

**ALL THE PARTS YOU NEED**



**TRIUMPH**  
**TR2 - TR3/3A**  
**TR4/4A - TR5**  
**TR250**  
**1953 - 1968**  
**PARTS & ACCESSORIES CATALOGUE**



**EDITION 2.1**  
SOURCE CODE TR2512



# THE RIMMER BROS SERVICE

WE HAVE THE  
PARTS

WE GUARANTEE  
THE QUALITY

WE'RE KEEN  
ON PRICE

WE DELIVER  
FAST

WE KNOW YOUR  
CAR



**RIMMER  
BROS**



## HELPING YOU CARE FOR YOUR TR2-5

The first-ever TR, the TR2, went on sale in 1953, and evolved steadily over the next two decades. At first, Standard-Triumph can have had no idea how successful and well-loved the TR would become. By the end of 1968, when the TR5/TR250 models gave way to the re-styled TR6, nearly 164,000 cars of all types had been made. Few components had been carried over in that period - for in that time there were two generations of chassis, two different styles, two different engines, and two different transmissions.

As ever with Triumph, though they were almost all built in Coventry (a few CKD cars were assembled in South Africa and Australia), the vast majority of all these cars were exported, mainly to North America, and this is where most surviving machines live to this day.

For today's TR enthusiasts, it is important to know that the TR3B, and TR250 types were originally only sold in North America, as was the beam rear axle version of the TR4A. On the other hand, the 150bhp Lucas-injected TR5 was never sold in North America, who had their own less-powerful version of this car, the TR250, instead.

Except for the advanced new Lucas fuel injection system on the TR5, these cars were all sturdy, and simple to maintain. Restoration and maintenance is straightforward.

With this catalogue, we aim to help keep your task of maintaining TRs as easy as possible, not only with an unbeatable spare parts stock, but with affordable prices, swift and efficient service.

## BRITISH MOTOR HERITAGE

Heritage Approval means that Rimmer Bros meet strict criteria regarding quality of service, product knowledge, financial stability, premises and that they carry a broad range of Heritage Original Equipment parts in stock.

Only the premier companies in the classic sector are approved to display the accreditation sign. Rimmer Bros have been Heritage approved for Triumph & Rover SD1 since 1987.



BRITISH MOTOR  
HERITAGE APPROVED

### Customer Benefits

The quality of service you receive is of the highest order and you know you are dealing with the best companies in the classic sector.

British Motor Heritage parts are produced to the highest standards, mostly from the original tooling and to the original specification.

All British Motor Heritage parts are identified by a distinctive product label.



## THE CARS WE SPECIALISE IN

As well as caring for your TR2-5, we also sell parts for TR6, TR7/8, Stag, Spitfire, GT6, Herald, Vitesse, 2000/2500/2.5Pi, Dolomite, Rover SD1, Range Rover, Discovery, Freelander, Defender, 90/110 & Land Rover 'Series' vehicles.

Additionally, we also supply parts for MG Rover cars - Rover 100/200/400/600/800/25/45/75, Mini, MGZR/ZS/ZT & MGF/TF.

Please refer to inside rear cover for details on all our catalogues.



# UK - WORLDWIDE





## SO WHERE DO WE GET OUR PARTS

Wherever possible we supply original stock from Triumph sources - lots of parts are still manufactured. Where this fails, we sometimes have parts re-manufactured. We have Heritage approval to do this, because we have satisfied them as to our quality control standards, and we use original tooling and factory drawings where these are available. Where original parts are unavailable and the cost of re-manufacture is prohibitive, we may supply a suitable alternative or in certain cases offer reconditioned or a used (non safety critical) part.



## THE PEOPLE YOU'RE DEALING WITH

This company really is owned by two brothers named Rimmer. Bill and Graham started their business from humble beginnings in the early 1980s, and it has grown to be one of the leading organisations of its kind in the world, supplying parts Worldwide to an ever growing list of customers.

Both Bill and Graham still work full-time in the business, helped now by over 60 members of staff.

The main qualification of membership of our staff is a recognition that our customers, and our company reputation, depend on our ability to get every aspect of our service right first time.

## THE STOCK WE NEED TO GIVE THE SERVICE YOU NEED

**Our degree of specialisation means two things.**

Firstly, our people know the cars we're dealing with inside and out, and can give you any advice you might need regarding part selection.

Secondly, we are able to stock in depth just about any part you might need. Triumph House was acquired in 1991. With over 75,000 square feet of warehousing alone, it is a cavernous building, and it needs to be! It currently contains more than 525,000 recorded part numbers with over 35,000 stock lines, and we hold as many of each as necessary to make it almost impossible to run out of stock.

All other aspects of our operation receive equal emphasis. A truly efficient mail order and stock control system. The latest racking and storage facilities for fast and accurate "order picking." Careful packaging and despatch procedures.



**RIMMER  
BROS**

# COMMITMENT TO CUSTOMER SERVICE

**Helpful - Accurate -  
Fast - Efficient**

**The overall objective at Rimmer Bros is to achieve customer satisfaction at all times.**

Our people know your car well, and every member of our staff is dedicated in helping to preserve Classic Cars.

Our computer system and web site give up-to-the minute information regarding availability and the price of any item.

We have an enviable reputation for despatching goods when the customer needs it, quickly and efficiently.

We try to make all our systems and documentation easy to follow and use, and make sure that our catalogues really do help our customers choose the right parts easily, first time.



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# THE TRIUMPH PARTS SPECIALIST



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## ORDERING ON-LINE

Our website hosts all our Parts Catalogues and also displays current prices and availability of parts.

**Placing an order is easy -  
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or order by email.

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# HOW TO

## THIS CATALOGUE

There are no prices in this catalogue. Use it to select the parts you need, then check their cost by referring to our web site or the separate Price Guide/CD rom.

## ORDERING BY PHONE

**UK TELEPHONE SALES: 01522 568000 OVERSEAS TELEPHONE SALES +44 1522 568000**

*See also "Overseas Orders & Payment."*



Please quote your home postcode and part numbers where possible. This gives instant access to our stock control system. If you have any difficulty in selecting the parts you need, our expert staff can help.

### UK Payment for Phone Orders

When you have checked on price, availability and delivery costs you can place your order by phone using Visa, MasterCard, Delta/Connect, Maestro, Solo, American Express, Diners Club, or JCB. You will need to tell us the card number, expiry date (or issue number), CVC security number, cardholder's full name and registered card address.

### After Hours Ordering Service

We operate a 24-hour answering/ordering service which is available to card holders out of normal hours for both UK and Overseas customers. Just leave all necessary details on our telephone voice mails, ie your vehicle type, year, model, the parts and/or the part numbers you require, plus your name, address (inc, postcode), credit card details and delivery address (if different).

Writing out these details before phoning usually helps a caller to give us clear instructions. If at all possible, please also leave a daytime telephone number.

## ORDERING BY POST

**Triumph House, Sleaford Road, Bracebridge Heath, Lincoln, LN4 2NA, England.**

We ask you to phone first if at all possible - to check your parts selection, and to advise of delivery charges. Because prices and availability sometimes change, we can also confirm the exact remittance needed, avoiding unnecessary delays. If you have not been able to telephone, please give us all possible information - car type/year, RH or LH, front/rear etc - so we can check your selection (including your name, address and postcode) in all correspondence.

Use our Order Form if you can. It asks specifically for all the details we might need. Please photostat or request additional copies of the order form if required.

If paying by cheque, please write your full name and address on the back. Clearance may take a few days, so please allow extra time for delivery.

You can also pay by bank transfer, postal orders, bank or building society cheque or credit/debit card. If you send cash or Rimmer Bros voucher's, use registered mail, as we cannot accept responsibility for any loss.

## ORDERING BY FAX

**UK SALES FAX: 01522 567600 OVERSEAS SALES FAX: +44 1522 567600**

*See also "Overseas Orders & Payment."*

Another facility for customers who wish to make enquiries, or order by credit, debit or charge card. Again, we will need your name, address (inc. postcode), credit card details and delivery address (if different). Plus fullest possible car/parts details - as for orders by post.

## COLLECTING IN PERSON

If you wish to 'call and collect', you will always be made welcome at our shop and sales counter during business hours. Our Visitor Information Centre has lots of interesting details of each production model and the factories where they were produced.

Customers drive here regularly from all over Europe. Lincoln is a historic Cathedral city and is an excellent place to visit. We're about 2 miles south of Lincoln on the A15 Lincoln to Sleaford road (see map on back cover). We advise you to pre-check by phone that we have the part/s you want in stock. You may also place your order on-line. Select the 'Counter Collection' delivery option, and we will have the order waiting for you.

We accept payment by credit/debit card, cash, bank draft or building society cheque. If paying by personal cheque, we may require some form of photo ID, such as a driving licence or passport.

## PRICING

For full information and details on prices, VAT, & VAT exempt export sales, please refer to our web site. Written quotations are available on request, for parts and/or delivery charges. Please confirm all prices when ordering - prices and availability can sometimes change at short notice.





## OVERSEAS ORDERS & PAYMENT

We supply parts to car owners Worldwide. We have thousands of customers in Europe and regularly send parts as far afield as Australia, North America, Africa and the Far East. Delivery costs of course, vary greatly (depending on size/weight/ urgency). We can quote accurately for the cost of parts and delivery once your requirements are known.

Our Multi-language European Order Forms explain how to order parts in English, Italian, German, Spanish and French, please request if needed.

### Payment By Export Customers:

**There is a choice of payment methods for customers overseas;**

- A) Credit card, Debit card or Charge card.
- B) Bank cheque - in ££s sterling (Drawn on a London Bank)
- C) Travellers Cheques (signed) - in ££s sterling.
- D) By Bank Transfer - see web site for details.

*Please note that all transactions must be in ££s sterling.*



## CHOICE OF DELIVERY METHODS

*(For Further Information/Cost Details, Please Refer to Web Site)*

### UNITED KINGDOM

There are numerous delivery options for the UK mainland ranging from Post to overnight carrier services. We can advise of the best method of despatch when you contact us. The type of service that we recommend depends upon the size, weight and urgency of the parts you require. Our web site indicates the approximate costs.

### WORLDWIDE (NON EC COUNTRIES)

We started exporting parts Worldwide in 1982, and since then we have gained an excellent reputation for our speed & efficiency of service. Delivery costs are based on size, weight, and method of delivery. We have discounted rates with well known carriers, so costs are kept to a minimum. Send us a list of the parts you need (using post, phone, fax or E-Mail), tell us quantities and urgency, and we will work out the best delivery method and quickly advise you of the cost. Written quotations are available on request. Please note that any local import duty, taxes or customs clearance are not included in our prices.

### EC COUNTRIES

The European Community Single Market permits the free movement of goods between all EC countries. This allows us to provide a superb service to all our customers within the EC, with the benefits of improved delivery - via lower charges and easier documentation. Deliveries can be easily arranged using air or surface transport. Our web site indicates approximate costs.

## BACK-ORDERS

Back-ordered items are not charged for until despatch. Upon despatch we will charge the price quoted at the time of ordering. Prices will be unaffected by any subsequent price alterations unless advised in writing to you. Please notify us in writing (letter, fax or e-mail) if you wish to cancel any back ordered items. Back orders will be automatically cancelled after 3 months.

## SPECIAL ORDERS

Certain items (coloured trim, carpets, hoods etc) are sometimes only available by special order. This means we have to order them for you specially from the manufacturer. For this reason, we require a 20% non-refundable deposit upon taking your order. The balance is payable when the goods are despatched. Please note that special order items can take several weeks to be supplied.

## WARRANTY & RETURNS

Please refer to our web site for full details.

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## NEW & RECONDITIONED PARTS

Almost every part we list is sold brand-new, but in many instances we also offer you the facility to buy "Reconditioned" (usually giving us your old component in part-exchange).

Where there is a reconditioned version of a part, you will find the letter 'R' added at the end of the part number.

## EXCHANGE SURCHARGES (REFUNDABLE)

Where parts are sold on an exchange basis, an "Exchange Surcharge" is applied - a deposit in effect, which is refunded to you when your old unit is received by us. This system allows you to make an exchange without having to send the old unit first ... it can often prevent your vehicle being off the road.

Before returning your old unit, please telephone our customer service dept on 01522 568000 in order to obtain a return authorisation number. See reverse of invoice for full details of return procedure. Units must be drained of oil, water and be serviceable; we reserve the right to retain all or part of the surcharge if the unit is irreparable, damaged, incomplete or not identical to the type supplied.

## SELECTED USED PARTS

We are often asked for parts that are no longer available, where the cost of re-tooling or re-manufacturing is prohibitive, and there is little or no chance of the part becoming available. We have also found that some customers prefer the option of being able to buy a (non safety critical) used alternative, where perhaps the cost of a new part is unjustified.

Over the years, we have acquired many parts which are suitable for re-sale. These parts have the same part number reference as new but with a 'U' suffix. All used parts have been cleaned and inspected and are sold as serviceable when fitted.

Errors & Omissions Excepted. All parts offered subject to availability.

All part numbers, illustrations and photographs used in this catalogue are intended for reference/ identification purposes only, and are not necessarily an exact representation of the goods supplied. Whilst we make every effort to ensure the accuracy of product descriptions in this catalogue, they are based upon information supplied by the manufacturer/distributor at the time of publication. There may be occasions - due to circumstances beyond our control - when specifications are changed, or when goods become temporarily unavailable.

Certain part numbers have been superseded to an alternative number when a later version or updated specification is offered.



# TR2 to TR5



## 15 YEARS OF EVOLUTION

Although the original TR2 of 1953 shared very few components with the last of the TR5/TR250 types built in 1968, a continuous, strong, and easily identified, pedigree linked all individual cars built in those fifteen years. The original design philosophy, which was to produce a simple, rugged, and reliable 100+ MPH sports car which could be maintained by any Standard-Triumph franchise, anywhere in the world, was retained throughout.

The original **TR2**, built from 1953 to 1955, set all the standards for later versions of these cars, which were retained. Harry Webster's engineers produced a remarkable chassis, Walter Belgrove's body designers offered a smart semi-traditional sports car style (complete with removable side curtains and cutaway doors), while Ken Richardson's diligence helped sort out every development problem. The heart of the car was the extremely robust 90bhp/1,991cc engine, which had easily removable 'wet' cylinder liners, and was closely related to engines used in the Standard Vanguard and, indeed, in the current Ferguson tractor. Body shells were produced by Mulliners in Birmingham, and final assembly was at Standard-Triumph's Canley plant.

As expected, most TRs were always sold in the North American market, where the optional Laycock overdrive, and centre-lock wire wheels, were always popular. Changes to the body structure, which resulted in the original full-depth passenger doors being changed to a 'short door' layout, came late in 1954, while a removable hardtop option became more and more popular.

The **TR3** took over from the TR2 at the end of 1955, the important changes being to provide more power (this rose from 90 to 95bhp at this time), along with a square slatted front radiator grille. Then, from late 1956, all new TR3s were equipped with front-wheel disc brakes as standard equipment, which gave the cars a performance and marketing advantage over all their rivals.

The biggest change then followed, for 1958, when the **TR3A** took over, this car having a modified 'wide-mouth' front style, exterior door handles and a higher level of trim and equipment. An enlarged, 2,138cc, engine became optional from 1959 (though few such cars were sold, it seems). It was this model which the American buyers really took to their hearts, for in the next four years more than 58,000 examples would be built.

Although the TR4 then came along, to replace the TR3A, in 1961, for one year only, in 1962, an interim 'old model' called the **TR3B** was produced, entirely for the North American market - this keeping the original 'side-curtain' style, but using the updated TR4 engine and transmission.

### New style, by Michelotti

For the new **TR4**, Standard-Triumph not only provided a completely new body style (shaped by its consultant Giovanni Michelotti), which came complete with wind-up windows, a more roomy cockpit with face-level ventilation, and a smart optional two-piece hardtop, which had a removable roof panel. Again as an option, a canvas 'Surrey' top with a simple bracing frame could be fitted instead of this roof panel.

Although based on the earlier chassis, the TR4 frame featured wider front (by four inches) and rear (by 2.5 inches) wheel tracks, along with rack-and-pinion steering. As before, both overdrive and centre-lock wire-spoke wheels were optional extras. For this model, a 100bhp/2,138cc engine became standard equipment, though the 1,991cc engine was still available to special order: very few such cars were ever built. The TR4 also got a new all-synchromesh gearbox, which was a direct descendant of the old type, though different in many detail ways.

Although the TR4 sold very well - more than 40,000 were built in less than four years., it was then replaced by the **TR4A** in the spring of 1965. Although this looked virtually the same as before, it featured an entirely new type of chassis frame, complete with independent rear suspension, featuring coil springs and semi-trailing arms (this being closely related to the modern Triumph 2000 saloon, which had recently gone on sale).

For sale only in North America (the USA and Canada), Triumph marketed an 'entry-level' TR4A with a lower price tag, that car having a beam axle/leaf spring rear suspension installation. It was a success, for about 10,000 of total TR4A production (of 28,465) had this layout.





# Six instead of four

The last big change in this long-running product line then followed in the autumn of 1967, when Triumph finally replaced the legendary old 'wet-liner' four cylinder by the longer, smoother and eventually more powerful 2,498cc straight-six-cylinder engine, which had already been in use on other Standard and Triumph models since 1960. Many nostalgic tears were shed over this decision, but it made sound technical sense, especially as the first exhaust emission limiting rules were being brought in, in North America: the dear old 'four' could not meet the new rules, and was in any case at the end of its development life.

Two versions of the engine, and two new models, were unveiled at the same time. For sale only in North America, the **TR250** was fitted with a 104bhp version of the engine, this using twin 175CD Zenith-Stromberg carburettors. Visually, this car was identified by having transverse 'speed stripes' across the bonnet and front wings. In later years, a number of TR250s were re-imported to the UK, as used 'classics'.

For the 'Rest of the World', there was the **TR5**, which was fitted with a 150bhp version of the new 'six', this time with Lucas fuel injection as standard equipment. It was Britain's first fuel-injected road car, and could reach 120mph, with much fiercer acceleration than in any previous TR. Although it cost £1,212 in the UK, it was still seen as a performance bargain, and some teething trouble with the injection equipment was soon sorted out.

These twin models, however, had a very short life, for an evolution was already being planned, and the last were produced before the end of 1968. This was the point at which the newly-shaped TR6 took over from both types, this being a car which looked, and in many ways was, very different from the Michelotti-styled TR5/TR250 style which had served so well.

# TR6, TR7 and TR8

From 1969, the re-styled TR6 took over from the TR5/TR250 family. Though mechanically similar to those cars, the style had been completely re-worked, with totally different front and rear ends. Over the years the design was further refined, this including as minor de-tune of the injected engine in 1973.

Then, from 1975, the all-new TR7 was introduced. Originally a fixed-head coupe with a 2-litre four-cylinder engine, and a beam rear axle, this car eventually spawned a V8-engined TR8 version too, and more derivatives would have followed if the parent company (British Leyland) had not been in such awful financial difficulties.

The last TR of all was produced in 1981, by which time nearly 210,000 TR6, TR7 and TR8 cars had been built.



| TR2 to TR5 : BASIC SUMMARIES |  |  |  |
|------------------------------|--|--|--|
| <b>TR2</b> (1953 - 1955)     | : Original style, with 2.0-litre engine.   |  |  |
| <b>TR3</b> (1955 - 1957)     | : Style as TR2, with more power. Disc brakes for 1957  |  |  |
| <b>TR3A</b> (1958 - 1961)    | : Wide-mouth style version of TR3. Optional 2.2-litre engine   |  |  |
| <b>TR3B</b> (1962)           | : TR3A style/chassis, with TR4 running gear.<br>Sold only in North America   |  |  |
| <b>TR4</b> (1961 - 1965)     | : Wide track chassis, with brand-new style   |  |  |
| <b>TR4A</b> (1965 - 1967)    | : Re-touched TR4 style, with new chassis, and independent rear suspension. beam rear axle option for North America |  |  |
| <b>TR5</b> (1967 - 1968)     | : Re-touched TR4A style, with new six-cylinder engine and fuel injection. Not sold in North America                |  |  |
| <b>TR250</b>                 | : North American version of TR5, with carburetted-engine   |  |  |

| TR PRODUCTION FIGURES : 1953 to 1968   |               |                |                |
|--|---------------|----------------|----------------|
| These were the number of TR sports cars built at Canley (or, in the case of the TR3B, in Birmingham) in the 1953 - 1968 period |               |                |                |
| Model  | UK Market     | Export Market  | Total          |
| <b>TR2</b>   | 2,823         | 5,805          | 8,628          |
| <b>TR3</b>   | 1,286         | 12,091         | 13,377         |
| <b>TR3A</b>  | 1,896         | 56,340         | 58,236         |
| <b>TR3B</b>  | -             | 3,331          | 3,331          |
| <b>TR4</b>   | 2,592         | 37,661         | 40,253         |
| <b>TR4A</b>  | 3,075         | 25,390         | 28,465         |
| <b>TR5</b>   | 1,161         | 1,786          | 2,947          |
| <b>TR250</b>   | -             | 8,484          | 8,484          |
| <b>Total</b>   | <b>12,833</b> | <b>150,888</b> | <b>163,721</b> |

*Note: The TR3B and TR250 models were officially sold only in North America. The TR5 was never officially sold in North America.*



Graham Robson



## TR2



## TR2

## 1953 1954 model year

- TS1 First production car (built 22nd Jul. 53)  
TS305 Last production car that year (built Dec. 53)

## 1954 1954 model year

- TS306 First production car (built 1st Jan. 54)  
TS4001 Last production car (built Oct. 54)

## 1955 model year

- TS4002 First production car (built Oct. 54)  
TS5202 Last production car that year (built Dec. 54)

## 1955 1955 model year

- TS5203 First production car (built 4th Jan. 55)  
TS8636 Last production TR2 (built 6th Oct. 55)

## TR3



## TR3

## 1955 1956 model year

- TS8709 First production car (built 7th Oct. 55)  
TS9665 Last production car that year (built Dec. 55)

## 1956 1956 model year

- TS9666 First production car (built 2nd Jan. 56)  
TS13045 Last production car (built Sept. 56)

## 1957 model year

- TS13046 First production car (built Sept. 56)  
TS14998 Last production car that year (built Dec. 56)

## 1957 1957 model year

- TS14999 First production car (built 1st Jan. 57)  
TS22013 Last production TR3 (built 17th Sept. 57)



## TR3A



## TR3A

## 1957 1958 model year

- TS22014 First production car (built 17th Sept. 57)  
TS25632 Last production car that year (built Dec. 57)

## 1958 1958 model year

- TS25633 First production car (built 1st Jan. 58)  
TS41667 Last production car that year (built Dec. 58)

## 1959 1958 model year

- TS41668 First production car (built 1st Jan. 59)  
TS60000 Last production car (built Oct. 59)

## 1960 model year

- TS60001 First production car (built Oct. 59)  
TS65123 Last production car that year (built Dec. 59)

## 1960 1960 model year

- TS65124 First production car (built Jan. 60)  
TS82029 Last production car that year (built Dec. 60)

## 1961 1961 model year

- TS82030 First production car (built Jan. 61)  
TS82339 Last production car that year (built Dec. 61)

## 1962 1961 model year

- TS82340 First production car (built Jan. 62)  
TS82347 Last production TR3A (built Jan. 62)

## TR3B

## 1962 1962 model year (TSF)

- TSF1 First production car (built 1st Mar. 62)  
TSF530 Last production car (built 19th Sept. 62)

## 1962 model year (TCF)

- TCF1 First production car (built 8th May 62)  
TCF2804 Last production TR3B (built Dec. 62)

## TR4



## TR4

## 1961 1962 model year

- CT1 First production car (built 18th Jul. 61)  
CT2648 Last production car that year (built Dec. 61)

## 1962 1962 model year

- CT2649 First production car (built 1st Jan. 62)  
CT18604 Last production car that year (built Dec. 62)

## 1963 1963 model year

- CT18605 First production car (built Jan. 63)  
CT28708 Last production car that year (built Dec. 63)

## 1964 1964 model year

- CT28709 First production car (built 1st Jan. 64)  
CT40192 Last production car that year (built Dec. 64)

## 1965 1964 model year

- CT40193 First production car (built 1st Jan. 65)  
CT40304 Last production TR4 (built 6th. Jan 65)

## TR4A



## TR4A

## 1965 1965 model year

- CTC50006 First production car (built 5th Jan. 65)  
CTC64147 Last production car that year (built Dec. 65)

## 1966 1966 model year

- CTC64148 First production car (built 3rd Jan. 66)  
CTC75171 Last production car that year (built Dec. 66)

## 1967 1966 model year

- CTC75172 First production car (built 2nd Jan. 67)  
CTC78684\* Last production TR4A (built 11th Jul. 67)  
\*CTC78687, the last TR4A numerically, built on 10th Jul. 67.

## TR5



## TR5

## 1967 1968 model year

- CP2 First production car (built 29th Aug. 67)  
CP585 Last production car that year (built Dec. 67)

## 1968 1968 model year

- CP586 First production car (built 1st Jan. 68)  
CP3101 Last production TR5 (built 19th Sept. 68)

## TR250



## TR250

## 1967 1968 model year

- CD1 First production car (built 11th Jul. 67)  
CD2684 Last production car that year (built Dec. 67)

## 1968 1968 model year

- CD2685 First production car (built Jan. 68)  
CD8594 Last production TR250 (built 19th Sept. 68)







## TR2, TR3, TR3A, TR3B

### Original Settings and Standard Capacities

#### Engine Settings

|                              |                                |
|------------------------------|--------------------------------|
| Firing Order (No.1 at Front) | 1,3,4,2                        |
| Spark Plug Gap               | 0.032"                         |
| Contact Breaker Gap          | 0.014" to 0.016"               |
| Rotation (Distributor)       | Anti-clockwise                 |
| Dwell Angle                  | 32-38 deg.                     |
| Ignition Timing - Static     | 4 deg. BTDC                    |
| Ignition Timing - Idle       | N/A                            |
| Idle Speed                   | 800 - 850 RPM                  |
| Fast Idle Speed              | 1100 - 1300 RPM                |
| Valve Clearance (Cold)       | Inlet 0.010"<br>Exhaust 0.012" |

#### Capacities

|  |                    |
|--|--------------------|
| Engine;                                |                    |
| Sump and Oil Filter                    | 11 Pints (6.25L)   |
| Sump Only                              | 10 Pints (5.7L)    |
| Cooling System (incl. Heater)          | 14 Pints (8L)      |
| Fuel Tank (Approx.);                   |                    |
| TR2                                    | 12.5 Gall (56.75L) |
| TR3, TR3A, TR3B                        | 12 Gall (54.48L)   |
| Gearbox;                               |                    |
| Non-Overdrive                          | 1.5 Pints (0.85L)  |
| Overdrive                              | 3.5 Pints (2L)     |
| Rear Axle                              | 1.5 Pints (0.8L)   |
| Tyre Pressures;                        |                    |
| Standard Wheels/Tyres - Normal Driving |                    |
| 5.50x15 Front (Cold)                   | 22lbs./sq.in.      |
| 5.50x15 Rear (Cold)                    | 24lbs./sq.in.      |



## TR4, TR4A

### Original Settings and Standard Capacities

#### Engine Settings

|                               |                  |
|-------------------------------|------------------|
| Firing Order (No.1 at Front)  | 1,3,4,2          |
| Spark Plug Gap                | 0.025"           |
| Contact Breaker Gap           | 0.014" to 0.016" |
| Rotation (Distributor)        | Anti-clockwise   |
| Dwell Angle                   |                  |
| Distributors 40735/77/83/850  | 32 - 38 deg.     |
| Distributors 40795/842        | 27 - 33 deg.     |
| Ignition Timing - Static      |                  |
| Distributors All Except 40777 | 4 deg. BTDC      |
| Distributor 40777             | TDC              |
| Ignition Timing - Idle        |                  |
| Distributors All Except 40777 | N/A              |
| Distributor 40777             | TDC              |
| Idle Speed                    |                  |
| All Except TR4A USA           | 800 - 850 RPM    |
| TR4A USA                      | 850 - 900 RPM    |
| Fast Idle Speed               | 1100 - 1300 RPM  |
| Valve Clearance (Cold)        | 0.010"           |

#### Capacities

|  |                    |
|--|--------------------|
| Engine                                   |                    |
| Sump and Oil Filter                      | 11 Pints (6.25L)   |
| Sump Only                                | 10 Pints (5.7L)    |
| Cooling System (incl. Heater)            | 14 Pints (8L)      |
| Fuel Tank (Approx.)                      | 11.75 Gall (53.5L) |
| Gearbox                                  |                    |
| Non-Overdrive                            | 2 Pints (1.13L)    |
| Overdrive                                | 3.5 Pints (2L)     |
| Rear Axle                                |                    |
| TR4, TR4A Rigid Axle                     | 1.5 Pints (0.8L)   |
| TR4A IRS                                 | 2.5 Pints (1.42L)  |
| Tyre Pressures                           |                    |
| (Standard Wheels/Tyres - Normal Driving) |                    |
| 6.95 x 15 Front (Cold)                   | 20 lbs./sq. in.    |
| 6.95 x 15 Rear (Cold)                    | 24 lbs./sq. in.    |
| 165 x 15 Front (Cold)                    | 24 lbs./sq. in.    |
| 165 x 15 Rear (Cold)                     | 28 lbs./sq. in.    |



## TR5, TR250

### Original Settings and Standard Capacities

#### Engine Settings

|                              |                  |
|------------------------------|------------------|
| Firing Order (No.1 at Front) | 1,5,3,4,6,2      |
| Spark Plug Gap               | 0.025"           |
| Contact Breaker Gap          | 0.014" to 0.016" |
| Rotation (Distributor)       | Anti-clockwise   |
| Dwell Angle                  | 32 - 38 deg.     |
| Ignition Timing - Static     |                  |
| TR5                          | 11 deg. BTDC     |
| TR250                        | 10 deg. BTDC     |
| Ignition Timing - Idle       |                  |
| TR5                          | N/A              |
| TR250                        | 4 deg. ATDC      |
| Idle Speed                   |                  |
| TR5                          | 700 - 850 RPM    |
| TR250                        | 800 - 850 RPM    |
| Fast Idle Speed              |                  |
| TR5                          | 1300 - 1500 RPM  |
| TR250                        | 1100 - 1300 RPM  |
| Valve Clearance (Cold)       | 0.010"           |

#### Capacities

|  |                   |
|--|-------------------|
| Engine                                   |                   |
| Sump and Oil Filter                      | 9 Pints (5.10L)   |
| Sump Only                                | 8 Pints (4.25L)   |
| Cooling System (incl. Heater)            | 11 Pints (6.2L)   |
| Fuel Tank (Approx.)                      | 11.25 Gall (51L)  |
| Gearbox                                  |                   |
| Non-Overdrive                            | 2 Pints (1.13L)   |
| Overdrive                                | 3.5 Pints (2L)    |
| Rear Axle                                | 2.5 Pints (1.42L) |
| Tyre Pressures                           |                   |
| (Standard Wheels/Tyres - Normal Driving) |                   |
| Front (Cold)                             | 22 lbs./sq. in.   |
| Rear (Cold)                              | 26 lbs./sq. in.   |



# ALL MODELS

This section will help you find the parts which are most frequently called for; filters, gaskets, seals, bushes, etc.

If you are unsure, you will find each part listed again under its appropriate section.

## Service Kits

SERVICE KIT, includes contact set, plugs, condenser, oil filter, air filters and fan belt, 6 Cylinder kits also include fuel filter;

|   |   |               |
|---|---|---------------|
| TR2 to TS8212, with H4 carbs and standard (canister type) oil filter  | 1 | <b>RW3107</b> |
| TR2 to TS8212, with H4 carbs and spin-on oil filter conversion  | 1 | <b>RW3108</b> |
| TR2 from TS8213, with H4 carbs and standard (canister type) oil filter  | 1 | <b>RW3213</b> |
| TR2 from TS8213, with H4 carbs and spin-on oil filter conversion  | 1 | <b>RW3214</b> |
| TR3, TR3A, TR4, with H6 carbs, open circuit breathing and standard (canister type) oil filter                 | 1 | <b>RW3109</b> |
| TR3, TR3A, TR4, with H6 carbs, open circuit breathing and spin-on oil filter conversion                       | 1 | <b>RW3110</b> |
| TR4 with closed circuit breathing through separate round air cleaners and standard (canister type) oil filter | 1 | <b>RF4148</b> |
| TR4 with closed circuit breathing through separate round air cleaner and spin-on oil filter conversion        | 1 | <b>RF4149</b> |
| TR4 with closed circuit breathing through air box, TR4A, with standard (canister type) oil filter             | 1 | <b>RF4150</b> |
| TR4 with closed circuit breathing through air box, TR4A, with spin-on oil filter conversion                   | 1 | <b>RF4151</b> |
| TR5 with standard (canister type) oil filter  | 1 | <b>RR1019</b> |
| TR5 with spin-on oil filter conversion  | 1 | <b>RR1233</b> |
| TR250 with standard (canister type) oil filter  | 1 | <b>RR1293</b> |
| TR250 with spin-on oil filter conversion  | 1 | <b>RR1295</b> |

## Service Items

|  |   |                    |
|--|---|--------------------|
| Oil Filter;  |   |                    |
| TR2/3/3A/4/4A (Standard)                             | 1 | <b>GFE104</b>      |
| TR5/250 (Standard)                                   | 1 | <b>GFE131</b>      |
| All Models (Spin On Conversion)                      | 1 | <b>RR1243</b>      |
| Air Filter (Standard);                               |   |                    |
| See 'Air Filters' section for K&N filters.           |   |                    |
| TR2 (With H4 Carbs.)                                 | 2 | <b>107356</b>      |
| TR3/3A/4 (With H6 Carbs.)                            | 2 | <b>203131</b>      |
| TR4 (Closed Circuit Breathing, Separate Air Filters) | 2 | <b>209269</b>      |
| TR4 (Closed Circuit Breathing, with Air Box)         | 2 | <b>212278</b>      |
| TR4A (Separate Air Cleaners or Air Box)              | 2 | <b>212278</b>      |
| TR250 (With Air Box)                                 | 2 | <b>GFE1020</b>     |
| TR5 (With Air Filter Cannister)                      | 1 | <b>GFE1048</b>     |
| Fuel Filter;   |   |                    |
| TR250  | 1 | <b>GFE7004</b>     |
| TR5  | 1 | <b>GFE5296</b>     |
| Contact Breaker Points;                              |   |                    |
| TR2  |   |                    |
| With Lucas No. 40403 Distributor                     | 1 | <b>501466</b>      |
| With Lucas No. 40480 Distributor,                    |   |                    |
| Standard   | 1 | <b>GCS101</b>      |
| Competition  | 1 | <b>GCS111</b>      |
| TR3/3A/4/4A/5/250                                    |   |                    |
| Standard   | 1 | <b>GCS101</b>      |
| Competition  | 1 | <b>GCS111</b>      |
| Condenser (All Models)                               | 1 | <b>GSC111</b>      |
| Rotor Arm;   |   |                    |
| TR2/3/3A/4/4A  | 1 | <b>GRA101</b>      |
| TR5/250  | 1 | <b>GRA102</b>      |
| Distributor Cap;                                     |   |                    |
| TR2/3/3A/4/4A  |   |                    |
| Side Entry, for Screw-In Leads                       | 1 | <b>GDC114</b>      |
| Top Entry, for Push-In Leads                         | 1 | <b>GDC103</b>      |
| TR5/250  | 1 | <b>GDC115</b>      |
| Spark Plugs;   |   |                    |
| TR2/3/3A/4/4A  |   |                    |
| Standard   | 4 | <b>GSP4366</b>     |
| High Performance                                     | 4 | <b>GSP4366HP</b>   |
| TR5/250  |   |                    |
| Standard   | 6 | <b>GSP4362</b>     |
| High Performance                                     | 6 | <b>GSP6462</b>     |
| Plug Lead Set;                                       |   |                    |
| TR2/3/3A/4/4A  |   |                    |
| Screw-In, Standard                                   | 1 | <b>HMP221001</b>   |
| Push-In, Standard                                    | 1 | <b>RF4099</b>      |
| Push-In, Silicone                                    | 1 | <b>RF4099S</b>     |
| TR5/250  |   |                    |
| Push-In, Standard                                    | 1 | <b>GHT142</b>      |
| Push-In, Silicone                                    | 1 | <b>GHT142S</b>     |
| Ignition Coil;                                       |   |                    |
| For Screw-In Leads                                   | 1 | <b>GCL110B</b>     |
| For Push-In Leads, Standard                          | 1 | <b>GCL110</b>      |
| For Push-In Leads, Lucas Manuf.                      | 1 | <b>GCL110LUCAS</b> |
| For Push-In Leads, Sports Type                       | 1 | <b>GCL110HP</b>    |
| Fan Belt;  |   |                    |
| TR2/3/3A/4/4A  |   |                    |
| Std. Wide Belt                                       | 1 | <b>GFB40975</b>    |
| With Narrow 3/8" Belt Conversion                     | 1 | <b>GCB10975</b>    |
| TR5/250  | 1 | <b>GCB11088</b>    |

## Engine Gaskets

|  |   |                    |
|--|---|--------------------|
| Head Gasket Set;                         |   |                    |
| TR2 (Low Port, H4 Carbs.)                | 1 | <b>501678</b>      |
| TR3 (Low Port, H6 Carbs.)                | 1 | <b>RF4211</b>      |
| TR3/3A/4/4A (High Port, up to 87mm bore) | 1 | <b>GEG178</b>      |
| TR250                                    | 1 | <b>517276</b>      |
| TR5                                      | 1 | <b>GEG179</b>      |
| Head Gasket Only;                        |   |                    |
| TR2/3/3A/4/4A                            |   |                    |
| 83/86mm bore                             | 1 | <b>205481</b>      |
| Steel Shim Type up to 87mm bore          | 1 | <b>202775</b>      |
| TR5/250 Non-Recessed Bore,               |   |                    |
| Standard                                 | 1 | <b>GEG346</b>      |
| Payen Manufacture                        | 1 | <b>GEG346PAYEN</b> |
| Rocker Cover Gasket;                     |   |                    |
| TR2/3/3A/4/4A                            | 1 | <b>GEG437</b>      |
| TR5/250                                  | 1 | <b>GEG413</b>      |
| Manifold to Head Gasket;                 |   |                    |
| TR2/3 (Low Port)                         | 2 | <b>106937</b>      |
| TR3/3A/4/4A (High Port)                  | 2 | <b>113122</b>      |
| TR5                                      | 1 | <b>GEG682</b>      |
| TR250                                    | 1 | <b>213641</b>      |
| Manifold to Down Pipe Gasket;            |   |                    |
| TR2/3/3A/4                               | 1 | <b>GEG718</b>      |
| TR4A                                     | 1 | <b>GEG724</b>      |
| TR5                                      | 1 | <b>GEG724</b>      |
| TR250                                    | 1 | <b>GEG718</b>      |
| Sump Gasket Set;                         |   |                    |
| TR2/3/3A/4/4A                            |   |                    |
| Without Seals                            | 1 | <b>GEG248</b>      |
| With Seals                               | 1 | <b>GEG248K</b>     |
| TR5/250                                  |   |                    |
| Without Seals                            | 1 | <b>GEG214</b>      |
| With Seals                               | 1 | <b>GEG214K</b>     |
| Sump Gasket Only;                        |   |                    |
| TR2/3/3A/4/4A                            | 1 | <b>211123</b>      |
| TR5/250                                  | 1 | <b>GEG515</b>      |
| Timing Cover Gasket;                     |   |                    |
| TR2/3/3A/4/4A                            | 1 | <b>211122</b>      |
| TR5/250                                  | 1 | <b>211126</b>      |
| Thermostat Gasket (All Models);          |   |                    |
| TR2 to TS1200                            | 1 | <b>105593</b>      |
| TR2 from TS1201                          | 1 | <b>GTG103</b>      |
| TR3/3A/4/4A/5/250                        | 1 | <b>GTG103</b>      |

## Oil Seals

|  |   |                 |
|--|---|-----------------|
| Timing Cover Oil Seal (Front Oil Seal);                            |   |                 |
| TR2/3/3A/4/4A  | 1 | <b>104662</b>   |
| TR5/250  |   |                 |
| Original Single Lip  | 1 | <b>125631</b>   |
| TR6 Type Twin Lip  | 1 | <b>UKC1110</b>  |
| Crankshaft Rear Main Oil Seal;                                     |   |                 |
| TR2/3/3A/4/4A  |   |                 |
| Original 2 Piece   | 1 | <b>60862</b>    |
| Upated Kit   | 1 | <b>60862RCT</b> |
| TR5/250  | 1 | <b>143456</b>   |
| Gearbox Front Oil Seal (All Models)                                | 1 | <b>141756</b>   |
| Gearbox Rear Oil Seal  | 1 | <b>146129</b>   |
| All Models, Including Overdrive.                                   |   |                 |
| Rear Axle Front Pinion Seal;                                       |   |                 |
| TR2/3/3A/4/4A Solid Axle   | 1 | <b>100898</b>   |
| TR4A IRS/5/250   |   |                 |
| Original Leather   | 1 | <b>140337</b>   |
| Improved Rubber  | 1 | <b>140337P</b>  |
| Rear Axle Output Oil Seal;   |   |                 |
| TR2 to TS5555 (Lockheed Axle)                                      | 2 | <b>103811</b>   |
| Check seal area diameter in hub to ensure correct seal is ordered. |   |                 |
| TR2 from TS5556,   |   |                 |
| TR3 to TS13045 (Lockheed Axle)                                     | 2 | <b>109543</b>   |
| Check seal area diameter in hub to ensure correct seal is ordered. |   |                 |
| TR3/3A/4/4A Solid (Girling Axle)                                   | 2 | <b>GHS185</b>   |
| TR4A IRS/5/250   | 2 | <b>138523</b>   |
| Front Hub Seal (All Models)  | 2 | <b>GHS110</b>   |
| Rear Hub Seal;   |   |                 |
| TR2 to TS5555 (Lockheed)   | 2 | <b>103811</b>   |
| TR2 from TS5556, TR3 (Lockheed)                                    | 2 | <b>109543</b>   |
| TR3/3A/4/4A Solid (Girling Axle)                                   | 2 | <b>GHS162</b>   |
| TR4A IRS/5/250   |   |                 |
| Inner Seal   | 2 | <b>GHS131</b>   |
| Outer Seal   | 2 | <b>GHS133</b>   |





## Mountings/Suspension Bushes

|   |     |                   |
|---|-----|-------------------|
| Front Engine Mounting;  |     |                   |
| TR2/3/3A  | 2   | <b>59180</b>      |
| TR4 Early (Round)   | 2   | <b>130985</b>     |
| TR4 Late/4A (Rectangular)   | 2   | <b>143057</b>     |
| <i>The rectangular engine mount is preferred fitment to the round one as its design restricts engine longitudinal movement and may replace the round type if fitted in pairs.</i> |     |                   |
| TR4 (Torque Restriction Buffer)   | 1   | <b>612962</b>     |
| TR5/250   | 2   | <b>UKC8330</b>    |
| Gearbox Mounting (All Models)   | 1   | <b>104086</b>     |
| Rear Axle Mountings;  |     |                   |
| TR4A IRS  |     |                   |
| Rubber Mounting Kit*  | 1   | <b>RF4140</b>     |
| Polyurethane Mounting Kit*  | 1   | <b>RF4140POLY</b> |
| Rubber Rear, Upper & Lower  | 4   | <b>134235</b>     |
| Polyurethane Rear, Upper & Lower  | 4   | <b>134235POLY</b> |
| TR4A IRS/5/250  |     |                   |
| Rubber Upper Front  | 2   | <b>134235</b>     |
| Polyurethane Upper Front  | 2   | <b>134235POLY</b> |
| Rubber Lower Front  | 2   | <b>134236</b>     |
| Polyurethane Lower Front  | 2   | <b>134236POLY</b> |
| TR5/250   |     |                   |
| Rubber Mounting Kit*  | 1   | <b>RR1390</b>     |
| Poly Mounting Kit*  | 1   | <b>RR1390POLY</b> |
| Rubber Rear   | 2   | <b>147783</b>     |
| Polyurethane Rear   | 2   | <b>147783POLY</b> |
| <i>*Includes front &amp; rear mountings, fasteners.</i>   |     |                   |
| Car Set Suspension Bush Kit;  |     |                   |
| TR2/3/3A/4  |     |                   |
| Rubber  | 1   | <b>RW3209</b>     |
| Polyurethane  | 1   | <b>RW3209POLY</b> |
| TR4A IRS/5/250  |     |                   |
| Rubber  | 1   | <b>RR1420</b>     |
| Polyurethane  | 1   | <b>RR1420POLY</b> |
| Front Coil Spring Insulator;  |     |                   |
| TR2/3/3A/4 (Use 6 if using spring packing pieces)   |     |                   |
| Rubber  | 6/4 | <b>100751</b>     |
| Polyurethane  | 6/4 | <b>100751POLY</b> |
| TR4A/5/250  |     |                   |
| Rubber  | 4   | <b>100751</b>     |
| Polyurethane  | 4   | <b>100751POLY</b> |
| Front Upper Wishbone Bush, All Models;  |     |                   |
| Rubber  | 8   | <b>102228</b>     |
| Polyurethane  | 4   | <b>102228POLY</b> |
| Front Lower Wishbone Bush;  |     |                   |
| TR2/3 to TS9120 (Rubber)  | 8   | <b>102228</b>     |
| TR3 from TS9121, TR3A/4 (Nylon)   | 4   | <b>110696</b>     |
| TR3 from TS9121, TR3A/4 (Steel)   | 4   | <b>110695</b>     |
| TR2/3/3A/4 (Poly)   | 4   | <b>110695POLY</b> |
| TR4A/5/250 (Rubber)   |     | <b>141481</b>     |
| TR4A/5/250 (Poly)   |     | <b>141481POLY</b> |
| Front Upper Shock Mounting Bush, All Models;  |     |                   |
| Rubber  | 4   | <b>152588</b>     |
| Polyurethane  | 4   | <b>152588POLY</b> |
| Front Lower Shock Mounting Bush;  |     |                   |
| TR2/3/3A/4  |     |                   |
| Rubber  | 4   | <b>102987</b>     |
| Polyurethane  | 4   | <b>102987POLY</b> |
| TR4A/5/250  |     |                   |
| Rubber  | 2   | <b>119450</b>     |
| Polyurethane  | 2   | <b>119450POLY</b> |
| Anti Roll Bar Link Bush, TR4A/5/250;  |     |                   |
| Rubber  | 4   | <b>517985</b>     |
| Polyurethane  | 4   | <b>517985POLY</b> |
| Anti Roll Bar Location Bush, TR4A/5/250;  |     |                   |
| Rubber  | 2   | <b>123998</b>     |
| Polyurethane  | 2   | <b>123998POLY</b> |
| Rear Spring Shackle Pin Bush;   |     |                   |
| TR2/3/3A/4/4A Solid Axle  |     |                   |
| Rubber  | 8   | <b>112503</b>     |
| Polyurethane  | 8   | <b>112503POLY</b> |
| Rear Coil Spring Insulator, TR4A IRS/5/250;   |     |                   |
| Rubber  | 2   | <b>138823</b>     |
| Polyurethane  | 2   | <b>138823POLY</b> |
| Rear Trailing Arm Bush, TR4A IRS/5/250;   |     |                   |
| Rubber  | 4   | <b>137599</b>     |
| Up-rated Rubber   | 4   | <b>137599H</b>    |
| Polyurethane  | 4   | <b>137599POLY</b> |
| Rear Shock Link Bush, TR4A IRS/5/250;   |     |                   |
| Rubber  | 4   | <b>152588</b>     |
| Polyurethane  | 4   | <b>152588POLY</b> |

## Ball Joints & Hub Bearings

|   |   |                 |
|---|---|-----------------|
| Front Upper Ball Joint;                 |   |                 |
| TR2/3/3A/Early TR4                      | 2 | <b>200772</b>   |
| Late TR4/4A/5/250                       | 2 | <b>GSJ131</b>   |
| Steering Tie/Track Rod End;             |   |                 |
| TR2/3/3A                                |   |                 |
| Tie Rod End Set                         | 2 | <b>110466/8</b> |
| Inner - RH Thread                       | 2 | <b>110466</b>   |
| Outer - LH Thread                       | 2 | <b>110468</b>   |
| TR4/4A/5/250                            | 2 | <b>GSJ156</b>   |
| Front Hub Bearing Kit (All Models)      | 2 | <b>GHK1021</b>  |
| Rear Hub Bearing, TR2/3 (Lockheed Axle) | 2 | <b>513897</b>   |
| Rear Hub Bearing Kit;                   |   |                 |
| TR3 (Girling Axle)/3A/4/4A Solid        | 2 | <b>GHK1144</b>  |
| TR4A IRS/5/250                          | 2 | <b>GHK1015</b>  |

## Cables

|                                |   |                 |
|--------------------------------|---|-----------------|
| Accelerator Cable, TR5         |   |                 |
| RH Steering                    | 1 | <b>149005</b>   |
| LH Steering                    | 1 | <b>149004</b>   |
| Choke Cable;                   |   |                 |
| TR2/3/3A                       | 1 | <b>400627</b>   |
| TR4 (H6 Carbs.)                | 1 | <b>401458</b>   |
| TR4/4A (175CD or HS6 Carbs.)   | 1 | <b>401900/1</b> |
| TR250 (Original)               | 1 | <b>214672</b>   |
| TR250 (Replacement)            | 1 | <b>UKC2121</b>  |
| TR5                            | 1 | <b>214888</b>   |
| Handbrake Cable;               |   |                 |
| TR2/3/3A/4 (Main Cable)        | 1 | <b>202069</b>   |
| Early TR2                      |   |                 |
| RH Axle Cable                  | 1 | <b>105810</b>   |
| LH Axle Cable                  | 1 | <b>105811</b>   |
| Late TR2/3/3A                  |   |                 |
| RH Axle Cable                  | 1 | <b>112469</b>   |
| LH Axle Cable                  | 1 | <b>112470</b>   |
| TR4                            |   |                 |
| RH Axle Cable                  | 1 | <b>129284</b>   |
| LH Axle Cable                  | 1 | <b>129283</b>   |
| TR4A/5/250                     |   |                 |
| Metal Sheathed                 | 1 | <b>140373</b>   |
| Plastic Alternative            | 1 | <b>TKC248</b>   |
| Wiper Drive Cable;             |   |                 |
| TR2, TR3 Early                 | 1 | <b>501730</b>   |
| Late TR3/3A/4/4A/5/250         | 1 | <b>RTC202A</b>  |
| <i>Cut to fit if required.</i> |   |                 |
| Speedometer Cable;             |   |                 |
| TR2/3/3A                       |   |                 |
| RHD (84" Long) - All           | 1 | <b>504611</b>   |
| LHD Non O/D (69" Long)         | 1 | <b>GSD169</b>   |
| LHD O/D (96" Long)             | 1 | <b>504609</b>   |
| TR4/4A                         |   |                 |
| RHD Non O/D (78" Long)         | 1 | <b>GSD141</b>   |
| LHD Non O/D (69" Long)         | 1 | <b>GSD169</b>   |
| O/D (69" Long) - All           | 1 | <b>GSD169</b>   |
| TR5/250                        |   |                 |
| RHD Non O/D (66" Long)         | 1 | <b>GSD114</b>   |
| LHD Non O/D (69" Long)         | 1 | <b>GSD169</b>   |
| O/D (69" Long) - All           | 1 | <b>GSD169</b>   |
| Rev Counter Cable;             |   |                 |
| TR2/3/3A                       |   |                 |
| RHD (51" Long)                 | 1 | <b>GSD113</b>   |
| LHD (36" Long)                 | 1 | <b>504619</b>   |
| TR4/4A                         |   |                 |
| RHD (48" Long)                 | 1 | <b>GSD111</b>   |
| LHD (36" Long)                 | 1 | <b>504619</b>   |
| TR5                            |   |                 |
| RHD Original (42" Long)        | 1 | <b>144370</b>   |
| RHD Easy-Fit (48" Long)        | 1 | <b>UKC2873</b>  |
| TR5/250                        |   |                 |
| LHD Original (33" Long)        | 1 | <b>148704</b>   |
| LHD Easy-Fit (36" Long)        | 1 | <b>UKC2873S</b> |

## MODEL IDENTIFICATION

**TR2** – Introduced July 1953.  
Chassis No. TS1 to TS8636.

**TR3** – Introduced October 1955.  
Chassis No. TS8709 to TS22013.

**TR3A** – Introduced September 1957.  
Chassis No. TS22014 to TS82347.

**TR3B** – Introduced March 1962.  
Chassis No. TSF1 to TSF530.  
Chassis No TCF1 to TCF2804.

**TR4** – Introduced July 1961.  
Chassis No. CT1 to CT40304.

**TR4A** – Introduced January 1965.  
Chassis No. CTC50006 to CTC78687.

**TR5** – Introduced August 1967.  
Chassis No. CP2 to CP3101.

**TR250** – Introduced July 1967.  
Chassis No. CD1 to CD8594.

## Rubber Body Seals

|   |   |                |
|---|---|----------------|
| Windscreen Glazing Seal;  |   |                |
| TR2/3/3A  | 1 | <b>CD31407</b> |
| TR4/4A/5/250  | 1 | <b>913442</b>  |
| Windscreen to Scuttle Seal;   |   |                |
| TR2/3/3A  | 1 | <b>704126</b>  |
| TR4/4A/5/250  | 1 | <b>650130</b>  |
| Windscreen to Door Glass Seal;  |   |                |
| TR4/4A/5/250  | 2 | <b>620913</b>  |
| Ventilator Lid Seal;  |   |                |
| TR2/3/3A  | 1 | <b>600597</b>  |
| TR4/4A/5/250  | 1 | <b>611118</b>  |
| Baffle Plate to Wing Seal, All Models   | 2 | <b>650172</b>  |
| Door Outer Glass Seal, TR4/4A/5/250   |   |                |
| RH  | 1 | <b>850325</b>  |
| LH  | 1 | <b>850324</b>  |
| Door Inner Glass Seal, TR4/4A/5/250   |   |                |
| RH  | 1 | <b>850323</b>  |
| LH  | 1 | <b>850322</b>  |
| Hood Frame Seal;  |   |                |
| TR4A/5/250 (Header Rail Seal)   | 1 | <b>616187</b>  |
| TR5/250   |   |                |
| Front Side Seal   | 2 | <b>627153</b>  |
| Rear Side Seal  | 2 | <b>627154</b>  |
| Bonnet Rear Seal, TR4/4A/5/250  | 1 | <b>610675</b>  |
| Boot Lid Seal;  |   |                |
| TR2/3/3A Early (Channel Type)   | 1 | <b>605810</b>  |
| TR3A Late (Lip Type)  | 1 | <b>608434</b>  |
| TR4/4A/5/250  | 1 | <b>613277</b>  |
| Spare Wheel Cover Seal, TR2/3/3A  | 1 | <b>552559</b>  |
| Door Sealing Rubber/Furlex;   |   |                |
| <i>Available in a range of colours including black, blue &amp; red.</i>   |   |                |
| <i>Refer to web site for current availability.</i>  |   |                |
| TR2/3/3A (Per Metre)  | 3 | <b>552877</b>  |
| TR4/4A/5/250  |   |                |
| <i>The TR4/4A/5/250 seals listed here replace the original separate draught excluder and seal design of the TR4 and TR4A.</i> |   |                |
| <i>See pages 229 and 237 for other options</i>  |   |                |
| Soft Top Models   | 2 | <b>RX3000</b>  |
| Surrey Top Models   | 1 | <b>RX3008</b>  |
| Door to 'A' Post Seal, TR2/3/3A   | 2 | <b>603257</b>  |
| Door Bottom Seal, TR2/3/3A  | 2 | <b>605301</b>  |





## TR2-4A

# ENGINE - EXTERNAL - 4 cylinder - TR2-4A

## ENGINE REBUILD KITS

### Full Engine Rebuild Kit

This kit contains everything you need to recondition your full engine. We assume you will have all machining done as required.

**IMPORTANT** - Piston and liner sets, bearing sets and thrust washer sets are supplied in standard size. Please advise specific sizes required at time of ordering.

#### Kit contains:-

Set of 4 pistons and liners (state size required)  
Main and big end bearing shells (state size required)  
Thrust washers (state size required)  
Head gasket set  
Timing cover oil seal  
Crankshaft rear oil seal  
Sump gasket set  
Inlet valves  
Exhaust valves  
Inlet valve guides  
Exhaust valve guides  
Valve spring set  
Oil pressure relief valve spring  
Cam follower set  
Crankshaft sprocket  
Timing chain  
Timing chain tensioner  
Oil pump  
Oil filter

#### Additionally why not add some or all of the following options to the rebuild kit:

Crankshaft  
Camshaft  
Rocker shaft  
Rocker arms  
Camshaft sprocket  
Con rods

In addition to the rebuild kits, the engine section of this catalogue lists all the other parts that you might want to buy, such as engine studs, cylinder head nuts, water pump etc.

#### FULL ENGINE REBUILD KIT;

|                               |            |
|-------------------------------|------------|
| TR2 to TS9349E                | RW3200     |
| TR3 from TS13052E, TR3A, TR3B | RW3201     |
| TR4 to CT21470                | RF4006R1BK |
| TR4 CT21471 to CT40304        | RF4006R2BK |
| TR4A from CT50001             | RF4007RBK  |

Owners of TR3s with engines prior to TS13052E - i.e. with low port head and H6 carburettors - should purchase full engine rebuild kit part no. RW3201 along with low port manifold gaskets part no. 106937 (order two off) to replace the high port items contained in the kit.

### Short Engine Rebuild Kit

This kit contains everything you need to recondition your short engine. We assume you will have all machining done as required.

**IMPORTANT** - Piston and liner sets, bearing sets and thrust washer sets are supplied in standard size. Please advise specific sizes required at time of ordering.

#### Kit contains:-

Set of 4 pistons and liners (state size required)  
Main and big end bearing shells (state size required)  
Thrust washers (state size required)  
Head gasket set  
Timing cover oil seal  
Crankshaft rear oil seal  
Sump gasket set  
Oil pressure relief valve spring  
(choice of Purolator or Tecalemit)  
Cam follower set  
Timing chain  
Timing chain tensioner  
Oil pump  
Oil filter

#### Additionally why not add some or all of the following options to the rebuild kit:

Crankshaft  
Camshaft  
Crankshaft sprocket  
Camshaft sprocket  
Con rods

In addition to the rebuild kits, the engine section of this catalogue lists all the other parts that you might want to buy, such as engine studs, cylinder head nuts, water pump etc.

#### SHORT ENGINE REBUILD KIT;

|  |           |
|--|-----------|
| TR2 to TS9349E                           | RW3202    |
| TR3 from TS13052E, TR3A, TR3B, TR4, TR4A | RF4013RBK |

Owners of TR3s with engines prior to TS13052E - i.e. with low port head and H6 carburettors - should purchase short engine rebuild kit part no. RF4013RBK along with low port manifold gaskets part no. 106937 (order two off) to replace the high port items contained in the kit.

### Engine Installation Kit

This kit contains everything you need to install your reconditioned engine.

#### Kit contains:-

Manifold gaskets  
Distributor gasket  
Water pump gasket  
Water pump housing gasket  
Crankshaft spigot bush  
Rocker cover gasket  
Exhaust downpipe gasket  
Oil filter  
Thermostat housing gasket  
Castrol XL30 (4.55 litres)

#### ENGINE INSTALLATION KIT;

|                                    |        |
|------------------------------------|--------|
| TR2 to TS9349E                     | RW3203 |
| TR3 TS9350E to TS13051E            | RW3203 |
| TR3 from TS13052E, TR3A, TR3B, TR4 | RF4010 |
| TR4A                               | RF4193 |

## External Engine

### GASKET SETS

The low port head gasket set is strictly speaking for TR2s only. Owners of TR3s with low port heads (and H6 carburettors) should purchase gasket set RF4211 which includes the high port head set GEG178 along with two low port manifold gaskets (106937) to replace the high port items contained in the set.

|   |          |
|---|----------|
| 1 HEAD GASKET SET;  |          |
| low port head (H4 Carbs)  | 1 501678 |
| TR2, TR3 to engine no TS13051E; 83mm & 86mm bore.                 |          |
| low port head (H6 Carbs)  | 1 RF4211 |
| TR3 to engine no. TS13051E; 83mm & 86mm bore.                     |          |
| high port head  | 1 GEG178 |
| TR3 from engine TS13052E, TR3A, TR3B, TR4, TR4A; up to 87mm bore. |          |

#### Head gasket sets include the following items:

|   |           |
|---|-----------|
| HEAD GASKET;  |           |
| 83mm & 86 mm bore and oversizes                                 | 1 205481  |
| steel shim type for up to 89mm bore                             | 1 202775  |
| Updated.  |           |
| Optional (at additional cost) in Head Gasket Set.               |           |
| ROCKER COVER GASKET   | 1 GEG437  |
| MANIFOLDS TO HEAD GASKET;                                       |           |
| low port head   | 2 106937  |
| TR2, TR3 to engine no TS13051E.                                 |           |
| high port head  | 2 113122  |
| TR3 from engine TS13052E, TR3A, TR3B, TR4, TR4A.                |           |
| DOWNPIPE GASKET;  |           |
| single pipe - TR2, TR3, TR3A/B, TR4                             | 1 GEG718  |
| twin pipe - TR4A  | 1 GEG724  |
| THERMOSTAT GASKET   | 1 GTG103  |
| CARBURETTOR GASKET (1 3/4")                                     | 4 112867  |
| WATER PUMP TO HOUSING GASKET                                    | 1 138587  |
| DISTRIBUTOR HOUSING GASKET                                      | 1 125251  |
| 2 SUMP GASKET AND SEAL SET                                      | 1 GEG248K |
| Includes sump gasket set and standard front and rear oil seals. |           |
| OIL SEAL;   |           |
| front   | 1 104662  |
| rear  | 1 60862   |
| SUMP GASKET SET (excl. seals)                                   | 1 GEG248  |

#### The sump gasket set includes the following items:

|  |          |
|--|----------|
| 3 SUMP GASKET                          | 1 211123 |
| 4 CORK SEALING 'T' PIECE               | 2 59381  |
| 5 FELT ROPE, sealing rear main bearing | 2 58335  |
| 6 DISTRIBUTOR PEDESTAL SHIM            | 1 125251 |
| 7 WATER PUMP HOUSING                   |          |
| TO BLOCK GASKET                        | 1 138586 |
| 8 FRONT ENGINE PLATE GASKET            | 1 56389  |
| 9 FIGURE OF 8 LINER TO BLOCK SEAL      | 2 112789 |

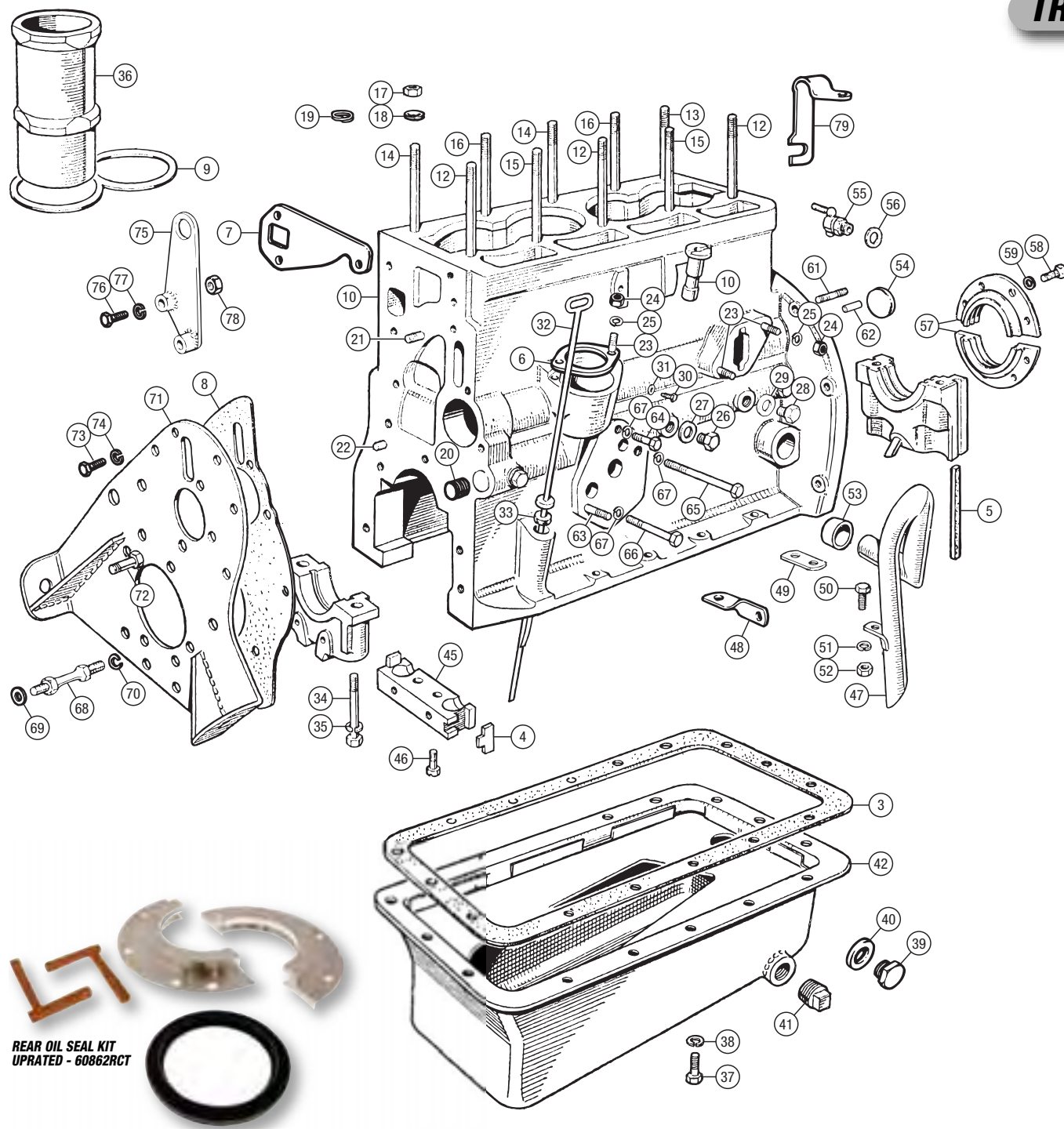
#### The following gaskets are also included in GEG248 and GEG248K but are not illustrated.

|   |          |
|---|----------|
| WATER PUMP TO HOUSING GASKET  | 1 138587 |
| OIL FILTER HOUSING GASKET   | 1 112146 |
| PETROL PUMP GASKET  | 1 139041 |
| TIMING COVER GASKET   | 1 211122 |
| OIL PUMP TO BLOCK GASKET  | 1 56282  |
| 10 BUSH, oil pump and distributor drive   | 1 56405  |
| 11 CYLINDER HEAD STUD & NUT KIT;  |          |
| The low port cylinder head stud & nut kit includes 10 each studs, washers and nuts; the high port kit includes 11 studs and 10 each washers & nuts. |          |
| low port head   | 1 RF4132 |
| TR2, TR3 to engine no. TS13051E.  |          |
| high port head  | 1 RF4133 |
| TR3 from engine no. TS13052E, TR3A, TR3B, TR4, TR4A.  |          |
| 12 STUD, cylinder head;   |          |
| 5" long (LH side front centre and rear)   | 3 106959 |
| TR2, TR3 to engine no. TS13051E.  |          |
| TR3 from engine no. TS13052E, TR3A, TR3B, TR4, TR4A without lifting bracket.  |          |
| 13 STUD, cylinder head;   |          |
| 5" long (RH side rear)  | 1 106959 |
| TR2, TR3 to engine no. TS13051E.  |          |
| 5 3/8" long (RH side rear)  | 1 113570 |
| TR3 from engine no. TS13052E, TR3A, TR3B, TR4, TR4A without lifting bracket.  |          |
| 5 9/16" long (RH side rear)   | 1 121734 |
| TR3 from engine no. TS13052E, TR3A, TR3B, TR4, TR4A without lifting bracket.  |          |
| 14 STUD, cylinder head;   |          |
| 5" long (RH side front and centre)  | 2 106959 |
| TR2, TR3 to engine no. TS13051E.  |          |
| 5 3/8" long (RH side front and centre)  | 2 113570 |
| TR3 from engine no. TS13052E, TR3A, TR3B, TR4, TR4A.  |          |

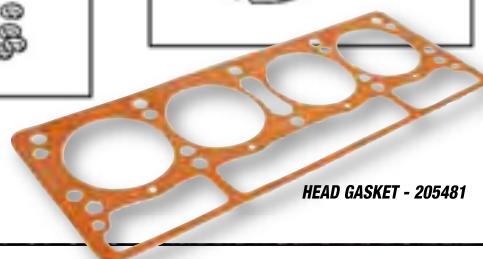
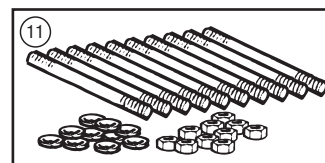
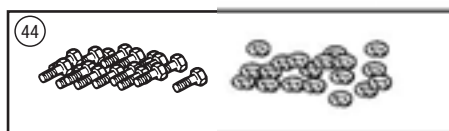
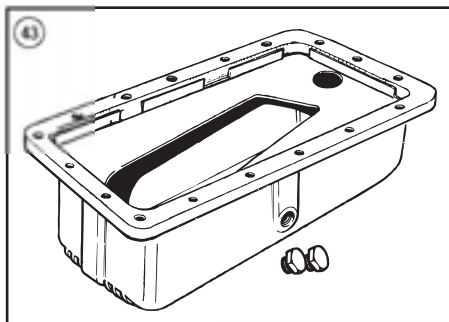
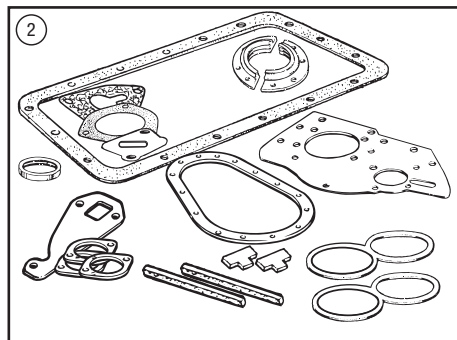
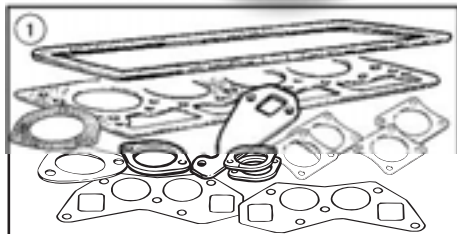
#### FULL ENGINE REBUILD KIT







REAR OIL SEAL KIT  
UPRATED - 60862RCT



HEAD GASKET - 205481



# TR2-4A

## ENGINE - EXTERNAL - 4 cylinder - TR2-4A

| No. | DESCRIPTION  | QTY REQ.                                       | PART No.  |
|-----|--|--|---|
| 15  | STUD, cylinder head;<br>9" long (LH side adjacent to cylinder liners)<br>TR2, TR3 to engine no. TS13051E<br>TR3 from engine no. TS13052E, TR3A, TR3B, TR4, TR4A.   | 2  | 106960  |
| 16  | STUD, cylinder head;<br>9" long (RH side adjacent to cylinder liners)<br>TR2, TR3 to engine no. TS13051E.<br>9 1/2" long (RH side adjacent to cylinder liners)<br>TR3 from engine no. TS13052E, TR3A, TR3B, TR4, TR4A  | 2  | 106960  |
| 17  | NUT, cylinder head stud  | 10   | 110962  |
| 18  | WASHER, plain  | 10   | WA112081  |
| 19  | LEAD LINGER<br><i>Use between washer and cylinder head to stop oil/water leakage along cylinder head attachment studs.</i>   | A/R  | 30123   |
| 20  | PLUG, screws into oil gallery ends   | 2  | PU1404  |
| 21  | STUD, engine plate attachment  | 1  | TE505111  |
| 22  | DOWEL, locating front engine plate   | 2  | DP514   |
| 23  | STUD, fuel pump & distributor pedestal   | 4  | TE505111  |
| 24  | NUT  | 4  | GHF201  |
| 25  | WASHER, locking  | 4  | GHF332  |
| 26  | PLUG, screwed into oil gallery   | 3  | 102785  |
| 27  | WASHER, copper, oil gallery plug   | 3  | 538532  |
| 28  | SCREW, oil gallery   | 1  | SH506041  |
| 29  | WASHER, copper   | 1  | 500464  |
| 30  | SCREW, dog pointed, cam bearings<br>TR3 from engine no. TS8997E, TR3A, TR3B, TR4, TR4A.  | 3  | 110462  |
| 31  | WASHER<br>TR3 from engine no. TS8997E, TR3A, TR3B, TR4, TR4A.  | 3  | GHF301  |
| 32  | DIPSTICK   | 1  | 102139  |
| 33  | SEAL, felt, on dipstick  | 1  | 32307   |
| 34  | BOLT, main bearing caps  | 6  | 57121   |
| 35  | WASHER, locking  | 6  | GHF335  |
| 36  | CYLINDER LINER;<br>83mm - Standard<br>83mm - 0.020" oversize<br>83mm - 0.030" oversize<br>83mm - 0.040" oversize<br>86mm - Standard<br>86mm - 0.020" oversize<br>86mm - 0.030" oversize<br>86mm - 0.040" oversize<br>87mm - - Standard<br>89mm - - Standard - set of 4 | 4<br>4<br>4<br>4<br>4<br>4<br>4<br>4<br>4<br>1 | 105539<br>105539.020<br>105539.030<br>105539.040<br>122166<br>122166.20<br>122166.30<br>122166.40<br>RF4196<br>122166.89SET |

### SUMP SCREWS; Without Closed Circuit Breather

|    |  |    |          |
|----|--|----|----------|
| 37 | SCREW, oil sump                          | 16 | SH505061 |
|    | BOLT, slave cyl. stay/breat clip to sump | 2  | BH505101 |
|    | SCREW, sump to front sealing block       | 1  | SH505051 |

### SUMP SCREWS; With Closed Circuit Breather

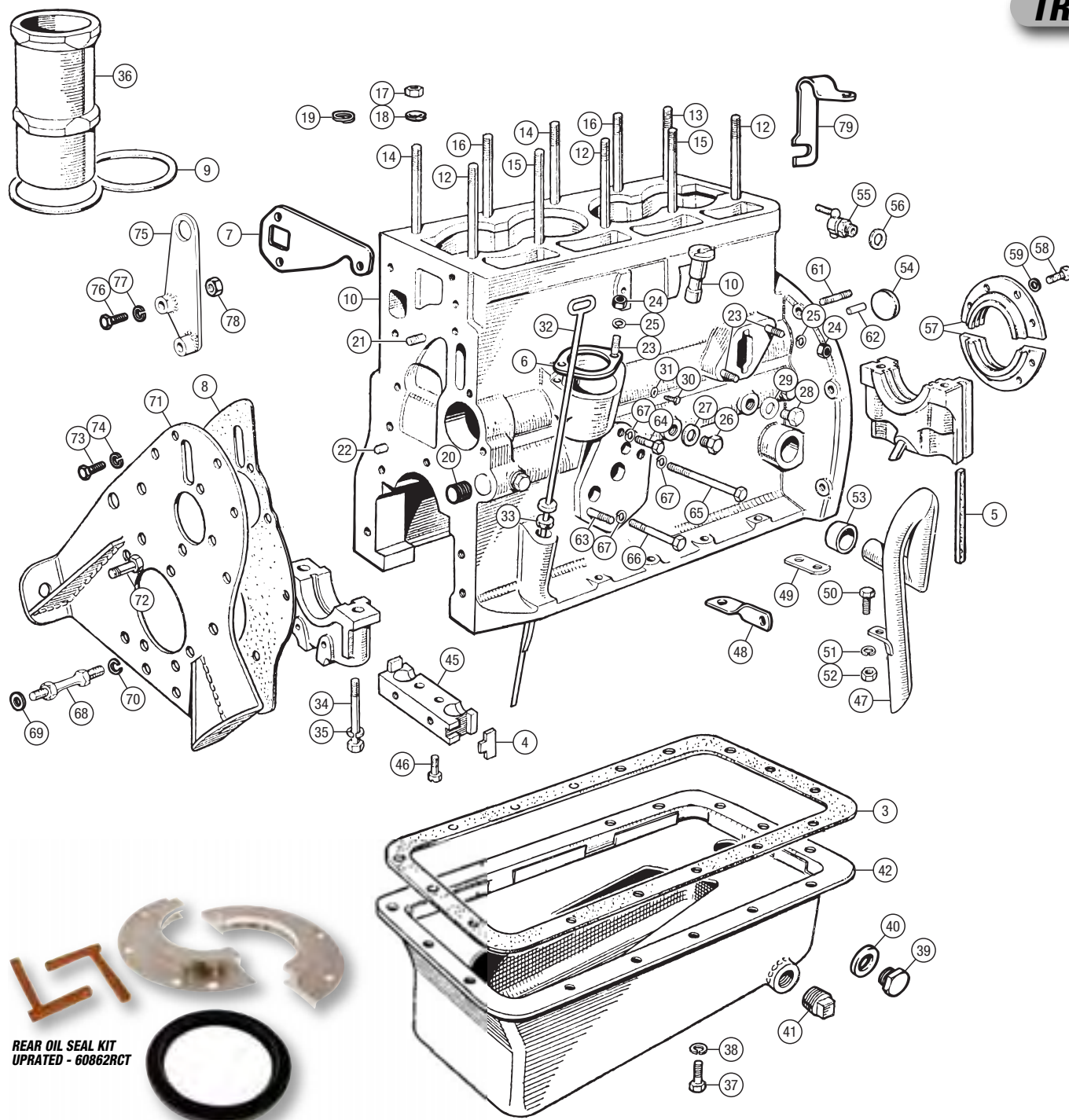
|  |                                    |    |          |
|--|------------------------------------|----|----------|
|  | SCREW, oil sump                    | 17 | SH505061 |
|  | BOLT, slave cylinder stay to sump  | 1  | BH505101 |
|  | SCREW, sump to front sealing block | 1  | SH505051 |

|    |   |             |                             |
|----|---|-------------|-----------------------------|
| 38 | WASHER, locking   | 19          | GHF332                      |
| 39 | PLUG, oil drain (shouldered type)<br>TR2, TR3 to engine no. TS18902E  | 1           | ULC1999                     |
| 40 | WASHER, fibre<br><i>Use with shouldered drain plug.</i>   | 1           | WF524                       |
| 41 | PLUG, oil drain, tapered;<br>square headed<br>TR3 from engine no. TS18902E, TR3A, TR3B, TR4, TR4A.<br>socket headed (alternative to 114774)<br>magnetic (alternative to 114774)<br><i>Oil sumps are interchangeable, but ensure the correct type of drain plug is fitted.</i>   | 1<br>1<br>1 | 114774<br>22G2115<br>155660 |
| 42 | SUMP, standard;<br>TR2, TR3 to engine no. TS18902E<br><i>Shouldered type drain plug.</i><br>TR3 from engine no. TS18902E, TR3A, TR3B, TR4, TR4A<br><i>Tapered type drain plug.</i>  | 1           | 56638                       |
| 43 | SUMP, alloy   | 1           | 301318                      |
| 44 | FITTING KIT, alloy sump<br><i>Includes correct length screws and washers.</i>   | 1           | 301318FK                    |
| 45 | FRONT SEALING BLOCK   | 1           | 55810                       |
| 46 | SCREW, front sealing block  | 2           | 56574                       |
| 47 | BREATHER PIPE;<br>TR2 to engine no. TS971E<br><i>(use with twisted bracket)</i><br><i>This pipe may only be used in crankcases (pt no 301148) prior to the change point unless modified by reducing the tube that fits in the crankcase from 2.53" to 1.22" beyond the dimples.</i><br>TR2 from engine no. TS972E, TR3, TR3A, TR3B, TR4, TR4A not closed circuit breathing.<br><i>(use with twisted bracket)</i><br>TR2 from engine no. TS972E, TR3, TR3A, TR3B, TR4, TR4A not closed circuit breathing<br><i>(use with flat bracket)</i> | 1<br>1<br>1 | 201650<br>202126<br>205020  |
| 48 | BRACKET, breather pipe, twisted<br><i>Use with pipe 201650 or 202126.</i>   |             | 106296                      |
| 49 | BRACKET, breather pipe, flat<br><i>Use with pipe 205020.</i>  | 1           | 120211                      |
| 50 | SCREW, pipe to bracket  | 1           | GHF120                      |

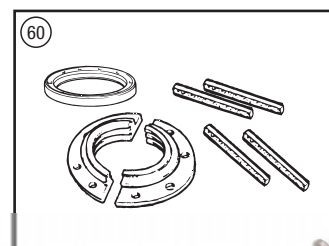
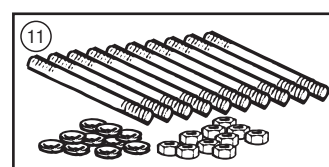
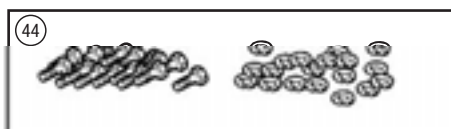
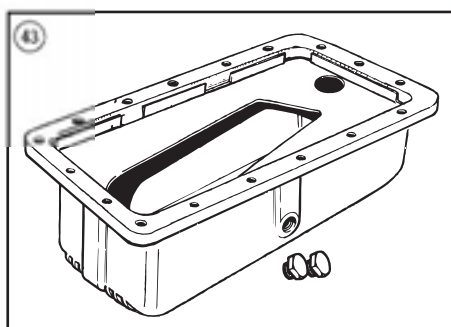
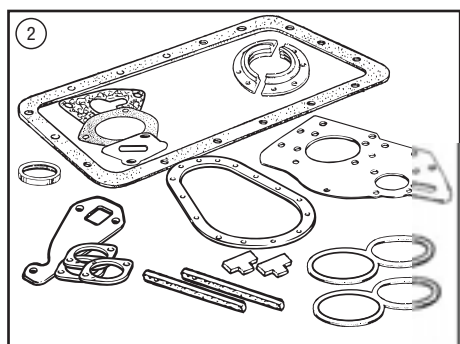
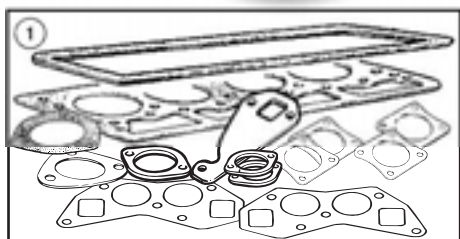
|    |   |             |                              |
|----|---|-------------|------------------------------|
| 51 | WASHER, locking   | 1           | GHF332                       |
| 52 | NUT, plain  | 1           | GHF201                       |
| 53 | PLUG, breather pipe hole in block<br>TR4, TR4A, closed circuit breathing.   | 1           | 132924                       |
| 54 | CORE PLUG, camshaft rear  | 1           | 44473                        |
| 55 | TAP, water drain, brass   | 1           | 61478                        |
| 56 | WASHER, fibre, drain tap to crankcase   | 1           | WF511A                       |
| 57 | OIL SEAL ASS'Y, rear crankshaft, original<br><i>2 piece aluminium assembly.</i>   | 1           | 60862                        |
| 58 | SCREW, oil seal halves to crank case  | 8           | SH504051                     |
| 59 | WASHER, locking   | 8           | GHF331                       |
| 60 | OIL SEAL KIT, rear crankshaft, uprated<br><i>Fillet of the replacement oil seal kit involves removing and machining the crankshaft seal area.</i>                               | 1           | 60862RCT                     |
| -  | REPLACEMENT OIL SEAL for above  | 1           | TT1032S                      |
| 61 | STUD, bell housing to crankcase - top rear;<br>TR2, TR3, TR3A,<br>TR3B TSF series (3 synchro gearbox).<br>TR3B TCF series, TR4,<br>TR4A (4 synchro gearbox)                     | 3           | TE505111                     |
| 62 | DOWEL, gearbox to crankcase locating  | 2           | DP619                        |
| 63 | STUD, oil pressure banjo & filter<br><i>Lower front position.</i>   | 1           | CHS2517                      |
| 64 | BOLT, oil filter attaching, upper front;<br>TR2<br>TR3 to engine no. TS9951E (bypass oil filter)<br>TR3 from engine no. TS9952E, TR3A, TR3B<br>TR4, TR4A (full flow oil filter) | 1<br>1<br>1 | GHF163<br>GHF163<br>SH505101 |
| 65 | BOLT, oil filter attaching, upper rear  | 1           | BH505321                     |
| 66 | BOLT, oil filter attaching, lower rear;<br>TR2<br>TR3 to eng. no. TS9951E (bypass oil filter)<br>TR3 from eng. no. TS9952E, TR3A, TR3B,<br>TR4, TR4A (full flow oil filter).    | 1<br>1<br>1 | HB874<br>HB874<br>BH505241   |
| 67 | WASHER, locking   | 3           | GHF332                       |
| 68 | PEDESTAL, timing cover support  | 1           | 56763                        |
| 69 | WASHER, fibre   | 1           | WF508                        |
| 70 | WASHER, locking   | 1           | GHF332                       |
| 71 | ENGINE PLATE, front;<br>TR2, TR3, TR3A, TR3B<br>TR4, TR4A   | 1<br>1      | 301251<br>304711             |
| 72 | PIN, timing chain tensioner pivot   | 1           | 58701                        |
| 73 | SCREW, front engine plate attachment  | 5           | SH505061                     |
| 74 | WASHER, locking   | 5           | GHF332                       |
| 75 | FRONT LIFTING EYE   | 1           | 121231                       |
| 76 | BOLT, front lifting eye to engine plate   | 2           | GHF104                       |
| 77 | WASHER, locking   | 2           | GHF332                       |
| 78 | NUT, plain  | 2           | GHF201                       |
| 79 | REAR LIFTING BRACKET<br><i>Fits to high port heads only.</i>  | 1           | 121752                       |







REAR OIL SEAL KIT  
UPDATED - 60862RCT





## TR2-4A

## Oil Filter

| No. | DESCRIPTION   | QTY REQ. | PART No. |
|-----|---|----------|----------|
| 1   | OIL FILTER ELEMENT AND SEALS<br><i>Includes a seal for either type of filter head.</i>                                | 1        | GFE104   |
| 2   | SEAL, container to filter head<br><i>For Purolator filter head.</i>   | 1        | 13H998   |
| 3   | SEAL, container to filter head<br><i>For Tecalomit filter head.</i>   | 1        | 507151   |
| 4   | STUD, oil pressure banjo & filter attach<br><i>Lower front position; suits both bypass and full flow oil filters.</i> | 1        | CHS2517  |
| 5   | BOLT, oil filter attaching, upper front;<br>TR2   | 1        | GHF163   |
|     | TR3 to engine no. TS9951E (bypass oil filter)   | 1        | GHF163   |
|     | TR3 from engine no. TS9952E, TR3A, TR3B, TR4, TR4A (full flow oil filter)   | 1        | SH505101 |
| 6   | BOLT, oil filter attaching, upper rear  | 1        | BH505321 |
| 7   | BOLT, oil filter attaching, lower rear;<br>TR2  | 1        | HB874    |
|     | TR3 to engine no. TS9951E (bypass oil filter)   | 1        | HB874    |
|     | TR3 from engine no. TS9952E, TR3A, TR3B, TR4, TR4A (full flow oil filter)   | 1        | BH505241 |
| 8   | WASHER, locking   | 3        | GHF332   |
| 9   | GASKET  | 1        | 112146   |
| 10  | OIL PIPE, filter head to bulkhead<br><i>Includes banjo.</i>   | 1        | 200646   |
| 11  | BANJO, on end of pipe   | 1        | 200646B  |
| 12  | DOMED NUT   | 1        | 14B2685  |
| 13  | COPPER WASHER (outer)<br><i>5/16" internal diameter.</i>  | 1        | 500469   |
| 14  | COPPER WASHER (inner)<br><i>3/8" internal diameter.</i>   | 1        | 233220A  |
| 15  | CLIP, 'P', oil pressure pipe to fuel pump stud  | 1        | 102227   |
| 16  | FLEXIBLE HOSE, s/s braided to oil gauge<br>TR2, TR3, TR3A, TR3B, early TR4  | 1        | 102238   |
| 17  | RIGID PIPE, bulkhead, flexible pipe to gauge<br>TR2, TR3, TR3A, TR3B, early TR4                                       | 1        | 202973   |
| 18  | NYLON PIPE - Late TR4, TR4A   | 1        | 138308   |
| 19  | CLIP, oil pressure pipe to bulkhead   | 2        | 59380    |
| 20  | SCREW, self tapping, clip to bulkhead   | 2        | YM506    |
| 21  | GROMMET   | 1        | 600395   |

## PUROLATOR TYPE BYPASS AND FULL FLOW FILTERS

|    |  |   |         |
|----|--|---|---------|
| 22 | FILTER HEAD, bypass oil filter;<br>TR2   | 1 | 501075  |
|    | TR3 to engine no. TS9951E  | 1 | 501075  |
|    | FILTER HEAD, fullflow oil filter;<br>TR3 from engine no. TS9952E to TS12649E                   | 1 | 503895  |
|    | TR3 from engine no. TS12650E   | 1 | 505300  |
|    | TR3A, TR3B, TR4, TR4A  | 1 | 505300  |
| 23 | CAP, filter bypass valve<br>TR3 from engine no. TS12650E, TR3A, TR3B, TR4, TR4A                | 1 | 505288  |
| 24 | WASHER, copper, filter bypass valve cap<br>TR3 from engine no. TS12650E, TR3A, TR3B, TR4, TR4A | 1 | 505290  |
| 25 | SPRING, filter bypass valve<br>TR3 from engine no. TS12650E, TR3A, TR3B, TR4, TR4A             | 1 | 505287  |
| 26 | BALL, filter bypass valve<br>TR3 from engine no. TS12650E, TR3A, TR3B, TR4, TR4A               | 1 | BL27    |
| 27 | NUT, locking adjusting screw   | 1 | 38054   |
| 28 | ADJUSTING SCREW, oil pressure  | 1 | 60416   |
| 29 | WASHER, lead linger  | 1 | 30123   |
| 30 | SPRING, relief valve   | 1 | 60414   |
| 31 | BALL, pressure relief valve  | 1 | BL27    |
| 32 | HOUSING, pressure relief valve   | 1 | 59615   |
| 33 | WASHER, relief valve seal to housing   | 1 | 500329  |
| 34 | SEAL, relief valve housing to filter head  | 1 | 500328  |
| 35 | BOLT, centre, oil filter container to head;<br>TR2, TR3 to engine no. TS12649E                 | 1 | 501078  |
|    | TR3 from engine no. TS12650E, TR3A, TR3B, TR4, TR4A  | 1 | 505289  |
| 36 | SEAL, bolt head to container   | 1 | 500321  |
| 37 | CONTAINER, oil filter housing  | 1 | 501077  |
| 38 | SPRING, fitted on centre bolt  | 1 | 500319  |
| 39 | WASHER, steel, seating rubber seal   | 1 | GHF302  |
| 40 | WASHER, rubber seal  | 1 | 7H28    |
| 41 | LOCATING PLATE, oil filter   | 1 | 500439  |
| 42 | CLIP, retaining plate, washers & spring<br><i>Retains items on bolt inside container.</i>      | 1 | 27H2573 |

