastic cover (refer Figure 20) from the window winder handle.



**Figure 20 Window Winder Handle Removal**

- b. Remove the securing screw.
- c. Remove the handle.
- d. Using a small screwdriver, prise the end covers from the interior handle (refer Figure 20).
- e. Remove the screws.
- f. Remove the handle from the door.
- g. Remove the plastic escutcheon from the lock button by depressing the locking tab with a small screwdriver (refer Figure 6).
- h. Remove the screws securing the interior lock handle bezel (refer Figure 20).
- i. Remove the bezel.
- j. Carefully prise the plastic trim fasteners from around the edge of the door trim.
- k. Remove the trim (refer Figure 21).

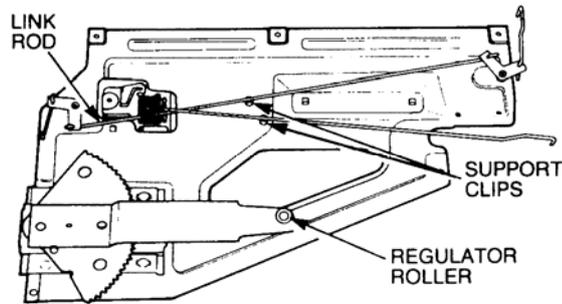


**Figure 21 Rear Side Door Trim Removal**

- l. Remove the screws and washers securing the water dam panel to the door frame.
- m. Remove the panel.
- n. Remove the adhesive tape and plastic sheet from the door.
- o. Temporarily fit the window winder handle to allow the window to be lowered approximately half way.
- p. Disconnect the clips and link rods from the interior door lock button.

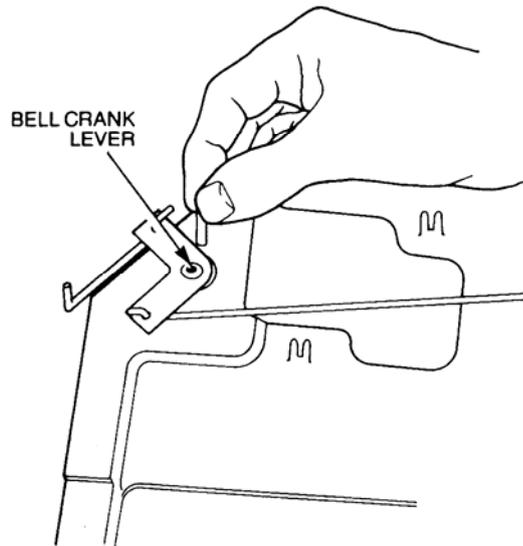
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- q.** Disconnect the lock button link at the lock assembly.
- r.** Disconnect the interior lock release link rod at the lock.
- s.** Remove the hexagonal head screws securing the inner panel.
- t.** Slide the panel towards the lock assembly to disengage the window regulator roller.
- u.** Remove the panel (refer Figure 22).



**Figure 22 Rear Side Door Inner Panel Removal**

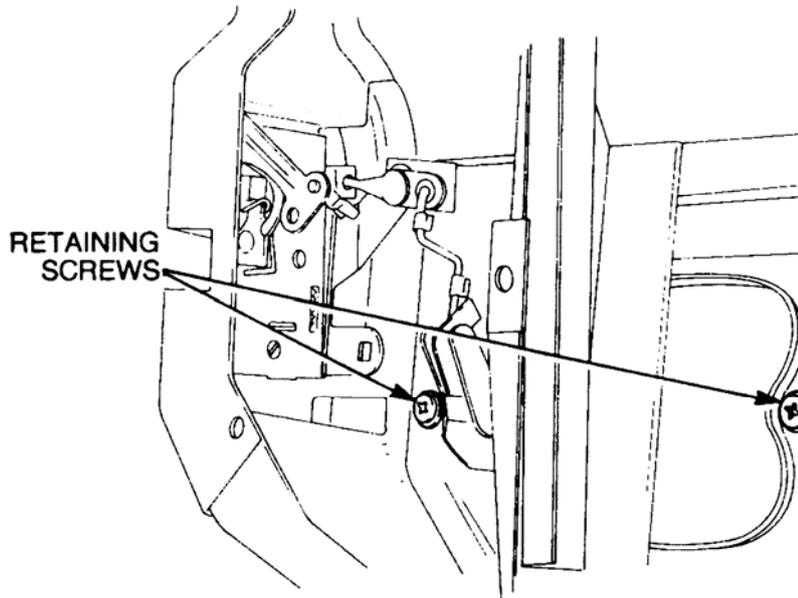
- v.** Remove the screws and washers securing the regulator assembly to the panel.
- w.** Remove the regulator.
- x.** Remove the pins from the centre of the bell crank lever pivots (refer Figure 23).