## TECALAMIT TYPE FULL FLOW FILTER

|    |  |   |         |
|----|--|---|---------|
| 43 | FILTER HEAD - TR4  | 1 | 508770  |
| 44 | SEATING, screwed plug, filter bypass valve   | 1 | 508772  |
| 45 | BALL, filter bypass valve  | 1 | BL28    |
| 46 | SPRING, filter bypass valve  | 1 | 59609   |
| 47 | NUT, locking adjusting screw   | 1 | 508777  |
| 48 | WASHER, lead linger  | 1 | 30123   |
| 49 | ADJUSTING SCREW, oil pressure  | 1 | 59614   |
| 50 | SPRING, relief valve   | 1 | 59609   |
| 51 | BALL, pressure relief valve  | 1 | BL28    |
| 52 | HOUSING, pressure relief valve   | 1 | 508776  |
| 53 | WASHER, relief valve housing to filter head  | 1 | 505272  |
| 54 | BOLT, centre, oil filter container to head   | 1 | 507147  |
| 55 | SEAL, bolt head to container   | 1 | 37H1173 |
| 56 | CONTAINER, oil filter housing  | 1 | 507148  |
| 57 | SPRING, fitted on centre bolt  | 1 | 502484  |
| 58 | WASHER, steel, seating felt seal   | 1 | 502487  |
| 59 | WASHER, felt seal  | 1 | 502490  |
| 60 | LOCATING PLATE, oil filter   | 1 | 17H846  |
| 61 | CLIP, retaining plate and spring<br><i>Retains items on bolt inside container.</i> | 1 | 27H2573 |
| 62 | CLAMP NUT<br><i>Fitted from top in filter head.</i>                                | 1 | 508773  |
| 63 | SEAL, clamp nut to filter head   | 1 | 505268  |
| 64 | CIRCLIP, retaining clamp nut   | 1 | 508774  |

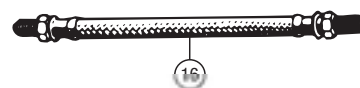
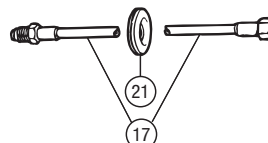
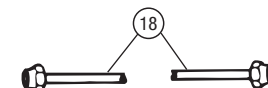
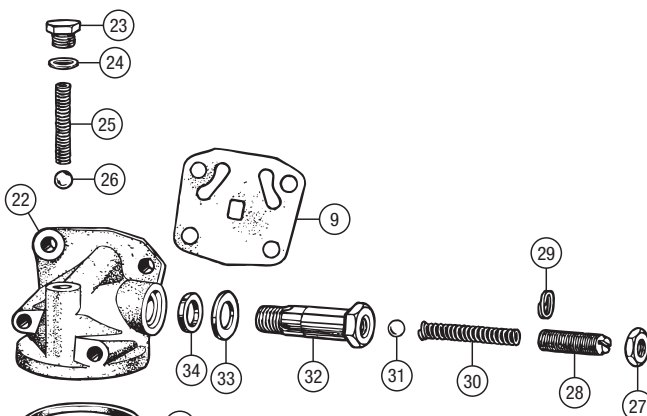
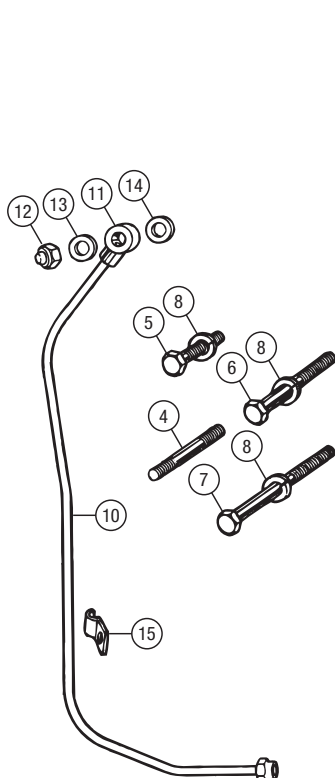
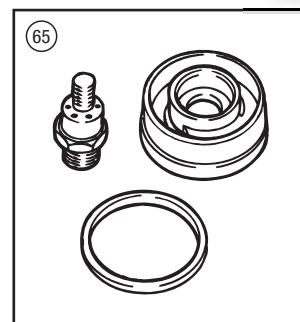
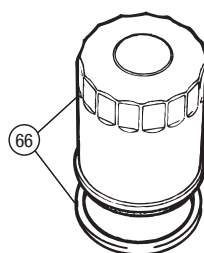
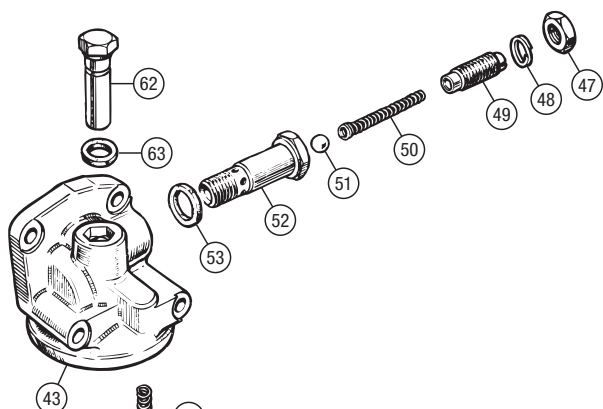
## SPIN-ON OIL FILTER CONVERSION ADAPTOR

This adaptor converts the standard 'bowl' type filter to the more efficient, anti-drain 'spin-on' cartridge type. It makes filter changing easier (and cleaner) and prevents oil draining back into the sump, thus avoiding the 'start-up rattle'.

|    |   |   |        |
|----|---|---|--------|
| 65 | ADAPTOR, spin-on oil filter conversion;<br>coarse thread for Purolator filter | 1 | RF4022 |
|    | fine thread for Tecalomit filter  | 1 | RF4023 |
| 66 | OIL FILTER ASSEMBLY, spin-on type<br><i>For conversion adaptor only.</i>      | 1 | RR1243 |







RIGID PIPE (TO GAUGE) - 202973



NYLON PIPE (TO GAUGE) - 138308

SPIN ON OIL FILTER  
CONVERSION - RF4023



# TR2-4A

## Internal Engine

|    |  |     |              |
|----|--|-----|--------------|
| 1  | CRANKSHAFT;<br>new   | 1   | 301815       |
|    | exchange   | 1   | 301815R      |
|    | <i>Reground with main bearings, big end bearings and thrust washers.</i> |     |              |
| 2  | MAIN BEARING SET;  |     |              |
|    | standard   | 1   | RF4014       |
|    | 0.010"   | 1   | RF4014.010   |
|    | 0.020"   | 1   | RF4014.020   |
|    | 0.030"   | 1   | RF4014.030   |
|    | 0.040"   | 1   | RF4014.040   |
|    | 0.050"   | 1   | RF4014.050   |
|    | 0.060"   | 1   | RF4014.060   |
| 3  | THRUST WASHER SET;   |     |              |
|    | standard   | A/R | RF4015       |
|    | 0.005"   | A/R | RF4015.005   |
|    | 0.008"   | A/R | RF4015.008   |
| 4  | CON ROD BEARING SET;   |     |              |
|    | standard   | 1   | RF4016       |
|    | 0.010"   | 1   | RF4016.010   |
|    | 0.020"   | 1   | RF4016.020   |
|    | 0.030"   | 1   | RF4016.030   |
|    | 0.040"   | 1   | RF4016.040   |
|    | 0.050"   | 1   | RF4016.050   |
|    | 0.060"   | 1   | RF4016.060   |
| 5  | CONNECTING ROD ASSEMBLY;   |     |              |
|    | TR2, TR3, TR3A,  | 4   | 201782       |
|    | TR4 to engine no. CT34071  | 4   | 211044       |
|    | TR4 from engine no. CT34072, TR4A  |     |              |
|    | <i>Must be fitted as balanced and weight matched sets.</i>               |     |              |
| 7  | BUSH, gudgeon pin  | 4   | C17164       |
| 8  | DOWEL, hollow, connecting cap to rod                                     | 4   | 106771       |
| 9  | TAB WASHER   | 4   | 105313       |
|    | TR2, TR3, TR3A, TR4 to engine no. CT34071.                               |     |              |
| 10 | BOLT, big end;   |     |              |
|    | use with tab washers   | 8   | 105312       |
|    | TR2, TR3, TR3A, TR4 to engine no. CT34071.                               |     |              |
|    | use without tab washers  | 8   | 138528       |
|    | TR4 from engine no. CT34072, TR4A.                                       |     |              |
| 11 | PISTON & LINER;  |     |              |
|    | 83mm - standard, set of 4  | 1   | AESA512      |
|    | 86mm - standard, set of 4  | 1   | RF4002       |
|    | 86mm - 0.020 oversize, set of 4  | 1   | RF4002.020   |
|    | 86mm - 0.030 oversize, set of 4  | 1   | RF4002.030   |
|    | 86mm - 0.040 oversize, set of 4  | 1   | RF4002.040   |
|    | 87mm PowerMax - std, single  | 4   | RF4001       |
|    | 89mm - standard, set of 4  | 1   | AE18510X     |
| 12 | CYLINDER LINER;  |     |              |
|    | 83mm - standard  | 4   | 105539       |
|    | 83mm - 0.020 oversize  | 4   | 105539.020   |
|    | 83mm - 0.030 oversize  | 4   | 105539.030   |
|    | 83mm - 0.040 oversize  | 4   | 105539.040   |
|    | 86mm - standard  | 4   | 122166       |
|    | 86mm - 0.020 oversize  | 4   | 122166.020   |
|    | 86mm - 0.030 oversize  | 4   | 122166.030   |
|    | 86mm - 0.040 oversize  | 4   | 122166.040   |
|    | 87mm - standard  | 4   | RF4196       |
|    | 89mm - standard, set of 4  | 1   | 122166.89SET |
| 13 | LINER TO BLOCK SEAL, figure of eight                                     | 2   | 112789       |
| 14 | PISTON;  |     |              |
|    | <i>Includes rings and gudgeon pin.</i>                                   |     |              |
|    | 83mm - standard, set of 4  | 1   | AE12655STD   |
|    | 83mm - 0.020 oversize, set of 4  | 1   | AE12655020   |
|    | 83mm - 0.030 oversize, set of 4  | 1   | AE12655030   |
|    | 86mm - standard, single  | 4   | RF4003       |
|    | 86mm - 0.020 oversize, single  | 4   | RF4003.020   |
|    | 86mm - 0.030 oversize, single  | 4   | RF4003.030   |
|    | 86mm - 0.040 oversize, single  | 4   | RF4003.040   |
|    | 87mm PowerMax - std, single  | 4   | AE18510KR    |
| 15 | GUDGEON PIN  | 4   | 60254        |
| 16 | CIRCLIP  | 8   | 45985        |



### 83mm 3 RING PISTONS

|    |           |   |            |
|----|-----------|---|------------|
| 17 | RING SET; |   |            |
|    | standard  | 1 | RF4134     |
|    | 0.020"    | 1 | RF4134.020 |
|    | 0.030"    | 1 | RF4134.030 |
|    | 0.040"    | 1 | RF4134.040 |
|    | 0.060"    | 1 | RF4134.060 |

### 83mm 4 RING PISTONS

|    |           |   |            |
|----|-----------|---|------------|
| 17 | RING SET; |   |            |
|    | standard  | 1 | RF4135     |
|    | 0.020"    | 1 | RF4135.020 |
|    | 0.030"    | 1 | RF4135.030 |
|    | 0.040"    | 1 | RF4135.040 |
|    | 0.060"    | 1 | RF4135.060 |

### 86mm 3 RING PISTONS

|    |           |   |            |
|----|-----------|---|------------|
| 17 | RING SET; |   |            |
|    | standard  | 1 | RF4004     |
|    | 0.020"    | 1 | RF4004.020 |
|    | 0.030"    | 1 | RF4004.030 |
|    | 0.040"    | 1 | RF4004.040 |

### 86mm 4 RING PISTONS

|    |           |   |            |
|----|-----------|---|------------|
| 17 | RING SET; |   |            |
|    | standard  | 1 | RF4005     |
|    | 0.020"    | 1 | RF4005.020 |
|    | 0.030"    | 1 | RF4005.030 |
|    | 0.040"    | 1 | RF4005.040 |

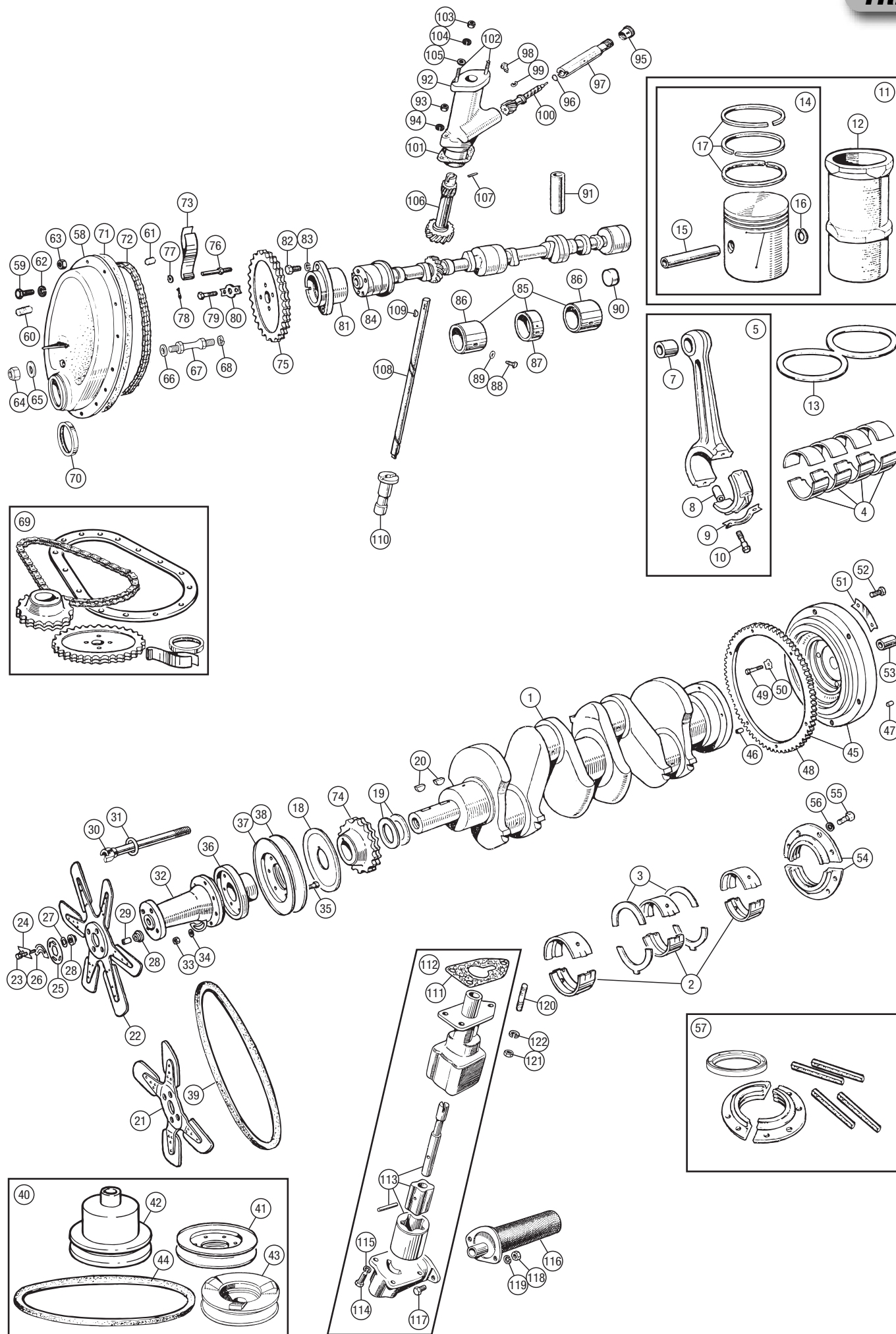
### 87mm OPTION PISTONS

|    |           |   |            |
|----|-----------|---|------------|
| 17 | RING SET; |   |            |
|    | Standard  | 1 | RF4136     |
|    | 0.030"    | 1 | RF4136.030 |

|    |   |     |          |
|----|---|-----|----------|
| 18 | OIL DEFLECTOR                               | 1   | 57196    |
| 19 | SHIM, sprocket;                             |     |          |
|    | 0.004"                                      | A/R | 56522    |
|    | 0.006"                                      | A/R | 56523    |
| 20 | KEY, crankshaft                             | 2   | WKN606   |
| 21 | FAN, 4-bladed;                              |     |          |
|    | TR2, TR3, TR3A                              | 1   | 202025   |
|    | TR4, TR4A                                   | 1   | 209792   |
| 22 | FAN, 6-bladed- TR4A optional                | 1   | 211986   |
| 23 | BOLT, fan attachment                        | 4   | BH605111 |
| 24 | TAB WASHER                                  | 2   | 107857   |
| 25 | LOCK PLATE, crank bolt                      | 1   | 108497   |
| 26 | BALANCE PIECE                               | 1   | 107858   |
| 27 | WASHER                                      | 4   | GHF301   |
| 28 | BUSH, fan mounting;                         |     |          |
|    | rubber                                      | 8   | 108496   |
|    | polyurethane                                | 8   | 108496P  |
| 29 | SLEEVE, steel                               | 4   | 108499   |
| 30 | BOLT, fan extension & pulley hub to crank;  |     |          |
|    | TR2, TR3, TR3A                              | 1   | 108498   |
|    | TR4, TR4A                                   | 1   | 128319   |
| 31 | SHIM, starting handle drive dog positioning | A/R | 108494   |
|    | <i>For cars with starting handle.</i>       |     |          |
| 32 | EXTENSION, fan hub;                         |     |          |
|    | TR2, TR3, TR3A                              | 1   | 108493   |
|    | TR4, TR4A                                   | 1   | 128318   |
| 33 | NUT, nyloc, pulley to hub                   | 6   | GHF271   |
| 34 | WASHER, under nut                           | 6   | WP127    |
| 35 | BOLT, pulley to hub                         | 6   | BH604111 |
| 36 | HUB, pulley                                 | 1   | 107250   |
| 37 | PULLEY, front half, dished                  | 1   | 107252   |
| 38 | PULLEY, rear half, flat                     | 1   | 110023   |
| 39 | FAN BELT, wide                              | 1   | GFB40975 |
|    | <i>Standard fitment.</i>                    |     |          |









## TR2-4A

### NARROW BELT CONVERSION

Fitting your 4 cylinder TR with a narrow fan belt is a case of choosing from the parts and kits listed here that are appropriate for your car.

There are several reasons why you should change from the original, wide belt to a narrow one; one is that of course you are always going to have more luck finding and buying a narrow belt (3/8" belts have been the standard for automotive use for many years) when you need one for servicing and repairs. There's also the fact that being what the industry almost always specified, the narrow belt benefits from years of development to make it more efficient and reliable.

If you're feeling particularly protective towards your engine, the damped narrow belt option gives you the opportunity to protect the crankshaft by significantly reducing harmonic shock waves. This does entail the elimination of the mechanical cooling fan and fan extension and the substitution of an electric cooling fan when the original crank pulley is replaced by the new damped pulley.

However, you do end up with a 'win-win' situation here because not only do you get a far better and more easily serviced fan belt on your car, but you also vastly improve the efficiency of the cooling system (the Achilles Heel of a 4 cylinder TR), too. For electric fan conversions, see 'Cooling Systems'.

For owners who want a narrow belt system but don't want to go as far as losing their friendly old mechanical cooling fan, an undamped narrow belt system can be chosen instead.

- |   |   |               |
|---|---|---------------|
| <b>40 NARROW BELT KIT;</b>  |   |               |
| undamped  | 1 | <b>RW3102</b> |
| <i>Fitment allows retention of mechanical cooling fan. Includes undamped alloy crankshaft pulley (using original fan extension), replacement alloy water pump pulley, alternator pulley, fan belt and fitting instructions.</i> |   |               |
| damped  | 1 | <b>RW3101</b> |
| <i>Fitment involves deletion of mechanical cooling fan. Includes damped alloy crankshaft pulley with spacer, washer and bolt, replacement alloy water pump pulley, alternator pulley, fan belt and fitting instructions.</i>    |   |               |

The following items are also serviced separately:

- |  |   |                    |
|--|---|--------------------|
| <b>41 PULLEY, crank, narrow belt,</b>                      |   |                    |
| undamped   | 1 | <b>107252ALLOY</b> |
| <i>Fitment allows retention of mechanical cooling fan.</i> |   |                    |
| <b>42 PULLEY, water pump, narrow belt</b>                  | 1 | <b>105537ALLOY</b> |
| <b>43 PULLEY, alternator, narrow belt;</b>                 |   |                    |
| 2 1/2" dia.  | 1 | <b>AEU1238</b>     |
| <i>For standard road use.</i>                              |   |                    |
| 2 3/4" dia.  | 1 | <b>12G1054</b>     |
| <i>For fast road use.</i>                                  |   |                    |
| <b>44 FAN BELT, narrow</b>                                 | 1 | <b>GCB10975</b>    |



**NARROW BELT KIT - RW3102**

- |  |     |                 |
|--|-----|-----------------|
| <b>45 FLYWHEEL;</b>  |     |                 |
| exchange, with ring gear   | 1   | <b>201475R</b>  |
| <i>TR2, TR3, TR3A to engine no. TS50000 (shrink-on ring gear).</i>                                   |     |                 |
| exchange, with ring gear   | 1   | <b>115785R</b>  |
| <i>TR3A from engine no. TS50001, TR4 (bolt-on ring gear).</i>  |     |                 |
| exchange, with ring gear   | 1   | <b>143105R</b>  |
| <i>TR4A (bolt-on ring gear).</i>   |     |                 |
| lightweight, without ring gear   | 1   | <b>143105LW</b> |
| <i>Bolt-on ring gear type. 8 bolt, 7 1/4" competition clutch only.</i>                               |     |                 |
| <b>46 DOWEL PIN, flywheel to crankshaft</b>  | 1   | <b>DP619</b>    |
| <b>47 DOWEL PIN, flywheel to cover;</b>  |     |                 |
| for spring clutch covers   | 2   | <b>UKC1937</b>  |
| for diaphragm clutch covers  | 3   | <b>UKC1937</b>  |
| RING GEAR (shrink-on)  | 1   | <b>201454</b>   |
| <i>TR2, TR3, TR3A to engine no. TS50000.</i>   |     |                 |
| <b>48 RING GEAR (bolt-on)</b>  | 1   | <b>202834</b>   |
| <i>TR3A from engine no. TS50001, TR4, TR4A.</i>  |     |                 |
| <b>49 BOLT, ring gear retaining</b>  | 6   | <b>112653</b>   |
| <i>TR3A from engine no. TS50001, TR4, TR4A.</i>  |     |                 |
| <b>50 TAB WASHER, ring gear bolts</b>  | 6   | <b>115776</b>   |
| <i>TR3A from engine no. TS50001, TR4, TR4A.</i>  |     |                 |
| <b>51 TAB WASHER, flywheel bolts</b>   | 2   | <b>56524</b>    |
| <i>TR2, TR3, TR3A, TR4 to engine no. CT34071.</i>  |     |                 |
| <b>52 BOLT, flywheel to crankshaft</b>   | 4   | <b>102065</b>   |
| <i>Use with tab washer; TR2, TR3, TR3A, TR4 to engine no. CT34071.</i>                               |     |                 |
| BOLT, self-locking, flywheel to crankshaft   | 4   | <b>138527</b>   |
| <i>Use without tab washer; TR4 from engine no. CT34072, TR4A.</i>                                    |     |                 |
| <b>53 BUSH, spigot</b>   | 1   | <b>47246</b>    |
| <i>Push fit in rear of crankshaft.</i>   |     |                 |
| <b>54 OIL SEAL ASS'Y, rear crank, original</b>   | 1   | <b>60862</b>    |
| <i>2 piece aluminium assembly.</i>   |     |                 |
| <b>55 SCREW, oil seal to crank case</b>  | 8   | <b>HU755</b>    |
| <b>56 WASHER, locking</b>  | 8   | <b>GHF331</b>   |
| <b>57 OIL SEAL KIT, rear crankshaft, uprated</b>   | 1   | <b>60862RCT</b> |
| <i>Fitment of the replacement oil seal kit involves removing and machining crankshaft seal area.</i> |     |                 |
| <b>58 COVER, timing chain</b>  | 1   | <b>203681</b>   |
| <b>59 SETSCREW;</b>  |     |                 |
| 7/8" long, UNC thread  | 7   | <b>HU857</b>    |
| 5/8" long, UNF thread  | 4   | <b>SH605051</b> |
| <i>When lifting eye not fitted.</i>  |     |                 |
| 5/8" long, UNF thread  | 2   | <b>SH605051</b> |
| <i>When lifting eye fitted.</i>  |     |                 |
| 1 1/2" long, UNF thread  | 2   | <b>GHF104</b>   |
| <i>When lifting eye fitted.</i>  |     |                 |
| <b>60 STUD</b>   | 1   | <b>TE505111</b> |
| <b>61 DOWEL, trim to correct length</b>  | 2   | <b>DP514</b>    |
| <i>5/16 diam. X 3/4 long.</i>  |     |                 |
| <b>62 WASHER, locking</b>  | 12  | <b>GHF332</b>   |
| <b>63 NUT, plain</b>   | 5   | <b>GHF201</b>   |
| <b>64 NUT, timing cover to pedestal</b>  | 1   | <b>GHF272</b>   |
| <b>65 WASHER, plain, outside timing cover</b>  | 1   | <b>GHF301</b>   |
| <b>66 WASHER, fibre, inside timing cover</b>   | 1   | <b>WF508</b>    |
| <b>67 PEDESTAL, timing cover support</b>   | 1   | <b>56763</b>    |
| <b>68 WASHER, locking, pedestal</b>  | 1   | <b>GHF332</b>   |
| <b>69 TIMING CHAIN KIT</b>   | 1   | <b>RF4024</b>   |
| <i>The kit includes items 70-75.</i>   |     |                 |
| <b>70 OIL SEAL, timing chain cover</b>   | 1   | <b>104662</b>   |
| <b>71 GASKET, timing chain cover</b>   | 1   | <b>211122</b>   |
| <b>72 TIMING CHAIN</b>   | 1   | <b>57151</b>    |
| <b>73 TENSIONER, timing chain</b>  | 1   | <b>43404</b>    |
| <b>74 SPROCKET, on crankshaft</b>  | 1   | <b>55971</b>    |
| <b>75 SPROCKET, on camshaft</b>  | 1   | <b>57113</b>    |
| <b>76 STUD, tensioner mounting</b>   | 1   | <b>58701</b>    |
| <b>77 WASHER, tensioner positioning</b>  | A/R | <b>WP18</b>     |
| <b>78 SPLIT PIN, tensioner to pin</b>  | 1   | <b>GHF500</b>   |
| <b>79 BOLT, cam sprocket retaining</b>   | 2   | <b>56370</b>    |
| <b>80 TAB WASHER, cam sprocket</b>   | 1   | <b>56293</b>    |
| <b>81 CAM BEARING, front</b>   | 1   | <b>60214</b>    |
| <b>82 BOLT, shouldered, front bearing</b>  | 2   | <b>56370</b>    |
| <b>83 WASHER, locking</b>  | 2   | <b>GHF332</b>   |
| <b>84 CAMSHAFT;</b>  |     |                 |
| new  | 1   | <b>301466</b>   |
| exchange   | 1   | <b>301466R</b>  |
| <b>85 CAM BEARING SET</b>  | 1   | <b>AEC3027S</b> |
| <i>The set includes items 86, 87.</i>  |     |                 |
| <b>86 CAM BEARING, centre and rear</b>   | 2   | <b>113522</b>   |
| <b>87 CAM BEARING, intermediate</b>  | 1   | <b>113523</b>   |
| <b>88 SCREW, dog pointed, cam bearings</b>   | 3   | <b>110462</b>   |
| <i>TR3 from engine no. TS8997E, TR3A, TR4, TR4A.</i>   |     |                 |
| <b>89 WASHER</b>   | 3   | <b>GHF301</b>   |
| <i>TR3 from engine no. TS8997E, TR3A, TR4, TR4A.</i>   |     |                 |
| <b>90 CORE PLUG, camshaft rear</b>   | 1   | <b>44473</b>    |
| <b>91 CAM FOLLOWER (tappet)</b>  | 8   | <b>57933</b>    |
| <b>92 PEDESTAL, distributor/tacho drive</b>  | 1   | <b>201623</b>   |
| <b>93 NUT, securing pedestal to block</b>  | 2   | <b>GHF201</b>   |
| <b>94 WASHER, locking</b>  | 2   | <b>GHF332</b>   |
| <b>95 SCREWED END, tacho drive</b>   | 1   | <b>60246</b>    |
| <b>96 OIL SEAL, tacho drive</b>  | 1   | <b>60247</b>    |
| <b>97 BEARING, tacho drive</b>   | 1   | <b>132472</b>   |
| <i>Complete with screwed end and oil seal.</i>   |     |                 |
| <b>98 SCREW, locating bearing in pedestal</b>  | 1   | <b>56305</b>    |
| <b>99 WASHER, locking</b>  | 1   | <b>GHF332</b>   |
| <b>100 GEAR, tacho drive</b>   | 1   | <b>106184</b>   |
| <b>101 GASKET SHIM, distributor pedestal to block;</b>   |     |                 |
| <i>Use to set correct drive gear fit in pedestal.</i>  |     |                 |
| thin   | A/R | <b>125251</b>   |
| <b>102 STUD, distributor to pedestal</b>   | 2   | <b>TE504081</b> |
| <b>103 NUT, plain, securing distributor</b>  | 2   | <b>GHF200</b>   |
| <b>104 WASHER, locking</b>   | 2   | <b>GHF331</b>   |
| <b>105 WASHER, securing distributor</b>  | 2   | <b>GHF300</b>   |
| <b>106 GEAR, driving</b>   | 1   | <b>106981</b>   |
| <i>Includes pin.</i>   |     |                 |
| <b>107 PIN, fitted in gear</b>   | 1   | <b>500975</b>   |
| <b>108 SHAFT, oil pump drive</b>   | 1   | <b>104966</b>   |
| <b>109 KEY, gear to shaft</b>  | 1   | <b>KW316</b>    |
| <b>110 BUSH, oil pump drive shaft</b>  | 1   | <b>56405</b>    |
| <b>111 GASKET, oil pump to block</b>   | 1   | <b>56282</b>    |



**OIL PUMP ASSEMBLY - 200155**

- |  |   |                 |
|--|---|-----------------|
| <b>112 OIL PUMP ASSEMBLY</b>             | 1 | <b>200155</b>   |
| <i>Includes items 113-115.</i>           |   |                 |
| <b>113 SPINDLE &amp; ROTOR, oil pump</b> | 1 | <b>504862</b>   |
| <b>114 SCREW, cover to oil pump</b>      | 4 | <b>SP1C</b>     |
| <b>115 WASHER, locking</b>               | 4 | <b>GHF331</b>   |
| <b>116 FILTER ASSEMBLY</b>               | 1 | <b>100682</b>   |
| <i>Includes strainer gauze.</i>          |   |                 |
| <b>117 SCREW, strainer to pump</b>       | 2 | <b>SH604051</b> |
| <b>118 NUT, securing strainer</b>        | 2 | <b>GHF200</b>   |
| <b>119 WASHER, locking</b>               | 2 | <b>GHF331</b>   |
| <b>120 STUD, block to oil pump body</b>  | 3 | <b>TE505111</b> |
| <b>121 NUT, plain</b>                    | 3 | <b>GHF201</b>   |
| <b>122 WASHER, locking</b>               | 3 | <b>GHF332</b>   |

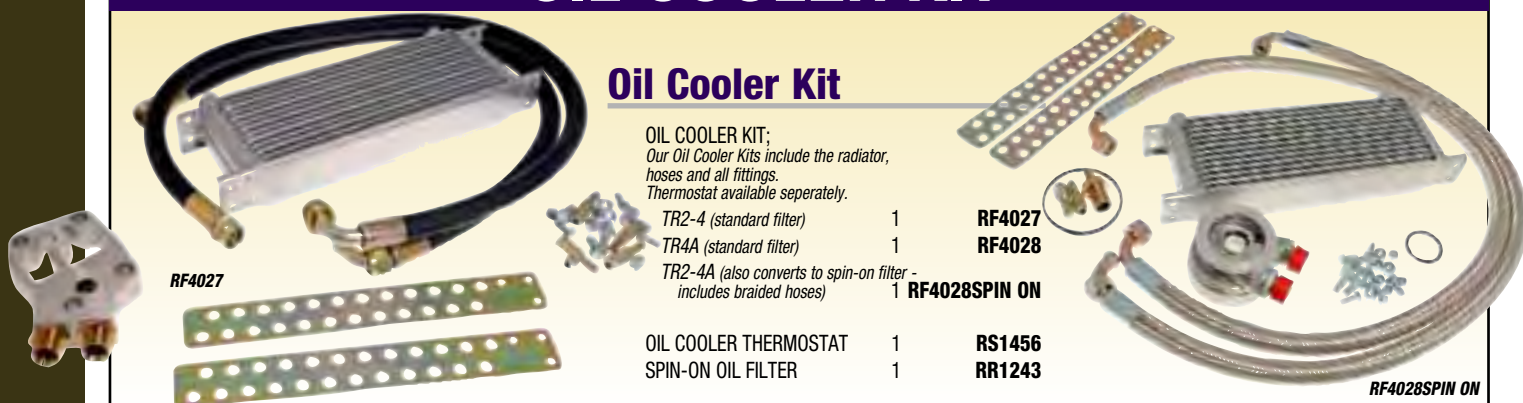
## OIL COOLER KIT

### Oil Cooler Kit

**OIL COOLER KIT;**  
Our Oil Cooler Kits include the radiator, hoses and all fittings.  
Thermostat available separately.

- |   |   |                      |
|---|---|----------------------|
| TR2-4 (standard filter)   | 1 | <b>RF4027</b>        |
| TR4A (standard filter)  | 1 | <b>RF4028</b>        |
| TR2-4A (also converts to spin-on filter - includes braided hoses) | 1 | <b>RF4028SPIN ON</b> |

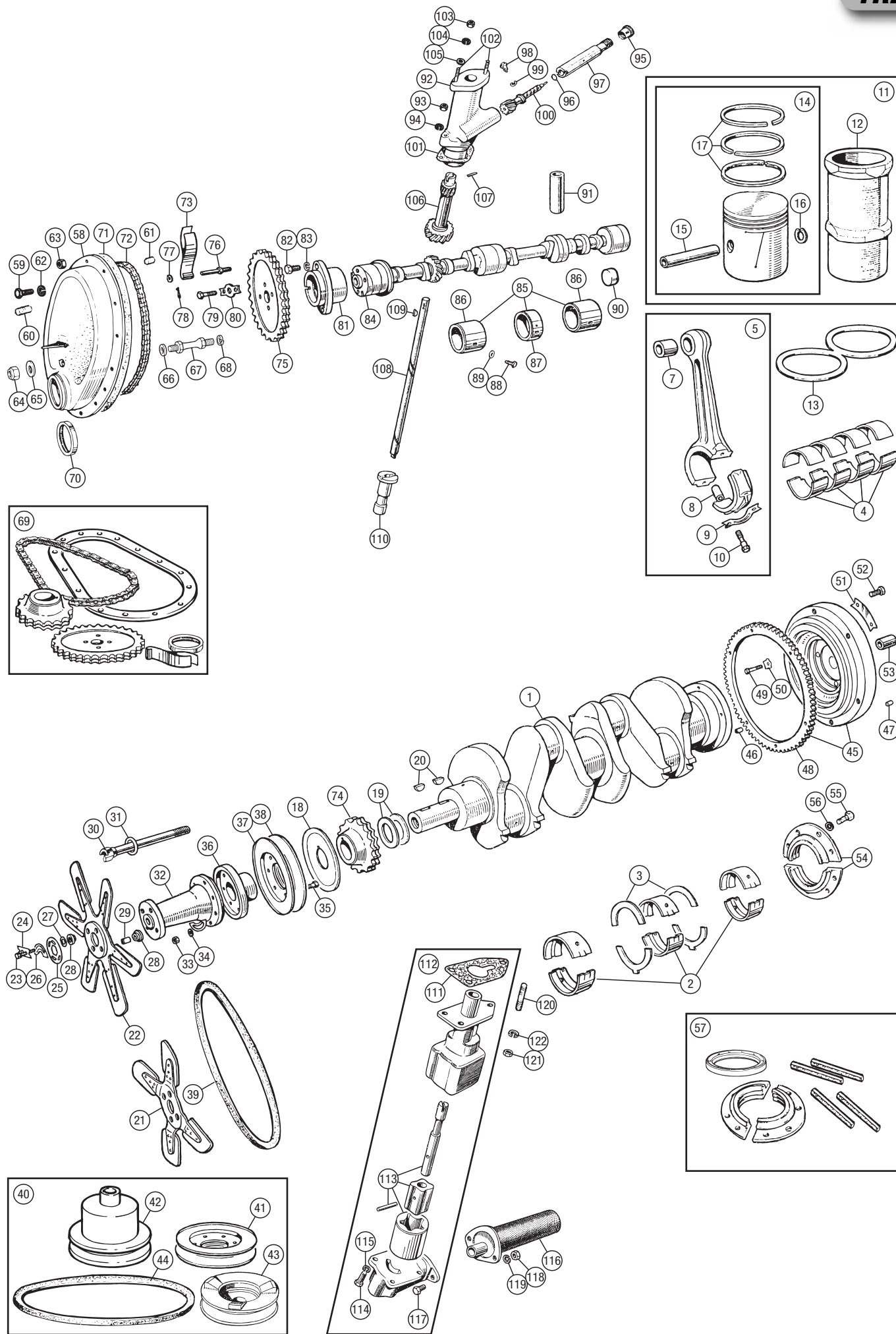
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|-----------------------|---|---------------|
| OIL COOLER THERMOSTAT | 1 | <b>RS1456</b> |
| SPIN-ON OIL FILTER    | 1 | <b>RR1243</b> |



**RF4027**

**RF4028SPIN ON**







| No. | DESCRIPTION | QTY REQ. | PART No. |
|-----|-------------|----------|----------|
|-----|-------------|----------|----------|

| No. | DESCRIPTION | QTY REQ. | PART No. |
|-----|-------------|----------|----------|
|-----|-------------|----------|----------|

| No. | DESCRIPTION | QTY REQ. | PART No. |
|-----|-------------|----------|----------|
|-----|-------------|----------|----------|

## TR2-4A

### New Cylinder Heads

Brand new cylinder heads and cylinder head assemblies are available in a choice of cast iron or alloy materials. These cylinder heads are all very close, top quality reproductions of the later 'high port' TR4 and TR4A style castings.

Two stages of build are offered:

- Cylinder Head - with valve guides and seats for standard valves fitted (but without valves, springs and caps); or
- Cylinder Head Assembly - completely finished and assembled with standard valves.

Note that the manufacturer recommends as much new hardware as practicable is used when installing a new head to ensure as good a fit as possible.

Also note that while engines with cast iron heads require the original Triumph recommended anti-freeze mixture, engines with alloy heads will require 100% summer coolant to prevent a sacrificial (electrolytic) corrosion reaction between the alloy and iron engine castings.

All cylinder heads listed are to lead free specification.

|   |  |   |         |
|---|--|---|---------|
| 1 | CYLINDER HEAD;                                     |   |         |
|   | with valve guides and seats                        | 1 | 511695  |
|   | Cast iron; 'high port' TR4 and TR4A style casting. |   |         |
|   | with valve guides and seats                        | 1 | 511695A |
|   | Alloy; 'high port' TR4 and TR4A style casting.     |   |         |
|   | CYLINDER HEAD ASSEMBLY, complete;                  |   |         |
|   | 'High port' TR4 and TR4A style casting.            |   |         |
|   | cast iron  | 1 | 514748  |
|   | alloy  | 1 | 514748A |

### Cylinder Head Rebuild Kit

This kit contains everything you need to recondition your cylinder head. We assume you will have any required machining done.

**Kit contains:-**

|                 |                |
|-----------------|----------------|
| Inlet valves    | Exhaust valves |
| Valve springs   | Valve guides   |
| Head gasket set |                |

Additionally why not add some or all of the following options to the rebuild kit:

|              |             |
|--------------|-------------|
| Rocker shaft | Rocker arms |
|--------------|-------------|

#### CYLINDER HEAD REBUILD KIT;

|                                |           |
|--------------------------------|-----------|
| TR2                            | RW3204    |
| TR3 from TS13052E, TR3A, TR3B, |           |
| TR4 to CT21470                 | RF4017RBK |
| TR4 from CT21471, TR4A         | RF4018RBK |

Owners of TR3s with engines prior to TS13052E - i.e. with low port head and H6 carburettors - should purchase cylinder head rebuild kit part no. RF4017RBK along with low port manifold gaskets part no. 106937 (order two off) to replace the high port items contained in the kit.

### Valves, Guides & Springs

|   |  |   |        |
|---|--|---|--------|
| 2 | SEAL, valve stem   | 8 | AEK113 |
|   | Supplementary filment. See item 79 - page 264 ref Rocker Feed Kit & Oil Consumption. |   |        |

#### TRIPLE EXHAUST AND TWIN INLET VALVE SPRINGS;

|   |  |   |        |
|---|--|---|--------|
| 3 | COTTER, split, valve retaining, pair   | 8 | 106663 |
| 4 | VALVE COLLAR, lower  | 4 | 108242 |
|   | Fitted to exhaust valves only (triple spring).   |   |        |
| 5 | COLLAR, valve spring, upper  | 8 | 105803 |
| 6 | VALVE SPRING SET   | 1 | RF4020 |
|   | Includes 16 uprated springs (double type) for inlet & exhaust.                           |   |        |
|   | The auxiliary exhaust valve springs (102564) are not necessary when installing this set. |   |        |
| 7 | VALVE SPRING, outer  | 8 | 107492 |
| 8 | VALVE SPRING, inner  | 8 | 107493 |
| 9 | VALVE SPRING, auxiliary  | 4 | 102564 |
|   | Fitted to exhaust valves only. Not required when fitting RF4020.                         |   |        |

#### TWIN EXHAUST AND TWIN INLET VALVE SPRINGS;

|    |                              |   |        |
|----|------------------------------|---|--------|
| 10 | COLLAR, valve spring         | 8 | 142137 |
|    | COLLAR, valve spring (alloy) | 8 | RW3001 |
| 11 | VALVE SPRING SET             | 1 | RF4021 |
|    | Includes 16 springs.         |   |        |
| 12 | VALVE SPRING, outer          | 8 | 142135 |
| 13 | VALVE SPRING, inner          | 8 | 142136 |

#### VALVES & GUIDES

|    |   |   |         |
|----|---|---|---------|
| 14 | EXHAUST VALVE 3/8" dia. stem                                    | 4 | 108806  |
|    | TR2, TR3, TR3A, TR4 to CT21470.                                 |   |         |
| 15 | EXHAUST VALVE 5/16" dia. stem                                   | 4 | 136567  |
|    | TR4 from CT21471, TR4A.   |   |         |
|    | Note: All exhaust valves that we sell are lead free compatible. |   |         |
| 16 | INLET VALVE, standard material                                  | 4 | 107626  |
| 17 | GUIDE, 3/8" dia. stem exhaust valve                             | 4 | 108239  |
|    | TR2, TR3, TR3A, TR4 to CT21470.                                 |   |         |
| 18 | GUIDE, 5/16" dia. stem exhaust valve;                           |   |         |
|    | TR4 from CT21471, TR4A  |   |         |
|    | standard  | 4 | 58923   |
|    | uprated   | 4 | 58923UR |
|    | GUIDE, conversion, exhaust valve                                | 4 | 136575  |
|    | Allows later exhaust valves to be fitted to early head.         |   |         |
| 19 | GUIDE, inlet valve;   |   |         |
|    | standard  | 4 | 58923   |
|    | uprated   | 4 | 58923UR |

### Rocker Gear

|    |   |     |            |
|----|---|-----|------------|
| 20 | END CAP, rocker shaft   | 2   | 60733      |
| 21 | SHAFT, rocker;  |     |            |
|    | standard  | 1   | 111064     |
|    | uprated (tuftrided)   | 1   | 111064UR   |
| 22 | SCREW, shaft retaining  | 1   | 42880      |
| 23 | WASHER, locking, cupped   | 1   | 510397     |
|    | TR2, TR3, TR3A, TR4; if fitted.   |     |            |
| 24 | PIN, retainer   | 2   | 500975     |
| 25 | SPRING, end   | 2   | 44630      |
| 26 | SPRING, intermediate;   |     |            |
|    | TR2, TR3, TR3A,   |     |            |
|    | TR4 to engine no. CT11858E  | 2   | 128075     |
|    | TR4 from engine no. CT11859E, TR4A.   | 2   | 130481     |
| 27 | SPRING, centre  | 1   | 128074     |
| 28 | PEDESTAL, front & intermediate  | 3   | 112546     |
| 29 | PEDESTAL, rear (drilled)  | 1   | 112545     |
| 30 | SHIM, pedestal, 0.06"   | A/R | 144973SHIM |
| 31 | SPACER SET  | 1   | RF4195     |
|    | Replaces springs on rocker shaft; uprated specification.  |     |            |
| 32 | NUT, rocker pedestal to cylinder head   | 4   | GHF202     |
| 33 | WASHER;   |     |            |
|    | locking   | 4   | GHF333     |
|    | TR2, TR3, TR3A, TR4 to engine no. CT6039E.  |     |            |
|    | plain   | 4   | WP9        |
|    | TR4 from engine no. CT6040E, TR4A.  |     |            |
| 34 | ROCKER ARM, with bush, no. 1,3,5,7  | 4   | 108012     |
| 35 | ROCKER ARM, with bush, no. 2,4,6,8  | 4   | 108014     |
| 36 | BUSH, rocker arm  | 16  | 44370      |
|    | Two per rocker arm. Beam to fit.  |     |            |
| 37 | ADJUSTER, rocker arm  | 8   | 109495     |
| 38 | JAM NUT, locking adjuster   | 8   | 57110      |
| 39 | CAM FOLLOWER  | 8   | 57933      |
| 40 | PUSHROD   | 8   | 106968     |
|    | The only type now available is the later 3/8" diameter item which is stronger than the early 5/16" diameter push rod and may be used to replace it (but only if a matched set is fitted). |     |            |

### Rocker Cover

|    |   |   |             |
|----|---|---|-------------|
| 41 | ROCKER COVER, original steel                                | 1 | See item 44 |
|    | 5 different types used, none now available.                 |   |             |
| 42 | PLUG, screwed, blanking breather hole                       | 1 | 129077      |
|    | When breather pipe is not fitted in threaded breather hole. |   |             |
| 43 | WASHER, fibre, sealing breather plug                        | 1 | WF511A      |
| 44 | ROCKER COVER, alloy, polished finish;                       |   |             |
|    | Includes cap.   |   |             |
|    | not ventilated  | 1 | RF4115      |
|    | ventilated  | 1 | RF4115V     |
| 45 | CAP, oil filler, bayonet                                    | 1 | RF4115CAP   |
|    | For aluminium rocker cover.                                 |   |             |
| 46 | CAP, oil filler, push-on;                                   |   |             |
|    | TR2, TR3 to engine no. TS18229E                             | 1 | 106386      |
|    | TR3 from engine no. TS18230E                                | 1 | 113569      |
|    | TR3A, TR4 to engine no. CT14233E                            | 1 | 113569      |
| 47 | DECAL, oil filler cap                                       | 1 | RW3040      |
|    | TR2, TR3, TR3A, TR4 to engine no. CT14233E.                 |   |             |
| 48 | CAP, oil filler;  |   |             |
|    | chromed, bayonet  | 1 | GZC1400     |
|    | TR4 from engine no. CT14234E                                |   |             |
|    | with closed circuit breathing.                              |   |             |
|    | zinc plated, bayonet  | 1 | 598231      |
|    | TR4 from engine no. CT14234E                                |   |             |
|    | with closed circuit breathing.                              |   |             |
|    | bayonet   | 1 | 143393      |
|    | TR4A.   |   |             |
| 49 | DECAL, oil filler cap                                       | 1 | CRST262     |
|    | TR4 from engine no. CT14234E                                |   |             |
|    | with closed circuit breathing, TR4A.                        |   |             |
| 50 | NUT, nyloc, rocker cover attaching                          | 2 | GHF222      |
| 51 | WASHER, steel   | 2 | GHF301      |
| 52 | WASHER, fibre   | 2 | WF508       |

### Heater Fittings

#### TR2, TR3, TR3A

|    |                                  |   |             |
|----|----------------------------------|---|-------------|
| 53 | WATER VALVE, heater;             |   |             |
|    | standard                         | 1 | 100399      |
|    | uprated (kit)                    | 1 | 100399URKIT |
|    | Allows in-car heater adjustment. |   |             |
| 54 | EXTENSION TUBE                   | 1 | 107994      |

#### TR4, TR4A

|    |  |   |             |
|----|--|---|-------------|
| 55 | WATER VALVE, heater;                                   |   |             |
|    | standard   | 1 | 565755      |
|    | uprated (kit)  | 1 | 565755URKIT |
|    | For use with standard or uprated heater (see page 47). |   |             |
| 56 | ADAPTOR, water valve to cylinder head                  | 1 | 133061      |

#### TR2-4A

|    |   |   |        |
|----|---|---|--------|
| 57 | SCREWED PLUG, water outlet                      | 1 | 114774 |
|    | Use on cylinder head when heater is not fitted. |   |        |

### Cylinder Head Gaskets

The low port head gasket set is strictly speaking for TR2s only. Owners of TR3s with low port heads (and H6 carburettors) should purchase gasket set RF4211 which includes the high port head set GEG178 along with two low port manifold gaskets (106937) to replace the high port items contained in the set.

|    |   |   |        |
|----|---|---|--------|
| 58 | HEAD GASKET SET;  |   |        |
|    | low port head (H4 Carbs)  | 1 | 501678 |
|    | TR2, TR3 to engine no. TS13051E; 83mm & 86mm bore.                |   |        |
|    | low port head (H6 Carbs)  | 1 | RF4211 |
|    | TR3 to engine no. TS13051E; 83mm & 86mm bore.                     |   |        |
|    | high port head  | 1 | GEG178 |
|    | TR3 from engine TS13052E, TR3A, TR3B, TR4, TR4A; up to 89mm bore. |   |        |
| 59 | HEAD GASKET;  |   |        |
|    | 83mm & 86mm bores & oversizes                                     | 1 | 205481 |
|    | steel shim type for up to 89mm bore                               | 1 | 202775 |
|    | Uprated.  |   |        |

Head gasket sets include the following items:

|    |  |   |        |
|----|--|---|--------|
| 59 | HEAD GASKET;                               |   |        |
|    | 83mm & 86mm bores & oversizes              | 1 | 205481 |
| 60 | ROCKER COVER GASKET                        | 1 | GEG437 |
| -  | MANIFOLDS TO HEAD GASKET;                  |   |        |
|    | low port head                              | 2 | 106937 |
|    | TR2, TR3 to engine no. TS13051E.           |   |        |
|    | high port head                             | 2 | 113122 |
|    | TR3 from engine TS13052E, TR3A, TR4, TR4A. |   |        |
| -  | DOWNPIPE GASKET;                           |   |        |
|    | TR2, TR3, TR3A, TR4 (single pipe)          | 1 | GEG718 |
|    | TR4A (twin pipe)                           | 1 | GEG724 |
| -  | THERMOSTAT GASKET                          | 1 | GTG103 |
| -  | CARBURETTER GASKET (1 3/4")                | 4 | 112867 |
| -  | WATER PUMP TO HOUSING GASKET               | 1 | 138587 |
| -  | GASKET, distributor pedestal               | 1 | 125251 |

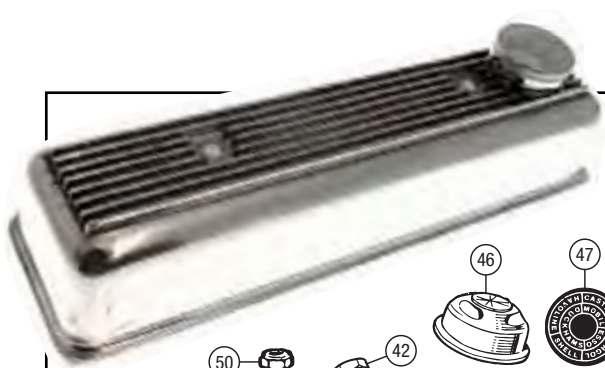
### Cylinder Head Attachments

|    |  |     |           |
|----|--|-----|-----------|
| 61 | TUBE, pushrod (part of cylinder head assembly)   | 8   | 100792    |
| 62 | CORE PLUG;   |     |           |
|    | dished (TR2, TR3, TR3A, TR4, early TR4A)   | 1   | 27378     |
|    | cupped (Late TR4A)   | 1   | 144648    |
| 63 | STUD, rocker pedestal to cyl head  | 4   | TE506241  |
| 64 | STUD, rocker cover to cylinder head;   |     |           |
|    | for original rocker covers   | 2   | 59011     |
|    | for alloy rocker cover   | 2   | TE505341  |
| 65 | CORE PLUG, top face of head  | 1   | PS1603    |
|    | Aluminium screwed plug.  |     |           |
| 66 | SCREW, rocker feed oil way   | 1   | SH506031L |
|    | In rear corner of cylinder head.   |     |           |
| 67 | WASHER, sealing oil way plug   | 1   | 500464    |
| 68 | STUD & NUT KIT, manifolds to head  | 1   | RW3191    |
|    | Kit includes 8 studs, 8 nuts and 8 washers.  |     |           |
| 69 | STUD, manifold to head;  |     |           |
|    | 11 1/16" long  | 2   | 58688     |
|    | Use if no engine lifting bracket fitted.   |     |           |
|    | 11 1/16" long  | 1   | 58688     |
|    | Use if engine lifting bracket fitted.  |     |           |
| 70 | STUD, manifold to head, 1 1/16" long   | 1   | 58917     |
|    | Use if engine lifting bracket fitted.  |     |           |
| 71 | STUD, manifold to head, 2 1/16" long   | 2   | 102474    |
| 72 | STUD, manifold to head, 2 3/8" long  | 4   | 107055    |
| 73 | WASHER, locking  | 8   | GHF333    |
| 74 | NUT, manifold attachment   | 8   | 56675     |
| 75 | DOWEL PIN, manifold to head  | 2   | DP514     |
| 76 | CYLINDER HEAD NUT  | 10  | 110962    |
| 77 | WASHER, cylinder head nut  | 10  | WA112081  |
| 78 | LEAD LINGER  | A/R | 30123     |
|    | Use between washer and cylinder head to stop water/oil leakage along cylinder head attachment studs. |     |           |

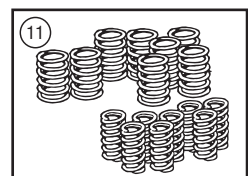
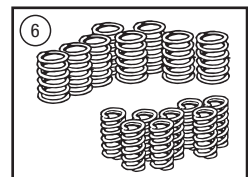
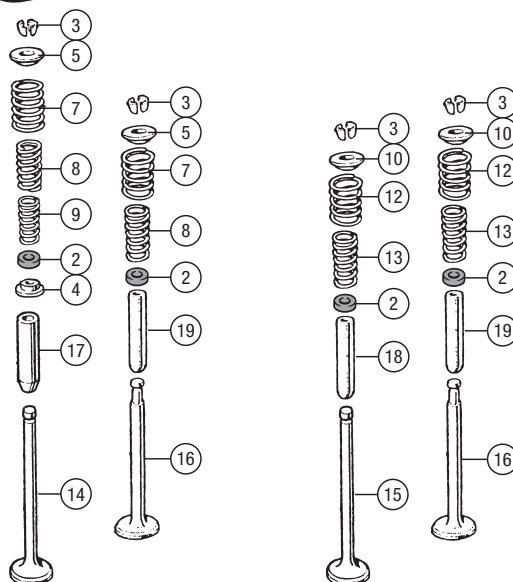
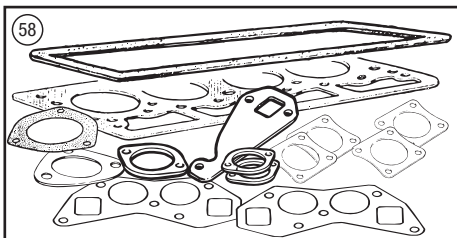
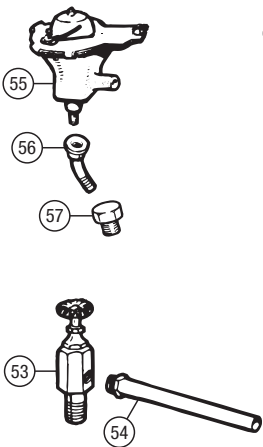
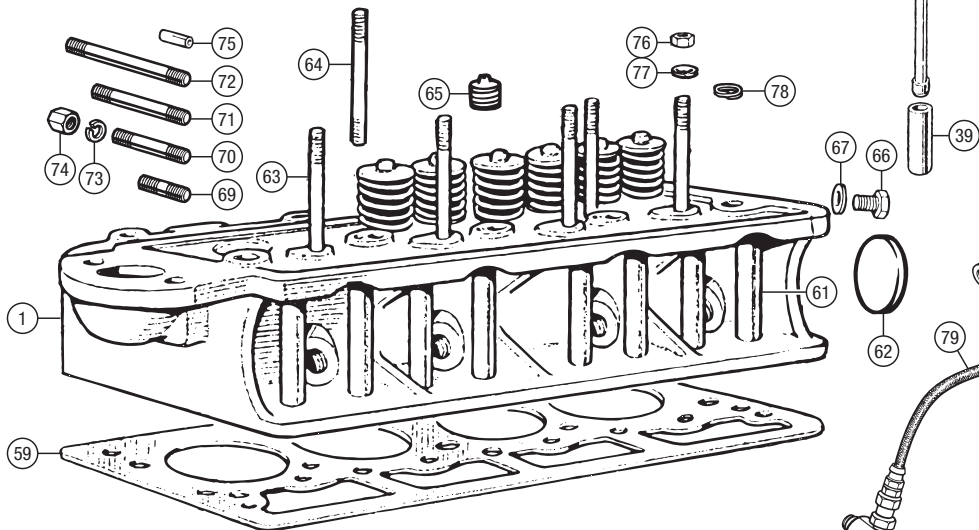
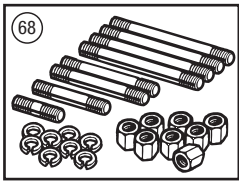
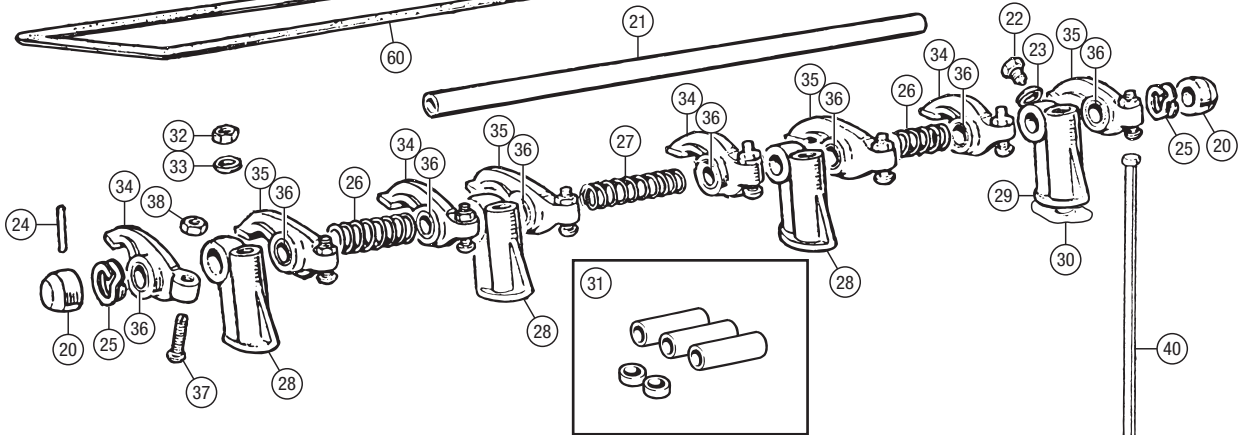
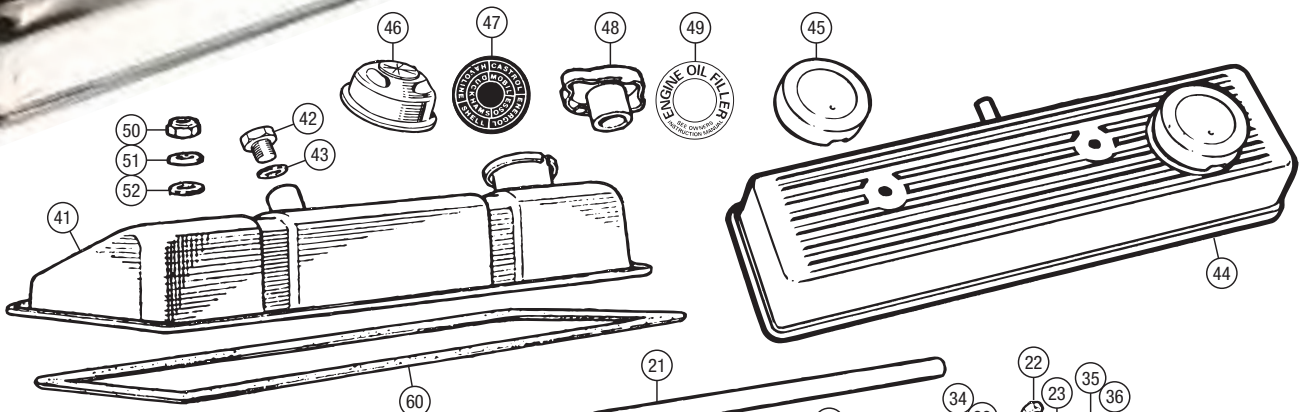
### Rocker Feed Kit

|    |  |   |        |
|----|--|---|--------|
| 79 | ROCKER FEED KIT  | 1 | RF4019 |
|    | External fitment to engine to improve oil feed to the rocker shaft and valve train. Please see Accessories for detailed information. |   |        |





ALLOY ROCKER COVER  
RF4115





**TR5-250****ENGINE REBUILD KITS****Full Engine Rebuild Kit**

This kit contains everything you need to recondition your full engine. We assume you will have all machining done as required.

**IMPORTANT** - Piston sets are supplied in +20 oversize, bearing sets and thrust washer sets are supplied in standard size.

Please advise specific sizes required at time of ordering.

**Kit contains:-**

Set of 6 pistons (state size required)  
Main & big end bearing shells (state size required)  
Thrust washers (state size required)  
Water pump gasket  
Water pump housing gasket  
Cylinder head gasket (non-recessed)  
Rocker cover gasket  
Manifold gasket  
Exhaust downpipe gasket  
Thermostat gasket  
Crankshaft rear oil seal  
Sump gasket set  
Timing cover oil seal  
Inlet valves  
Exhaust valves  
Inlet valve guides  
Exhaust valve guides  
Valve spring set  
Valve stem oil seals  
Oil pressure relief valve sealing washer  
Oil pressure relief valve spring  
Oil pressure relief valve  
Oil pressure switch  
Cam follower set (large diameter)  
Crankshaft sprocket  
Camshaft sprocket tab washer  
Timing chain  
Timing chain tensioner  
Oil pump  
Oil filter

**Additionally why not add some or all of the following options to the rebuild kit:**

Crankshaft  
Camshaft  
Rocker shaft  
Rocker arms  
Con rods

In addition to the rebuild kits, the engine section of this catalogue lists all the other parts that you might want to buy, such as engine studs, cylinder head nuts, water pump etc.

**FULL ENGINE REBUILD KIT;**

**TR5 Pi** from CP1E  
**TR250** from CC1E

**RF4008RBK**  
**RF4009RBK**

**Short Engine Rebuild Kit**

This kit contains everything you need to recondition your short engine. We assume you will have all machining done as required.

**IMPORTANT** - Piston sets are supplied in +20 oversize, bearing sets and thrust washer sets are supplied in standard size.

Please advise specific sizes required at time of ordering.

**Kit contains:-**

Set of 6 pistons (state size required)  
Main & big end bearing shells (state size required)  
Thrust washers (state size required)  
Water pump gasket  
Water pump housing gasket  
Cylinder head gasket (non-recessed)  
Rocker cover gasket  
Manifold gasket  
Exhaust downpipe gasket  
Thermostat gasket  
Crankshaft rear oil seal  
Sump gasket set (excl. oil seals)  
Timing cover oil seal  
Oil pressure relief valve sealing washer  
Oil pressure relief valve spring  
Oil pressure relief valve  
Oil pressure switch  
Cam follower set (large diameter)  
Timing chain  
Timing chain tensioner  
Oil pump  
Oil filter

**Additionally why not add some or all of the following options to the rebuild kit:**

Crankshaft  
Camshaft  
Crankshaft sprocket  
Camshaft sprocket  
Con rods

In addition to the rebuild kits, the engine section of this catalogue lists all the other parts that you might want to buy, such as engine studs, cylinder head nuts, water pump etc.

**SHORT ENGINE REBUILD KIT**

**TR5 Pi, TR250**

**RR2001RBK**

**Engine Installation Kit**

This kit contains everything you need to install your reconditioned engine.

**Kit contains:-**

Pedestal gasket  
Water pump gasket  
Water pump housing gasket  
Crankshaft spigot bush  
Rocker cover gasket  
Manifold gasket  
Exhaust downpipe gasket  
Oil filter  
Thermostat housing gasket  
Castrol XL30 (4.55 litres)

**ENGINE INSTALLATION KIT;**

**TR5 Pi** from CP1E  
**TR250** from CC1E

**RF4011**  
**RF4012**

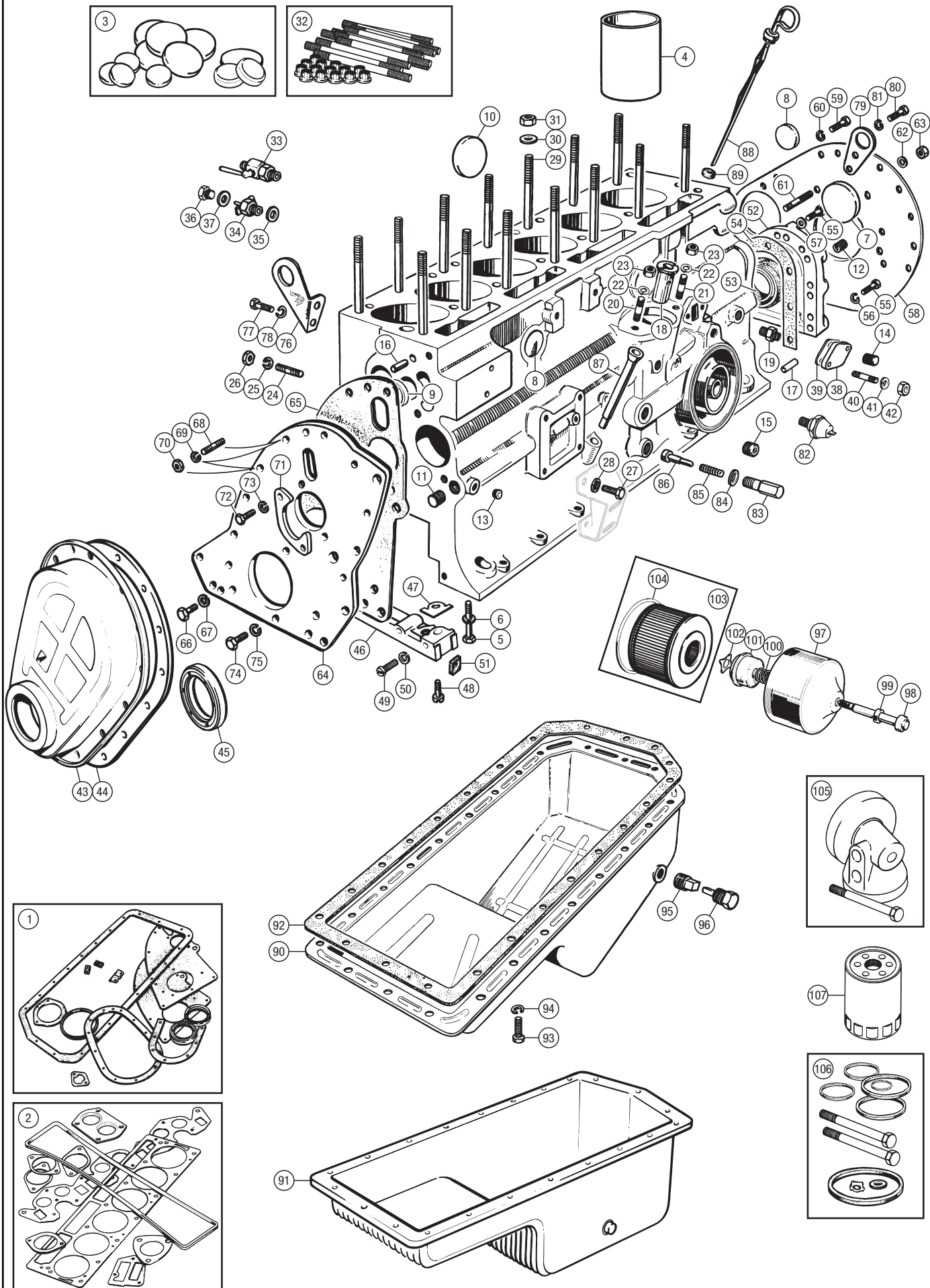
**External Engine**

- |           |  |   |                  |
|-----------|--|---|------------------|
| <b>1</b>  | SUMP GASKET SET;<br>with oil seals   | 1 | <b>GEG214K</b>   |
|           | without oil seals  | 1 | <b>GEG214</b>    |
| <b>2</b>  | HEAD GASKET SET;<br>TR5  | 1 | <b>GEG179</b>    |
|           | TR250  | 1 | <b>517276</b>    |
| <b>3</b>  | CORE PLUG SET, for block and head  | 1 | <b>RG1034</b>    |
| <b>4</b>  | CYLINDER LINER   | 6 | <b>158942</b>    |
| <b>5</b>  | BOLT, main bearing cap (3" long);*<br>standard   | 8 | <b>BH607241</b>  |
|           | uprated  | 8 | <b>BH607241X</b> |
| <b>6</b>  | WASHER, locking*   | 8 | <b>WL600071</b>  |
|           | Use with BH607241.   |   |                  |
|           | BOLT, main bearing cap (2 3/4" long)*8   | 8 | <b>BH607221</b>  |
|           | Alternative to 5.  |   |                  |
|           | <small>*Note: A factory modification on TR6 in 1971 deleted the use of locking washers on main bearing cap bolts, shorter bolts being introduced at this time. Bolts measuring 3" from under the head to the end should be used with locking washers, whereas the less desirable shorter bolts should not.</small> |   |                  |
| <b>7</b>  | PLUG, core, rear of camshaft, 2"   | 1 | <b>148353</b>    |
| <b>8</b>  | PLUG, core, rear and LH side of block<br>1 1/4"  | 3 | <b>144686</b>    |
| <b>9</b>  | PLUG, core, front of block, 1"   | 1 | <b>144687</b>    |
| <b>10</b> | PLUG, core, front and RH side, 1 1/2"  | 5 | <b>144688</b>    |
| <b>11</b> | PLUG, oil gallery, front<br>Sold as a stick of 9.  | 1 | <b>PS1103</b>    |
| <b>12</b> | PLUG, oil gallery, rear  | 1 | <b>118632</b>    |
| <b>13</b> | PLUG, oil gallery, LH side   | 5 | <b>118686</b>    |
| <b>14</b> | PLUG, oil gallery<br>Sold as a stick of 9.   | 1 | <b>PU1404</b>    |
| <b>15</b> | PLUG, oil gallery, above relief valve  | 1 | <b>116511</b>    |
| <b>16</b> | DOWEL PIN, timing cover locating   | 2 | <b>DP514</b>     |
| <b>17</b> | DOWEL PIN, rear plate locating   | 2 | <b>DP619</b>     |
| <b>18</b> | BUSH, oil pump drive;<br>TR5   | 1 | <b>149776</b>    |
|           | TR250  | 1 | <b>137978</b>    |
| <b>18</b> | ADAPTOR, oil pressure gauge pipe   | 1 | <b>143943</b>    |
| <b>20</b> | STUD, distributor pedestal (short); (1.1/4")<br>TR5  | 1 | <b>TE605105</b>  |
|           | TR250  | 2 | <b>TE605105</b>  |
| <b>21</b> | STUD, distributor pedestal (long) (2.1/2")<br>TR5  | 1 | <b>FHS2520</b>   |
| <b>22</b> | WASHER, locking  | 2 | <b>GHF332</b>    |
| <b>23</b> | NUT  | 2 | <b>GHF201</b>    |



**FULL ENGINE REBUILD KIT -  
RF4008RBK**







# TR5-250

| No. | DESCRIPTION  | QTY REQ. | PART No. |
|-----|--|----------|----------|
| 24  | STUD, RH engine mounting bracket and air manifold to block | 2        | 105124   |
| 25  | WASHER, locking  | 2        | GHF333   |
| 26  | NUT, bracket and stay attaching                            | 2        | GHF202   |
| 27  | SCREW, engine mounting bracket to block                    | 6        | SH606061 |
| 28  | WASHER, locking  | 6        | GHF333   |
| 29  | STUD, cylinder head  | 14       | 156274   |
| 30  | WASHER, under cylinder head nut                            | 14       | WB600070 |
| 31  | NUT, special, cylinder head attachment; standard           | 14       | 103810   |
|     | uprated  | 14       | 103810X  |



COMPETITION HEAD STUD KIT - RR1510

|    |   |   |          |
|----|---|---|----------|
| 32 | COMPETITION HEAD STUD KIT<br>Includes 14 studs & nuts. Manufactured with high grade materials for greater control of clamping pressure. | 1 | RR1510   |
| 33 | TAP, water drain (Original item)  | 1 | 61478    |
| 34 | TAP, water drain (Later TR6 alternative)  | 1 | 602915   |
| 35 | WASHER, fibre, drain tap  | 1 | WF511A   |
| 36 | PLUG, water drain (Alternative to tap)  | 1 | 129077   |
| 37 | WASHER, fibre, drain plug   | 1 | WF511A   |
| 38 | BLANKING PLATE, fuel pump aperture TR5.   | 1 | 147876   |
| 39 | GASKET, blanking plate or fuel pump to block  | 1 | 138791   |
| 40 | STUD, blanking plate to block   | 2 | 100433   |
| 41 | WASHER, locking   | 2 | GHF332   |
| 42 | NUT   | 2 | GHF201   |
| 43 | TIMING COVER  | 1 | 214678   |
| 44 | GASKET, timing cover  | 1 | 211126   |
| 45 | OIL SEAL, timing cover; single lip (Original item)  | 1 | 125631   |
|    | twin lip (Later TR6 alternative)  | 1 | UKC1110  |
| 46 | SEALING BLOCK, front  | 1 | 151134   |
| 47 | GASKET, sealing block to cylinder block   | 2 | UKC8321  |
| 48 | SCREW, sealing block to cylinder block  | 2 | SW605081 |
| 49 | SCREW, engine plate to sealing block  | 2 | SE605061 |
| 50 | WASHER, locking   | 2 | GHF332   |
| 51 | FILLING PIECE   | 2 | 36234    |
| 52 | HOUSING AND SEAL ASSEMBLY, rear   | 1 | 156530   |
| 53 | OIL SEAL, crankshaft rear   | 1 | 143456   |
| 54 | GASKET, housing to cylinder block   | 1 | 105321   |
| 55 | SCREW, housing to cylinder block  | 7 | SH605091 |
| 56 | WASHER, locking   | 6 | GHF332   |
| 57 | WASHER, copper (top centre bolt only) To avoid oil leaks.   | 1 | 500469   |
| 58 | BACK PLATE, engine  | 1 | 211505   |
| 59 | SCREW, back plate to cylinder block   | 7 | SH605071 |
| 60 | WASHER, locking   | 7 | GHF332   |
| 61 | STUD, gearbox/back plate to block   | 3 | TE605141 |
| 62 | WASHER, locking   | 3 | GHF332   |
| 63 | NUT   | 3 | GHF201   |
| 64 | FRONT PLATE, engine   | 1 | 215349   |
| 65 | GASKET, front plate to cylinder block   | 1 | 215350   |
| 66 | SCREW, front plate to cylinder block  | 3 | GHF120   |
| 67 | WASHER, locking   | 3 | GHF332   |
| 68 | STUD, timing cover and front plate to cylinder block  | 2 | 100433   |
| 69 | WASHER, locking   | 2 | GHF332   |
| 70 | NUT   | 2 | GHF201   |
| 71 | PLATE, camshaft locating  | 1 | 105114   |
| 72 | SCREW, locating plate to cylinder block   | 2 | SH605071 |
| 73 | WASHER, locking   | 2 | GHF332   |
| 74 | SCREW, engine plate and timing cover to cylinder block  | 5 | SH605071 |

|     |  |    |           |
|-----|--|----|-----------|
| 75  | WASHER, locking  | 5  | GHF332    |
| 76  | LIFTING EYE, front   | 1  | 123716    |
| 77  | SCREW, lifting eye to cylinder block   | 2  | SH605051  |
| 78  | WASHER, locking  | 2  | GHF332    |
| 79  | LIFTING EYE, rear  | 1  | 145987    |
| 80  | SCREW, lifting eye to cylinder block   | 2  | SH605051  |
| 81  | WASHER, locking  | 2  | GHF332    |
| 82  | OIL PRESSURE SWITCH  | 1  | GPS117    |
| 83  | PLUG, oil pressure relief valve  | 1  | 107246    |
| 84  | WASHER, copper, sealing plug   | 1  | 6K433     |
| 85  | SPRING; original   | 1  | 131535    |
|     | uprated  | 1  | 131535UR  |
| 86  | PISTON, oil pressure relief valve  | 1  | 132107    |
| 87  | DIPSTICK TUBE  | 1  | 127652    |
| 88  | DIPSTICK   | 1  | 147712    |
| 89  | WASHER, felt, sealing dipstick in tube   | 1  | 32307     |
| 90  | OIL SUMP (Alternative to 307834)   | 1  | 307836    |
|     | OIL SUMP (Alternative to 307836) Both oil sumps are interchangeable the difference being the location of the drain plug. | 1  | 307834    |
| 91  | OIL SUMP, aluminium  | 1  | 307834ALU |
| 92  | GASKET, oil sump to block  | 1  | GEG515    |
| 93  | SCREW, oil sump to block   | 23 | GHF120    |
| 94  | WASHER, locking  | 23 | GHF332    |
| 95  | PLUG, tapered, oil drain (Square headed)   | 1  | 114774    |
| 96  | PLUG, tapered, magnetic, oil drain Magnetic alternative.   | 1  | 155660    |
| 97  | CANISTER, oil filter   | 1  | 510107    |
| 98  | BOLT, canister to cylinder block   | 1  | 510108    |
| 99  | SEAL, rubber, under head of bolt   | 1  | 510109    |
| 100 | SPRING, retaining element  | 1  | 510110    |
| 101 | VALVE ASSEMBLY   | 1  | 510111    |
| 102 | CENTRALISER, element   | 1  | 509883    |
| 103 | OIL FILTER ELEMENT, with sealing ring  | 1  | GFE131    |
| 104 | SEALING RING   | 1  | 272539    |



SPIN-ON FILTER ADAPTOR - RR1238

|     |   |   |             |
|-----|---|---|-------------|
| 105 | SPIN-ON FILTER ADAPTOR; without oil cooler hose tappings        | 1 | RR1238      |
|     | with oil cooler hose tappings                                   | 1 | RR1275      |
| 106 | SERVICE KIT, spin on adaptor Includes O rings, bolts & washers. | 1 | RR1238S-KIT |
| 107 | OIL FILTER, spin on type  | 1 | RR1243      |

SPIN-ON OIL FILTER - RR1243



## OIL COOLER KIT

### Oil Cooler Kit

OIL COOLER KIT, TR5/250 1 RR1296

Also converts to spin-on filter.  
Our Oil Cooler Kits include the radiator, hoses and all fittings.  
Thermostat available separately.



OIL COOLER THERMOSTAT - RS1456

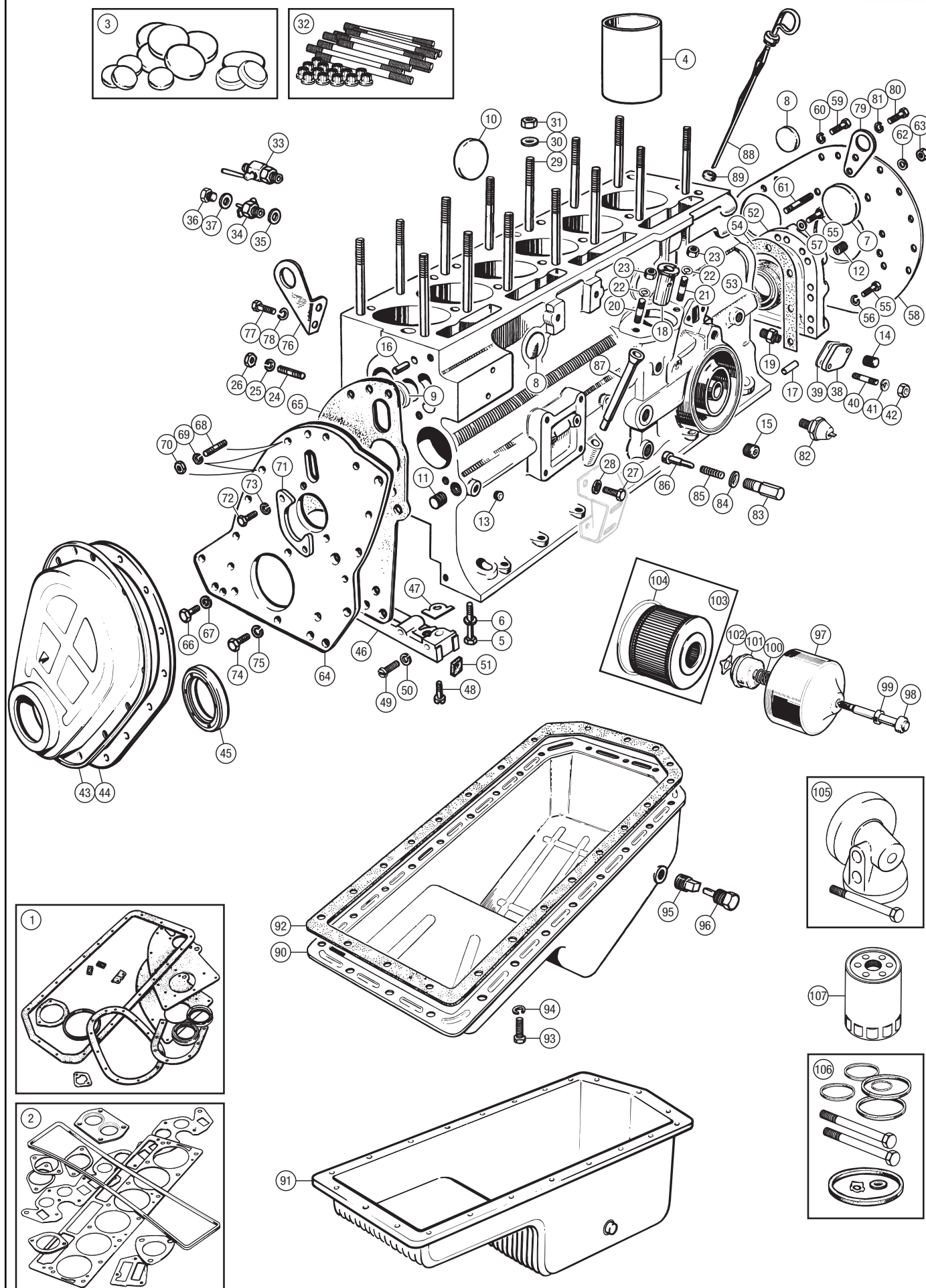
|                       |   |        |
|-----------------------|---|--------|
| OIL COOLER THERMOSTAT | 1 | RS1456 |
| SPIN-ON OIL FILTER    | 1 | RR1243 |



OIL COOLER KIT - RR1296









## TR5-250

## Internal Engine

- 1 CRANKSHAFT;  
reconditioned, exchange,  
TR5, TR250; 'Long Back' crank\*.  
Includes appropriate bearing sets  
new 1 **311322**  
Later TR6 alternative; 'Short Back' crank\*.  
reconditioned exchange,  
Later TR6 alternative; 'Short Back' crank\*.  
Includes appropriate bearing sets  
Tuftriding service also available, please enquire.

\*Note: 'Long' and 'short backed' refer to the depth of the rear oil seal surface. Having removed the flywheel and any spacers, if the end of the crank is flush with the engine back plate, it is a 'short backed' crank. If almost an inch of crankshaft stands proud, a 'long backed' crank is fitted. The flywheel design differs accordingly, i.e. long back cranks use a recessed flywheel, short backs a non recessed flywheel. A short back crank may be used to replace an original TR5, TR250 long back item, but only if the flywheel is swapped for the later version as well. In case you should wish to do so, or in case a previous engine rebuilder has already swapped the crank and flywheel pair in your engine, the short back crank and flywheel are listed in this section.

- 2 PLUG, screwed, crankshaft oilways 6 **118632**  
Ensure replacements are obtained before removal.  
3 PLUG, brass, oilway jet 6 **149748**  
Ensure replacements are obtained before removal.

- 4 MAIN BEARING SET, standard size;  
Vandervell 1 **RTC1752V-VEL**  
Glacier 1 **RTC1752AE**  
County 1 **RTC1752COUNTY**

Main bearings are obtainable in a range of oversizes (+.010" to +.060") depending upon availability. Please check web site or contact us. When ordering please quote part number and size required (i.e. RTC1752.010V-VEL for .010 oversize in Vandervell, RTC1752.010AE for .010 oversize in Glacier, etc.).

- 5 THRUST WASHER SET - Glacier, std 1 **BHM1366**  
Thrust washers are obtainable in the following oversizes -  
+.005, +.010 & +.015.  
When ordering please quote part number and size required  
(i.e. BHM1366.005 for .005 oversize).

- 6 CON ROD BEARING SET;  
Glacier, std size 1 **RTC1751AE**  
County, std size 1 **RTC1751COUNTY**  
Connecting rod bearings are obtainable in a range of oversizes (+.010" to +.060") depending upon availability. Please check web site or contact us. When ordering please quote part number and size required (i.e. RTC1751.010COUNTY for .010 oversize in County, RTC1751.010AE for .010 oversize in Glacier, etc.).

- 7 CON ROD ASSEMBLY;  
new 6 **146454**  
recon., exchange 6 **146454R**

- 8 BUSH KIT, small end 1 **119813K6**

- 9 BUSH, small end 6 **119813**

- 10 DOWEL, hollow, cap locating 12 **107401**

- 11 BOLT, special, connecting rod 12 **UKC2598**  
Use 'Loctite' when fitting.

- 12 PISTON SET;  
Includes rings and gudgeon pins.  
Hepolite, std size 1 **148118HEP**  
Replacement, std size 1 **148118REP**

Piston Sets are obtainable in a range of oversizes (+.020" to +.060") depending upon availability. Please check web site or contact us. When ordering please quote part number and size required (i.e. 148118.020HEP for .020 oversize in Hepolite and 148118.020REP for .020 oversize for replacements). Each piston includes rings, gudgeon pin and circlips.

- 13 GUDGEON PIN 6 **149215**

- 14 CIRCLIP, gudgeon pin retaining 12 **508978**

- 15 PISTON RING CAR SET, standard size 1 **RTC2430**  
Hepolite.  
Piston Ring Sets are obtainable in the following oversizes -  
+.020: +.030: .040: +.060.  
When ordering please quote part number and size required  
(i.e. RTC2430.020 for .020 for oversize).

- 16 SPROCKET, crankshaft;  
duplex chain type (TR5, late TR250) 1 **145864**  
single row chain type (Early TR250) 1 **119389**

- 17 SHIM;  
0.004, timing gear alignment A/R **145275**  
0.006, timing gear alignment A/R **145276**

- 18 KEY, timing gear and pulley locating 1 **133234**

- 19 OIL THROWER 1 **119390**

- 20 SLEEVE, timing cover oil seal 1 **133235**

- 21 CAMSHAFT;  
TR5 (2 rings on front journal)  
new 1 **307689**  
reconditioned exchange 1 **307689R**

TR250 (1 ring on front journal)  
new 1 **307621**  
reconditioned exchange 1 **307621R**

- 22 CAM BEARING SET 1 **142647K**

- 23 CAM FOLLOWER ('tappet');  
standard 12 **143552**  
uprated 12 **143552UR**

It is vital that a camshaft and its followers are properly lubricated when installed and run in an engine for the first time. Use 'Cam Lube' (RX1358).



TIMING CHAIN KIT - RF4069

- 24 PLATE, locating camshaft 1 **105114**  
25 SCREW, locating plate to cylinder block 2 **SH605071**  
26 WASHER, locking 2 **GHF332**  
27 SPROCKET, camshaft;  
duplex chain type (TR5, late TR250) 1 **145865**  
single row chain type (Early TR250) 1 **35960**  
28 BOLT, timing gear to camshaft 2 **100500**  
29 LOCKTAB, timing gear bolt 1 **36411**

- 30 TIMING CHAIN KIT;  
duplex type  
TR5, late TR250; includes timing chain, oil seal,  
tensioner and gasket. 1 **RF4069**  
single row chain type  
Early TR250; includes timing chain, oil seal, tensioner and gasket. 1 **RH5003**

- 31 TIMING CHAIN;  
duplex type (TR5, late TR250) 1 **145870**  
single row chain type (Early TR250) 1 **105131**

- 32 TIMING COVER;  
single timing mark type (Original item) 1 **214678**  
multiple timing mark type (Alternative) 1 **217790**

- 33 ANCHOR PLATE, tensioner 1 **43752**

- 34 RIVET, anchor plate to timing cover 2 **RR610040**

- 35 OIL SEAL, timing cover;  
single lip (Original item) 1 **125631**  
double lip (Later TR6 alternative) 1 **UKC1110**

- 36 GASKET, timing cover to front plate 1 **211126**

- 37 TENSIONER, timing chain;  
duplex chain type (TR5, late TR250) 1 **145866**  
single row chain type (Early TR250) 1 **42425**

- 38 PIN, tensioner pivot 1 **33214**

- 39 WASHER, plain 2 **WP18**

- 40 SPLIT PIN, tensioner pivot pin retaining 2 **PS103121**

- 41 SCREW, hex head, timing cover to block 5 **SH605071**

- 42 WASHER, locking 5 **GHF332**

- 43 SCREW, pan head, timing cover to block 5 **SE605031**

- 44 WASHER, locking 5 **GHF332**

- 45 STUD, timing cover to cylinder block 2 **100433**

- 46 WASHER, locking 2 **GHF332**

- 47 NUT 2 **GHF201**

- 48 DOWEL PIN, timing cover locating 2 **DP514**

- 49 FLYWHEEL, with ring gear;  
recessed type,  
For TR5, TR250 long back crank.  
Reconditioned, exchange. 1 **148041R\***

- non-recessed,  
For later TR6 short back crank.  
Reconditioned, exchange. 1 **151214R\***

- \*Note: The flywheel changes to suit the design of crankshaft fitted.  
See the note at the top of this page about 'long & short' backed cranks.

- 50 RING GEAR 1 **201350**

- 51 DOWEL PIN, locating clutch cover 3 **UKC1937**

- 52 DOWEL PIN, locating flywheel 1 **DP619**

- 53 BOLT, flywheel to crankshaft  
Fit with 'Loctite'. 4 **UKC4254**

- 54 SPIGOT BUSH, crankshaft;  
1"x1" in crank  
For TR5, TR250 long back crank.  
1"x1/2" in flywheel  
For later TR6 short back crank. 1 **47246**

- 55 OIL SEAL, crankshaft rear 1 **143456**

- 56 FRONT PULLEY AND DAMPER  
3/8" groove. 1 **214479**

- 57 EXTENSION, fan 1 **148831**

- 58 DOWEL PIN, locating extension 2 **140419**

- 59 BOLT, extension & pulley to crankshaft 1 **148832**

- 60 FAN BELT, 3/8" wide 1 **GCB11088**

- 61 FAN, 8 blade, plastic (blue) 1 **308353**

- 62 FITTING KIT, fan blade (for 308353) 1 **308353FK**

- 63 BUSH, fan to extension 8 **108496**

- 64 SLEEVE, fan to extension 4 **108499**

- 65 WASHER, plain 4 **GHF301**

- 66 TAB WASHER 2 **107857**

- 67 BOLT, fan to extension 4 **BH605101**

## OIL PUMP ASSEMBLY;

## Original Cast Iron Item

- 68 OIL PUMP ASSEMBLY, cast iron body\* 1 **149634**  
69 ROTOR AND SPINDLE ASSEMBLY 1 **508975**  
70 FILTER, oil pump 1 **149621**  
71 BOLT, oil pump, (3" long) 2 **BH604241**  
72 BOLT, oil pump, (3 1/2" long) 1 **BH604281**  
73 WASHER, locking 3 **GHF331**

\*The later, higher capacity aluminium bodied oil pump can be used to replace the earlier cast iron version.

## OIL PUMP ASSEMBLY;

## Later TR6 High Capacity Aluminium Item

- 74 OIL PUMP ASSEMBLY, aluminium body\*1 **217488**  
75 BODY, oil pump 1 **217486**  
76 ROTOR AND SPINDLE ASSEMBLY 1 **217488REPKIT**  
77 STRAINER ASSEMBLY 1 **TKC2006**  
78 BOLT, oil pump to cylinder block 3 **HB726**  
79 WASHER, locking 3 **GHF331**

## 80 DRIVE SHAFT &amp; GEAR ASSEMBLY;

- TR5 1 **149099**  
TR250 1 **126786**

- 81 SHAFT;  
driving oil pump and gear - TR5 1 **149097**

- driving oil pump - TR250 1 **NSS**

- 82 GEAR, driving shaft 1 **126785**

- 83 PIN, mills, securing shaft driving gear 1 **500974**

- 84 GEAR, driving distributor  
& metering unit - TR5 1 **149098**

- 85 PIN, mills, securing gear to shaft 1 **500975**

- TR5.

- 86 BUSH, supporting drive shaft assembly;  
TR5 (press fit in block) 1 **149776**  
TR250 (press fit in block) 1 **137978**

## DISTRIBUTOR PEDESTAL; TR250

Refer to the factory workshop manual for details on using the pedestal to block gaskets as shims to set gear end float.

- 87 DISTRIBUTOR PEDESTAL 1 **126784**

- 88 SCREW, distributor to pedestal 2 **SH604041**

- 89 WASHER, locking 2 **GHF331**

- 90 WASHER, plain 2 **GHF300**

- 91 GASKET, pedestal to cylinder block  
See note above distributor pedestal assembly. A/R **104939**

- 92 STUD, distributor pedestal 2 **TE605105**

- 93 WASHER, locking 2 **GHF332**

- 94 NUT 2 **GHF201**

## DISTRIBUTOR PEDESTAL; TR5

Refer to the factory workshop manual for details on using the pedestal to block gaskets as shims to set gear end float.

- 95 DISTRIBUTOR PEDESTAL ASSEMBLY;

- new 1 **308396**

- reconditioned exchange 1 **308396R**

- 96 GEAR, driving metering unit 1 **149100**

- 97 SEAL, fuel 1 **145720**

- Always replace both seals at the same time.

- 98 SEAL, oil 1 **145720**

- Always replace both seals at the same time.

- 99 PLUG, driving gear end thrust and  
pedestal sealing 1 **149226**

- 100 'O' RING, on plug 1 **NKC101A**

- 101 SCREW, thrust plug retaining  
Fit with 'Loctite'. 1 **157092**

- 102 WASHER, plain 1 **WC701121**

- 103 GASKET, pedestal to cylinder block  
See note above distributor pedestal assembly. A/R **104939**

- 104 STUD, distributor pedestal (short) (1 1/4") 1 **TE605105**

- 105 STUD, distributor pedestal (long) (2 1/2") 1 **FHS2520**

- 106 WASHER, locking 2 **GHF332**

- 107 NUT 2 **GHF201**

- 108 SCREW, distributor to pedestal 1 **SH605051**

- 109 WASHER, locking 1 **GHF332**

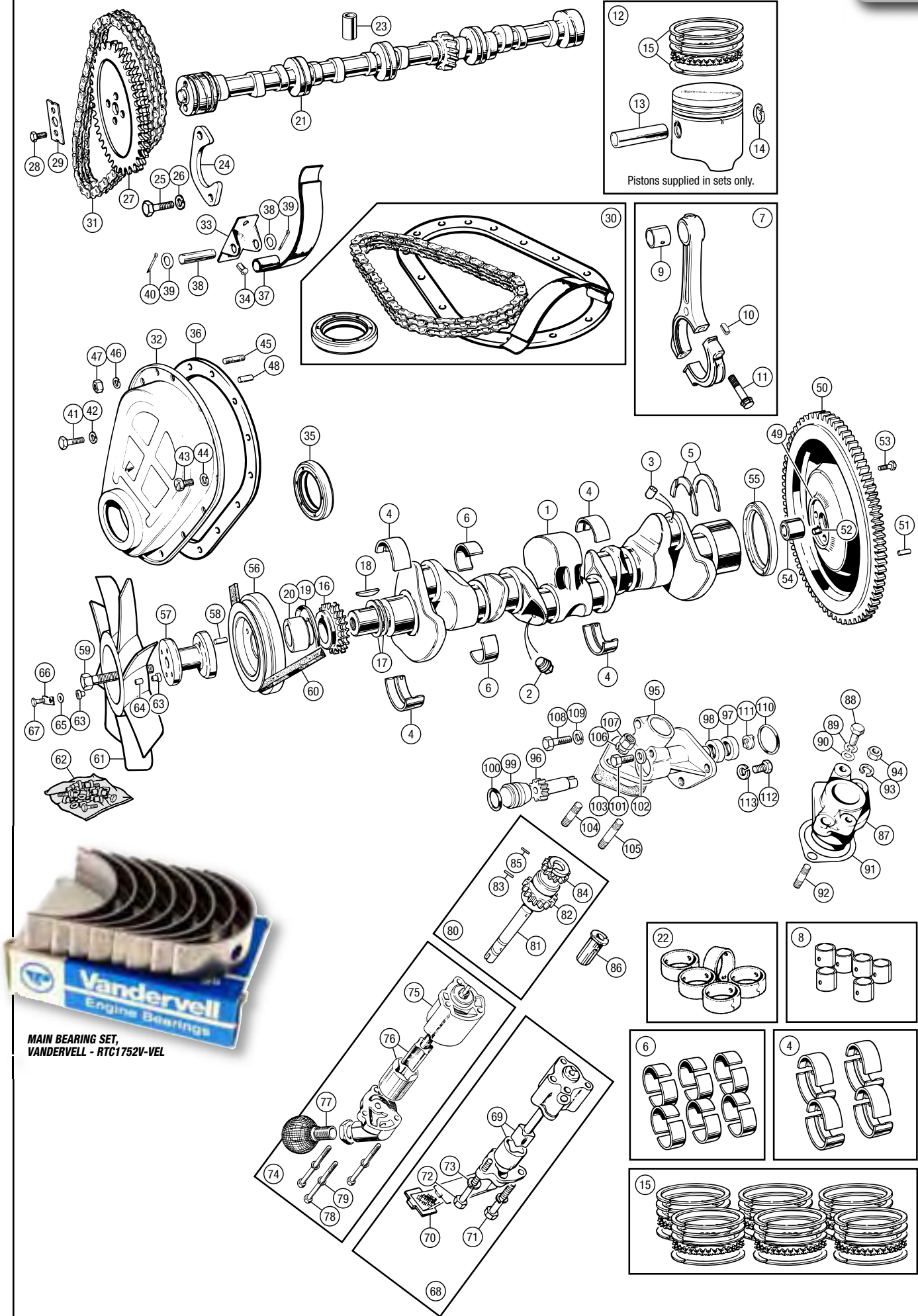
- 110 'O' RING, metering unit to pedestal 1 **149486**

- 111 DRIVE, plastic, metering unit 1 **149595**

- 112 SCREW, metering unit to pedestal 3 **SH604071**

- 113 WASHER, locking 3 **GHF331**







## TR5-250

# ENGINE - CYLINDER HEAD - 6 cylinder - TR5-250

### CYLINDER HEAD REBUILD KIT

Identifying which cylinder head is on your engine should be fairly straight forward with the TR250. Assuming you have a TR250 engine in your car, the original TR250 cylinder head is the only head that will work on your engine. Not so straight forward with the TR5; unless you know for sure it still has its original TR5 cylinder head, it could conceivably have a later TR6 item fitted and you will need to identify which head it has before ordering a cylinder head rebuild kit. Identification is achieved by looking at the head casting number: 308351 is the original head casting for the TR5 and early TR6, while 312388 and V3298 are later TR6 castings.

The cylinder head rebuild kit contains everything you need to recondition your cylinder head. We assume you will have any required machining done.

The exhaust valves in the kit are lead-free compatible, but please note that TR5 injection cars also require a Bosch fuel pump and a modified metering unit for unleaded application.



#### Kit contains:-

Inlet valves, Exhaust valves, Valve springs  
Valve guides, Head gasket set, Valve stem oil seals

Additionally why not add some or all of the following options to the rebuild kit:

Rocker shaft, Rocker arms

#### CYLINDER HEAD REBUILD KIT;

|  |                   |
|--|-------------------|
| <b>TR250</b>                                   | <b>516796RBK</b>  |
| <b>TR5 (for original head casting 308351)</b>  | <b>516798RBK</b>  |
| <b>TR5 (for later TR6 head casting 312388)</b> | <b>520869RBK</b>  |
| <b>TR5 (for later TR6 head casting V3298)</b>  | <b>UKG1420RBK</b> |

|   |   |   |                 |
|---|---|---|-----------------|
| 1 | CORE PLUG SET, block/head                               | 1 | <b>RG1034</b>   |
| 2 | CORE PLUG, large, rear face of head<br>1 5/8" diameter. | 1 | <b>144648</b>   |
| 3 | CORE PLUG, small, rear face of head<br>1 1/4" diameter. | 1 | <b>144686</b>   |
| 4 | SCREW, plugging rocker oil feed                         | 1 | <b>SH605041</b> |
| 5 | WASHER, copper, sealing screw                           | 1 | <b>500469</b>   |

### Valves, Guides & Springs

|  |   |    |                 |
|--|---|----|-----------------|
| 6  | GUIDE, inlet valve, short (2.0625");<br>standard  | 6  | <b>58923</b>    |
|  | uprated (Silicone/Bronze)   | 6  | <b>58923UR</b>  |
| 7  | GUIDE, exhaust valve, long (2.25");<br>standard   | 6  | <b>111869</b>   |
|  | uprated (Silicone/Bronze)   | 6  | <b>111869UR</b> |
| <i>Note that the valve seat inserts, valves and valve springs listed here are appropriate for TR250 and original TR5 cylinder heads only. If your TR5's cylinder head bears casting numbers 312388 or V3298 (later TR6 items) it is likely you will require different components - please enquire for details.</i> |   |    |                 |
| 8  | INSERT, valve seat, Inlet   | 6  | <b>146496</b>   |
| 9  | INSERT, valve seat, Exhaust   | 6  | <b>146497</b>   |
| 10   | VALVE, inlet, 1.44";<br>standard  | 6  | <b>146128</b>   |
|  | stainless steel   | 6  | <b>146128SS</b> |
| 11   | VALVE, exhaust, 1.25";<br>standard  | 6  | <b>149658</b>   |
|  | stainless steel   | 6  | <b>149658SS</b> |
| <i>All exhaust valves that we sell are lead-free compatible.</i>   |   |    |                 |
| 12   | VALVE SPRING, outer (twin fitment)<br>TR5.  | 12 | <b>149633</b>   |
| 13   | VALVE SPRING, inner (twin fitment)<br>TR5.  | 12 | <b>102564</b>   |
| 14   | VALVE SPRING (single fitment)<br>TR250.   | 12 | <b>136487</b>   |
| 15   | VALVE STEM OIL SEAL<br>Supplementary fitment. See this page ref. rocker feed kit & oil consumption. | 12 | <b>AEK113</b>   |
| 16   | COLLAR, valve spring, lower ;<br>twin spring fitment - TR5  | 12 | <b>149717</b>   |
|  | single spring fitment - TR250   | 12 | <b>105118</b>   |
| 17   | COLLAR, inlet spring, upper   | 6  | <b>111870</b>   |
| 18   | COLLAR, exhaust spring upper outer  | 6  | <b>128335</b>   |
| 19   | COLLAR, exhaust spring upper inner  | 6  | <b>128334</b>   |
| 20   | COLLET, split cone type, pair   | 12 | <b>106663</b>   |

### Rocker Gear Overhaul Kit

If your rocker gear is worn and noisy, this kit allows a significant saving to buying all the parts individually. It includes new rocker shaft, 12 rocker arms, shaft springs and end plugs.

|    |                           |   |               |
|----|---------------------------|---|---------------|
| 21 | OVERHAUL KIT, rocker gear | 1 | <b>RR1312</b> |
|----|---------------------------|---|---------------|

### Rocker Shaft Complete Assembly

This assembly is built with reconditioned rocker arms and pedestals. All other components used are new.

|    |                             |   |                    |
|----|-----------------------------|---|--------------------|
| 22 | ROCKER SHAFT COMPLETE ASS'Y | 1 | <b>214559RASSY</b> |
|----|-----------------------------|---|--------------------|

Exchange (reconditioned).

### Rocker Gear

|  |   |    |                   |
|--|---|----|-------------------|
| 23   | ROCKER SHAFT, new                         | 1  | <b>214559</b>     |
| <i>Rocker shafts are tubular in construction. The ends of the shaft must be plugged to form an oil gallery inside the shaft. Oil is fed via the rear rocker pedestal into the shaft; drillings in the shaft allow lubrication of the rockers.</i>  |   |    |                   |
| 24   | PLUG, rocker shaft ends                   | 2  | <b>137811</b>     |
| 25   | PEDESTAL, no. 1                           | 1  | <b>145867</b>     |
| 26   | PEDESTAL, intermediate                    | 4  | <b>144974</b>     |
| 27   | PEDESTAL, no. 6 (drilled for oil feed)    | 1  | <b>145869</b>     |
| 28   | SHIM, pedestal (if required)              | 6  | <b>144973SHIM</b> |
| 29   | SCREW, locating shaft to drilled pedestal | 1  | <b>104859</b>     |
| 30   | STUD, rocker pedestal to cylinder head    | 6  | <b>132495</b>     |
| 31   | WASHER, plain                             | 6  | <b>WP9</b>        |
| 32   | NUT                                       | 6  | <b>GHF202</b>     |
| 33   | ROCKER ARM, odd (1, 3, 5, 7, 9, 11.)      | 6  | <b>109024</b>     |
| 34   | ROCKER ARM, even (2, 4, 6, 8, 10, 12.)    | 6  | <b>109023</b>     |
| 35   | SCREW, rocker clearance adjusting         | 12 | <b>109495</b>     |
| 36   | NUT, half, locking adjusting screw        | 12 | <b>57110</b>      |
| 37   | SPRING, rocker shaft, outer               | 2  | <b>105322</b>     |
| 38   | SPRING, rocker shaft, intermediate        | 5  | <b>119313</b>     |
| 39   | WASHER, rocker shaft spacing              | 4  | <b>WP12</b>       |
| 40   | SPLIT PIN, rocker shaft end               | 1  | <b>PC10</b>       |
| 41   | ROLLER ROCKER CONVERSION                  | 1  | <b>RR1511</b>     |
| <i>The complete rocker assembly is replaced with this kit. The new rocker arms use roller tips and internal rollers on an all new steel shaft. The rocker ratio is increased from 1.5 to 1.65:1 giving greater valve lift. Note: the external rocker feed kit (RR1340) should also be fitted with this conversion.</i> |   |    |                   |
| 42   | PUSHROD;<br>(8.11") - TR5                 | 12 | <b>149513</b>     |
|  | (8.30") - TR250                           | 12 | <b>148916</b>     |
| 43   | CAM FOLLOWER;<br>standard                 | 12 | <b>143552</b>     |
|  | uprated                                   | 12 | <b>143552UR</b>   |

### Rocker Cover

|   |   |   |                    |
|---|---|---|--------------------|
| 44  | ROCKER COVER, silver, reconditioned                   | 1 | <b>210908R</b>     |
| 45  | CAP, oil filler;<br>zinc plated                       | 1 | <b>598231</b>      |
|   | chrome (Alternative)                                  | 1 | <b>GZC1400</b>     |
| <i>Note: These oil caps are only suitable for the original steel rocker covers.</i>   |   |   |                    |
| 46  | LABEL, oil cap  | 1 | <b>CRST262</b>     |
| 47  | ROCKER COVER, alloy, includes cap;<br>polished finish | 1 | <b>TKC378A</b>     |
|   | black crackle finish                                  | 1 | <b>TKC378AP</b>    |
| 48  | CAP ONLY, alloy rocker cover                          | 1 | <b>TKC378A/CAP</b> |
| <i>All rocker covers listed are completely interchangeable - standard fasteners and gasket are used to attach both steel and alloy rocker covers. The alloy rocker cover is a precision, high pressure die cast item and includes a unique bright chrome or black filler cap.</i> |   |   |                    |
| 49  | GASKET, rocker cover                                  | 1 | <b>GEG413</b>      |
| 50  | NUT, nylon, rocker cover (Do not overtighten)         | 3 | <b>GHF272</b>      |
| 51  | WASHER, plain   | 3 | <b>GHF301</b>      |
| 52  | WASHER, fibre   | 3 | <b>WF508</b>       |
| 53  | STUD, rocker cover to cylinder head                   | 3 | <b>105123</b>      |
| 54  | NUT, locking, stud to cylinder head                   | 3 | <b>GHF201</b>      |
| 55  | GASKET, manifold;<br>TR5                              | 1 | <b>GEG682</b>      |
|   | TR250   | 1 | <b>213641</b>      |
| 56  | DOWEL, locating inlet manifolds                       | 3 | <b>DS3113</b>      |
| 57  | STUD, exhaust manifold mounting                       | 4 | <b>105124</b>      |
| 58  | STUD, inlet/exhaust manifold mounting                 | 6 | <b>105125</b>      |
| 59  | STUD, inlet manifold mounting - TR5                   | 3 | <b>TE605105</b>    |
|   | BOLT, inlet manifold mounting - TR250                 | 3 | <b>BH605281</b>    |
| <i>Note: For manifolds, fixing details and fittings, please see 'Manifold' section.</i>   |   |   |                    |

### Heater Fittings

|   |  |   |                    |
|---|--|---|--------------------|
| 60  | WATER VALVE, heater;<br>standard                         | 1 | <b>565755</b>      |
|   | uprated (kit)  | 1 | <b>565755URKIT</b> |
| <i>For use with standard or uprated heater (see page 47).</i>       |  |   |                    |
| 61  | ADAPTOR, water valve to head;<br>TR5                     | 1 | <b>148435</b>      |
|   | TR250  | 1 | <b>133061</b>      |
| 62  | PLUG, replaces water adaptor<br>Vehicles without heater. | 1 | <b>114774</b>      |
| <i>Note: For other heater details, please see 'Heater' section.</i> |  |   |                    |

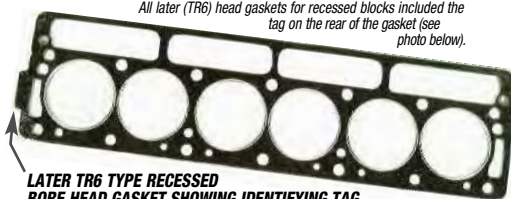
### Cylinder Head Gaskets

|    |  |   |                    |
|----|--|---|--------------------|
| 63 | HEAD GASKET SET, non-recessed bore;<br>TR5   | 1 | <b>GEG179</b>      |
|    | TR250  | 1 | <b>517276</b>      |
| 64 | GASKET, head, non-recessed bore;<br>standard | 1 | <b>GEG346</b>      |
|    | Payen  | 1 | <b>GEG346PAYEN</b> |

If a friend does you a favour by giving you a head gasket for your car, don't be ungrateful, but check its design first. Don't try to fit a recessed bore-type head gasket to your TR5, TR250 unless you know your car has been equipped with a much later TR6 engine, for which a recessed bore head gasket is appropriate.

As a guide to identifying which head gasket set or head gasket that you need they are identifiable by the presence or the lack of presence of a tag.

All later (TR6) head gaskets for recessed blocks included the tag on the rear of the gasket (see photo below).



LATER TR6 TYPE RECESSED BORE HEAD GASKET SHOWING IDENTIFYING TAG

### Cylinder Head Attachments

|    |                                    |    |                 |
|----|------------------------------------|----|-----------------|
| 65 | NUT, special                       | 14 | <b>103810</b>   |
|    | NUT, special, uprated              | 14 | <b>103810X</b>  |
| 66 | WASHER, special, cylinder head nut | 14 | <b>WB600070</b> |

*Note: For cylinder head studs, please see 'External Engine'.*

#### ROCKER FEED KIT

Excessive rocker shaft wear is a classic complaint about the Triumph push rod engines (of which the TR5, TR250 units are obviously examples). The external rocker feed kit is an effective and easy to fit solution to the problem. It works by piping oil from a plug hole in the cylinder block main oil gallery up to the cylinder head, thereby maintaining a higher oil flow than standard. No drilling or tapping is required for installation. The kit is so good, it looks as though it should always have been there!

|    |                          |   |               |
|----|--------------------------|---|---------------|
| 67 | EXTERNAL ROCKER FEED KIT | 1 | <b>RR1340</b> |
|----|--------------------------|---|---------------|



EXTERNAL ROCKER FEED KIT - RR1340

#### THE ROCKER FEED KIT AND OIL CONSUMPTION

When the supplementary oil feed to the rocker gear is fitted on Triumph TR5, TR250 engines an increase in oil consumption is often encountered. This is attributed to oil being drawn down worn valve guides. The extra amount of lubricating oil flowing through the valve and rocker chamber, as supplied by the feed kit, exaggerates any tendency for oil to be sucked down worn valve guides past worn valve stems. The best solution is to fit new valves and guides, but this is not always on the top of the repair priority list. To assist in the reduction of oil being sucked down the guides a method of valve stem oil seal is required. We offer the simple do-nut rubber ring that is used so successfully on MG sports cars. Its part number is AEK113, 12 of which are required, one per valve stem, to service an engine.

Now the clever bit... How to fit them without removing the cylinder head from the car.

Each seal needs to be fitted to the valve stem above the valve guide but below the valve spring upper retaining cap(s).

Remove the rocker cover, rocker gear and the spark plugs. Cover the holes that the push rods come up through so nothing can be dropped down into the engine. Turn the crankshaft so that number one piston is at bottom dead centre (BDC). Feed a length of clean, pliable rope down the spark plug hole of number one cylinder, leaving a bit hanging out so you can retrieve it. Now, slowly and carefully turn the crankshaft clockwise by hand, a resistance will be felt as the rising piston in that bore compresses the rope against the combustion faces of the two valves in that cylinder, holding them against their seats. The valve collets and spring caps of that cylinder can now be removed without the fear of losing the valves down the bore. The valve stem oil seals can be fitted to these two valve stems and perhaps a new set of valve springs. Be honest, this tip has saved the cost of a decoke set! Once the valve stem oil seals and other parts have been refitted to this first pair of valves satisfactorily, simply turn the crank anticlockwise to BDC, withdraw the rope and repeat the process on the remaining five cylinders and five pairs of valves. To be sure that the rope has compressed sufficiently against the faces of the valves, attempt to push the valves by hand, as if being acted on by the rockers before removing the spring caps or collets, this is the fail safe check. This method can be adopted anywhere as it does not require the use of compressed air, special tools or luck.

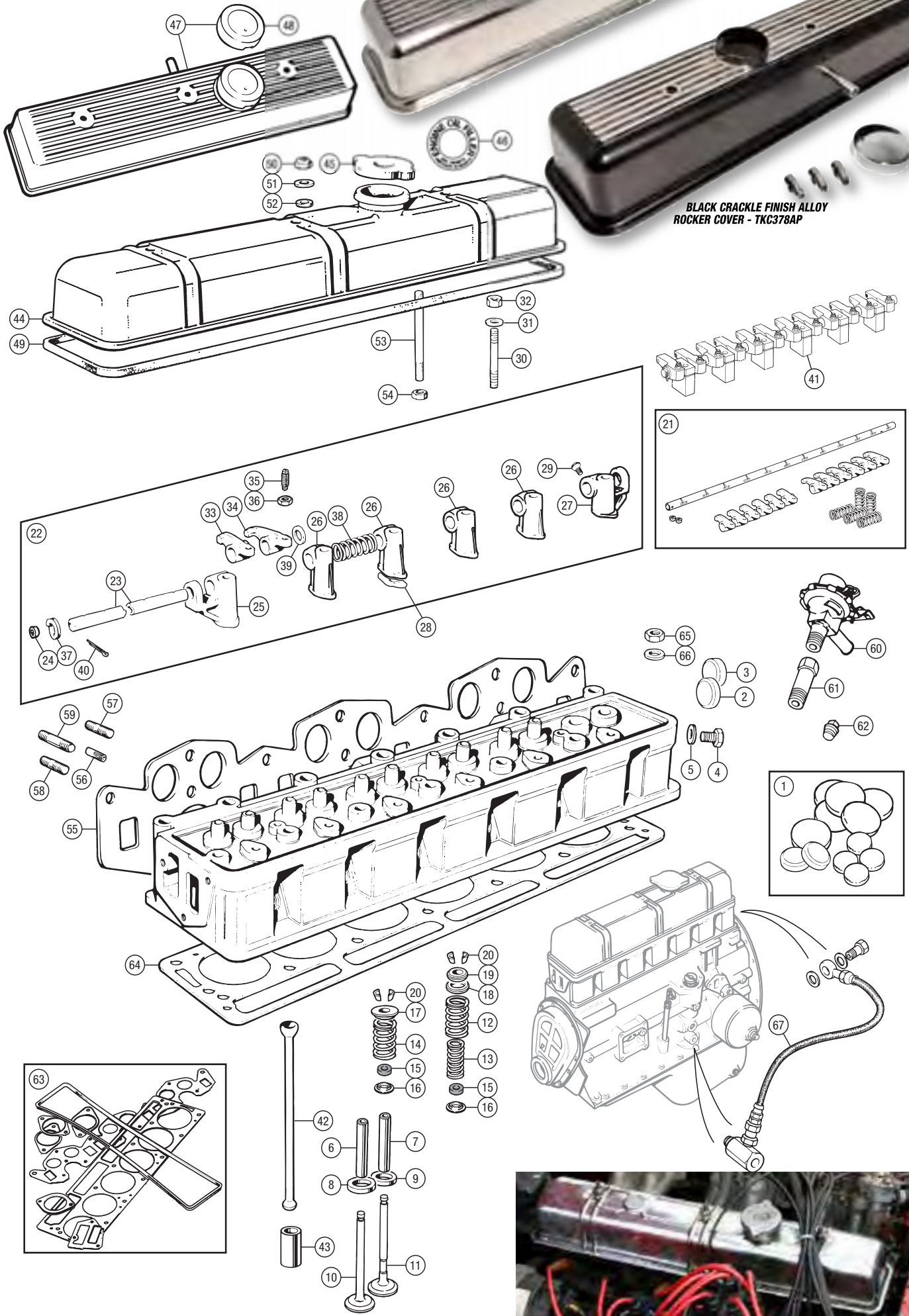


POLISHED FINISH ALLOY ROCKER COVER - TKC378A

TR5-250

ENGINE - CYLINDER HEAD - 6 cylinder - TR5-250

BLACK CRACKLE FINISH ALLOY ROCKER COVER - TKC378AP





## TR2-4A

### Clutch Assembly

|   |   |   |        |
|---|---|---|--------|
| 1 | CLUTCH KIT, 3 piece, spring type TR2, TR3, TR3A, TR4. Includes items 2-4. | 1 | RF4025 |
| 2 | CLUTCH COVER, 9" dia.   | 1 | GCC127 |
| 3 | CLUTCH PLATE  | 1 | 116638 |
| 4 | CLUTCH RELEASE BEARING  | 1 | 501608 |
| 5 | CLUTCH KIT, 3 piece, diaphragm type TR4A. Includes items 6-8.             | 1 | RF4026 |

The original Laycock clutch assembly for the TR4A is no longer serviced, whereas the alternative Borg and Beck assembly is still available. If your TR4A is fitted with a Laycock set of components, the entire Borg and Beck set should be fitted, even if only one component is in need of replacement (components within the sets cannot be mixed and matched). You will also need the longer screws (no. 9) to fit the thicker Borg and Beck clutch cover to the flywheel.

|     |   |   |          |
|-----|---|---|----------|
| 6   | CLUTCH COVER, 8 1/2" dia.   | 1 | GCC228   |
| 7   | CLUTCH PLATE  | 1 | GCP143   |
| 8   | CLUTCH RELEASE BEARING, uprated                                   | 1 | GRB211UR |
| 9   | SCREW, clutch cover to flywheel; 3/4" long; for Borg & Beck cover | 6 | SH505061 |
|     | 5/8" long; for Laycock cover                                      | 6 | SH505051 |
| 10  | WASHER, locking   | 6 | GHF332   |
| 11  | DOWEL PIN, flywheel to cover; Spring type clutch                  | 2 | UKC1937  |
|     | Diaphragm type clutch   | 3 | UKC1937  |
| 11A | CLUTCH ALIGNMENT TOOL   | 1 | RX1389   |

Probably the trickiest aspect of clutch replacement is the fact that the clutch driven plate must be exactly centred on the flywheel when the clutch cover is fastened over it. This must be done to ensure that the gearbox input shaft mates correctly with both the driven plate and the spigot bush in the tail of the crankshaft. The result of clutch plate misalignment is the gearbox's stubborn inability to clamp up flush to the back of the engine when reassembly is attempted. A clutch alignment tool will take the guesswork out of trying to centre the clutch driven plate. Most alignment tools are of a universal type; the item listed here is manufactured as a plastic replica of a TR gearbox input shaft - there is no more accurate way of aligning your clutch (other than using a real, 'spare' input shaft!).

Having secured a new clutch to the flywheel, and before refitting the gearbox to the engine, a very light coating of copper grease should be applied to the splines (having wire brushed and cleaned them first) and spigot end of the gearbox input shaft.

### Operating Mechanism

|    |  |   |         |
|----|--|---|---------|
| 12 | SLEEVE, release bearing carrier TR2, TR3, TR3A, TR4  | 1 | 100159  |
| 13 | SLEEVE, release bearing carrier- TR4A; original brass type   | 1 | 141967  |
|    | replacement coated cast iron   | 1 | 147858  |
|    | made from special material for smoother clutch operation   | 1 | 147858X |
| 14 | ROLL PIN, release fork to carrier - TR4A   | 1 | DS811   |
| 15 | RELEASE FORK, clutch Includes item 16.   | 1 | 106022  |
| 16 | PIN, clutch fork   | 2 | 100164  |
| 17 | SHAFT, clutch operating; TR2; use with greaseable bushes   | 1 | 108893  |
|    | TR3, TR3A, TR4 if fitted; use with greaseable bushes   | 1 | 108887  |
|    | TR4 if fitted, TR4A; use with non-greaseable bushes and locating screw   | 1 | 142413  |
|    | TR4 if fitted, TR4A; use with non-greaseable bushes and no locating screw  | 1 | 136354  |
| 18 | GREASE NIPPLE For greaseable clutch shaft.   | 2 | LN30041 |
| 19 | WASHER, fibre For greaseable clutch shaft.   | 2 | ACH5980 |
| 20 | SPRING, clutch shaft When locating screw is fitted.  | 1 | 105752  |
|    | SPRING, clutch shaft When locating screw is not fitted.  | 1 | 144754  |
| 21 | SCREW, locating shaft in bell housing Fit if shaft requires.   | 1 | 102805  |
| 22 | WASHER, locking Fit if shaft requires.   | 1 | GHF332  |
| 23 | PIN, fork to clutch shaft (tapered) The tapered pin holding the release fork to the cross shaft often cracks or breaks. This can be the reason for clutch drag - caused by part of the slave cylinder push rod travel being taken up by movement between the fork and the cross shaft. When carrying out any work involving the removal of the engine, gearbox or both from the car, the opportunity should be taken to replace the pin while access to it is easy, whether it appears to need replacing or not. Correct seating of the pin in the cross shaft is important. Ensure that any broken parts of the pin are removed from the fork and shaft. Also, the taper angle of the pin should correspond to that in the hole in the cross shaft. Trial fitting of the pin in the hole in the cross shaft without the presence of the release fork will bring to light any irregularities in the two components: if the pin wobbles in the hole, it may be 'lapped' into a better fit. If the amount of lapping required is excessive, replacement of the clutch cross shaft or the tapered pin may be necessary. | 1 | 158777  |
| 24 | LOCKING WIRE, for tapered pin  | 1 | 512781  |
| 25 | BUSH, shaft, in bell housing; for greaseable clutch shaft  |   |         |
|    | RH   | 1 | 36997   |
|    | LH   | 1 | 36998   |
|    | for non-greaseable clutch shaft  | 2 | 137651  |

## Slave Cylinder

### LOCKHEED SLAVE CYLINDER; TR2, TR3 TO TS13045

|    |   |   |         |
|----|---|---|---------|
| 26 | SLAVE CYLINDER High quality reproduction of original Lockheed cylinder. | 1 | 109746  |
| 27 | REPAIR KIT, slave cylinder For original cylinder.                       | 1 | 502281  |
| 28 | SLAVE CYLINDER Replacement TR5 type Girling cylinder.                   | 1 | UKC8677 |
| 29 | REPAIR KIT, slave cylinder For replacement TR5 type cylinder.           | 1 | 513390  |

For many years, the original Lockheed type slave cylinder was not available, but it has now been reintroduced. During the long period of non-availability, customers with TR2s and early TR3s needing a new slave cylinder had little option other than to fit the Girling TR5 slave cylinder, mounted on the opposite side of the support bracket to the way the Lockheed cylinder was mounted, and the pushrod modified in length to suit the new 'throw' distance. Please check which set up is fitted to your car before ordering a repair kit.

|    |  |   |          |
|----|--|---|----------|
| 30 | BLEED NIPPLE, slave cylinder   | 1 | 606733A  |
| 31 | BRACKET, slave cylinder support                                      | 1 | 106701   |
| 32 | SCREW, slave cyl. to support bracket                                 | 1 | SH605091 |
| 33 | WASHER, locking  | 1 | GHF332   |
| 34 | NUT  | 1 | GHF201   |
| 35 | STAY   | 1 | 128043   |
| 36 | NUT, plain, stay attachment  | 1 | GHF201   |
| 37 | NUT, nyloc, stay attachment  | 1 | GHF222   |
| 38 | PUSHROD, replacement Girling item Cut to length for Lockheed system. | 1 | 504852   |
| 39 | NUT  | 1 | NT605041 |
| 40 | FORK END ASSEMBLY Includes items 41, 42.                             | 1 | 57190    |
| 41 | FORK   | 1 | 57194    |
| 42 | SCREW PIN, with spring   | 1 | 216421A  |
| 43 | ANCHOR PLATE   | 1 | 106347   |
| 44 | SPLIT PIN  | 1 | PC34     |
| 45 | SPRING, push rod return  | 1 | 27645    |

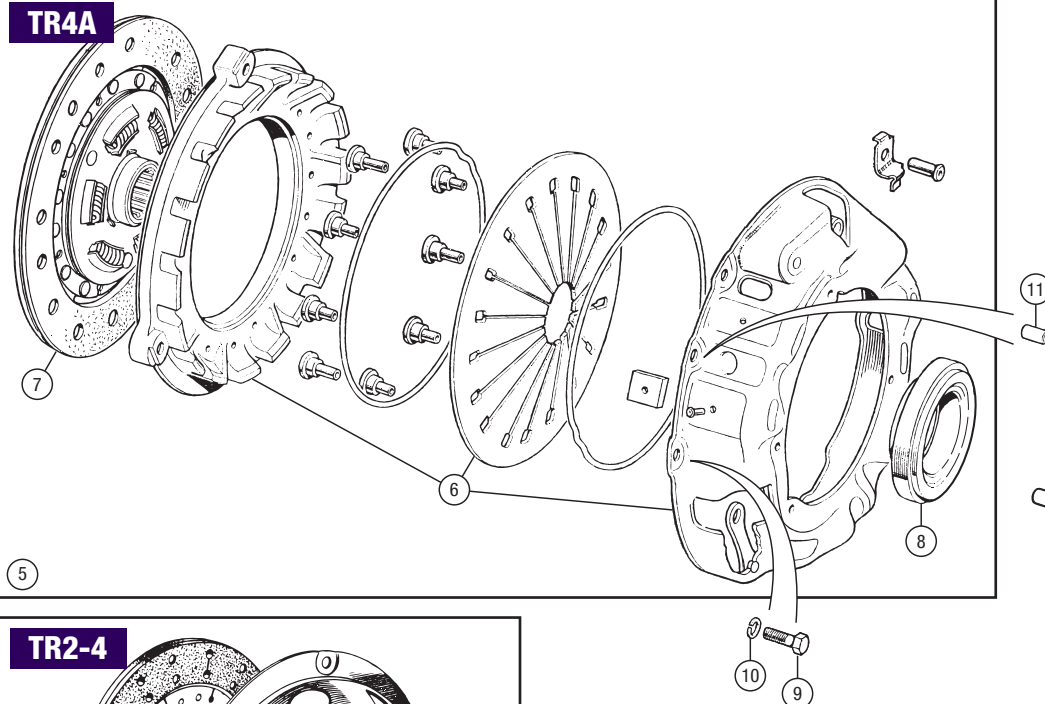
### GIRLING SLAVE CYLINDER; TR3 FROM TS13046, TR3A, TR4, TR4A

|    |   |   |          |
|----|---|---|----------|
| 46 | SLAVE CYLINDER, inc bleed nipple                      | 1 | 516788   |
| 47 | REPAIR KIT, slave cylinder                            | 1 | 505704   |
| 48 | BLEED NIPPLE  | 1 | 556508A  |
| 49 | BRACKET, slave cylinder mounting                      | 1 | 128042   |
| 50 | SCREW, slave cylinder to bracket                      | 1 | SH605091 |
| 51 | WASHER, locking                                       | 1 | GHF332   |
| 52 | NUT, plain  | 1 | GHF201   |
| 53 | STAY, slave cylinder                                  | 1 | 128043   |
| 54 | NUT, plain  | 1 | GHF201   |
| 55 | WASHER, plain   | 1 | GHF302   |
| 56 | NUT, nyloc  | 1 | GHF272   |
| 57 | PUSHROD   | 1 | 504852   |
| 58 | NUT, locking  | 1 | NT605041 |
| 59 | FORK END ASSEMBLY Includes items 60, 61.              | 1 | 57193    |
| 60 | FORK END  | 1 | 57194    |
| 61 | SCREW PIN   | 1 | 216421A  |
| 62 | SPLIT PIN   | 1 | PC35     |
| 63 | ANCHOR PLATE TR4 using spring type clutch.            | 1 | 106347   |
| 64 | SPRING, push rod return TR4 using spring type clutch. | 1 | 27645    |

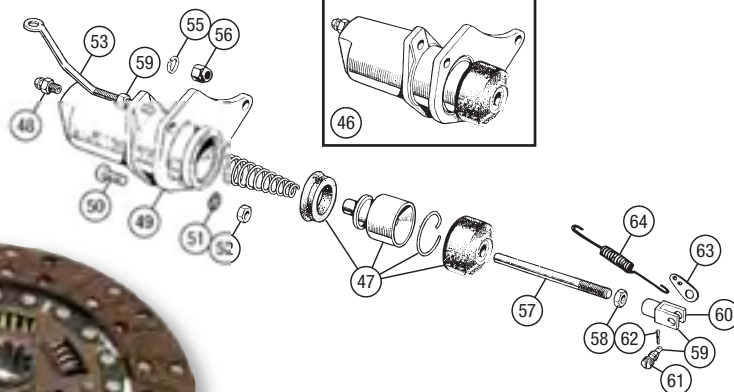
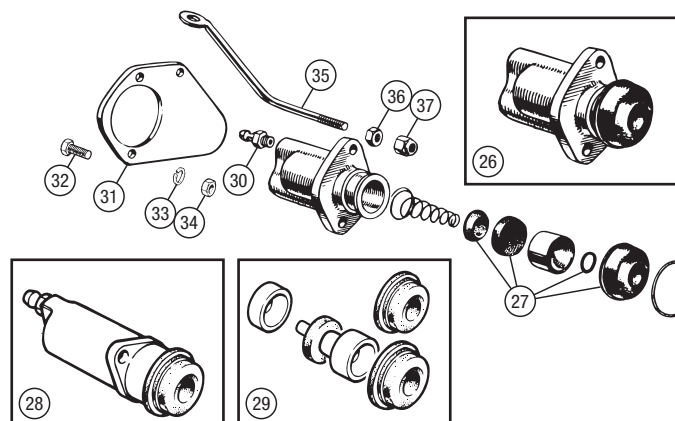
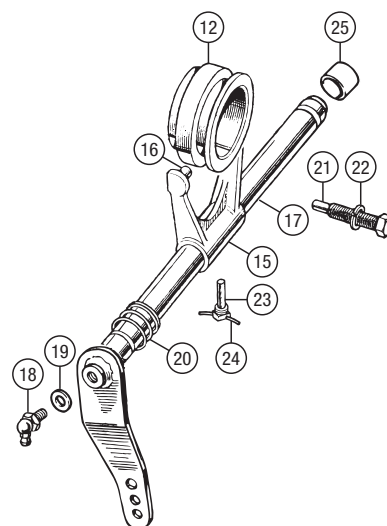
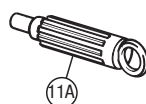
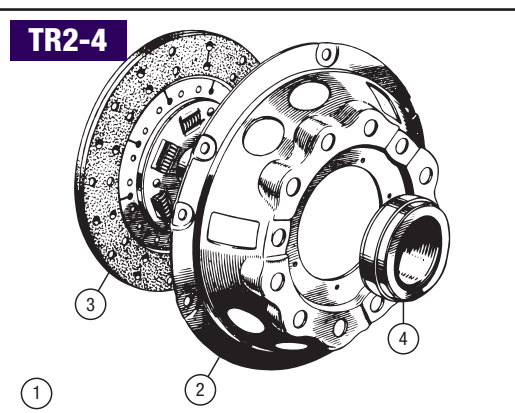




TR4A



TR2-4



CLUTCH KIT - RF4025



# TR2-4A

## Master Cylinder

### LOCKHEED MASTER CYLINDER; TR2, TR3 to TS13045

|    |  |   |         |
|----|--|---|---------|
| 1  | MASTER CYLINDER ASS'Y<br><i>Original; BSF threaded.</i>  | 1 | 201821  |
| 2  | MASTER CYLINDER ASS'Y<br><i>Replacement; UNF threaded.<br/>The replacement master cylinder is supplied together with the adaptor UNF/BSF brake pipe required to attach it to the four-way union in the brake system.</i> | 1 | RW3002  |
| 3  | REPAIR KIT, services both types,<br>less bellows   | 1 | 8G8224  |
| 4  | FILLER CAP, metal  | 1 | 501522  |
| 5  | SEAL, filler cap   | 1 | 501524  |
| 6  | FILLER CAP, plastic<br><i>Replacement for metal cap.</i>   | 1 | 513123A |
| 7  | ADAPTOR, master cylinder;<br>for original cylinder<br><i>BSF male thread.</i><br>for replacement cylinder<br><i>UNF male thread.</i>   | 1 | 108415  |
| 8  | WASHER, adaptor to master cylinder   | 1 | 233220A |
| 9  | COVER, top <i>(Original master cylinder)</i>   | 1 | 501189  |
| 10 | SCREW, top cover/front plate to body   | 6 | 501195  |
| 11 | WASHER, star   | 6 | GHF321  |
| 12 | GASKET, cover <i>(Original master cylinder)</i>  | 1 | 501190  |
| 13 | PLATE, front   | 1 | 501193  |
| 14 | GASKET, front plate<br><i>Must be replaced during rebuild.</i>   | 1 | AAA4757 |
| 15 | SPRING   | 2 | 59270   |

### ORIGINAL PUSHROD ASSEMBLY

|    |                            |   |          |
|----|----------------------------|---|----------|
| 16 | PUSHROD ASSEMBLY           | 2 | 501775   |
| 17 | CLEVIS PIN                 | 2 | CLZ516   |
| 18 | SPLIT PIN                  | 2 | PS103121 |
| 19 | WASHER, double coil spring | 2 | WS600051 |
| 20 | WASHER, plain              | 2 | GHF301   |

### REPLACEMENT PUSHROD ASSEMBLY

|    |  |   |          |
|----|--|---|----------|
| 21 | PUSHROD <i>(Cut to correct length)</i>             | 2 | 504852   |
| 22 | FORK END ASSEMBLY<br><i>Includes items 23, 24.</i> | 1 | 57190    |
| 23 | FORK   | 2 | 57194    |
| 24 | SCREW PIN, with spring                             | 2 | 216421A  |
| 25 | JAM NUT for fork                                   | 2 | NT605041 |
| 26 | SPLIT PIN  | 2 | PC34     |

|    |  |   |          |
|----|--|---|----------|
| 27 | BELLOW, push rod   | 2 | 501194   |
| 28 | BOLT, master cylinder to support<br>and adjustment bracket | 2 | BH606261 |
| 29 | WASHER, plain  | 4 | WP9      |
| 30 | WASHER, locking  | 2 | GHF333   |
| 31 | NUT  | 2 | GHF202   |
| 32 | BRACKET ASS'Y, cylinder adjustment                         | 2 | 107691   |
| 33 | JAM NUT  | 4 | NT604041 |

### GIRLING MASTER CYLINDER; TR3 from TS13046, TR3A

|    |   |   |          |
|----|---|---|----------|
| 34 | SUPPLY TANK, twin master cylinders                              | 1 | 114530   |
| 35 | FILLER CAP  | 1 | 106094   |
| 36 | SEAL, filler cap  | 1 | 106095   |
| 37 | DECAL, GIRLING WARNING  | 1 | RW3039   |
| 38 | CLIP, tank attachment   | 1 | 113368   |
| 39 | SCREW   | 2 | GHF117   |
| 40 | NUT, plain  | 2 | GHF200   |
| 41 | WASHER, locking   | 2 | GHF331   |
| 42 | PIPE, supply tank to master cylinder                            | 1 | 505062   |
| 43 | CLUTCH MASTER CYLINDER<br><i>Includes pushrod but not fork.</i> | 1 | 122167   |
| 44 | REPAIR KIT, clutch master cylinder                              | 1 | GRK1027  |
| 45 | SPRING, piston return   | 1 | 510815A  |
| 46 | SPACER, piston to plunger                                       | 1 | 111163   |
| 47 | PUSHROD   | 1 | 507206   |
| 48 | NUT, locking  | 1 | NT605041 |
| 49 | FORK END ASS'Y <i>(Includes items 50, 51)</i>                   | 1 | 57190    |
| 50 | FORK END  | 1 | 57194    |
| 51 | SCREW PIN, with spring  | 1 | 216421A  |
| 52 | SPLIT PIN   | 1 | PC34     |
| 53 | SCREW, master cylinder to support bracket                       | 2 | SH605071 |
| 54 | NUT, plain  | 1 | GHF201   |
| 55 | WASHER, locking   | 2 | GHF332   |

### CLUTCH MASTER CYLINDER; TR4, TR4A

|    |  |   |         |
|----|--|---|---------|
| 56 | CLUTCH MASTER CYLINDER;<br>0.75" bore <i>includes pushrod</i>  | 1 | 130887  |
|    | 0.70" bore <i>pushrod not included</i><br><i>The 0.70" bore master cylinder is identified as such by a marking in the casting.</i> | 1 | 132909  |
| 57 | REPAIR KIT;<br>0.75" cylinder  | 1 | GRK1027 |
|    | 0.70" cylinder   | 1 | 18G8986 |
| 58 | FILLER CAP   | 1 | 106094  |
| 59 | SEAL, filler cap   | 1 | 106095  |
| 60 | SPRING, piston return  | 1 | 510815A |
| 61 | SPACER, piston to plunger  | 1 | 111163  |
| 62 | PUSHROD  | 1 | 510197  |
| 63 | SCREW, master cylinder to bracket  | 2 | GHF103  |
| 64 | NUT, plain   | 2 | GHF202  |
| 65 | WASHER, locking  | 2 | GHF333  |

## Clutch Mounting, Pedal & Fittings

|    |   |   |          |
|----|---|---|----------|
| 66 | BRACKET ASSEMBLY;<br>TR2, TR3 to TS13045, Lockheed<br>TR3 from TS13046, TR3A, Girling<br>TR4 to CT26929<br><i>With hydraulic operated brake light switch.</i> | 1 | 106668   |
|    |   | 1 | 203239   |
|    |   | 1 | 132012   |
| 67 | BRACKET ASSEMBLY<br>TR4 from CT26930, TR4A<br><i>With mechanical brake light switch on the master cylinder bracket.</i>                                       | 1 | 138910   |
| 68 | COVER ASSEMBLY, pedal shaft   | 1 | 106670   |
| 69 | NUT, bracket and cover to bulkhead  | 4 | GHF201   |
| 70 | WASHER, locking   | 4 | GHF332   |
| 71 | SCREW, securing master cylinder<br><i>Attaches master cylinder and cover to bulkhead.</i>   | 2 | GHF120   |
| 72 | WASHER, locking   | 2 | GHF332   |
| 73 | SCREW, cover to bulkhead  | 2 | SH605051 |
| 74 | WASHER, locking   | 2 | GHF332   |
| 75 | SCREW, pedal stop, TR2, TR3 to TS13045  | 2 | SH604091 |
| 76 | NUT, jam, TR2, TR3 to TS13045   | 2 | GHF200   |
| 77 | BUSH, pedal pivot<br><i>Included in pedal assembly.</i>   | 4 | 100954   |
| 78 | SHAFT, pedal support  | 1 | 110016   |
| 79 | BRACKET, supporting pedal shaft   | 2 | 106678   |
| 80 | SCREW, securing bracket to shaft  | 2 | SH606061 |
| 81 | WASHER, locking   | 2 | GHF333   |
| 82 | CLEVIS PIN;<br>TR2, TR3 to TS13045  | 2 | CLZ516   |
|    | TR3 from TS13046, TR3A <i>(Screwed)</i>   | 2 | 216421A  |
|    | TR4, TR4A   | 2 | CLZ516   |
| 83 | WASHER, double coil<br>TR2, TR3 to TS13045  | 2 | WS600051 |
| 84 | SPRING, anti-rattle;<br>TR3 from TS13046, TR3A<br>TR4, TR4A   | 2 | AJD7731  |
|    |   | 2 | 131787   |
| 85 | WASHER, plain<br>TR2, TR3 to TS13045, TR4, TR4A   | 2 | GHF301   |
| 86 | SPLIT PIN;<br>TR2, TR3 to TS13045   | 2 | PS103121 |
|    | TR3 from TS13046, TR3A  | 2 | PC34     |
|    | TR4, TR4A   | 2 | PC10     |
|    | PEDAL RUBBER, ribbed<br>TR2, TR3 to TS13045   | 2 | 105159   |
| 87 | PEDAL RUBBER, 'T' logo<br>TR3 from TS13046, TR3A, TR4, TR4A.  | 2 | 122289   |
| 88 | SPRING, pedal return  | 2 | 57950    |

## Clutch Pipework

### LOCKHEED PIPEWORK; TR2, TR3 to TS13045

|    |   |     |           |
|----|---|-----|-----------|
| 89 | PIPE, master cyl. to chassis bracket;<br>RHD                | 1   | 108217    |
|    | LHD   | 1   | 108218    |
| 90 | CLIP, pipe to bulkhead<br><i>Quantity increases on RHD.</i> | 1/2 | 33084     |
| 91 | NUT, hose to chassis bracket                                | 1   | 59364     |
| 92 | WASHER, star  | 1   | WE600101  |
| 93 | HOSE, slave cylinder;<br>original flexible type             | 1   | GVP1001   |
|    | stainless steel braided alternative                         | 1   | GVP1001SS |
| 94 | WASHER, copper, hose to cylinder                            | 1   | 538532    |

### STAINLESS STEEL BRAIDED SLAVE CYLINDER HOSE - GBH415GR

### GIRLING PIPEWORK; TR3 from TS13046, TR3A.

|    |   |   |          |
|----|---|---|----------|
| 95 | PIPE, master cyl. to hose bracket;<br>RHD       | 1 | 507200   |
|    | LHD   | 1 | 507201   |
| 96 | NUT, locking, hose to bracket                   | 1 | NT606041 |
| 97 | WASHER, shakeproof                              | 1 | GHF323   |
| 98 | HOSE, slave cylinder;<br>original flexible type | 1 | GBH415   |
|    | s/steel braided alternative                     | 1 | GBH415GR |
| 99 | WASHER, hose to slave cylinder                  | 1 | 233220A  |

### CLUTCH PIPEWORK; TR4.

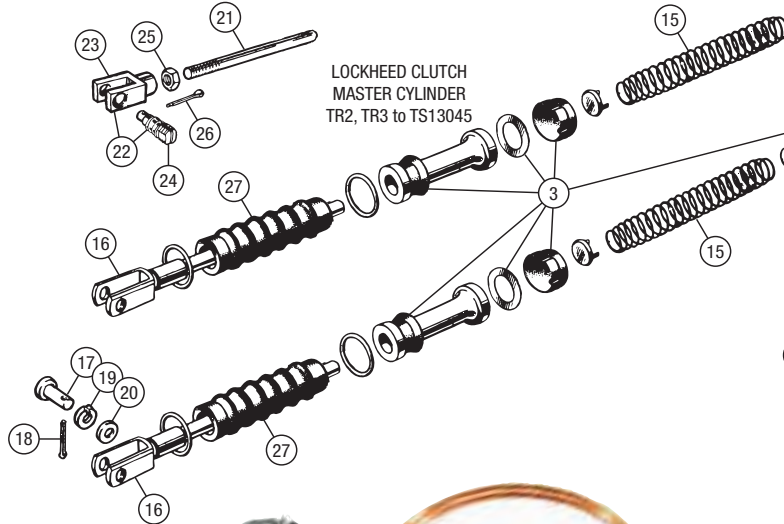
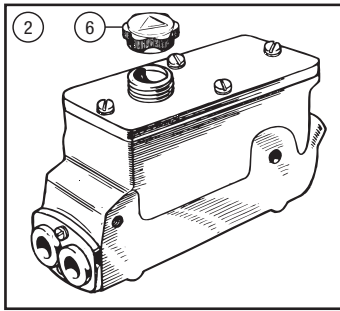
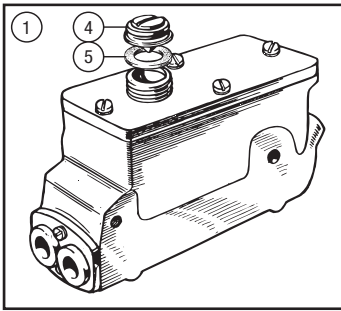
|     |  |   |          |
|-----|--|---|----------|
| 100 | PIPE, master cylinder to bracket;<br>RHD | 1 | 305385   |
|     | LHD                                      | 1 | 208531   |
| 101 | NUT, locking, hose to bracket            | 1 | NT606041 |
| 102 | WASHER, shakeproof                       | 1 | GHF323   |
| 103 | HOSE;<br>flexible rubber                 | 1 | GBH415   |
|     | stainless steel braided                  | 1 | GBH415GR |
| 104 | WASHER, hose to slave cylinder           | 1 | 233220A  |

### CLUTCH PIPEWORK; TR4A.

|     |   |     |          |
|-----|---|-----|----------|
| 105 | PIPE, master cylinder to union;<br>RHD                          | 1   | 308362   |
|     | LHD   | 1   | 148816   |
| 106 | UNION, double ended, hose to pipe                               | 1   | 598693   |
| 107 | HOSE, slave cylinder;<br>original plastic type                  | 1   | 143354   |
|     | s/steel braided alternative                                     | 1   | 143354GR |
| 108 | ADAPTER, hose to slave cylinder                                 | 1   | 143033   |
| 109 | BOLT, banjo, pipe to master cylinder                            | 1   | C5192A   |
| 110 | WASHER, copper  | 1   | 216914   |
| 111 | BANJO UNION   | 1   | BHA4310  |
| 112 | WASHER, copper<br>ADAPTOR, pipe to master cylinder<br>TR4A; LHD | 1   | 233220A  |
|     | WASHER, copper - TR4A; LHD                                      | 1   | 143033   |
| 113 | CLIP, pipe to bulkhead - TR4A; RHD                              | 1   | 108943   |
| 114 | SCREW, attaching clip - TR4A; RHD                               | 1   | GHF421   |
| 115 | CLIP, pipe to bulkhead<br>TR4A; quantity increases on RHD.      | 1/2 | 149766   |
| 116 | SCREW, attaching clip<br>TR4A; quantity increases on RHD.       | 1/2 | YM506    |

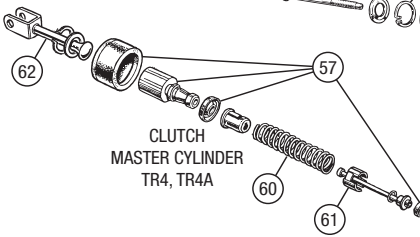
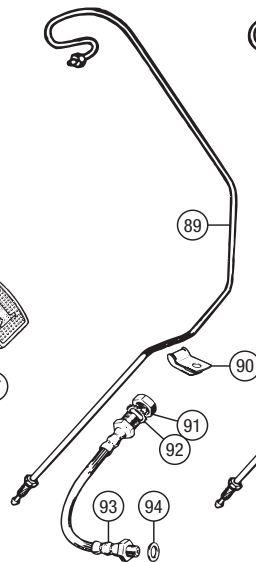
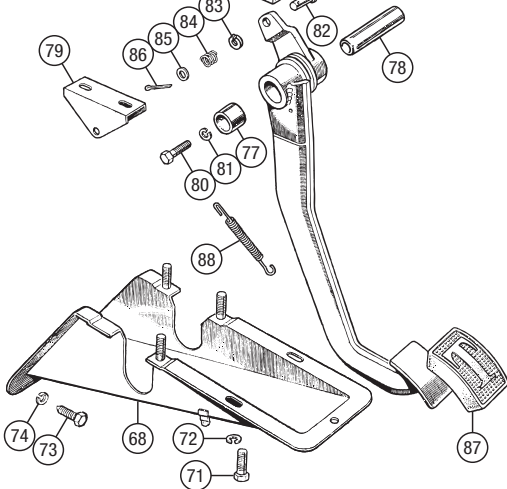
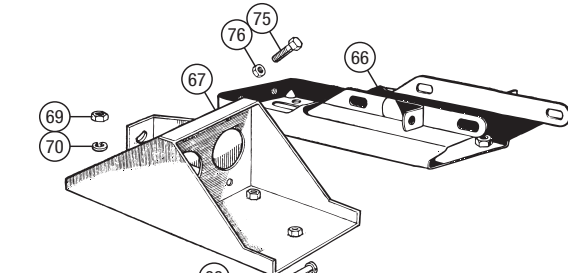




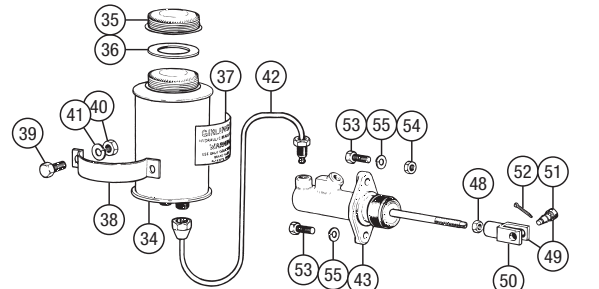
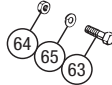
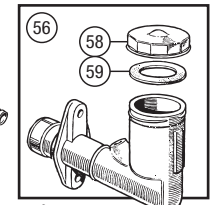


LOCKHEED CLUTCH  
MASTER CYLINDER  
TR2, TR3 to TS13045

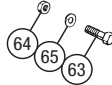
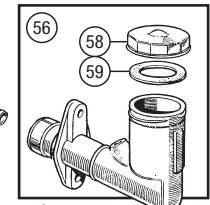
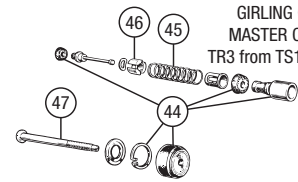
MASTER CYLINDER  
ASSEMBLY & PIPE -  
RW3002



CLUTCH  
MASTER CYLINDER  
TR4, TR4A



GIRLING CLUTCH  
MASTER CYLINDER  
TR3 from TS13046, TR3A





## TR5-250

# CLUTCH - 6 cylinder - TR5-250

## Clutch Assembly

Two different manufacturers supplied clutch assemblies for production line fitment to the 6 cylinder TRs. Debate still rages on the pros and cons to be had from using either a Borg and Beck or a Laycock clutch; the only indisputable fact is that they are completely interchangeable if fitted as functional sets of cover and plate.

Please note that the Borg and Beck clutch is usually the only one now available. Please enquire for current availability of Laycock components. One limiting factor must be considered when changing allegiances from one manufacturer to the other: the Borg And Beck cover assembly requires longer screws to attach it to the flywheel than those used to fit the Laycock cover (this is because the mounting flange on the Laycock cover is thinner than that on the Borg And Beck item). On the other hand, the length of the screw thread must not exceed 3/4" (for the Borg and Beck clutch) or 5/8" (for the Laycock clutch), otherwise the screws may bottom in the tapped hole in the flywheel, leaving the clutch cover loose.

|    |   |   |          |
|----|---|---|----------|
| 1  | CLUTCH KIT, 3 piece<br><i>Borg and Beck.</i>  | 1 | RR1114   |
| 2  | CLUTCH COVER ASSEMBLY<br><i>Borg and Beck.</i>  | 1 | GCC228   |
| 3  | CLUTCH DRIVEN PLATE<br><i>Borg and Beck.</i>  | 1 | GCP143   |
| 4  | CLUTCH COVER ASSEMBLY<br><i>Laycock.</i>  | 1 | GCC139   |
| 5  | CLUTCH DRIVEN PLATE<br><i>Laycock.</i>  | 1 | GCP214   |
| 6  | RELEASE BEARING, uprated specification<br><i>All applications.</i>  | 1 | GRB211UR |
| 7  | SCREW, clutch cover;<br>3/4" (fit in sets only)<br><i>Borg and Beck clutches.</i><br>5/8" (fit in sets only)<br><i>Laycock clutches.</i><br><i>We recommend locking these screws.</i><br><i>Adhere to the recommended 20 ft/lbs. fixing torque.</i>   | 6 | SH505061 |
| 8  | WASHER, locking<br><i>Always replace these.</i>   | 6 | GHF332   |
| 9  | DOWEL PIN, locating cover on flywheel   | 3 | UKC1937  |
| 10 | CLUTCH ALIGNMENT TOOL<br><i>Probably the trickiest aspect of clutch replacement is the fact that the clutch driven plate must be exactly centred on the flywheel when the clutch cover is fastened over it. This must be done to ensure that the gearbox input shaft mates correctly with both the driven plate and the spigot bush in the tail of the crankshaft. The result of clutch plate misalignment is the gearbox's stubborn inability to clamp up flush to the back of the engine when reassembled is attempted.</i><br><i>A clutch alignment tool will take the guesswork out of trying to centre the clutch driven plate. Most alignment tools are of a universal type; the item listed here is manufactured as a plastic replica of a 6 cylinder TR gearbox input shaft - there is no more accurate way of aligning your clutch (other than using a real, 'spare', input shaft!).</i><br><i>Having secured a new clutch to the flywheel, and before refitting the gearbox to the engine, a very light coating of copper grease should be applied to the splines (having wire brushed and cleaned them first) and spigot end of the gearbox input shaft.</i> | 1 | RX1389   |

## Clutch Operating Mechanism

|    |  |   |        |
|----|--|---|--------|
| 11 | SLEEVE, release bearing carrier;<br>original type (coated cast iron)<br>made from special material<br><i>For smoother clutch operation.</i>  | 1 | 147858 |
| 12 | ROLL PIN, locating fork on sleeve  | 1 | DS811  |
| 13 | RELEASE FORK ASSEMBLY  | 1 | 106022 |
| 14 | PIN, pivot, release fork to sleeve   | 2 | 100164 |
| 15 | PIN, tapered, fork to cross shaft<br><i>The tapered pin holding the release fork to the cross shaft often cracks or breaks. This can be the reason for clutch drag - caused by part of the slave cylinder push rod travel being taken up by movement between the fork and the cross shaft. When carrying out any work involving the removal of the engine, gearbox or both from the car, the opportunity should be taken to replace the pin while access to it is easy, whether it appears to need replacing or not.</i><br><i>Correct seating of the pin in the cross shaft is important. Ensure that any broken parts of the pin are removed from the fork and shaft. Also, the taper angle of the pin should correspond to that in the hole in the cross shaft. Trial fitment of the pin in the hole in the cross shaft without the presence of the release fork will bring to light any irregularities in the two components: if the pin wobbles in the hole, it may be 'lapped' into a better fit. If the amount of lapping required is excessive, replacement of the clutch cross shaft or the tapered pin may be necessary.</i> | 1 | 158777 |
| 16 | LOCKING WIRE, tapered pin  | 1 | 512781 |
| 17 | CROSS SHAFT AND LEVER ASS'Y  | 1 | 136354 |
| 18 | SPRING, alignment, cross shaft   | 1 | 144578 |
| 19 | BUSH, cross shaft (in gearbox casing)  | 2 | 137651 |
| 20 | PUSH ROD ASS'Y*,<br>slave cylinder to cross shaft lever<br><i>*This should connect to the centre hole on the lever assembly. The bottom hole is used by 2000 and 2.5 saloons. The top hole could be used to obtain extra clutch release bearing movement at the expense of a heavier clutch.</i>   | 1 | 138572 |
| 21 | CLEVIS PIN, securing push rod on lever   | 1 | PJ8808 |
| 22 | WASHER, plain  | 1 | GHF301 |
| 23 | SPLIT PIN  | 1 | PC10   |



CLUTCH KIT - RR1114

## Clutch Slave Cylinder

At an undefined time in the past, the design of some of the internal components of the clutch slave cylinder was changed. While the cylinder bore size remained unaltered, the seal and piston changed in the way they assembled. As stated above the change point was not documented, so the repair kit that is now supplied includes not only the parts to reveal a later cylinder, but also those required to update an earlier version.

SLAVE CYLINDER ASSEMBLY - UKC8677



|    |                                    |   |          |
|----|------------------------------------|---|----------|
| 24 | SLAVE CYLINDER ASSEMBLY, clutch    | 1 | UKC8677  |
| 25 | REPAIR KIT, slave cylinder         | 1 | 513390   |
| 26 | NIPPLE, bleed                      | 1 | 606733A  |
| 27 | SPRING                             | 1 | 606731   |
| 28 | BRACKET, slave cylinder to gearbox | 1 | 136353   |
| 29 | BOLT, slave cylinder to bracket    | 2 | SH605091 |
| 30 | WASHER, locking                    | 2 | GHF332   |
| 31 | NUT                                | 2 | GHF201   |
| 32 | BOLT, bracket to gearbox casing    | 2 | BH605131 |
| 33 | WASHER, locking                    | 2 | GHF332   |
| 34 | NUT                                | 2 | GHF201   |

## Clutch Master Cylinder

The TR5, TR250 master cylinders were continued unchanged well into TR6 production. However on later TR6s, the bore of the clutch master cylinder assembly changed from 3/4" (0.75) to 7/10" (0.70). The change very effectively lightened the clutch pedal load; the downside was that it aggravated the problem of insufficient clutch clearance on a mechanism that was worn or had a broken tapered pin in the cross shaft. The later, smaller bore diameter, master cylinders may be used to replace earlier types but the above comment must be taken into account if doing so.

If a repair kit is required, before placing an order the cylinder bore diameter must obviously be identified (don't assume because you have an earlier 6 cylinder TR that you have an earlier cylinder fitted). This is simply achieved by reading the size off the exterior of the cylinder.

|    |   |   |         |
|----|---|---|---------|
| 35 | CLUTCH MASTER CYLINDER ASS'Y;<br>RH steering,<br>original 0.75" bore<br>later 0.70" bore<br>LH steering,<br>original 0.75" bore<br>later 0.70" bore | 1 | 148531  |
| 36 | PUSH ROD ASSEMBLY;<br>RH steering<br>LH steering  | 1 | 122296  |
| 37 | FILLER CAP  | 1 | 148607  |
| 38 | SPRING, piston return   | 1 | 106094  |
| 39 | REPAIR KIT, master cylinder;<br>original 0.75" bore<br>later 0.70" bore   | 1 | 510815A |
| 40 | SEAL, filler cap  | 1 | GRK1027 |
| 41 | CIRCLIP, push rod retaining   | 1 | 1868986 |
| 42 | CLEVIS PIN, securing pushrod to pedal   | 1 | 106095  |
| 43 | WASHER, plain   | 1 | 106092  |
| 44 | SPLIT PIN   | 1 | PJ8808  |

Any wear or looseness of the clevis pin (ill. no. 42), either in the pedal or in the master cylinder push rod, must be rectified. The wear will restrict the total amount of clutch pedal movement being transmitted to the master cylinder. This in turn brings on the age old problem of clutch drag that 6 cylinder TRs seem to be dogged with as they get older. If you suffer clutch drag (symptoms: 'rattling' engagement into reverse gear; engagement/ disengagement stiffness in other gears), fit new clevis pins as they may just fix your problem - at minimal expense!

## Clutch Mounting, Pedal & Fittings

|    |  |   |          |
|----|--|---|----------|
| 45 | BRACKET, clutch mounting   | 1 | 146313   |
| 46 | DUST COVER, clutch pedal & push rod                              | 1 | 125217   |
| 47 | SCREW, master cylinder to bracket;<br>RH steering<br>LH steering | 2 | SH605071 |
| 48 | WASHER, locking  | 2 | GHF103   |
| 49 | PEDAL ASSEMBLY, clutch;<br>RH steering<br>LH steering            | 1 | GHF332   |
| 50 | PAD, pedal, rubber   | 1 | 148021   |
| 51 | BUSH, clutch pedal to pedal shaft                                | 1 | 148023   |
| 52 | RETURN SPRING, pedal   | 2 | 122289   |
|    |  | 1 | 136611   |
|    |  | 1 | 57950    |

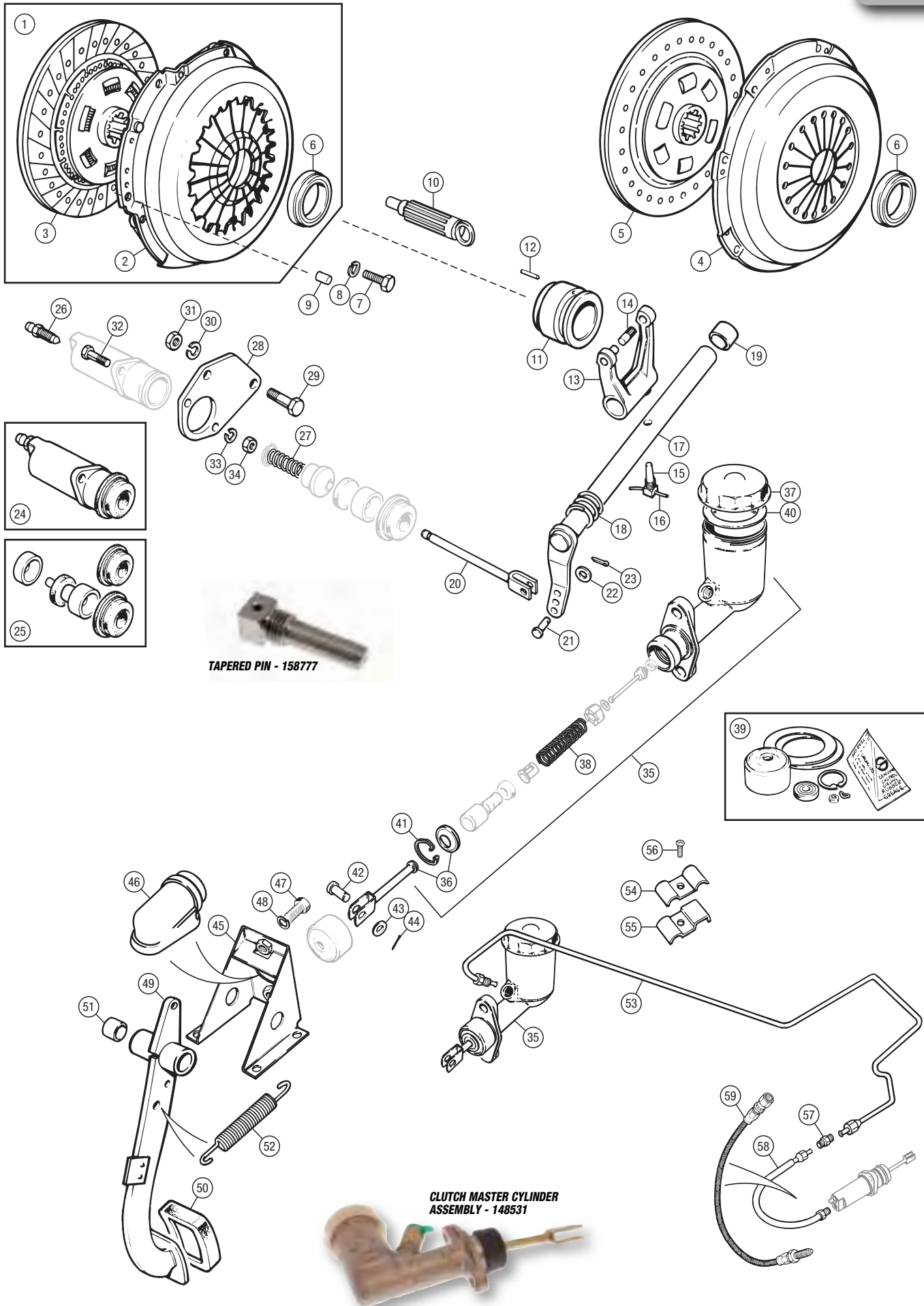
Please see 'Brake' section for brake pedal and other pedal box details.

## Clutch Pipework

|    |   |     |          |
|----|---|-----|----------|
| 53 | PIPE, master cylinder to hose;<br>RH steering<br>LH steering  | 1   | 308362   |
| 54 | CLIP, pipe to bulkhead - RH Steering  | 1   | 148816   |
| 55 | CLIP, pipe to bulkhead - LH Steering  | 4   | 108943   |
| 56 | SCREW, pipe clip to bulkhead<br><i>Qty. increased on RH steering models.</i>  | 1   | 149766   |
| 57 | CONNECTOR, pipe to hose   | 1/4 | AB606039 |
| 58 | HOSE, flexible,<br>connector to slave cylinder<br><i>Original specification.</i>                                      | 1   | 598693   |
| 59 | HOSE, flexible, connector to slave cylinder,<br>stainless steel braided<br><i>Alternative; uprated specification.</i> | 1   | 140420   |
|    |   | 1   | 140420GR |









## ALL MODELS

### Engine Mountings

#### TR2, TR3, TR3A, TR3B

|   |                                      |     |        |
|---|--------------------------------------|-----|--------|
| 1 | MOUNTING, engine, flexible           | 2   | 59180  |
| 2 | NUT, nyloc, mounting to engine plate | 2   | TN3209 |
| 3 | WASHER, plain                        | 2   | WP9    |
| 4 | SCREW, mounting to chassis           | 4   | GHF103 |
| 5 | WASHER, plain                        | 4   | GHF301 |
| 6 | NUT, nyloc                           | 2   | GHF272 |
| 7 | WASHER, locking                      | 2   | GHF332 |
| 8 | SHIM, engine mounting                | A/R | 109582 |
| 9 | BRACKET, steady                      | 4   | 106428 |

The steady bracket restricts longitudinal movement of the engine when braking or accelerating.

#### RECTANGULAR ENGINE MOUNTING - 143057



#### TR4, TR4A

|  |   |     |        |
|--|---|-----|--------|
| 10   | MOUNTING, engine, flexible, round                   | 2   | 130985 |
| <i>Early TR4. See item 11 also.</i>  |   |     |        |
| 11   | MOUNTING, engine, flexible, rectangular             | 2   | 143057 |
| <i>Late TR4, TR4A. The rectangular engine mount is preferred fitment to the round one (early TR4) as its design restricts engine longitudinal movement, and may replace the round type if fitted in pairs.</i> |   |     |        |
| 12   | NUT, engine mounting                                | 4   | GHF202 |
| 13   | WASHER, locking                                     | 4   | GHF333 |
| 14   | WASHER, packing                                     | A/R | 134234 |
| <i>The rectangular engine mount is preferred fitment to the round one as its design restricts engine longitudinal movement.</i>  |   |     |        |
| 15   | BRACKET, engine torque restriction - TR4            | 1   | 133471 |
| 16   | BUFFER, torque restriction bracket to chassis - TR4 | 1   | 612962 |
| 17   | NUT - TR4   | 1   | GHF201 |
| 18   | WASHER, locking - TR4                               | 1   | GHF332 |

The torque restriction bracket assembly was factory fitted to TR4s. It can be fitted without modifications to TR4As.

#### TR5, TR250

|   |   |     |          |
|---|---|-----|----------|
| 19  | BRACKET, engine mounting                                | 2   | 145385   |
| 20  | SCREW, bracket to cylinder block                        | 6/8 | SH606061 |
| <i>Qty. increases for TR250.</i>  |   |     |          |
| 21  | WASHER, locking   | 6/8 | GHF333   |
| 58  | CROSSMEMBER, gearbox mounting                           | 1   | 211361   |
| 22  | STUD, bracket and air manifold stay to cyl. block - TR5 | 2   | 105124   |
| 23  | WASHER, locking - TR5                                   | 2   | GHF333   |
| 24  | NUT - TR5   | 2   | GHF202   |
| <i>The stud, washer and nut listed above are located on the upper positions of the RH bracket. They also secure the air manifold stay on petrol injection models.</i> |   |     |          |
| 25  | MOUNTING, engine, flexible                              | 2   | UKC8330  |
| 26  | WASHER, plain   | 4   | GHF302   |
| 27  | NUT, nyloc, mounting to bracket                         | 4   | TN3209   |
| 28  | SCREW, mounting to chassis frame                        | 4   | SH606091 |
| 29  | WASHER, plain   | 4   | GHF302   |
| 30  | NUT, nyloc  | 4   | GHF223   |

#### 'J' TYPE O/D CONVERSION CROSSMEMBER ASSEMBLY - 211361X



### Gearbox Mountings

#### TR2, TR3, TR3A

|   |                                    |   |            |
|---|------------------------------------|---|------------|
| 31  | CROSSMEMBER, gearbox mounting      | 1 | 128055     |
| <i>Finish gearbox mounting holes as required.</i>   |                                    |   |            |
| 32  | SCREW, crossmember to chassis      | 4 | SH606061   |
| 33  | WASHER, locking                    | 4 | GHF333     |
| 34  | MOUNTING, gearbox, flexible        | 1 | 104086     |
| 35  | ADAPTOR, gearbox mounting          | 1 | 1104086ADP |
| <i>Allows saloon A type overdrive to be fitted to 104086 mounting. Minor overdrive casing modifications are required.</i> |                                    |   |            |
| 36  | WASHER, plain                      | 2 | WC600071   |
| 37  | WASHER, locking                    | 2 | WL600071   |
| 38  | NUT, mounting to crossmember       | 2 | GHF203     |
| 39  | BRACKET, steady, gearbox mounting  | 2 | 107895     |
| 40  | BOLT, gearbox to flexible mounting | 2 | GHF109     |
| 41  | WASHER, locking                    | 2 | GHF335     |
| 42  | NUT, gearbox to flexible mounting  | 2 | GHF204     |

#### TR3B, TR4

|   |   |   |            |
|---|---|---|------------|
| 43  | CROSSMEMBER, gearbox mounting               | 1 | 128055     |
| <i>Finish gearbox mounting holes as required.</i>   |   |   |            |
| 44  | SCREW, crossmember to chassis               | 4 | SH606061   |
| 45  | WASHER, locking                             | 4 | GHF333     |
| 46  | MOUNTING, gearbox, flexible                 | 1 | 104086     |
| 47  | ADAPTOR, gearbox mounting                   | 1 | 1104086ADP |
| <i>Allows saloon A type overdrive to be fitted to 104086 mounting. Minor overdrive casing modifications are required.</i> |   |   |            |
| 48  | WASHER, plain                               | 2 | WC600071   |
| 49  | WASHER, locking                             | 2 | WL600071   |
| 50  | NUT, mounting to crossmember                | 2 | GHF203     |
| 51  | BOLT, gearbox to flexible mounting, RH      | 1 | GHF109     |
| 52  | WASHER, locking                             | 1 | GHF335     |
| 53  | NUT, gearbox to flexible mounting, RH       | 1 | GHF204     |
| 54  | BOLT, gearbox to flexible mounting, LH      | 1 | BH608161   |
| 55  | WASHER, spacing LH bolt                     | 1 | 131690     |
| 56  | STRAP, gearbox top cover to mounting flange | 1 | 131711     |
| 57  | NUT & BRACKET ASS'Y, to LH gearbox mounting | 1 | 130888     |

#### TR4A

|   |   |   |            |
|---|---|---|------------|
| 58  | CROSSMEMBER, gearbox mounting               | 1 | 211361     |
| 59  | CROSSMEMBER ASSEMBLY, conversion            | 1 | 211361X    |
| <i>Allows gearbox with later J type overdrive to be fitted to an A type overdrive chassis. Includes mounting rubber and hardware.</i> |   |   |            |
| 60  | SCREW, crossmember to chassis frame         | 4 | SH606061   |
| 61  | WASHER, plain                               | 4 | GHF302     |
| 62  | WASHER, plain                               | 4 | GHF302     |
| 63  | WASHER, locking                             | 4 | GHF333     |
| 64  | NUT   | 4 | GHF202     |
| 65  | MOUNTING, gearbox, flexible                 | 1 | 104086     |
| 66  | ADAPTOR, gearbox mounting                   | 1 | 1104086ADP |
| <i>Allows saloon A type overdrive to be fitted to 104086 mounting. Minor overdrive casing modifications are required.</i>             |   |   |            |
| 67  | WASHER, plain                               | 2 | WC600071   |
| 68  | WASHER, locking                             | 2 | WL600071   |
| 69  | NUT, mounting to crossmember                | 2 | GHF203     |
| 70  | BOLT, gearbox to flexible mounting, RH      | 1 | GHF109     |
| 71  | WASHER, locking                             | 1 | GHF335     |
| 72  | NUT, gearbox to flexible mounting, RH       | 1 | GHF204     |
| 73  | BOLT, gearbox to flexible mounting, LH      | 1 | BH608161   |
| 74  | WASHER, spacing LH bolt                     | 1 | 131690     |
| 75  | STRAP, gearbox top cover to mounting flange | 1 | 131711     |
| 76  | NUT & BRACKET ASS'Y, to LH gearbox mounting | 1 | 142531     |

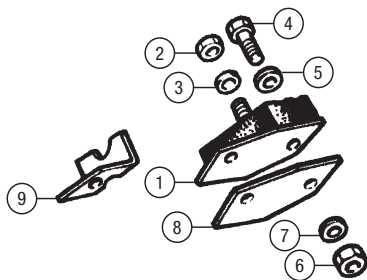
#### TR5, TR250

|   |  |   |            |
|---|--|---|------------|
| 77  | CROSSMEMBER, gearbox mounting                            | 1 | 211361     |
| 78  | CROSSMEMBER ASSEMBLY, conversion                         | 1 | 211361X    |
| <i>Allows gearbox with later J type overdrive to be fitted to an A type overdrive chassis. Includes mounting rubber and hardware.</i> |  |   |            |
| 79  | SCREW, crossmember to chassis frame                      | 4 | SH606061   |
| 80  | WASHER, plain  | 4 | GHF302     |
| 81  | WASHER, plain  | 4 | GHF302     |
| 82  | WASHER, locking  | 4 | GHF333     |
| 83  | NUT  | 4 | GHF202     |
| 84  | MOUNTING, gearbox, flexible                              | 1 | 104086     |
| 85  | ADAPTOR, gearbox mounting                                | 1 | 1104086ADP |
| <i>Allows saloon A type overdrive to be fitted to 104086 mounting. Minor overdrive casing modifications are required.</i>             |  |   |            |
| 86  | WASHER, plain  | 2 | WC600071   |
| 87  | WASHER, locking  | 2 | WL600071   |
| 88  | NUT, mounting to crossmember                             | 2 | GHF203     |
| 89  | BOLT, gearbox to flexible mounting                       | 2 | GHF109     |
| 90  | WASHER, locking  | 1 | GHF335     |
| 91  | NUT, gearbox to flexible mounting, RH                    | 1 | GHF204     |
| 92  | NUT & BRACKET ASS'Y, gearbox mounting to exhaust - TR5   | 1 | 148875     |
| 93  | NUT & BRACKET ASS'Y, gearbox mounting to exhaust - TR250 | 1 | 142531     |

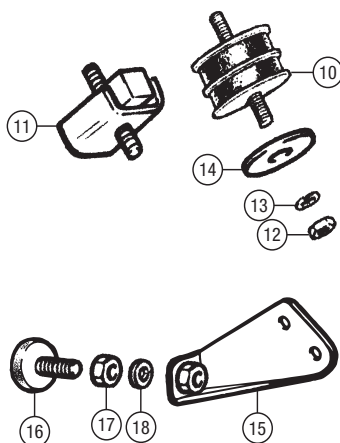




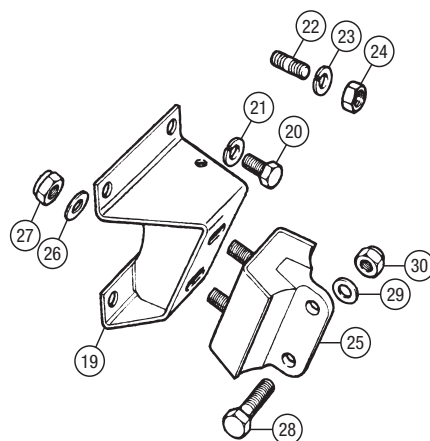
# TR2, TR3, TR3A, TR3B



# TR4, TR4A

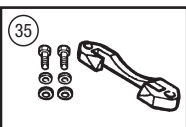
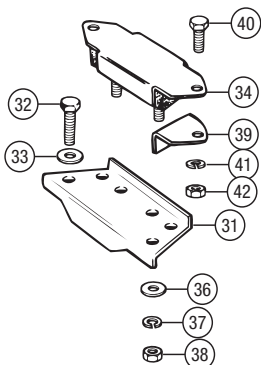
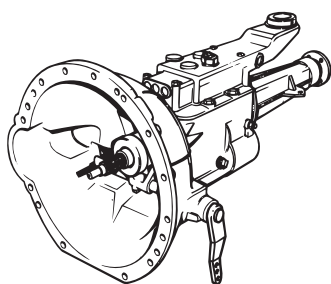


# TR5, TR250

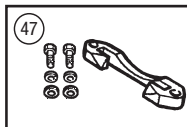
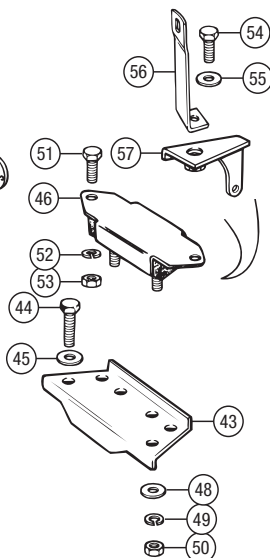
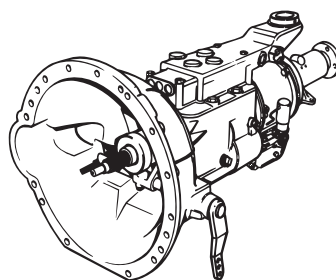


# ALL MODELS

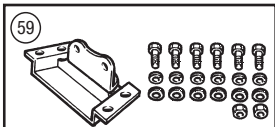
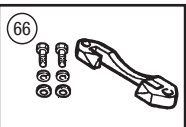
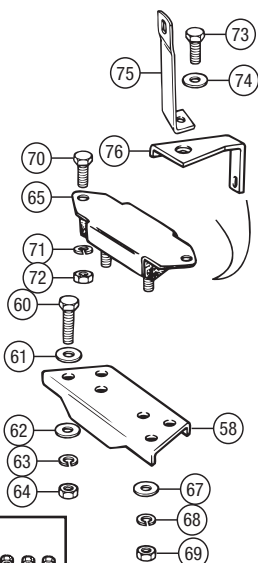
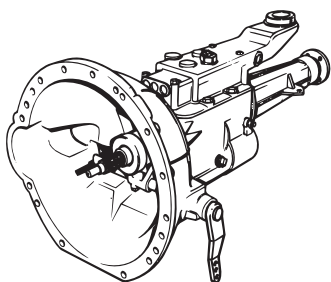
# TR2, TR3, TR3A



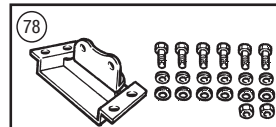
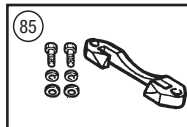
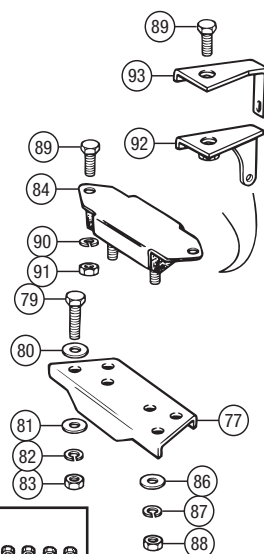
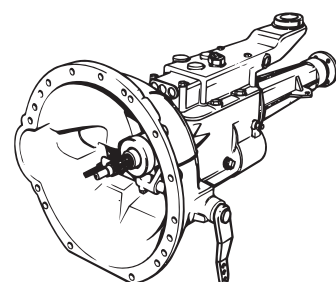
# TR3B, TR4



# TR4A



# TR5, TR250





## TR2-4A

COOLING - 4 cylinder - TR2-4A

The cooling system of the 4 cylinder TR is troublesome if not maintained. The standard mechanical cooling fan is not only inefficient as a cooling device at idling speeds but saps engine power when driving.