**Figure 23 Link Rod Bell Crank Pivot Removal**

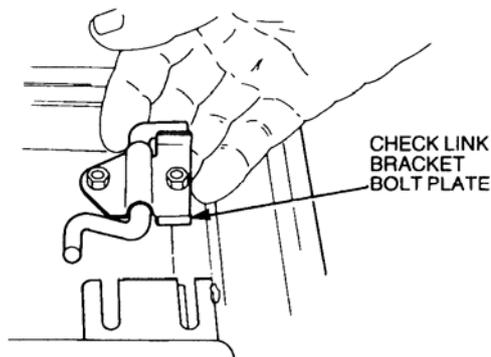
- y.** Remove the bell cranks and link rod.
- z.** Remove the screws securing the interior lock handle.
- aa.** Remove the handle.
- bb.** Disconnect the outer handle link rod from the handle.
- cc.** Remove the countersunk screws securing the lock assembly to the door (refer Figure 24).
- dd.** Remove the lock.

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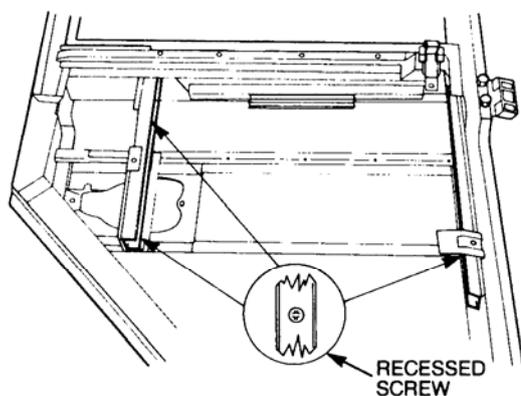
**Figure 24 Rear Side Door Lock Removal**

- ee. Remove the screws securing the outer door handle to the door.
- ff. Remove the handle and gaskets.
- gg. Loosen the nuts securing the door check link to the door (refer Figure 25).



**Figure 25 Check Link Bracket Removal**

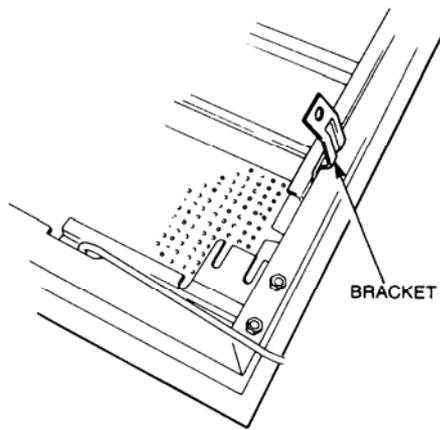
- hh. Remove the bracket and bolt plate as an assembly.
- ii. Remove the recessed screws securing the lower ends of the window channels to the door frame (refer Figure 26).



**Figure 26 Window Channel Screws Removal**

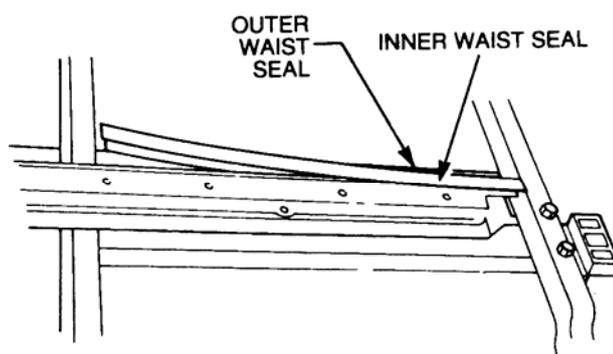
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- jj.** Using suitable pliers, bend the stop tab retaining the check link.
- kk.** Remove the link.
- ll.** Carefully bend back the bracket at the lower end of the forward channel (refer Figure 27).
- mm.** Lift the lower edge of the glass.