### Kenlowe Fan Kit

- |   |   |   |                  |
|---|---|---|------------------|
| 1 | KENLOWE cooling fan kit;<br>TR2, TR3, TR3A<br>TR4, TR4A   | 1 | RW3037<br>RB7065 |
| 2 | KENLOWE FAN ONLY<br><i>Replacement, no motor.</i>   | 1 | RB7065FAN        |
| 3 | KENLOWE thermostatic radiator control<br><i>Probe fits in top hose, included with kit.</i>  | 1 | KLM1416          |
| 4 | KENLOWE FAN SWITCH<br><i>Included with kit.</i><br><i>Automatic control of the Kenlowe fan can alternatively be achieved by the use of an 'Otter' temperature switch fitted in a specially adapted bottom hose connecting pipe. For details, see items 80 and 81.</i> | 1 | KLM0570          |



### Fan

- |    |   |   |          |
|----|---|---|----------|
| 5  | FAN, 4-bladed - TR2, TR3, TR3A          | 1 | 202025   |
| 6  | FAN, 4-bladed - TR4, TR4A               | 1 | 209792   |
| 7  | FAN, 6-bladed - TR4A option             | 1 | 211986   |
| 8  | BOLT, fan attachment                    | 4 | BH605111 |
| 9  | TAB WASHER, fan bolt locking            | 2 | 107857   |
| 10 | WASHER, plain                           | 4 | GHF301   |
| 11 | BUSH, rubber, fan mounting;<br>standard | 8 | 108496   |
|    | polyurethane                            | 8 | 108496P  |
| 12 | SLEEVE, steel in fan bush               | 4 | 108499   |
| 13 | KIT, fan attachment                     | 1 | 308353FK |

### Water Pump Housing & Thermostat

- |    |  |   |          |
|----|--|---|----------|
| 14 | HOUSING, water pump  | 1 | 57014    |
| 15 | GASKET, housing to block   | 1 | 138586   |
| 16 | BOLT, housing to block   | 2 | BH506181 |
| 17 | WASHER, locking  | 2 | GHF333   |
| 18 | PLUG, screwed<br><i>Fitted when heater not installed.</i>  | 1 | 114774   |
| 19 | ADAPTOR, screwed<br><i>Fitted when heater is installed.</i>  | 1 | 101343   |
| 20 | THERMOSTAT, bellows type;<br><i>Original design thermostat.</i>  |   |          |
|    | winter   | 1 | 107590WW |
|    | summer - 160°F, 74°C   | 1 | 107590   |
| 21 | THERMOSTAT;<br>hot climates - 160°F, 74°C  | 1 | GTS102   |
|    | standard - 180°F, 82°C   | 1 | GTS104   |
|    | cold climates - 195°F, 88°C  | 1 | GTS106   |
| 22 | TRANSMITTER, temperature gauge<br>TR4, TR4A  | 1 | GTR104   |
|    | <i>This transmitter screws into the thermostat housing on TR4s &amp; TR4As.<br/>TR2, TR3 &amp; TR3A use a capillary type gauge - see 'Instruments &amp; Switches'.</i> |   |          |
| 23 | WASHER, fibre,<br>sealing temperature sender<br><i>Use if shouldered, parallel-threaded temperature sender is fitted.</i>  | 1 | WF513    |

#### TR2 to engine no. TS1200E

- |    |  |   |          |
|----|--|---|----------|
| 24 | COVER PLATE, thermostat housing        | 1 | 108490   |
| 25 | COVER, with outlet, thermostat         | 1 | 105584   |
| 26 | GASKET, cover to housing               | 1 | 105593   |
| 27 | GASKET, housing to cylinder head       | 1 | GTG103   |
| 28 | GASKET, top cover                      | 1 | 154680   |
| 29 | HOUSING, thermostat                    | 1 | 201522   |
| 30 | BOLT, housing & cover plate attachment | 1 | BH505281 |
| 31 | BOLT, housing attachment               | 1 | BH505161 |
| 32 | NUT, plain                             | 5 | GHF201   |
| 33 | STUD, cover plate attachment           | 2 | 107067   |
| 34 | STUD, thermostat cover attachment      | 2 | FHS2512  |
| 35 | WASHER, locking                        | 7 | GHF332   |



UNDAMPED  
NARROW BELT  
CONVERSION KIT -  
RW3102

#### TR2 from engine no. TS1201E, TR3, TR3A, TR4, TR4A

- |    |  |   |          |
|----|--|---|----------|
| 36 | COVER, with outlet, thermostat   | 1 | 124744   |
| 37 | GASKET, thermostat cover & housing   | 2 | GTG103   |
| 38 | HOUSING, thermostat;<br>attach with BH605221 bolts   | 1 | 202033   |
|    | attach with BH605161 bolts   | 1 | 203781   |
|    | <i>Measure the depth of the thermostat housing to determine the length of attachment bolts required.</i> |   |          |
| 39 | NUT, plain   | 2 | GHF201   |
| 40 | STUD, thermostat cover   | 2 | FHS2512  |
| 41 | BOLT, thermostat cover<br><i>Alternative to stud and nut.</i>  | 2 | BH605111 |
| 42 | BOLT, thermostat housing;<br>2 3/4" (Use on 202033 housing)<br>2" (Use on 203781 housing)                | 2 | BH505221 |
|    |  | 2 | BH505161 |
| 43 | WASHER, locking  | 4 | GHF332   |

### Water Pump

- |    |   |     |             |
|----|---|-----|-------------|
| 44 | WATER PUMP & PULLEY ASS'Y;<br><i>With removable pulley.</i>   |     |             |
|    | standard  | 1   | 501488      |
|    | uprated   | 1   | 501488UR    |
| 45 | WATER PUMP, less pulley;<br>standard  | 1   | GWP202      |
|    | uprated   | 1   | GWP202UR    |
| 46 | GASKET, pump to housing<br><i>Included with water pump.</i>   | 1   | 138587      |
| 47 | PULLEY, water pump;<br>for standard wide fan belt<br>alloy pulley for narrow drive<br>belt conversion | 1   | 105537      |
|    |   | 1   | 105537ALLOY |
| 48 | STUD, water pump to housing   | 2   | 56243       |
| 49 | WASHER, locking   | 3   | GHF333      |
| 50 | NUT   | 2/3 | GHF202      |
|    | <i>Quantity increases for replacement pump with non-removable pulley.</i>                             |     |             |
| 51 | BOLT, water pump to housing<br><i>Use with removable pulley pumps.</i>                                | 1   | BH506241    |
|    | STUD, to replace bolt<br><i>Use with non-removable pulley pumps.</i>                                  | 1   | TE506241    |
| 52 | KEY, pulley to shaft  | 1   | WKN405      |
| 53 | WASHER, plain   | 1   | WP19        |
| 54 | NUT, self-locking   | 1   | GHF242      |
| 55 | GREASE NIPPLE   | 1   | 125361      |



NEW TR4A  
RADIATOR -  
307309

UPGRADED TR4  
ALUMINIUM  
RADIATOR -  
402001UR

SEE PAGE 268  
FOR ADDITIONAL PHOTO'S.

### Fan Belt

- |    |   |   |          |
|----|---|---|----------|
| 56 | FAN BELT;<br>original style 'wide' drive belt | 1 | GFB40975 |
|    | replacement 'narrow' drive belt               | 1 | GCB10975 |

#### NARROW BELT CONVERSION

Fitting your 4 cylinder TR with a narrow fan belt is a case of choosing from the parts and kits listed here that are appropriate for your car. There are several reasons why you should change from the original, wide belt to a narrow one; one is that of course you are always going to have more luck finding and buying a narrow belt (3/8" belts have been the standard for automotive use for many years) when you need one for servicing and repairs. There's also the fact that being what the industry almost always specified, the narrow belt benefits from years of development to make it more efficient and reliable. If you're feeling particularly protective towards your engine, the dampened narrow belt option gives you the opportunity to protect the crankshaft by significantly reducing harmonic shock waves. This does entail the elimination of the mechanical cooling fan and fan extension and the substitution of an electric cooling fan when the original crank pulley is replaced by the new dampened pulley. However, you do end up with a 'win-win' situation here because not only do you get a far better and more easily serviced fan belt on your car, but you also vastly improve the efficiency of the cooling system (the Achilles Heel of a 4 cylinder TR), too. For owners who want a narrow belt system but don't want to go as far as losing their friendly old mechanical cooling fan, an undamped narrow belt system can be chosen instead.

- |    |   |   |        |
|----|---|---|--------|
| 57 | NARROW BELT KIT;<br>undamped  | 1 | RW3102 |
|    | <i>Fitment allows retention of mechanical cooling fan.<br/>Includes undamped alloy crankshaft pulley (using original fan extension), replacement alloy water pump pulley, alternator pulley, fan belt and fitting instructions.</i> |   |        |
|    | damped  | 1 | RW3101 |
|    | <i>Fitment involves deletion of mechanical cooling fan.<br/>Includes damped alloy crankshaft pulley with spacer, washer and bolt, replacement alloy water pump pulley, alternator pulley, fan belt and fitting instructions.</i>    |   |        |

#### The following items are also serviced separately:

- |    |   |   |             |
|----|---|---|-------------|
| 58 | PULLEY, crank, narrow belt,<br>undamped                                 | 1 | 107252ALLOY |
|    | <i>Fitment allows retention of mechanical cooling fan.</i>              |   |             |
| 59 | PULLEY, water pump, narrow belt   | 1 | 105537ALLOY |
| 60 | PULLEY, alternator, narrow belt;<br>2 1/2" dia. (for standard road use) | 1 | AEU1238     |
|    | 2 3/4" dia. (for fast road use)   | 1 | 12G1054     |
| 61 | FAN BELT, narrow  | 1 | GCB10975    |

### Radiator

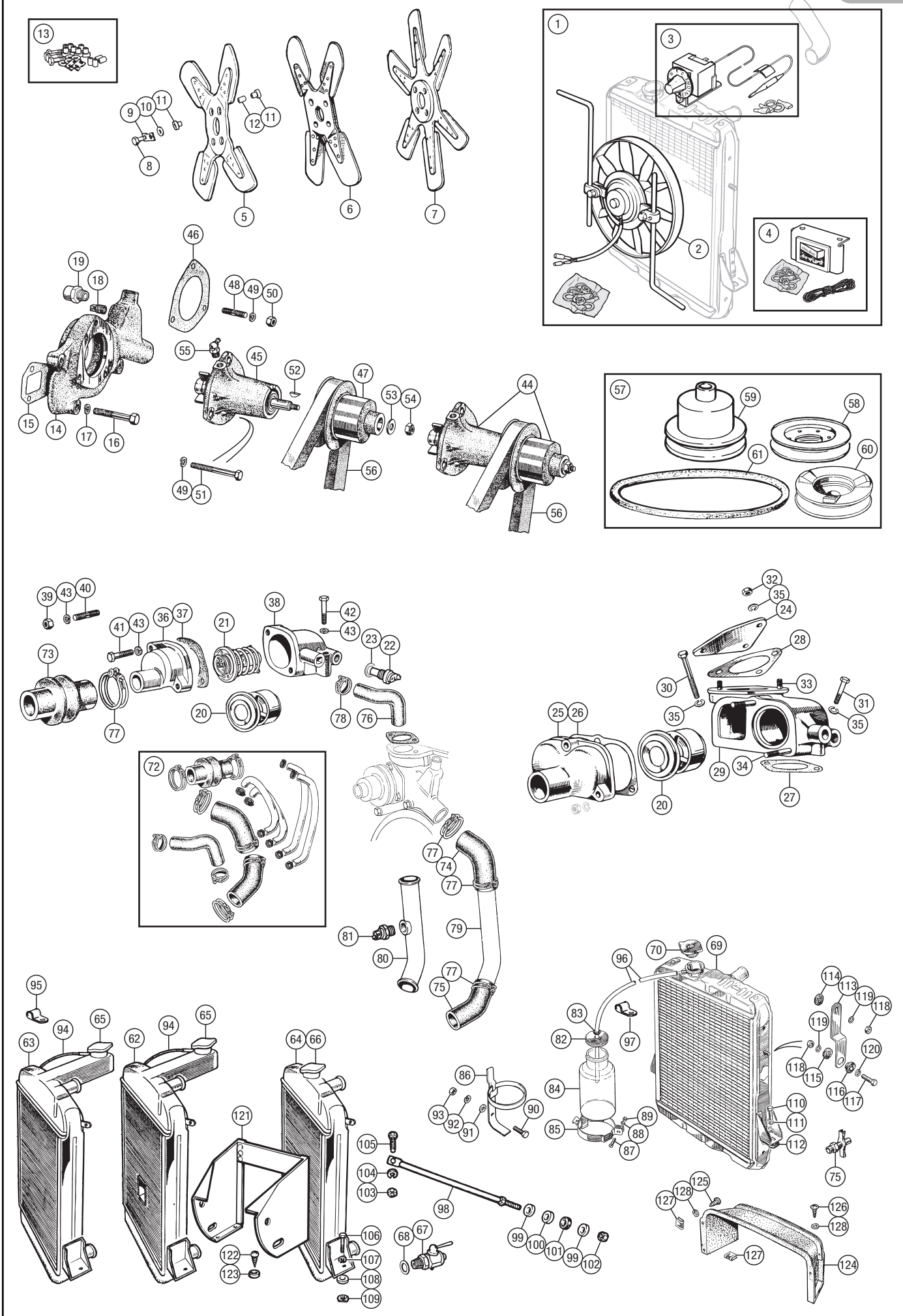
#### TR2, TR3, TR3A, TR4

- |    |  |   |          |
|----|--|---|----------|
| 62 | RADIATOR;<br>centre inlet - TR2 to engine no. TS1200E  |   |          |
|    | exchange   | 1 | 400311R  |
|    | long neck, offset inlet, with starting handle hole<br>TR2 from engine no. TS1201E, TR3, TR3A |   |          |
|    | new  | 1 | 400412   |
|    | exchange   | 1 | 400412R  |
|    | uprated, aluminium   | 1 | 401869UR |
|    | TR4 type (long neck, without starter handle hole).   |   |          |
|    | long neck, with starting handle hole - TR4   |   |          |
|    | new  | 1 | 134456   |
|    | exchange   | 1 | 134456R  |
| 63 | RADIATOR;<br>long neck, without starting handle hole<br>TR4 to comm. no. CT9552              |   |          |
|    | new  | 1 | 401869   |
|    | exchange   | 1 | 401869R  |
|    | uprated, aluminium   | 1 | 401869UR |
|    | TR2, TR3, TR3A, TR4 to CT9552.   |   |          |
| 64 | RADIATOR;<br>no neck, without starting handle hole<br>TR4 from comm. no. CT9556.             |   |          |
|    | new  | 1 | 402001   |
|    | exchange   | 1 | 402001R  |
|    | uprated, aluminium - TR4 from CT9556   | 1 | 402001UR |
| 65 | CAP, radiator;<br>4lb, 1" depth - TR2, TR3, TR3A   | 1 | GRC103   |
|    | 7lb, 1" depth  | 1 | GRC101   |
|    | Optional TR2, TR3, TR3A; TR4 with filler neck.   |   |          |
| 66 | CAP, radiator;<br>7lb, 3/4" depth - TR4 without filler neck                                  | 1 | GRC112   |
|    | 13lb, 3/4" depth   | 1 | GRC114   |
|    | Optional TR4 without filler neck.  |   |          |
| 67 | TAP, radiator drain  | 1 | 61864    |
| 68 | WASHER, fibre, sealing drain tap   | 1 | WF511A   |

#### TR4A

- |    |                                   |   |          |
|----|-----------------------------------|---|----------|
| 69 | RADIATOR;<br>new                  | 1 | 307309   |
|    | exchange                          | 1 | 307309R  |
|    | uprated, aluminium                | 1 | 307309UR |
| 70 | CAP, radiator;<br>7lb, 3/4" depth | 1 | GRC112   |
|    | 13 lb, 3/4" depth (Optional)      | 1 | GRC114   |
| 71 | TAP, radiator drain               | 1 | 132565   |







## TR2-4A

# COOLING - 4 cylinder - TR2-4A

### RUBBER HOSE KIT - RF4035



## Radiator Hoses

### HOSE KITS

Hose kits include all radiator and heater hoses, plus Jubilee type clips.

|                                   |   |               |
|-----------------------------------|---|---------------|
| <b>72</b> HOSE KIT, rubber hoses; |   |               |
| TR2, TR3, TR3A                    | 1 | <b>RW3046</b> |
| TR4                               | 1 | <b>RF4035</b> |
| TR4A                              | 1 | <b>RF4036</b> |

### RADIATOR HOSES

|  |   |                   |
|--|---|-------------------|
| <b>73</b> HOSE, thermostat housing to radiator (top hose); |   |                   |
| rubber   | 1 | <b>GRH453</b>     |
| silicone   | 1 | <b>GRH453X</b>    |
| <b>74</b> HOSE, pipe to water pump (intermediate hose);    |   |                   |
| rubber   | 1 | <b>GRH389</b>     |
| silicone   | 1 | <b>GRH389X</b>    |
| <b>75</b> HOSE, radiator to pipe (bottom hose);            |   |                   |
| rubber - TR2, TR3, TR3A                                    | 1 | <b>GRH389</b>     |
| silicone - TR2, TR3, TR3A                                  | 1 | <b>GRH389X</b>    |
| rubber - TR4, TR4A   | 1 | <b>130038</b>     |
| silicone - TR4, TR4A                                       | 1 | <b>130038X</b>    |
| <b>76</b> HOSE, bypass;                                    |   |                   |
| rubber   | 1 | <b>105598</b>     |
| silicone   | 1 | <b>105598X</b>    |
| <b>77</b> CLIP, top, intermediate & bottom hoses;          |   |                   |
| original wire band type                                    | 6 | <b>CS4029</b>     |
| replacement 'Jubilee' type                                 | 6 | <b>GHC1217</b>    |
| <b>78</b> CLIP, bypass hose;                               |   |                   |
| original type  | 2 | <b>CS4020</b>     |
| replacement 'Jubilee' type                                 | 2 | <b>GHC913</b>     |
| <b>79</b> PIPE, connecting hoses;                          |   |                   |
| mild steel (original type)                                 | 1 | <b>130039</b>     |
| stainless steel (replacement type)                         | 1 | <b>130039SS</b>   |
| <b>80</b> PIPE, connecting hoses,                          |   |                   |
| stainless steel (with Otter switch boss)                   | 1 | <b>130039SSST</b> |
| <b>81</b> TEMPERATURE SWITCH, Otter                        | 1 | <b>RW3041</b>     |
| <i>For auto control of Kenlowe fan (86° on, 76° off)</i>   |   |                   |

## Overflow Bottle

### TR4A

|   |   |                 |
|---|---|-----------------|
| <b>82</b> CAP, overflow bottle                  | 1 | <b>137743</b>   |
| <b>83</b> GROMMET                               | 1 | <b>616925</b>   |
| <b>84</b> BOTTLE, overflow                      | 1 | <b>137632</b>   |
| <b>85</b> BRACKET, overflow bottle, original    | 1 | <b>141606</b>   |
| <i>Fits to radiator mounting bolt.</i>          |   |                 |
| <b>86</b> BRACKET, overflow bottle, replacement | 1 | <b>713544</b>   |
| <i>Fits with items 90-93.</i>                   |   |                 |
| <b>87</b> SCREW, clamping bottle in bracket     | 1 | <b>PT508</b>    |
| <b>88</b> WASHER, locking                       | 1 | <b>WL105001</b> |
| <b>89</b> NUT, plain                            | 1 | <b>HN2005</b>   |
| <b>90</b> SCREW, replacement bracket            |   |                 |
| to inner wing                                   | 2 | <b>HU504</b>    |
| <i>Use with replacement bracket.</i>            |   |                 |
| <b>91</b> WASHER, plain                         | 2 | <b>WP5</b>      |
| <b>92</b> WASHER, locking                       | 2 | <b>WL105001</b> |
| <b>93</b> NUT, plain                            | 2 | <b>HN2005</b>   |

### OVERFLOW HOSE; TR2, TR3, TR3A, TR4

|  |   |                 |
|--|---|-----------------|
| <b>94</b> HOSE, overflow, (cut to 30") | 1 | <b>GRH1001M</b> |
| <b>95</b> CLIP, overflow hose;         |   |                 |
| to RH stay                             | 1 | <b>239600</b>   |
| to mounting bracket - TR4              | 1 | <b>611793</b>   |

### OVERFLOW HOSE; TR4A

|  |   |               |
|--|---|---------------|
| <b>96</b> HOSE, overflow                   | 1 | <b>137742</b> |
| <b>97</b> CLIP, 'P' type, overflow hose to |   |               |
| radiator stay                              | 1 | <b>508185</b> |

## Air Duct & Stay Rods

### STAY RODS; TR2, TR3, TR3A, TR4

|  |   |                 |
|--|---|-----------------|
| <b>98</b> ROD, radiator support;                   |   |                 |
| TR2, TR3, TR3A                                     | 2 | <b>111164</b>   |
| TR4  | 2 | <b>131585</b>   |
| <b>99</b> WASHER, plain                            | 4 | <b>RTC610A</b>  |
| <b>100</b> BUSH TR4 from CT1016.                   | 2 | <b>GEX7329</b>  |
| <b>101</b> WASHER, rubber TR4 from CT1016.         | 2 | <b>GEX7330</b>  |
| <b>102</b> NUT, jam, stay to body bracket          | 4 | <b>NT605041</b> |
| <b>103</b> NUT, plain, stay to radiator attachment | 2 | <b>GHF201</b>   |
| <b>104</b> WASHER, locking                         | 2 | <b>GHF332</b>   |
| <b>105</b> SCREW, stay to radiator                 | 2 | <b>GHF120</b>   |

### RADIATOR MOUNTINGS; TR2, TR3, TR3A, TR4

|  |     |                 |
|--|-----|-----------------|
| <b>106</b> SCREW, radiator mounting  | 2   | <b>SH606101</b> |
| <i>Note: this screw is fitted from the top on TR4 and TR4A and from the bottom on TR2, TR3 and TR3A.</i> |     |                 |
| <b>107</b> WASHER, locking   | 2   | <b>GHF333</b>   |
| <b>108</b> WASHER, plain   | 2   | <b>GHF316</b>   |
| <b>109</b> PACKING, radiator mounting  | A/R | <b>601994</b>   |
| <i>Positions the top hose inlet pipe with thermostat housing.</i>  |     |                 |

### RADIATOR MOUNTINGS; TR4A

|   |     |                 |
|---|-----|-----------------|
| <b>110</b> SCREW, radiator mounting                               | 2   | <b>SH606101</b> |
| <b>111</b> WASHER, locking  | 2   | <b>GHF333</b>   |
| <b>112</b> PACKING, radiator mounting                             | A/R | <b>601994</b>   |
| <i>Positions the top hose inlet pipe with thermostat housing.</i> |     |                 |

### STAY BRACKETS; TR4A

|  |   |                 |
|--|---|-----------------|
| <b>113</b> BRACKET, radiator support       | 2 | <b>142665</b>   |
| <b>114</b> WASHER, rubber                  | 2 | <b>2K9679</b>   |
| <b>115</b> WASHER, rubber                  | 2 | <b>GEX7330</b>  |
| <b>116</b> BUSH, rubber, stay to front     |   |                 |
| suspension box                             | 2 | <b>GEX7329</b>  |
| <b>117</b> BOLT, bracket to suspension box | 2 | <b>BH605101</b> |
| <b>118</b> NUT, bracket to radiator and    |   |                 |
| suspension box                             | 4 | <b>GHF201</b>   |
| <b>119</b> WASHER, locking                 | 4 | <b>GHF332</b>   |
| <b>120</b> WASHER, plain                   | 2 | <b>RTC610A</b>  |

### RADIATOR DUCT; TR3A

|                                |   |                 |
|--------------------------------|---|-----------------|
| <b>121</b> RADIATOR DUCT SET   | 1 | <b>803440/8</b> |
| <b>122</b> SCREW, self tapping | 4 | <b>YZ3404</b>   |
| <b>123</b> WASHER, plain       | 4 | <b>WP4</b>      |



RADIATOR DUCT - 850435

### RADIATOR DUCT; TR4, TR4A

|  |   |                 |
|--|---|-----------------|
| <b>124</b> RADIATOR DUCT                 | 1 | <b>850435</b>   |
| <b>125</b> SCREW, self tapping 1/2" long | 4 | <b>AB610043</b> |
| <b>126</b> SCREW, self tapping 3/4" long | 3 | <b>AB610063</b> |
| <b>127</b> SPIRE NUT, fixing             | 7 | <b>GHF712</b>   |
| <b>128</b> WASHER, plain                 | 7 | <b>WP5</b>      |



## Original Style Hose Clips

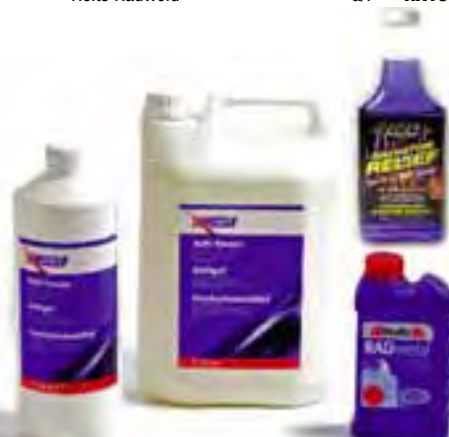
Measure the thickness/outside diameter of your hoses to get the right size:

|                            |     |               |
|----------------------------|-----|---------------|
| HOSE CLIP, wire band type; |     |               |
| 3/4" to 7/8"               | A/R | <b>CS4012</b> |
| 1 3/16" to 1 3/8"          | A/R | <b>CS4020</b> |
| 1 3/8" to 1 9/16"          | A/R | <b>CS4025</b> |
| 1 7/16" to 1 5/8"          | A/R | <b>CS4026</b> |
| 1 11/16" to 1 7/8"         | A/R | <b>CS4029</b> |
| 2 1/4" to 2 7/16"          | A/R | <b>CS4038</b> |
| 2 13/32" to 2 5/8"         | A/R | <b>CS4042</b> |

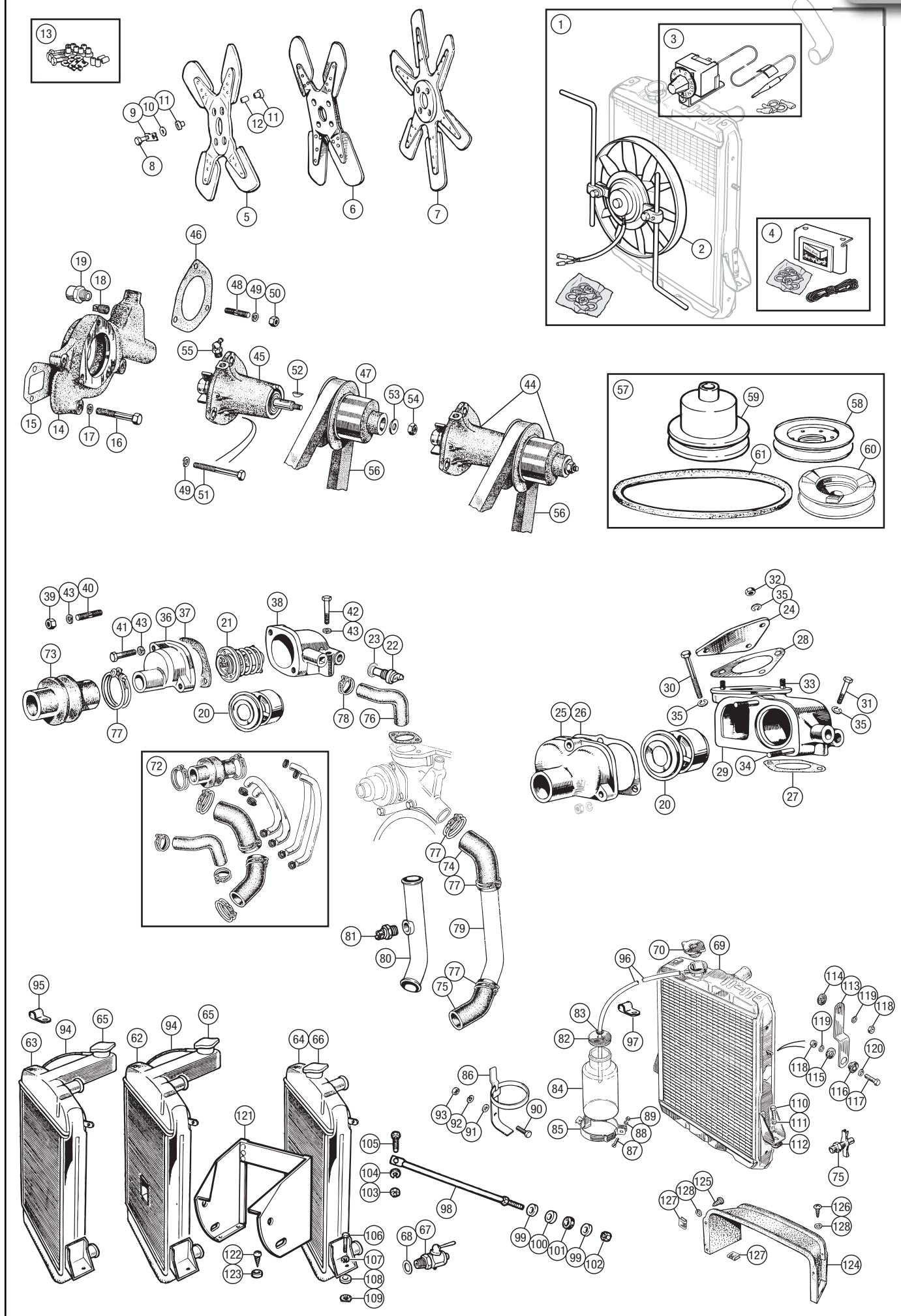
## Anti-freeze

8 litre capacity cooling system.

|                          |     |                |
|--------------------------|-----|----------------|
| Anti-freeze;             |     |                |
| 1 litre                  | a/r | <b>GAC2018</b> |
| 5 litre                  | a/r | <b>GAC2019</b> |
| Radiator Relief          |     |                |
| Cooling system additive. | 1   | <b>RX1461</b>  |
| Holts Radweld            | a/r | <b>RX1508</b>  |









| No. | DESCRIPTION | QTY REQ. | PART No. | No. | DESCRIPTION | QTY REQ. | PART No. | No. | DESCRIPTION | QTY REQ. | PART No. |
|-----|-------------|----------|----------|-----|-------------|----------|----------|-----|-------------|----------|----------|
|-----|-------------|----------|----------|-----|-------------|----------|----------|-----|-------------|----------|----------|

## TR5-250

### Kenlowe Fan Kit

|   |   |   |           |
|---|---|---|-----------|
| 1 | KENLOWE ELECTRIC FAN KIT  | 1 | RB7065    |
| 2 | KENLOWE FAN ONLY<br><i>Replacement (no motor).</i>                    | 1 | RB7065FAN |
| 3 | THERMO SWITCHING SENSOR<br><i>included with kit.</i>                  | 1 | KLM1416   |
| 4 | MANUAL OVER-RIDE SWITCH<br><i>included with kit. (Facia mounted).</i> | 1 | KLM0570   |

Automatic control of the Kenlowe fan can alternatively be achieved by the use of an 'Otter' temperature switch fitted in a specially adapted bottom hose connecting pipe. For details, see items listed under no. 80.

### Fan

|    |   |   |          |
|----|---|---|----------|
| 5  | FAN, 8 blade, plastic (blue)<br><i>Original item.</i> | 1 | 308353   |
| 7  | FITTING KIT, fan blade                                | 1 | 308353FK |
| 8  | BOLT, extension and pulley<br>to crankshaft           | 1 | 148832   |
| 9  | EXTENSION, fan  | 1 | 148831   |
| 10 | DOWEL PIN, extension to pulley                        | 1 | 140419   |
| 11 | BUSH, fan to extension;<br>standard                   | 8 | 108496   |
|    | polyurethane ( <i>Upgraded</i> )                      | 8 | 108496P  |
| 12 | SLEEVE, fan to extension                              | 4 | 108499   |
| 13 | WASHER, plain   | 4 | GHF301   |
| 14 | WASHER, tab, fan attachment bolt                      | 2 | 107857   |
| 15 | BOLT, fan to extension                                | 4 | BH605101 |
| 16 | PULLEY & DAMPER ASSEMBLY,<br>3/8" wide belt groove.   | 1 | 154380   |

### Water Pump Housing & Thermostat

|    |   |   |          |
|----|---|---|----------|
| 17 | HOUSING, water pump;<br>standard                          | 1 | 307095   |
|    | alloy   | 1 | 307095A  |
| 18 | STUD, water pump to housing                               | 3 | TE605105 |
| 19 | WASHER, locking   | 3 | GHF332   |
| 20 | NUT   | 3 | GHF201   |
| 21 | GASKET, housing to cylinder head                          | 1 | 138792   |
| 22 | BOLT, housing to cylinder head;<br>original (3 1/8" long) | 1 | BH605251 |
|    | alternative (3 1/4" long)                                 | 1 | BH605261 |
| 23 | BOLT, housing to cylinder head<br>2 1/4" long.            | 2 | BH605181 |
| 24 | WASHER, locking   | 3 | GHF332   |
| 25 | ADAPTOR, heater return pipe to housing                    | 1 | 101343   |
| 26 | PIPE, heater return, TR5<br>stainless steel               | 1 | 214404SS |
| 27 | PIPE, heater return, TR250<br>stainless steel             | 1 | 214405SS |
| 28 | NUT, tube   | 1 | 101302   |
| 29 | OLIVE, sealing  | 1 | TL11     |
| 30 | PLUG, blanking<br><i>Use if heater is not fitted.</i>     | 1 | 114774   |
| 31 | PLUG, blanking - TR5                                      | 1 | 122132   |
| 32 | WASHER, fibre, sealing plug - TR5                         | 1 | WF513    |
| 33 | ADAPTOR, housing to inlet manifold<br>TR250.              | 1 | 138530   |
| 34 | WASHER, fibre, sealing adaptor - TR250                    | 1 | WF524    |
| 35 | TEMPERATURE SENDER UNIT                                   | 1 | GTR108   |
| 36 | THERMOSTAT;<br>180°F (82°C) standard                      | 1 | GTS104   |
|    | 160°F (74°C)<br><i>Hot climates/summer.</i>               | 1 | GTS102   |
|    | 195°F (88°C)<br><i>Cold climates/winter.</i>              | 1 | GTS106   |
| 37 | ELBOW, water outlet ( <i>replacement type</i> )           | 1 | 156333   |
| 38 | GASKET, water outlet                                      | 1 | GTG103   |
| 39 | SCREW, elbow to housing                                   | 1 | GHF103   |
| 40 | BOLT, elbow to housing;<br>original                       | 1 | BH605141 |
|    | replacement   | 1 | BH605101 |
| 41 | WASHER, locking   | 2 | GHF332   |

KENLOWE ELECTRIC  
FAN KIT - RB7065



### Water Pump

TR5s, TR250s and the earliest TR6's were fitted with a water pump that had a detachable pulley. This type of pump is easily identified by the self locking nut that retains the pulley on the pump spindle; as a bonus, this design of water pump is repairable. It was replaced on later TR6s by a water pump and pulley assembly; this time the pulley was pressed on to the shaft. This unfortunately means that the pulley cannot easily be removed and therefore the pump is not easily repaired. The pump and pulley assembly, GWP201, will substitute for any previous TR5 and TR250 water pump application.

#### WITH DETACHABLE PULLEY

|    |   |     |         |
|----|---|-----|---------|
| 42 | WATER PUMP & PULLEY ASSEMBLY<br><i>with detachable 3/8" wide pulley</i> | 1   | 517257  |
| 43 | SPINDLE   | 1   | 104839  |
| 44 | IMPELLOR  | 1   | 104840  |
| 45 | SEAL, impeller to bearing housing                                       | 1   | 148322  |
| 46 | SEAL, on spindle  | 1   | 60313   |
| 47 | CIRCLIP, bearing locating on shaft                                      | 1   | 500047  |
| 48 | WASHER, abutment circlip to bearing                                     | 1   | 101092  |
| 49 | BEARING   | 2   | 100764  |
| 50 | SPACER, between bearings  | 1   | 104841  |
| 51 | CIRCLIP, bearing locating in housing                                    | 1   | 100851  |
| 52 | KEY, woodruff, spindle to pulley  | 1   | WKN405  |
| 53 | WASHER, plain   | 1   | WP19    |
| 54 | NUT, nyloc, pulley to spindle   | 1   | GHF272  |
| 55 | PULLEY, pump driving, 3/8" wide belt drive;<br>standard                 | 1   | 133239  |
|    | alloy   | 1   | 133239A |
| 56 | PLUG, lubrication hole  | 1   | 122115  |
| 57 | LUBRICATOR, grease nipple<br><i>Fitted only when servicing.</i>         | A/R | 125361  |

#### WITH FIXED PULLEY

|    |   |   |         |
|----|---|---|---------|
| 58 | WATER PUMP & PULLEY ASSEMBLY,<br>with fixed 3/8" wide pulley;<br>standard | 1 | GWP201  |
|    | alloy   | 1 | GWP201A |
| 59 | GASKET, pump to housing   | 1 | 138701  |

### Fan Belt

|    |                |   |          |
|----|----------------|---|----------|
| 60 | FAN BELT, 3/8" | 1 | GCB11088 |
|----|----------------|---|----------|

### Radiator

Note that the later TR6 style radiators 312347, 312347R and 312347UR have an angled (rather than straight) bottom outlet and therefore require fitting of the TR6 type water return pipe (see item 80).

|    |                                    |   |          |
|----|------------------------------------|---|----------|
| 61 | RADIATOR;<br>new                   |   |          |
|    | original type                      | 1 | 308850   |
|    | later TR6 type                     | 1 | 312347   |
|    | uprated (aluminium) later TR6 type | 1 | 312347UR |
|    | reconditioned, exchange            |   |          |
|    | original type                      | 1 | 308850R  |
|    | TR6 type                           | 1 | 312347R  |
| 62 | CAP, radiator, 7 psi               | 1 | GRC112   |
| 63 | DRAIN TAP                          | 1 | 132565   |

#### SCREWED RADIATOR MOUNTING

|    |                                  |     |          |
|----|----------------------------------|-----|----------|
| 64 | SCREW, radiator to chassis frame | 2   | SH606091 |
| 65 | WASHER, plain                    | 2   | GHF302   |
| 66 | PACKING, radiator mounting       | A/R | 601994   |

#### STUD RADIATOR MOUNTING; Alternative to 64-66

|    |                                      |     |        |
|----|--------------------------------------|-----|--------|
| 67 | STUD, radiator mounting to chassis   | 2   | 143712 |
| 68 | WASHER, plain                        | 2   | GHF302 |
| 69 | NUT, plain, radiator mounting        | 2   | GHF202 |
| 70 | PACKING, radiator mounting           | A/R | 601994 |
| 71 | STAY, radiator to chassis cross tube | 2   | 147574 |
| 72 | SCREW, stay to cross tube            | 2   | GHF120 |
| 73 | WASHER, locking                      | 2   | GHF332 |
| 74 | NUT                                  | 2   | GHF201 |
| 75 | WASHER, locking                      | 2   | GHF332 |
| 76 | NUT, stay to radiator frame          | 2   | GHF201 |

## Radiator Hoses

### HOSE KITS

Kits include all hoses for cooling and heating & corresponding jubilee type hose clips. Available in black or green.

|    |   |   |         |
|----|---|---|---------|
| 77 | HOSE KIT;                                     |   |         |
|    | black - TR5                                   | 1 | RR1168  |
|    | green (Later TR6 alternative; will fit TR5)   | 1 | RR1168G |
|    | black - TR250                                 | 1 | RF4037  |
|    | green (Later TR6 alternative; will fit TR250) | 1 | RR1266G |

### RADIATOR HOSES

Note: For heater hoses, refer to Heater section.

|    |  |   |             |
|----|--|---|-------------|
| 78 | TOP HOSE;  |   |             |
|    | black (original colour)  | 1 | GZA971      |
|    | green (later TR6 alternative)  | 1 | GZA971GREEN |
| 79 | BOTTOM HOSE, curved;   |   |             |
|    | black (original colour)  | 1 | GRH393      |
|    | curved, green (later TR6 colour)   | 1 | GRH393GREEN |
| 80 | PIPE, water return;  |   |             |
|    | steel, original type   | 1 | 145398      |
|    | steel, TR6 type  | 1 | 158417      |
|    | stainless steel, TR6 type  | 1 | 158417SS    |
|    | stainless, with Kenlowe fan<br>switch boss   | 1 | 158417SST   |
|    | Otter switch, Kenlowe fan,<br>86° on, 76° off  | 1 | RW3041      |
|    | Note that 158417, 158417SS and 158417SST return pipes require fitting of a later TR6 radiator with angled bottom outlet (see item 61). |   |             |
| 81 | BOTTOM HOSE, straight;   |   |             |
|    | black (original colour)  | 1 | GRH392      |
|    | green (later TR6 colour)   | 1 | GRH392GREEN |
| 82 | CLIP, hose clamping;   |   |             |
|    | 'Supergrip' wire band type   | 6 | CS4024      |
|    | 'Jubilee' type (alternative)   | 6 | GHC1217     |

#### INLET MANIFOLD HOSES; TR250

|    |   |   |              |
|----|---|---|--------------|
| 83 | HOSE, water pump to inlet manifold;         |   |              |
|    | black (original colour)                     | 1 | 149699       |
|    | green (later TR6 colour)                    | 1 | 149699GREEN  |
| 84 | CLIP, hose clamping                         | 2 | CS4012       |
| 85 | HOSE, inlet manifold to heater return pipe; |   |              |
|    | black (original colour)                     | 1 | UKC5253      |
|    | green (later TR6 colour)                    | 1 | UKC5253GREEN |
| 86 | CLIP (clamping hose to heater return pipe)  | 1 | CS4012       |
| 87 | CLIP (clamping hose to inlet manifold)      | 1 | CS4014       |

## Overflow Bottle

|    |                                 |   |          |
|----|---------------------------------|---|----------|
| 88 | BOTTLE, overflow                | 1 | 137632   |
| 89 | CAP, overflow bottle            | 1 | 137743   |
| 90 | GROMMET, protecting pipe in cap | 1 | 616925   |
| 91 | PIPE, overflow                  | 1 | 137742   |
| 92 | BRACKET, overflow bottle        | 1 | 713544   |
| 93 | SCREW, bracket to wheel arch    | 2 | HU504    |
| 94 | WASHER, plain                   | 2 | WP5      |
| 95 | WASHER, locking                 | 2 | WL105001 |
| 96 | NUT                             | 2 | HN2005   |

## Valances

### TR250

|    |                                 |   |        |
|----|---------------------------------|---|--------|
| 97 | VALANCE, wheel arch to radiator | 2 | 714536 |
| 98 | CLIP, valance                   | 8 | 613600 |

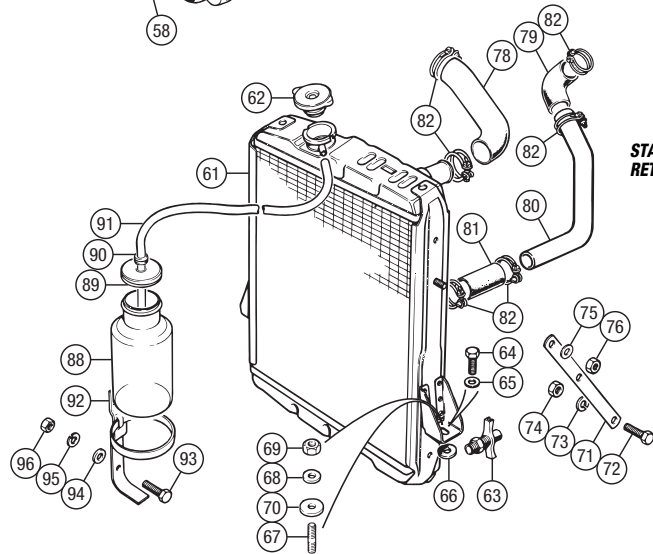
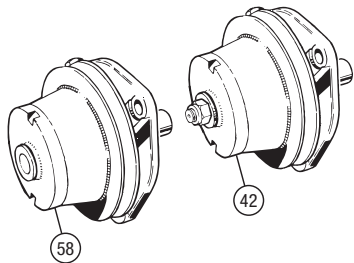
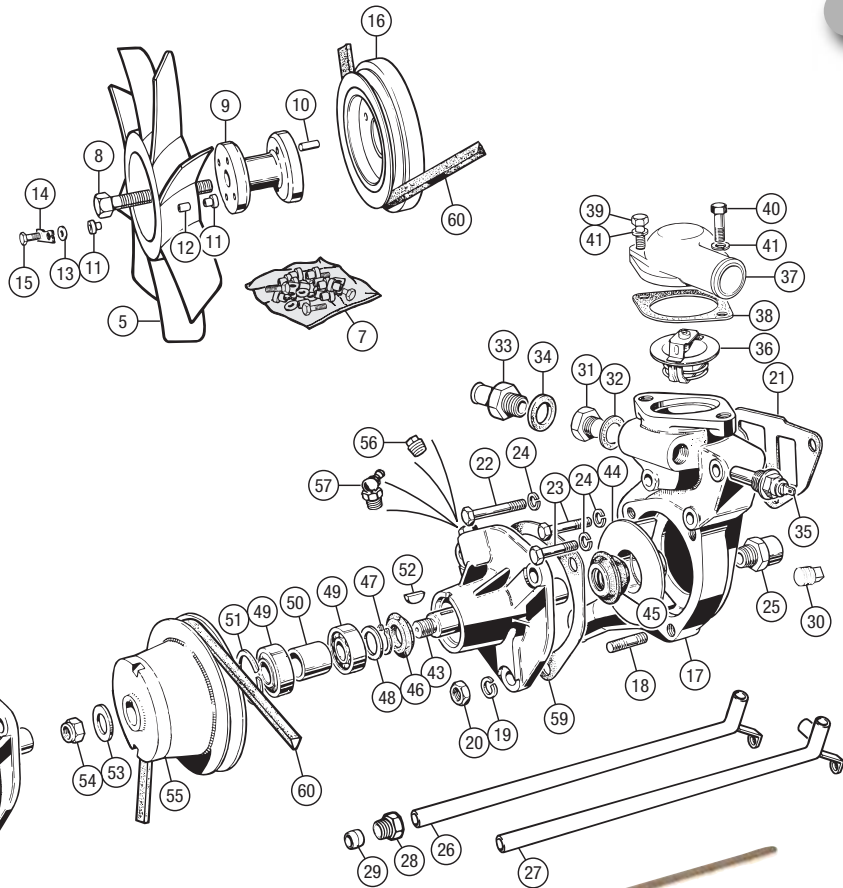
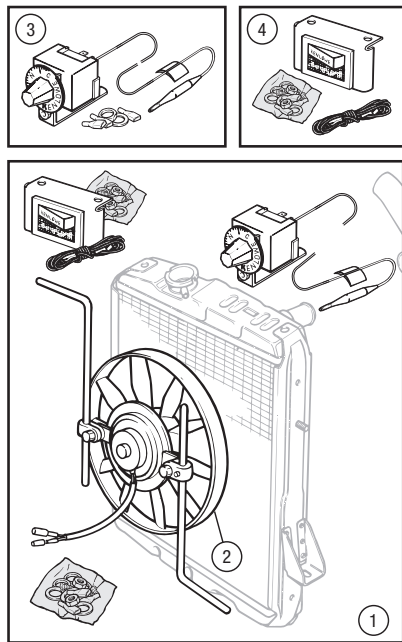
## Anti-freeze

6.2 litre capacity cooling system.

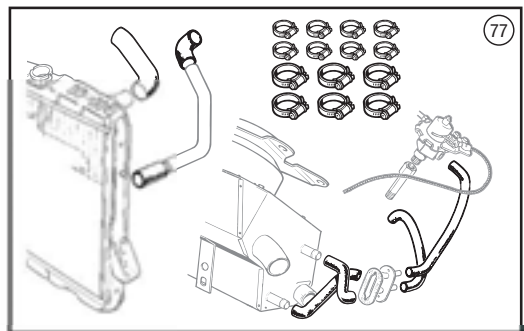
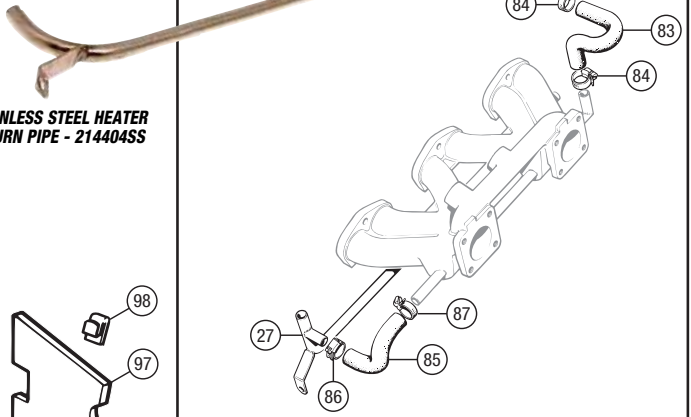
|  |     |  |         |
|--|-----|--|---------|
| Anti-freeze;                                       |     |  |         |
| 1 litre  | a/r |  | GAC2018 |
| 5 litre  | a/r |  | GAC2019 |
| Radiator Relief<br><i>Cooling system additive.</i> | 1   |  | RX1461  |
| Holts Radweld                                      | a/r |  | RX1508  |



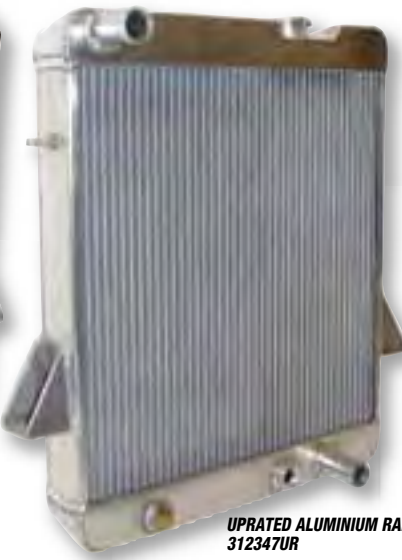




STAINLESS STEEL HEATER  
RETURN PIPE - 214404SS



RADIATOR - 312347



UPRATED ALUMINIUM RADIATOR -  
312347UR



GREEN HOSE KIT -  
RR1266G



## TR2-3A

## Heater Assembly

## ORIGINAL HEATER ASSEMBLY

|    |  |        |                      |
|----|--|--------|----------------------|
| 1  | HEATER ASSEMBLY<br><i>Includes matrix.</i> | 1      | 700899               |
| 2  | MATRIX, heater;<br>2 1/2" deep<br>4" deep  | 1<br>1 | 700899M<br>700899M-4 |
| 3  | BRACKET ASS'Y, heater support              | 1      | 700855               |
| 4  | NUT, support bracket to bulkhead           | 1      | GHF200               |
| 5  | WASHER, locking                            | 1      | GHF331               |
| 6  | SPIRE NUT                                  | 2      | FJ24074              |
| 7  | SCREW, bracket to dash support             | 2      | UL2706               |
| 8  | WASHER, plain                              | 2      | GHF300               |
| 9  | NUT, heater to support bracket             | 3      | GHF200               |
| 10 | WASHER, locking                            | 3      | GHF331               |
| 11 | HEATER PLATE, "Smiths"                     | 1      | CRCP302              |
| 12 | RIVET, attaching plate                     | 2      | 713531               |

## REPLACEMENT HEATER ASSEMBLY

|    |  |   |           |
|----|--|---|-----------|
| 13 | HEATER ASSEMBLY, replacement<br><i>High output replacement Clayton heater,<br/>complete with fitting kit and instructions.</i> | 1 | 700899UR  |
| -  | HEATER VALVE KIT<br><i>Suitable for uprated heater above.<br/>Also allows in-car heater adjustments</i>                        | 1 | 700899URV |

## Heater Hoses

|    |  |   |          |
|----|--|---|----------|
| 14 | ADAPTOR, water pump housing                              | 1 | 101343   |
| 15 | OLIVE, brass   | 1 | TL11     |
| 16 | NUT  | 1 | 101302   |
| 17 | PIPE, from water pump housing<br><i>Stainless steel.</i> | 1 | 201947SS |
| 18 | SCREW, pipe to engine                                    | 1 | HU755    |
| 19 | WASHER, locking  | 1 | GHF331   |
| 20 | HOSE, bulkhead to engine                                 | 2 | 105176   |
| 21 | CLIP, engine compartment hoses                           | 4 | CS4012   |
| 22 | ADAPTOR, bulkhead  | 2 | 601950   |
| 23 | PAD, rubber  | 2 | 601951   |
| 24 | SCREW, adaptor to bulkhead                               | 4 | GHF405   |
| 25 | SPIRE NUT  | 4 | FU2585   |
| 26 | CLIP, under dash hoses                                   | 4 | CS4013   |
| 27 | HOSE, heater inlet and outlet;<br>rubber                 | 2 | 602057   |
|    | silicone   | 2 | 602057X  |



STANDARD HEATER CONTROL VALVE - 100399

## Water Valve

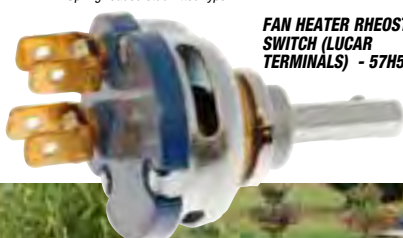
|    |   |        |                       |
|----|---|--------|-----------------------|
| 28 | PIPE, heater valve extension                        | 1      | 107994                |
| 29 | VALVE, heater control;<br>standard<br>uprated (kit) | 1<br>1 | 100399<br>100399URKIT |

Allows in-car heater adjustments, use with standard heater.

UPGRADED  
HEATER  
CONTROL  
VALVE KIT -  
100399URKIT

## Heater Controls

|    |   |   |         |
|----|---|---|---------|
| 30 | RHEOSTAT SWITCH, heater fan;<br>with screw terminals and<br>screw-fitted knob | 1 | 101622  |
|    | with screw terminals and spring-loaded<br>stud fitted knob                    | 1 | 509848  |
|    | with Lucar terminals and spring-loaded<br>stud fitted knob                    | 1 | 57H5260 |
| 31 | KNOB, heater rheostat<br><i>Screw-fitted type.</i>                            | 1 | 500513  |
| 32 | SCREW, for knob   | 1 | 500513S |
| 33 | KNOB, heater rheostat<br><i>Spring-loaded stud fitted type.</i>               | 1 | 509735  |

FAN HEATER RHEOSTAT  
SWITCH (LUCAR  
TERMINALS) - 57H5260

## Demister &amp; Air Hoses

|    |                                  |   |          |
|----|----------------------------------|---|----------|
| 34 | DEMISTER HOSE, LH                | 1 | 602056   |
| 35 | DEMISTER HOSE, RH                | 1 | 602055   |
| 36 | ADAPTOR, heater to 'Y' connector | 1 | 602019   |
| 37 | CONNECTOR, 'Y'                   | 1 | 602134   |
| 38 | NOZZLE ASS'Y, demister duct      | 2 | 700849   |
| 39 | NUT, nozzle to dash              | 4 | GHF200   |
| 40 | WASHER, plain                    | 4 | WC701121 |
| 41 | WASHER, locking                  | 4 | GHF331   |

## Heater Hose Kit

|    |                 |   |        |
|----|-----------------|---|--------|
| 42 | HEATER HOSE KIT | 1 | RW3047 |
|----|-----------------|---|--------|

The kit includes the following items:

|    |                                |   |        |
|----|--------------------------------|---|--------|
| 34 | DEMISTER HOSE, LH              | 1 | 602056 |
| 35 | DEMISTER HOSE, RH              | 1 | 602055 |
| 20 | HOSE, bulkhead to engine       | 2 | 105176 |
| 21 | CLIP, engine compartment hoses | 4 | CS4012 |
| 26 | CLIP, under dash hoses         | 4 | CS4013 |
| 27 | HOSE, heater inlet & outlet    | 2 | 602057 |



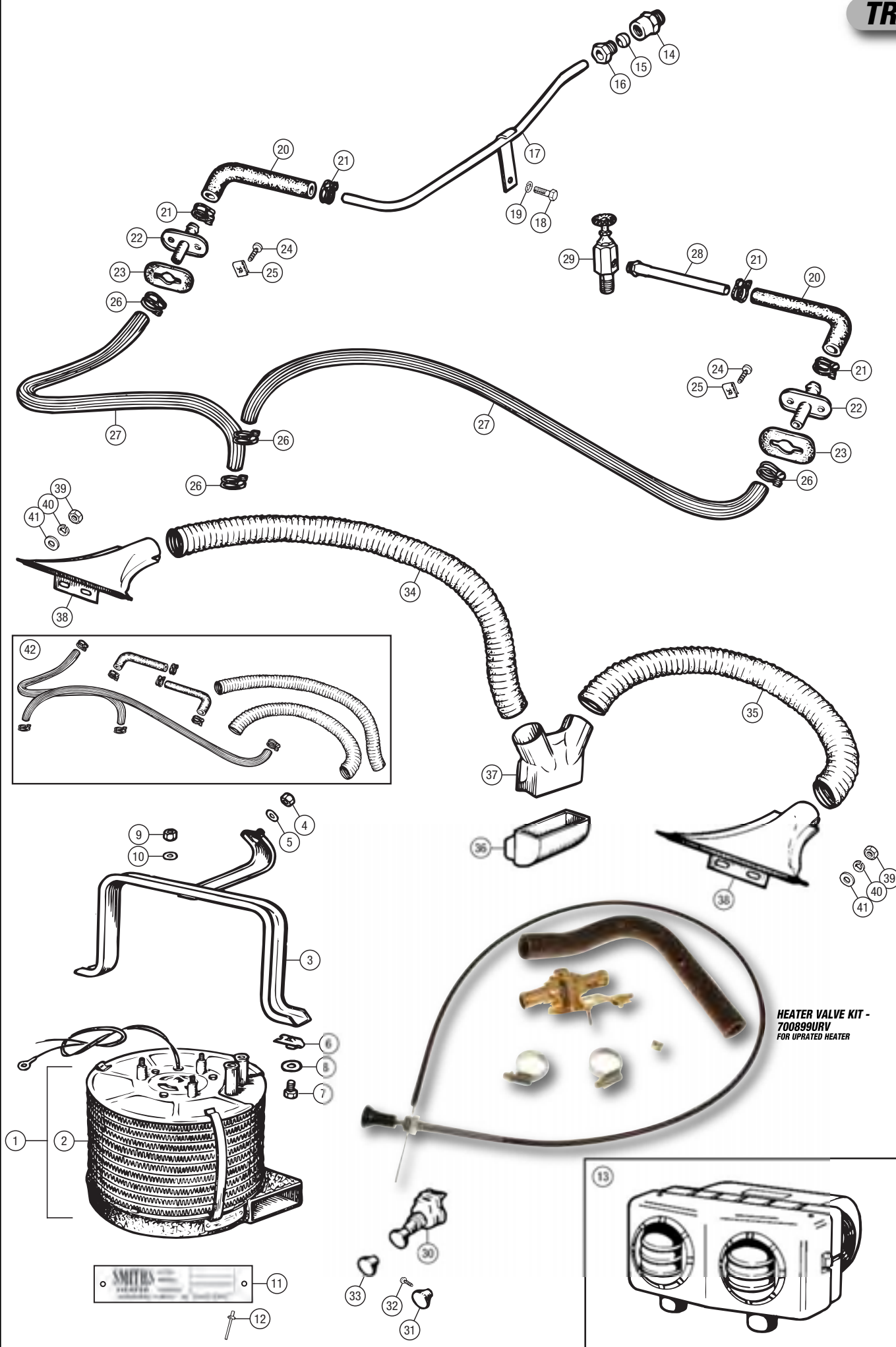
HEATER HOSE KIT - RW3047



KNOB - 509735







HEATER VALVE KIT -  
700899URV  
FOR UPDATED HEATER



**TR4-4A-5-250**

**UPDATED (HIGH OUTPUT) HEATER UNIT - 812301HX**

**Heater****TR4, TR4A; without footwell outlets**

|   |                        |   |         |
|---|------------------------|---|---------|
| 1 | HEATER ASSEMBLY;       |   |         |
|   | new                    | 1 | 808047  |
|   | reconditioned exchange | 1 | 808047R |

**TR5, TR250; with footwell outlets**

|   |                        |   |          |
|---|------------------------|---|----------|
| 1 | HEATER ASSEMBLY;       |   |          |
|   | new                    | 1 | 812301   |
|   | reconditioned exchange | 1 | 812301R  |
|   | updated, high output*  | 1 | 812301HX |

\*See also Updated Heater Valve Kit (item 42).



**HEATER MATRIX - 812301MATRIX**

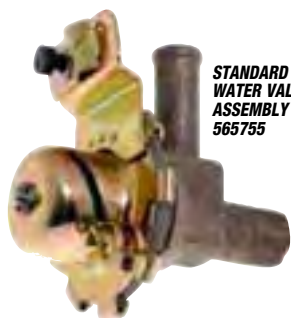
|   |  |   |              |
|---|--|---|--------------|
| 2   | MATRIX                                   | 1 | 812301MATRIX |
| 3   | FAN MOTOR, standard                      | 1 | 812301MOTOR  |
| 4   | FAN, standard                            | 1 | 512365       |
| 5   | SPIRE CLIP, securing fan                 | 1 | GHF704       |
| 6   | RIVET, motor to cradle                   | 3 | GHF602       |
| 7   | GROMMET, motor to cradle                 | 3 | GHF807       |
| 8   | CRADLE, fan motor                        | 1 | 521080CR     |
| 9   | SCREW, cradle to casing                  | 3 | HU503        |
| 10  | RESISTOR                                 | 1 | 7H6926       |
| 11  | RIVET, securing resistor                 | 2 | 574437       |
| 12  | FITTING KIT, heater                      | 1 | 812301FK     |
| <i>Items 13-21 included in fitting kit 812301FK</i> |  |   |              |
| 13  | SEAL, rubber, heater air inlet to plenum | 1 | 812301S      |
| 14  | SCREW, heater assembly to plenum         | 3 | GHF101       |
| 15  | WASHER, plain                            | 3 | WP167        |
| 16  | GROMMET, screws to heater                | 3 | 17H5431X     |
| 17  | WASHER, plain                            | 3 | GHF300       |
| 18  | SPACER, heater assembly to plenum        | 3 | 566374       |
| 19  | NUT, heater assembly to bulkhead         | 1 | GHF200       |
| 20  | WASHER, plain                            | 1 | GHF300       |
| 21  | WASHER, rubber                           | 1 | 612241       |
| 22  | PLATE, heater, 'Smith's' - TR4, TR4A     | 1 | CRCP302      |
| 23  | PLATE, heater, 'Caution' - TR4, TR4A     | 1 | CRCP303      |
| 24  | RIVET, plate attaching - TR4, TR4A       | 4 | 713531       |
| 25  | LABEL, heater, 'Smith's' - TR5, TR250    | 1 | CRST267      |
| 26  | LABEL, heater, 'Caution' - TR5, TR250    | 1 | CRST127      |

**Heater Hoses**

|   |  |   |              |
|---|--|---|--------------|
| 27  | HOSE KIT;                              |   |              |
| <i>Hose kits include all hoses for cooling and heating and corresponding jubilee type hose clips.</i> |  |   |              |
| <i>Available in black, with green alternatives for TR5 and TR250.</i>                                 |  |   |              |
|   | black - TR4                            | 1 | RF4035       |
|   | black - TR4A                           | 1 | RF4036       |
|   | black - TR5                            | 1 | RR1168       |
|   | green - TR5                            | 1 | RR1168G      |
|   | black - TR250                          | 1 | RF4037       |
|   | green - TR6 (will fit TR250)           | 1 | RR1266G      |
| 28  | HOSE, water, outlet, black             | 1 | 623285       |
| 29  | HOSE, water, inlet, black              | 1 | 623284       |
| 30  | CLAMP, hose securing;                  |   |              |
|   | 'Supergrip' wire band type             | 4 | CS4012       |
|   | 'Jubilee' type (alternative)           | 4 | GHC406       |
| 31  | GASKET, rubber, connection to bulkhead | 1 | 611040       |
| 32  | CONNECTION, bulkhead, heater hoses     | 1 | 611043       |
| 33  | SCREW, connection to bulkhead          | 2 | AD606062     |
| 34  | SPIRE NUT                              | 2 | GHF712       |
| 35  | HOSE, water, feed;                     |   |              |
|   | black - TR4, TR4A                      | 1 | GRH812       |
|   | black and yellow - TR5, TR250          | 1 | 622141       |
|   | black alternative - TR5, TR250         | 1 | 627310       |
|   | green alternative - TR5, TR250         | 1 | 627310GREEN  |
| 36  | HOSE, water, return;                   |   |              |
|   | black - TR4, TR4A                      | 1 | GZA1336      |
|   | black and yellow - TR5, TR250          | 1 | 622158       |
|   | black alternative - TR5, TR250         | 1 | GZA1336      |
|   | green alternative - TR5, TR250         | 1 | GZA1336GREEN |
| 37  | CLAMP, hose securing;                  |   |              |
|   | 'Supergrip' wire band type             | 4 | CS4012       |
|   | 'Jubilee' type (alternative)           | 4 | GHC406       |

**Heater Pipes**

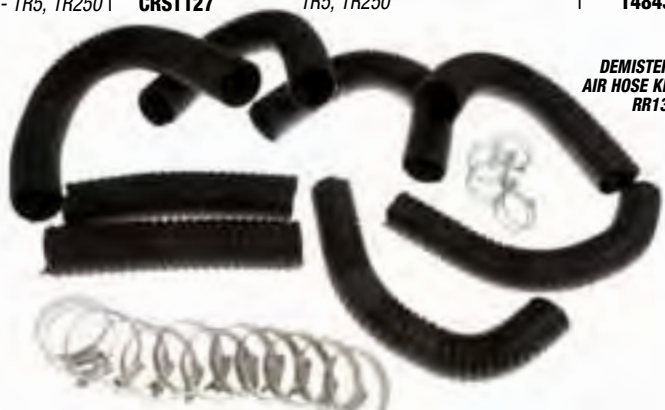
|    |                                       |   |          |
|----|---------------------------------------|---|----------|
| 38 | PIPE, heater return, stainless steel; |   |          |
|    | TR4, TR4A                             | 1 | 208606SS |
|    | TR5                                   | 1 | 214404SS |
| 39 | PIPE, heater return, stainless steel; |   |          |
|    | TR250                                 | 1 | 214405SS |
| 40 | NUT, tube                             | 1 | 101302   |
| 41 | OLIVE, sealing                        | 1 | TL11     |



**STANDARD WATER VALVE ASSEMBLY - 565755**

**Water Valve**

|  |  |   |             |
|--|--|---|-------------|
| 42   | WATER VALVE ASSEMBLY;                  |   |             |
|  | standard                               | 1 | 565755      |
|  | updated (kit)                          | 1 | 565755URKIT |
| <i>For use with standard or updated heater. (Improved flow).</i> |  |   |             |
|  | updated (valve only)                   | 1 | 565755UR    |
| <i>Service replacement.</i>                                      |  |   |             |
| 43   | ADAPTOR, water valve to cylinder head; |   |             |
|  | TR4, TR4A                              | 1 | 133061      |
|  | TR5, TR250                             | 1 | 148435      |



**DEMISTER & AIR HOSE KIT - RR1330**

**Heater Controls**

|    |  |   |         |
|----|--|---|---------|
| 44 | TRUNNION KIT, cable clamp                  | 1 | 609123K |
| 45 | TRUNNION, cable clamp                      | 1 | 609123  |
| 46 | SCREW, cable clamping                      | 1 | 559980  |
| 47 | CABLE ASSEMBLY, water valve control        | 1 | 622361  |
| 48 | GROMMET, on control cable                  | 1 | 600396  |
| 49 | BEZEL, securing cable to switch plinth     | 1 | 566047  |
| 50 | KNOB*, water valve control                 |   |         |
|    | TR4, TR4A                                  | 1 | 704884  |
| 51 | KNOB*, water valve control, pictorial type |   |         |
|    | TR5, TR250                                 | 1 | 712903  |
| 52 | KNOB*, water valve control, written type   |   |         |
|    | TR5, TR250 alternative                     | 1 | 725372  |
| 53 | TRUNNION KIT, cable clamp                  | 1 | 609123K |
| 54 | TRUNNION, cable clamp                      | 1 | 609123  |
| 55 | SCREW, cable clamping                      | 1 | 559980  |
| 56 | CABLE ASSEMBLY, air distribution;          |   |         |
|    | TR4, TR4A                                  | 1 | 612262  |
|    | TR5, TR250                                 | 1 | 622362  |
| 57 | BEZEL, securing cable to switch plinth     | 1 | 566047  |
| 58 | KNOB*, air distribution TR4, TR4A          | 1 | 704881  |
| 59 | KNOB*, air distribution, pictorial type    |   |         |
|    | TR5, TR250                                 | 1 | 712909  |
| 60 | KNOB*, air distribution, written type      |   |         |
|    | TR5, TR250 alternative                     | 1 | 725370  |

**SWITCH; TR4, TR4A**

|    |                                    |   |        |
|----|------------------------------------|---|--------|
| 61 | SWITCH, heater fan, push pull type | 1 | 2H4841 |
| 62 | BEZEL, for heater switch           | 1 | 609933 |
| 63 | KNOB*, heater fan switch           | 1 | 704883 |

**SWITCH; TR5, TR250**

|   |  |   |         |
|---|--|---|---------|
| 64                                      | SWITCH, heater fan, push pull type       | 1 | 131812  |
| 65                                      | BEZEL, for heater switch                 | 1 | 609792  |
| 66                                      | WASHER, under knob                       | 1 | 128089  |
| 67                                      | KNOB*, heater fan switch, pictorial type | 1 | 712911  |
| 68                                      | KNOB*, heater fan switch, written type   | 1 | 725371  |
| <i>Alternative to pictorial knob.</i>   |  |   |         |
| 69                                      | SWITCH, heater fan, toggle type          | 1 | BCA4294 |
| <i>Alternative to push pull switch.</i> |  |   |         |

\*Knob sets also available: please see Fascia Instruments section.

**Demister & Air Hoses****ALL MODELS**

|    |                                      |   |          |
|----|--------------------------------------|---|----------|
| 70 | ESCUTCHEON, demister outlet          | 2 | 610181   |
| 71 | WASHER, plain                        | 4 | WP5      |
| 72 | WASHER, locking                      | 4 | WL105001 |
| 73 | NUT, escutcheon and nozzle attaching | 4 | HN2005   |
| 74 | NOZZLE ASSEMBLY, demister, LH        | 1 | 806740   |
| 75 | NOZZLE ASSEMBLY, demister, RH        | 1 | 806741   |

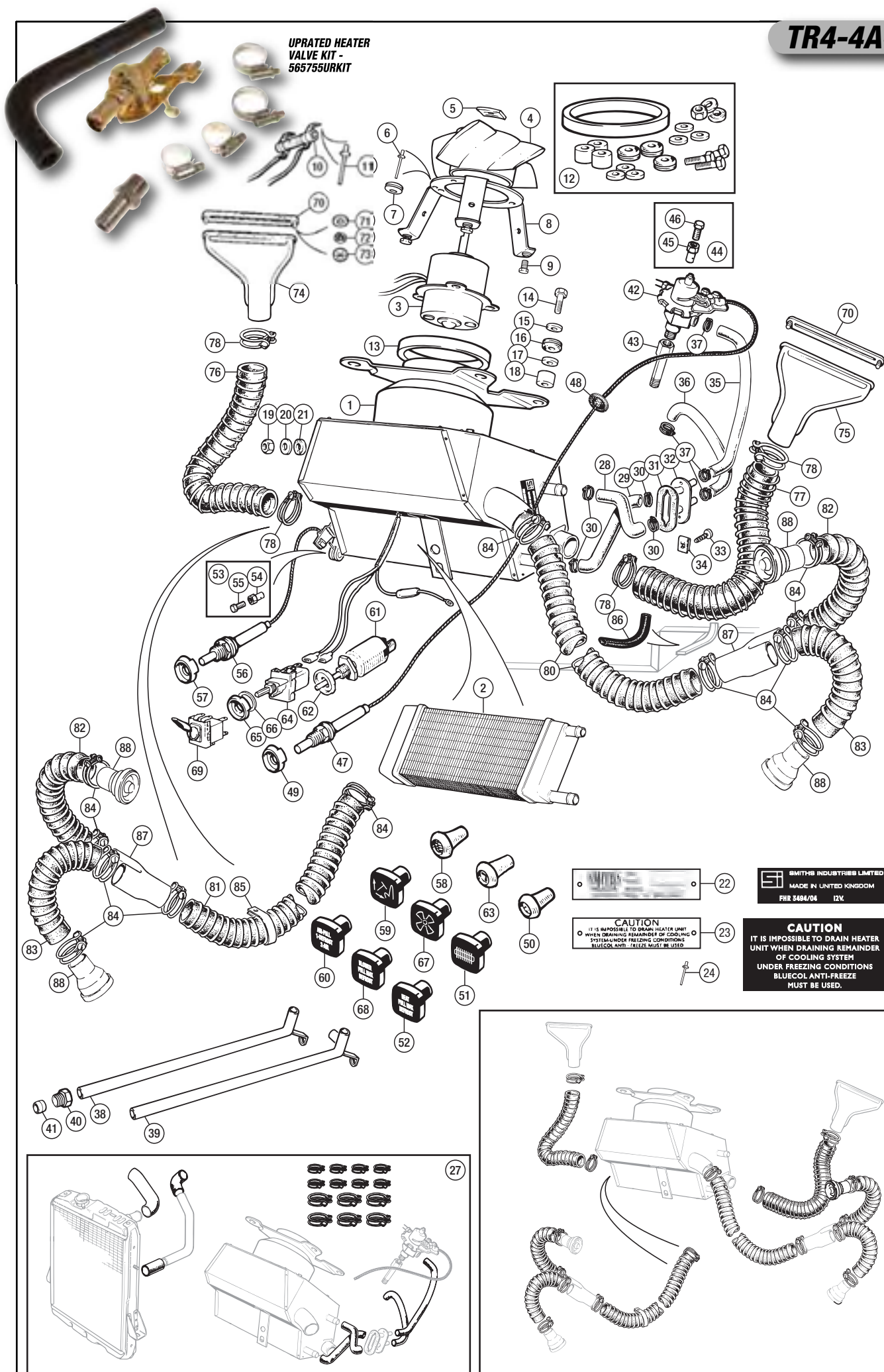
**TR4, TR4A**

|  |                                      |   |        |
|--|--------------------------------------|---|--------|
| 76                                     | HOSE, heater to demister nozzle, LH, | 1 | 602636 |
| <i>11 1/2" long x 1 1/2" diameter.</i> |                                      |   |        |
| 77                                     | HOSE, heater to demister nozzle, RH  | 1 | 602638 |
| <i>13 1/2" long x 1 1/2" diameter.</i> |                                      |   |        |
| 78                                     | CLAMP, hose securing                 | 4 | CS4024 |

**TR5, TR250**

|  |  |    |         |
|--|--|----|---------|
| 79   | DEMISTER & AIR HOSE KIT                  | 1  | RR1330  |
| <i>Items 76 to 84 included.</i>  |  |    |         |
| 76   | HOSE, heater to demister nozzle, LH,     | 1  | 602636  |
| <i>11 1/2" long x 1 1/2" diameter.</i>   |  |    |         |
| 77   | HOSE, heater to demister nozzle, RH      | 1  | 602638  |
| <i>13 1/2" long x 1 1/2" diameter.</i>   |  |    |         |
| 78   | CLAMP, hose securing                     | 4  | CS4024  |
| 80   | HOSE, heater to 'Y' piece tube, driver's | 1  | 715034  |
| <i>Side, 14" long x 1 3/4" diameter.</i>   |  |    |         |
| 81   | HOSE, heater to 'Y' piece tube,          | 1  | 715031  |
| <i>Passenger's side, 18" long x 1 3/4" dia.</i>  |  |    |         |
| 82   | HOSE, 'Y' piece tube to fascia louvre,   | 2  | 715032  |
| <i>7 1/2" long x 1 3/4" diameter</i>   |  |    |         |
| 83   | HOSE, 'Y' piece tube to footwell louvre, | 2  | 715033  |
| <i>11 1/2" long x 1 3/4" diameter.</i>   |  |    |         |
| 84   | CLAMP, hose securing                     | 12 | GHC1217 |
| 85   | CLAMP, hose retaining                    | 1  | 622151  |
| <i>Driver's side only.</i>   |  |    |         |
| 86   | SLEEVE, PVC, protecting hose             | 1  | UKC5424 |
| <i>Driver's side only.</i>   |  |    |         |
| 87   | TUBE, 'Y' piece                          | 2  | 622138  |
| <i>Eye ball vent.</i>  |  |    |         |
| 88   | LOUVRE ASSEMBLY, fresh air, metal        | 4  | 713040  |
| <i>For the mounting hardware to install the louvres see Fascia section later in catalogue.</i> |  |    |         |







No. DESCRIPTION QTY REQ. PART No.

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**ALL MODELS****Air Cleaners (Standard)**

107356

**TR2; With SU H4 Type Carburettors**

|   |                                    |   |        |
|---|------------------------------------|---|--------|
| 1 | AIR CLEANER                        | 2 | 107356 |
| 2 | DECAL, air cleaner                 | 2 | RW3043 |
| 3 | SCREW, air cleaner to carburetter  | 4 | GHF103 |
| 4 | WASHER, locking                    | 4 | GHF332 |
| 5 | GASKET, air cleaner to carburetter | 2 | 102488 |

203131

**TR3, TR3A, TR4 (without closed circuit breathing); With SU H6 Type Carburettors**

|    |                                    |   |        |
|----|------------------------------------|---|--------|
| 6  | AIR CLEANER                        | 2 | 203131 |
| 7  | DECAL, air cleaner                 | 2 | RW3043 |
| 8  | SCREW, air cleaner to carburetter  | 4 | GHF103 |
| 9  | WASHER, locking                    | 4 | GHF332 |
| 10 | GASKET, air cleaner to carburetter | 2 | 112892 |

209269

**TR4 (with closed circuit breathing); Separate Air Cleaners**

|    |   |   |          |
|----|---|---|----------|
| 11 | AIR CLEANER ASSEMBLY                      | 2 | 209269   |
| 12 | DECAL, air cleaner                        | 2 | CRST256  |
| 13 | BOLT, air cleaner to carburetter          | 2 | BH605221 |
| 14 | BOLT, 'Y' piece to air cleaner to carb. 2 | 2 | BH605241 |
| 15 | WASHER, plain                             | 4 | GHF301   |
| 16 | WASHER, locking                           | 4 | GHF332   |
| 17 | NUT, plain                                | 4 | GHF201   |
| 18 | GASKET, air cleaner to carburetter        | 2 | 112892   |

212278

**TR4 (with closed circuit breathing); Air Box**

|    |  |   |          |
|----|--|---|----------|
| 19 | AIR CLEANER ELEMENT                                | 2 | 212278   |
| 20 | DECAL, air cleaner                                 | 2 | CRST257  |
| 21 | BOLT, air cleaner to carburetter                   | 4 | BH605261 |
| 22 | WASHER, plain                                      | 4 | GHF301   |
| 23 | WASHER, locking                                    | 4 | GHF332   |
| 24 | NUT, plain   | 4 | GHF201   |
| 25 | HOSE, breather rocker cover to filter box          | 1 | 154627   |
| 26 | AIR CLEANER BOX BACK PLATE                         | 1 | 212277   |
| 27 | AIR CLEANER BOX COVER                              | 1 | 212275   |
| 28 | SCREW, air box backplate to cover                  | 1 | SH604041 |
| 29 | WASHER, locking, backplate to cover                | 1 | GHF331   |
| 30 | WASHER, plain, backplate to cover                  | 1 | GHF300   |
| 31 | GASKET, air cleaner to back plate, cover and carb. | 6 | 112892   |



212278

**TR4A; Separate Air Cleaners**

|    |                                    |   |          |
|----|------------------------------------|---|----------|
| 32 | AIR CLEANER ELEMENT                | 2 | 212278   |
| 33 | DECAL, air cleaner                 | 2 | CRST257  |
| 34 | BOLT, air cleaner to carburetter   | 4 | BH605261 |
| 35 | WASHER, plain                      | 4 | GHF301   |
| 36 | WASHER, locking                    | 4 | GHF332   |
| 37 | NUT, plain                         | 4 | GHF201   |
| 38 | GASKET, air cleaner to carburetter | 2 | 112892   |

**TR4A; Air Box**

|    |  |   |          |
|----|--|---|----------|
| 39 | AIR CLEANER ELEMENT                                | 2 | 212278   |
| 40 | DECAL, air cleaner                                 | 2 | CRST257  |
| 41 | BOLT, air box attachment                           | 4 | BH605261 |
| 42 | WASHER, plain                                      | 4 | GHF301   |
| 43 | WASHER, locking                                    | 4 | GHF332   |
| 44 | NUT, plain   | 4 | GHF201   |
| 45 | AIR CLEANER BOX BACKPLATE                          | 1 | 212276   |
| 46 | AIR CLEANER BOX COVER                              | 1 | 212275   |
| 47 | SEALING STRIP, backplate to cover                  | 2 | 141648   |
| 48 | SCREW, air box backplate to cover                  | 1 | SH604041 |
| 49 | WASHER, locking, backplate to cover                | 1 | GHF331   |
| 50 | WASHER, plain, backplate to cover                  | 1 | GHF301   |
| 51 | GASKET, air cleaner to back plate, cover and carb. | 6 | 112892   |

GFE1048

**TR5; Air Box**

|    |   |   |                        |
|----|---|---|------------------------|
| 52 | AIR CLEANER ASSEMBLY<br><i>Includes lid, nut and element.</i>                       | 1 | 308444                 |
| 53 | NUT, nyloc  | 1 | 517410                 |
| 54 | AIR CLEANER ELEMENT;<br>standard<br>K&N ( <i>fits inside standard air cleaner</i> ) | 1 | GFE1048<br>1GFE1048K-N |
| 55 | INSULATOR, rubber   | 1 | 517411                 |
| 56 | CLIP, securing air cleaner & insulator  | 1 | GHC2228                |
| 57 | DECAL, 'AC' air cleaner   | 1 | CRST283                |
| 58 | BRACKET, air cleaner support  | 1 | 149306                 |
| 59 | SCREW, bracket to radiator stay   | 1 | SH605051               |
| 60 | WASHER, locking   | 1 | GHF332                 |
| 61 | NUT   | 1 | GHF201                 |
| 62 | NUT ( <i>bracket &amp; radiator stay to radiator</i> )                              | 1 | GHF201                 |
| 63 | WASHER, locking   | 1 | GHF332                 |
| 64 | AIR CLEANER ASSEMBLY<br>stainless steel   | 1 | 308444SS               |

GFE1020

**TR250; Air Box**

|    |   |   |                         |
|----|---|---|-------------------------|
| 65 | AIR CLEANER ASSEMBLY<br><i>Includes cover, backplate and elements.</i>              | 1 | 148636                  |
| 66 | AIR CLEANER ELEMENT;<br>standard<br>K&N ( <i>fits inside standard air cleaner</i> ) | 2 | GFE1020<br>2 GFE1020K-N |
| 67 | BOLT, air cleaner to carburetter  | 6 | BH505181                |
| 68 | WASHER, locking   | 6 | GHF332                  |
| 69 | AIR FILTER BOX BACKPLATE  | 1 | 214466                  |
| 70 | AIR FILTER BOX COVER  | 1 | 214468                  |
| 71 | GASKET, backplate to carburetter  | 2 | 148007                  |

**Air Cleaners (K&N)****For improved engine breathing and performance.**

As well as being cleanable and reusable, K&N's are available either as replacements for the standard air filters (i.e. fit inside existing air cleaner box) for certain applications, or as replacements for the standard air cleaner assembly, which will obviously change the appearance of your engine bay. Please see 'Accessories' for cleaning and re-oiling products.