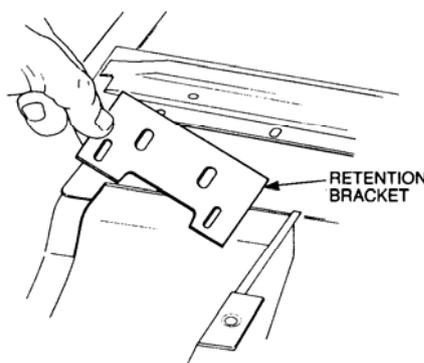
**Figure 27 Window Glass Removal**

- nn.** Slide the window down and out of the channels.
- oo.** Remove the inner and outer waist seals from the door flanges (refer Figure 28).



**Figure 28 Window Waist Seals Removal**

- pp.** Slide the rear channel from the division channel.
- qq.** Remove the screw securing the top of the division channel to the top of the door frame.
- rr.** Remove the channel and spacers.
- ss.** Remove the nuts, washers and screws securing the quarter window retention bracket to the frame (refer Figure 29).



**Figure 29 Quarter Window Retaining Bracket**

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- tt. Remove the bracket.
- uu. Pull the forward channel from the glass (refer Figure 30).

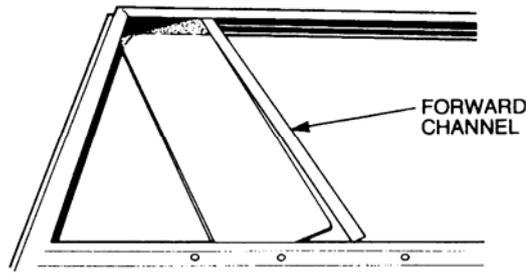


Figure 30 Quarter Window Glass Removal

- vv. Remove the glass.
- ww. Remove the screws securing the top and rear quarter window channels to the frame.
- xx. Remove the channels.
- yy. Remove the screws securing the top and forward window channels to the frame.
- zz. Remove the channels, plastic filler strips, spacer and corner piece.
- aaa. Remove the screws and washers securing the interior door lock button to the door frame (refer Figure 31).
- bbb. Remove the assembly.

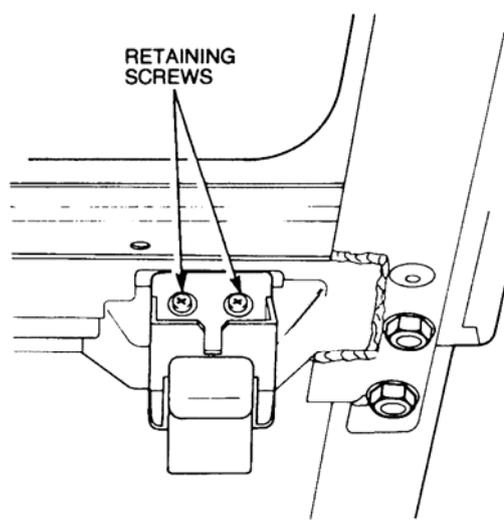


Figure 31 Interior Door Lock Button Removal

28. **Reassembly.** Reassemble the rear side door as follows:
- a. Install the interior door lock button and secure with the screws and washers (refer Figure 31).
  - b. Install the top, rear and forward plastic fill channels and two corner pieces on the door frame.
  - c. Install the quarter window channel with the open end uppermost.
  - d. Secure the rear channel to the frame with the screws.
  - e. Install the top quarter window channel and carefully slide the glass into place.
  - f. Push the forward channel onto the glass.
  - g. Fit the quarter division channel.

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**NOTE**

Ensure that it is correctly located on the window channel and in the slot provided in the top of the door frame.

- h.** Secure the top of the channel with the screw.
- i.** Install the quarter window retaining bracket (refer Figure 29).

**NOTE**

Ensure that the bracket is pushed hard against the window lower channel.