56-9128

**TR2; With SU H4 Type Carburettors**

|    |                        |   |         |
|----|------------------------|---|---------|
| 72 | AIR CLEANER, K&N, each | 2 | 56-9128 |
|----|------------------------|---|---------|

56-9132

**TR3, TR3A, TR4; With SU H6 Type Carburettors**

|    |                        |   |         |
|----|------------------------|---|---------|
| 73 | AIR CLEANER, K&N, each | 2 | 56-9132 |
|----|------------------------|---|---------|

RR1369

**TR4, TR4A, TR250; With Stromberg 175 CD Carburettors**

|    |                                       |   |            |
|----|---------------------------------------|---|------------|
| 74 | AIR CLEANER, K&N, each,<br>1.75" deep | 2 | RR1369     |
|    | 3.25" deep                            | 2 | RR1369DEEP |

RB7070

**TR4A; With SU HS6 Type Carburettors**

|    |                        |   |        |
|----|------------------------|---|--------|
| 75 | AIR CLEANER, K&N, each | 2 | RB7070 |
|----|------------------------|---|--------|

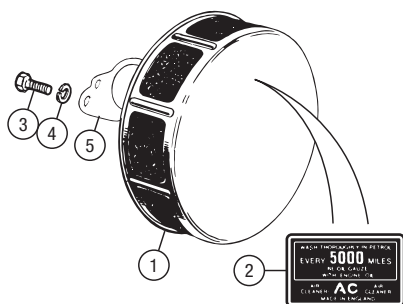
GFE1048K-N

**TR5 Pi**

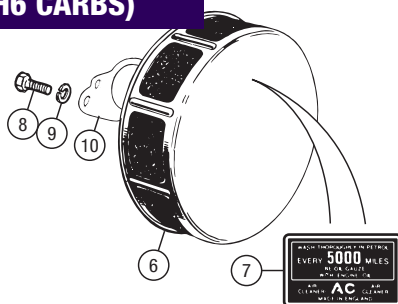
|    |   |   |            |
|----|---|---|------------|
| 76 | AIR CLEANER, K&N,<br>fits in standard cannister   | 1 | GFE1048K-N |
| 77 | AIR CLEANER, K&N, intake manifold<br><i>Replaces air manifold, hose and standard cannister.</i> | 3 | RR1515     |
| 78 | AIR CLEANER, K&N, air manifold<br><i>Cone type. Replaces hose and standard cannister.</i>       | 1 | RA1060     |



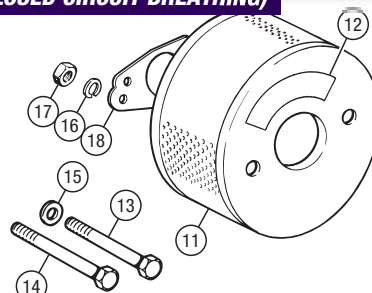
**TR2 (H4 CARBS)**



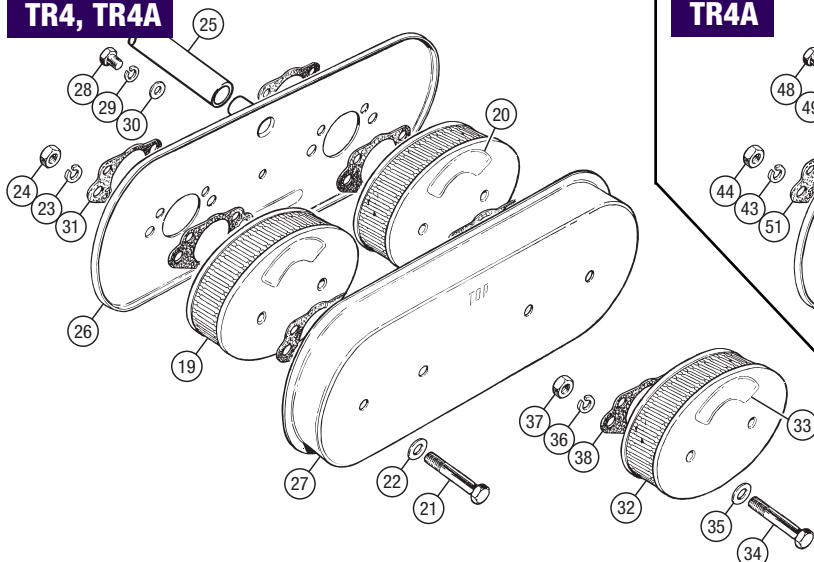
**TR3, TR3A, TR4 (H6 CARBS)**



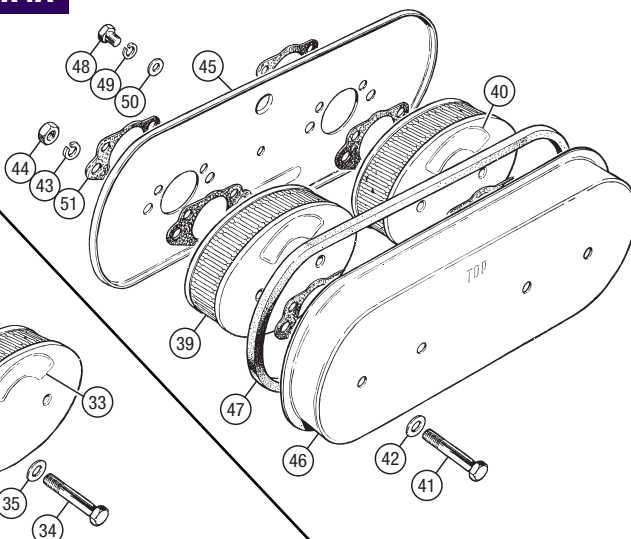
**TR4 (CLOSED CIRCUIT BREATHING)**



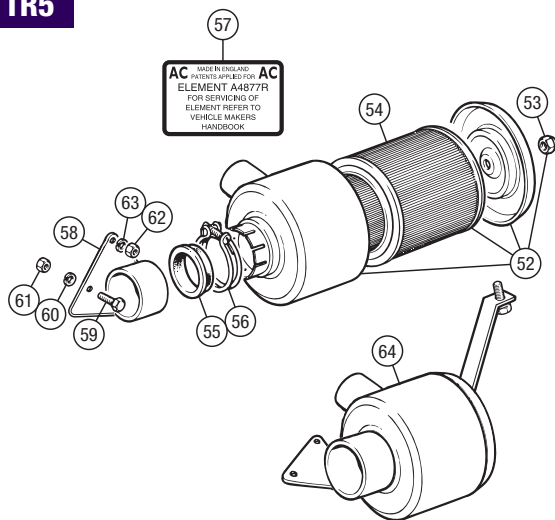
**TR4, TR4A**



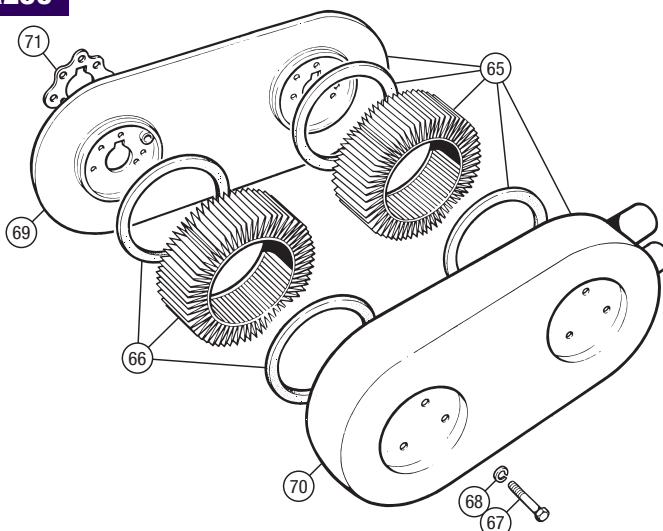
**TR4A**



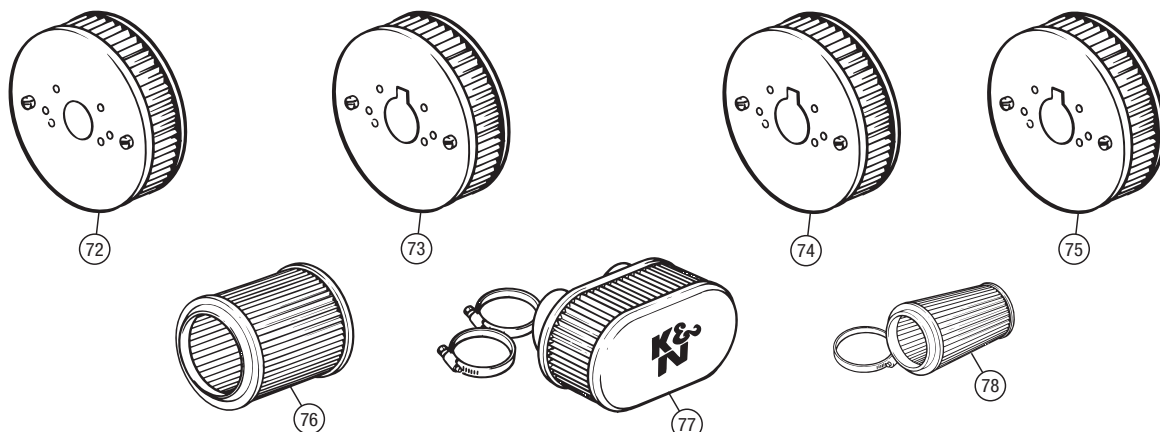
**TR5**



**TR250**



**K&N**





## TR2-4A

## Fuel Tank &amp; Fittings

## TR2, TR3, TR3A

|   |                                     |   |          |
|---|-------------------------------------|---|----------|
| 1   | FUEL TANK;<br>mild steel            |   |          |
|   | TR2                                 | 1 | 301235   |
|   | TR3, TR3A to TS60000                | 1 | 302125   |
|   | TR3A from TS60001                   | 1 | 303999   |
|   | stainless steel                     |   |          |
|   | TR2, TR3, TR3A to TS60000           | 1 | 302125SS |
|   | TR3A from TS60001                   | 1 | 303999SS |
|   | aluminium                           |   |          |
|   | outlet in bottom centre             | 1 | 302125AL |
|   | outlet at bottom right              |   | 303999AL |
| Note that centre outlet tanks made in stainless steel and aluminium, while capable of being fitted to TR2s, are in fact to the slightly smaller capacity specification of TR3s and pre-TS60001 TR3As. |                                     |   |          |
| 2   | DRAIN PLUG (Original tanks only)    | 1 | 103222   |
| 3   | WASHER, fibre (Original tanks only) | 1 | WF513    |
| 4   | GROMMET;<br>1/2" hole, vent pipe    | 1 | 61917    |
|   | 1" hole, vent pipe                  | 1 | 600395   |
| Alternative if 1" hole is present.  |                                     |   |          |
| 5   | STRAP, tank retaining;              |   |          |
|   | TR2                                 | 2 | 201864   |
|   | TR3                                 | 2 | 203139   |
|   | TR3A to TS60000                     | 2 | 204964   |
|   | TR3A from TS60001                   | 2 | 206370   |
| 6   | SCREW, tank attachment;<br>short    | 2 | SH606061 |
|   | long                                | 2 | SH606101 |
| 7   | WASHER, locking                     | 4 | GHF333   |
| 8   | FELT STRIP, tank base to body       | 2 | 621721   |
|   | Cut to fit.                         |   |          |
| 9   | FELT STRIP, retaining strap to tank | 2 | 107563   |
| 10  | PIPE ASSEMBLY, vent                 | 1 | 202003   |
| 11  | WASHER, fibre, upper                | 1 | WF524    |
|   | Original tanks only.                |   |          |
| 12  | WASHER, fibre, lower                | 1 | WF511A   |
|   | Original tanks only.                |   |          |
| 13  | BANJO BOLT, fuel tank vent          | 1 | 102213   |
|   | Original tanks only.                |   |          |
| 14  | CLIP, vent & fuel pipes to chassis  | 3 | 59191    |
| 15  | SENDER UNIT, fuel gauge             | 1 | 203610   |
| 16  | GASKET, seating sender unit         | 1 | 2H1082   |
| 17  | SCREW, sender unit to tank          | 6 | TR6504   |
| 18  | WASHER, locking                     | 6 | WF702101 |
| 19  | WASHER, fibre                       | 6 | WF505    |

## TR4, TR4A

|    |   |   |         |
|----|---|---|---------|
| 20 | FUEL TANK;  |   |         |
|    | with vent pipe boss                               | 1 | 304849  |
|    | Original; TR4 to CT 19970.                        |   |         |
|    | without vent pipe boss                            | 1 | 306363  |
|    | Original; TR4 from CT19971, TR4A.                 |   |         |
|    | aluminium   | 1 | 312359A |
|    | Replacement for all applications.                 |   |         |
|    | mild steel  | 1 | 312359  |
|    | Replacement for all applications.                 |   |         |
| 21 | PLUG, tank drain                                  | 1 | 103222  |
| 22 | WASHER, drain plug                                | 1 | WF513   |
| 23 | PAD, drain plug to floor                          | 1 | 611733  |
| 24 | SCREW, fuel tank to body                          | 6 | GHF101  |
| 25 | WASHER, locking                                   | 6 | GHF331  |
| 26 | WASHER, plain                                     | 6 | GHF314  |
| 27 | PAD, felt, tank mounting, rear                    | 2 | 621721  |
| 28 | PIPE ASS'Y, vent (TR4 to CT 1970)                 | 1 | 208503  |
| 29 | WASHER, fibre, upper                              | 1 | WF524   |
| 30 | WASHER, fibre, lower (Original tanks)             | 1 | WF511A  |
| 31 | BANJO BOLT, fuel tank vent                        | 1 | 102213  |
| 32 | CLIP, vent pipe to chassis                        | 1 | 59191   |
| 33 | CLIP, vent pipe to chassis                        | 1 | 107554  |
| 34 | GROMMET;  |   |         |
|    | 1/2" hole, vent pipe                              | 1 | 61917   |
|    | TR4 to CT 11663.                                  |   |         |
|    | 1" hole, vent pipe                                | 1 | 600395  |
|    | TR4 from CT 11664 to CT19970.                     |   |         |
|    | PLUG;   |   |         |
|    | 1/2" vent pipe hole                               | 1 | CD27769 |
|    | When no vent pipe fitted.                         |   |         |
|    | 1" vent pipe hole                                 | 1 | 600399  |
|    | Alternative for 1" hole when no vent pipe fitted. |   |         |
| 35 | SENDER UNIT, fuel gauge;                          |   |         |
|    | Recon'd (Smiths no. TF1002/097)                   | 1 | 208209R |
|    | Recon'd (Smiths no. TF1002/500)                   | 1 | 209195R |
|    | New (Later TR6 replacement item)                  | 1 | 214465  |
| 36 | GASKET  | 1 | 2H1082  |
| 37 | SCREW   | 6 | TR6504  |
| 38 | WASHER, fibre                                     | 6 | WF505   |
| 39 | RING, anti-rattle - TR4A                          | 1 | 139908  |

## Fuel Filler Caps

|   |  |   |            |
|---|--|---|------------|
| 40  | FUEL CAP, screw assembly type<br>TR2, TR3, TR3A original item. | 1 | 704551     |
| 41  | CHROMED ESCUTCHEON   | 1 | 704551W    |
| 42  | WASHER, fibre  | 1 | -          |
| 43  | EXTENSION, screwed to filler cap                               | 1 | 704551NECK |
| 44  | FUEL CAP;  |   |            |
|   | TR4 to CT 19970  | 1 | 650266     |
|   | TR4 from CT19971, TR4A   | 1 | 613506     |
|   | With tube extension.   |   |            |
| The TR4 and TR4A fuel cap 613506 also makes a good alternative fitment for TR2, TR3 and TR3A models. It may be fitted without modification. |  |   |            |
| 45  | GROMMET, rear deck   | 1 | 650247     |
|   | For fuel caps nos. 44 and 46.                                  |   |            |
| 46  | FUEL CAP, locking, round, inc flange                           | 1 | 571086     |
|   | Alternative; with mounting flange.                             |   |            |
| 47  | FUEL CAP, locking, round                                       | 1 | 571086CAP  |
|   | Cap only (without mounting flange).                            |   |            |
| 48  | FUEL CAP, locking, lozenge shaped                              | 1 | GAC6001X   |
|   | Alternative.   |   |            |
| 49  | HOSE, rubber, filler to tank                                   | 1 | UKC9920    |
|   | Replacement item.  |   |            |
| 50  | CLAMP, wire band type;   |   |            |
|   | for original filler hose                                       | 2 | CS4038     |
|   | for replacement filler hose                                    | 2 | CS4042     |

## Fuel Pump

## ORIGINAL STYLE MECHANICAL FUEL PUMP

Depending on availability, new fuel pumps may or may not be fitted with the priming handle found on original pumps.

|    |   |   |          |
|----|---|---|----------|
| 51 | FUEL PUMP ASSEMBLY                      | 1 | 109637   |
|    | Includes items 52-59.                   |   |          |
| 52 | GAUZE                                   | 1 | 500419   |
| 53 | SPRING, under diaphragm                 | 1 | 52492A   |
| 54 | SCREW, retaining valve plate            | 2 | 59660    |
| 55 | FUEL PUMP REPAIR KIT                    | 1 | AEU2760A |
|    | Includes diaphragm, valves and gaskets. |   |          |
| 56 | GASKET, sediment bowl                   | 1 | 500418   |
| 57 | GASKET, fuel pump to block              | 1 | 139041   |
| 58 | C' CLIP, on pivot                       | 2 | 52484    |
| 59 | SPRING, priming handle                  | 1 | 52498    |
| 60 | NUT, pump attachment to block           | 2 | GHF201   |
| 61 | WASHER, locking                         | 2 | GHF332   |

## ELECTRIC FUEL PUMP KIT

62 ELECTRIC FUEL PUMP KIT;

|  |  |   |        |
|--|--|---|--------|
|  | Includes pump, pump mounts, wiring, fuel hose, clips and filter. |   |        |
|  | positive earth   | 1 | RF4197 |
|  | negative earth   | 1 | RF4198 |

## Pipe Work

## TR2, TR3, TR3A

|    |  |   |          |
|----|--|---|----------|
| 63 | FUEL PIPE, rigid, tank to coupling                             | 1 | 206402   |
|    | Cut and bend to fit.   |   |          |
| 64 | UNION, fuel pipe connecting                                    | 1 | 60172    |
|    | Includes olive.  |   |          |
|    | OLIVE  | 2 | TL8      |
| 65 | FUEL PIPE, rigid, tap to coupling                              | 1 | 303754   |
|    | Cut and bend to fit.   |   |          |
| 66 | GROMMET, fuel pipe, in chassis                                 | 2 | CD23720  |
| 67 | FUEL TAP ASSEMBLY  | 1 | 104818   |
|    | CORK SEAL, in fuel tap   | 1 | 104818C  |
| 68 | HOSE, stainless braided, tap to pump                           | 1 | 104842SS |
|    | Alternative to 69-71; includes union and nuts.                 |   |          |
| 69 | HOSE, flexible, fuel inlet to pipe                             | 1 | 115784   |
|    | Alternative to 68.   |   |          |
| 70 | PIPE ASS'Y, fuel inlet to pump                                 | 1 | 149556   |
|    | Alternative to 68.   |   |          |
| 71 | PIPE ASS'Y, fuel tap outlet                                    | 1 | 115780   |
|    | Alternative to 68.   |   |          |
| 72 | PIPE, pump to carb. inlet hose                                 | 1 | 203121   |
|    | Cut and bend to fit; use with item 74. Includes nut and olive. |   |          |
|    | UNION NUT, 3/8 thread 5/16" pipe                               | 1 | 60142    |
|    | OLIVE, 5/16"   | 1 | TL8      |
|    | PIPE, pump to carb. inlet hose                                 | 1 | 205048   |
|    | Cut and bend to fit; use with item 75. Includes nut and olive. |   |          |
|    | UNION NUT, 3/8 thread 1/4" pipe                                | 1 | 60176    |
|    | OLIVE, 1/4"  | 1 | 102729   |
| 73 | OLIVE, 5/16"   | 1 | TL8      |
|    | Use with items 72, 74.   |   |          |
| 74 | HOSE, flexible, with banjos                                    | 1 | 203120   |
|    | Carb. to carb. (alt. to 75-77).                                |   |          |
| 75 | HOSE, flexible, pipe to front carb.                            | 1 | 115784   |
|    | Carb. to carb. (alt. to 74).                                   |   |          |

|    |                                      |   |        |
|----|--------------------------------------|---|--------|
| 76 | PIPE, rigid                          | 1 | 120329 |
|    | Carb. to carb. (alt. to 74).         |   |        |
| 77 | HOSE, pipe to carburettors           | 2 | 120331 |
|    | Carb. to carb. (alt. to 74).         |   |        |
| 78 | RIGID VENT PIPE, float chamber       | 2 | 121273 |
|    | Use with AUC878 carbs.               |   |        |
| 79 | HOSE, flexible, vent pipes to carbs. | 2 | 143788 |
|    | Use with AUC878 carbs.               |   |        |

## TR4, TR4A

|     |                                     |     |         |
|-----|-------------------------------------|-----|---------|
| 80  | PIPE, tank outlet - TR4             | 1   | 208495  |
| 81  | CLIP, pipe to rear floor            | 1   | 119868  |
| 82  | WASHER, locking                     | 1   | GHF331  |
| 83  | WASHER, plain                       | 1   | GHF314  |
| 84  | NUT, clip to rear floor             | 1   | GHF200  |
| 85  | CONNECTOR, fuel pipe - TR4          | 2   | 115784  |
| 86  | PIPE, intermediate - TR4            | 1   | 303754  |
| 87  | GROMMET, fuel pipe to chassis - TR4 | 2   | CD23720 |
| 88  | PIPE, pump inlet - TR4              | 1   | 149556  |
|     | Includes nut and olive.             |     |         |
|     | UNION NUT, 3/8 thread 5/16" pipe    | 1   | 60142   |
|     | OLIVE, 5/16"                        | 1   | TL8     |
| 89  | PIPE, pump to carb. inlet hose;     |     |         |
|     | cut and bend to fit                 | 1   | 205048  |
|     | TR4 to engine no. CT16800E and from |     |         |
|     | CT16901E to CT 21470E               | 1   | 303059  |
|     | TR4 engine no. CT16801E to CT16900E |     |         |
|     | and from CT21471E; TR4A             | 1   | 305995  |
|     | Includes nut and olive.             |     |         |
|     | UNION NUT, 3/8 thread 1/4" pipe     | 1   | 60176   |
|     | OLIVE, 1/4"                         | 1   | 102729  |
| 90  | CONNECTOR, pipe to carb.            | 1   | 115784  |
| 91  | PIPE, carb. to carb.                | 1   | 120329  |
|     | TR4 with H6 carburettors.           |     |         |
| 92  | PIPE, carb. to carb.                | 1   | 136489  |
|     | TR4, TR4A with Stromberg carbs.     |     |         |
| 93  | PIPE, carb. to carb.                | 1   | 145124  |
|     | TR4A with H6 carburettors.          |     |         |
| 94  | CONNECTOR, pipe to carb - TR4       | 2   | 120331  |
| 95  | CONNECTOR, feed pipe to carb        | 1   | 115784  |
|     | TR4A with Stromberg carbs.          |     |         |
| 96  | CONNECTOR, feed pipe to carb        | 2   | 120331  |
|     | TR4A with H6 carburettors.          |     |         |
| 97  | CLIP, pipe to clutch hose bracket   | 1   | 130882  |
| 98  | CLIP, pipe to chassis frame         | 4   | 59191   |
| 99  | PIPE, pump inlet                    | 1   | 149556  |
|     | TR4A; includes nut and olive.       |     |         |
|     | UNION NUT, 3/8 thread, 5/16" pipe   | 1   | 60142   |
|     | OLIVE, 5/16"                        | 1   | TL8     |
| 100 | CONNECTOR, fuel pipes - TR4A        | 3   | 115784  |
| 101 | GROMMET - TR4A                      | 3   | CD23720 |
| 102 | PIPE, intermediate to pump inlet;   |     |         |
|     | early TR4A                          | 1   | 212515  |
|     | late TR4A                           | 1   | 212799  |
| 103 | PIPE, intermediate;                 |     |         |
|     | early TR4A                          | 1   | 307378  |
|     | late TR4A                           | 1   | 307532  |
| 104 | PIPE, tank to intermediate pipe;    |     |         |
|     | early TR4A                          | 1   | 307370  |
|     | late TR4A                           | 1   | 143846  |
| 105 | CLIP, pipe to frame;                |     |         |
|     | TR4A                                | 1   | 611793  |
|     | TR4A; alternative                   | 1   | 551490  |
| 106 | CLIP, pipe to thermostat housing    | 1   | 133072  |
| 107 | INSULATOR, rubber, pipe to clip     | 1   | 133083  |
| 108 | CLIP, fuel pipe, single             | A/R | 150930  |
|     | Plastic. TR4 and TR4A alternative.  |     |         |
| 109 | CLIP, fuel pipe/brake pipe, twin    | A/R | 624155  |
|     | Plastic. TR4 and TR4A alternative.  |     |         |

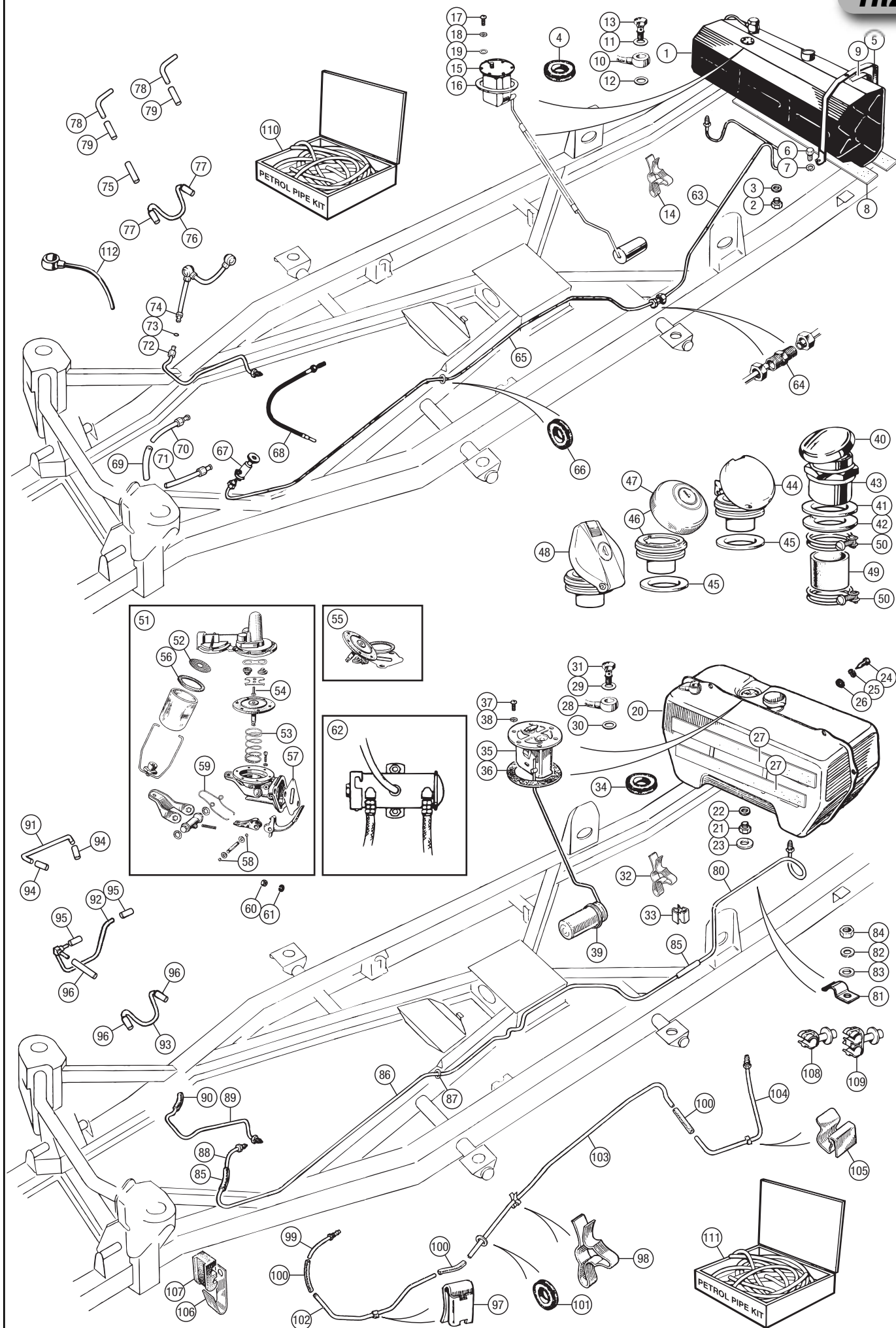
## Fuel Pipe Kit

|     |   |   |                 |
|-----|---|---|-----------------|
| 110 | FUEL PIPE KIT, copper, tank to pump   |   |                 |
|     | TR2, TR3, TR3A  | 1 | RW3044          |
|     | Kit includes fuel pipes, stainless braided tap to pump hose, pipe to chassis clips, grommets and union. |   |                 |
| 111 | FUEL PIPE KIT, copper, car set - TR4, TR4A;   |   |                 |
|     | with SU HS6 carburettors  | 1 | RF4107SU        |
|     | with Stromberg carburettors   | 1 | RF4107STROMBERG |

## Carburettor Overflow Pipe

|     |  |   |         |
|-----|--|---|---------|
| 112 | OVERFLOW PIPE ASS'Y;                           |   |         |
|     | for H4 carburettors (banjo fitted fuel supply) | 2 | AUC1866 |
|     | for H6 carburettors (banjo fitted fuel supply) | 2 | 113209  |







| No. | DESCRIPTION | QTY REQ. | PART No. | No. | DESCRIPTION | QTY REQ. | PART No. | No. | DESCRIPTION | QTY REQ. | PART No. |
|-----|-------------|----------|----------|-----|-------------|----------|----------|-----|-------------|----------|----------|
|-----|-------------|----------|----------|-----|-------------|----------|----------|-----|-------------|----------|----------|

## TR5 PROBLEM SOLVING

The most common problems affecting classic cars these days are caused by their low general usage and the periods that they spent in storage.

Even in dry garages the inside of the fuel tank may corrode, shedding fine iron sediment as soon as the car is moved. Once corrosion has started it may be more expensive to cure/eradicate than the cost of a new tank.

If a problem is suspected, the tank may have to be flushed by filling and draining several times. Another common ailment is caused by water, which will sit at the bottom of the tank, under the fuel, and cause corrosion. This may actually get as far as the engine where it will cause havoc to a metering unit or injector.

The P.I system may need pressure checking at several points to identify a problem. The pressure relief valve should 'blow' at 105 - 110 PSI, and there should be over 90 PSI at the metering unit outlets. Injectors pop at 45-55 PSI. Rebuilt injectors are tested to perform within this pressure window and spray an even cone of fuel.

See pages 67 / 68 for Injection Equipment.



FUEL CAP - 613506



FUEL CAP - 725117



## Fuel Tank & Fittings

|    |  |   |          |
|----|--|---|----------|
| 1  | FUEL TANK;<br>mild steel                       | 1 | 312359   |
|    | aluminium replacement (includes baffles)       | 1 | 312359A  |
| 2  | PLUG, drain                                    | 1 | 103222   |
| 3  | WASHER, fibre                                  | 1 | WF513    |
| 4  | SEAL, drain plug, tank to floor                | 1 | 611733   |
| 5  | PAD, felt, tank mounting, rear top             | 1 | 621721   |
| 6  | PAD, felt, tank mounting, rear bottom          | 1 | 621721   |
| 7  | SCREW, fuel tank to body                       | 6 | GHF101   |
| 8  | WASHER, locking                                | 6 | GHF331   |
| 9  | WASHER, plain                                  | 6 | GHF314   |
| 10 | FUEL CAP, original item                        | 1 | 613506   |
| 11 | FUEL CAP, later TR6 alternative                | 1 | 725117   |
| 12 | SEAL, cap to filler neck, vented               | 1 | 718738   |
| 13 | FUEL CAP, magnetic                             | 1 | 714774   |
| 14 | FUEL CAP, locking, round (Alternative)         | 1 | 571086   |
| 15 | FUEL CAP, locking, lozenge shaped Alternative. | 1 | GAC6001X |
| 16 | GROMMET  | 1 | 650247   |
| 17 | HOSE, filler;<br>original                      | 1 | 650279   |
|    | replacement                                    | 1 | UKC9920  |
| 18 | CLIP;<br>wire band type                        | 2 | CS4038   |
|    | 'Jubilee' type (Alternative)                   | 2 | GHC1622  |
| 19 | SENDER UNIT, fuel gauge                        | 1 | 214465   |
| 20 | WASHER, rubber, anti rattle on float           | 1 | 139908   |
| 21 | GASKET, cork, sender to tank                   | 1 | 2H1082   |
| 22 | SCREW, sender to tank                          | 6 | TR6504   |
| 23 | WASHER, fibre                                  | 6 | WF505    |



FUEL GAUGE SENDER UNIT - 214465

### PIPEWORK: FUEL TANK TO FILTER

|    |  |   |        |
|----|--|---|--------|
| 24 | PIPE & UNION ASSEMBLY, tank outlet       | 1 | 149556 |
| 25 | UNION NUT, 3/8" thread, 5/16" pipe       | 1 | 60142  |
| 26 | OLIVE, 5/16"                             | 1 | TL8    |
| 27 | HOSE, fuel tank to filter inlet, 13 1/2" | 1 | 149608 |
| 28 | PIPE & UNION ASSEMBLY, filter inlet      | 1 | 149556 |
| 29 | UNION NUT, 3/8" thread, 5/16" pipe       | 1 | 60142  |
| 30 | OLIVE, 5/16"                             | 1 | TL8    |

## Fuel Filter Pipework

### PIPEWORK: FUEL FILTER VENT

|    |  |   |        |
|----|--|---|--------|
| 31 | PIPE, filter vent to tank              | 1 | 214895 |
| 32 | UNION NUT, 3/8" thread, 1/4" pipe      | 2 | 60176  |
| 33 | OLIVE, 1/4"                            | 2 | 102729 |
| 34 | CONNECTION ADAPTOR, vent pipe          | 1 | 148312 |
| 35 | WASHER, sealing adaptor to filter head | 1 | 150710 |

### PIPEWORK: FUEL FILTER TO FUEL PUMP

|    |   |   |        |
|----|---|---|--------|
| 36 | PIPE & UNION ASSEMBLY, hose to filter   | 1 | 149556 |
| 37 | UNION NUT, 3/8" thread, 5/16" pipe      | 1 | 60142  |
| 38 | OLIVE, 5/16"                            | 1 | TL8    |
| 39 | HOSE, filter to pump inlet, 9 1/2" long | 1 | 149607 |
| 40 | PIPE & UNION ASSEMBLY, pump inlet       | 1 | 149557 |
| 41 | OLIVE & TUBE                            | 1 | 148813 |
| 42 | NUT, TUBE                               | 1 | 151878 |

## Fuel Pump Pipework

### PIPEWORK: FUEL PUMP VENT/DRAIN

|    |                              |   |        |
|----|------------------------------|---|--------|
| 43 | TUBING, fuel pump vent/drain | 1 | 149775 |
| 44 | GROMMET, fuel pump vent      | 1 | 600396 |

### PIPEWORK: FUEL PUMP TO PRESSURE RELIEF VALVE

|    |                                    |   |        |
|----|------------------------------------|---|--------|
| 45 | HOSE, fuel pump to PRV 'T' piece   | 1 | 215585 |
| 46 | GROMMET, return through boot floor | 1 | 600396 |

## Pressure Relief Valve Pipework

### PIPEWORK: RETURN FROM PRESSURE RELIEF VALVE TO FUEL FILTER

|    |                                 |   |        |
|----|---------------------------------|---|--------|
| 47 | HOSE, return from PRV to filter | 1 | 214892 |
| 48 | GROMMET, PRV to filter hose     | 1 | 600395 |

### PIPEWORK: DELIVERY FROM PRESSURE RELIEF VALVE TO METERING UNIT

|    |                                   |   |        |
|----|-----------------------------------|---|--------|
| 49 | PIPE ASSEMBLY, PRV to D.E. union  | 1 | 308826 |
| 50 | DOUBLE ENDED UNION (D.E. union)   | 1 | 149767 |
| 51 | PIPE ASSEMBLY, D.E. union to hose | 1 | 149754 |
| 52 | HOSE, flexible                    | 1 | 214890 |

### PIPEWORK: DRAIN FROM METERING UNIT TO FUEL FILTER VENT PIPE

|    |  |   |        |
|----|--|---|--------|
| 53 | ELBOW HOSE, rubber (Push on connection)                | 1 | 148947 |
| 54 | PIPE, front  | 1 | 214588 |
| 55 | CONNECTOR, front pipe to intermediate 5" x 3/16" bore. | 1 | 148945 |
| 56 | PIPE, intermediate                                     | 1 | 308493 |
| 57 | CONNECTOR, intermediate pipe & tank 2 3" x 3/16" bore. | 2 | 148945 |
| 58 | PIPE ASSEMBLY, rear                                    | 1 | 214896 |
| 59 | GROMMET, return pipe                                   | 1 | 600395 |

## Pipe Clips

|    |  |     |          |
|----|--|-----|----------|
| 60 | CLIP, fuel pipe to chassis, double                 | 3   | 149765   |
| 61 | RIVET, 'Pop' type, clip attaching                  | 6   | 560772   |
| 62 | CLIP, fuel pipe to chassis                         | 1   | 149810   |
| 63 | CLIP, rear drain pipe to tank support              | 1   | 59380    |
| 64 | SCREW, self tapping                                | 1   | AB608031 |
| 65 | CLIP, pipe securing to crossmember                 | 1   | 149815   |
| 66 | SCREW, clip retaining                              | 2   | PX503    |
| 67 | WASHER, locking                                    | 2   | WL105001 |
| 68 | NUT  | 2   | HN2005   |
| 69 | CLIP, pipes to rear crossmember                    | 2   | 137048   |
| 70 | CLIP, double, 3/16" to 5/16", anti fret As fitted. | A/R | 148820   |

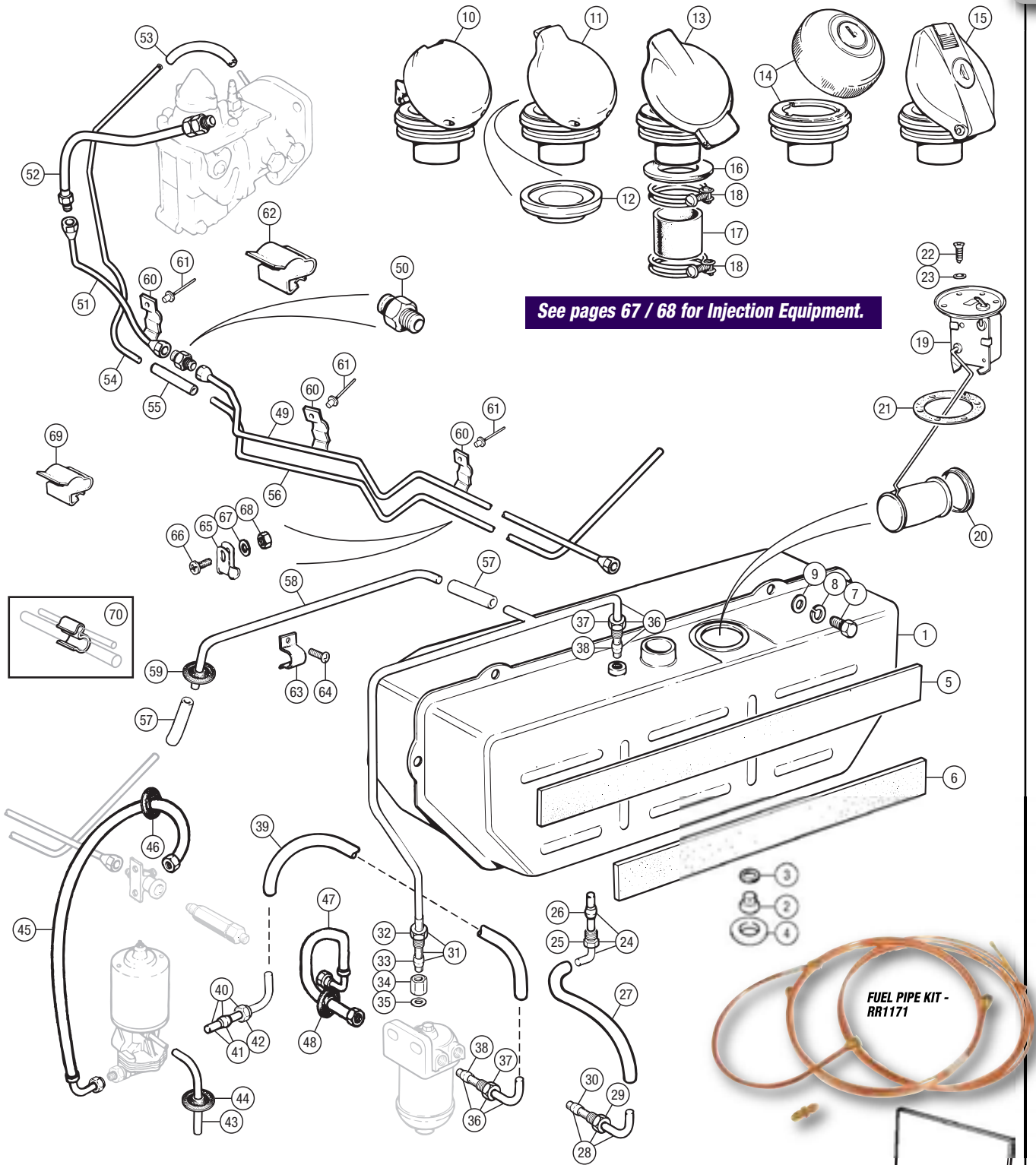
## Fuel Pipe Kit

|    |   |   |        |
|----|---|---|--------|
| 71 | FUEL PIPE KIT<br>Includes supply and return copper pipes only. Does not include rubber connections for the supply pipes to the injectors. | 1 | RR1171 |
|----|---|---|--------|

Abbreviations:

PRV is for Pressure Release Valve  
D.E. union is for Double End Union.





MILD STEEL FUEL TANK - 312359



ALUMINIUM REPLACEMENT FUEL TANK - 312359A



## TR250



STEEL FUEL TANK - 312359

ALUMINIUM FUEL TANK - 312359A

## Fuel Tank & Fittings

|    |                                       |   |           |
|----|---------------------------------------|---|-----------|
| 1  | FUEL TANK;                            |   |           |
|    | original TR250 item                   | 1 | 308312    |
|    | steel replacement                     | 1 | 312359    |
|    | aluminium replacement                 | 1 | 312359A   |
| 2  | PLUG, tank drain                      | 1 | 103222    |
| 3  | WASHER, drain plug                    | 1 | WF513     |
| 4  | PAD, drain plug to floor              | 1 | 611733    |
| 5  | SCREW, fuel tank to body              | 6 | GHF101    |
| 6  | WASHER, plain                         | 6 | GHF314    |
| 7  | WASHER, locking                       | 6 | GHF331    |
| 8  | PAD, felt, tank mounting, rear top    | 1 | 621721    |
| 9  | PAD, felt, tank mounting, rear bottom | 1 | 621721    |
| 10 | PLUG;                                 |   |           |
|    | 1/2", vent pipe hole (If required)    | 1 | CD27769   |
|    | 1", vent pipe hole (If required)      | 1 | 600399    |
| 11 | FUEL CAP, original, not locking       | 1 | 714393    |
| 12 | FUEL CAP, not locking                 | 1 | 725117    |
|    | Alternative to 714393.                |   |           |
| 13 | FUEL CAP, locking, round, with flange | 1 | 571086    |
| 14 | FUEL CAP ONLY                         | 1 | 571086CAP |
| 15 | FUEL CAP, locking, lozenge shaped     | 1 | GAC6001X  |
|    | Alternative to 571086.                |   |           |
| 16 | SEAL, cap to filler neck, vented      | 1 | 718738    |
| 17 | GROMMET, fuel cap                     | 1 | 650247    |
| 18 | HOSE, rubber, filler to tank          | 1 | UKC9920   |
|    | Replacement for original.             |   |           |
| 19 | CLAMP, wire band type;                |   |           |
|    | use with original filler hose         | 2 | CS4038    |
|    | use with replacement hose             | 2 | CS4042    |
| 20 | SENDER UNIT, fuel gauge               | 1 | 214465    |
| 21 | GASKET                                | 1 | 2H1082    |
| 22 | SCREW                                 | 6 | TR6504    |
| 23 | WASHER, fibre                         | 6 | WF505     |
| 24 | RING, anti-rattle                     | 1 | 139908    |

## Fuel Pump

### ORIGINAL MECHANICAL FUEL PUMP

|    |   |   |          |
|----|---|---|----------|
| 25 | FUEL PUMP ASSEMBLY  | 1 | 213577   |
| 26 | FUEL PUMP REPAIR KIT                                      | 1 | AEU2760A |
|    | Includes diaphragm, valves and gaskets for original pump. |   |          |
| 27 | GASKET, fuel pump to block                                | 1 | 138791   |
| 28 | NUT, pump to block  | 2 | GHF201   |
| 29 | WASHER, locking   | 2 | GHF332   |



FUEL PUMP REPAIR KIT - AEU2760A

### ALTERNATIVE ELECTRIC FUEL PUMP

|    |  |   |        |
|----|--|---|--------|
| 30 | ELECTRIC FUEL PUMP KIT   | 1 | RF4198 |
|    | Includes pump, pump mounts, wiring, fuel hose, clips and filter. |   |        |
| 31 | BLANKING PLATE   | 1 | 147876 |
|    | Blanks mechanical pump aperture in block.                        |   |        |
| 32 | GASKET, blanking plate to block                                  | 1 | 138791 |
| 33 | NUT, blanking plate to block                                     | 2 | GHF201 |
| 34 | WASHER, locking  | 2 | GHF332 |

## Pipe Work

### FUEL TANK TO INTERMEDIATE PIPES

|    |  |   |        |
|----|--|---|--------|
| 35 | PIPE, tank to connector                    | 1 | 149556 |
|    | Includes nut and olive.                    |   |        |
| 36 | UNION NUT, 3/8 thread, 5/16" pipe          | 1 | 60142  |
| 37 | OLIVE, 5/16                                | 1 | TL8    |
| 38 | CONNECTOR, tank to rear intermediate pipes | 1 | 115784 |
| 39 | PIPE, rear intermediate                    | 1 | 307532 |
| 40 | CONNECTOR, intermediate pipes              | 1 | 144938 |

### INTERMEDIATE TO PUMP PIPES - Without Fuel Filter

|    |   |   |        |
|----|---|---|--------|
| 41 | PIPE, front intermediate                    | 1 | 149637 |
| 42 | CONNECTOR, front intermediate to pump pipes | 1 | 115784 |
| 43 | PIPE, connector to pump                     | 1 | 149556 |
|    | Includes nut and olive.                     |   |        |
| 44 | UNION NUT, 3/8 thread, 5/16" pipe           | 1 | 60142  |
| 45 | OLIVE, 5/16"                                | 1 | TL8    |

### INTERMEDIATE TO PUMP PIPES - With Fuel Filter

|    |  |   |         |
|----|--|---|---------|
| 46 | PIPE, front intermediate                     | 1 | 149637  |
| 47 | CONNECTOR, front intermediate pipe to filter | 1 | 115784  |
| 48 | FILTER                                       | 1 | GFE7004 |
| 49 | CONNECTOR, filter to pump pipe               | 1 | 115784  |
| 50 | PIPE, filter to pump                         | 1 | 149556  |
|    | Includes nut and olive.                      |   |         |
| 51 | UNION NUT, 3/8 thread, 5/16" pipe            | 1 | 60142   |
| 52 | OLIVE, 5/16"                                 | 1 | TL8     |

### PUMP TO CARBURETTOR PIPES

|    |                                  |   |        |
|----|----------------------------------|---|--------|
| 53 | PIPE, pump to carburettor        | 1 | 306570 |
|    | Includes nut and olive.          |   |        |
| 54 | UNION NUT                        | 1 | 60176  |
| 55 | OLIVE                            | 1 | 102729 |
| 56 | BRACKET, supporting pipe         | 1 | 138516 |
| 57 | GROMMET, pipe in bracket         | 1 | 114178 |
| 58 | PIPE, carburettor to carburettor | 1 | 138386 |
| 59 | CONNECTOR;                       |   |        |
|    | black                            | 3 | 120331 |
|    | black and gold                   | 3 | 148992 |
|    | Alternative to 120331.           |   |        |

## Pipe Clips

|    |                                  |     |        |
|----|----------------------------------|-----|--------|
| 60 | CLIP, pipe to frame              | 3   | 551490 |
|    | Original item.                   |     |        |
|    | CLIP, fuel pipe, single          | A/R | 150930 |
|    | Plastic alternative to item 60.  |     |        |
| 61 | CLIP, fuel and brake pipes, twin | A/R | 624155 |
|    | Plastic alternative to item 60.  |     |        |

## Fuel Pipe Kit

|    |   |   |                 |
|----|---|---|-----------------|
| 62 | FUEL PIPE KIT, copper, car set                          | 1 | RF4107STROMBERG |
|    | Add items 47, 48 to this kit for cars with fuel filter. |   |                 |



725117

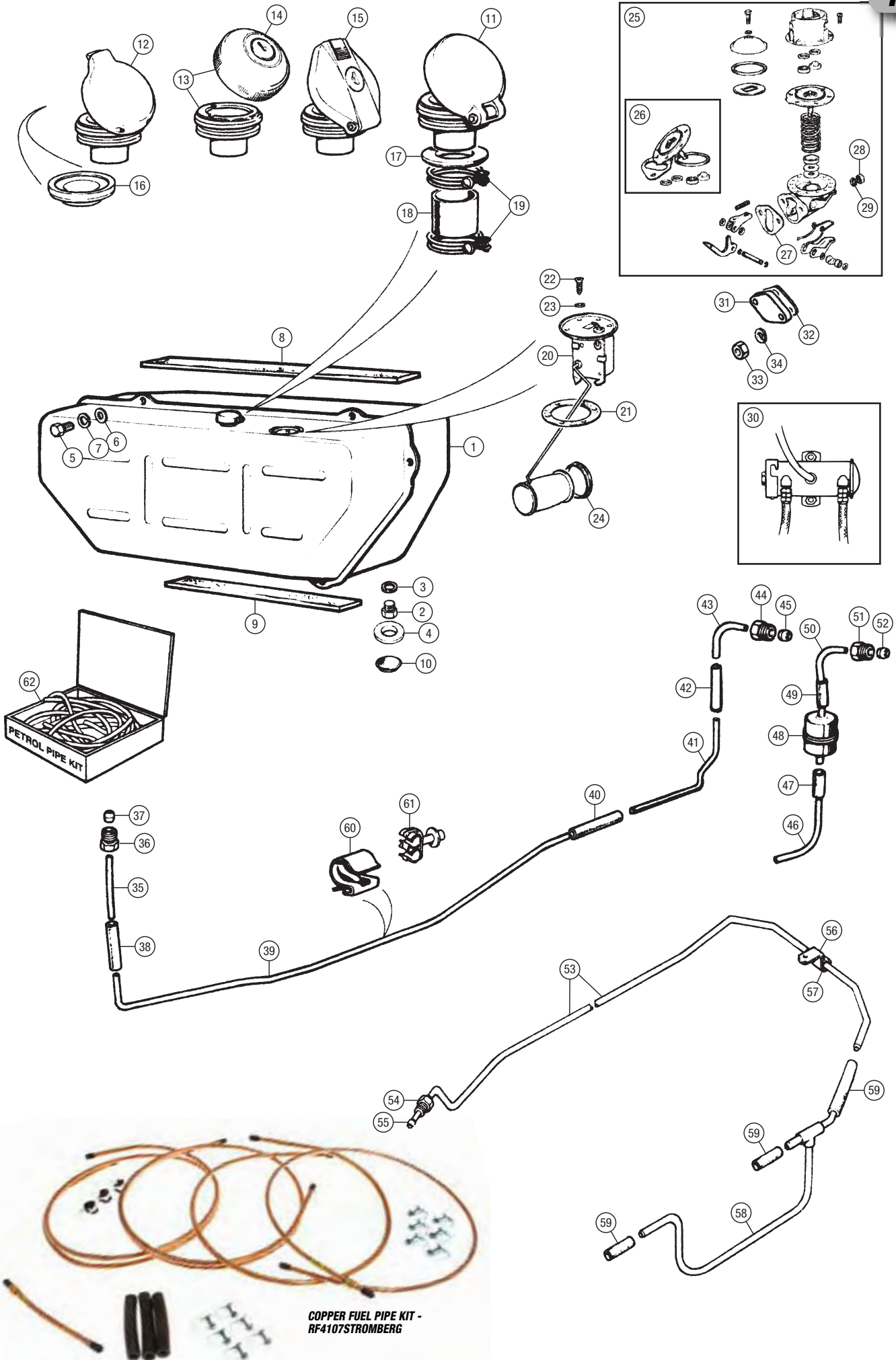
FUEL CAPS

571086

GAC6001X









## Carburetter Assemblies

|   |                              |   |         |
|---|------------------------------|---|---------|
| 1 | PAIR OF CARBURETTERS;<br>new | 1 | AUC721T |
|   | reconditioned, exchange      | 1 | AUC721R |
| 2 | CARBURETTER ASSEMBLY, front  | 1 | 201996  |
| 3 | CARBURETTER ASSEMBLY, rear   | 1 | 201997  |

## Service & Rebuild Kits

|   |   |   |        |
|---|---|---|--------|
| 4 | GASKET KIT, for one carburetter<br><i>Includes items 42, 43, 56, 62, 64, 65, 68, 69, 96, 100, 101, 103, 111, 114.</i> | 2 | AUE901 |
| 5 | SERVICE KIT, for one carburetter<br><i>Includes gasket kit, plus items 74, 95.</i>                                    | 2 | CSK40  |
| 6 | REBUILD KIT;<br>for one carburetter   | 2 | CRK205 |
|   | <i>Includes service kit, plus items 80, 81, 97, 117, 119, 120, 126, 127.</i>  |   |        |
|   | for two carburetters  | 1 | RW3003 |
|   | <i>Includes CRK205 rebuild kit, plus item 61.</i>   |   |        |
| - | DASHPOT OIL (25ml)  | 1 | BDR125 |

## Linkages

|    |  |     |          |
|----|--|-----|----------|
| 7  | SHAFT, connecting front to rear<br>throttle spindles <i>(Cut to 3 3/16" long)</i>  | 1   | AUC1462  |
| 8  | COUPLING ASSEMBLY <i>(Includes items 9-12)</i>   | 2   | RTC169   |
| 9  | COUPLING   | 2   | AUC4334  |
| 10 | BOLT, coupling, 4BA  | 4   | AUC2669  |
| 11 | NUT, bolt clamping, 4BA  | 4   | AJD8014Z |
| 12 | WASHER, plain  | 4   | AUC4612  |
| 13 | LEVER, throttle shaft,<br>on front carburetter   | 1   | AUE191   |
| 14 | BOLT, for lever, 2BA   | 1   | AUC2694  |
| 15 | WASHER, locking  | 1   | AUC4612  |
| 16 | NUT, bolt clamping, 2BA  | 1   | AJD8014Z |
| 17 | LINK ROD ASSEMBLY, short vertical  | 1   | 148496   |
| 18 | LOCK NUT   | 2   | GHF200   |
| 19 | NUT, rod to lever  | 1   | GHF200   |
| 20 | WASHER, locking  | 4   | GHF331   |
| 21 | PIVOT PIN AND BRACKET ASSEMBLY   | 1   | 106759   |
| 22 | SCREW, pivot to manifold   | 1   | GHF120   |
| 23 | WASHER, locking  | 1   | GHF332   |
| 24 | BELL CRANK LEVER ASSEMBLY  | 1   | 106756   |
| 25 | WASHER   | 1   | GHF301   |
| 26 | SPLIT PIN, bell crank to pivot pin   | 1   | GHF500   |
| 27 | LINK ROD ASSEMBLY, long horizontal   | 1   | 106764   |
| 28 | LOCK NUT   | 2   | GHF200   |
| 29 | CHOKE INTERCONNECTION ROD<br>AND FORK ASS'Y <i>(Includes items 30-36)<br/>Improved design with two adjustable forks.</i> | 1   | 107834   |
| 30 | ROD, jet connecting  | 1   | AUC3435  |
| 31 | FORK, rod end  | 2   | AUC2256  |
| 32 | LOCKNUT, 2BA   | 2   | AJD8012Z |
| 33 | CLEVIS PIN,<br>connecting rod to front lever   | 1   | AUC5074  |
| 34 | WASHER, plain  | A/R | AUC8396  |
| 35 | CLEVIS PIN,<br>connecting rod to rear lever  | 1   | 108326   |
| 36 | SPLIT PIN  | 2   | GHF500   |
| 37 | TRUNNION, choke cable, original  | 1   | 58997    |
|    | TRUNNION ASS'Y, alternative  | 1   | ACC5062  |
| 38 | SCREW, original trunnion   | 1   | HU503    |
| 39 | WASHER, plain, original trunnion   | 1   | WP28     |
| 40 | NUT, original trunnion   | 1   | GHF220   |

## Carburetter Attachments

|    |  |   |         |
|----|--|---|---------|
| 41 | INSULATING BLOCK, carb to manifold<br><i>Replacement item; fit in pairs.</i> | 2 | AHH5713 |
| 42 | GASKET, carburetter to manifold  | 4 | AEH551  |
| 43 | GASKET, air cleaner to carburetter   | 2 | 102488  |
| 44 | STUD, carburetter to manifold  | 4 | 58917   |
| 45 | NUT, carburetter to manifold;<br>steel <i>(Alternative to brass nut)</i>     | 4 | 56675   |
|    | brass <i>(Alternative to steel nut)</i>                                      | 4 | 108951  |
| 46 | WASHER, locking  | 4 | GHF333  |

## Carburetter Components

### BODY AND CHAMBER

|    |  |   |          |
|----|--|---|----------|
| 47 | BODY ASSEMBLY;<br>front carburetter  | 1 | AUC6020  |
|    | rear carburetter   | 1 | AUC6020  |
| 48 | LIFT PIN KIT (tickler pin)<br><i>Includes items 49-51.</i>                         | 2 | WZX993   |
| 49 | PIN, piston lifting  | 2 | WZX1105  |
| 50 | SPRING, pin  | 2 | AUD1151  |
| 51 | RETAINER, pin  | 2 | AUD4150  |
| 52 | UNION, auto ignition vacuum,<br>front carburetter                                  | 1 | AUC5100  |
|    |  | 2 | AUC8019  |
| 53 | CHAMBER & PISTON ASSEMBLY<br><i>Natural finish; includes item 57.</i>              | 2 | AUC8019P |
|    | CHAMBER & PISTON ASSEMBLY<br><i>Alternative polished finish; includes item 57.</i> | 2 | AUC2383  |
| 54 | SCREW, needle locking  | 2 | AUC2383  |
| 55 | CAP & DAMPER ASSEMBLY;<br>brass <i>(Original item)</i>                             | 2 | GSU321HB |
|    | plastic <i>(Replacement item)</i>  | 2 | GSU321   |
| 56 | WASHER, fibre  | 2 | AUC4900A |
| 57 | SPRING, piston return, red   | 2 | AUC4387  |
| 58 | WASHER, under piston spring<br><i>Do not use with flat end springs.</i>            | 2 | AUC3071  |
| 59 | SCREW, chamber to body   | 6 | JZX1394  |
| 60 | WASHER, locking  | 6 | WL105001 |

### JET BEARING KIT - WZX1593



### JET, BEARING AND NEEDLE

|    |   |   |         |
|----|---|---|---------|
| 61 | JET BEARING KIT<br><i>Includes items 62-73.</i> | 2 | WZX1593 |
| 62 | WASHER, top bearing                             | 2 | AUC2122 |
| 63 | BEARING, top                                    | 2 | AUC3230 |
| 64 | WASHER, gland (cork)                            | 4 | AUC2120 |
| 65 | WASHER, cupped (brass)                          | 4 | AUC2119 |
| 66 | SPRING, jet gland                               | 2 | AUC1158 |
| 67 | BEARING, bottom                                 | 2 | AUC3231 |
| 68 | WASHER, bottom bearing                          | 2 | AUC3233 |
| 69 | RING, sealing (cork)                            | 2 | AUC2118 |
| 70 | RING, sealing (aluminium)                       | 2 | AUC2117 |
| 71 | NUT, jet sealing                                | 2 | AUC3232 |
| 72 | SPRING, mixture nut                             | 2 | AUC2114 |
| 73 | NUT, mixture adjusting                          | 2 | AUC2121 |
| 74 | JET ASSEMBLY                                    | 2 | WZX1595 |
| 75 | NEEDLE, jet;<br>standard (FV)                   | 2 | AUD1201 |
|    | weak (CR)                                       | 2 | AUD1108 |
|    | rich (GER)                                      | 2 | AUD1228 |

### LINKAGES

|    |   |    |          |
|----|---|----|----------|
| 76 | LEVER, operating jet, front carburetter   | 1  | AUC3234  |
| 77 | LEVER, operating jet, rear carburetter  | 1  | AUC3346  |
| 78 | LINK, front carb body to choke lever<br><i>Clamps outer choke cable.</i>  | 1  | AUE63    |
| 79 | LINK, rear carb body to choke lever   | 1  | AUC3419  |
| 80 | CLEVIS PIN, attaching link to jet lever<br>and carburetter body and attaching choke<br>interconnecting rod to jet levers. | 6  | PJ8506   |
|    |   | 11 | GHF500   |
| 81 | SPLIT PIN   | 11 | GHF500   |
| 82 | SPRING, jet return, jet lever to<br>carburetter body  | 2  | AUC4667  |
| 83 | FAST IDLE LINK KIT<br><i>Includes items 81, 84, 85, 86, 87, 88.</i>   | 1  | WZX976   |
| 84 | LEVER, fast idle relay  | 1  | AUC3502  |
| 85 | BOLT, pivot, fast idle relay lever  | 1  | AUC3471  |
| 86 | WASHER, double coil, under bolt head  | 1  | AJD7722  |
| 87 | WASHER, plain,<br>lever to carburetter body   | 1  | AUC4848  |
| 88 | LINK ROD, front carburetter,<br>jet lever to fast idle lever  | 1  | AUC4853  |
| 89 | BOLT, clamping outer choke cable  | 1  | AUB660   |
| 90 | NUT, plain  | 1  | AJD8012  |
| 91 | WASHER, locking   | 1  | WL105001 |

### FLOAT CHAMBERS

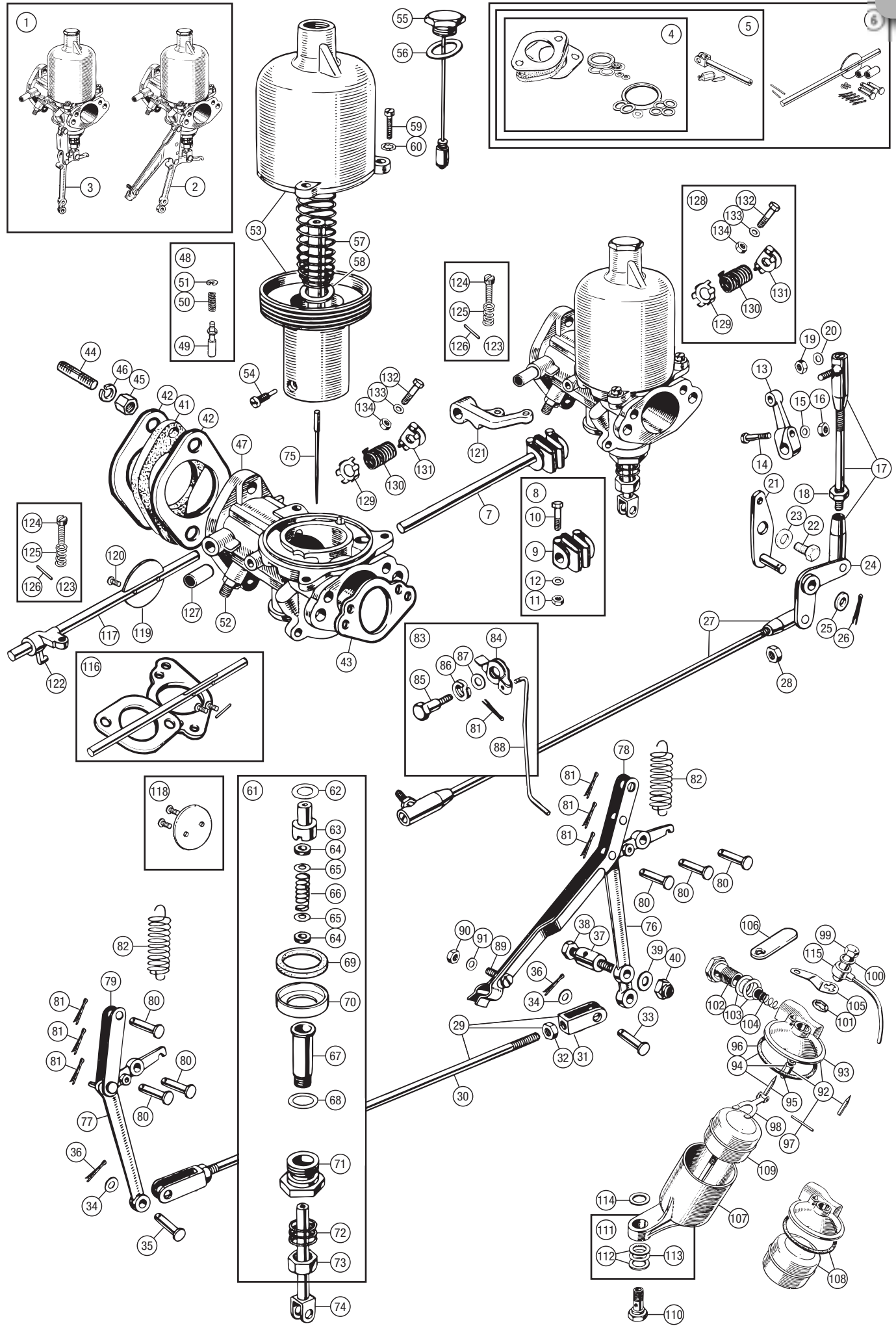
|     |   |   |           |
|-----|---|---|-----------|
| 92  | FLOAT LID ASSEMBLY<br><i>Includes items 93, 94, 97.</i>             | 2 | AUE479    |
| 93  | FLOAT LID   | 2 | AUC4760   |
| 94  | NEEDLE AND SEAT KIT<br><i>Includes items 95, 96.</i>                | 2 | WZX1101A* |
| 95  | NEEDLE AND SEAT   | 2 | AUC8170   |
| 96  | GASKET, float chamber lid   | 2 | AUC1147A* |
| 97  | PIN, lever pivot  | 2 | AUC1152*  |
| 98  | LEVER, float<br>Use on new float lids<br>Use on original float lids | 2 | AUD2285   |
|     |   | 2 | AUC1980   |
| 99  | CAP NUT, retaining float lid<br>Natural finish                      | 2 | AUC1867   |
|     | Alternative polished brass finish                                   | 2 | AUC1867B  |
| 100 | WASHER, under nut (aluminium)                                       | 2 | AUC1557   |
| 101 | WASHER, serrated, on float lid (fibre)                              | 4 | AUC1928   |
| 102 | BOLT, banjo, fuel line to lid<br>Natural finish                     | 2 | 150926    |
|     | Alternative polished brass finish                                   | 2 | AUC2698B  |
| 103 | WASHER, fibre   | 4 | WF524     |
| 104 | FILTER, fuel inlet  | 2 | AUC2139   |
| 105 | ARM, float chamber support  | 2 | AUC4998   |
| 106 | IDENTIFICATION TAG (blank)  | 2 | AUC1051   |
| 107 | CHAMBER, float  | 2 | AUC3495   |
| 108 | FLOAT AND GASKET KIT<br><i>Includes items 96, 109.</i>              | 2 | WZX1303   |
| 109 | FLOAT   | 2 | AUC1128*  |
| 110 | BOLT, hold up, float chamber to<br>carburetter body                 | 2 | AUC1541   |
| 111 | WASHER KIT, 2 fibre and 1 metal<br><i>Includes items 112, 113.</i>  | 2 | AUE6      |
| 112 | WASHER, fibre   | 4 | AUC5027   |
| 113 | WASHER, metal, between fibre washers                                | 2 | AUC5026   |
| 114 | WASHER, fibre, chamber to body                                      | 2 | AUC2130   |
| 115 | VENT PIPE, float chamber  | 2 | AUC1866   |

### THROTTLE SPINDLE

|     |   |   |           |
|-----|---|---|-----------|
| 116 | THROTTLE SPINDLE KIT<br><i>Includes items 42, 43, 117, 121, 127.</i>                | 2 | WZX988    |
| 117 | SPINDLE, throttle;<br>standard  | 2 | AUC3242   |
|     | oversize replacement<br><i>To repair worn body.</i>                                 | 2 | AUC3242RP |
| 118 | THROTTLE DISC KIT<br><i>Includes items 119, 120.</i>                                | 2 | WZX1323   |
| 119 | DISC, throttle  | 2 | AUC3116   |
| 120 | SCREW, throttle disc  | 4 | AUC1358   |
| 121 | LEVER, throttle stop, front carburetter   | 1 | AUC3437   |
| 122 | LEVER, throttle stop, rear carburetter  | 1 | AUC2189   |
| 123 | SLOW RUNNING SCREW KIT<br><i>Includes items 124-126.</i>                            | 3 | WZX983    |
| 124 | SCREW, in spring  | 3 | AUC8483   |
| 125 | SPRING, slow running screw  | 3 | AUC2451   |
| 126 | PIN, tapered, lever to spindle  | 2 | AUD2906   |
| 127 | BUSH, throttle spindle to body<br><i>To repair worn body; machine fit and ream.</i> | 4 | AUD3080   |
| 128 | THROTTLE SPINDLE RETURN<br>SPRING KIT<br><i>Includes items 129-134.</i>             | 2 | WZX1594   |
| 129 | ANCHOR PLATE, spring  | 2 | AUC4770   |
| 130 | SPRING, left hand, throttle return  | 2 | AUC4782   |
| 131 | CLIP, return spring   | 2 | AUC4771   |
| 132 | BOLT, for clip, 4BA   | 2 | AUC2669   |
| 133 | WASHER, locking   | 2 | AUC4612   |
| 134 | NUT, clamping bolt, 4BA   | 2 | AJD8014Z  |









| No. | DESCRIPTION | QTY REQ. | PART No. |
|-----|-------------|----------|----------|
|-----|-------------|----------|----------|

**TR3-3A-4****Carburettor Assemblies****TR3**

|   |                              |   |         |
|---|------------------------------|---|---------|
| 1 | PAIR OF CARBURETTERS;<br>new | 1 | AUC786T |
|   | reconditioned, exchange      | 1 | AUC786R |
| 2 | CARBURETTOR ASSEMBLY, front  | 1 | 203129  |
| 3 | CARBURETTOR ASSEMBLY, rear   | 1 | 203130  |

**TR3A, TR4 to CT21470**

|   |                              |   |         |
|---|------------------------------|---|---------|
| 1 | PAIR OF CARBURETTERS;<br>new | 1 | RF4029  |
|   | reconditioned, exchange      | 1 | RF4029R |
| 2 | CARBURETTOR ASSEMBLY, front  | 1 | 207535  |
| 3 | CARBURETTOR ASSEMBLY, rear   | 1 | 207536  |

**Service & Rebuild Kits**

|   |  |   |         |
|---|--|---|---------|
| 4 | GASKET KIT, for one carburettor<br><i>Includes items 41, 42, 57, 63, 65, 66, 69, 70, 102, 107, 108, 110, 121/125, 122.</i> | 2 | AUE801A |
| 5 | SERVICE KIT, for one carburettor<br><i>Includes gasket kit, plus items 75, 100.</i>  | 2 | CSK41   |
| 6 | REBUILD KIT, for one carburettor<br><i>Includes service kit, plus items 81, 82, 103, 130, 132, 133, 139, 140.</i>          | 2 | CRK210  |
| - | DASHPOT OIL (25ml)   | 1 | BDR125  |

**Linkages**

|    |  |     |          |
|----|--|-----|----------|
| 7  | SHAFT, connecting front to rear throttle<br>spindles ( <i>Cut to 3 3/16" long</i> )                                    | 1   | AUC1462  |
| 8  | COUPLING ASSEMBLY<br><i>Includes items 9-12.</i>   | 2   | RTC169   |
| 9  | COUPLING   | 2   | AUC4334  |
| 10 | BOLT, coupling, 4BA  | 4   | AUC2669  |
| 11 | NUT, bolt clamping, 4BA  | 4   | AJD8014Z |
| 12 | WASHER, plain  | 4   | AUC4612  |
| 13 | LEVER, throttle shaft,<br>on front carburettor   | 1   | AUE191   |
| 14 | BOLT, for lever, 2BA   | 1   | AUC2694  |
| 15 | WASHER, locking  | 1   | WL105001 |
| 16 | NUT, bolt clamping, 2BA  | 1   | AJD8012  |
| 17 | LINK ROD ASSEMBLY, short vertical  | 1   | 148496   |
| 18 | LOCK NUT   | 2   | GHF200   |
| 19 | NUT, rod to lever  | 1   | GHF200   |
| 20 | WASHER, locking  | 4   | GHF331   |
| 21 | PIVOT PIN AND BRACKET ASSEMBLY   | 1   | 106759   |
| 22 | SCREW, pivot to manifold   | 1   | GHF120   |
| 23 | WASHER, locking  | 1   | GHF332   |
| 24 | BELL CRANK LEVER ASSEMBLY  | 1   | 106756   |
| 25 | WASHER   | 1   | GHF301   |
| 26 | SPLIT PIN, bell crank to pivot pin   | 1   | GHF500   |
| 27 | LINK ROD ASSEMBLY, long horizontal   | 1   | 106764   |
| 28 | LOCK NUT   | 2   | GHF200   |
| 29 | CHOKE INTERCONNECTION ROD<br>AND FORK ASS'Y<br><i>Includes items 30-35. Improved design with two adjustable forks.</i> | 1   | 107834   |
| 30 | ROD, jet connecting  | 1   | AUC3435  |
| 31 | FORK, rod end  | 2   | AUC2256  |
| 32 | LOCKNUT, 2BA   | 2   | AJD8012Z |
| 33 | CLEVIS PIN,<br>connecting rod to front lever   | 1   | 108326   |
| 34 | WASHER, plain  | A/R | AUC8396  |
| 35 | SPLIT PIN  | 2   | GHF500   |
| 36 | TRUNNION AND PIVOT ASS'Y,<br>choke cable clamping<br><i>Includes items 37-39.</i>                                      | 1   | WZX875   |
| 37 | TRUNNION AND PIVOT   | 1   | 113454   |
| 38 | WASHER, plain  | 1   | WP5      |
| 39 | NUT  | 1   | AJD8204Z |

**Carburettor Attachments****STANDARD ATTACHMENTS**

|    |  |   |        |
|----|--|---|--------|
| 40 | INSULATING BLOCK,<br>carburettor to manifold | 2 | 112866 |
| 41 | GASKET, carburettor to manifold              | 4 | 112867 |
| 42 | GASKET, air cleaner to carburettor           | 2 | 112892 |
| 43 | STUD, carburettor to manifold                | 8 | 112907 |
| 44 | NUT, carburettor to manifold                 | 8 | GHF201 |
| 45 | WASHER, locking                              | 8 | GHF332 |

**ADAPTOR PLATE KIT**

The adaptor plate kit rubber mounts the carburetters to the engine, reducing frothing of fuel, poor float needle seating and therefore flooding because of vibration in the float chambers. The kit may also be used to fit later type H56 carburetters if desired and includes adaptor plates, rubber mountings, bolts, gaskets and Studloc.

|    |   |   |         |
|----|---|---|---------|
| 46 | ADAPTOR PLATE KIT,<br>with rubber mountings | 1 | RW3042  |
| 47 | RUBBER MOUNTING ONLY                        | 2 | TKC1338 |

**Carburettor Components****BODY & CHAMBER**

|    |   |   |           |
|----|---|---|-----------|
| 48 | BODY ASSEMBLY;<br>front carburettor                                     | 1 | AUC6040   |
|    | rear carburettor  | 1 | AUC6040   |
| 49 | LIFT PIN KIT (tickler pin)<br><i>Includes items 50-52.</i>              | 2 | WZX993    |
| 50 | PIN, piston lifting   | 2 | WZX1105   |
| 51 | SPRING, pin   | 2 | AUD1151   |
| 52 | RETAINER, pin   | 2 | AUD4150   |
| 53 | UNION, auto ignition vacuum,<br>front carburettor                       | 1 | AUC5100   |
| 54 | CHAMBER & PISTON ASSEMBLY<br>Natural finish ( <i>includes item 55</i> ) | 2 | AUC8054   |
|    | Alternative polished finish<br><i>Includes item 55.</i>                 | 2 | AUC8054P  |
| 55 | SCREW, needle locking   | 2 | AUC2468   |
| 56 | CAP & DAMPER ASSEMBLY,<br>brass cap ( <i>Original item</i> )            | 2 | AUC8102A  |
|    | plastic cap ( <i>Replacement item</i> )                                 | 2 | AUC8102HB |
| 57 | WASHER, fibre   | 2 | AUC4900A  |
| 58 | SPRING, piston return, red  | 2 | AUC4387   |
| 59 | WASHER, under piston spring<br><i>Do not use with flat end springs.</i> | 2 | AUC3071   |
| 60 | SCREW, chamber to body  | 6 | JZX1394   |
| 61 | WASHER, locking   | 6 | WL105001  |

**JET, BEARING & NEEDLE**

|    |   |   |         |
|----|---|---|---------|
| 62 | JET BEARING KIT<br><i>Includes items 63-74.</i> | 2 | WZX1593 |
| 63 | WASHER, top bearing                             | 2 | AUC2122 |
| 64 | BEARING, top                                    | 2 | AUC3230 |
| 65 | WASHER, gland (cork)                            | 4 | AUC2120 |
| 66 | WASHER, cupped (brass)                          | 4 | AUC2119 |
| 67 | SPRING, jet gland                               | 2 | AUC1158 |
| 68 | BEARING, bottom                                 | 2 | AUC3231 |
| 69 | WASHER, bottom bearing                          | 2 | AUC3233 |
| 70 | RING, sealing (cork)                            | 2 | AUC2118 |
| 71 | RING, sealing (aluminium)                       | 2 | AUC2117 |
| 72 | NUT, jet sealing                                | 2 | AUC3232 |
| 73 | SPRING, mixture nut                             | 2 | AUC2114 |
| 74 | NUT, mixture adjusting                          | 2 | AUC2121 |
| 75 | JET ASSEMBLY                                    | 2 | AUC8183 |
| 76 | NEEDLE, jet;<br>standard (SM)                   | 2 | AUD1328 |
|    | weak (SL)                                       | 2 | AUD1327 |
|    | rich (RH)                                       | 2 | AUD1291 |

**LINKAGES**

|    |  |    |          |
|----|--|----|----------|
| 77 | LEVER, operating jet, front carburettor  | 1  | AUC1029  |
| 78 | LEVER, operating jet, rear carburettor   | 1  | AUC1029  |
| 79 | LINK, front carb body to choke lever<br><i>Clamps choke cable outer.</i>   | 1  | AUE55    |
| 80 | LINK, rear carb body to choke lever  | 1  | AUC3419  |
| 81 | CLEVIS PIN, attaching link to jet lever<br>and carburettor body and attaching choke<br>interconnecting rod to jet levers | 6  | PJ8506   |
| 82 | SPLIT PIN  | 11 | GHF500   |
| 83 | SPRING, jet return, jet lever to<br>carburettor body   | 2  | AUC4667  |
| 84 | FAST IDLE LINK KIT<br><i>Includes items 85-90.</i>   | 1  | WZX998   |
| 85 | CAM, fast idle relay   | 1  | AUC4730  |
| 86 | BOLT, pivot, fast idle relay lever   | 1  | AUC3471  |
| 87 | WASHER, double coil, under bolt head   | 1  | AJD7722  |
| 88 | LINK ROD, front carburettor,<br>jet lever to fast idle lever   | 1  | AUC3525  |
| 89 | PIN, link rod to lever   | 1  | AUC5011  |
| 90 | WASHER, 'starlock', rod securing   | 2  | AUC5004  |
| 91 | BOLT, clamping outer choke cable   | 1  | AUB660   |
| 92 | NUT, plain   | 1  | AJD8012  |
| 93 | WASHER, locking  | 1  | WL105001 |

**FLOAT CHAMBERS**

|     |  |   |          |
|-----|--|---|----------|
| 94  | FLOAT LID ASSEMBLY - TR3<br><i>Includes items 95, 101, 103.</i>  | 2 | AUE254   |
| 95  | FLOAT LID - TR3  | 2 | AUE478   |
| 96  | FLOAT LID ASSEMBLY, front<br><i>TR3A, TR4 to CT21470. Includes items 98, 101, 103.</i>                               | 1 | AUE258   |
| 97  | FLOAT LID ASSEMBLY, rear<br><i>TR3A, TR4 to CT21470. Includes items 99, 101, 103.</i>                                | 1 | AUE259   |
| 98  | FLOAT LID, front ( <i>TR3A, TR4 to CT21470</i> )   | 1 | AUC4103  |
| 99  | FLOAT LID, rear ( <i>TR3A, TR4 to CT21470</i> )  | 1 | AUC4104  |
| 100 | NEEDLE AND SEAT KIT<br><i>Includes items 101, 102.</i>   | 2 | WZX1101A |
| 101 | NEEDLE AND SEAT  | 2 | AUC8170  |
| 102 | GASKET, float chamber lid  | 2 | AUC1147A |
| 103 | PIN, lever pivot   | 2 | AUC1152  |
| 104 | LEVER, float;<br>use on new float lids<br>use on original float lids   | 2 | AUD2285  |
|     |  | 2 | AUC1980  |
| 105 | CAP NUT, retaining float lid - TR3;<br>natural finish<br>alternative polished brass finish                           | 2 | AUC1867  |
|     |  | 2 | AUC1867B |
| 106 | CAP NUT, retaining float lid ( <i>TR3A, TR4 to CT21470</i> );<br>natural finish<br>alternative polished brass finish | 2 | AUC1163  |
|     |  | 2 | AUC1163B |
| 107 | WASHER, under nut (aluminium)  | 2 | AUC1557  |
| 108 | WASHER, serrated, on float lid, (fibre)<br>TR3   | 4 | AUC1928  |
| 109 | BOLT, banjo, fuel line to lid - TR3;<br>natural finish<br>alternative polished brass finish                          | 2 | 150926   |
|     |  | 2 | AUC2698B |
| 110 | WASHER, fibre - TR3  | 4 | WF524    |
| 111 | FILTER, fuel inlet - TR3   | 2 | AUC2139  |
| 112 | IDENTIFICATION TAG (blank)   | 2 | AUC1051  |
| 113 | VENT PIPE, float chamber - TR3   | 2 | AUC1866  |
| 114 | VENT PIPE, float chamber<br><i>TR3A, TR4 to CT21470.</i>   | 2 | 121273   |
| 115 | PIPE, flexible, vent pipe to float chamber lid<br><i>TR3A, TR4 to CT21470.</i>                                       | 2 | 120331   |
| 116 | CHAMBER, float   | 2 | AUC3495  |
| 117 | FLOAT AND GASKET KIT<br><i>Includes items 102, 118.</i>  | 2 | WZX1303  |
| 118 | FLOAT  | 2 | AUC1128  |

**FLOAT CHAMBER MOUNTING - TR3**

|     |   |   |         |
|-----|---|---|---------|
| 119 | BOLT, hold up, float chamber<br>to carburettor body               | 2 | AUC1335 |
| 120 | WASHER KIT, 2 rubber & 1 metal<br><i>Includes items 121, 122.</i> | 2 | 509620  |
| 121 | WASHER, rubber  | 4 | AUC1534 |
| 122 | WASHER, metal, dished   | 2 | AUC1337 |

**FLOAT CHAMBER MOUNTING - TR3A, TR4 to CT21470.**

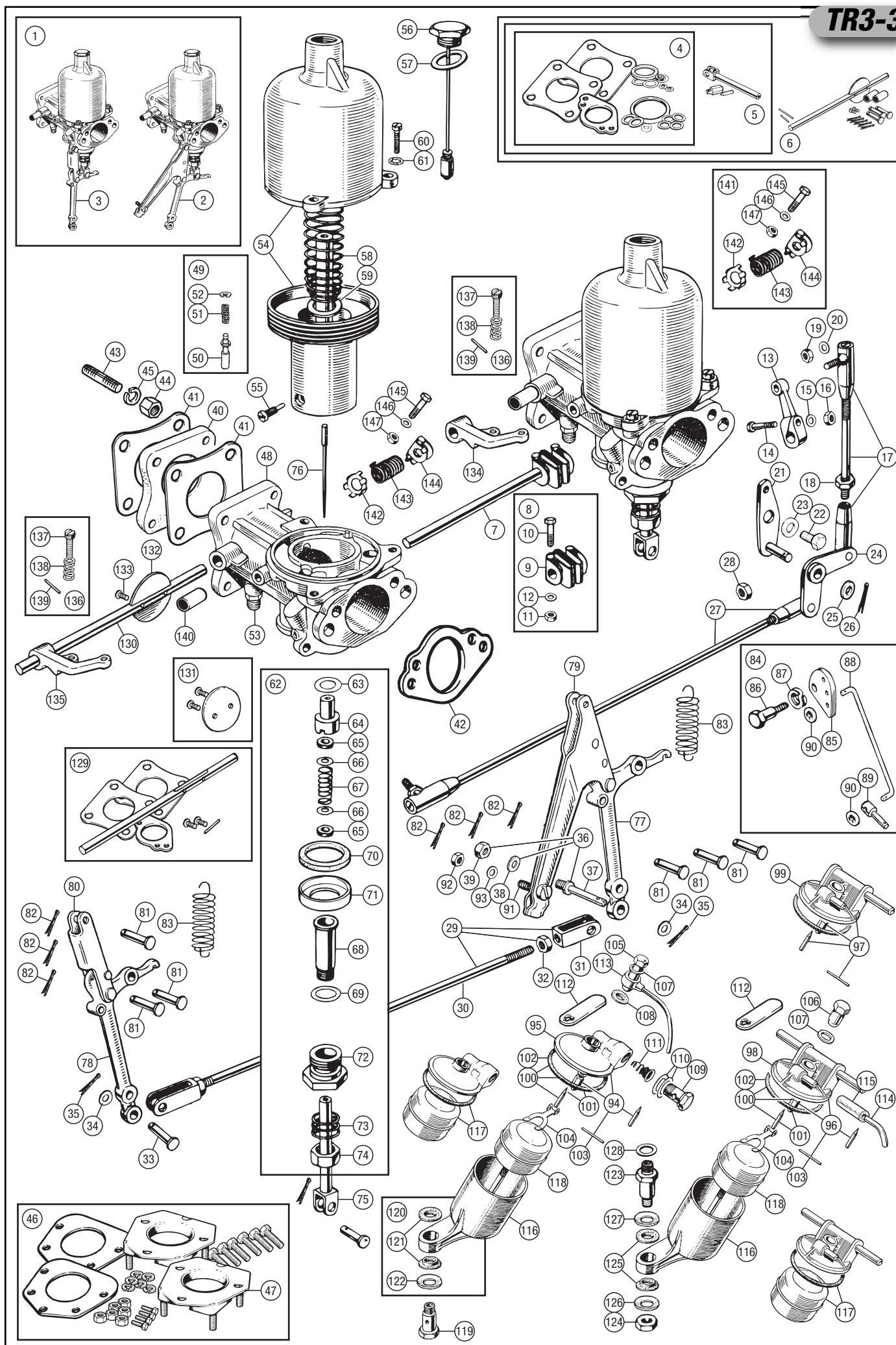
The 'hold up bolt' style of fixing used on the earlier TR3 float chambers (see 119-122) can be used as an alternative to items 123-128.

|     |  |   |         |
|-----|--|---|---------|
| 123 | STUD, float chamber to body            | 2 | AUC1387 |
| 124 | NUT, securing float chamber to stud    | 2 | AJD8206 |
| 125 | WASHER, rubber                         | 4 | AUC1534 |
| 126 | WASHER, steel, nut to lower washer     | 2 | GHF302  |
| 127 | WASHER, steel, middle, chamber to stud | 2 | AUC1389 |
| 128 | WASHER, fibre, stud to body            | 2 | AUC1384 |

**THROTTLE SPINDLE**

|     |   |   |           |
|-----|---|---|-----------|
| 129 | THROTTLE SPINDLE KIT<br><i>Includes items 41, 42, 130, 133, 139.</i>                  | 2 | WZX989    |
| 130 | SPINDLE, throttle;<br>original<br>oversize replacement<br><i>To repair worn body.</i> | 2 | AUC4284   |
|     |   | 2 | AUC3242RP |
| 131 | THROTTLE DISC KIT ( <i>includes items 132, 133</i> )                                  | 2 | WZX1321   |
| 132 | DISC, throttle  | 2 | AUC3280   |
| 133 | SCREW, throttle disc  | 4 | AUC1358   |
| 134 | LEVER, throttle stop, front carburettor   | 1 | AUC5049   |
| 135 | LEVER, throttle stop, rear carburettor  | 1 | AUC2198   |
| 136 | SLOW RUNNING SCREW KIT<br><i>Includes items 137-139.</i>                              | 3 | WZX983    |
| 137 | SCREW, in spring  | 3 | AUC8483   |
| 138 | SPRING, slow running screw  | 3 | AUC2451   |
| 139 | PIN, tapered, lever to spindle  | 2 | AUD2906   |
| 140 | BUSH, throttle spindle to body<br><i>To repair worn body; machine fit and ream.</i>   | 4 | AUD3080   |
| 141 | THROTTLE SPINDLE RETURN<br>SPRING KIT ( <i>includes items 142-147</i> )               | 2 | WZX1594   |
| 142 | ANCHOR PLATE, spring  | 2 | AUC4770   |
| 143 | SPRING, left hand, throttle return  | 2 | AUC4782   |
| 144 | CLIP, return spring   | 2 | AUC4771   |
| 145 | BOLT, for clip, 4BA   | 2 | AUC2669   |
| 146 | WASHER, locking   | 2 | AUC4612   |
| 147 | NUT, clamping bolt, 4BA   | 2 | AJD8014Z  |







## TR4A

## Carburettor Assemblies

## TR4A, Standard Specification

|   |                             |   |         |
|---|-----------------------------|---|---------|
| 1 | PAIR OF CARBURETTERS;       |   |         |
|   | new                         | 1 | RF4030  |
|   | reconditioned, exchange     | 1 | RF4030R |
| 2 | CARBURETTOR ASSEMBLY, front | 1 | 213216  |
| 3 | CARBURETTOR ASSEMBLY, rear  | 1 | 213217  |

## TR4A, North American Specification

|   |                         |   |         |
|---|-------------------------|---|---------|
| 2 | PAIR OF CARBURETTERS;   |   |         |
|   | new                     | 1 | RF4031  |
|   | reconditioned, exchange | 1 | RF4031R |

## Service &amp; Rebuild Kits

|  |  |   |          |
|--|--|---|----------|
| 4  | GASKET KIT, for one carburettor                        | 2 | AUE812A  |
| <i>Includes items 37, 38, 60, 71-73, 94.</i> |  |   |          |
| 5  | SERVICE KIT, for pair of carburetters;                 |   |          |
|  | for AUD209 carburetters                                | 1 | WZX1855X |
|  | <i>Includes gasket kits, plus items 70, 82, 92.</i>    |   |          |
|  | for AUD284 carburetters                                | 1 | RF4191   |
|  | <i>Includes gasket kits, plus items 70, 82, 92.</i>    |   |          |
| 6  | REBUILD KIT, for pair of carburetters;                 |   |          |
|  | for AUD209 carburetters                                | 1 | CRK249   |
|  | <i>Includes service kit, plus items 109, 111, 122.</i> |   |          |
|  | for AUD284 carburetters                                | 1 | RF4192   |
|  | <i>Includes service kit, plus items 108, 112, 122.</i> |   |          |
| -  | DASHPOT OIL (25ml)                                     | 1 | BDR125   |

## Linkages

|    |  |   |         |
|----|--|---|---------|
| 7  | ROD AND LEVER ASSEMBLY,                            |   |         |
|    | throttle connecting                                | 1 | 145074  |
| 8  | ROD, throttle connecting                           | 1 | AUE668  |
| 9  | LEVER ASSEMBLY, throttle connecting                | 1 | AUE191  |
| 10 | LEVER, throttle rod;                               |   |         |
|    | to rear carburettor <i>(includes items 11-13)</i>  | 1 | AUE586  |
|    | to front carburettor <i>(includes items 11-13)</i> | 1 | AUE587  |
| 11 | BOLT   | 2 | AUC2694 |
| 12 | WASHER   | 2 | AUC8396 |
| 13 | NUT  | 2 | AJD8012 |
| 14 | ROD AND LEVER ASSEMBLY,                            |   |         |
|    | jet lever connecting <i>(includes items 15-16)</i> | 1 | 515222  |
| 15 | ROD, jet lever connecting                          | 1 | AUE668  |
| 16 | LEVER, jet rod;                                    |   |         |
|    | to rear carburettor <i>(includes items 17-19)</i>  | 1 | AUE586  |
|    | to front carburettor <i>(includes items 17-19)</i> | 1 | AUE587  |
| 17 | BOLT   | 2 | AUC2694 |
| 18 | WASHER   | 2 | AUC8396 |
| 19 | NUT  | 2 | AJD8012 |
| 20 | LINK ROD ASSEMBLY, short vertical                  | 1 | 148496  |
| 21 | LOCK NUT   | 2 | GHF200  |
| 22 | WASHER, locking, fitted on rods                    | 4 | GHF331  |
| 23 | NUT, short rod to throttle lever                   | 1 | GHF200  |
| 24 | BELLCRANK  | 1 | 148960  |
| 25 | BOLT, shouldered, bellcrank to bracket             | 1 | 136482  |
| 26 | WASHER, plain                                      | 1 | GHF301  |
| 27 | WASHER, locking                                    | 1 | GHF332  |
| 28 | NUT  | 1 | GHF201  |
| 29 | LINK ROD ASSEMBLY, long horizontal                 | 1 | 145077  |
| 30 | LOCK NUT   | 2 | GHF200  |
| 31 | BRACKET, supporting bellcrank                      | 1 | 218410  |
| 32 | SPRING, throttle return                            | 2 | 145197  |
| 33 | TRUNNION AND PIVOT ASS'Y,                          |   |         |
|    | choke cable clamping <i>(inc's items 34, 35)</i>   | 1 | AUE34   |
| 34 | TRUNNION AND PIVOT                                 | 1 | AUC5046 |
| 35 | SCREW  | 1 | AUC5047 |

## Carburettor Attachments

## STANDARD ATTACHMENTS

|    |                                    |   |        |
|----|------------------------------------|---|--------|
| 36 | INSULATING BLOCK,                  |   |        |
|    | carburettor to manifold            | 2 | 112866 |
| 37 | GASKET, carburettor to manifold    | 4 | 112867 |
| 38 | GASKET, air cleaner to carburettor | 2 | 112892 |
| 39 | STUD, carburettor to manifold      | 8 | 112907 |
| 40 | NUT, carburettor to manifold       | 8 | GHF201 |
| 41 | WASHER, locking                    | 8 | GHF332 |

## ADAPTOR PLATE KIT

The adaptor plate kit rubber mounts the carburetters to the engine, reducing frothing of fuel, poor float needle seating and therefore flooding because of vibration in the float chambers. The kit may also be used to fit later type HS6 carburetters if desired and includes adaptor plates, rubber mountings, bolts, gaskets and Studloc.

|    |                       |   |         |
|----|-----------------------|---|---------|
| 42 | ADAPTOR PLATE KIT,    |   |         |
|    | with rubber mountings | 1 | RW3042  |
| 43 | RUBBER MOUNTING ONLY  | 2 | TKC1338 |