- j.** Fit the screws, new lock washers and nuts, then tighten securely.
- k.** Fit the forward and top window channels together with the shims.
- l.** Install the upper screws and tighten securely.
- m.** Install the rear window channel into the division channel.

**NOTE**

Ensure that the channel is pushed fully into the top of the door frame.

- n.** Position the window glass into the window channels, then raise the glass to the top of the door.
- o.** Align the lower channel mounting holes in the frame and secure with the screws (refer Figure 26).
- p.** Install the door check link into the slide and bend back the stop tab.
- q.** Bend the inner panel mounting (refer Figure 27) back into position.
- r.** Install the inner and outer waist rail seals on the door flanges (refer Figure 28).
- s.** Fit the new rubber gaskets to the door handle and install the handle on the door.
- t.** Install the screws.

**NOTE**

Ensure that the longest screw is fitted towards the front of the handle.

- u.** Install the door lock assembly in the door frame (refer Figure 24).
- v.** Secure with the countersunk screws.
- w.** Connect the link rod to the outer door handle and secure with the clip.
- x.** Position the window regulator on the inner panel and secure with the screws and washers.
- y.** Fit the internal door handle and link rod to the door frame.
- z.** Insert the screws and tighten securely.
- aa.** Press the link rod into the support clip (refer Figure 22).
- bb.** Install the bell crank levers and link rods onto the inner panel.
- cc.** Press the securing pins into the pivots and press the intermediate link rod into the upper support clip.
- dd.** Position the inner panel on the door frame and ensure that the window regulator roller engages in the window lift channels.
- ee.** Fit the top screws and the lower rear screw and washer, then tighten securely.
- ff.** Install the door check link torsion bar and bracket assembly (refer Figure 25).
- gg.** Tighten the nuts securely.
- hh.** Fit the water dam panel (refer Figure 21) and secure with the screw and washer.
- ii.** Fit the hexagonal head screw and washer that secures the dam to the inner panel.
- jj.** Lightly smear a suitable grease into the window lift channel.

- kk. Install the plastic sheet onto the door using new adhesive tape as required.
- ll. Position the door trim on the door, then secure with the plastic fasteners.
- mm. Install the interior lock handle trim and secure with the screw.



**Do not over tighten the screw.**

- nn. Install the window winder handle and escutcheon and secure with the screw.
- oo. Press in the plastic cover.
- pp. Fit the grab handle and secure with the screws.
- qq. Clip the end covers into place.

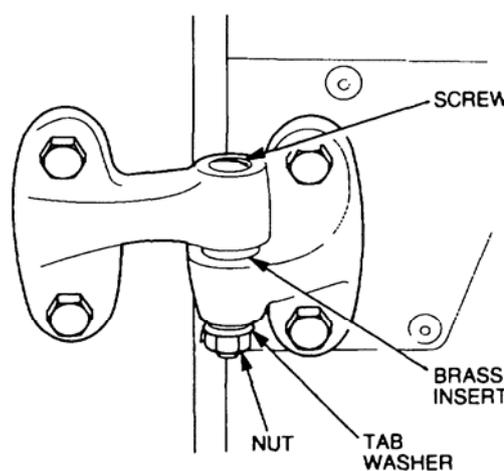
**29. Installation.** Install the rear side door as follows:

- a. Support the door and position the hinges.
- b. Install the bolts.
- c. Fit the special plastic washers towards the door frame and install the lock nuts.
- d. Tighten the lock nuts securely.
- e. Ensure that the door lock aligns with the striker plate and, if necessary, slacken the bolts that secure the hinges to the B pillar, then retighten.
- f. Instal the check link into the bracket and secure with a new lock nut.

**Rear Door**

**30. Removal.** Remove the rear door as follows:

- a. Remove the split pin securing the door check link clevis pin to the bracket.
- b. Remove the washer and pin.
- c. Disconnect the number plate lamp wiring at the connectors.
- d. Support the door and remove the screws, tabs washers and nuts securing the hinge valves together (refer Figure 32).
- e. Lift the door off the hinge halves.
- f. Remove the brass inserts.



**Figure 32 Rear Door Removal**

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31. **Installation.** Install the rear door as follows:
- Position the brass inserts on the hinges.
  - Fit the door.
  - Install the screws, tab washers and nuts (refer Figure 32).
  - Tighten the nuts sufficiently to remove all slack.
  - Secure with the lock tab.

### Rear Door Glass

32. **Removal.** Remove the rear door glass as follows:
- Open the rear door.
  - Remove the screws securing the lower glass retainer to the door frame.
  - Remove the retainer (refer Figure 33).

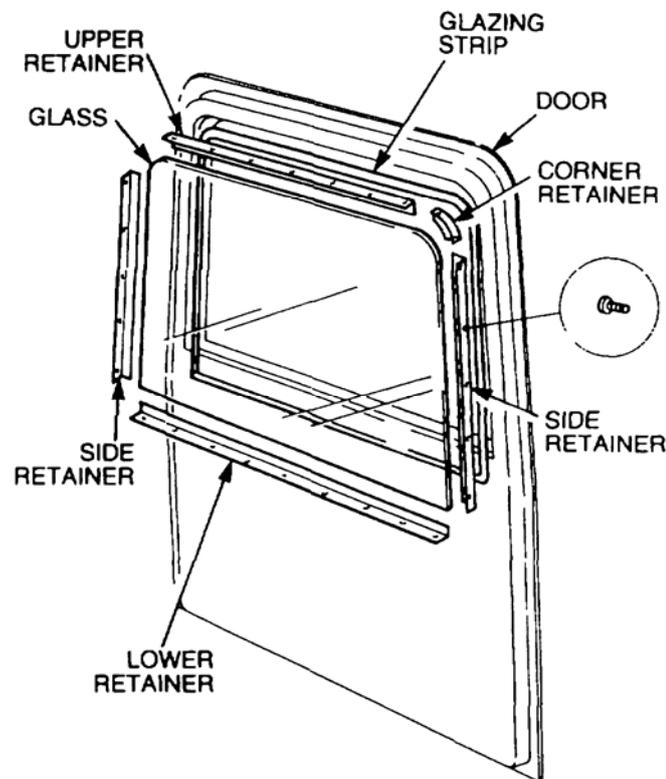


Figure 33 Rear Door Glass Removal

- Remove the screws securing each of the two side glass retainers to the door.
- Remove the two side glass retainers.
- Remove the screws securing each of the upper corner retainers to the door.
- Remove the upper corner retainers.
- Remove the screws securing the upper glass retainers to the door.
- Remove the upper glass retainers.
- Remove the glazing strip from around the inside of the window.
- Carefully push the glass inwards from the window aperture.
- Remove all traces of sealant used around the glass retainers and door.

33. **Installation.** Install the rear door glass as follows:
- Apply a thin bead of sealant around the window aperture.
  - Fit the glass.
  - Install a new glazing strip (refer Figure 33) on the inside of the window.
  - Fit all the retainers.
  - Tighten all the retaining screws securely.
  - Trim off any excess sealant.

#### Rear Side Window

34. **Replacement.** Replace the rear side window as follows:
- Remove the rubber filler strip from the groove in the glazing rubber (refer Figure 34) to expose the rivets.

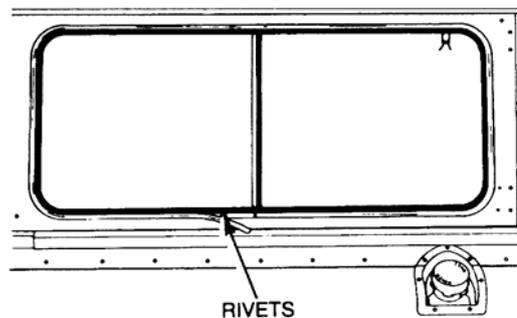


Figure 34 Filler Strip Removal

- Using a suitable drill, remove the rivets securing the window to the body side.
- Remove the window assembly.
- Remove the rubber filler strip from the inside groove at the front of the window frame (refer Figure 35).