## Carburettor Components

## BODY &amp; CHAMBER

|  |  |   |           |
|--|--|---|-----------|
| 44   | BODY ASSEMBLY;                                       |   |           |
|  | front carburettor                                    | 1 | AUC9330   |
|  | rear carburettor                                     | 1 | AUC9331   |
| 45   | LIFT PIN KIT (tickler pin)                           | 2 | WZX1112   |
| <i>AUD209 carbs. Includes items 46-50.</i> |  |   |           |
| 46   | PIN, piston lifting <i>(AUD209 carbs)</i>            | 2 | AUD2160   |
| 47   | WASHER, neoprene <i>(AUD209 carbs)</i>               | 2 | AUC4943   |
| 48   | SPRING, pin <i>(AUD209 carbs)</i>                    | 2 | AUC1152   |
| 49   | WASHER, brass <i>(AUD209 carbs)</i>                  | 2 | AUC4944   |
| 50   | RETAINER, pin <i>(AUD209 carbs)</i>                  | 2 | AUD4150   |
| 51   | LIFT PIN KIT (tickler pin)                           | 2 | WZX993    |
| <i>AUD284 carbs. Includes items 52-54.</i> |  |   |           |
| 52   | PIN, piston lifting <i>(AUD284 carbs)</i>            | 2 | WZX1105   |
| 53   | SPRING, pin <i>(AUD284 carbs)</i>                    | 2 | AUD1151   |
| 54   | RETAINER, pin <i>(AUD284 carbs)</i>                  | 2 | AUD4150   |
| 55   | CHAMBER & PISTON ASSEMBLY;                           |   |           |
|  | natural finish                                       | 2 | AUD9187   |
|  | <i>AUD209 carbs. Includes item 57.</i>               |   |           |
|  | alternative polished finish                          | 2 | AUD9187P  |
|  | <i>AUD209 carbs. Includes item 57.</i>               |   |           |
| 56   | CHAMBER & PISTON ASSEMBLY;                           |   |           |
|  | natural finish                                       | 2 | AUD9632   |
|  | <i>AUD284 carbs. Includes item 57.</i>               |   |           |
|  | alternative polished finish                          | 2 | AUD9632P  |
|  | <i>AUD284 carbs. Includes item 57.</i>               |   |           |
| 57   | SCREW, needle locking                                | 2 | AUC2057   |
| 58   | CAP & DAMPER ASSEMBLY;                               |   |           |
|  | plastic cap  | 2 | AUC8114A  |
|  | <i>AUD209 carbs. Original black plastic cap.</i>     |   |           |
|  | brass cap  | 2 | AUC8114HI |
|  | <i>AUD209 carbs. Alternative polished brass cap.</i> |   |           |
| 59   | CAP & DAMPER ASSEMBLY;                               |   |           |
|  | plastic cap  | 2 | GSU321    |
|  | <i>AUD284 carbs. Original black plastic cap.</i>     |   |           |
|  | brass cap  | 2 | GSU321HB  |
|  | <i>AUD284 carbs. Alternative polished brass cap.</i> |   |           |
| 60   | WASHER, fibre  | 2 | AUC4900A  |
| 61   | SPRING, piston return, red                           | 2 | AUC4387   |
| 62   | SCREW, chamber to body                               | 6 | JZX1394   |
| 63   | WASHER, locking                                      | 6 | WL105001  |

## JET, BEARING &amp; NEEDLE

|    |   |   |          |
|----|---|---|----------|
| 64 | JET BEARING KIT <i>(includes items 65-69)</i> | 2 | WZX1341  |
| 65 | BEARING, jet                                  | 2 | AUC8460  |
| 66 | WASHER, jet bearing                           | 2 | AUC8478  |
| 67 | NUT, bearing to body                          | 2 | AUC2002  |
| 68 | SPRING, jet locating                          | 2 | AUC2114  |
| 69 | NUT, mixture adjusting                        | 2 | AUC8461  |
| 70 | JET ASSEMBLY <i>(includes items 71-73);</i>   |   |          |
|    | front carburettor <i>(for AUD209 carbs)</i>   | 1 | AUD9148A |
|    | rear carburettor <i>(for AUD209 carbs)</i>    | 1 | AUD9149A |
|    | front carburettor <i>(for AUD284 carbs)</i>   | 1 | AUD9142A |
|    | rear carburettor <i>(for AUD284 carbs)</i>    | 1 | AUD9141A |
| 71 | WASHER, rubber,                               |   |          |
|    | jet tube to float chamber                     | 2 | AUD2194  |
| 72 | WASHER, metal,                                |   |          |
|    | jet tube to float chamber                     | 2 | AUD2193  |
| 73 | NUT, jet tube to float chamber                | 2 | AUD2129  |
| 74 | NEEDLE, jet;                                  |   |          |
|    | standard (TW) <i>(For AUD209 carbs)</i>       | 2 | AUD1362  |
|    | weak (C1W) <i>(For AUD209 carbs)</i>          | 2 | AUD1117  |
|    | rich (SW) <i>(For AUD209 carbs)</i>           | 2 | AUD1337  |
|    | standard (QW) <i>(For AUD209 carbs)</i>       | 2 | AUD1284  |

## LINKAGES

|    |  |   |         |
|----|--|---|---------|
| 75 | RETURN SPRING KIT;                               |   |         |
|    | front carburettor <i>(includes items 76, 77)</i> | 1 | WZX1335 |
|    | rear carburettor <i>(includes items 76, 77)</i>  | 1 | WZX1336 |
| 76 | SPRING, jet return;                              |   |         |
|    | front carburettor                                | 1 | AUC1375 |
|    | rear carburettor                                 | 1 | AUC8462 |
| 77 | SPRING, cam lever return;                        |   |         |
|    | front carburettor                                | 1 | AUD2432 |
|    | rear carburettor                                 | 1 | AUD2431 |
| 78 | LEVER AND LINK ASS'Y, choke operating;           |   |         |
|    | front carb.                                      | 1 | AUD9091 |
|    | rear carb.                                       | 1 | AUD9090 |

These are the original design lever and link assemblies, fixed by screws (no 90) to the jets. Ensure the same design is fitted to both carburetters (the set fast idle differs between the two designs of lever and link assembly).

|   |  |   |         |
|---|--|---|---------|
| 79  | LEVER AND LINK ASS'Y, <i>(includes items 81-83);</i> |   |         |
|   | choke operating, front carb.                         | 1 | WZX1352 |
|   | choke operating, rear carb.                          | 1 | WZX1353 |
| <i>These are the replacement design lever and link assemblies, fixed by starlock washers (no 89) to the jets. Ensure the same design is fitted to both carburetters (the set fast idle differs between the two designs of lever and link assembly).</i> |  |   |         |
| 80  | LEVER, jet pick up and choke operating;              |   |         |
|   | front carb   | 1 | AUD2388 |
|   | rear carb  | 1 | AUD2387 |
| 81  | LINK   | 2 | AUD2427 |
| 82  | WASHER, 'Starlock', securing link to jet             |   |         |
|   | and lever  | 4 | AUC5002 |
| <i>Use with replacement lever and link no. 79.</i>  |  |   |         |
| 83  | SCREW, lever to jet                                  | 2 | 515248  |
| <i>Use with original lever and link no. 78.</i>   |  |   |         |
| 84  | PIVOT BOLT KIT <i>(includes items 85-88)</i>         | 2 | WZX1331 |
| 85  | TUBE, for pivot bolt                                 | 2 | AUC8473 |
| 86  | WASHER, distance, on pivot bolt tube                 | 2 | AUC5032 |
| 87  | WASHER, locking                                      | 2 | AUD2076 |
| 88  | BOLT, pivot, pickup and cam levers                   |   |         |
|   | to body  | 2 | AUC1426 |
| 89  | LEVER, cam;  |   |         |
|   | front carburettor                                    | 1 | AUD2163 |
|   | rear carburettor                                     | 1 | AUD2164 |

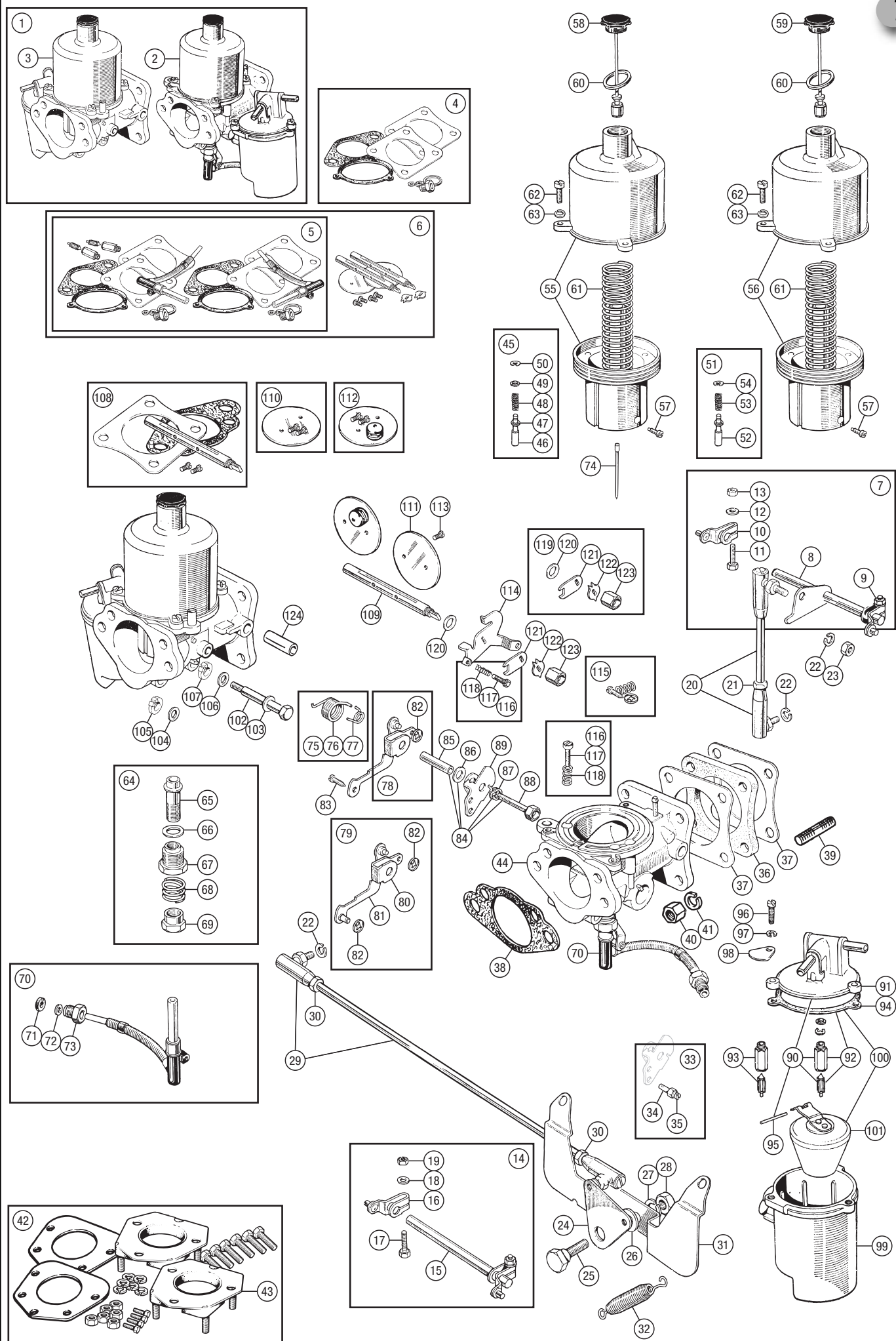
## FLOAT CHAMBERS

|   |  |   |          |
|---|--|---|----------|
| 90  | FLOAT LID ASSEMBLY;                                  |   |          |
|   | front carburettor <i>(includes items 91, 93, 95)</i> | 1 | AUE269   |
|   | rear carburettor <i>(includes items 91, 93, 95)</i>  | 1 | AUE272   |
| 91  | FLOAT LID;   |   |          |
|   | front carburettor                                    | 1 | AUC9255  |
|   | rear carburettor                                     | 1 | AUC9258  |
| 92  | NEEDLE & SEAT KIT <i>(includes items 93, 94)</i>     | 2 | WZX1101A |
| 93  | NEEDLE AND SEAT                                      | 2 | AUD9096  |
| 94  | GASKET, float chamber lid                            | 2 | AUC8459A |
| 95  | PIN, lever pivot                                     | 2 | AUC1152  |
| 96  | SCREW, retaining float lid                           | 6 | JZX1394  |
| 97  | WASHER, locking                                      | 6 | AUC1557  |
| 98  | IDENTIFICATION TAG (blank)                           | 2 | AUC1051  |
| 99  | CHAMBER, float                                       | 2 | AUC1310  |
| 100   | FLOAT & GASKET KIT <i>(includes items 94, 101)</i>   | 2 | WZX1300  |
| 101   | FLOAT  | 2 | AUD9202  |
| 102   | BOLT, float chamber to carb. body                    | 2 | 515242   |
| 103   | WASHER, plain  | 2 | 511744   |
| <i>The float chamber mounting varies, with a choice of rigid or flexible adaptor designs. Ensure both carburetters are fitted with the same design.</i> |  |   |          |
| 104   | WASHER, locking <i>(rigid mounting)</i>              | 2 | GHF331   |
| 105   | ADAPTOR, float chamber to body;                      |   |          |
|   | front carburettor <i>(rigid mounting)</i>            | 1 | AUD2072  |
|   | rear carburettor <i>(rigid mounting)</i>             | 1 | AUD2071  |
| 106   | WASHER, rubber <i>(rigid mounting)</i>               | 2 | AUC1318  |
| 107   | ADAPTOR, float chamber to body;                      |   |          |
|   | front carburettor <i>(flexible mounting)</i>         | 1 | AUD2676  |
|   | rear carburettor <i>(flexible mounting)</i>          | 1 | AUC1367  |

## THROTTLE SPINDLE

|   |                                 |   |         |
|---|---------------------------------|---|---------|
| 108   | THROTTLE SPINDLE KIT            | 2 | WZX1178 |
| <i>Includes items 37, 38, 109, 113.</i>           |                                 |   |         |
| 109   | SPINDLE, throttle               | 2 | AUC8494 |
| 110   | THROTTLE DISC KIT               | 2 | WZX1321 |
| <i>For AUD209 carbs; includes items 111, 113.</i> |                                 |   |         |
| 111   | DISC, throttle                  | 2 | AUC3280 |
| <i>For AUD209 carbs.</i>                          |                                 |   |         |
| 112   | THROTTLE DISC KIT               | 2 | WZX1326 |
| <i>For AUD284 carbs; includes item 113.</i>       |                                 |   |         |
| 113   | SCREW, throttle disc            | 4 | AUC1358 |
| 114   | LEVER, throttle;                |   |         |
|   | front carburettor               | 1 | AUC2787 |
|   | throttle, rear carburettor      | 1 | AUC2788 |
| 115   | SUNDRY PARTS KIT                | 2 | WZX1140 |
| <i>Includes items 82, 83, 113.</i>                |                                 |   |         |
| 116   | SLOW RUNNING SCREW KIT          | 4 | WZX981  |
| <i>Includes items 117, 118.</i>                   |                                 |   |         |
| 117   | SCREW, in spring                | 4 | AUC8483 |
| 118   | SPRING, slow running screw      | 4 | AUC2451 |
| 119   | LOST MOTION LEVER KIT           | 2 | WZX1130 |
| <i>Includes items 120-123.</i>                    |                                 |   |         |
| 120   | WASHER, brass, body to lever    | 2 | AUC2625 |
| 121   | LEVER, lost motion              | 2 | JZX1328 |
| 122   | WASHER, tab, locking nut        | 2 | AUC1206 |
| 123   | NUT, lost motion lever to shaft | 2 | AUC1424 |
| 124   | BUSH, throttle spindle to body  | 4 | AUD3080 |
| <i>To repair worn body; machine fit and ream.</i> |                                 |   |         |







| No. | DESCRIPTION | QTY REQ. | PART No. |
|-----|-------------|----------|----------|
|-----|-------------|----------|----------|

| No. | DESCRIPTION | QTY REQ. | PART No. |
|-----|-------------|----------|----------|
|-----|-------------|----------|----------|

| No. | DESCRIPTION | QTY REQ. | PART No. |
|-----|-------------|----------|----------|
|-----|-------------|----------|----------|

## TR4-4A

### Carburettor Assemblies

#### 175CD No. C1825; TR4

|   |   |   |           |
|---|---|---|-----------|
| 1 | PAIR OF CARBURETTERS, reconditioned, exchange | 1 | 209832-3R |
| 2 | CARBURETTOR ASSEMBLY, front                   | 1 | 209832    |
| 3 | CARBURETTOR ASSEMBLY, rear                    | 1 | 209833    |

#### 175CD No. 3043; Early TR4A

|   |   |   |         |
|---|---|---|---------|
| 1 | PAIR OF CARBURETTERS, reconditioned, exchange | 1 | RF4200R |
|---|---|---|---------|

#### 175CD No. 3069; Late TR4A

|   |   |   |           |
|---|---|---|-----------|
| 1 | PAIR OF CARBURETTERS, reconditioned, exchange | 1 | 212746-7R |
| 2 | CARBURETTOR ASSEMBLY, front                   | 1 | 212746    |
| 3 | CARBURETTOR ASSEMBLY, rear                    | 1 | 212747    |

### Service & Rebuild Kits

|   |  |   |        |
|---|--|---|--------|
| 4 | GASKET KIT, for one carburettor<br><i>Includes items 30, 31, 40, 51, 53, 60, 65, 67, 71, 76, 82, 83.</i> | 2 | RF4032 |
| 5 | SERVICE KIT, for pair of carburettors<br><i>Includes gasket kits, plus items 46, 63, 81.</i>             | 1 | CDSK15 |
| 6 | REBUILD KIT, for pair of carburettors<br><i>Includes service kit, plus items 92, 94, 95.</i>             | 1 | CDRK6  |
| - | DASHPOT OIL (25ml)   | 1 | BDR125 |

### Linkages

|    |   |   |          |
|----|---|---|----------|
| 7  | SHAFT AND COUPLING ASS'Y<br><i>Includes items 8, 9.</i> | 1 | 20151    |
| 8  | SHAFT, front to rear throttle spindles                  | 1 | 512336   |
| 9  | COUPLING ASSEMBLY<br><i>Includes items 10-13.</i>       | 2 | RTC169   |
| 10 | COUPLING  | 2 | AUC4334  |
| 11 | BOLT, coupling, 4BA                                     | 4 | AUC2669  |
| 12 | NUT, bolt clamping, 4BA                                 | 4 | AJD8014Z |
| 13 | WASHER, plain   | 4 | AUC4612  |
| 14 | LINK ROD ASSEMBLY, short vertical                       | 1 | 148496   |
| 15 | LOCK NUT  | 2 | GHF200   |
| 16 | NUT, rod to lever                                       | 4 | GHF200   |
| 17 | WASHER, locking   | 4 | GHF331   |
| 18 | BOLT, shouldered, bellcrank to manifold                 | 1 | 136482   |
| 19 | BELL CRANK LEVER ASSEMBLY                               | 1 | 136481   |
| 20 | WASHER, plain   | 1 | GHF301   |
| 21 | LINK ROD ASSEMBLY, long horizontal                      | 1 | 106764   |
| 22 | LOCK NUT  | 2 | GHF200   |
| 23 | SHAFT AND COUPLING ASS'Y<br><i>Includes item 24.</i>    | 1 | 512337   |
| 24 | COUPLING ASSEMBLY<br><i>Includes items 25-28.</i>       | 2 | RTC169   |
| 25 | COUPLING  | 2 | AUC4334  |
| 26 | BOLT, coupling, 4BA                                     | 4 | AUC2669  |
| 27 | NUT, bolt clamping, 4BA                                 | 4 | AJD8014Z |
| 28 | WASHER, plain   | 4 | AUC4612  |

### Carburettor Attachments

#### STANDARD ATTACHMENTS

|    |   |   |        |
|----|---|---|--------|
| 29 | INSULATING BLOCK, carburettor to manifold           | 2 | 112866 |
| 30 | GASKET, carburettor to manifold                     | 4 | 112867 |
| 31 | GASKET, air cleaner to carburettor; without air box | 2 | 112892 |
|    | with air box  | 6 | 112892 |
| 32 | STUD, carburettor to manifold                       | 8 | 112907 |
| 33 | NUT, carburettor to manifold                        | 8 | GHF201 |
| 34 | WASHER, locking                                     | 8 | GHF332 |

Applications with the optional airbox fitted require six of the 112892 gaskets. One is fitted either side of each air cleaner and another is required between the airbox and each carburettor.

#### ADAPTOR PLATE KIT

The adaptor plate kit rubber mounts the carburettors to the engine, reducing frothing of fuel, poor float needle seating and therefore flooding because of vibration in the float chambers. The kit may also be used to fit later type H56 carburettors if desired and includes adaptor plates, rubber mountings, bolts, gaskets and Studloc.

|    |  |   |         |
|----|--|---|---------|
| 35 | ADAPTOR PLATE KIT, with rubber mountings | 1 | RW3042  |
| 36 | RUBBER MOUNTING ONLY                     | 2 | TKC1338 |

### Carburettor Components

#### BODY & CHAMBER

|    |  |        |                  |
|----|--|--------|------------------|
| 37 | BODY ASSEMBLY; front carburettor<br><i>Includes items 38-41.</i>                             | 1      | 512322           |
|    | rear carburettor<br><i>Includes items 38-40, 42.</i>   | 1      | 512322           |
| 38 | PIN, piston lifting  | 2      | 512326           |
| 39 | SPRING, pin  | 2      | 512325           |
| 40 | RETAINER, pin  | 2      | 512324           |
| 41 | UNION, auto ignition vacuum, front carburettor   | 1      | 512328           |
| 42 | BLANKING CAP, vacuum union, rear carburettor   | 1      | P26              |
| 43 | CHAMBER COVER  | 2      | 512275           |
| 44 | PISTON AND DIAPHRAGM ASSEMBLY<br><i>Includes items 45-49.</i>                                | 2      | 512279           |
| 45 | PISTON   | 2      | 19590            |
| 46 | DIAPHRAGM  | 2      | 512278           |
| 47 | RING, retaining diaphragm  | 2      | 512277           |
| 48 | SCREW, ring and diaphragm to piston  | 8      | 517119           |
| 49 | SCREW, needle locking  | 2      | 605845           |
| 50 | CAP & DAMPER ASSEMBLY, plastic<br><i>Includes items 51-53.</i>                               | 2      | 518432A          |
| 51 | WASHER   | 2      | B17632Z          |
| 52 | BUSH   | 2      | 19640            |
| 53 | RETAINER   | 2      | 19641            |
| 54 | SPRING, piston return; natural (for carburettors C1825, 3043)<br>blue (for carburettor 3069) | 2<br>2 | 512321<br>515026 |
| 55 | WASHER, fibre  | 2      | 512320           |
| 56 | SCREW, cover to body   | 8      | 605847A          |

#### JET, BEARING & NEEDLE

|    |   |             |                            |
|----|---|-------------|----------------------------|
| 57 | JET BEARING KIT<br><i>Includes items 58-62.</i>   | 2           | RW3048                     |
| 58 | BEARING, jet orifice  | 2           | 512318                     |
| 59 | WASHER, jet bearing   | 2           | 512319                     |
| 60 | O' RING   | 2           | 512317                     |
| 61 | WASHER, for 'O' ring  | 2           | 512316                     |
| 62 | SPRING, jet locating  | 2           | 512315                     |
| 63 | JET, orifice  | 2           | 512313                     |
| 64 | SCREW, bush retaining   | 2           | 512312                     |
| 65 | O' RING   | 2           | 512311                     |
| 66 | SCREW, mixture adjusting  | 2           | 512307                     |
| 67 | O' RING   | 2           | 512308                     |
| 68 | NEEDLE, jet, standard; 2A (for carburettor C1825)<br>2E (for carburettor 3043)<br>2H (for carburettor 3069) | 2<br>2<br>2 | 512323<br>RF4033<br>514835 |

#### STARTER BAR (CHOKE)

|    |   |        |                  |
|----|---|--------|------------------|
| 69 | STARTER BAR ASS'Y, front carb.                                    | 1      | 512297           |
| 70 | STARTER BAR & PIN ASS'Y, rear carb.                               | 1      | 512329           |
| 71 | CIRCLIP, retaining starter bar                                    | 4      | 512298           |
| 72 | SPRING, starter bar return; front carburettor<br>rear carburettor | 1<br>1 | 512296<br>512330 |
| 73 | LEVER, loose, choke cable end stop, front carburettor             | 1      | 512295           |
| 74 | SPRING, return, loose lever, front carburettor                    | 1      | 512294           |
| 75 | LEVER, choke operating, front carb                                | 1      | 512293           |
| 76 | WASHER, shakeproof  | 1      | GHF332           |
| 77 | NUT, securing levers to front carb starter bar                    | 1      | 512292           |
| 78 | SCREW, choke wire clamping, front carburettor                     | 1      | 512314           |

#### FLOAT CHAMBERS

|    |   |    |            |
|----|---|----|------------|
| 79 | FLOAT CHAMBER                                       | 2  | 512303     |
| 80 | NEEDLE AND SEAT KIT<br><i>Includes items 81-83.</i> | 2  | RTC1482    |
| 81 | NEEDLE VALVE  | 2  | AAU4547    |
| 82 | WASHER, needle valve seating                        | 2  | 512301     |
| 83 | GASKET, float chamber lid                           | 2  | 512309     |
| 84 | PIN, float pivot                                    | 2  | 512299     |
| 85 | CLIP, pivot pin locating<br><i>If fitted.</i>       | 2  | 517001CLIP |
| 86 | FLOAT AND ARM ASSEMBLY                              | 2  | 605833A    |
| 87 | SCREW, retaining float chamber, short               | 6  | 605838     |
| 88 | SCREW, retaining float chamber, long                | 10 | 605837     |
| 89 | WASHER, plain                                       | 16 | 20102      |
| 90 | WASHER, locking                                     | 16 | 512304     |

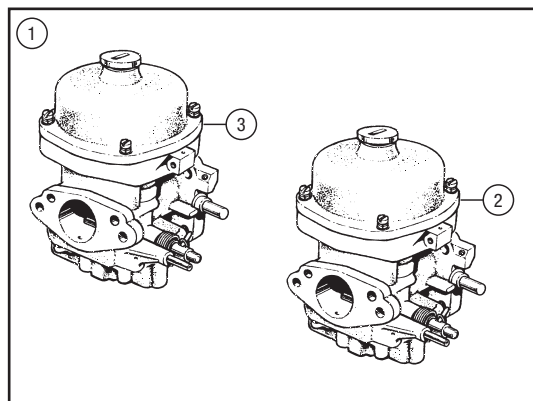
#### THROTTLE SPINDLE

|     |   |        |                  |
|-----|---|--------|------------------|
| 91  | THROTTLE SPINDLE KIT<br><i>Includes items 30, 31, 92, 95.</i>             | 2      | RW3049           |
| 92  | SPINDLE, throttle, original   | 2      | 512285           |
| 93  | THROTTLE DISC KIT<br><i>Includes items 94, 95.</i>                        | 2      | RW3050           |
| 94  | DISC, throttle  | 2      | 605800           |
| 95  | SCREW, throttle disc  | 4      | 605801           |
| 96  | LEVER, throttle stop and fast idle; front carburettor<br>rear carburettor | 1<br>1 | 512289<br>512332 |
| 97  | LEVER, throttle, front carburettor  | 1      | 512290           |
| 98  | SPACER, replacing throttle lever, rear carburettor                        | 1      | 512333           |
| 99  | FAST IDLE SCREW KIT<br><i>Includes items 100, 101.</i>                    | 1      | RW3051           |
| 100 | SCREW, fast idle  | 1      | 512288           |
| 101 | NUT, locking screw  | 1      | 512287           |
| 102 | SPRING, return, throttle spindle; front carburettor<br>rear carburettor   | 1<br>1 | 512286<br>512321 |
| 103 | WASHER, shakeproof  | 2      | GHF332           |
| 104 | NUT, retaining levers to spindle  | 2      | 512292           |
| 105 | SCREW, slow running   | 2      | 512314           |
| 106 | SPRING, slow running screw  | 2      | 512282           |

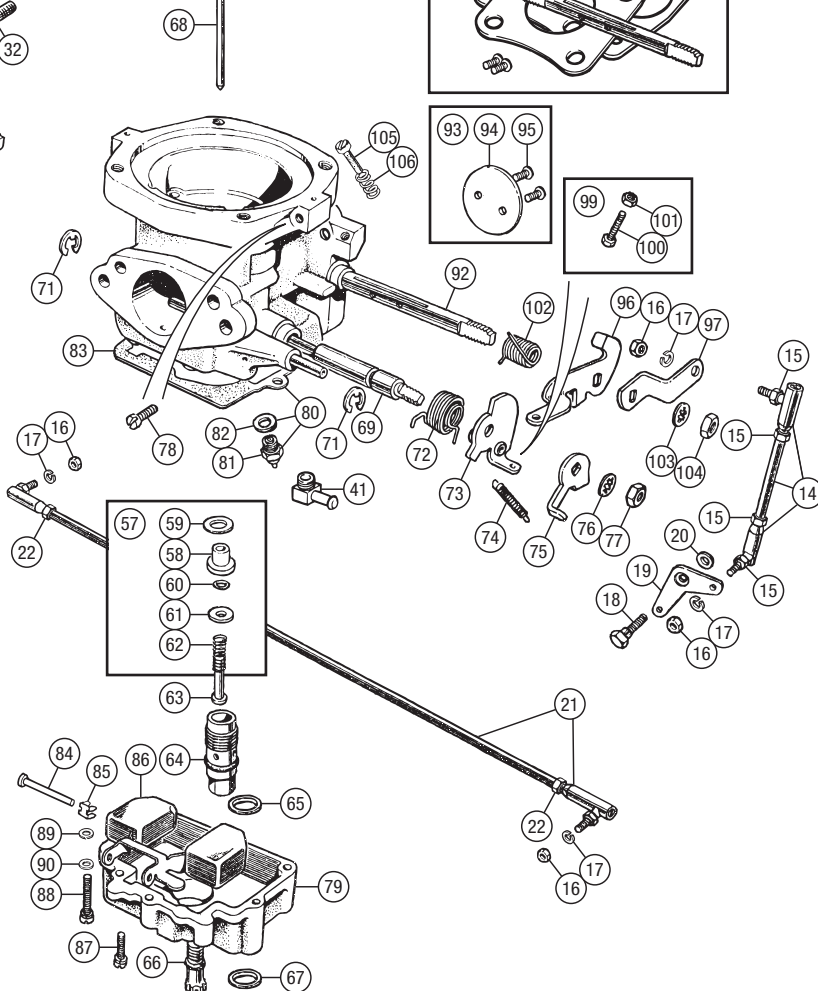
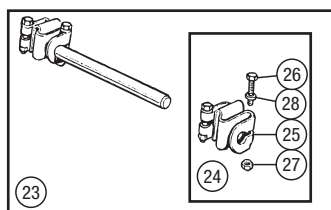
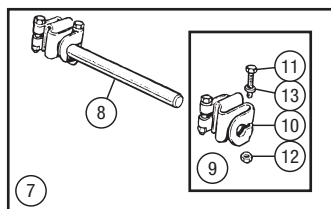
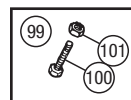
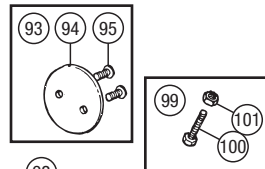
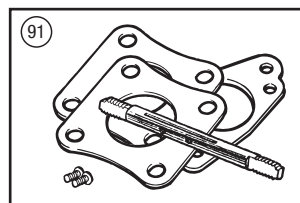
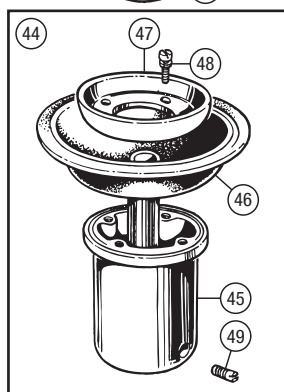
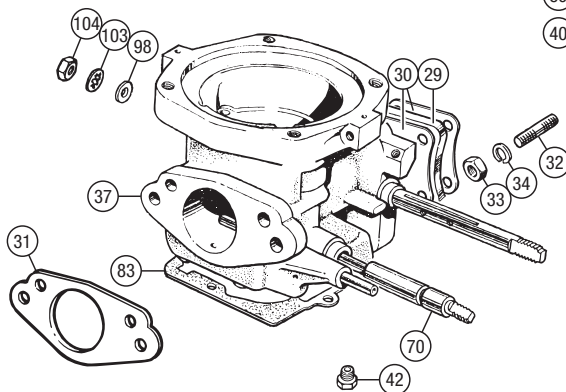
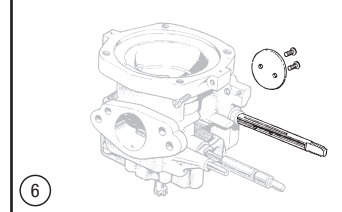
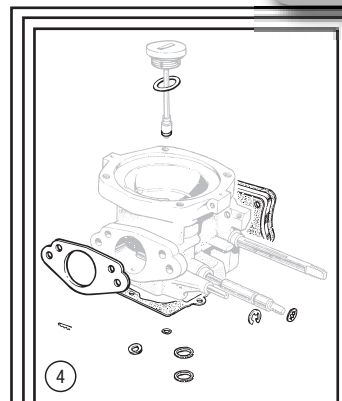
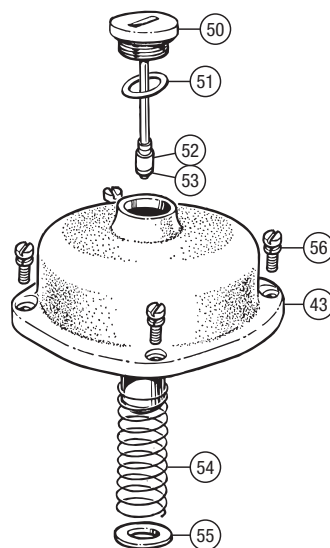
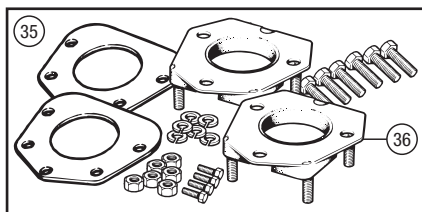


CARBURETTOR REBUILD KIT  
- CD RK6





THROTTLE SPINDLE KIT - RW3049

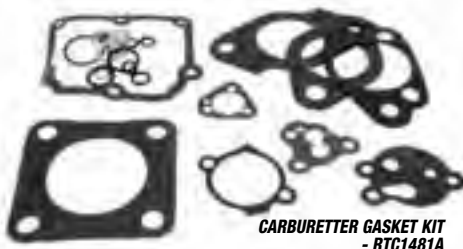




| No. | DESCRIPTION | QTY REQ. | PART No. |
|-----|-------------|----------|----------|
|-----|-------------|----------|----------|

**TR250****Carburettor Assemblies**

|   |   |   |           |
|---|---|---|-----------|
| 1 | PAIR OF CARBURETTORS, reconditioned, exchange | 1 | 308376-7R |
| 2 | CARBURETTOR ASSEMBLY, front                   | 1 | 308377    |
| 3 | CARBURETTOR ASSEMBLY, rear                    | 1 | 308376    |

**Service & Rebuild Kits**

|   |   |   |          |
|---|---|---|----------|
| 4 | GASKET KIT, for one carburettor<br><i>Includes items 32, 33, 43, 54, 59, 66, 67, 87, 88, 95, 104.</i> | 2 | RTC1481A |
| 5 | SERVICE KIT, for one carburettor<br><i>Includes gasket kit, plus items 46, 58, 86.</i>                | 2 | AAU7222  |
| 6 | REBUILD KIT, for two carburettors<br><i>Includes service kits, plus items 94, 97, 98.</i>             | 1 | CDRK16   |
| - | DASHPOT OIL (25ml)  | 1 | BDR125   |

**Linkages**

|    |   |   |          |
|----|---|---|----------|
| 7  | SHAFT ASS'Y, connects front to rear throttle spindles               | 1 | 517006   |
| 8  | COUPLING ASSEMBLY<br><i>Includes items 9-12.</i>                    | 2 | RTC169   |
| 9  | COUPLING  | 2 | AUC4334  |
| 10 | BOLT, coupling, 4BA   | 4 | AUC2669  |
| 11 | NUT, bolt clamping, 4BA   | 4 | AJD8014Z |
| 12 | WASHER, plain   | 4 | AUC4612  |
| 13 | LINK ROD ASSEMBLY, short vertical                                   | 1 | 148496   |
| 14 | LOCK NUT  | 2 | GHF200   |
| 15 | NUT, rod to lever   | 1 | GHF200   |
| 16 | WASHER, locking   | 2 | GHF331   |
| 17 | BELL CRANK LEVER ASSEMBLY   | 1 | 148960   |
| 18 | BOLT, shouldered, bell crank to support bracket                     | 1 | 136482   |
| 19 | WASHER, plain   | 1 | GHF301   |
| 20 | WASHER, locking   | 1 | GHF332   |
| 21 | NUT   | 1 | GHF201   |
| 22 | SUPPORT BRACKET, bell crank lever                                   | 1 | 214407   |
| 23 | STOP, throttle, adjustable  | 1 | 148972   |
| 24 | WASHER, locking   | 1 | 518103   |
| 25 | NUT   | 1 | 519989   |
| 26 | LINK ROD ASSEMBLY, long horizontal<br><i>Includes items 27, 28.</i> | 1 | 148497   |
| 27 | SPRING, link rod  | 1 | 131368   |
| 28 | LOCK NUT  | 1 | GHF200   |
| 29 | WASHER, locking   | 1 | WL105001 |
| 30 | CLIP, link rod to control lever on pedal shaft                      | 1 | 606698   |

| No. | DESCRIPTION | QTY REQ. | PART No. |
|-----|-------------|----------|----------|
|-----|-------------|----------|----------|

**Carburettor Attachments**

|    |  |   |          |
|----|--|---|----------|
| 31 | INSULATING BLOCK, carburettor to manifold  | 2 | 148036   |
| 32 | GASKET, carburettor to manifold            | 4 | 148035   |
| 33 | GASKET, air cleaner to carburettor         | 2 | 148007   |
| 34 | STUD, carburettor to inlet manifold, long  | 2 | 112907   |
| 35 | STUD, carburettor to inlet manifold, short | 6 | TE605141 |
| 36 | NUT, carburettor to manifold, steel        | 8 | GHF201   |
| 37 | WASHER, locking                            | 8 | GHF332   |

**Carburettor Components****BODY & CHAMBER**

|    |   |   |           |
|----|---|---|-----------|
| 38 | UNION, auto ignition vacuum, front carburettor        | 1 | 516993    |
| 39 | BYPASS VALVE ASSEMBLY                                 | 2 | 517002    |
| 40 | SCREW, bypass valve                                   | 2 | 516969    |
|    | DIAPHRAGM KIT, bypass valve                           | 2 | ZEB18844P |
| 41 | SCREW, bypass valve to carburettor                    | 6 | 605838    |
| 42 | WASHER, locking                                       | 6 | 514980    |
| 43 | GASKET, bypass valve                                  | 2 | 516967    |
| 44 | SCREW, idler trimming                                 | 2 | 516975    |
| 45 | SPRING, idler trimming screw                          | 2 | 516976    |
| 46 | DIAPHRAGM   | 2 | JS499A    |
| 47 | RING, retaining diaphragm                             | 2 | RTC164    |
| 48 | SCREW, ring and diaphragm to piston                   | 8 | 517119    |
| 49 | SCREW, needle locking                                 | 2 | 605845    |
| 50 | CAP & DAMPER ASSEMBLY<br><i>Includes items 51-53.</i> | 2 | 518432A   |
| 51 | WASHER  | 2 | B17632Z   |
| 52 | BUSH  | 2 | 19640     |
| 53 | RETAINER  | 2 | 19641     |
| 54 | WASHER, fibre   | 2 | 520962    |
| 55 | SPRING, piston return                                 | 2 | 516946A   |
| 56 | SCREW, cover to body                                  | 8 | 605847A   |

**JET & NEEDLE**

|    |   |   |        |
|----|---|---|--------|
| 57 | PLUG, JET AND 'O' RING KIT<br><i>Includes items 58, 59.</i> | 2 | 516979 |
| 58 | JET, orifice  | 2 | RR1350 |
| 59 | O' RING   | 2 | RTC165 |
| 60 | NEEDLE, jet (B2Y)   | 2 | 516944 |

**TEMPERATURE COMPENSATOR**

|    |                                      |   |        |
|----|--------------------------------------|---|--------|
| 61 | TEMPERATURE COMPENSATOR              | 2 | 12849  |
| 62 | SCREW, compensator to carburettor    | 4 | 516973 |
| 63 | WASHER, shakeproof                   | 4 | 516974 |
| 64 | COVER, temperature compensator       | 2 | 516968 |
| 65 | SCREW, cover to compensator          | 4 | 516969 |
| 66 | SEAL, small, carburettor body        | 2 | 516972 |
| 67 | SEAL, large, temperature compensator | 2 | 516971 |

| No. | DESCRIPTION | QTY REQ. | PART No. |
|-----|-------------|----------|----------|
|-----|-------------|----------|----------|

**STARTER BOX (CHOKE)**

|    |   |   |            |
|----|---|---|------------|
| 68 | STARTER BOX ASSEMBLY<br><i>Includes items 69-78.</i>  | 2 | RTC1279    |
| 69 | NUT, starter spindle                                  | 2 | 513687     |
| 70 | CAM LEVER   | 2 | 516999     |
| 71 | WASHER, spacing                                       | 2 | 517000     |
| 72 | WASHER, shakeproof                                    | 2 | GHF321     |
| 73 | SCREW, swivel   | 2 | 513723     |
| 74 | SPRING, return  | 2 | 516957     |
| 75 | COVER, starter box                                    | 2 | 516998     |
| 76 | SPRING, starter                                       | 2 | 516955     |
| 77 | STARTER SPINDLE ASSEMBLY                              | 2 | 516954     |
| 78 | C' WASHER, spindle                                    | 2 | 516956     |
| 79 | SCREW, starter box to carburettor                     | 4 | 516960     |
| 80 | WASHER, shakeproof                                    | 4 | 516961     |
| 81 | BRACKET, choke cable<br><i>Includes items 82, 83.</i> | 2 | 517001     |
| 82 | CLIP, choke cable clamping                            | 2 | 517001CLIP |
| 83 | SCREW, bracket securing                               | 2 | 516963     |

**FLOAT CHAMBERS**

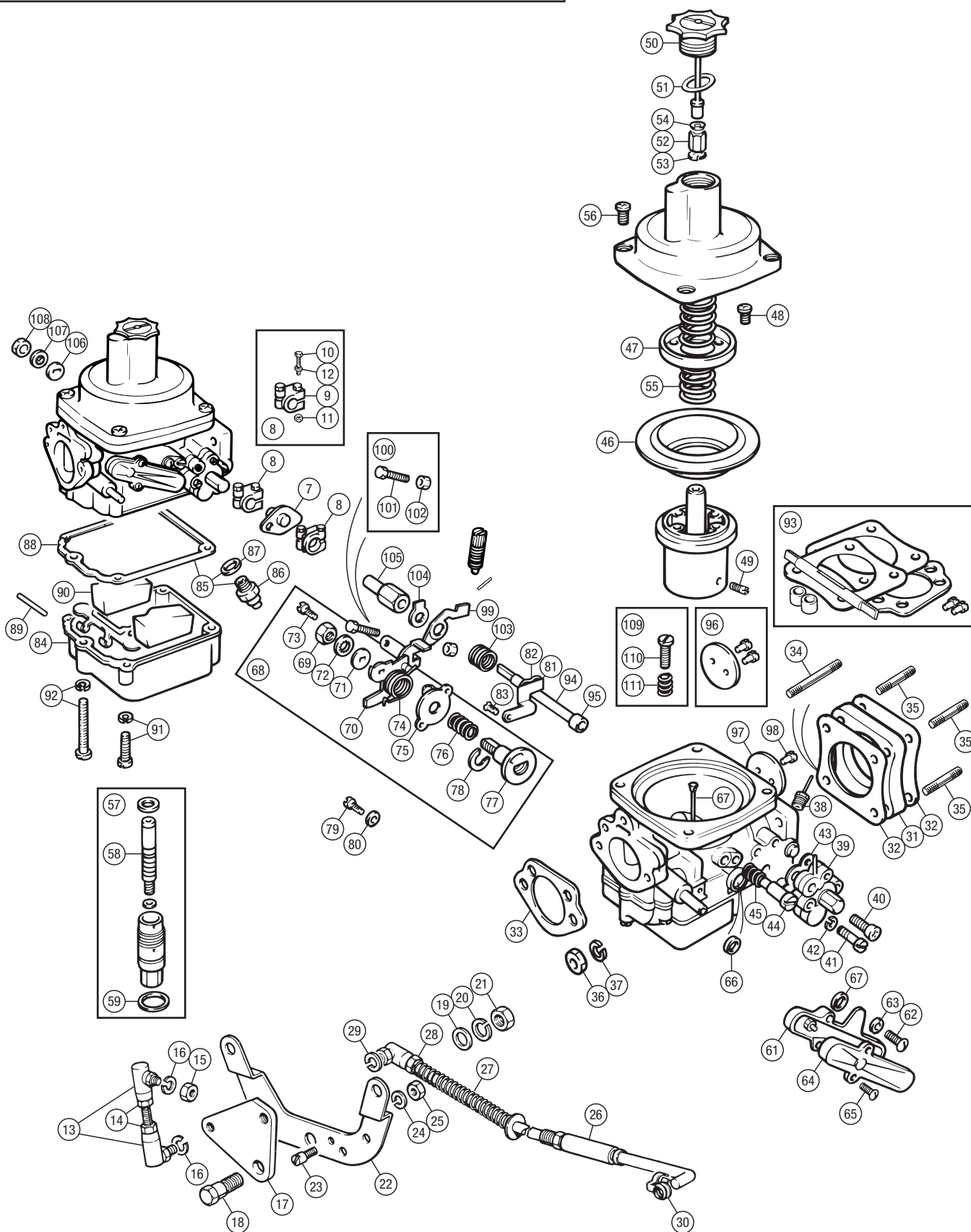
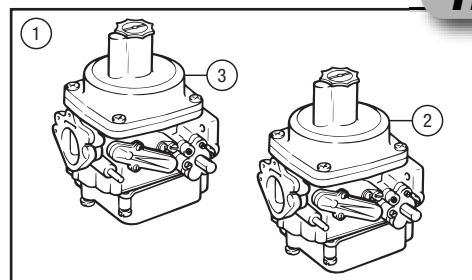
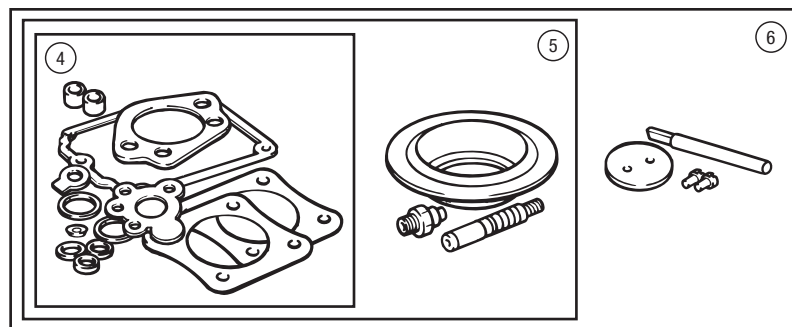
|    |   |   |         |
|----|---|---|---------|
| 84 | FLOAT CHAMBER                                       | 2 | 605836  |
| 85 | NEEDLE AND SEAT KIT<br><i>Includes items 86-88.</i> | 2 | RTC1482 |
| 86 | NEEDLE VALVE  | 2 | AAU4547 |
| 87 | WASHER, needle valve seating                        | 2 | 516005  |
| 88 | GASKET, float chamber lid                           | 2 | 512309  |
| 89 | PIN, float pivot                                    | 2 | 606819A |
| 90 | FLOAT AND ARM ASSEMBLY                              | 2 | 605833A |
| 91 | SCREW AND WASHER, float chamber, short              | 6 | 605838  |
| 92 | SCREW AND WASHER, float chamber, long               | 6 | 605837  |

**THROTTLE DISC KIT - RW3050****THROTTLE SPINDLE**

|     |  |   |         |
|-----|--|---|---------|
| 93  | THROTTLE SPINDLE KIT; front carburettor<br><i>Includes items 32, 33, 94, 95, 98.</i> | 1 | RW3052  |
|     | rear carburettor<br><i>Includes items 32, 33, 94, 95, 98.</i>                        | 1 | RW3053  |
| 94  | SPINDLE, throttle; front carburettor   | 1 | 512285  |
|     | rear carburettor   | 1 | 517005  |
| 95  | SEAL, throttle spindle   | 4 | 517003  |
| 96  | THROTTLE DISC KIT<br><i>Includes items 97, 98.</i>                                   | 2 | RW3050  |
| 97  | DISC, throttle   | 2 | 605800  |
| 98  | SCREW, throttle disc   | 4 | 605801  |
| 99  | LEVER, throttle stop and fast idle   | 2 | 516995  |
| 100 | FAST IDLE SCREW KIT<br><i>Includes items 101, 102.</i>                               | 1 | RW3054  |
| 101 | SCREW, fast idle   | 1 | 516965  |
| 102 | NUT, locking screw   | 1 | 512287  |
| 103 | SPRING, return, throttle spindle   | 2 | 516951A |
| 104 | LOCK TAB, front carburettor  | 1 | RTC162  |
| 105 | NUT, extension, front carburettor  | 1 | 516997  |
| 106 | WASHER, spacing, rear carburettor  | 2 | 512333  |
| 107 | WASHER, shakeproof, rear carburettor   | 1 | GHF322  |
| 108 | NUT, rear carburettor  | 1 | 512292  |
| 109 | SLOW RUNNING SCREW KIT<br><i>Includes items 110, 111.</i>                            | 2 | RW3055  |
| 110 | SCREW, in spring   | 2 | 512281  |
| 111 | SPRING, slow running screw   | 2 | 512282  |









# TR5

## Metering Units

Much has been written about the benefits and failings of the petrol injection system made by Lucas that was fitted to Triumph TR5 and TR6 models. Few spares to assist the home repairer are available. The only major option is an exchange rebuilt unit, in the event of your own going wrong through normal wear and tear or internal failure. Units returned for exchange must be complete and serviceable or a surcharge will be levied until an acceptable item is received (see illustration on opposite page for acceptable condition). A standard metering unit is not suitable for unleaded fuel. All metering units supplied by Rimmer Bros are suitable for use with unleaded or leaded fuel. Notice that we also list two TR6-type metering units for use on TR5s. This is because some TR5s have been modified over the years to incorporate the air bleed tick-over system found originally on TR6s; the two TR6 units listed allow for the choice of either the push on fuel return tube or the screw on type.

### This is the history:

#### METERING UNIT;

with push on fuel return tube and without air bleed tick-over control valve

|                                   |   |          |
|-----------------------------------|---|----------|
| TR5                               | 1 | (308205) |
| TR6 to engine no. CP52533         | 1 | (309154) |
| TR6 engine no. CP52534 to CP53160 | 1 | (312070) |
| TR6 engine no. CP53161 to CP75314 | 1 | (312097) |

with screwed fuel return tube and with air bleed tick-over control valve.

|  |   |          |
|--|---|----------|
| TR6 engine no. CP 75315 to CR1                     | 1 | (312529) |
| TR6 from engine no. CR1                            | 1 | (RKC94)  |
| Control cap sometimes green.                       |   |          |
| TR6 from engine no. CR1                            | 1 | (RKC95)  |
| For high altitudes                                 |   |          |
| Identifiable by the double sided control assembly. |   |          |

How the world understands and sells it for the TR5:

#### 1 METERING UNIT;

with push on fuel return tube and without air bleed tick-over control valve, exchange

|                   |   |         |
|-------------------|---|---------|
| TR5 original item | 1 | 308205R |
|-------------------|---|---------|

with push on fuel return tube and with air bleed tick-over control valve, exchange

|  |   |         |
|--|---|---------|
| TR5 modified to have air bleed tick-over | 1 | 309154R |
|--|---|---------|

with screw on fuel return tube and with air bleed tick-over control valve, exchange

|  |   |         |
|--|---|---------|
| TR5 modified to have air bleed tick-over | 1 | 312529R |
|--|---|---------|

The changing of engine components such as the camshaft or exhaust system may alter the fuelling requirements of an engine. The metering units listed above are for use on standard specification engines.

|  |   |            |
|--|---|------------|
| - SEAL/DIAPHRAGM, distributor control    | 1 | 519870     |
| Not illustrated.                         |   |            |
| 2 UNION, push-on                         | 1 | RR1384     |
| 3 UNION, screw-on                        | 1 | RR1385     |
| 4 WASHER, outlet sealing                 | 4 | 518495     |
| 5 WASHER, inlet sealing                  | 1 | 152068     |
| 6 STRAINER                               | 1 | 152069     |
| 7 PLASTIC DRIVE, for metering unit       | 1 | 149595     |
| 8 UNION SET, metering unit               | 1 | RR1297     |
| 9 SEAL SET, installation, metering unit  | 1 | 516917     |
| 10 'O' RING, metering unit housing       | 1 | 149486     |
| 11 'O' RING, banjos                      | 4 | 159386     |
| 12 BANJO BOLT                            | 2 | 518630     |
| Outlets nos. 2 and 5.                    |   |            |
| 13 CLIP, choke cable to metering unit    | 1 | 517001CLIP |
| 14 CLAMP ASSEMBLY, choke cable           | 1 | AUE34      |
| Includes items 15, 16.                   |   |            |
| 15 TRUNNION, cable clamping              | 1 | 150342     |
| 16 SCREW, cable clamping                 | 1 | 53K3503    |
| 17 SCREW, metering unit to drive housing | 3 | SH604071   |
| 18 WASHER, locking                       | 3 | GHF331     |
| 19 WASHER, plain                         | 3 | WC701121   |
| 20 ELBOW, rubber                         | 1 | 148946     |
| 21 HOSE, vacuum                          | 1 | 149609     |
| 22 CLIP, hose attachment                 | 1 | PCR1011    |

## Injectors

There are three different types of injectors and one of these is not serviceable (see illustration opposite). If you find yourself in possession of the type that cannot be reconditioned please try to obtain one which can be for exchange purposes. The two serviceable types are identifiable by a wire 'c' clip fitted to the nozzle end of the injector. The non-serviceable type has the nozzle end held into the body by crimping. All injectors, after installation need to be 'bled' to expel any air from them. This will ensure that they work satisfactorily. If any of the fuel lines to the injectors is disconnected, they too will need 'bleeding' to purge them of air. If your engine starts on less than 6 cylinders, the fault may be traced to either numbers 2 or 5 fuel injector. Often the mistfiring of one of these two cylinders is caused by a faulty banjo bolt part number 518630, not a failed injector. Substitution of another injector that is known to be working will pin-point these banjo bolts, that include a non return valve, to be at fault.

|   |   |          |
|---|---|----------|
| 23 INJECTOR, (see illustration opposite); |   |          |
| new                                       | 6 | 157913   |
| reconditioned exchange                    | 6 | 157913R  |
| 24 ADAPTOR, nylon, injector to manifold;  |   |          |
| push fitting                              | 6 | 516922   |
| screw fitting                             | 6 | 516922S  |
| 25 'O' RING, adaptor block to manifold    | 6 | TRS1114  |
| 26 PLATE, clamping injectors;             |   |          |
| original                                  | 3 | 149308   |
| stainless steel (alternative)             | 3 | 149308SS |
| 27 SCREW, clamping plate to manifold      | 3 | SH605041 |
| 28 WASHER, locking                        | 3 | GHF332   |



STAINLESS BRAIDED  
INJECTOR PIPE ASSEMBLY KIT -  
RR1169BRAIDED

## Injector Pipes

Always replace the banjo bolt 'O' rings (ill. no. 11) when fitting new injector pipes.

|                                       |   |               |
|---------------------------------------|---|---------------|
| 29 INJECTOR PIPE ASSEMBLY KIT,        |   |               |
| set of 6 pipes - black nylon          | 1 | RR1169        |
| See also (47) braided pipe kit        |   |               |
| INJECTOR PIPE ASSEMBLY, no. 1         | 1 | UKC351        |
| 30 TUBE, black nylon, 30 1/4"         | 1 | Refer Assy    |
| 31 ELBOW, to injector                 | 1 | 517307        |
| 32 NIPPLE & NUT, to metering unit     | 1 | 517306        |
| INJECTOR PIPE ASSEMBLY, no. 2         | 1 | UKC361        |
| 33 TUBE, black nylon, 31"             | 1 | Refer Assy    |
| 34 ELBOW, to injector                 | 1 | 517307        |
| 35 BANJO, to metering unit            | 1 | 517308        |
| INJECTOR PIPE ASSEMBLY, no. 3         | 1 | UKC371        |
| 36 TUBE, black nylon, 30"             | 1 | Refer Assy    |
| 37 ELBOW, to injector & metering unit | 2 | 517307        |
| INJECTOR PIPE ASSEMBLY, no. 4         | 1 | UKC372        |
| 38 TUBE, black nylon, 39 1/8"         | 1 | Refer Assy    |
| 39 ELBOW, to injector & metering unit | 2 | 517307        |
| INJECTOR PIPE ASSEMBLY, no. 5         | 1 | UKC362        |
| 40 TUBE, black nylon, 21 1/4"         | 1 | Refer Assy    |
| 41 ELBOW, to injector                 | 1 | 517307        |
| 42 BANJO, to metering unit            | 1 | 517308        |
| INJECTOR PIPE ASSEMBLY, no. 6         | 1 | UKC352        |
| 43 TUBE, black nylon, 20 1/4"         | 1 | Refer Assy    |
| 44 ELBOW, to injector                 | 1 | 517307        |
| 45 NIPPLE & NUT, to metering unit     | 1 | 517306        |
| 46 CLIP, strapping pipes              | 3 | 145891        |
| 47 INJECTOR PIPE ASSEMBLY KIT,        |   |               |
| set of 6 pipes, stainless, braided    | 1 | RR1169BRAIDED |

## Pressure Relief Valves

All units are calibrated to give 105-110 p.s.i., which is the correct working fuel pressure for these Lucas injection systems. TR5 and early TR6 models had a short (3/8 in.) valve. Later TR6's had a longer (1 1/4 in.) valve. They are interchangeable. The design change was adopted to help to stop valve body distortion and subsequent relief valve pressure fluctuations. For information on setting the pressure relief valve, please refer to the workshop manual.

### TR5 ORIGINAL ITEM

|                                  |   |         |
|----------------------------------|---|---------|
| 48 RELIEF VALVE & STRAINER ASS'Y | 1 | 152066  |
| 49 STRAINER                      | 1 | 152069  |
| 50 RELIEF VALVE, short bodied;   |   |         |
| new                              | 1 | 149811  |
| reconditioned exchange           | 1 | 149811R |
| 51 DOWTY WASHER, relief valve    | 1 | 152068  |

### LATER TR6 ALTERNATIVE

|                                  |   |         |
|----------------------------------|---|---------|
| 52 RELIEF VALVE & STRAINER ASS'Y | 1 | 156160  |
| 53 STRAINER                      | 1 | 152069  |
| 54 RELIEF VALVE, long bodied;    |   |         |
| new                              | 1 | 156167  |
| reconditioned exchange           | 1 | 156167R |
| 55 DOWTY WASHER, relief valve    | 1 | 152068  |

|   |   |          |
|---|---|----------|
| 56 'T' PIECE, PRV mounting                  | 1 | 149773   |
| 57 DOWTY WASHER (relief valve to 'T' piece) | 1 | 152068   |
| 58 MOUNTING, flexible                       | 4 | UKC2451  |
| 59 WASHER, plain                            | 4 | WC701121 |
| 60 WASHER, locking                          | 4 | GHF331   |
| 61 NUT, plain                               | 4 | GHF200   |

## Fuel Pumps

### LUCAS FUEL PUMP

This unit was not a wonderfully designed piece of engineering. It is based on a windscreen wiper motor and is required to operate continuously at a much higher speed. The increase raises its running temperature to a point where, in high ambient temperatures it is likely to vaporise the fuel as it enters the pump housing. The incoming fuel then takes on the role of a coolant for the pump. If the fuel temperature is raised too high it will vaporise. The pump has no resistance when pumping fuel so the motor overspeeds; this is the wailing tone the pump makes as the engine stops working. Keeping the pump cool and subsequently the fuel within it, is of primary importance. The solution is a cooling coil that fits around the fuel pump motor. It carries diverted split fuel from the pressure relief valve around the pump motor before returning it to the fuel tank. The fitment of a fuel pump cooling coil is strongly recommended. The Lucas pump is not compatible with unleaded fuels and must be run with a suitable fuel additive. Should Lucas pumps become available suitable for unleaded fuel, refer to web site (or our sales office) and suffixed part number.

An alternative to the Lucas pump / cooling coil combination is the Bosch type replacement pump. This is of more modern design and extremely reliable if installed correctly (it's also a lot quieter and compatible with unleaded fuels). See below for further details.

|   |   |            |
|---|---|------------|
| 62 FUEL PUMP (Lucas);                   |   |            |
| new                                     | 1 | 214347     |
| reconditioned exchange                  | 1 | 214347R    |
| 63 PUMP REPAIR KIT                      | 1 | 214347RKIT |
| Inc. brushes, springs and seals.        |   |            |
| 64 'O' RING, sealing pump to motor body | 1 | 517413     |
| 65 SEAL, drive shaft                    | 1 | 517419     |
| 66 BRUSH & SPRING SET                   | 1 | 517416     |
| 67 BRUSH GEAR                           | 1 | 517644     |
| 68 UNION, outlet and inlet              | 2 | 518632     |
| 69 WASHER, sealing                      | 2 | 518495     |
| 70 MOUNTING, flexible                   | 3 | UKC2451    |
| 71 WASHER, plain                        | 3 | WC701121   |
| 72 WASHER, locking                      | 3 | GHF331     |
| 73 NUT, plain                           | 3 | GHF200     |
| 74 COOLING COIL, fuel pump              | 1 | RR1135     |

### BOSCH REPLACEMENT FUEL PUMP

The Bosch pump is an ideal replacement for the notoriously unreliable Lucas unit. It is installed in the same position and can be easily piped in and wired following the instructions supplied. The quiet operation and suitability for both leaded and unleaded fuel make it an ideal choice for any P.I.

Remember that 100P.S.I. pressure is required from the fuel pump - ensure that air is expelled from the fuel filter when fitting. Also, note that because the pump to P.R.V. hose is not rigid, it can cause some noise which is often misdiagnosed as a problem with the Bosch fuel pump.

|                                       |   |             |
|---------------------------------------|---|-------------|
| 75 BOSCH FUEL PUMP KIT                | 1 | 214347BOSCH |
| 76 FITTING KIT, Bosch fuel pump (TR5) | 1 | 214347BFK   |

## Fuel Filter

|   |   |         |
|---|---|---------|
| 77 BOWL ASSEMBLY, fuel filter             | 1 | 215299  |
| 78 FUEL FILTER ELEMENT                    | 1 | GFE5296 |
| 79 'O' RING, sealing element bolt         | 2 | 512147  |
| 80 WASHER, sealing element retaining bolt | 1 | 522940A |
| 81 CONNECTION ADAPTOR, vent pipe          | 1 | 148312  |
| 82 WASHER, sealing adaptor to filter head | 1 | 150710  |
| 83 PLUG, screwed, blanking                | 2 | 151203  |
| 84 WASHER, copper, sealing plug           | 2 | 506682  |
| 85 SCREW, filter assembly                 | 2 | GHF105  |
| 86 WASHER, plain                          | 2 | WP9     |
| 87 WASHER, locking                        | 2 | GHF333  |
| 88 NUT, plain                             | 2 | GHF202  |

For pipe work and other fuel system parts see 'Fuel System - TR5'.



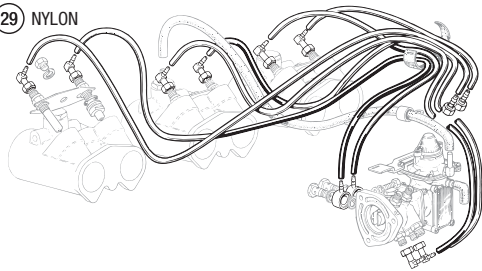
FUEL FILTER  
BOWL ASSEMBLY - 215299



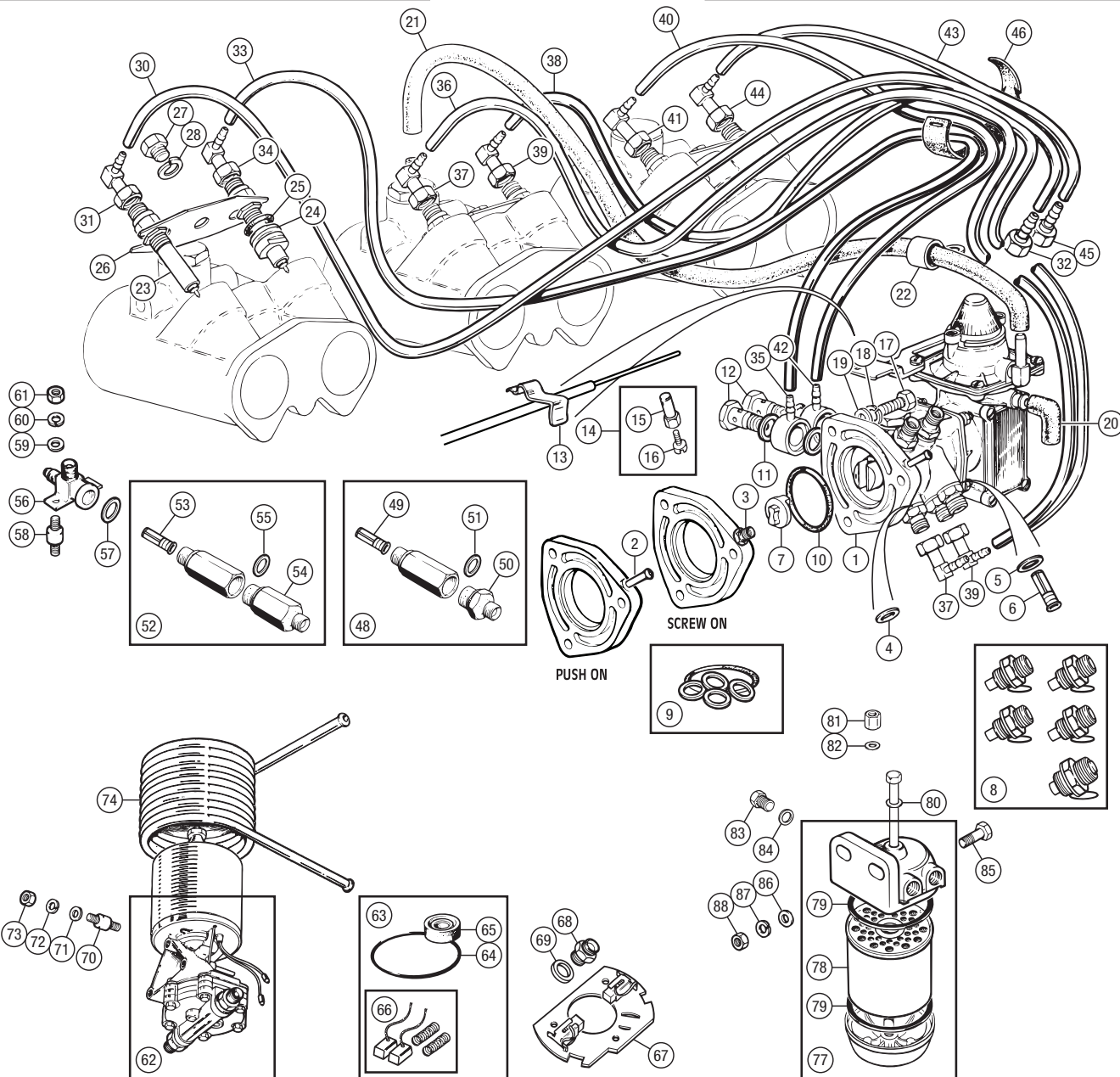
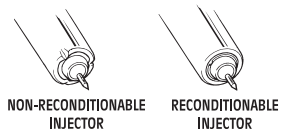
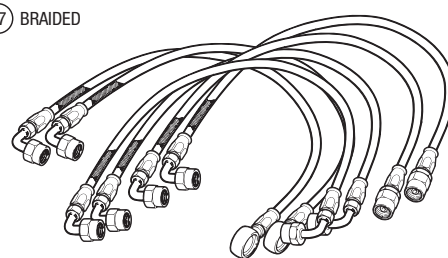
FUEL FILTER  
ELEMENT -  
GFE5296



29 NYLON



47 BRAIDED

**EXCHANGE METERING UNIT**

ACCEPTABLE CONDITION

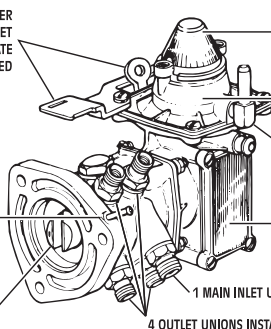
UNITS SHOULD BE DRAINED OF FUEL. CLEAN EXTERNALLY. SHOW NO SIGNS OF TAMPERING OR CASE DAMAGE.

Weight = 1.96 kg min.

OVERFUEL LEVER & BRACKET FREE TO OPERATE AND INSTALLED

SPILL FUEL RETURN UNION (SCREWED OR PUSH ON TYPE) INSTALLED

ROTOR MUST BE FREE TO ROTATE



PLASTIC CAP ATTACHED BY 2 SCREWS

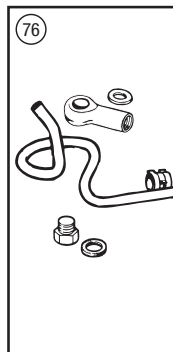
TOP COVER ATTACHED BY 4 SCREWS

VACUUM UNIT INSTALLED

PLASTIC SIDE COVER ATTACHED BY 4 SCREWS

1 MAIN INLET UNION INSTALLED

4 OUTLET UNIONS INSTALLED





**TR2-4A-250****Accelerator Pedals**

Note: For accelerator linkages (link rods, bell crank levers etc) please refer to the carburettor section appropriate for your car.

**RIGHT HAND STEERING;  
TR2, TR3, TR3A, TR4, TR4A**

|    |  |   |          |
|----|--|---|----------|
| 1  | PEDAL AND SHAFT, accelerator;          |   |          |
|    | TR2, TR3, TR3A                         | 1 | 208437   |
|    | TR4, TR4A                              | 1 | 209411   |
| 2  | BRACKET, pedal attachment;             |   |          |
|    | TR2, TR3, TR3A                         | 2 | 106752   |
|    | TR4, TR4A                              | 2 | 131253   |
| 3  | WASHER, double coil                    | 1 | WS600061 |
| 4  | SPLIT PIN                              | 2 | PC34     |
| 5  | WASHER                                 | 2 | WP20X    |
| 6  | SCREW, bracket to body                 | 4 | GHF117   |
| 7  | WASHER, locking                        | 4 | GHF331   |
| 8  | SCREW, pedal limit stop                | 1 | SH604161 |
| 9  | NUT, locking                           | 1 | GHF200   |
| 10 | BUSH, supporting pedal and lever       | 1 | 58282    |
| 11 | PLATE, bush retaining                  | 2 | 105226   |
| 12 | SCREW, plate retaining                 | 4 | YM506    |
| 13 | LEVER ASSEMBLY                         | 1 | 106753   |
| 14 | PIN, locating lever to shaft           | 1 | DS1312   |
| 15 | SPRING, pedal return                   | 1 | 27645    |
| 16 | SCREW, blanking                        | 3 | GHF117   |
|    | Blanks holes for LH steering controls. |   |          |
| 17 | WASHER, locking                        | 3 | GHF331   |
| 18 | PLUG, blanking 1 1/2" diameter         | 1 | 600400   |

**LEFT HAND STEERING;  
TR2, TR3, TR3A, TR4, TR4A**

|    |   |     |          |
|----|---|-----|----------|
| 19 | PEDAL, accelerator                              | 1   | 106749   |
|    | TR2, TR3, TR3A to TS29820.                      |     |          |
| 20 | SHAFT, connecting pedal to lever                | 1   | 106762   |
|    | TR2, TR3, TR3A to TS29820.                      |     |          |
| 21 | CONNECTOR AND BUSH pedal to shaft               | 1   | 108614   |
|    | TR2, TR3, TR3A to TS29820.                      |     |          |
|    | PEDAL AND SHAFT, accelerator                    | 1   | 206590   |
|    | TR3A from TS29821, TR4, TR4A.                   |     |          |
|    | BUSH, pedal shaft                               | 1   | 120443   |
|    | TR3A from TS29821, TR4, TR4A.                   |     |          |
| 22 | PIN, locating bush and shafts                   | 2/1 | DS1312   |
|    | Qty. decreases on TR3A from TS29821, TR4, TR4A. |     |          |
| 23 | BRACKET, shaft attachment                       | 1   | 106763   |
| 24 | SCREW, bracket attachment                       | 2   | GHF117   |
| 25 | WASHER, locking                                 | 2   | GHF331   |
| 26 | SPLIT PIN                                       | 1   | PC34     |
| 27 | WASHER  | 1   | WP20X    |
| 28 | LEVER ASSEMBLY                                  | 1   | 106753   |
| 29 | WASHER, double coil                             | 1   | WS600061 |
| 30 | PIN, locating lever                             | 1   | DS1312   |
| 31 | BUSH, supporting pedal and lever                | 2   | 58282    |
| 32 | PLATE, bush retaining                           | 4   | 105226   |
| 33 | SCREW, plate retaining                          | 8   | YM506    |
| 34 | SCREW, pedal limit stop                         | 1   | SH604161 |
| 35 | NUT, locking                                    | 1   | GHF200   |
| 36 | SPRING, pedal return                            | 1   | 27645    |

**LEFT HAND STEERING; TR250**

|    |                                    |   |            |
|----|------------------------------------|---|------------|
| 37 | PEDAL AND SHAFT, accelerator       | 1 | 214444     |
| 38 | NUT, locking                       | 1 | GHF200     |
| 39 | SCREW, pedal limit stop            | 1 | GHF101     |
| 40 | SPLIT PIN                          | 1 | PC10       |
| 41 | WASHER                             | 2 | WP9        |
| 42 | WASHER, double coil                | 1 | WS600051   |
| 43 | BEARING, fitted in bulkhead panel; |   |            |
|    | original                           | 2 | 138490     |
|    | uprated polyurethane replacement   | 2 | 138490POLY |
| 44 | LEVER, throttle rod control        | 1 | 148500     |
| 45 | BOLT, lever clamping               | 1 | BQ4811     |
| 46 | WASHER                             | 1 | GHF301     |
| 47 | WASHER, locking                    | 1 | GHF332     |
| 48 | NUT                                | 1 | GHF201     |
| 49 | SPRING, pedal return               | 1 | 27645      |

**Choke Cables**

For choke linkages (carburettor connecting rods etc.) please refer to the carburettor section appropriate for your car.

**TR2, TR3, TR3A**

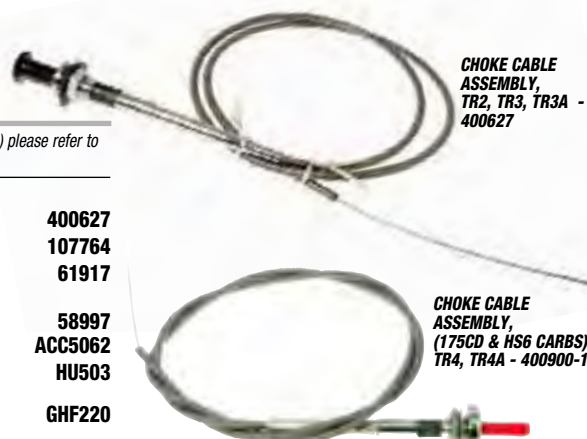
|    |                                    |   |          |
|----|------------------------------------|---|----------|
| 50 | CHOKE CABLE ASSEMBLY               | 1 | 400627   |
| 51 | KNOB, choke cable                  | 1 | 107764   |
| 52 | GROMMET, cable through bulkhead    | 1 | 61917    |
| 53 | TRUNNION, cable (H4 carburetters); |   |          |
|    | original                           | 1 | 58997    |
|    | alternative                        | 1 | ACC5062  |
| 54 | SCREW, original trunnion           | 1 | HU503    |
|    | H4 carburetters.                   |   |          |
| 55 | NUT, nyloc, original trunnion      | 1 | GHF220   |
|    | H4 carburetters.                   |   |          |
| 56 | WASHER, original trunnion          | 1 | WP28     |
|    | H4 carburetters.                   |   |          |
| 57 | TRUNNION ASS'Y, cable              | 1 | WZX875   |
|    | H6 carburetters.                   |   |          |
| 58 | TRUNNION, cable                    | 1 | 113454   |
|    | H6 carburetters.                   |   |          |
| 59 | NUT, clamping cable                | 1 | AJD8204Z |
|    | H6 carburetters.                   |   |          |
| 60 | WASHER                             | 1 | WP5      |
|    | H6 carburetters.                   |   |          |

**TR4, TR4A**

|    |                                 |   |          |
|----|---------------------------------|---|----------|
| 61 | CHOKE CABLE ASSEMBLY;           |   |          |
|    | H6 carburetters                 | 1 | 401458   |
|    | 175CD and HS6 carburetters      | 1 | 401900-1 |
| 62 | KNOB, choke cable               | 1 | 704873   |
| 63 | GROMMET, cable through bulkhead | 1 | 61917    |
| 64 | CLEAT, choke cable securing;    |   |          |
|    | original fir tree type          | 1 | 145890   |
|    | alternative cable tie type      | 1 | BMK1900  |
| 65 | TRUNNION ASS'Y, cable           | 1 | WZX875   |
|    | H6 carburetters.                |   |          |
| 66 | TRUNNION, cable                 | 1 | 113454   |
|    | H6 carburetters.                |   |          |
| 67 | NUT, clamping cable             | 1 | AJD8204Z |
|    | H6 carburetters.                |   |          |
| 68 | WASHER                          | 1 | WP5      |
|    | H6 carburetters.                |   |          |
| 69 | SCREW, cable clamping           | 1 | 512314   |
|    | 175CD carburetters.             |   |          |
| 70 | TRUNNION ASS'Y, cable clamping  | 1 | AUE34    |
|    | HS6 carburetters.               |   |          |

**TR250**

|    |                                    |   |            |
|----|------------------------------------|---|------------|
| 71 | CHOKE CABLE ASSEMBLY;              |   |            |
|    | original item, twin flexible wires | 1 | 214672     |
|    | replacement item, twin rigid wires | 1 | UKC2121    |
| 72 | CHOKE KNOB                         | 1 | 712907     |
| 73 | GROMMET, cable through bulkhead    | 1 | 61917      |
| 74 | CLEAT, choke cable securing;       |   |            |
|    | original fir tree type             | 1 | 145890     |
|    | alternative cable tie type         | 1 | BMK1900    |
| 75 | CLIP, outer cable to carb. bracket | 2 | 517001CLIP |

**Emission Control****CLOSED CIRCUIT BREATHING SYSTEM;  
TR4 from CT23594**

|    |  |   |         |
|----|--|---|---------|
| 76 | HOSE, rocker cover to pipe                   | 1 | 149995  |
| 77 | PIPE, hose to 'Y' piece flame trap           | 1 | 138078  |
| 78 | HOSE, pipe to 'Y' piece flame trap           | 1 | 154627  |
| 79 | 'Y' PIECE FLAME TRAP ASS'Y                   | 1 | 138073  |
| 80 | HOSE, flame trap to air cleaner              | 2 | BHH1238 |
| 81 | AIR FILTER ASS'Y                             | 2 | 209269  |
|    | Replacement type with breather hose fitting. |   |         |

**POSITIVE CRANKCASE VENTILATION  
VALVE SYSTEM; TR4A**

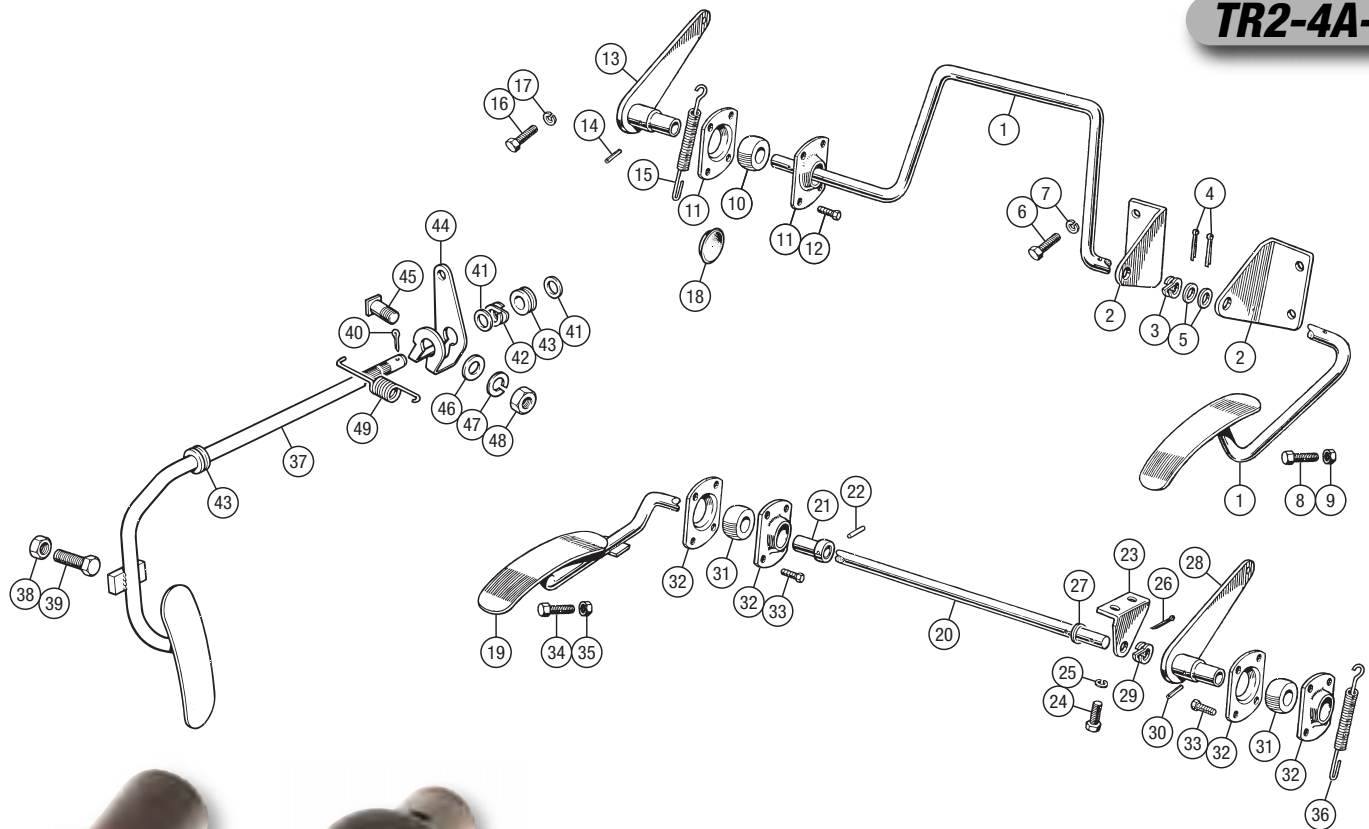
|    |                                    |   |         |
|----|------------------------------------|---|---------|
| 82 | PCV VALVE ASSEMBLY                 | 1 | 151658  |
| 83 | REPAIR KIT, PCV valve              | 1 | 149343  |
|    | Includes diaphragm.                |   |         |
| 84 | DIAPHRAGM, PCV valve               | 1 | 27H7758 |
| 85 | HOSE, rocker cover to valve        | 1 | 143323  |
| 86 | HOSE, valve to inlet manifold      | 1 | 143314  |
| 87 | CLIP;                              |   |         |
|    | wire band type                     | 4 | CS4012  |
|    | worm drive type                    | 4 | GHC507  |
|    | Alternative to CS4012.             |   |         |
| 88 | ADAPTOR, hose to manifold          | 1 | 138530  |
| 89 | WASHER, fibre, adaptor to manifold | 1 | WF524   |
| 90 | BRACKET, valve to inlet manifold   | 1 | 143313  |
| 91 | SCREW, bracket to valve            | 1 | GHF101  |
| 92 | WASHER, plain                      | 1 | GHF300  |
| 93 | NUT, nyloc                         | 1 | GHF271  |

**POSITIVE CRANKCASE VENTILATION  
VALVE SYSTEM; TR250**

|     |                                     |   |         |
|-----|-------------------------------------|---|---------|
| 94  | PCV VALVE ASSEMBLY                  | 1 | 151444  |
| 95  | REPAIR KIT, PCV valve               | 1 | 149343  |
|     | Includes diaphragm.                 |   |         |
| 96  | DIAPHRAGM, PCV valve                | 1 | 27H7758 |
| 97  | 'T' PIECE, emission hoses and valve | 1 | 154211  |
| 98  | HOSE, 'T' piece to air cleaner      | 1 | 149158  |
| 99  | HOSE, 'T' piece to rocker cover     | 1 | 149153  |
| 100 | HOSE, 'T' piece to emission valve   | 1 | 149157  |
| 101 | CLIP, securing hose                 | 6 | CC5011  |







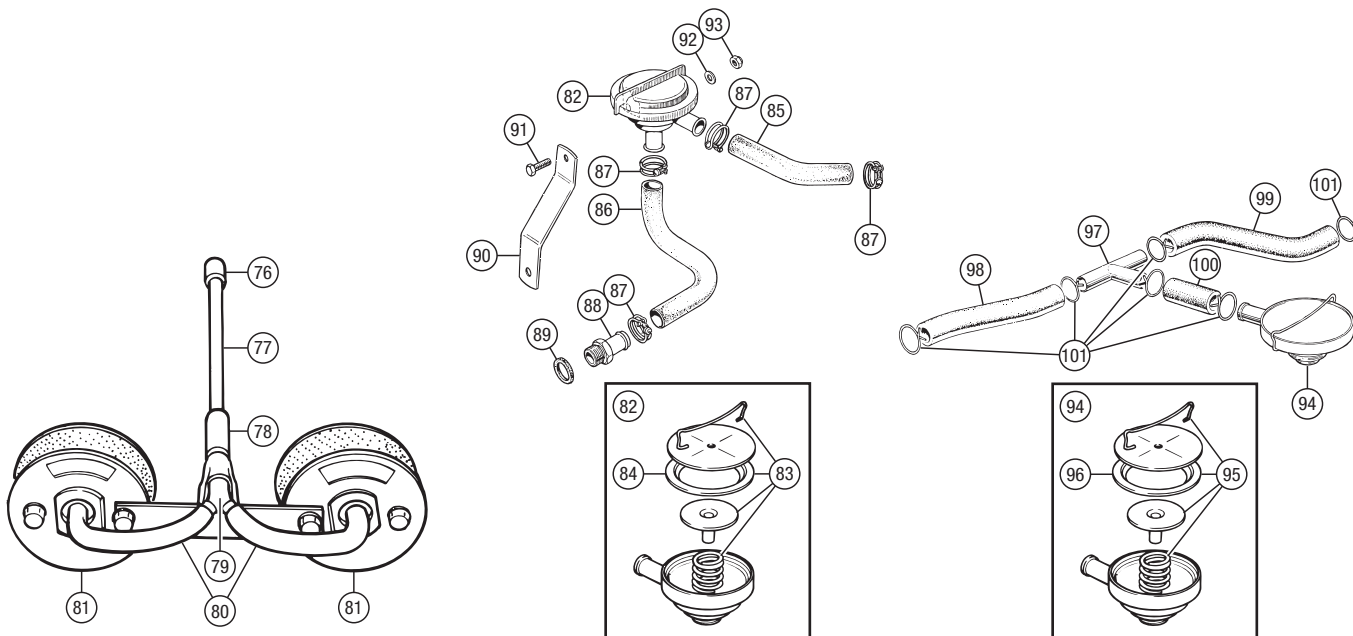
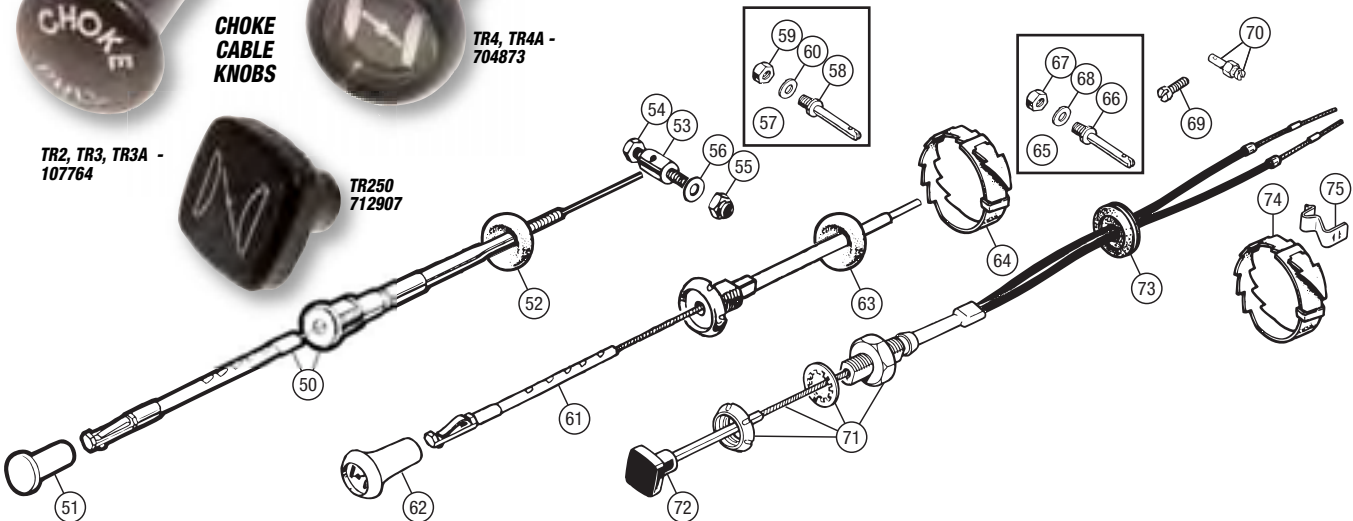
**CHOKE  
CABLE  
KNOBS**

TR4, TR4A -  
704873

TR2, TR3, TR3A -  
107764



TR250  
712907





| No. | DESCRIPTION | QTY REQ. | PART No. | No. | DESCRIPTION | QTY REQ. | PART No. | No. | DESCRIPTION | QTY REQ. | PART No. |
|-----|-------------|----------|----------|-----|-------------|----------|----------|-----|-------------|----------|----------|
|-----|-------------|----------|----------|-----|-------------|----------|----------|-----|-------------|----------|----------|

TR5



ACCELERATOR CABLE - 149005

## Accelerator Pedals & Cables

### RIGHT HAND STEERING

|    |  |   |          |
|----|--|---|----------|
| 1  | ACCELERATOR PEDAL ASSEMBLY             | 1 | 214420   |
| 2  | PLATE, bearing ass'y, RH pedal support | 1 | 148526   |
| 3  | BEARING; original                      | 1 | 138490   |
|    | polyurethane (Alternative)             | 1 | 138490P  |
| 4  | SCREW, plate to pedal box              | 2 | SH604051 |
| 5  | WASHER, locking                        | 2 | GHF331   |
| 6  | NUT                                    | 2 | GHF200   |
| 7  | WASHER, plain, pedal shaft thrust      | 1 | WP9      |
| 8  | SPLIT PIN, pedal shaft locating        | 1 | PC10     |
| 9  | BEARING (fitted in bulkhead); original | 1 | 138490   |
|    | polyurethane (Alternative)             | 1 | 138490P  |
| 10 | BOLT, accelerator pedal stop           | 1 | SH605161 |
| 11 | NUT, locking pedal stop bolt           | 1 | GHF201   |
| 12 | SPRING, pedal return                   | 1 | 27645    |
| 13 | ACCELERATOR CABLE                      | 1 | 149005   |
| 14 | WASHER, rubber                         | 1 | 131492   |
| 15 | CLIP, edge type, cable end to pedal    | 1 | 613766   |
| 16 | CLIP, cable to RH inner wing           | 1 | 610652   |
| 17 | CLEVIS PIN, cable end to linkage lever | 1 | PJ8504   |
| 18 | WASHER, plain                          | 2 | WP5      |
| 19 | SPLIT PIN                              | 1 | PC5      |

### LEFT HAND STEERING

|    |  |   |          |
|----|--|---|----------|
| 20 | ACCELERATOR PEDAL ASSEMBLY             | 1 | 159877   |
| 21 | PLATE, bearing ass'y, LH pedal support | 1 | 148954   |
| 22 | BEARING; original                      | 1 | 138490   |
|    | polyurethane (Alternative)             | 1 | 138490P  |
| 23 | SCREW, securing plate to footwell      | 2 | SH604051 |
| 24 | WASHER, locking                        | 2 | GHF331   |
| 25 | NUT                                    | 2 | GHF200   |
| 26 | WASHER, plain, pedal shaft thrust      | 1 | WP9      |
| 27 | SPLIT PIN, pedal shaft locating        | 1 | PC10     |
| 28 | BEARING (fitted in bulkhead); original | 1 | 138490   |
|    | polyurethane (Alternative)             | 1 | 138490P  |
| 29 | SCREW, accelerator pedal stop          | 1 | GHF101   |
| 30 | NUT, locking pedal stop screw          | 1 | GHF201   |
| 31 | SPRING, pedal return                   | 1 | 27645    |
| 32 | ACCELERATOR CABLE                      | 1 | 149004   |
| 33 | WASHER, rubber                         | 1 | 131492   |
| 34 | CLIP, tubular type, cable end to pedal | 1 | 153041   |
| 35 | CLIP, cable to dash shelf              | 1 | 59380    |
| 36 | 'P' CLIP, cable to battery fixing rod  | 2 | 516510   |
| 37 | CLEVIS PIN, cable end to linkage lever | 1 | PJ8504   |
| 38 | WASHER, plain                          | 2 | WP5      |
| 39 | SPLIT PIN                              | 1 | PC5      |

## Choke Cables

|    |   |   |            |
|----|---|---|------------|
| 40 | CHOKE CABLE ASSEMBLY                                  | 1 | 214888     |
| 41 | BEZEL, chrome   | 1 | 146987     |
| 42 | WASHER, shakeproof                                    | 1 | GHF325     |
| 43 | NUT, locking  | 1 | 515789     |
| 44 | KNOB, choke (pictorial)                               | 1 | 712907     |
| 45 | GROMMET, cable through bulkhead                       | 1 | 61917      |
| 46 | TRUNNION ASS'Y, cable to overfuel lever               | 1 | AUE34      |
| 47 | TRUNNION, cable to overfuel lever                     | 1 | 150342     |
| 48 | SCREW, trunnion                                       | 1 | 53K3503    |
| 49 | ADJUSTER ASSEMBLY                                     | 1 | BHH1059    |
| 50 | ADJUSTER, choke cable                                 | 1 | 147930     |
| 51 | NUT, locking cable adjuster                           | 2 | 146984     |
| 52 | CLIP, outer cable to metering unit                    | 1 | 517001CLIP |
| 53 | TRUNNION ASS'Y, cable to fast idle cam                | 1 | AUE34      |
| 54 | TRUNNION, cable to fast idle cam                      | 1 | 150342     |
| 55 | SCREW, trunnion                                       | 1 | 53K3503    |
| 56 | CLEAT, 'fir tree type', choke cable to injector pipes | 1 | 240431A    |



CHOKE KNOB - 712907



TRUNNION ASSEMBLY - AUE34

## Injection System Linkage

|    |   |   |           |
|----|---|---|-----------|
| 57 | COUNTERSHAFT ASSEMBLY   | 1 | 149604    |
| 58 | BEARING BRACKET ASSEMBLY  | 2 | 148927    |
| 59 | BEARING, countershaft assembly; original  | 3 | 138490    |
|    | polyurethane (Alternative)  | 3 | 138490P   |
| 60 | SCREW, bearing bracket to manifold  | 6 | SH604051  |
| 61 | WASHER, locking   | 6 | GHF331    |
| 62 | BRACKET, throttle stop  | 1 | 149618    |
| 63 | SCREW, throttle stop adjusting  | 1 | PT508     |
| 64 | SPRING, throttle stop screw   | 1 | 149552    |
| 65 | SPRING, countershaft return   | 1 | 145197    |
| 66 | THROTTLE LINK ROD   | 3 | 149537    |
| 67 | SWIVEL POST, centre link, upper   | 1 | 149536    |
| 68 | SWIVEL POST, centre link, lower   | 1 | 149535    |
| 69 | SWIVEL POST, front and rear link, upper   | 2 | 149780    |
| 70 | SWIVEL POST, front and rear link, lower   | 2 | 149535    |
| 71 | NUT (locking link rod to upper swivel post)   | 6 | HN2005    |
| 72 | NUT, swivel post to lever   | 6 | HN2005    |
| 73 | WASHER, locking   | 6 | WL105001  |
| 74 | WASHER, plain   | 6 | WC701121  |
| 75 | FIX NUT, throttle link rod to top swivel post<br>Alternative method preventing swivel post nuts from working loose. | 3 | FX3203    |
| 76 | CAM CARRIER   | 1 | 149778    |
| 77 | CAM, cable operated fast idle   | 1 | 149779    |
| 78 | BOLT, special, cam to carrier   | 1 | 136482    |
| 79 | WASHER, waved, cam to cam carrier   | 1 | 624905    |
| 80 | DOWEL PIN   | 1 | UKC6398   |
| 81 | WASHER, plain, bolt to cam<br>7/16" int. diameter.  | 1 | WB600071A |
| 82 | WASHER, plain, cam to carrier<br>5/16" int. diameter.   | 1 | WP129     |
| 83 | WASHER, locking   | 1 | GHF332    |
| 84 | NUT, locking cam pivot bolt   | 1 | GHF201    |
| 85 | SCREW, adjusting  | 1 | 512288    |
| 86 | NUT, locking adjusting screw  | 1 | 512287    |
| 87 | SPRING, choke cam return  | 1 | 145197    |
| 88 | LINK, cam return spring   | 1 | 149785    |

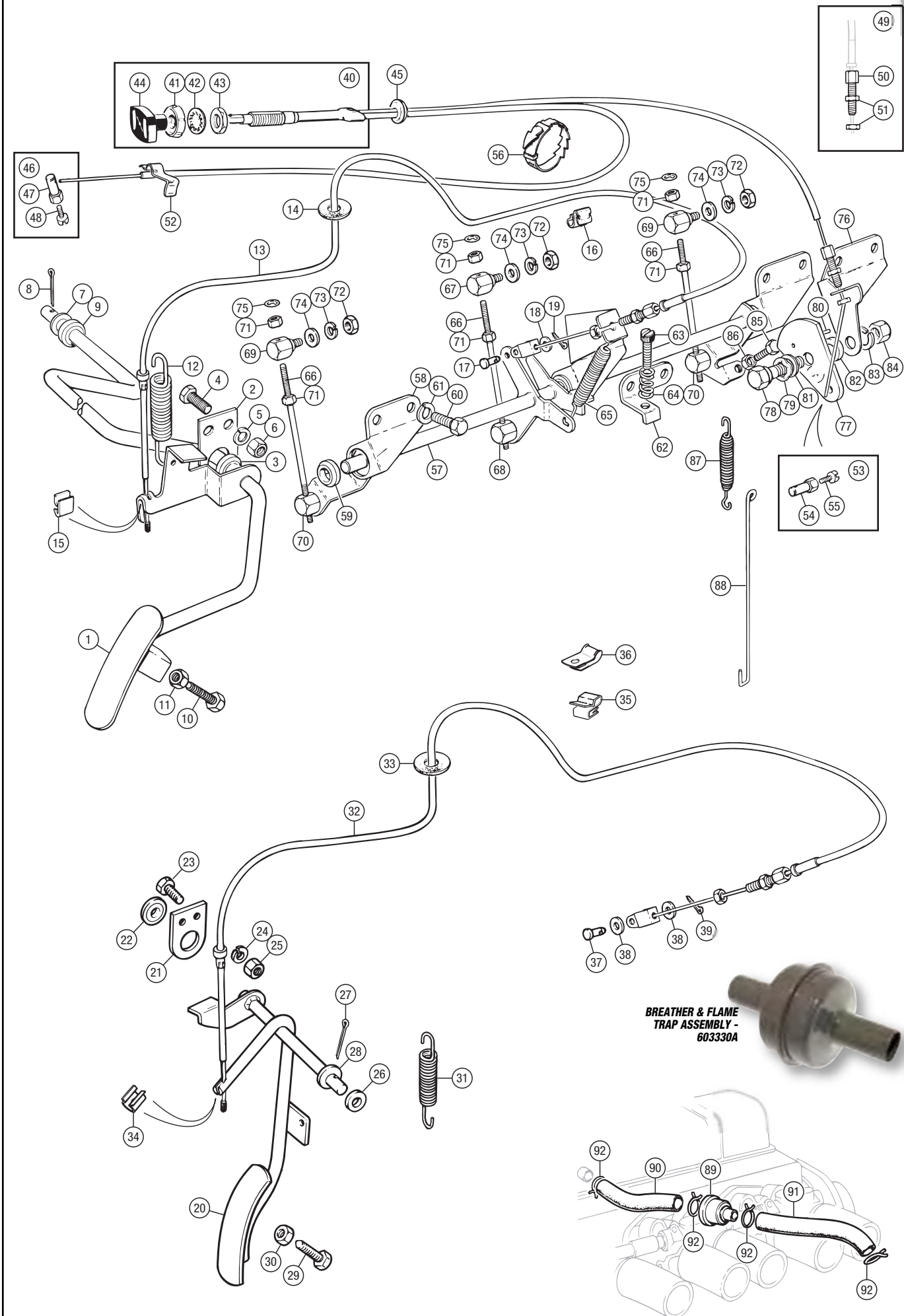
## Emission Control

### CLOSED CIRCUIT BREATHER

|    |  |   |         |
|----|--|---|---------|
| 89 | BREATHER & FLAME TRAP ASSEMBLY; original | 1 | 149996  |
|    | alternative                              | 1 | 603330A |
| 90 | HOSE, breather to rocker cover           | 1 | 154627  |
| 91 | HOSE, breather to air manifold           | 1 | 154627  |
| 92 | CLIP, Corbin, hose fitting               | 4 | CC5011  |









## TR2-4A

MANIFOLDS - 4 cylinder - TR2-4A



TR3 INLET MANIFOLD  
LOW PORT - 302006

## Exhaust Manifold (Standard)

For tubular extractor manifolds please refer to Sports Exhausts - 4 Cylinder.