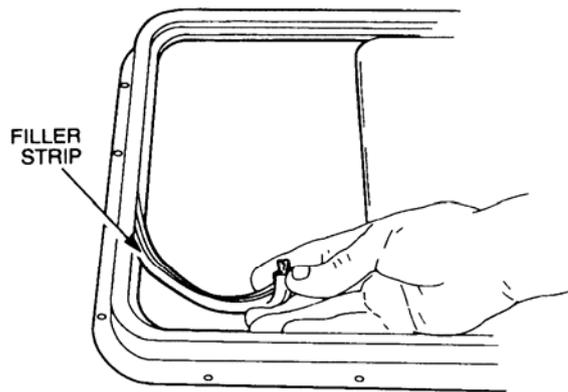
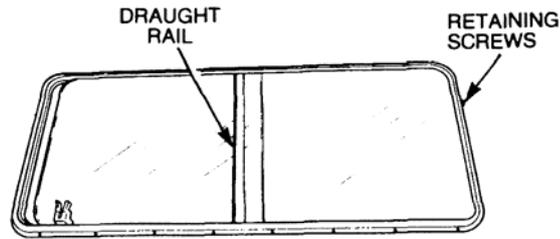


Figure 35 Forward Filler Strip Removal

- Remove the recessed screws securing the upper and lower halves of the window frame together (refer Figure 36).

#### NOTE

Two of the recessed screws retain the draught rail to the window frame.

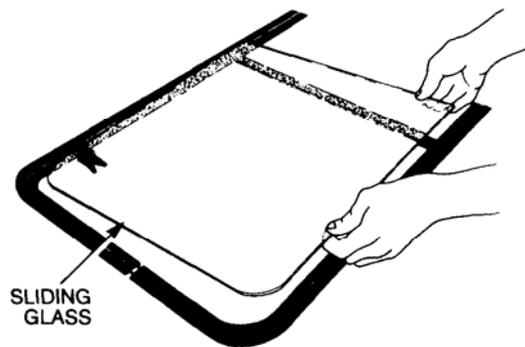


**Figure 36 Window Frame Halves Removal**

**NOTE**

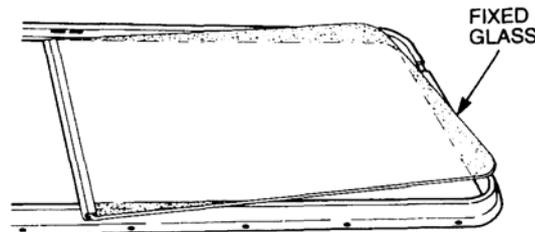
Do not pull the frame completely apart at this stage as damage to the felt channel could result.

- f. Carefully pull the frame halves apart sufficiently to allow the glass to be removed (refer Figure 37).



**Figure 37 Sliding Glass Removal**

- g. Remove the sliding glass.
- h. Carefully remove the fixed glass and draught rail from the glazing rubber (refer Figure 38).



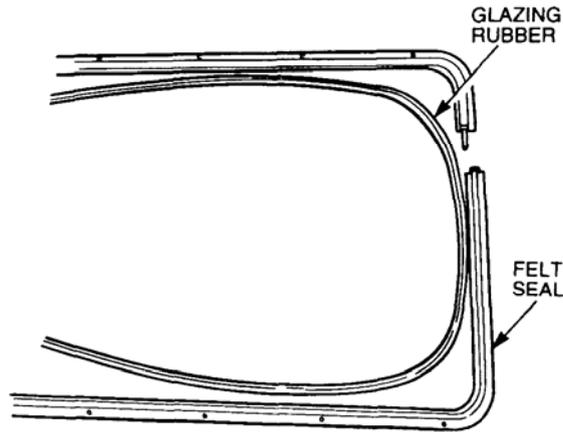
**Figure 38 Fixed Glass Removal**

- i. Remove the glazing rubber from the frame.
- j. If necessary, remove the felt seals (refer Figure 39).