### TR2, TR3, TR3A, TR4

|   |   |   |        |
|---|---|---|--------|
| 1 | MANIFOLD, exhaust;<br>low port head<br>TR2, TR3 to engine no. TS13051 | 1 | 301144 |
|   | high port head TR3 from engine no. TS13052,<br>TR3A, TR4              | 1 | 304164 |
| 2 | GASKET, manifold to front pipe  | 1 | GEG718 |
| 3 | STUD, manifold to front pipe  | 3 | 101442 |
| 4 | WASHER, locking   | 3 | GHF333 |
| 5 | NUT, brass  | 3 | 108951 |

### TR4A

|    |                                |   |        |
|----|--------------------------------|---|--------|
| 6  | MANIFOLD, exhaust              | 1 | 306378 |
| 7  | GASKET, manifold to front pipe | 1 | GEG724 |
| 8  | STUD, manifold to front pipe   | 4 | 115696 |
| 9  | WASHER, locking                | 4 | GHF333 |
| 10 | NUT, brass                     | 4 | 108951 |
| 11 | NUT, inlet to exhaust manifold | 2 | GHF201 |
| 12 | WASHER, locking                | 2 | GHF332 |



MANIFOLD TO FRONT  
PIPE GASKET,  
TR2, TR3, TR3A, TR4 -  
GEG718



MANIFOLD TO FRONT PIPE GASKET,  
TR4A - GEG724

## Inlet Manifold

|    |  |   |          |
|----|--|---|----------|
| 13 | MANIFOLD, inlet, low port;<br>TR2 (H4 carburettors)  | 1 | 301145   |
|    | TR3 to engine no. TS9349E (H6 carburettors)  | 1 | 302118   |
|    | TR3 from engine no. TS9350E to TS13051E  | 1 | 302006   |
| 14 | MANIFOLD, inlet, high port;<br>TR3 from engine no. TS13052E, TR3A<br>TR3B, TR4 to engine no. CT16800E<br>and 16901E to 21470E.<br>(with balance tube boss) | 1 | 302119   |
|    |  | 1 | 305547   |
| 15 | MANIFOLD, inlet, curved tubes;<br>TR4 CT16801E to 16900E & from 21471E<br>(no tapping with balance tube boss)<br>TR4A (with PCV valve tapping)             | 1 | 305744   |
|    |  | 1 | 307455   |
| 16 | STUD, carb. to manifold - TR2  | 4 | 58917    |
| 17 | NUT - TR2;<br>steel  | 4 | 56675    |
|    | brass  | 4 | 108951   |
| 18 | WASHER, locking - TR2  | 4 | GHF333   |
| 19 | STUD, carb. to manifold<br>TR3, TR3A, TR4, TR4A.   | 8 | 112907   |
| 20 | NUT, steel<br>TR3, TR3A, TR4, TR4A.  | 8 | GHF201   |
| 21 | WASHER, locking<br>TR3, TR3A, TR4, TR4A.   | 8 | GHF332   |
| 22 | STUD, inlet to exhaust manifold<br>TR2.  | 2 | TE605141 |
| 23 | STUD, inlet to exhaust manifold<br>TR3, TR3A, TR4, TR4A.   | 2 | 112907   |
| 24 | GASKET, carb. to inlet manifold<br>TR2; H4 carburettors.   | 4 | AEH551   |
| 25 | INSULATOR, carb. to inlet manifold<br>TR2; H4 carburettors.  | 2 | AHH5713  |
| 26 | GASKET, both sides of insulator,<br>carburettor to inlet manifold<br>TR3, TR3A, TR3B, TR4, TR4A; H6, HS6 or<br>Stromberg carburettors.                     | 4 | 112867   |
| 27 | INSULATOR, carb. to inlet manifold<br>TR3, TR3A, TR3B, TR4, TR4A; H6, HS6 or<br>Stromberg carburettors.  | 2 | 112866   |
| 28 | DOWEL, plain, throttle linkage bracket<br>to inlet manifold<br>TR2, TR3, TR3A, TR3B, TR4.  | 1 | DP308    |

## Manifold to Head Fixings

|    |   |   |        |
|----|---|---|--------|
| 29 | GASKET, manifold, low port<br>TR2, TR3 to engine no. TS13051E                       | 2 | 106937 |
| 30 | GASKET, manifold, high port<br>TR3 from engine no. TS13052E, TR3A, TR3B, TR4, TR4A. | 2 | 113122 |
| 31 | STUD, manifold;<br>2 1/16", upper   | 4 | 102474 |
|    | 2 3/8", upper centre  | 2 | 107055 |
|    | 1 11/16", lower front   | 1 | 58688  |
|    | 1 11/16", lower rear<br>Without engine lifting eye fitted.                          | 1 | 58688  |
|    | 1 15/16", lower rear<br>With engine lifting eye fitted.                             | 1 | 58917  |
| 32 | CLAMP, manifold, large  | 2 | 33148  |
| 33 | CLAMP, manifold, small  | 4 | 58258  |
| 34 | WASHER, locking, manifold   | 8 | GHF333 |
| 35 | NUT, manifold;<br>steel   | 8 | 56675  |
|    | brass   | 8 | 108951 |
| 36 | DOWEL, plain, inlet manifold<br>to cylinder head                                    | 2 | DP514  |



MANIFOLD LARGE  
CLAMP - 33148



MANIFOLD SMALL  
CLAMP - 58258



MANIFOLD LOCKING  
WASHER - GHF333

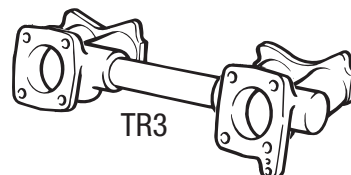
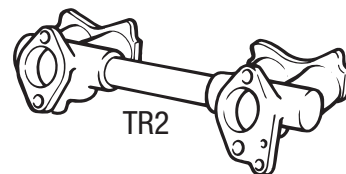
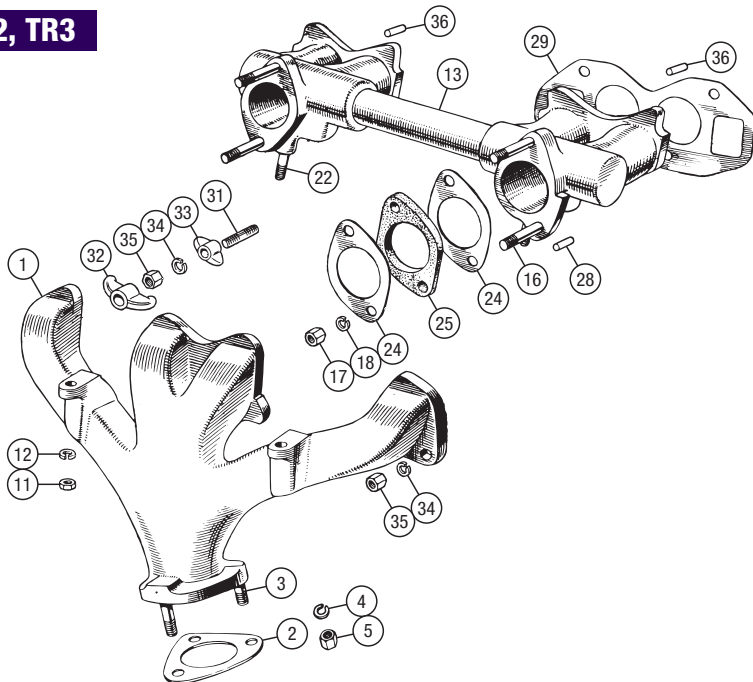


BRASS MANIFOLD NUT  
- 108951

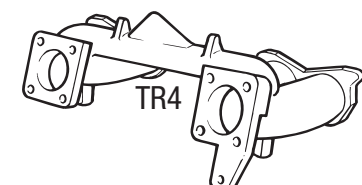
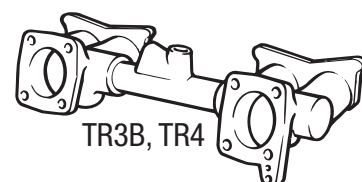
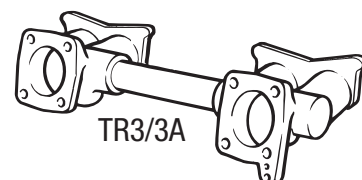
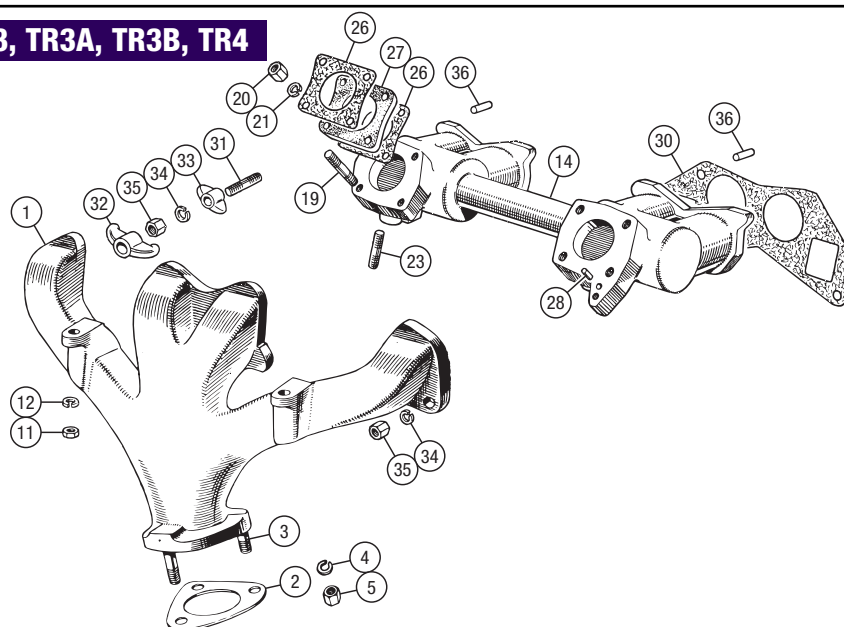




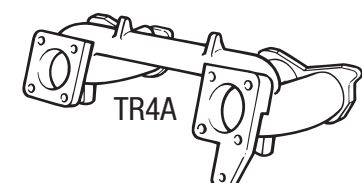
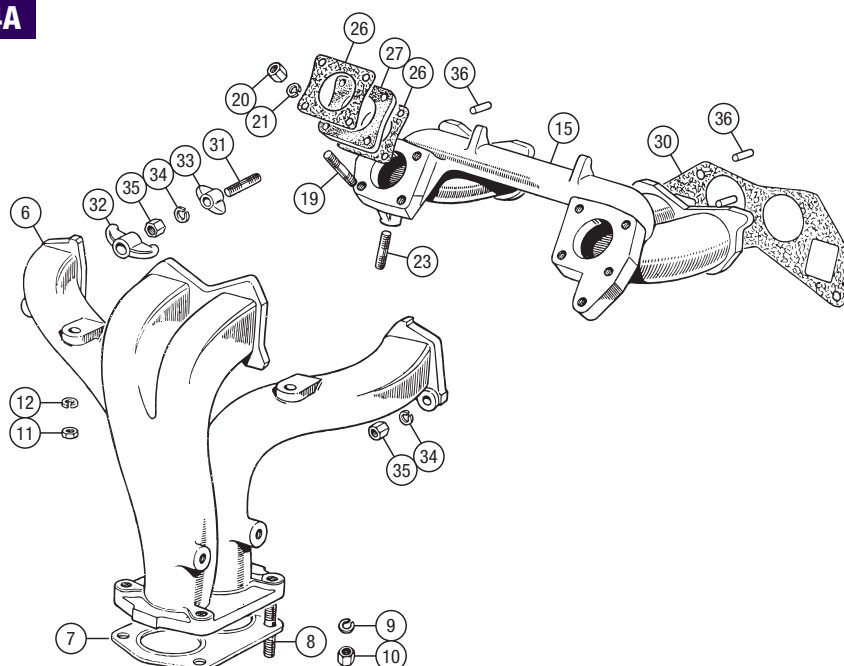
## TR2, TR3



## TR3, TR3A, TR3B, TR4



## TR4A





## TR5-250

### Exhaust Manifold (Standard)

For tubular extractor manifolds refer to Sports Exhaust - 6 cylinder.

#### TR5

|    |  |   |          |
|----|--|---|----------|
| 1  | GASKET, exhaust and inlet manifolds to cylinder head | 1 | GEG682   |
| 2  | DOWEL, scrolled, locating manifolds                  | 3 | DS3113   |
| 3  | STUD, intake manifold to cylinder head               | 3 | TE605105 |
| 4  | CLAMP, securing manifolds                            | 6 | 58258    |
| 5  | WASHER, locking, 5/16"                               | 3 | GHF332   |
| 6  | NUT, 5/16" UNF                                       | 3 | GHF201   |
| 7  | STUD, exhaust manifold to cylinder head              | 4 | 105124   |
| 8  | WASHER, locking, 3/8"                                | 4 | GHF333   |
| 9  | NUT, 3/8" UNF  | 4 | 100498   |
| 10 | STUD, both manifolds to cylinder head                | 6 | 105125   |
| 11 | WASHER, locking, 3/8"                                | 6 | GHF333   |
| 12 | NUT, 3/8" UNF  | 6 | 100498   |
| 13 | MANIFOLD, exhaust                                    | 1 | 308292   |
| 14 | GASKET, exhaust down pipe                            | 1 | GEG724   |
| 15 | STUD, manifold to exhaust down pipe                  | 4 | 115696   |
| 16 | WASHER, locking                                      | 4 | GHF333   |
| 17 | NUT, brass   | 4 | 108951   |

#### TR250

|    |  |   |          |
|----|--|---|----------|
| 18 | GASKET, exhaust and inlet manifolds to cylinder head | 1 | 213641   |
| 19 | DOWEL, scrolled, locating manifolds                  | 2 | DS3113   |
| 20 | BOLT, intake manifold to cylinder head               | 3 | BH605281 |
| 21 | CLAMP, securing manifolds                            | 6 | 58258    |
| 22 | WASHER, locking                                      | 6 | GHF333   |
| 23 | NUT  | 6 | 100498   |
| 24 | STUD, exhaust manifold to cylinder head              | 4 | 105124   |
| 25 | WASHER, locking                                      | 4 | GHF333   |
| 26 | NUT  | 4 | 100498   |
| 27 | STUD, both manifolds to cylinder head                | 6 | 105125   |
| 28 | WASHER, locking                                      | 3 | GHF332   |
| 29 | MANIFOLD, exhaust                                    | 1 | 308290   |
| 30 | GASKET, exhaust down pipe                            | 1 | GEG718   |
| 31 | STUD, manifold to exhaust down pipe                  | 3 | 115696   |
| 32 | WASHER, locking                                      | 3 | GHF333   |
| 33 | NUT, brass   | 3 | 108951   |



INLET MANIFOLD - 152807

### Inlet Manifolds

#### TR5 NON-AIR BLEED AND TR6 AIR BLEED

If your TR5 is fitted with air bleed - a not uncommon modification - it has received its manifolds and metering unit (see 'Fuel Systems - Injection Equipment') from a TR6 at some point in its past. For this reason, both TR5 non-air bleed and early TR6 air bleed manifolds are described here.

|    |   |     |         |
|----|---|-----|---------|
| 34 | INLET MANIFOLD, set of 3, reconditioned; Including spindles, discs etc. (exchange). |     |         |
|    | TR5 original items without air bleed  | 1   | RR1380R |
|    | TR6 alternatives with air bleed   | 1   | RR1381R |
| 35 | MANIFOLD, front inlet (air bleed)   | 1   | 152807  |
|    | TR6 manifold with air bleed.  |     |         |
| 36 | PLUG, blanking  | 1   | 122132  |
| 37 | WASHER, fibre   | 3   | WF513   |
| 38 | PLUG, spindle bore  | 3   | 148986  |
| 39 | PLUG, blanking, cross drill;  |     |         |
|    | TR5 original manifolds  | 6   | PU702   |
|    | TR6 manifolds   | 6   | PU852   |
| 40 | TUBE, air balance   | 4   | 148899  |
| 41 | SCREW, metering, air valve;   |     |         |
|    | Late TR5 original manifolds   | 1   | 508782  |
|    | TR6 manifolds   | 1   | 152685  |
| 42 | SPRING, metering screw;   |     |         |
|    | Late TR5 original manifolds   | 1   | 152691  |
|    | TR6 manifolds   | 1   | 152684  |
| 43 | HOSE, air valve to air inlet manifold;  |     |         |
|    | TR5 original manifolds  | 1   | 152891  |
|    | TR6 manifolds   | 1   | 152855  |
| 44 | TUBE, air inlet   | 6   | 149374  |
| 45 | MANIFOLD, centre inlet  | 1   | 149651  |
| 46 | ADAPTOR, metering unit control hose   | 1   | 149764  |
| 47 | MANIFOLD, rear inlet  | 1   | 149659  |
| 48 | ADAPTOR, brake servo hose   | 1   | 21K8342 |
| 49 | PLUG, core, rear  | 2/1 | 144537  |
|    | Qty. reduces for TR6 manifolds.   |     |         |
| 50 | SPINDLE, throttle assembly  | 3   | 148880  |
|    | TR5 original manifolds.   |     |         |
| 51 | LEVER, throttle   | 3   | 149747  |
|    | TR5 original manifolds.   |     |         |
| 52 | NUT, nylon  | 3   | GHF221  |
|    | TR5 original manifolds.   |     |         |
| 53 | SPINDLE, throttle assembly  | 3   | 152185  |
|    | TR6 manifolds.  |     |         |
|    | May be used to replace original TR5 spindle and lever.                              |     |         |
| 54 | SCREW, slow running adjustment  | 3   | 149805  |
| 55 | SPRING, slow running adjustment   | 3   | 149552  |
| 56 | DISC, throttle  | 6   | 160109  |
| 57 | SCREW, throttle disc to spindle   | 12  | 148988  |
| 58 | SPRING, throttle return   | 3   | 148987  |
| 59 | PIPE, air balance   | 2   | 148899  |



### Air Manifold

#### TR5 NON-AIR BLEED AND TR6 AIR BLEED

|    |  |   |         |
|----|--|---|---------|
| 60 | AIR MANIFOLD ASSEMBLY;   |   |         |
|    | TR5; non-air bleed   | 1 | 214804  |
|    | TR6; air bleed   | 1 | 216374  |
| 61 | HOSE, air manifold to inlet manifold   | 6 | 152601  |
| 62 | CLIP, hose attachment  | 4 | GHC1622 |
|    | Fitted to the two outer-most hoses only.   |   |         |
| 63 | STAY, supporting air manifold  | 1 | 214840  |
| 64 | SCREW, stay to air manifold  | 2 | GHF117  |
| 65 | WASHER, locking  | 2 | GHF331  |
| 66 | NUT  | 2 | GHF200  |
| 67 | STUD, support stay and engine mounting bracket to cylinder block   | 2 | 105124  |
| 68 | WASHER, locking  | 2 | GHF333  |
| 69 | NUT  | 2 | GHF202  |
| 70 | HOSE, air cleaner to air manifold  | 1 | 149693  |
|    | For air cleaners, see 'Air Cleaners' section. For closed circuit breather, see 'Fuel System - Controls and Emissions TR5' section. |   |         |



AIR MANIFOLD TO INLET MANIFOLD HOSE - 152601



AIR CLEANER HOSE - 149693

### Inlet Manifold

#### TR250

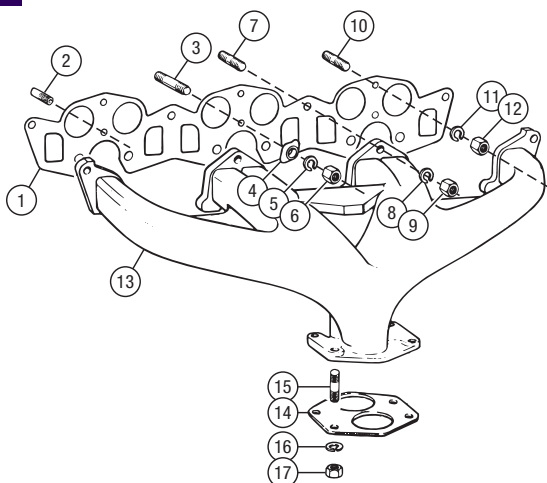
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|----|-------------------------------------|---|----------|
| 71 | MANIFOLD, inlet                     | 1 | 308088   |
| 72 | PLUG, core, inlet manifold          | 2 | 46172    |
| 73 | ADAPTOR, inlet manifold water hoses | 2 | 138810   |
| 74 | PLUG, screwed, inlet manifold       | 1 | 116516   |
| 75 | CONNECTOR, banjo, vacuum            | 1 | 149362   |
| 76 | ADAPTOR AND BOLT, banjo, vacuum     | 1 | 149360   |
| 77 | WASHER, fibre                       | 2 | WF513    |
| 78 | STUD, carburetter to inlet manifold | 2 | 112907   |
| 79 | STUD, carburetter to inlet manifold | 6 | TE605141 |



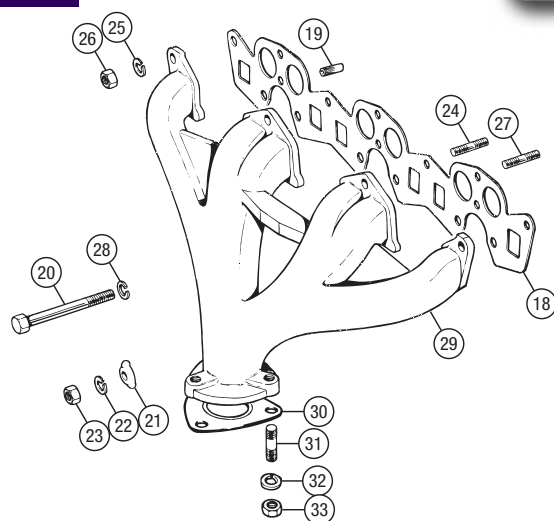
THROTTLE ASSEMBLY SPINDLE (TR6 TYPE) - 152185



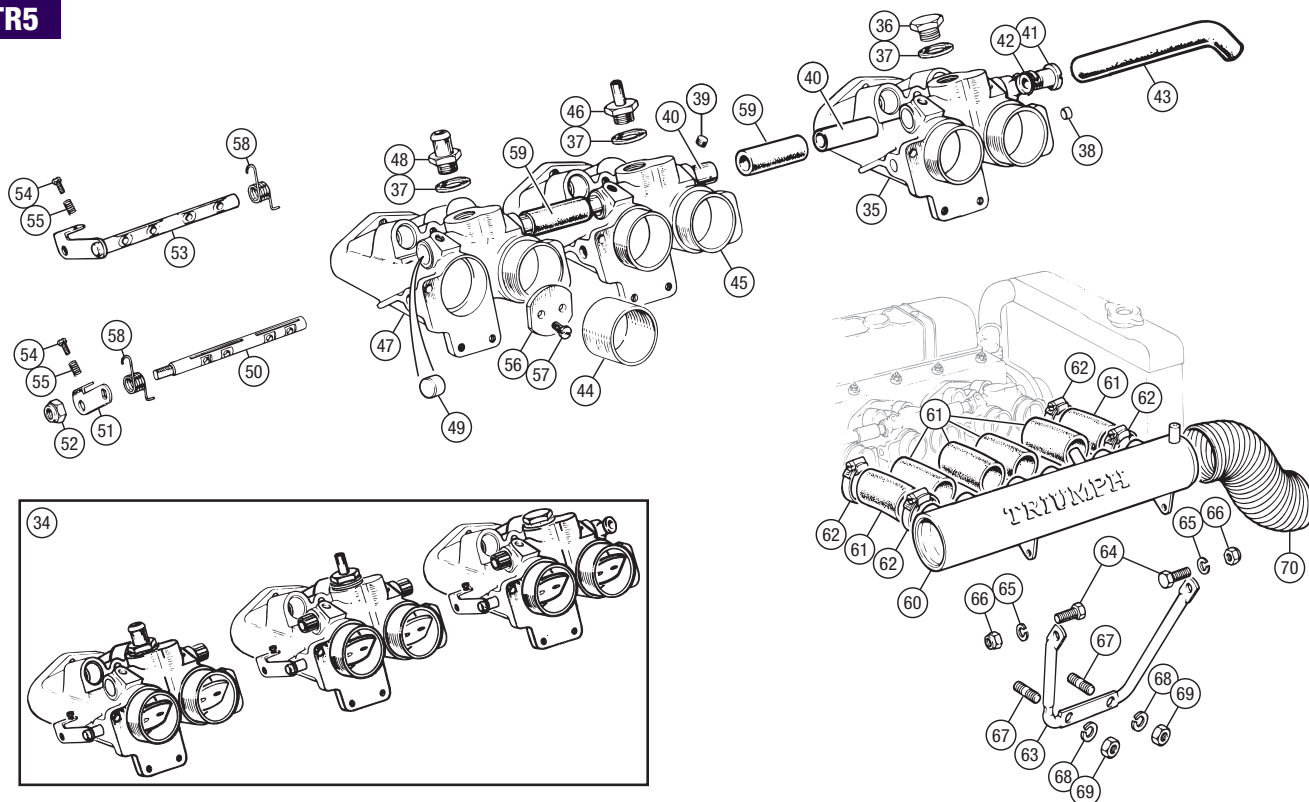
TR5



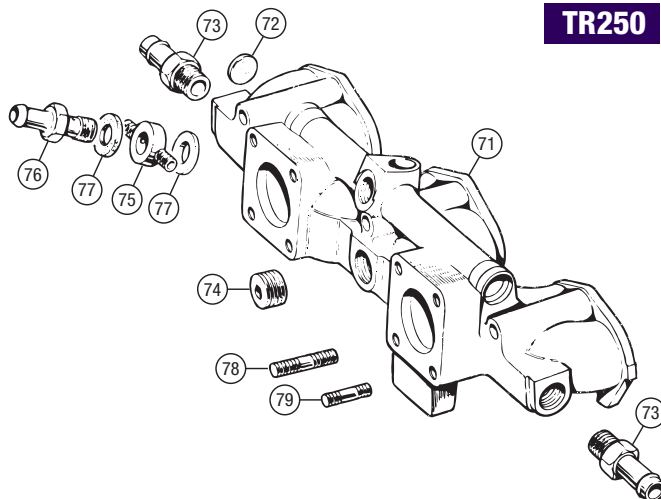
TR250



TR5



TR250





## TR2-4A

Exhaust Standard Systems  
- TR2, TR3, TR3A, TR4

## MILD STEEL

FULL SYSTEM;

TR2, TR3 to TS11716

TR3 from TS11717, TR3A, TR4

The following parts are included:-

|   |                              |   |         |
|---|------------------------------|---|---------|
| 1 | FRONT DOWN PIPE              | 1 | GEX1254 |
| 2 | FRONT SILENCER               | 1 | GEX3203 |
| 3 | REAR PIPE                    | 1 | 202009  |
|   | TR2, TR3 to TS11716.         |   |         |
| 4 | REAR SILENCER                | 1 | GEX3204 |
|   | TR3 from TS11717, TR3A, TR4. |   |         |

## STAINLESS STEEL

FULL SYSTEM;

TR2, TR3 to TS11716

TR3 from TS11717, TR3A, TR4

The following parts are included:-

|   |                              |   |           |
|---|------------------------------|---|-----------|
| 1 | FRONT DOWN PIPE              | 1 | GEX1254SS |
| 2 | FRONT SILENCER               | 1 | GEX3203SS |
| 3 | REAR PIPE                    | 1 | 202009SS  |
|   | TR2, TR3 to TS11716.         |   |           |
| 4 | REAR SILENCER                | 1 | GEX3204SS |
|   | TR3 from TS11717, TR3A, TR4. |   |           |

|   |                                  |   |          |
|---|----------------------------------|---|----------|
| 5 | TAIL PIPE EXTENSION, chrome      | 1 | HRTT9177 |
|   | Push-on type.                    |   |          |
|   | CLAMP, tail pipe extension       | 1 | 107602   |
|   | For original clamp-on extension. |   |          |

## MANIFOLD JOINT TR2, TR3, TR3A, TR4

|   |                                |   |        |
|---|--------------------------------|---|--------|
| 6 | GASKET, manifold to front pipe | 1 | GEG718 |
| 7 | STUD, manifold to front pipe   | 3 | 101442 |
| 8 | WASHER, locking                | 3 | GHF333 |
| 9 | NUT, brass                     | 3 | 108951 |

## FRONT MOUNTING TR2, TR3 to TS11716

|    |                                  |   |        |
|----|----------------------------------|---|--------|
| 10 | CLAMP, lower                     | 1 | 107642 |
|    | TR2 to TS4309.                   |   |        |
| 11 | CLAMP, upper                     | 1 | 107643 |
|    | TR2 to TS4309.                   |   |        |
| 12 | CLAMP, one piece                 | 1 | 110397 |
|    | TR2 from TS4310, TR3 to TS11716. |   |        |

In the event of the above brackets not being available, please note that the later TR3 one piece clamp 114074 cannot be substituted without undertaking modifications. A more simple answer is to utilise the TR4 bracket (130888) and clamp (130890) with their associated fixings to mount the exhaust to the gearbox mounting, rather than the chassis as original. Not authentic, but it works and it's easy.

|    |                                  |   |          |
|----|----------------------------------|---|----------|
| 13 | SCREW, clamp assembly            |   |          |
|    | TR2 to TS4309                    | 2 | GHF103   |
|    | TR2 from TS4310, TR3 to TS11716  | 1 | GHF103   |
| 14 | NUT                              |   |          |
|    | TR2 to TS4309                    | 3 | GHF201   |
|    | TR2 from TS4310, TR3 to TS11716  | 2 | GHF201   |
| 15 | BUSH, in clamp                   | 1 | GEX7329  |
|    | TR2 to TS4309.                   |   |          |
|    | BUSH, in chassis                 | 2 | GEX7329  |
|    | TR2 from TS4310, TR3 to TS11716. |   |          |
| 16 | WASHER, rubber                   | 1 | GEX7330  |
| 17 | WASHER                           | 1 | RTC610A  |
| 18 | SCREW, clamp to chassis          | 1 | GHF103   |
|    | TR2 to TS4309.                   |   |          |
|    | BOLT, clamp to chassis           | 1 | BH605201 |
|    | TR2 from TS4310, TR3 to TS11716. |   |          |
| 19 | FLEXIBLE STRAP                   | 1 | GEX7359  |
| 20 | CLAMP PLATE                      | 2 | GEX7510  |
| 21 | SCREW, flexible strap            | 2 | SH605091 |
| 22 | NUT                              | 2 | GHF201   |
| 23 | WASHER, locking                  |   |          |
|    | TR2 to TS4309                    | 5 | GHF332   |
|    | TR2 from TS4310, TR3 to TS11716  | 4 | GHF332   |
| 24 | WASHER                           |   |          |
|    | TR2 to TS4309                    | 4 | GHF301   |
|    | TR2 from TS4310, TR3 to TS11716  | 3 | GHF301   |

## FRONT MOUNTING TR3 from TS11717, TR3A

|    |                        |   |          |
|----|------------------------|---|----------|
| 25 | CLAMP, one piece       | 1 | 114074   |
| 26 | SCREW, clamp assembly  | 1 | GHF103   |
| 27 | NUT, self-locking      | 3 | GHF242   |
| 28 | BUSH, in chassis       | 4 | GEX7329  |
| 29 | WASHER, plain          | 6 | RTC610A  |
| 30 | BOLT, clamp to chassis | 2 | BH605201 |

## FRONT MOUNTING TR4

|    |                            |   |          |
|----|----------------------------|---|----------|
| 31 | BRACKET, mounting          | 1 | 130888   |
| 32 | CLAMP                      | 1 | 130890   |
| 33 | SCREW, clamp to bracket    | 1 | GHF103   |
| 34 | WASHER, locking            | 1 | GHF332   |
| 35 | NUT                        | 1 | GHF201   |
| 36 | SCREW, to gearbox mounting | 1 | SH608141 |
| 37 | WASHER, locking            | 1 | GHF335   |

## INTERMEDIATE CLAMP TR2, TR3, TR3A, TR4

|    |                         |   |          |
|----|-------------------------|---|----------|
| 38 | CLAMP,                  |   |          |
|    | original pinch type     | 1 | GEX7500  |
|    | replacement U bolt type | 1 | GEX9009  |
| 39 | BOLT, clamp             | 1 | BH605221 |
| 40 | WASHER                  | 2 | GHF301   |
| 41 | WASHER, locking         | 1 | GHF332   |
| 42 | NUT                     | 1 | GHF201   |

## INTERMEDIATE MOUNTING TR4 from CT11454

|    |                           |   |         |
|----|---------------------------|---|---------|
| 43 | BRACKET, strap to exhaust | 1 | 105578  |
| 44 | FLEXIBLE STRAP            | 1 | GEX7359 |
| 45 | SCREW, flexible strap     | 2 | GHF103  |
| 46 | CLAMP PLATE               | 2 | GEX7510 |
| 47 | WASHER, locking           | 2 | GHF332  |
| 48 | NUT                       | 2 | GHF201  |

## REAR MOUNTING TR2, TR3, TR3A, TR4

|    |                       |   |          |
|----|-----------------------|---|----------|
| 49 | CLAMP, pinch type     | 1 | 107602   |
| 50 | BOLT, clamp           | 1 | BH605241 |
| 51 | FLEXIBLE STRAP        | 1 | GEX7359  |
| 52 | SCREW, flexible strap | 2 | GHF103   |
| 53 | CLAMP PLATE           | 2 | GEX7510  |
| 54 | WASHER                | 3 | GHF301   |
| 55 | WASHER, locking       | 3 | GHF332   |
| 56 | NUT                   | 3 | GHF201   |

Exhaust Fitting Kits  
- TR2, TR3, TR3A, TR4

|    |   |   |         |
|----|---|---|---------|
| 57 | EXHAUST FITTING KIT;                                      |   |         |
|    | comprehensive   | 1 | RW3056  |
|    | TR3 from TS11717, TR3A.                                   |   |         |
|    | Includes items 6-9, 25-30, 38-42, 49-56.                  |   |         |
| 58 | EXHAUST FITTING KIT;                                      |   |         |
|    | comprehensive   | 1 | RF4040K |
|    | TR4. Includes items 6-9, 31-56.                           |   |         |
|    | basic   | 1 | RF4040  |
|    | TR4. Includes items 6, 8, 9, 38 (replacement type),       |   |         |
|    | 39, 40, 49-54, 2 x nyloc nuts, exhaust jointing compound. |   |         |

Exhaust Standard System  
- TR4A Twin Box Exhaust, to CTC70488

## MILD STEEL

|                                    |                   |   |           |
|------------------------------------|-------------------|---|-----------|
|                                    | FULL SYSTEM       | 1 | RF4205MS  |
| The following parts are included:- |                   |   |           |
| 59                                 | FRONT DOWN PIPE   | 1 | GEX1255   |
| 60                                 | FRONT SILENCER    | 1 | GEX3205SS |
| 61                                 | LARGE 'Y' PIECE   | 1 | GEX1256   |
| 62                                 | REAR SILENCER, LH | 1 | GEX3207   |
| 63                                 | REAR SILENCER, RH | 1 | GEX3206   |

## STAINLESS STEEL

|                                    |                   |   |           |
|------------------------------------|-------------------|---|-----------|
|                                    | FULL SYSTEM       | 1 | RF4205SS  |
| The following parts are included:- |                   |   |           |
| 59                                 | FRONT DOWN PIPE   | 1 | GEX1255SS |
| 60                                 | FRONT SILENCER    | 1 | GEX3205SS |
| 61                                 | LARGE 'Y' PIECE   | 1 | GEX1256SS |
| 62                                 | REAR SILENCER, LH | 1 | GEX3207SS |
| 63                                 | REAR SILENCER, RH | 1 | GEX3206SS |

## MOUNTINGS &amp; FIXINGS TR4A to CTC70488

|    |                                |    |          |
|----|--------------------------------|----|----------|
| 64 | GASKET, manifold to front pipe | 1  | GEG724   |
| 65 | STUD, manifold to front pipe   | 4  | 115696   |
| 66 | WASHER, locking                | 4  | GHF333   |
| 67 | NUT, brass                     | 4  | 108951   |
| 68 | CLAMP, original pinch type     | 4  | GEX7506  |
| 69 | BOLT, clamp                    | 4  | BH605241 |
| 70 | WASHER                         | 12 | GHF301   |
| 71 | WASHER, locking                | 9  | GHF332   |
| 72 | NUT                            | 9  | GHF201   |
| 73 | BRACKET, mounting              | 1  | 142531   |
| 74 | CLAMP                          | 1  | 130890   |
| 75 | SCREW, clamp and straps        | 5  | GHF103   |
| 76 | FLEXIBLE STRAP                 | 2  | GEX7359  |
| 77 | CLAMP PLATE                    | 4  | GEX7510  |
| 78 | SLEEVE, distance               | 4  | 155249   |

Exhaust Fitting Kit  
- TR4A Twin Box Exhaust, to CTC70488

|    |   |   |         |
|----|---|---|---------|
| 79 | EXHAUST FITTING KIT;  |   |         |
|    | comprehensive   | 1 | RF4042K |
|    | Includes items 64-78.   |   |         |
|    | basic   | 1 | RF4042  |
|    | Includes items 64, 66-69, 71 (8 off), 72 (4 off), 75 (4 off), |   |         |
|    | 76, 77, 4 x nyloc nuts, exhaust jointing compound.            |   |         |

Exhaust Standard System  
- TR4A Cross Box Exhaust, from CTC70489

## MILD STEEL

|                                    |                   |   |          |
|------------------------------------|-------------------|---|----------|
|                                    | FULL SYSTEM       | 1 | RF4043MS |
| The following parts are included:- |                   |   |          |
| 80                                 | FRONT DOWN PIPE   | 1 | GEX1255  |
| 81                                 | FRONT 'Y' PIECE   | 1 | GEX1257  |
| 82                                 | INTERMEDIATE PIPE | 1 | GEX1258  |
| 83                                 | REAR SILENCER     | 1 | GEX3208  |

## STAINLESS STEEL

|                                    |                   |   |           |
|------------------------------------|-------------------|---|-----------|
|                                    | FULL SYSTEM       | 1 | RF4043SS  |
| The following parts are included:- |                   |   |           |
| 80                                 | FRONT DOWN PIPE   | 1 | GEX1255SS |
| 81                                 | FRONT 'Y' PIECE   | 1 | GEX1257SS |
| 82                                 | INTERMEDIATE PIPE | 1 | GEX1258SS |
| 83                                 | REAR SILENCER     | 1 | GEX3208SS |

## MOUNTINGS &amp; FIXINGS TR4A from CTC70489

|     |                                |    |          |
|-----|--------------------------------|----|----------|
| 84  | GASKET, manifold to front pipe | 1  | GEG724   |
| 85  | STUD, manifold to front pipe   | 4  | 115696   |
| 86  | WASHER, locking                | 4  | GHF333   |
| 87  | NUT, brass                     | 4  | 108951   |
| 88  | CLAMP, original pinch type     | 2  | GEX7506  |
| 89  | BOLT, clamp                    | 3  | BH605241 |
| 90  | WASHER                         | 10 | GHF301   |
| 91  | WASHER, locking                | 8  | GHF332   |
| 92  | NUT                            | 8  | GHF201   |
| 93  | BRACKET, mounting              | 1  | 142531   |
| 94  | CLAMP                          | 1  | 130890   |
| 95  | SCREW, clamp and straps        | 5  | GHF103   |
| 96  | FLEXIBLE STRAP                 | 1  | GEX7360  |
| 97  | CLAMP PLATE                    | 6  | GEX7510  |
| 98  | BRACKET, angled                | 1  | 105578   |
| 99  | CLAMP, original pinch type     | 1  | GEX7500  |
| 100 | FLEXIBLE STRAP                 | 1  | GEX7359  |
| 101 | SLEEVE, distance               | 4  | 155249   |

Exhaust Fitting Kit  
- TR4A Cross Box Exhaust, from CTC70489

|     |   |   |         |
|-----|---|---|---------|
| 102 | EXHAUST FITTING KIT;                              |   |         |
|     | comprehensive                                     | 1 | RF4044K |
|     | Includes items 84-101.                            |   |         |
|     | basic   | 1 | RF4044  |
|     | Includes items 84, 86-90, 95-100, 8 x nyloc nuts, |   |         |
|     | exhaust jointing compound.                        |   |         |

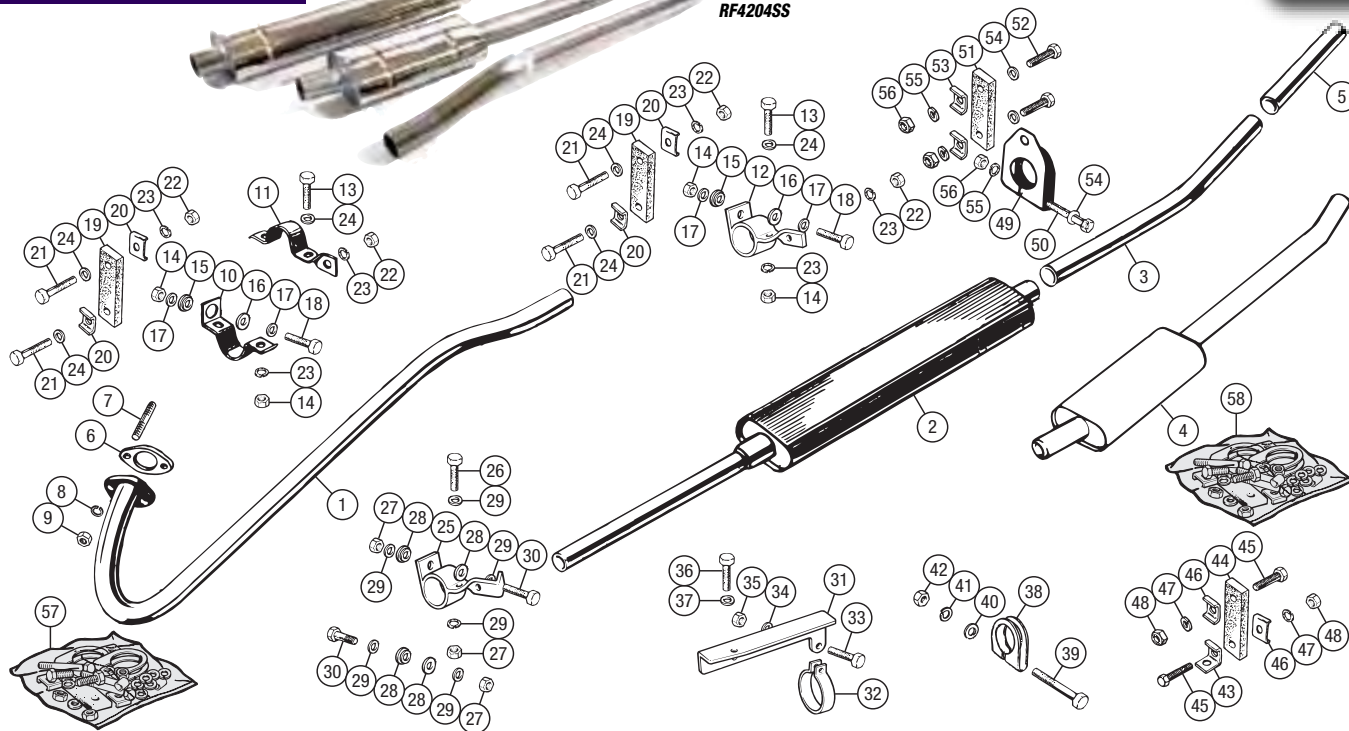


# TR2, TR3, TR3A, TR4

STAINLESS STEEL  
STANDARD SYSTEM -  
RF4204SS

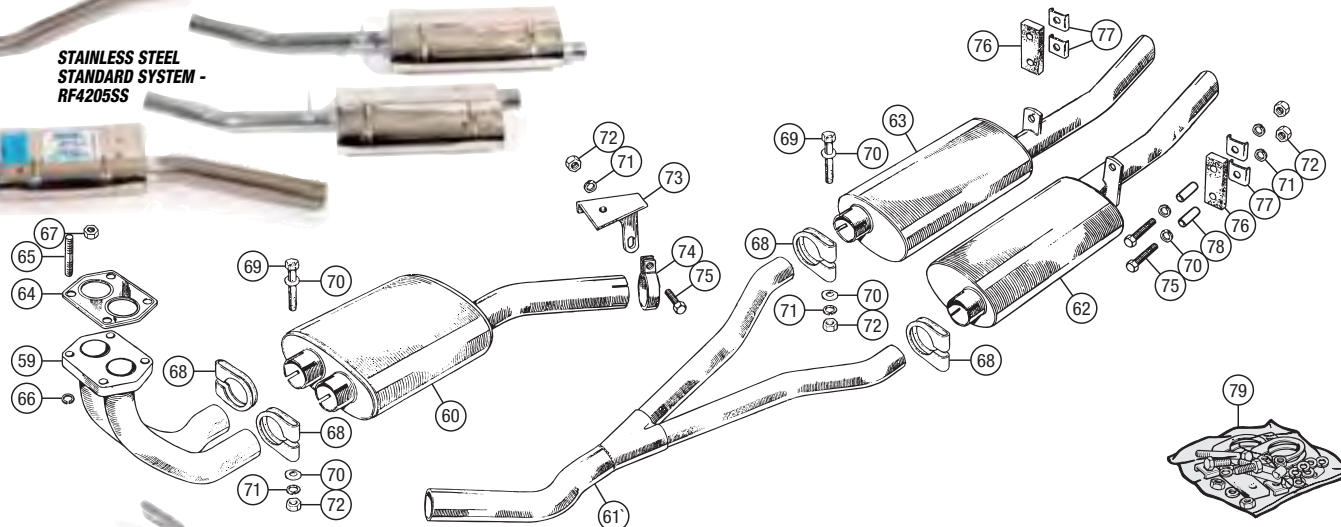
# TR2-4A

EXHAUST - STANDARD - 4 cylinder - TR2-4A



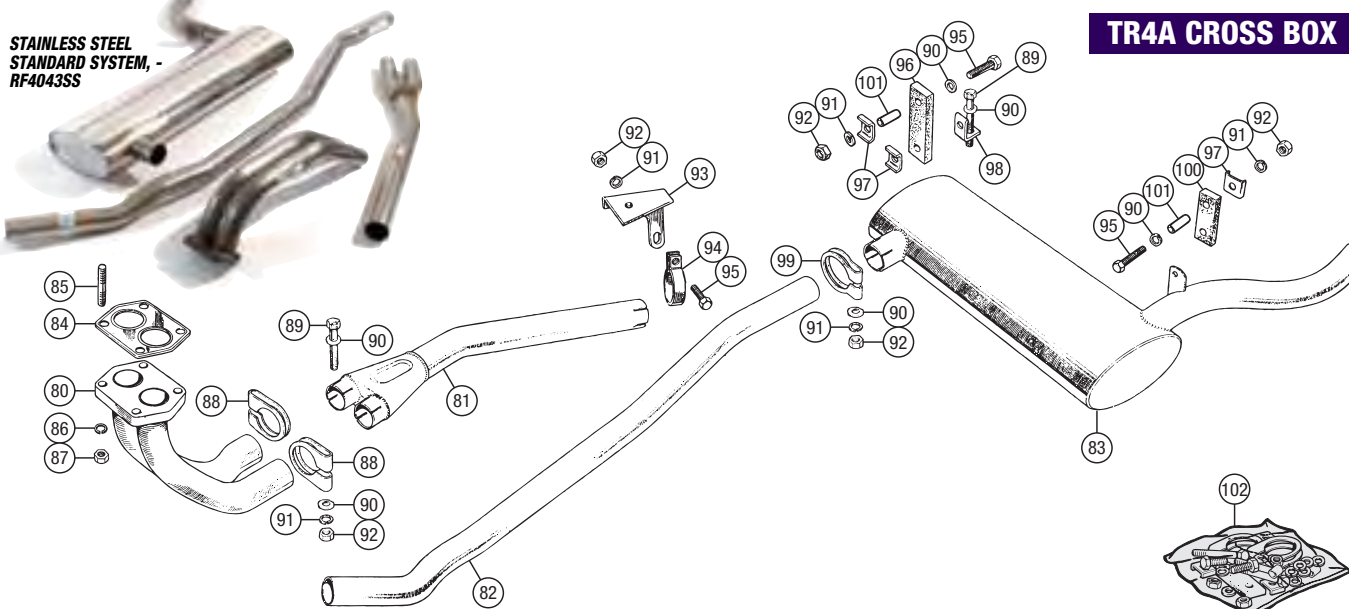
# TR4A TWIN BOX

STAINLESS STEEL  
STANDARD SYSTEM -  
RF4205SS



STAINLESS STEEL  
STANDARD SYSTEM, -  
RF4043SS

# TR4A CROSS BOX





| No. | DESCRIPTION | QTY REQ. | PART No. | No. | DESCRIPTION | QTY REQ. | PART No. | No. | DESCRIPTION | QTY REQ. | PART No. |
|-----|-------------|----------|----------|-----|-------------|----------|----------|-----|-------------|----------|----------|
|-----|-------------|----------|----------|-----|-------------|----------|----------|-----|-------------|----------|----------|

**TR5-250****Exhaust Standard Systems  
- TR5****MILD STEEL**

EXHAUST SYSTEM, mild steel 1 **RR1115MS**  
*6 pieces.*

**The following parts are included:-**

|   |                              |   |                |
|---|------------------------------|---|----------------|
| 1 | DOWNPIPE                     | 1 | <b>GEX1255</b> |
| 2 | INTERMEDIATE PIPE, front, LH | 1 | <b>GEX1270</b> |
| 3 | INTERMEDIATE PIPE, front, RH | 1 | <b>GEX1269</b> |
| 4 | INTERMEDIATE PIPE, rear      | 2 | <b>GEX1271</b> |
| 5 | SILENCER AND TAILPIPE        | 1 | <b>GEX3391</b> |

**STAINLESS STEEL**

EXHAUST SYSTEM, stainless steel 1 **RR1115SS**  
*6 pieces.*

**The following parts are included:-**

|   |                              |   |                  |
|---|------------------------------|---|------------------|
| 1 | DOWNPIPE                     | 1 | <b>GEX1255SS</b> |
| 2 | INTERMEDIATE PIPE, front, LH | 1 | <b>GEX1270SS</b> |
| 3 | INTERMEDIATE PIPE, front, RH | 1 | <b>GEX1269SS</b> |
| 4 | INTERMEDIATE PIPE, rear      | 2 | <b>GEX1271SS</b> |
| 5 | SILENCER AND TAILPIPE        | 1 | <b>GEX3391SS</b> |

|   |   |   |                 |
|---|---|---|-----------------|
| 6 | EXHAUST FITTING KIT<br><i>Includes items; 8-15, 17-20, 22-40 &amp; exhaust jointing compound.</i> | 1 | <b>RR1115FK</b> |
|---|---|---|-----------------|

|    |                            |   |                 |
|----|----------------------------|---|-----------------|
| 7  | STUD, downpipe to manifold | 4 | <b>115696</b>   |
| 8  | GASKET, downpipe           | 1 | <b>GEG724</b>   |
| 9  | WASHER, locking            | 4 | <b>GHF333</b>   |
| 10 | NUT, brass                 | 4 | <b>108951</b>   |
| 11 | CLAMP, exhaust pipe        | 4 | <b>GEX7506</b>  |
| 12 | BOLT, exhaust pipe clamp   | 4 | <b>BH605241</b> |
| 13 | WASHER, plain              | 8 | <b>GHF301</b>   |
| 14 | WASHER, locking            | 4 | <b>GHF332</b>   |
| 15 | NUT                        | 4 | <b>GHF201</b>   |

|    |   |   |               |
|----|---|---|---------------|
| 16 | BRACKET, gearbox mounting to front intermediate pipes | 1 | <b>148875</b> |
|----|---|---|---------------|

|    |                                  |   |                 |
|----|----------------------------------|---|-----------------|
| 17 | SCREW, intermediate pipe bracket | 1 | <b>GHF103</b>   |
| 18 | WASHER, plain                    | 1 | <b>GHF301</b>   |
| 19 | WASHER, locking                  | 1 | <b>GHF332</b>   |
| 20 | NUT                              | 1 | <b>GHF201</b>   |
| 21 | BRACKET, rear exhaust mounting   | 1 | <b>148871</b>   |
| 22 | CLAMP, exhaust pipe              | 2 | <b>GEX7506</b>  |
| 23 | BOLT, exhaust pipe clamp         | 2 | <b>BH605241</b> |
| 24 | WASHER, plain                    | 4 | <b>GHF301</b>   |
| 25 | WASHER, locking                  | 2 | <b>GHF332</b>   |
| 26 | NUT                              | 2 | <b>GHF201</b>   |

|    |  |   |                |
|----|--|---|----------------|
| 27 | FLEXIBLE STRAP, rear mounting bracket to chassis<br><i>3" between screw holes.</i> | 1 | <b>GEX7360</b> |
|----|--|---|----------------|

|    |   |   |                |
|----|---|---|----------------|
| 28 | SCREW, securing flexible strap  | 2 | <b>GHF103</b>  |
| 29 | WASHER, plain   | 2 | <b>GHF301</b>  |
| 30 | SLEEVE, distance, in flexible strap                                       | 2 | <b>155249</b>  |
| 31 | PLATE, reinforcing flexible strap   | 2 | <b>GEX7510</b> |
| 32 | WASHER, locking   | 2 | <b>GHF332</b>  |
| 33 | NUT   | 2 | <b>GHF201</b>  |
| 34 | FLEXIBLE STRAP, silencer to chassis<br><i>1 1/2" between screw holes.</i> | 1 | <b>GEX7359</b> |

|    |                                     |   |                |
|----|-------------------------------------|---|----------------|
| 35 | SCREW, securing flexible strap      | 2 | <b>GHF103</b>  |
| 36 | WASHER, plain                       | 2 | <b>GHF301</b>  |
| 37 | SLEEVE, distance, in flexible strap | 2 | <b>155249</b>  |
| 38 | PLATE, reinforcing flexible strap   | 2 | <b>GEX7510</b> |
| 39 | WASHER, locking                     | 2 | <b>GHF332</b>  |
| 40 | NUT                                 | 2 | <b>GHF201</b>  |

**Exhaust Standard Systems  
- TR250****MILD STEEL**

EXHAUST SYSTEM, mild steel 1 **RR1167MS**  
*3 pieces.*

**The following parts are included:-**

|    |                     |   |                |
|----|---------------------|---|----------------|
| 41 | DOWNPIPE            | 1 | <b>GEX1268</b> |
| 42 | INTERMEDIATE PIPE   | 1 | <b>GEX1258</b> |
| 43 | SILENCER & TAILPIPE | 1 | <b>308724</b>  |

**STAINLESS STEEL**

EXHAUST SYSTEM, stainless steel 1 **RR1167SS**  
*3 pieces.*

**The following parts are included:-**

|    |                     |   |                  |
|----|---------------------|---|------------------|
| 41 | DOWNPIPE            | 1 | <b>GEX1268SS</b> |
| 42 | INTERMEDIATE PIPE   | 1 | <b>GEX1258SS</b> |
| 43 | SILENCER & TAILPIPE | 1 | <b>308724SS</b>  |

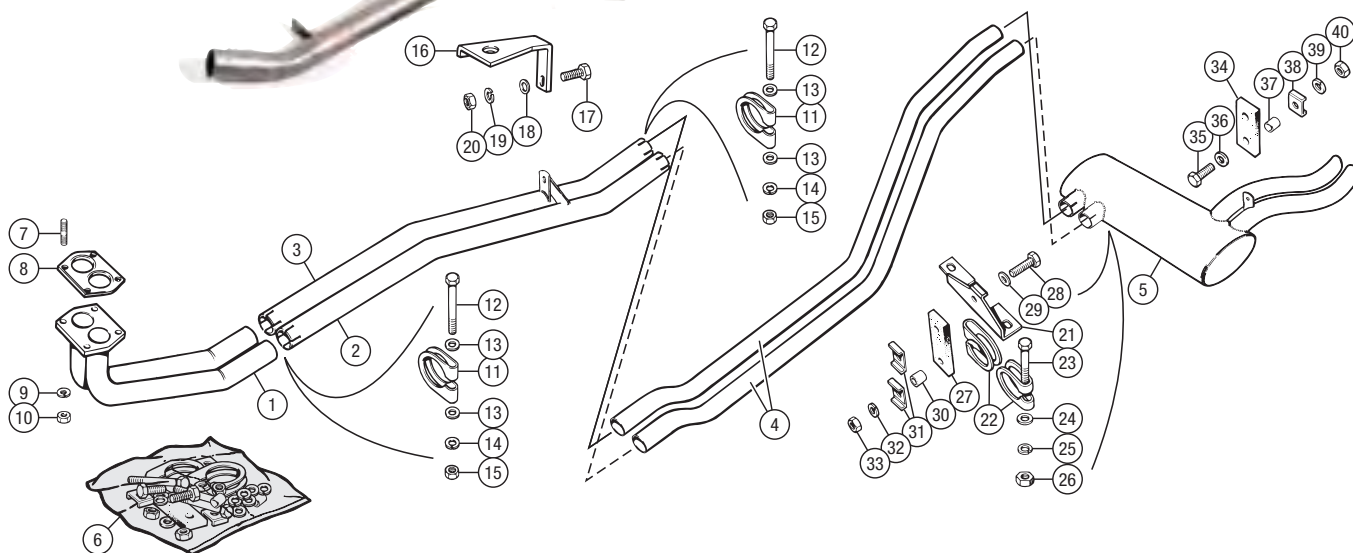
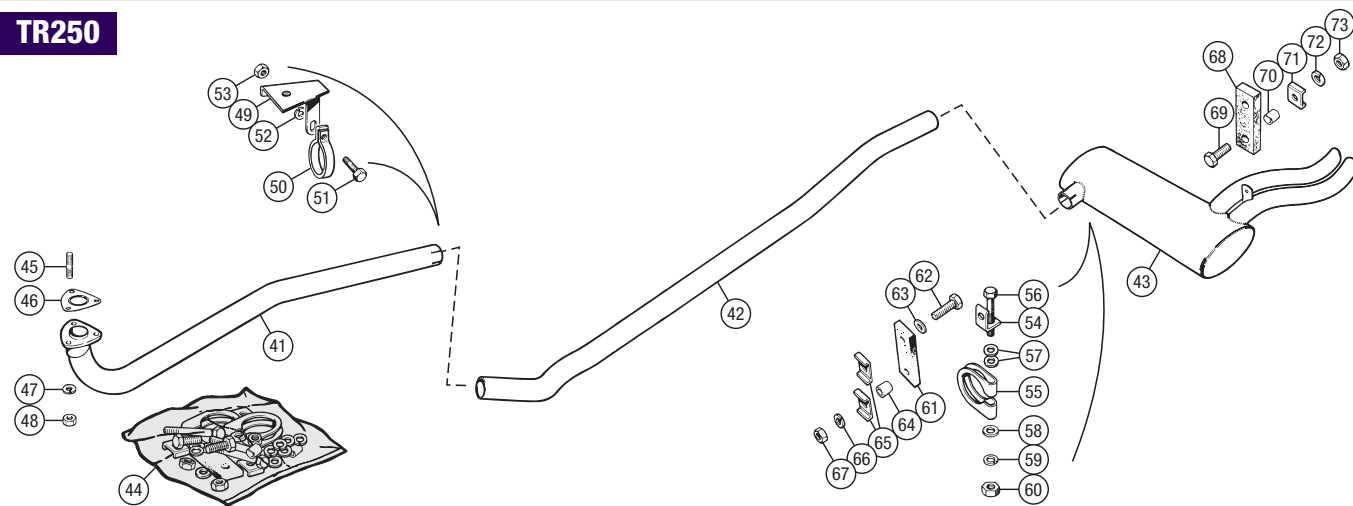
STAINLESS STEEL  
STANDARD SYSTEM,  
TR250 - RR1167SS



|    |   |   |                 |
|----|---|---|-----------------|
| 44 | EXHAUST FITTING KIT<br><i>Includes items; 46-48, 50-73 &amp; exhaust jointing compound.</i> | 1 | <b>RR1167FK</b> |
| 45 | STUD, downpipe to manifold  | 3 | <b>115696</b>   |
| 46 | GASKET, downpipe  | 1 | <b>GEG718</b>   |
| 47 | WASHER, locking   | 3 | <b>GHF333</b>   |
| 48 | NUT, brass  | 3 | <b>108951</b>   |
| 49 | BRACKET, gearbox mounting to intermediate pipe<br><i>original TR250 item</i>                | 1 | <b>149450</b>   |
|    | <i>TR4A type alternative</i>  | 1 | <b>142531</b>   |
| 50 | CLAMP, exhaust pipe to gearbox bracket  | 1 | <b>130890</b>   |
| 51 | BOLT, exhaust pipe clamp to bracket   | 1 | <b>BH605101</b> |
| 52 | WASHER, locking   | 1 | <b>GHF332</b>   |
| 53 | NUT   | 1 | <b>GHF201</b>   |
| 54 | BRACKET, intermediate pipe clamp to flexible mounting                                       | 1 | <b>105578</b>   |
| 55 | CLAMP, exhaust pipe   | 1 | <b>GEX7500</b>  |
| 56 | BOLT, bracket to clamp.   | 1 | <b>BH605241</b> |
| 57 | WASHER, plain   | 2 | <b>WP129</b>    |
| 58 | WASHER, plain   | 1 | <b>GHF301</b>   |
| 59 | WASHER, locking   | 1 | <b>GHF332</b>   |
| 60 | NUT   | 1 | <b>GHF201</b>   |
| 61 | FLEXIBLE STRAP, rear mounting bracket to chassis<br><i>3" between screw holes.</i>          | 1 | <b>GEX7360</b>  |
| 62 | SCREW, securing flexible strap  | 2 | <b>GHF103</b>   |
| 63 | WASHER, plain   | 2 | <b>GHF301</b>   |
| 64 | SLEEVE, distance, in flexible strap   | 2 | <b>155249</b>   |
| 65 | PLATE, reinforcing flexible strap   | 2 | <b>GEX7510</b>  |
| 66 | WASHER, locking   | 2 | <b>GHF332</b>   |
| 67 | NUT   | 2 | <b>GHF201</b>   |
| 68 | FLEXIBLE STRAP, silencer tailpipes<br><i>1 1/2" between screw holes.</i>                    | 1 | <b>GEX7359</b>  |
| 69 | SCREW, securing flexible strap  | 2 | <b>GHF103</b>   |
| 70 | SLEEVE, distance, in flexible strap   | 2 | <b>155249</b>   |
| 71 | PLATE, reinforcing flexible strap   | 2 | <b>GEX7510</b>  |
| 72 | WASHER, locking   | 2 | <b>GHF332</b>   |
| 73 | NUT   | 2 | <b>GHF201</b>   |





**TR5****MILD STEEL STANDARD  
SYSTEM, TR5 -  
RR1115MS****TR5-250****EXHAUST - STANDARD - 6 cylinder - TR5-250****TR250****ORDER** BY PHONE: 01522 568000 / ON LINE: [www.rimmerbros.co.uk](http://www.rimmerbros.co.uk) / E-MAIL: [sales@rimmerbros.co.uk](mailto:sales@rimmerbros.co.uk)



## TR2-4A

### Exhaust Manifold (Sports)

**NOTE:-** Uses standard gaskets and manifold fittings. The Rimmer Bros stainless steel tubular extractor manifold is designed to improve exhaust efficiency through its gas flowed 4 into 1 style. It allows the engine to rev more freely and improve bhp. It will only fit engines fitted with high port cylinder heads - in other words cylinder heads originally fitted on TR3s from TS13052E, TR3As, TR4s and TR4As - and will not fit around the earlier 'bomb' type starter motor original to TR2s, TR3s and TR3As to TS50000.



- |   |   |   |               |
|---|---|---|---------------|
| 1 | TUBULAR MANIFOLD, sports, stainless steel     | 1 | <b>RF4075</b> |
| 2 | GASKET, manifold to cylinder head             | 2 | <b>113122</b> |
| 3 | STUD, manifold;                               |   |               |
|   | 2 1/16", upper                                | 4 | <b>102474</b> |
|   | 2 3/8", upper centre                          | 2 | <b>107055</b> |
|   | 1 11/16", lower front                         | 1 | <b>58688</b>  |
|   | 1 11/16", lower rear                          | 1 | <b>58688</b>  |
|   | Without engine lifting eye fitted.            |   |               |
|   | 1 15/16", lower rear                          | 1 | <b>58917</b>  |
|   | With engine lifting eye fitted.               |   |               |
| 4 | CLAMP, manifold, large                        | 2 | <b>33148</b>  |
| 5 | CLAMP, manifold, small                        | 4 | <b>58258</b>  |
| 6 | WASHER, locking, manifold                     | 8 | <b>GHF333</b> |
| 7 | NUT, manifold;                                |   |               |
|   | steel   | 8 | <b>56675</b>  |
|   | brass   | 8 | <b>108951</b> |
| 8 | DOWEL, plain, inlet manifold to cylinder head | 2 | <b>DP514</b>  |

### INSULATING HEAT WRAP

#### For Tubular Manifolds

Thermo-Tec Insulating Wrap gives safety with Performance. Tubular manifolds by design produce a vast amount of heat in the engine compartment. This increases the possibility of electrical/ignition components not working effectively and promotes a higher risk of fire (if any combustible material comes into contact with the manifold), not to mention the likelihood of severe burns when working on the engine!

By wrapping your tubular manifold with Thermo-Tec insulating wrap you can overcome all these risk factors.

Thermo-Tec keeps the heat within the manifold so the exhaust gases have a much higher velocity; this induces negative pressure (scavenging) which increases air intake flow, resulting in better performance and economy.

#### Technical Notes:

Thermo-Tec heat wrap - which is race and rally proven - comes in rolls 2" wide x 50ft long (one roll is sufficient for most 4 cylinder manifolds, two rolls are required for 6 cylinder manifolds) and moulds to the contours of the manifold. Being a silica based fabric (it does not contain asbestos or carcinogens) it is unaffected by oil or water, withstands temperatures up to 1000 degrees Celsius and reduces under-bonnet temperatures by up to 70%.

#### SNAP-STRAP RETAINING KIT

We strongly recommend that you use Snap-Straps to retain the insulation. These are stainless steel straps with a narrow profile (for tight spots) that you cut to length and fasten with snap type heads. Alternatively you can skin your knuckles and use hose clips!

#### HY-COTE PAINT

Preserves and protects the exhaust wrap after installation. Extra resins and binders seal the pores, toughen the surface and help extend the life of the wrap.

THERMO-TEC INSULATING WRAP 1 **RX1382**  
2" x 50' roll.

THERMO-TEC SNAP-STRAP KIT 1 **RX1383**  
Stainless steel.

HY-COTE PAINT, aerosol, black (400ml) 1 **RX1432A**

## Exhaust System (Sports)

### STAINLESS STEEL

We offer either big bore full sports exhaust systems including the high port type tubular manifold or standard bore sports systems designed to use with the car's original cast manifold/downpipe.

#### SYSTEM A

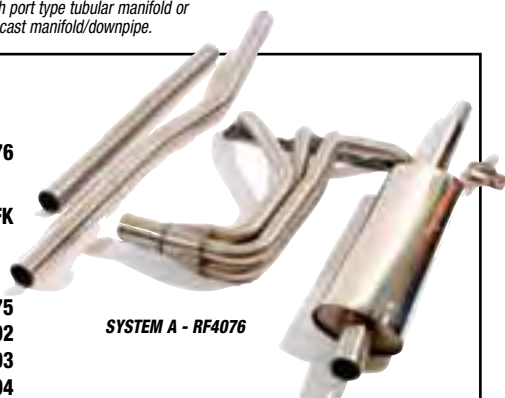
##### TR3 from TS13052E, TR3A, TR4; with single sports rear silencer

FULL SPORTS EXHAUST SYSTEM 1 **RF4076**  
Excludes fitting kit. Includes tubular manifold (see note), big bore intermediate pipes and single sports rear silencer.

9 FITTING KIT, for above 1 **RF4076FK**  
Excludes manifold studs.

##### Components included in System A:

10 TUBULAR MANIFOLD, sports, stainless steel (see note) 1 **RF4075**  
11 INTERMEDIATE PIPE, front, big bore 1 **TH402**  
12 INTERMEDIATE PIPE, rear, big bore 1 **TH403**  
13 SPORTS SILENCER, big bore 1 **TH404**



SYSTEM A - RF4076

#### SYSTEM B

##### TR4A; with twin sports rear silencers

FULL SPORTS EXHAUST SYSTEM 1 **RF4077**  
Excludes fitting kit. Includes tubular manifold, big bore intermediate and Y pipes and twin sports rear silencers.

14 FITTING KIT, for above 1 **RF4077FK**  
Excludes manifold studs.

##### Components included in System B:

15 TUBULAR MANIFOLD, sports, stainless steel 1 **RF4075**  
16 INTERMEDIATE PIPE, front, big bore 1 **TH408**  
17 Y-PIPE, rear, big bore 1 **TH409**  
18 SPORTS SILENCER, big bore 2 **TH73P**



SYSTEM B - RF4077

#### SYSTEM C

##### TR4A; with single sports rear silencer

FULL SPORTS EXHAUST SYSTEM 1 **RF4078**  
Excludes fitting kit. Includes tubular manifold, big bore intermediate pipe and single sports rear silencer.

19 FITTING KIT, for above 1 **RF4078FK**  
Excludes manifold studs.

##### Components included in System C:

20 TUBULAR MANIFOLD, sports, stainless steel 1 **RF4075**  
21 INTERMEDIATE PIPE, big bore 1 **TH407**  
22 SPORTS SILENCER, big bore 1 **RR1400C**



SYSTEM C - RF4078

#### SYSTEM D

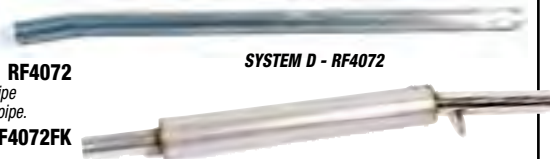
##### TR2, TR3, TR3A, TR4; with single sports rear silencer

SPORTS EXHAUST SYSTEM 1 **RF4072**  
Excludes fitting kit. Includes std. bore intermediate pipe and single sports rear silencer. Fits to standard downpipe.

23 FITTING KIT, for above 1 **RF4072FK**

##### Components included in System D:

24 INTERMEDIATE PIPE, std. bore 1 **FSTT5003**  
25 SPORTS SILENCER, std. bore 1 **FSTT5002**



SYSTEM D - RF4072

#### SYSTEM E

##### TR4A; with twin sports rear silencers

SPORTS EXHAUST SYSTEM 1 **RF4073**  
Excludes fitting kit. Includes std. bore Y pipes and twin sports rear silencers. Fits to standard downpipe.

26 FITTING KIT, for above 1 **RF4073FK**

##### Components included in System E:

27 Y-PIPE, front, std. bore 1 **GEX1257SS**  
28 Y-PIPE, rear, std. bore 1 **GEX1256SS**  
29 SPORTS SILENCER, std. bore 2 **TT5409**



SYSTEM E - RF4073

#### SYSTEM F

##### TR4A; with single sports rear silencer

SPORTS EXHAUST SYSTEM 1 **RF4074**  
Excludes fitting kit. Includes std. bore Y and intermediate pipes and single sports rear silencer. Fits to standard downpipe.

30 FITTING KIT, for above 1 **RF4074FK**

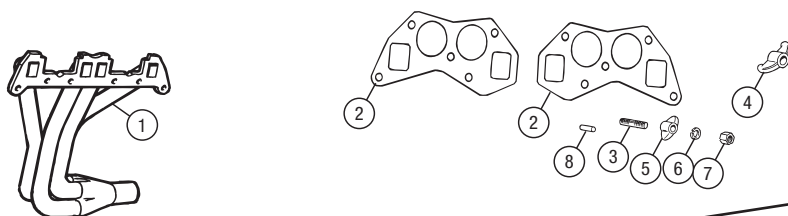
##### Components included in System F:

31 Y-PIPE, front, std. bore 1 **GEX1257SS**  
32 INTERMEDIATE PIPE, rear, std. bore 1 **FSTT5103**  
33 SPORTS SILENCER, std. bore 1 **FSTT5002**

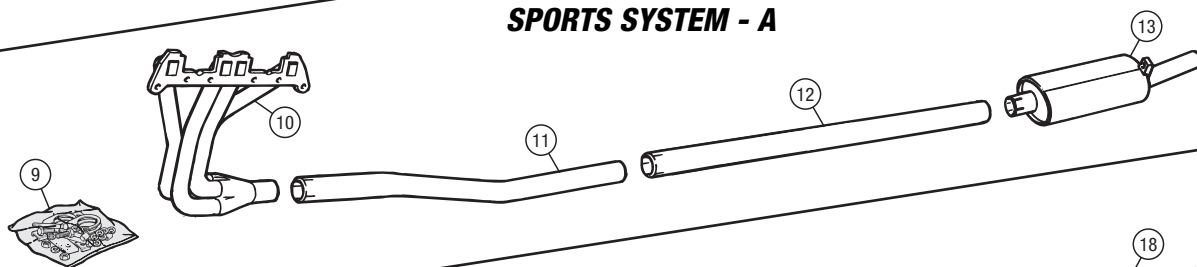


SYSTEM F - RF4074

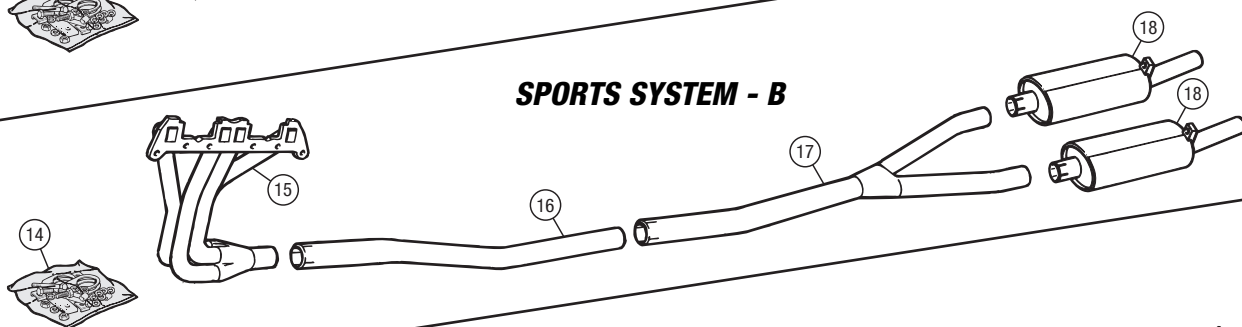




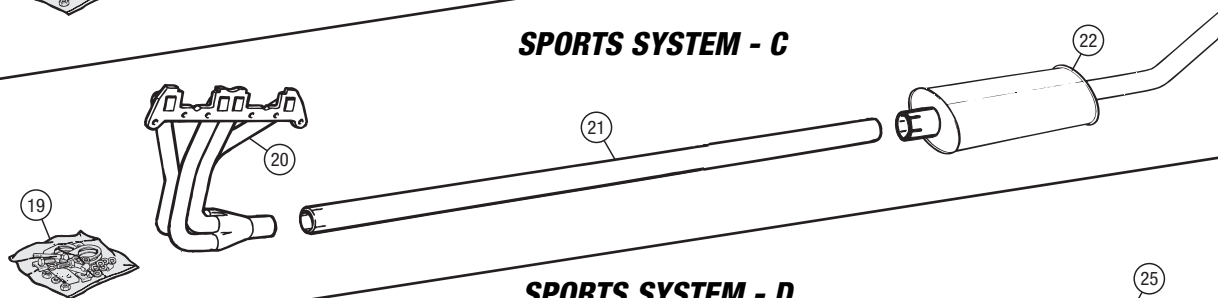
**SPORTS SYSTEM - A**



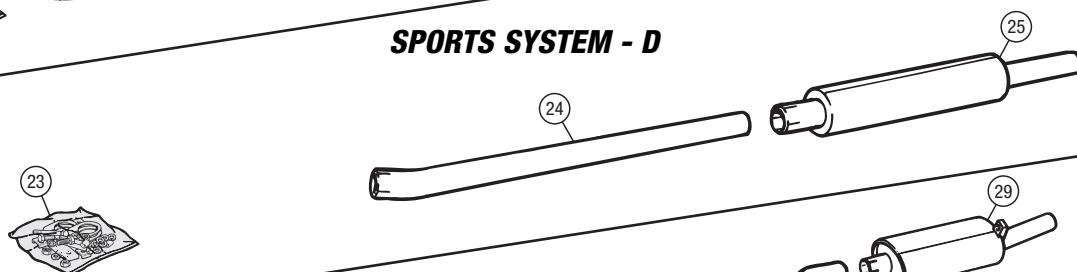
**SPORTS SYSTEM - B**



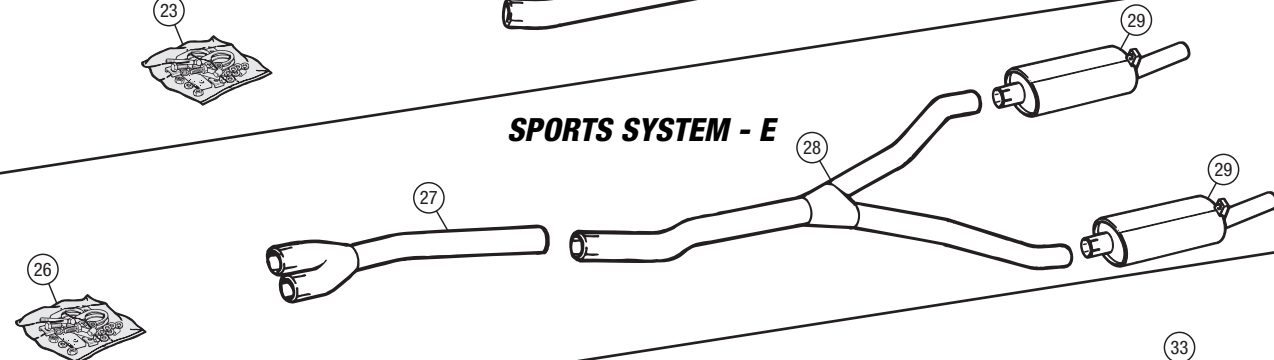
**SPORTS SYSTEM - C**



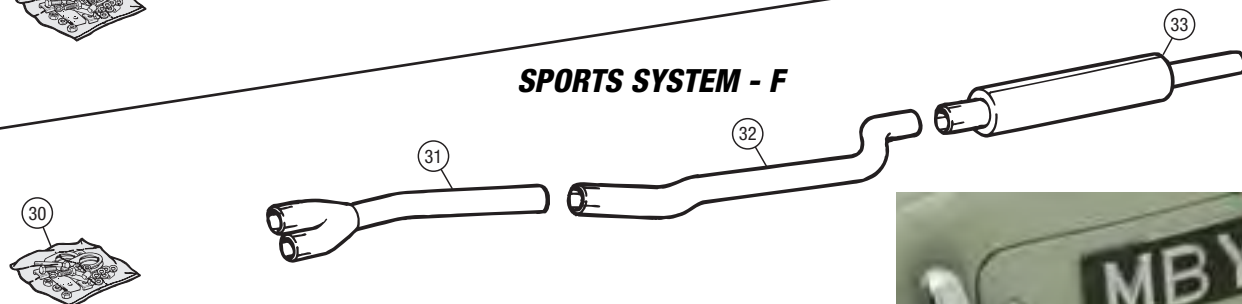
**SPORTS SYSTEM - D**



**SPORTS SYSTEM - E**



**SPORTS SYSTEM - F**





## TR5-250

### Exhaust Manifold (Sports)

#### STAINLESS STEEL

The Rimmer Bros stainless steel tubular extractor manifolds are designed to improve exhaust efficiency. They allow the engine to rev more freely and improve bhp. We offer two designs with different pipework configurations. See also 'Sports Exhaust System'.