**NOTE**

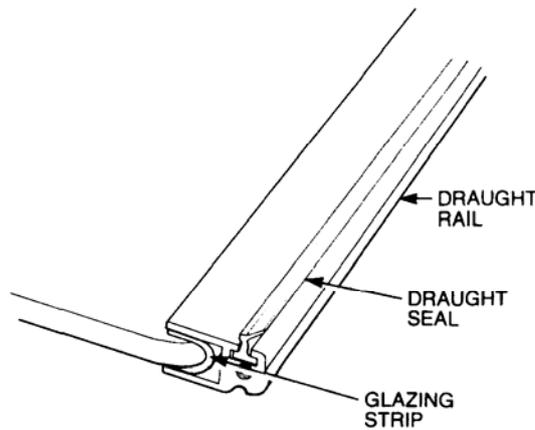
Do not remove the felt channel unless it is to be replaced as damage to the seal could result.

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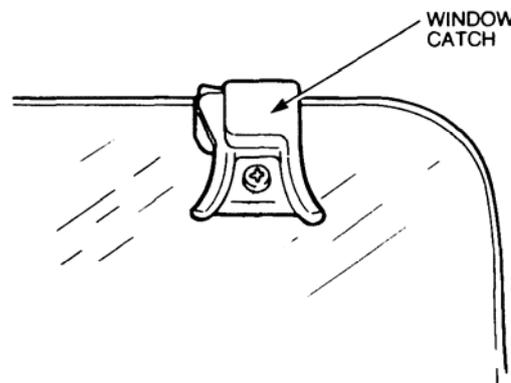
**Figure 39 Glazing Rubber Removal**

- k. Remove the draught rail seal by pulling it out of the groove (refer Figure 40).



**Figure 40 Draught Rail Removal**

- l. Carefully tap the draught rail off the glass.
- m. Discard the glazing strip.
- n. Remove the screw securing the window catch to the sliding window (refer Figure 41).
- o. Remove the catch.

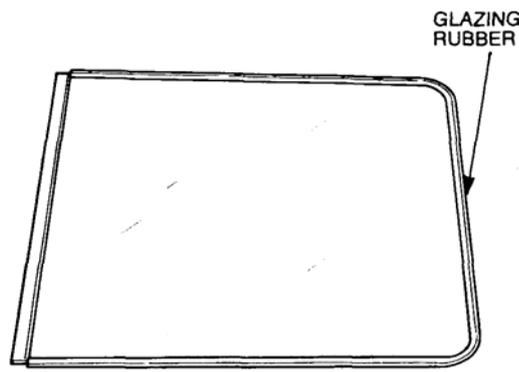


**Figure 41 Window Catch Removal**

- p. Apply a small amount of sealant around the catch mounting hole in the sliding window.
- q. Fit the catch.
- r. Secure with the screw.

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- s. Fit a new glazing strip on the sliding window.
- t. Apply a soapy solution to the glass.
- u. Using a soft-faced hammer, tap the rail fully onto the strip and glass.
- v. Trim off any excess strip.
- w. Lubricate the draught rail seal with the soapy solution and fit the draught seal (refer Figure 40).
- x. Apply a soapy solution to the outside edge of the fixed window glass and position the glazing rubber around the glass.
- y. Locate the rubber around the glass, ensuring that the glass is located in the groove (refer Figure 42).



**Figure 42 Fixed Window Rubber Installation**

- z. Fit the sliding and fixed window glass into the frame.

**NOTE**

Ensure that the windows are in their respective channels and the fixed glass has the draught rail seal facing the sliding glass.

- aa. Push the fixed window and seal into the channel as far as possible.
- bb. Install the screws to secure the two halves of the window frame together.
- cc. Apply pressure on the fixed glass and carefully ease the seal into the channel.
- dd. Using a small screwdriver, ensure that the seal is correctly located.
- ee. Check that the sliding glass moves freely and seats correctly in the felt channel when fully cleared.
- ff. Tighten the screws securely (refer Figure 36).
- gg. Fit the filler strip to the outer channel at the sliding glass end of the frame (refer Figure 35).
- hh. Remove all traces of sealant from the window frame aperture on the vehicle.
- ii. Install the new frame seal on the outside of the quarter panel.
- jj. Position the window frame in the body aperture and secure with rivets (refer Figure 34).
- kk. Install the frame filler strip.

**END**

Distribution List: **VEH G 16.4 – Code 2** (Maint Level)  
(Sponsor: LV SPO, Light B Vehicles)  
(Authority: TRAMM)