- 1 TUBULAR MANIFOLD, (2 sets of pipes, 3 into 1), can be fitted to either the standard exhaust system or the 'Sports' twin exhaust system. Note:- Will not fit standard TR250 system, refer to Full Sports Systems A, B or D. 1 **RR1154SS**



- 2 TUBULAR MANIFOLD, (6 into 3 into 1), designed for use with 'Sports' systems only, either twin or single exit. Note:- Will not fit standard TR250 system, refer to Full Sports Systems A, B or D. 1 **RR1400A**
- 3 GASKET, exhaust/inlet manifold  
TR5 1 **GEG682**  
TR250 1 **213641**
- 4 STUD, manifold to head 4 **105124**
- 5 STUD, manifold to head 6 **105125**
- 6 CLAMP, manifold securing 6 **58258**
- 7 WASHER, locking 10 **GHF333**
- 8 NUT 10 **100498**

### INSULATING HEAT WRAP

#### For Tubular Manifolds

Thermo-Tec Insulating Wrap gives safety with Performance Tubular manifolds by design produce a vast amount of heat in the engine compartment. This increases the possibility of electrical/ignition components not working effectively and promotes a higher risk of fire (if any combustible material comes into contact with the manifold), not to mention the likelihood of severe burns when working on the engine!

By wrapping your tubular manifold with Thermo-Tec insulating wrap you can overcome all these risk factors.

Thermo-Tec keeps the heat within the manifold so the exhaust gases have a much higher velocity; this induces negative pressure (scavenging) which increases air intake flow, resulting in better performance and economy.

#### Technical Notes:

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#### SNAP-STRAP RETAINING KIT

We strongly recommend that you use Snap-Straps to retain the insulation. These are stainless steel straps with a narrow profile (for tight spots) that you cut to length and fasten with snap type heads. Alternatively you can skin your knuckles and use hose clips!

#### HY-COTE PAINT

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THERMO-TEC INSULATING WRAP 1 **RX1382**  
2" x 50' roll.

THERMO-TEC SNAP-STRAP KIT 1 **RX1383**  
Stainless steel.

HY-COTE PAINT, aerosol, black (400ml) 1 **RX1432A**

We offer two arrangements of stainless steel sports exhaust system - either a twin rear box system coupling to the standard manifold or one of two tubular manifolds - or a single pipe / single rear box big bore race type system coupling to a special tubular manifold.

### Exhaust System (Sports) Twin Rear Silencer

These systems (A, B & C) use twin stainless steel rear silencers (exiting equi-distant from the centre rear of the car) and twin pipework coupling to either the standard manifold or one of two tubular manifolds depending on the system purchased.

#### SYSTEM A (TR5, TR250)

Full, Twin Sports Exhaust System 1 **RR1373SS**  
(Excludes fitting kit) Includes stainless steel tubular manifold, (2 sets of pipes, 3 into 1) intermediate pipes and twin rear silencers.

9 Fitting Kit for above 1 **RR1373FK**  
Note: for studs & fixings, refer to items nos 3-8.

#### Individual Components - SYSTEM A

- 10 TUBULAR MANIFOLD 1 **RR1154SS**  
2 sets of pipes 3 into 1.
- 11 INTERMEDIATE PIPE, front, LH 1 **TH77S**
- 12 INTERMEDIATE PIPE, front, RH 1 **TH76S**
- 13 INTERMEDIATE PIPE, rear, LH 1 **TH72**
- 14 INTERMEDIATE PIPE, rear, RH 1 **TH71**
- 15 SILENCER AND TAILPIPE 2 **TH73**



SYSTEM A - RR1373SS

#### SYSTEM B (TR5, TR250)

Full, Twin Sports Exhaust System 1 **RR1509SS**  
(Excludes fitting kit) Includes special stainless steel tubular manifold, (6 into 3 into 1), Y-piece, intermediate pipes and twin rear silencers.

16 Fitting Kit for above 1 **RR1509FK**  
Note: for studs & fixings, refer to items nos 3-8.

#### Individual Components - SYSTEM B

- 17 TUBULAR MANIFOLD 1 **RR1400A**  
6 into 3 into 1.
- 18 Y-PIPE 1 **RR1508**
- 19 INTERMEDIATE PIPE, rear, LH 1 **TH72**
- 20 INTERMEDIATE PIPE, rear, RH 1 **TH71**
- 21 SILENCER AND TAILPIPE 2 **TH73**



SYSTEM B - RR1509SS

#### SYSTEM C (TR5)

Twin Sports Exhaust System **RR1153SS**  
(Excludes fitting kit) less manifold. Includes standard stainless steel downpipe, intermediate pipes and twin rear silencers.  
Note:- Will not fit standard TR250 manifold.

22 Fitting Kit for above 1 **RR1153FK**

#### Individual Components - SYSTEM C

- 23 FRONT DOWNPIPE 1 **GEX1255SS**
- 24 INTERMEDIATE PIPE, front, LH 1 **TH77S**
- 25 INTERMEDIATE PIPE, front, RH 1 **TH76S**
- 26 INTERMEDIATE PIPE, rear, LH 1 **TH72**
- 27 INTERMEDIATE PIPE, rear, RH 1 **TH71**
- 28 SILENCER AND TAILPIPE 2 **TH73**

#### Additional Components - SYSTEM C

- 29 STUD, exhaust pipe to manifold 4 **115696**
- 30 GASKET, exhaust pipe 1 **GEG724**
- 31 WASHER, locking 4 **GHF333**
- 32 NUT, brass 4 **108951**



SYSTEM C - RR1153SS

### Exhaust System (Sports) Single Rear Silencer

This system (D) uses a specially developed stainless steel tubular extractor manifold (Designed as 6 into 3 into 1) which couples to a large bore single pipe system exiting at a race type silencer with an upswept and slash cut tailpipe (slightly off-centre at the rear of the car).  
All components made from top quality 304 stainless steel.



SYSTEM D - RR1400SS

#### SYSTEM D (TR5, TR250)

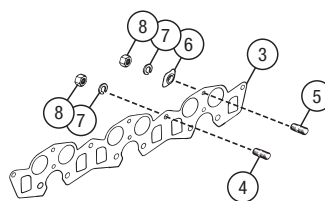
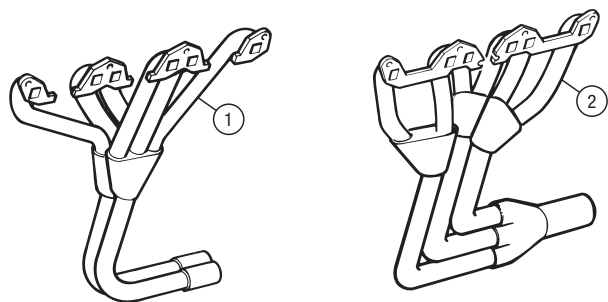
Full, Single Sports Large Bore System 1 **RR1400SS**  
(Excludes fitting kit) Includes stainless steel special tubular manifold (6 into 3 into 1), intermediate pipe and race type single rear silencer.

33 Fitting Kit for above 1 **RR1400FK**  
Note: for studs & fixings, refer to items nos 3-8.

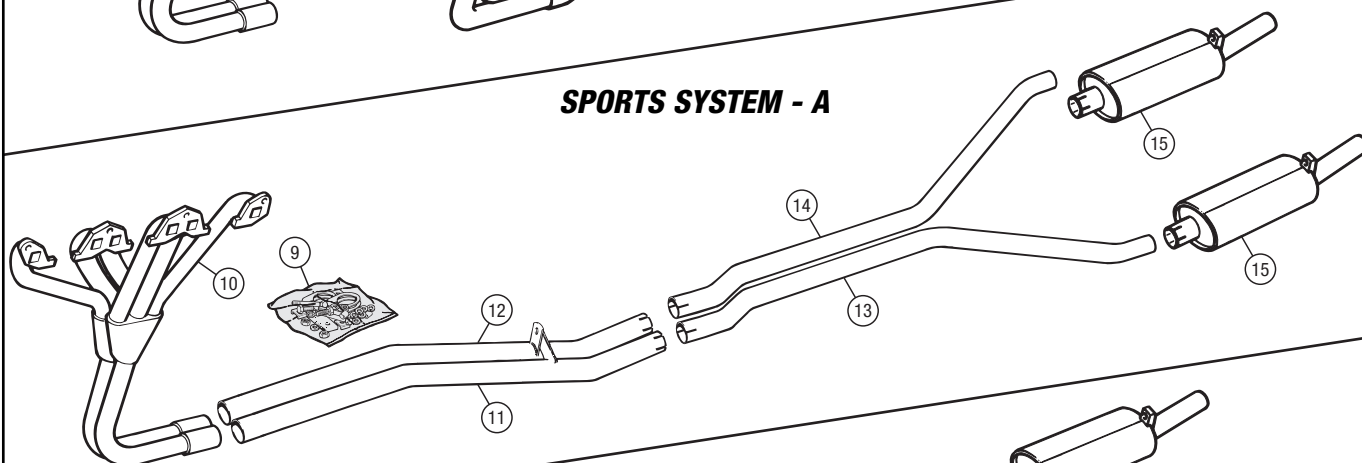
#### Individual Components - SYSTEM D

- 34 TUBULAR MANIFOLD (6 into 3 into 1) 1 **RR1400A**
- 35 INTERMEDIATE PIPE 1 **RR1400B**
- 36 SILENCER AND TAILPIPE 1 **RR1400C**

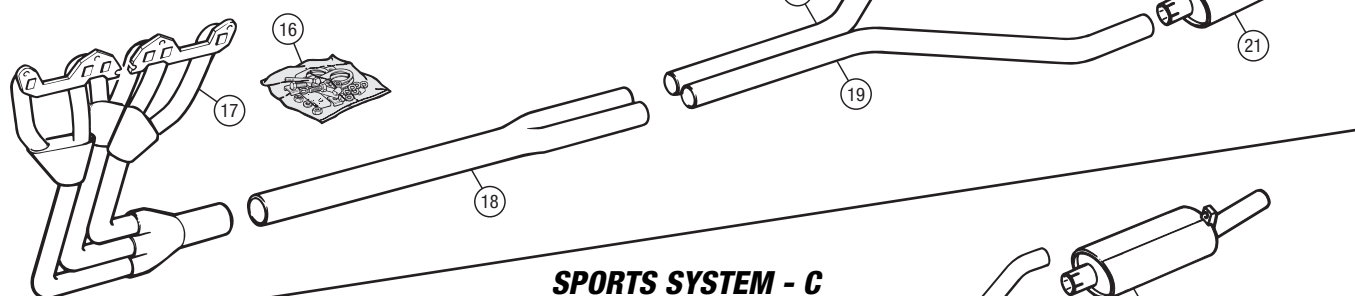




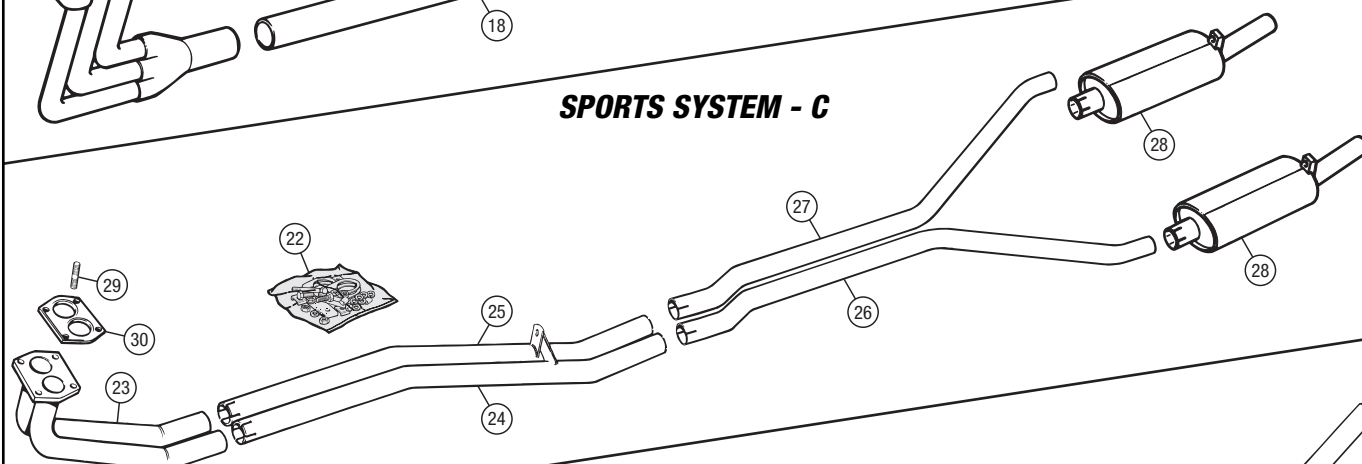
**SPORTS SYSTEM - A**



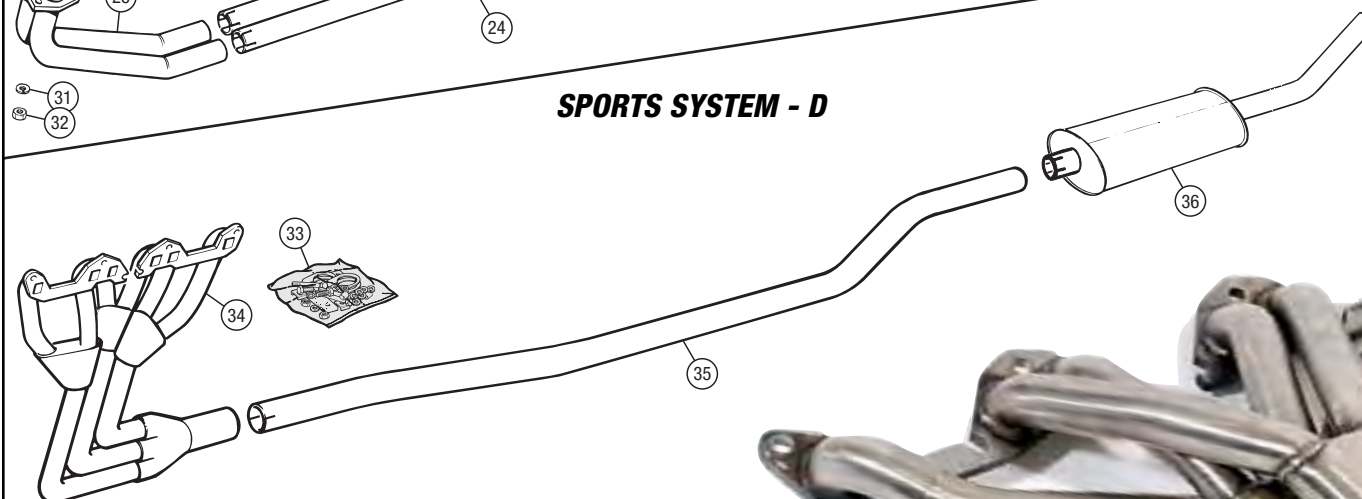
**SPORTS SYSTEM - B**



**SPORTS SYSTEM - C**



**SPORTS SYSTEM - D**





## ALL MODELS

## Reconditioned Exchange Gearboxes

Reconditioned exchange gearboxes have different specifications to match your vehicle. Whether you exchange your old gearbox for a reconditioned item, or attempt a rebuild or repair yourself, you must first establish the exact type of gearbox which you currently possess in your TR. The gearbox number is always stamped on one of the lower corners of the bell housing: usually the lower left hand corner, adjacent to where the clutch operating cross shaft protrudes. Genuine Triumph TR gearboxes were numbered with TS (3 synchro), CT, CD, CC, or CF (4 synchro) prefixes; these prefixes and the subsequent serial numbers bore little relationship to the commission (chassis) number of the car. To further compound the lottery of what might be fitted in your car, gearboxes from other Triumph sports and saloon models could be fitted directly or adapted to fit - and frequently were. The most commonly discovered anomaly on 6 cylinder TRs is fitment of the overdrive gearbox from the Triumph 'Large Car' 2000/2.5 saloon range. Such fitment does however involve an amount of adaptation on the gearbox, chassis, and clutch. Original factory exchange reconditioned units were numbered with the prefix 'GR' and a suffix of '17', and can be identified by these markings. Overdrive gearboxes were coupled to an 'A' type overdrive, which operated on 4th gear only on TR2s up to TS5979 and on 2nd, 3rd and 4th gears on models thereafter. Units returned for the exchange reconditioning scheme should as a matter of course be completely assembled, drained of oil and externally clean, with no obvious visual damage. In addition, they should be of identical type to that supplied. Please contact us to determine exactly what is required in return as an exchange old unit (i.e. less clutch operating ancillaries, adaptor plates etc. - see also 'Specification'). Note that non-TR old units will incur a surcharge.

Note: We can also offer a customer-own-unit reconditioning service, particularly useful when we have no unit available off the shelf, due to lack of old core. Overdrives are also sold separately, for full details of overdrive units, please see **Overdrive section**. For gearbox tunnel covers, see **Interior - Carpet and Boot Trim sections**.

## SPECIFICATION - RECONDITIONED EXCHANGE GEARBOXES AND OVERDRIVES

Exchange reconditioned gearboxes are fitted with new bearings, seals, gaskets, synchro rings, countershaft and have matched internals. All units are fitted with the top cover/selectors but please check that this is compatible with the unit removed from the car (i.e. switches, wiring, etc.). You may need to swap over top covers. Please note that the gear lever, wiring, switches, clutch cross shaft, fork, release bearing carrier, adaptor plate (O/D) and rear extension housing (non O/D) are not supplied with our units - again, you will need to transfer over from your old gearbox. Exchange reconditioned gearbox and overdrive assemblies are as above supplied less overdrive solenoid, output flange and any mounting bracketry. Depending upon availability, the type of overdrive annulus fitted may differ from original, necessitating recalibration of the speedometer.

## TR2, TR3, TR3A TO TS50000;

## THREE SYNCHRO

- |   |   |   |         |
|---|---|---|---------|
| 1   | GEARBOX ASS'Y, non overdrive, reconditioned exchange  | 1 | RW3057R |
| 2   | GEARBOX ASS'Y, overdrive type, reconditioned exchange | 1 | RW3058R |
| <i>Ensure overdrive is clean internally before fitting to gearbox, to avoid cross-contamination from dirty oil.</i> |   |   |         |
| 3   | GEARBOX & OVERDRIVE ASSEMBLY; reconditioned exchange  | 1 | RW3059R |
|   | TR2 to TS5979   |   |         |
|   | TR2 from TS5980, TR3, TR3A to TS50000.                | 1 | RW3060R |

## TR3A from TS50001, TR3B TSF series;

## THREE SYNCHRO

- |   |   |   |         |
|---|---|---|---------|
| 1   | GEARBOX ASS'Y, non overdrive, reconditioned exchange  | 1 | RW3061R |
| 2   | GEARBOX ASS'Y, overdrive type, reconditioned exchange | 1 | RW3062R |
| <i>Ensure overdrive is clean internally before fitting to gearbox, to avoid cross-contamination from dirty oil.</i> |   |   |         |
| 3   | GEARBOX & OVERDRIVE ASSEMBLY, reconditioned exchange  | 1 | RW3063R |

## TR3B TCF series, TR4, TR4A; FOUR SYNCHRO

- |   |   |   |         |
|---|---|---|---------|
| 1   | GEARBOX ASS'Y, non overdrive, reconditioned exchange  | 1 | RF4085R |
| 2   | GEARBOX ASS'Y, overdrive type, reconditioned exchange | 1 | RF4086R |
| <i>Ensure overdrive is clean internally before fitting to gearbox, to avoid cross-contamination from dirty oil.</i> |   |   |         |
| 3   | GEARBOX & OVERDRIVE ASSEMBLY, reconditioned exchange  | 1 | RF4087R |

## TR5, TR250; FOUR SYNCHRO

- |   |   |   |         |
|---|---|---|---------|
| 1   | GEARBOX ASS'Y, non overdrive, reconditioned exchange  | 1 | RR1119R |
| 2   | GEARBOX ASS'Y, overdrive type, reconditioned exchange | 1 | RR1088R |
| <i>Ensure overdrive is clean internally before fitting to gearbox, to avoid cross-contamination from dirty oil.</i> |   |   |         |
| 3   | GEARBOX & OVERDRIVE ASSEMBLY, reconditioned exchange  | 1 | RR1164R |



## External Gearbox

- |  |  |   |        |
|--|--|---|--------|
| 4  | BUSH;                                    |   |        |
|  | RH, clutch shaft, greased type           | 1 | 36997  |
|  | TR2, TR3, TR3A, TR3B, TR4 to CT50124     |   |        |
|  | LH, clutch shaft, greased type           | 1 | 36998  |
|  | TR2, TR3, TR3A, TR3B, TR4 to CT50124     |   |        |
|  | clutch operating shaft                   | 2 | 137651 |
|  | TR4 from CT 50125, TR4A, TR5, TR250      |   |        |
| 5  | PLUG, drain, plain                       | 1 | 114774 |
| 6  | PLUG, drain, magnetic type               | 1 | 155660 |
|  | Alternative.                             |   |        |
| <i>The two types of drain plug are interchangeable. It is advisable to use the magnetic type for safety's sake, to attract and collect any unwanted ferrous particles in the gearbox lubricant.</i>  |  |   |        |
| 7  | PLUG, oil filler and level               | 1 | 114774 |
| 8  | COVER, front                             | 1 | 100157 |
| <i>The length of the tube on the cover must not exceed 2 inches. This is important to check, because the release fingers on the diaphragm type clutches now supplied will foul on the 2 3/8" tube originally found on TR2s to TR4s. Incidentally, the part number 100157 may be found stamped on either length of cover, so measure the tube and shorten if necessary.</i> |  |   |        |
| 9  | SCREW, 'Locwel', front cover to gearcase | 4 | 155541 |
| 10   | WASHER, copper                           | 4 | 500469 |
| 11   | OIL SEAL, input (first motion) shaft     | 1 | 141756 |
| 12   | GASKET SET, gearbox                      | 1 | 515121 |
| 13   | GASKET, front cover                      | 1 | 59537  |
| 14   | GASKET, layshaft end cover               | 1 | 55774  |
| 15   | GASKET, rear extension                   | 1 | 132465 |
| 16   | GASKET, top cover                        | 1 | 105758 |
| 17   | COVER, layshaft end                      | 1 | 55773  |
| 18   | SCREW, 'Locwel', layshaft cover          | 2 | 155542 |
| 19   | WASHER, copper                           | 2 | 500469 |

## TR2, TR3, TR3A, TR3B, TR4, TR4A

- |    |                         |   |          |
|----|-------------------------|---|----------|
| 20 | COVER, clutch housing   | 1 | 112445   |
| 21 | SCREW, cover to gearbox | 2 | GHF103   |
| 22 | SCREW, cover to gearbox | 2 | SH605101 |
| 23 | WASHER, locking         | 4 | GHF332   |
| 24 | NUT                     | 4 | GHF201   |

- |    |   |   |          |
|----|---|---|----------|
| 25 | OIL SEAL, output (third motion)                       | 1 | 146129   |
| 26 | SCREW, 1"; rear extension                             | 5 | GHF163   |
|    | Non-overdrive only.                                   |   |          |
|    | overdrive adaptor plate                               | 6 | 155541   |
|    | Use with WP107 washer.                                |   |          |
| 27 | BOLT, 2", rear extension                              | 1 | BH505161 |
|    | Non-overdrive only (use in position by speedo drive). |   |          |
| 28 | WASHER, locking                                       | 6 | GHF332   |



GAUNTLET MATERIAL - 729511

## Gear Lever

- |    |   |   |          |
|----|---|---|----------|
| 29 | KNOB, gear lever, thin teardrop, push-on        | 1 | 107885   |
|    | TR2 to TS2876.                                  |   |          |
| 30 | KNOB, gear lever, thin teardrop, screw-on       | 1 | 109045   |
|    | TR2 from TS2877, TR3, TR3A to TS50000           | 1 | 123961   |
|    | TR3A from TS50001, TR3B                         |   |          |
| 31 | KNOB, gear lever, spherical, screw-on           | 1 | 131246   |
|    | TR4, TR4A, TR5                                  |   |          |
| 32 | KNOB, gear lever, thick teardrop, leather       | 1 | 148870   |
|    | TR250   |   |          |
| 33 | NUT, half, locking screw-on gear lever knob;    |   |          |
|    | original  | 1 | 508422   |
|    | alternative                                     | 1 | NT605041 |
| 34 | KNOB, gear lever, with 'TR' shield;             |   |          |
|    | 5/16" thread, alloy insert, large 'AMCO' style. | 1 | RL1528WA |
|    | wood  | 1 | RL1528LA |
|    | leather   |   |          |
| 35 | KNOB, gear lever, with 'TR' shield              |   |          |
|    | Self threading, nylon insert.                   |   |          |
|    | wood  | 1 | RL1528W  |
|    | leather   | 1 | RL1528L  |
| 36 | GEAR LEVER, upper TR2 to TS2876                 | 1 | 107891   |
| 37 | GEAR LEVER, lower TR2 to TS2876                 | 1 | 107888   |
| 38 | GEAR LEVER ASSEMBLY                             |   |          |
|    | TR2 from TS2877, TR3, TR3A, TR3B                | 1 | 112447   |
| 39 | GEAR LEVER ASSEMBLY;                            |   |          |
|    | TR4   | 1 | 131507   |
|    | TR4A  | 1 | 143624   |
|    | TR5, TR250                                      | 1 | 148095   |
| 40 | PLUNGER, anti-rattle, in ball end of lever      | 1 | 112424   |
|    | Not TR2 to TS2876.                              |   |          |
| 41 | SPRING, anti-rattle plunger                     | 1 | 137988   |
|    | Not TR2 to TS2876.                              |   |          |

## Gear Lever Cap

## TR2, TR3, TR3A, TR3B, TR4, TR4A

- |    |   |   |          |
|----|---|---|----------|
| 42 | CAP, lever retaining (3 attachment holes) | 1 | 105787   |
| 43 | SPRING, fitted under cap                  | 1 | 109531   |
| 44 | BOLT, cap and lever retaining             | 1 | BH604281 |
| 45 | NUT, nyloc                                | 1 | GHF271   |

## TR5, TR250

- |    |   |   |        |
|----|---|---|--------|
| 46 | CAP, lever retaining (3 attachment holes) | 1 | 140816 |
| 47 | SPRING (fitted under cap)                 | 1 | 145796 |
| 48 | PIN, threaded, locating gear lever        | 2 | 141984 |

## LATER TRIUMPH ALTERNATIVE

- |    |  |   |        |
|----|--|---|--------|
| 49 | CAP, gear lever retaining (bayonet type) | 1 | 156460 |
| 50 | SPRING (fitted under cap)                | 1 | 145796 |
| 51 | SCREW, shouldered-hex head               | 2 | 156408 |

*Gear lever retaining cap 156460 and spring 145796 can be used as a pair to replace the earlier caps and springs.*

- |    |   |   |          |
|----|---|---|----------|
| 52 | RETAINER, spring (fitted under cap)                   | 1 | 112442   |
| 53 | NUT, half, locking cap to pin                         | 2 | GHF201   |
|    | Not used with 105787 cap.                             |   |          |
| 54 | STUD, shouldered                                      | 2 | 160190   |
|    | Use with anti-vibration strap (see Engine Mountings). |   |          |
| 55 | SCREW, locating cap                                   | 1 | SH604031 |
| 56 | WASHER, locking                                       | 1 | GHF331   |

## Gear Lever Grommet

## TR2, TR3, TR3A, TR3B

- |    |                     |   |        |
|----|---------------------|---|--------|
| 57 | GROMMET, gear lever | 1 | 603065 |
|----|---------------------|---|--------|

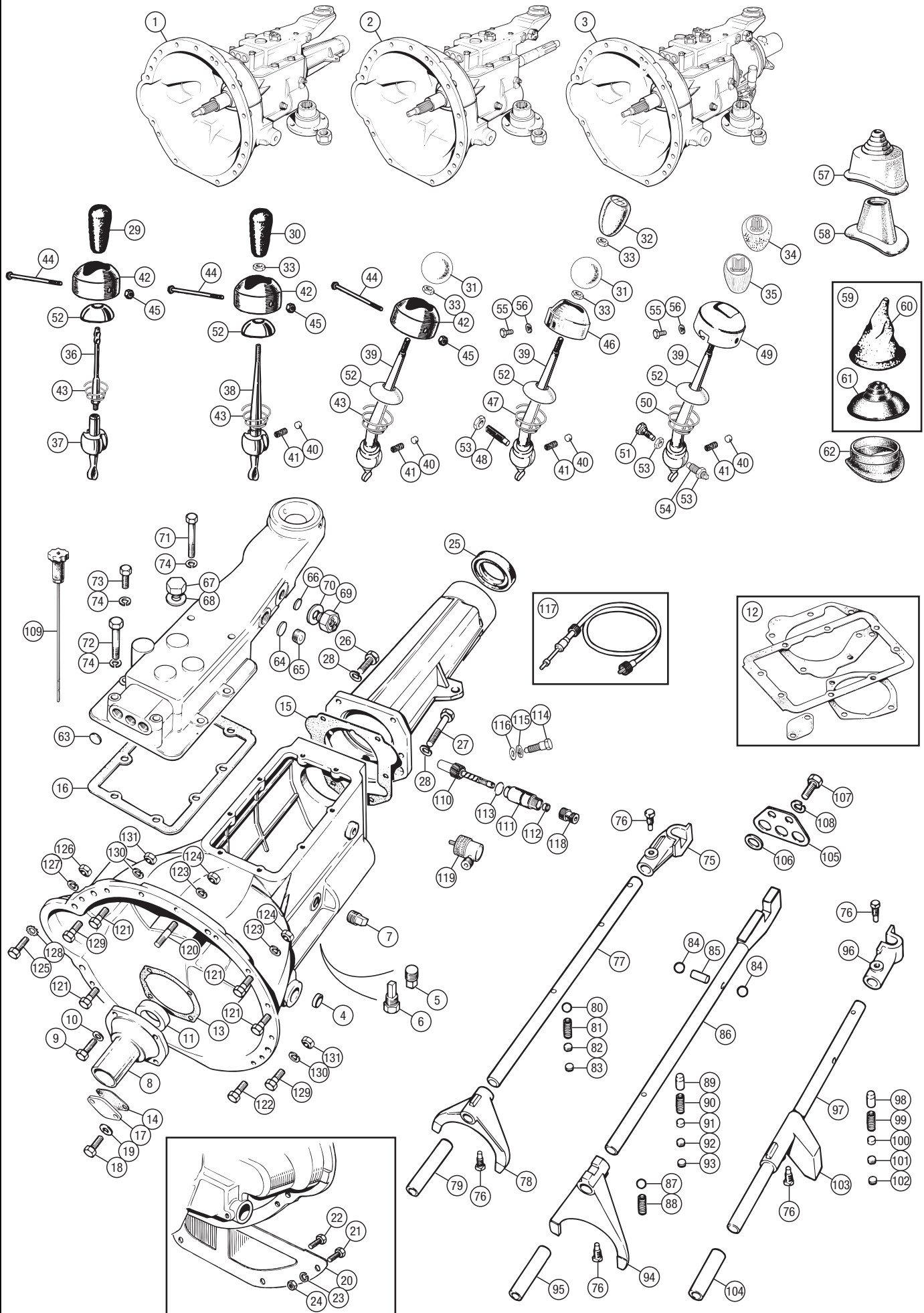
## TR4

- |    |                     |   |        |
|----|---------------------|---|--------|
| 58 | GROMMET, gear lever | 1 | 705913 |
|----|---------------------|---|--------|

## TR4A, TR5, TR250

- |  |                            |   |        |
|--|----------------------------|---|--------|
| 59   | GAUNTLET/GROMMET ASS'Y;    |   |        |
|  | Black; coarse grain        | 1 | 631881 |
|  | Black; smooth grain        | 1 | 622381 |
| 60   | GAUNTLET, material only    | 1 | 729511 |
| <i>Range of colours available:- black, beige, shadow blue, chestnut, red or tan.</i> |                            |   |        |
| 61   | GROMMET, gear-lever, upper | 1 | 709328 |
| 62   | GROMMET, gear lever, lower | 1 | 709329 |







## ALL MODELS

## Top Cover

There are a great number of gearbox top cover assemblies, for overdrive/non-overdrive and the electrical interlock requirements of other equipment.

These types are identified by the quantity and positioning of electrical switches, plus on earlier models the provision of a hole for the dipstick. Conversion of non-overdrive top covers to overdrive type is a matter of drilling and tapping to accept the switch(es) in the correct position(s). This can be done by the owner, or by a machine shop.

Original top cover specifications are as follows;

- TR2 to TS5979 with one o/d switch and dipstick hole.
- TR2 from TS5980, TR3, TR3A to TS50000 with two o/d switches and dipstick hole.
- TR3A from TS50001, TR3B TSF series with two o/d switches but no dipstick hole.
- TR3B TCF series, TR4, TR4A with three o/d and rev. lamp switches.
- non overdrive TR5, TR250 with top-fitted reverse light switch.
- overdrive TR5, TR250 with 3 top-fitted switches.

|    |  |     |          |
|----|--|-----|----------|
| 63 | PLUG, 'welch', selector shafts ends                      | 3   | 104449   |
| 64 | PLUG, 'welch', left and right sides<br><i>As fitted.</i> | 2   | 54505    |
| 65 | PLUG, screwed, left and right sides<br><i>As fitted.</i> | 2   | PS1004   |
| 66 | PLUG, 'welch', interlock plunger, side                   | 1   | 104449   |
| 67 | PLUG, screwed<br><i>Blanks unused switch holes.</i>      | A/R | 108114   |
| 68 | WASHER, sealing, blanking plug                           | A/R | 6K433    |
| 69 | SWITCH, overdrive &/or reverse light                     | A/R | BAU1074A |
| 70 | WASHER, sealing/adjusting, switch                        | A/R | 502146   |

For gearbox and overdrive electrical details, plus note on switch fitting, see the Electrical section.

Selector (inhibitor) switches are best adjusted with the lid off the gearbox. Ideally use a test meter or an illuminated circuit tester (power source, bulb and wires as shown in various workshop manuals) to test for makes or breaks. The further 'in' the switch is screwed the more resistance to ease of gear change will be felt when the gear-lever is moved from gear to gear. The idea therefore is to screw the switch into the lid the least possible amount to get positive circuit makes and breaks. As the packing washers are thin card, which changes its thickness as it compresses, this can only be achieved by trial and error, and 1 - 3 is the normal range of requirement. Each switch must be adjusted individually. Don't take chances with broken insulation on the switches and/or very loose terminals. There's a lot of 'stripping out' involved to get at a rogue switch which will far outweigh replacement cost (ditto: dodgy wiring).

TR2s, TR3s and TR3As up to TS60000 originally had overdrive switches with screw terminals for the wiring. Later spade terminal switches may of course be used, so long as the ring terminals on the wiring are replaced with Lucar 1/4" wide spade types (part no. RTC220A). The switches may require adjustment during the life of the gearbox as the selector forks wear at the top where the switch makes contact. Wear in the gearbox bushes may cause selector fork face wear, which may also cause intermittent overdrive operation. These faulty switch operations will in turn cause the solenoid to chatter and that will certainly cause premature solenoid failure as the points burn out. Reference was made to the switches providing a safety circuit to protect the overdrive. The simple fact is that the unidirectional clutch is exactly that: a unit that works in one direction. It fails very expensively when driven the wrong way, usually destroying the gearbox 3rd motion shaft (or mainshaft) in addition to the whole overdrive. The inhibitor switches are really there to prevent overdrive engagement in reverse.

|    |   |   |          |
|----|---|---|----------|
| 71 | BOLT, top cover, rear (2 7/8")  | 2 | BH505241 |
| 72 | BOLT, top cover, front (2 3/4")   | 2 | BH505221 |
| 73 | SCREW, top cover, middle  | 4 | 56370    |
| 74 | WASHER, locking   | 8 | GHF332   |
| 75 | SELECTOR, 1st and 2nd speeds  | 1 | 127386   |
| 76 | SCREW, selectors and forks to shafts                                      | 5 | 122653   |
| 77 | SHAFT, 1st and 2nd speed selector;<br>TR2, TR3, TR3A, TR3B TSF series     | 1 | 122071   |
|    | TR3B TCF series, TR4, TR4A, TR5, TR250                                    | 1 | 122071   |
|    | original  | 1 | 128066   |
|    | alternative.  | 1 | 158464   |
| 78 | FORK, 1st and 2nd speed selector;<br>TR2, TR3, TR3A, TR3B TSF series      | 1 | 127383   |
|    | TR3B TCF series, TR4, TR4A, TR5, TR250                                    | 1 | 128067   |
| 79 | SLEEVE, 1st and 2nd speed selector;<br>TR3A from TS50001, TR3B TSF series | 1 | 122062   |
|    | TR3B TCF series, TR4, TR4A, TR5, TR250                                    | 1 | 128063   |
| 80 | BALL, 1st and 2nd speed selector  | 1 | BLS112   |
| 81 | SPRING, 1st and 2nd speed selector  | 1 | FRC7195A |
| 82 | PLUG, screwed   | 1 | 108166   |
| 83 | PLUG, cup type ( <i>As fitted</i> ).                                      | 1 | 156665   |
| 84 | BALL, interlock   | 2 | BLS112   |
| 85 | ROLLER, interlock   | 1 | 105788   |
| 86 | SHAFT, 3rd and 4th speed selector;<br>original                            | 1 | 129986   |
|    | alternative   | 1 | 156373   |

|   |   |   |          |
|---|---|---|----------|
| 87  | BALL, 3rd and 4th speed selector<br>TR2, TR3, TR3A, TR3B, TR4 to CT9898.  | 1 | BLS112   |
| 88  | SPRING, 3rd and 4th speed selector<br>TR2, TR3, TR3A, TR3B, TR4 to CT9898 | 1 | 155632   |
| 89  | PLUNGER, 3rd and 4th speed selector<br>TR4 from CT9899, TR4A, TR5, TR250  | 1 | 106481   |
| 90  | SPRING, 3rd and 4th speed selector<br>TR4 from CT9899, TR4A, TR5, TR250   | 1 | 2262198  |
| 91  | DISTANCE PIECE, plunger   | 1 | 109401   |
| 92  | PLUG, screwed   | 1 | 108166   |
| 93  | PLUG, cup type ( <i>As fitted</i> )                                       | 1 | 156665   |
| 94  | FORK, 3rd and 4th selector  | 1 | 127387   |
| 95  | SLEEVE, 3rd and 4th selector  | 1 | 117811   |
| 96  | SELECTOR, reverse   | 1 | 127385   |
| 97  | SHAFT, reverse selector   | 1 | 132389   |
| 98  | PLUNGER, reverse selector   | 1 | 136990   |
| 99  | SPRING, reverse plunger   | 1 | 2262198  |
| 100   | DISTANCE PIECE, reverse plunger   | 1 | 109401   |
| 101   | PLUG, screwed   | 1 | 108166   |
| 102   | PLUG, cup type ( <i>As fitted</i> )                                       | 1 | 156665   |
| The spring and plunger combination 106489 and 109401 may be found fitted in other selector shaft positions (depending on the machining specification of the top cover casting). |   |   |          |
| 103   | FORK, reverse selector;<br>TR2, TR3, TR3A, TR3B TSF series                | 1 | 127389   |
|   | TR3B TCF series, TR4, TR4A, TR5, TR250                                    | 1 | 129780   |
| 104   | SLEEVE, reverse selector;<br>TR3A from TS50001, TR3B TSF series           | 1 | 122064   |
|   | TR3B TCF series, TR4, TR4A, TR5, TR250                                    | 1 | 209902   |
| 105   | PLATE, retaining  | 1 | 106051   |
| 106   | RING, sealing, selector shafts  | 3 | 106050   |
| 107   | SCREW, plate to casing  | 2 | SH604041 |
| 108   | WASHER, locking   | 2 | GHF331   |
| 109   | DIPSTICK, gearbox oil level<br>TR2, TR3, TR3A to TS50000.                 | 2 | 108164   |

## Speedo Drive

## NON-OVERDRIVE MODELS

|     |  |   |         |
|-----|--|---|---------|
| 110 | PINION ASSEMBLY, speedometer   | 1 | 147965  |
| 111 | BEARING HOUSING, speedo pinion                                       | 1 | 146542  |
| 112 | OIL SEAL, pinion to bearing housing                                  | 1 | NKC105A |
| 113 | 'O' RING, housing to gearbox extension<br><i>Non-overdrive only.</i> | 1 | RTC1949 |
| 114 | SCREW, special ( <i>locating bearing housing</i> )                   | 1 | 506071  |
| 115 | WASHER, locking  | 1 | GHF332  |
| 116 | WASHER, plain  | 1 | 538532  |

## Speedometer Cables

## TR2, TR3, TR3A, TR3B

|     |                                 |   |        |
|-----|---------------------------------|---|--------|
| 117 | SPEEDOMETER CABLE;              |   |        |
|     | 84" RH steering, all            | 1 | 504611 |
|     | 69" LH steering, non-overdrive  | 1 | GSD169 |
|     | 96" LH steering, overdrive      | 1 | 504609 |
| 118 | END CAP, screwed, speedo pinion | 1 | 60246  |

## TR4, TR4A

|     |                                |   |        |
|-----|--------------------------------|---|--------|
| 117 | SPEEDOMETER CABLE;             |   |        |
|     | 78" RH steering, non-overdrive | 1 | GSD141 |
|     | 69" LH steering, non-overdrive | 1 | GSD169 |
|     | 69" Overdrive models, all      | 1 | GSD169 |

## TR5, TR250

|     |                                |   |        |
|-----|--------------------------------|---|--------|
| 117 | SPEEDOMETER CABLE;             |   |        |
|     | 66" RH steering, non-overdrive | 1 | GSD114 |
|     | 69" LH steering, non-overdrive | 1 | GSD169 |
|     | 69" Overdrive models, all      | 1 | GSD169 |

The 69" long speedometer cable is the one preferred for RH steering TR5s as it allows that little extra length when routing. Remember all cables must be securely clipped to prevent chaffing or snagging.

|     |  |   |        |
|-----|--|---|--------|
| 119 | DRIVE, angled, RH steering & overdrive | 1 | 120694 |
|-----|--|---|--------|

## Gearbox to Engine Mounting Hardware

## 11mm MOUNTING FLANGE - TR2, TR3, TR3A, TR3B, Early TR4

|     |   |    |          |
|-----|---|----|----------|
| 120 | STUD, bell housing to engine<br><i>Top 3 positions.</i> | 3  | TE505111 |
| 121 | SCREW, gearbox to cylinder block                        | 6  | GHF163   |
| 122 | BOLT, slave cyl. bracket to<br>gearbox flange           | 2  | GHF103   |
| 123 | WASHER, locking   | 11 | GHF332   |

|     |                                       |   |          |
|-----|---------------------------------------|---|----------|
| 124 | NUT, for stud and slave cylinder bolt | 5 | GHF201   |
| 125 | BOLT, starter motor attachment        | 2 | BH606161 |
| 126 | NUT, starter attachment bolt          | 2 | GHF202   |
| 127 | WASHER, locking                       | 2 | GHF333   |

## 14mm MOUNTING FLANGE - Later TR4, TR4A

|     |   |    |          |
|-----|---|----|----------|
| 120 | STUD, bell housing to engine<br><i>Top 3 positions.</i> | 3  | TE505131 |
| 121 | SCREW, gearbox to cylinder block                        | 6  | SH505101 |
| 122 | BOLT, slave cyl. bracket to<br>gearbox flange           | 2  | GHF104   |
| 123 | WASHER, locking   | 11 | GHF332   |
| 124 | NUT, for stud and slave cylinder bolt                   | 5  | GHF201   |
| 125 | BOLT, starter motor attachment                          | 2  | BH606191 |
| 126 | NUT, starter attachment bolt                            | 2  | GHF202   |
| 127 | WASHER, locking   | 2  | GHF333   |

## 14mm MOUNTING FLANGE - TR5, TR250

|     |   |    |          |
|-----|---|----|----------|
| 120 | STUD, bell housing to engine<br><i>Top 3 positions.</i> | 3  | TE605141 |
| 121 | SCREW, gearbox to cylinder block                        | 8  | BH605111 |
| 122 | BOLT, slave cyl. bracket to<br>gearbox flange           | 2  | BH605131 |
| 123 | WASHER, locking   | 13 | GHF332   |
| 124 | NUT   | 13 | GHF201   |
| 125 | BOLT, starter motor attachment                          | 2  | BH606161 |
| 126 | NUT, starter attachment bolt                            | 2  | GHF202   |
| 127 | WASHER, locking   | 2  | GHF333   |
| 128 | WASHER, shakeproof, bolt head<br>to starter             | 2  | WE600061 |
| 129 | BOLT, dowel   | 2  | GHF106   |
| 130 | WASHER, locking   | 2  | GHF333   |
| 131 | NUT   | 2  | GHF202   |

For gearbox steady brackets and mountings see **Engine and Gearbox Mountings** section.

## GEARBOX OIL CAPACITIES;

|                          |              |
|--------------------------|--------------|
| Gearbox - non overdrive  | 1.13 Litres. |
| Gearbox - with overdrive | 2 Litres.    |

## GEARBOX HINTS

Certain simple inspection routines can be carried out to ascertain what type of (or level) of repair may be required to your gearbox. The primary requirement of anything mechanical is of course the correct amount of a suitable lubricant. TR gearboxes are less robust in certain bearing areas which means lubrication is all important.

1 New or unusual noises from the gearbox may mean the failure of an internal component has occurred. The favourite is a knock or rattle in first, second and third gears; this usually indicates the failure of the countershaft (layshaft) bearings.

2 Drain the gearbox oil into a clean container and look at the oil and what may have come out with it.

a. If oil has moderate brassy look this is normal.

b. Pieces of brass denote broken synchro rings or bushes.

c. If the oil contains grey coloured lumps, remove the gearbox top cover and look for obvious damage to gears. The grey sludge invariably indicates the countershaft (layshaft); countershaft gear and bearings have collapsed.

The fitment of a magnetic drain plug will guarantee a heart attack every time you remove it! It will also enable you to assess the amount of ferrous sludge in your gearbox. The overdrive unit should have a magnetic washer inside the large brass drain plug.

3 While inspecting inside the gearbox with the top cover removed, check the end float of 2nd. gear: If 2nd gear play exceeds 0.020", suspect its thrust washer has broken. This can eventually destroy the gear and mainshaft if not attended to.

4 After reinstalling a gearbox and refilling it with the correct quantity and grade of oil, test-drive the car before refitting tunnel or trim.

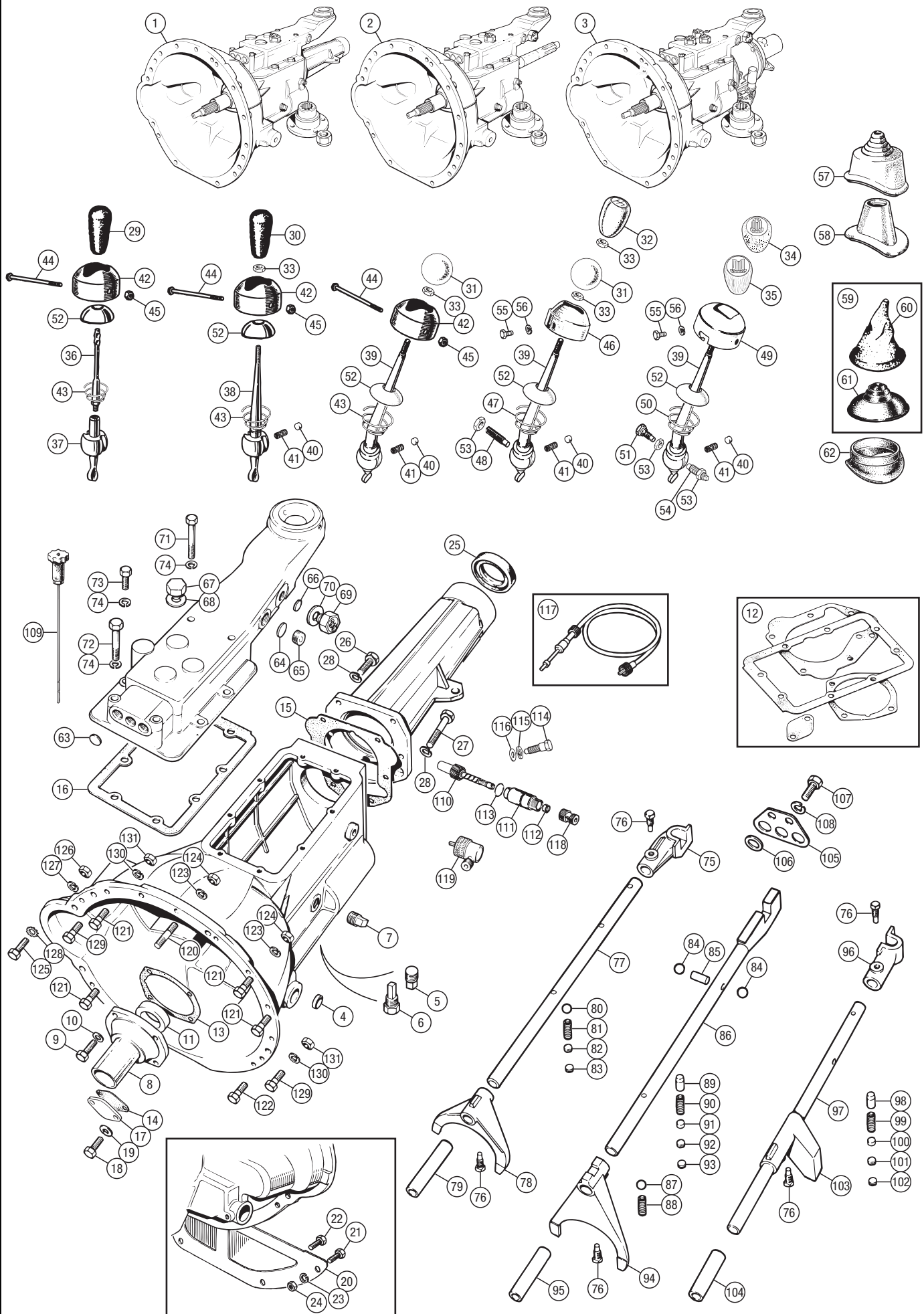
There is nothing more depressing than having to disassemble the interior of the car to re-attach the reversing lights wiring that you forgot and now the reversing lights do not work.

5 A useful tip to aid with installing a gearbox on a 6 cylinder car is with the gearbox flush with the engine backplate, and hanging off the 3 5/16" studs at the top, to ensure the 2 dowel (or place) bolts are fitted prior to fitting or tightening any of the others. These are 2 bolts (3/8" unf) which fit opposite each other at approx. 2 o'clock and 7 o'clock. Their purpose is to align the engine to the gearbox on 6 cylinder cars and such is their fit, they may require driving into place. Misalignment of the gearbox and engine may produce any one of a number of clutch problems which are dealt with in some detail in the clutch section, so careful installation of these bolts is paramount; before going on to look for other "erratic" clutch cures.

6 If you've got a 4 synchro gearbox and would like a higher 1st gear (giving a closer-ratio gearbox), the time to change is when rectifying the failed layshaft, which will probably have damaged the existing laygear in addition. Simply substitute UKC662 laygear and 152803 1st gear (from the post-73 TR6 gearbox) for the existing pair. You could even go the whole way and fit that close ratio gear set you always dreamed of but never had an excuse for before. (RR1512 fits all 4 synchro gearboxes.)

7 **Don't forget!** A standard gearbox requires 1.13 litres and an overdrive type 2 litres of oil.







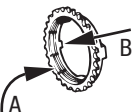
## TR2-3B(TSF)

### Constant Pinion & Mainshafts

|    |  |   |        |
|----|--|---|--------|
| 1  | CIRCLIP, bearing retaining   | 1 | 58956  |
| 2  | WASHER   | 1 | 60078  |
| 3  | BEARING, front & centre  | 2 | 58391  |
| 4  | CIRCLIP, bearing locating  | 2 | 58955  |
| 5  | OIL THROWER  | 1 | 60658  |
| 6  | CONSTANT PINION SHAFT;<br>TR2, TR3, TR3A to TS26824,<br>TR3A from TS27051 to TS27062                                 | 1 | 201712 |
|    | TR3A from TS26825 to TS27050,<br>TR3A from TS27063, TR3B TSF series  | 1 | 204215 |
| 7  | GEAR SET, input shaft and constant mesh gear;<br>TR3A from TS26825 to TS27050,<br>TR3A from TS27063, TR3B TSF series | 1 | 148949 |
| 8  | BUSH, input shaft;<br>TR2, TR3, TR3A to TS26824,<br>TR3A from TS27051 to TS27062                                     | 1 | 55911  |
| 9  | BEARING ASSEMBLY, input shaft;<br>TR3A from TS26825 to TS27050,<br>TR3A from TS27063, TR3B TSF series                | 1 | 145008 |
| 10 | MAINSHAFT;<br>non-overdrive<br>TR2, TR3, TR3A to TS26824   | 1 | 201590 |
|    | TR3A from TS26825, TR3B TSF series   | 1 | 204011 |
|    | overdrive<br>TR2, TR3, TR3A to TS26824   | 1 | 110736 |
|    | TR3A from TS26825, TR3B TSF series   | 1 | 204044 |
| 11 | WASHER, 1st gear to bearing;<br>use with bush 55911  | 1 | 60569  |
|    | use with bearing 145008  | 1 | 116496 |
| 12 | WASHER, circlip to bearing   | 1 | 59443  |
| 13 | CIRCLIP  | 1 | 58956  |
| 14 | WASHER, rear mainshaft   | 1 | 58949  |
| 15 | BEARING, rear  | 1 | 513897 |
| 16 | FLANGE;<br>original  | 1 | 58948  |
|    | replacement  | 1 | 518109 |
| 17 | SPLIT PIN  | 1 | PC12   |
| 18 | WASHER   | 1 | WP24   |
| 19 | NUT, slotted   | 1 | 57868  |



INPUT SHAFT BEARING -  
145008



### Mainshaft Gears

|    |                           |   |         |
|----|---------------------------|---|---------|
| 20 | SYNCHRO RING;<br>standard | 3 | 113431  |
|    | superior material         | 3 | 113431X |

Early TR boxes used rings made of "Iron Bronze", a sintered metal containing copper and iron predominately. This provided synchronising (of sorts) and long life. The brass compounds used these days offer improved synchronising, though nowhere near that of modern gearboxes. In reality the actual ring size and friction area are inadequate. The working life of the ring is indicated externally by the gap between the dog teeth on the ring and the gear, from the 0.045" (new) down to 0.025" (worn) range. It is not unknown for less than scrupulous rebuilders to skim off the back face to give the appearance of a new ring. The problem here is that this ignores the relationship between the areas shown, A and B, to give the internals of the box their correct clearance.

|     |  |     |         |
|-----|--|-----|---------|
| 21  | HUB & SLEEVE ASSEMBLY,<br>3rd and 4th gears<br><i>Includes balls, springs and shims.</i> | 1   | 153844  |
| 21A | OUTER SLEEVE, 3rd & 4th synchro hub  | 1   | 153844X |
| 22  | BALL, detent   | 3   | BLS108  |
| 23  | SPRING, for ball   | 3   | 137988  |
| 24  | SHIM, to adjust spring tension   | A/R | 37948   |
| 25  | CIRCLIP, 3rd gear to shaft   | 1   | 55707   |



THIRD GEAR CIRCLIP -  
55707

|    |   |     |         |
|----|---|-----|---------|
| 26 | WASHER, circlip to gear   | 1   | 157054  |
| 27 | GEAR, 3rd   | 1   | 105630  |
| 28 | BUSH;<br>3rd gear<br>uprated, 3rd gear<br><i>Manufactured from special steel.</i> | 1   | 101585  |
|    |   | 1   | 101585X |
| 29 | BUSH;<br>2nd gear<br>uprated, 2nd gear<br><i>Manufactured from special steel.</i> | 1   | 105731  |
|    |   | 1   | 105731X |
| 30 | GEAR, 2nd   | 1   | 105629  |
| 31 | WASHER  | 1   | 105732  |
| 32 | GEAR, 1st<br><i>Includes items 33-36.</i>   | 1   | 109137  |
| 33 | BALL, interlock   | 1   | BLS108  |
| 34 | PLUNGER, interlock  | 1   | 106106  |
| 35 | BALL, detent  | 3   | BLS108  |
| 36 | SPRING, for ball  | 3   | 137988  |
|    | SHIM, to adjust spring tension  | A/R | 37948   |
| 37 | INNER HUB, 1st gear   | 1   | 105627  |

### Countershaft Gears

|    |                                     |    |        |
|----|-------------------------------------|----|--------|
| 38 | THRUST WASHER, front                | 1  | 129955 |
| 39 | GEAR, constant, countershaft        | 1  | 105626 |
| 40 | DISTANCE PIECE                      | 1  | 59465  |
| 41 | GEAR, 3rd, countershaft             | 1  | 140509 |
| 42 | GEAR, 2nd, countershaft             | 1  | 105658 |
| 43 | RETAINER, needle bearing            | 4  | 55721  |
| 44 | NEEDLE BEARING                      | 48 | 58088  |
| 45 | GEAR, 1st and reverse, countershaft | 1  | 105625 |
| 46 | THRUST WASHER, rear                 | 1  | 129956 |
| 47 | COUNTERSHAFT (layshaft)             | 1  | 108168 |



FRONT THRUST WASHER -  
129955



COUNTERSHAFT - 108168

### Reverse Gear

|    |                          |   |        |
|----|--------------------------|---|--------|
| 48 | FORK, reverse            | 1 | 105727 |
| 49 | ROD, reverse fork        | 1 | 105782 |
| 50 | BUSH, reverse rod        | 1 | 58951  |
| 51 | SCREW, rod retaining     | 1 | 55815  |
| 52 | NUT, screw locking       | 1 | 57110  |
| 53 | GEAR, reverse            | 1 | 111153 |
| 54 | SPINDLE, reverse gear    | 1 | 105757 |
| 55 | SCREW, spindle retaining | 1 | 55715  |
| 56 | WASHER, for screw        | 1 | GHF332 |

### Gearbox Overhaul Kits

#### NON-OVERDRIVE GEARBOX

|    |  |   |        |
|----|--|---|--------|
| 57 | GEARBOX OVERHAUL KIT<br><i>Non-overdrive type.</i> | 1 | RW3064 |
|----|--|---|--------|

The following parts are included:-

|   |    |        |
|---|----|--------|
| GASKET SET, gearbox   | 1  | 515121 |
| OIL SEAL, constant pinion   | 1  | 141756 |
| OIL SEAL, rear  | 1  | 146129 |
| BUSH, input shaft   | 1  | 55911  |
| TR2, TR3, TR3A to TS26824, TR3A from TS27051 to TS27062.          |    |        |
| BEARING ASSEMBLY, input shaft                                     | 1  | 145008 |
| TR3A from TS26825 to TS27050, TR3A from TS27063, TR3B TSF series. |    |        |
| BEARING, front & centre   | 2  | 58391  |
| BEARING, rear   | 1  | 513897 |
| SYNCHRO RING  | 3  | 113431 |
| CIRCLIP, mainshaft  | 1  | 55707  |
| THRUST WASHER, front  | 1  | 129955 |
| THRUST WASHER, rear   | 1  | 129956 |
| NEEDLE BEARING, countershaft                                      | 48 | 58088  |
| COUNTERSHAFT  | 1  | 108168 |

#### GEARBOX FITTED WITH 'A' TYPE OVERDRIVE

|    |  |   |        |
|----|--|---|--------|
| 58 | GEARBOX OVERHAUL KIT<br><i>Overdrive type.</i> | 1 | RW3065 |
|----|--|---|--------|

The following parts are included:-

|   |    |        |
|---|----|--------|
| GASKET SET, gearbox   | 1  | 515121 |
| GASKET overdrive to adaptor plate                                 | 1  | 502556 |
| GASKET overdrive side plate                                       | 1  | 500645 |
| WASHER, fibre, overdrive sump plug                                | 1  | 500641 |
| OIL SEAL, constant pinion   | 1  | 141756 |
| OIL SEAL, rear  | 1  | 146129 |
| BUSH, input shaft   | 1  | 55911  |
| TR2, TR3, TR3A to TS26824, TR3A from TS27051 to TS27062.          |    |        |
| BEARING ASSEMBLY, input shaft                                     | 1  | 145008 |
| TR3A from TS26825 to TS27050, TR3A from TS27063, TR3B TSF series. |    |        |
| BEARING, front & centre   | 2  | 58391  |
| SYNCHRO RING  | 3  | 113431 |
| CIRCLIP, mainshaft  | 1  | 55707  |
| THRUST WASHER, front  | 1  | 129955 |
| THRUST WASHER, rear   | 1  | 129956 |
| NEEDLE BEARING, countershaft                                      | 48 | 58088  |
| COUNTERSHAFT  | 1  | 108168 |

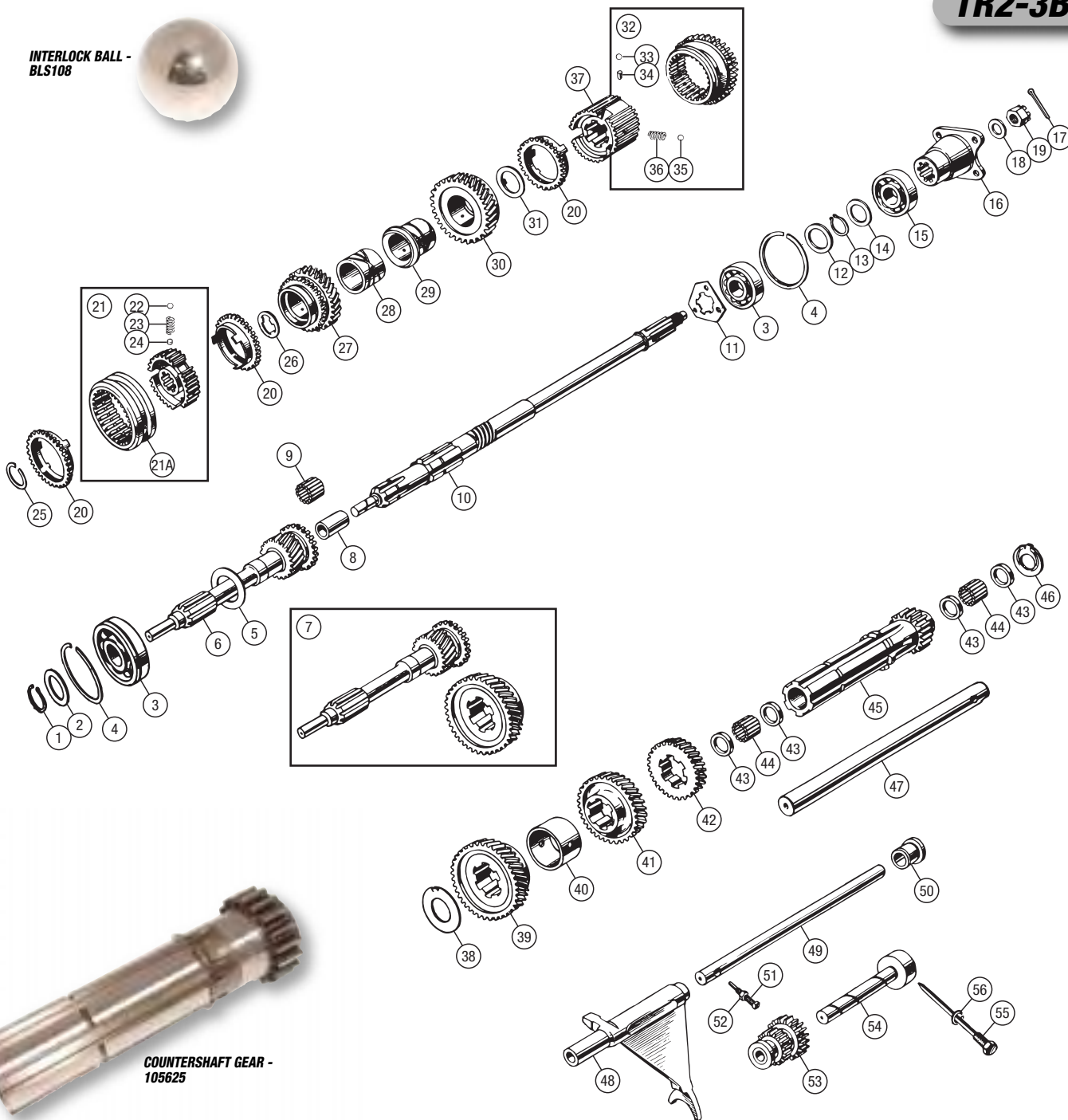


REAR BEARING -  
513897

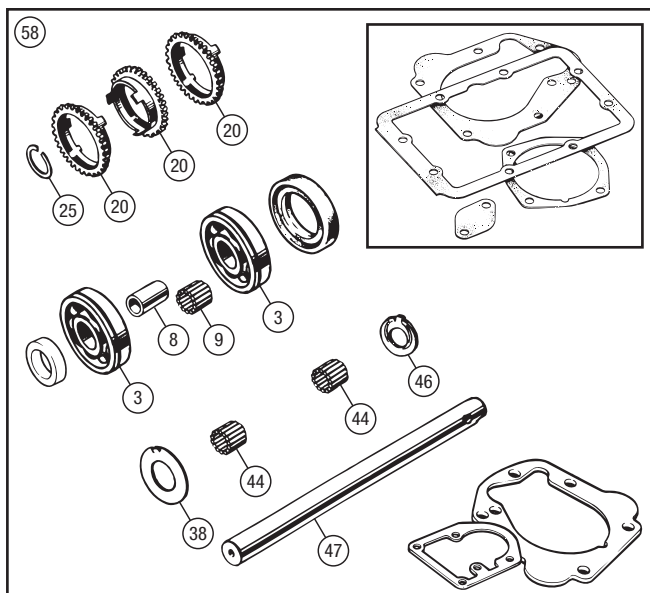
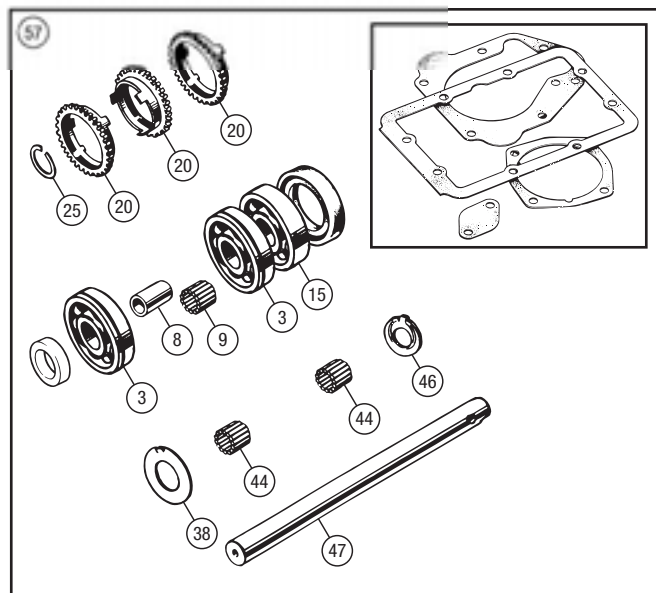




INTERLOCK BALL -  
BLS108



COUNTERSHAFT GEAR -  
105625





| No. | DESCRIPTION | QTY REQ. | PART No. |
|-----|-------------|----------|----------|
|-----|-------------|----------|----------|

| No. | DESCRIPTION | QTY REQ. | PART No. |
|-----|-------------|----------|----------|
|-----|-------------|----------|----------|

| No. | DESCRIPTION | QTY REQ. | PART No. |
|-----|-------------|----------|----------|
|-----|-------------|----------|----------|

## TR3B(TCF)-4-4A-5-250

### Constant Pinion & Main Shafts

4 synchro gearboxes original to the cars supported by this catalogue have gearbox numbers prefixed by CT (TR4, TR4A) or CD (TR5, TR250).

This section and the previous one dealing with external gearbox contain information relevant to original fitment gearboxes. If your gearbox has a number subsequent to CD20281, or a prefix of CC or CF, then you are in possession of a later TR6 unit which differs in important details and is not covered here. We would suggest in this instance that you should acquire our TR6 parts catalogue.

Having said that, there is a chart at the end of this section which groups the major TR6 gearbox changes together, thus making the substitution of groups of later components into an earlier gearbox an easier task to understand (for example, if you wish to fit the post-73 taller first gear and laygear, nos. 152803 and UKC662 respectively).

If your gearbox number has any other prefix, it is likely to have been donated to the TR cause by a Triumph saloon at some point in its history, and while it will be similar in most respects there will be detail differences you will need to be aware of before embarking on a rebuild. Please contact us for further information if this should be the case.

Lastly, if you have an overdrive gearbox, it should be coupled to an A type overdrive to be original. Later TR6s and saloons used a J type unit (adaptor brackets are available to fit the J type into earlier TR chassis). The manufacturer's plate on the overdrive body will tell you if yours is an A or J type; if the plate is missing or illegible, look at the underside of the overdrive - the A type has a large screw cap, whereas the J type has a cast ribbed rectangular cover plate. The recommendation if you find the latter is the same as before - locate and note down the prefix and gearbox number, then contact us for further information.

|   |                                |   |        |
|---|--------------------------------|---|--------|
| 1 | CIRCLIP, retaining             | 1 | 58956  |
| 2 | WASHER                         | 1 | 60078  |
| 3 | BEARING, constant pinion shaft | 1 | 58391  |
| 4 | CIRCLIP, locating              | 1 | 58955  |
| 5 | OIL THROWER                    | 1 | 60658  |
| 6 | GEAR SET, constant mesh        | 1 | 148949 |

The gear set 148949 contains three matched items, an constant pinion shaft, constant gear and shell bearing, 145008. It should be used as a complete set to service original TR4, TR4A, TR5 and TR250 gearboxes and runs with mainshafts 208051 and 208052.

|  |                       |   |  |
|--|-----------------------|---|--|
| 7  | CONSTANT PINION SHAFT | - |  |
| See note with item 6.  |                       |   |  |
| Care must be taken to ensure the angular cut of the teeth match between the constant gear and constant pinion shaft, by building them together prior to installation in the gearbox. This angle is called the 'helix'. This should not, however, be an issue if using the 148949 gear set. |                       |   |  |

|  |                           |   |         |
|--|---------------------------|---|---------|
| 8  | BEARING, mainshaft spigot | 1 | 145008  |
| 9  | SLEEVE, spigot bearing    | 1 | 145008X |
| If using a late-model TR6 metric-bore constant pinion gear (part no. 219126), this precision ground steel sleeve should be pressed into it to enable the proper fitment of bearing 145008. It therefore allows imperial nosed mainshafts to be compatible with later metric constant pinion gears. |                           |   |         |

|  |                                     |     |        |
|--|-------------------------------------|-----|--------|
| 10                                       | MAINSHAFT, non-overdrive (imperial) | 1   | 208051 |
| 11                                       | MAINSHAFT, overdrive (imperial)     | 1   | 208052 |
| 12                                       | BEARING, mainshaft centre           | 1   | 58391  |
| 13                                       | CIRCLIP, locating                   | 1   | 58955  |
| 14                                       | WASHER, plain, bearing supporting   | 1   | 59443  |
| 15                                       | CIRCLIP, bearing retaining*         | 1/2 | 58956  |
| 16                                       | WASHER, plain, bearing supporting*  | 1   | 58949  |
| 17                                       | BEARING, mainshaft rear*            | 1   | 513897 |
| *Fitted to non-overdrive gearboxes only. |                                     |     |        |

|    |   |   |        |
|----|---|---|--------|
| 18 | FLANGE, mainshaft, square, interchangeable with 518109. | 1 | 58948  |
| 19 | FLANGE, mainshaft, round interchangeable with 58948.    | 1 | 518109 |
| 20 | WASHER  | 1 | WP24   |
| 21 | NUT, slotted  | 1 | 57868  |
| 22 | NUT, nyloc Alternative to slotted nut.                  | 1 | 157642 |
| 23 | SPLIT PIN Use with slotted nut.                         | 1 | PC12   |

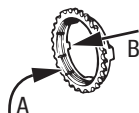
OVERDRIVE MAINSHAFT - 208052



### Mainshaft Gears

|    |  |   |         |
|----|--|---|---------|
| 24 | SYNCHRO CUP, 3/4 synchro hub; standard | 2 | 113431  |
|    | superior material                      | 2 | 113431X |

Early TR boxes used rings made of "Iron Bronze", a sintered metal containing copper and iron predominately. This provided synchronising (of sorts) and long life. The brass compounds used these days offer improved synchronising, though nowhere near that of modern gearboxes. In reality the actual ring size and friction area are inadequate. The working life of the ring is indicated externally by the gap between the dog teeth on the ring and the gear, from the 0.045" (new) down to 0.025" (worn) range. It is not unknown for less than scrupulous rebuilders to skim off the back face to give the appearance of a new ring. The problem here is that this ignores the relationship between the areas shown, A and B, to give the internals of the box their correct clearance.



|   |   |     |         |
|---|---|-----|---------|
| 25  | SYNCHRO HUB ASSEMBLY, 3rd & 4th; original fitment | 1   | 509649  |
|   | alternative to 509649                             | 1   | 153844  |
| 26  | OUTER SLEEVE, 3rd & 4th synchro hub               | 1   | 153844X |
| 27  | BALL  | 3   | BLS108  |
| 28  | SPRING; use in 509649 hub                         | 3   | 137988  |
|   | use in 153844 hub                                 | 3   | 153318  |
| 29  | SHIM, spring tension adjusting                    | A/R | 37948   |
| 30  | CIRCLIP, retaining third gear*                    | 1   | 55707   |
| *Never try to reuse an old 55707 circlip. |   |     |         |

|    |  |   |        |
|----|--|---|--------|
| 31 | WASHER, retaining; alternative to 157054 | 1 | 156136 |
|    | alternative to 156136                    | 1 | 157054 |

|   |                         |   |        |
|---|-------------------------|---|--------|
| 32  | BUSH, third gear; brass | 1 | 129940 |
|   | steel*                  | 1 | 153238 |
| *The bush part no. 153238, may be considered uprated and can be used to replace 129940. |                         |   |        |

|  |                            |   |         |
|--|----------------------------|---|---------|
| 33   | GEAR, third                | 1 | 105630  |
| 34   | BUSH, second gear (brass)  | 1 | 129939  |
| 35   | BUSH, second gear, uprated | 1 | 129939X |
| The brass second gear bush often breaks where its flange joins the cylindrical body. This breakage leads to excessive end float in the second and third gears, which in turn causes severe and rapid mechanical failure. This uprated bush may be supplied as a one or two piece item. |                            |   |         |

|    |                               |     |         |
|----|-------------------------------|-----|---------|
| 36 | GEAR, second                  | 1   | 105629  |
| 37 | GEAR KIT, second, uprated     | 1   | 152771X |
| 38 | WASHER, spacer; 0.118, silver | A/R | 129941  |
|    | 0.121, green                  | A/R | 129942  |
|    | 0.124, blue                   | A/R | 129943  |
|    | 0.127, orange                 | A/R | 129944  |
|    | 0.131, uncoloured             | A/R | 155951  |
|    | 0.132                         | A/R | 134670  |

|    |  |   |         |
|----|--|---|---------|
| 39 | SYNCHRO CUP, 1/2 synchro hub; standard | 2 | 113431  |
|    | superior material                      | 2 | 113431X |

|    |   |   |        |
|----|---|---|--------|
| 40 | SYNCHRO HUB ASSEMBLY, 1st, 2nd, reverse; original fitment | 1 | 515650 |
|    | alternative to 515650                                     | 1 | 153843 |
| 41 | GEAR, 1st, 2nd, reverse synchro hub                       | 1 | 152773 |

|    |                                |     |        |
|----|--------------------------------|-----|--------|
| 42 | BALL                           | 3   | BLS108 |
| 43 | SPRING; use in 515650 hub      | 3   | 137988 |
|    | use in 153843 hub              | 3   | 153318 |
| 44 | SHIM, spring tension adjusting | A/R | 37948  |
| 45 | WASHER, spacer; 0.118, silver  | A/R | 129941 |
|    | 0.121, green                   | A/R | 129942 |
|    | 0.124, blue                    | A/R | 129943 |
|    | 0.127, orange                  | A/R | 129944 |
|    | 0.131, uncoloured              | A/R | 155951 |
|    | 0.132, yellow                  | A/R | 134670 |
| 46 | BUSH, first gear; brass        | 1   | 129940 |
|    | steel*                         | 1   | 153238 |

\*The bush part no. 153238, may be considered uprated and can be used to replace 129940.

|    |                                    |   |        |
|----|------------------------------------|---|--------|
| 47 | GEAR, first (33 teeth)             | 1 | 128100 |
| 48 | WASHER, between 1st gear & bearing | 1 | 116496 |

### Countershaft Gears

|                          |  |   |        |
|--------------------------|--|---|--------|
| 49                       | THRUST WASHER, countershaft, front       | 1 | 129955 |
| 50                       | BEARING, countershaft, open cage type2   | 1 | 150339 |
| 51                       | CIRCLIP, countershaft bearing retaining* | 2 | 147749 |
| 52                       | SPACER, supporting bearing *             | 2 | 154396 |
| *Use with bearing 150339 |  |   |        |

|    |                                   |   |        |
|----|-----------------------------------|---|--------|
| 53 | BEARING, countershaft, shell type | 2 | 126862 |
|----|-----------------------------------|---|--------|

Alternative to items 52-54.

Bearing part no. 126862, originally fitted in TR3Bs, TR4s and TR4As, was never fitted in production TR5s or TR250s. By this time the factory, to improve the durability of the countershaft bearings, had changed production gearboxes to use the open cage type bearing, this type being a more efficient high speed bearing arrangement. The earlier shell type bearings do however appear in the later gearboxes as they proved to be a good alternative to salvage countershaft gears with slightly pitted bearing surfaces. When fitting new countershafts and gears the open cage bearings should always be used. The 126862 shell type bearing is identifiable by an external solid steel shell or case. It is a press fit in the countershaft gear. The 150339 open cage bearing is loose fitted in the counter gear and is retained by a spacer and circlip except on early installations. If the countershaft gear has a circlip groove, it must be fitted with a circlip to retain the bearing.

|                       |  |   |        |
|-----------------------|--|---|--------|
| 54                    | CONSTANT GEAR, countershaft                  | 1 | -      |
| See note with item 6. |  |   |        |
| 55                    | DISTANCE PIECE                               | 1 | 59456  |
| 56                    | GEAR, countershaft, third                    | 1 | 140509 |
| 57                    | GEAR, countershaft, second                   | 1 | 140508 |
| 58                    | LAYGEAR, 1st & reverse (16 tooth first gear) | 1 | 128107 |

It is strongly recommended that the post-73 TR6 laygear, UKC662 (with its matching 1st speed gear 152803), be used for all uprated/modified engine/competition boxes. Please see the chart at the end of this section for details.



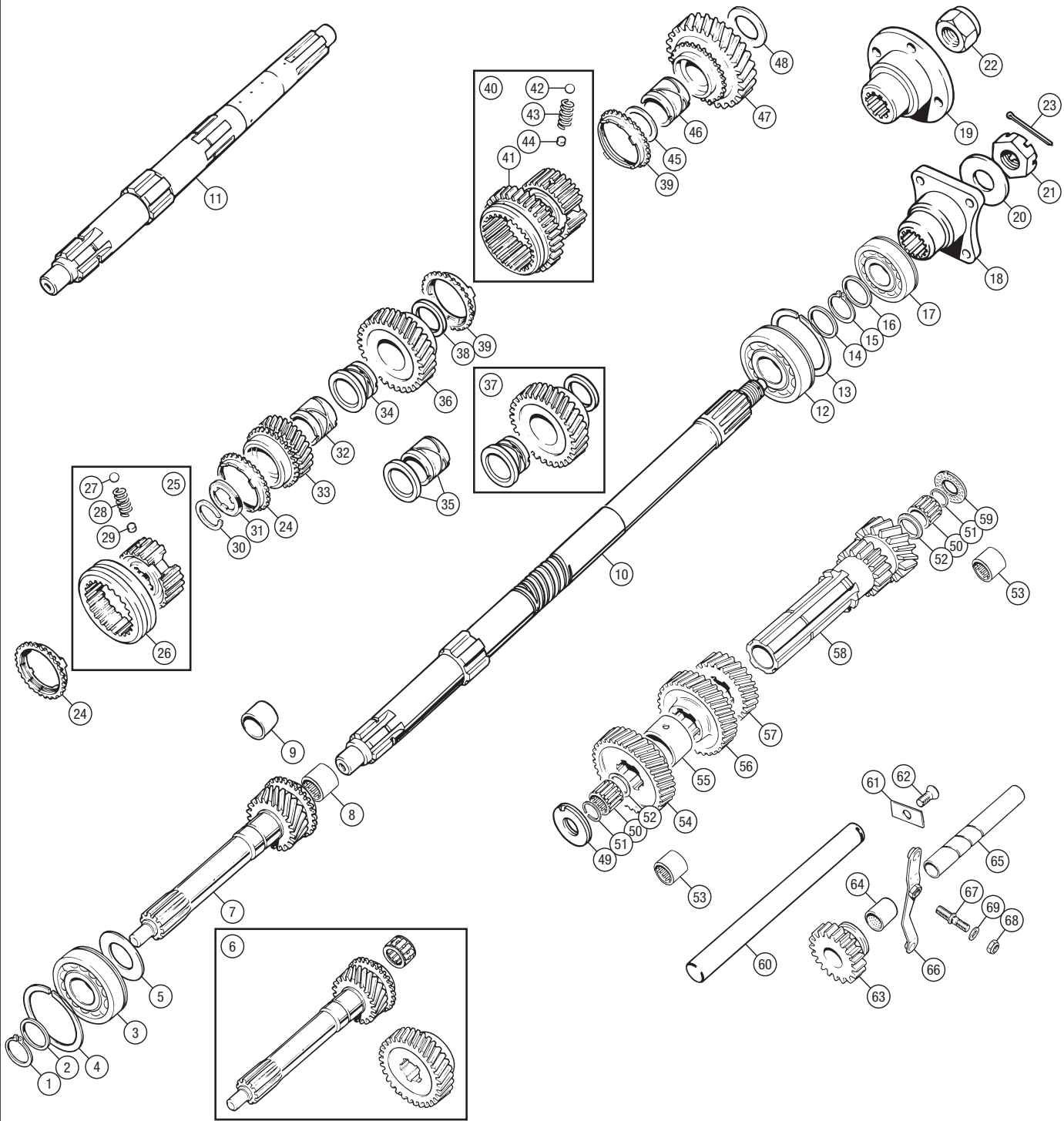
### UPRATED LAYGEARS

Most TR owners know that the Stag and Police spec saloon gearboxes were uprated by the modifications to the weak zones of the laygear and shaft, and the replacement of the bimetal thrust washers with needle bearing thrusts. The rear end of the shaft and gearbox became 'metric', so this conversion would be quite difficult. Uprated laygears come complete with 3 bearings and fittings. The twin bearings fitted to the rear end each have twice the load capacity of the original (150339). They fit the standard gearbox and layshaft, so no modifications are required. If your gearbox has suffered such a failure, you will appreciate this is a "fit and forget" solution.

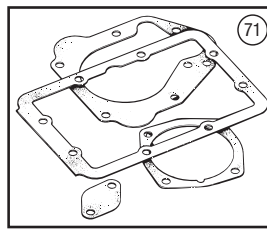
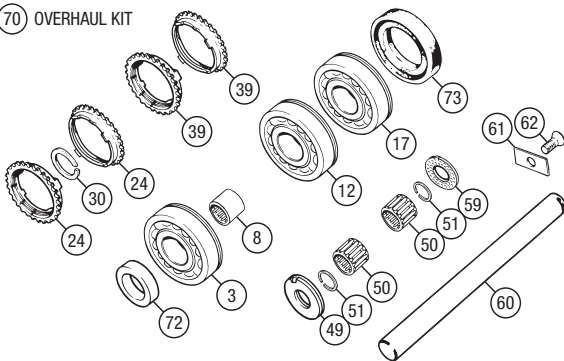
|   |   |          |
|---|---|----------|
| LAY GEAR KIT, uprated                           | 1 | 128107UR |
| Includes bearings, circlips and thrust washers. |   |          |

|    |  |   |        |
|----|--|---|--------|
| 59 | THRUST WASHER, countershaft, rear                    | 1 | 129956 |
| 60 | COUNTERSHAFT   | 1 | 128105 |
| 61 | PLATE, locking countershaft and reverse gear spindle | 1 | 129938 |
| 62 | SCREW, countersunk, lock plate                       | 1 | 129954 |



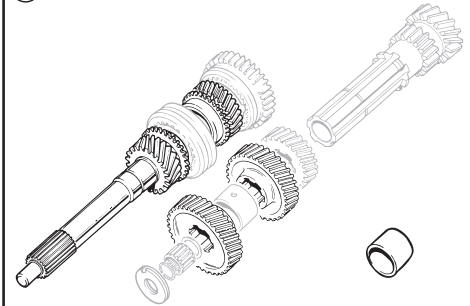


(70) OVERHAUL KIT



(71)

(74) CLOSE RATIO GEAR SET





## TR3B(TCF)-4-4A-5-250

### Reverse Gear

|    |                                       |   |        |
|----|---------------------------------------|---|--------|
| 63 | GEAR, reverse                         | 1 | 128110 |
| 64 | BUSH, reverse gear                    | 1 | 129862 |
| 65 | SPINDLE, reverse gear                 | 1 | 129937 |
| 66 | LEVER, reverse operating              | 1 | 129894 |
| 67 | PIN, fulcrum, reverse operating lever | 1 | 106448 |
| 68 | NUT, nyloc                            | 1 | TN3209 |
| 69 | WASHER, plain                         | 1 | GHF333 |

### Gearbox Overhaul Kits

Our gearbox overhaul kits contain the parts you will need to rebuild a tired but serviceable gearbox.  
See also Overdrive Overhaul Kit on the following pages.

#### NON-OVERDRIVE GEARBOX

|    |                      |   |        |
|----|----------------------|---|--------|
| 70 | GEARBOX OVERHAUL KIT | 1 | RR1386 |
|----|----------------------|---|--------|

The above kit contains the following parts:

|   |                                    |   |        |
|---|------------------------------------|---|--------|
| 71  | GASKET SET, gearbox                | 1 | 515121 |
| 72  | OIL SEAL, constant pinion          | 1 | 141756 |
| 73  | OIL SEAL, rear                     | 1 | 146129 |
| 3   | BEARING, constant pinion shaft     | 1 | 58391  |
| 8   | BEARING, mainshaft spigot          | 1 | 145008 |
|   | BEARING, mainshaft spigot*         | 1 | 158368 |
| *The application of this kit is shared with earlier TR6 models; thus bearing 158368 is not required for original TR3B, TR4, TR4A, TR5 or TR250 gearboxes. |                                    |   |        |
| 12  | BEARING, mainshaft centre          | 1 | 58391  |
| 17  | BEARING, mainshaft rear            | 1 | 513897 |
| 24  | SYNCHRO CUP, 3/4 synchro hub       | 2 | 113431 |
| 30  | CIRCLIP, retaining third gear      | 1 | 55707  |
| 39  | SYNCHRO CUP, 1/2 synchro hub       | 2 | 113431 |
| 49  | THRUST WASHER, countershaft, front | 1 | 129955 |
| 50  | BEARING, countershaft              | 2 | 150339 |
| 51  | CIRCLIP, bearing retaining         | 2 | 147749 |
| 59  | THRUST WASHER, countershaft, rear  | 1 | 129956 |
| 60  | COUNTERSHAFT                       | 1 | 128105 |
| 61  | PLATE, locking countershaft        | 1 | 129938 |
| 62  | SCREW, countersunk, lock plate     | 1 | 129954 |

#### GEARBOX FITTED WITH 'A' TYPE OVERDRIVE

|  |                      |   |        |
|--|----------------------|---|--------|
|  | GEARBOX OVERHAUL KIT | 1 | RR1387 |
|--|----------------------|---|--------|

Not illustrated.

The above kit contains the following parts:

|   |                                    |   |        |
|---|------------------------------------|---|--------|
| 71  | GASKET SET, gearbox                | 1 | 515121 |
|   | GASKET, overdrive adaptor          | 1 | 502556 |
| 72  | OIL SEAL, constant pinion          | 1 | 141756 |
| 73  | OIL SEAL, rear                     | 1 | 146129 |
| 3   | BEARING, constant pinion shaft     | 1 | 58391  |
| 8   | BEARING, mainshaft spigot          | 1 | 145008 |
|   | BEARING, mainshaft spigot          | 1 | 158368 |
| *The application of this kit is shared with earlier TR6 models; thus bearing 158368 is not required for original TR3B, TR4, TR4A, TR5 or TR250 gearboxes. |                                    |   |        |
| 12  | BEARING, mainshaft centre          | 1 | 58391  |
| 24  | SYNCHRO CUP, 3/4 synchro hub       | 2 | 113431 |
| 30  | CIRCLIP, third gear on mainshaft   | 1 | 55707  |
| 39  | SYNCHRO CUP, 1/2 synchro hub       | 2 | 113431 |
| 49  | THRUST WASHER, countershaft, front | 1 | 129955 |
| 50  | BEARING, countershaft              | 2 | 150339 |
| 51  | CIRCLIP, bearing retaining         | 2 | 147749 |
| 59  | THRUST WASHER, countershaft, rear  | 1 | 129956 |
| 60  | COUNTERSHAFT                       | 1 | 128105 |
| 61  | PLATE, locking countershaft        | 1 | 129938 |
| 62  | SCREW, countersunk                 | 1 | 129954 |

### Close Ratio Gear Set

Suitable for all Triumph gearboxes with needle roller constant pinion bearings, including 2000 but not Stag or Sprint.  
The gear set uses a 1" x 23 spline input shaft to allow use of a wider range of clutches. It includes 3rd and 4th gear pairs and an adaptor enabling fitment to the imperial-spigoted mainshaft. Suits lower axle ratio e.g. 4.1:1.

|    |                      |   |        |
|----|----------------------|---|--------|
| 74 | CLOSE RATIO GEAR SET | 1 | RR1512 |
|----|----------------------|---|--------|



GEARBOX OVERHAUL KIT  
NON-OVERDRIVE - RR1386

### INTERCHANGING COMPONENTS

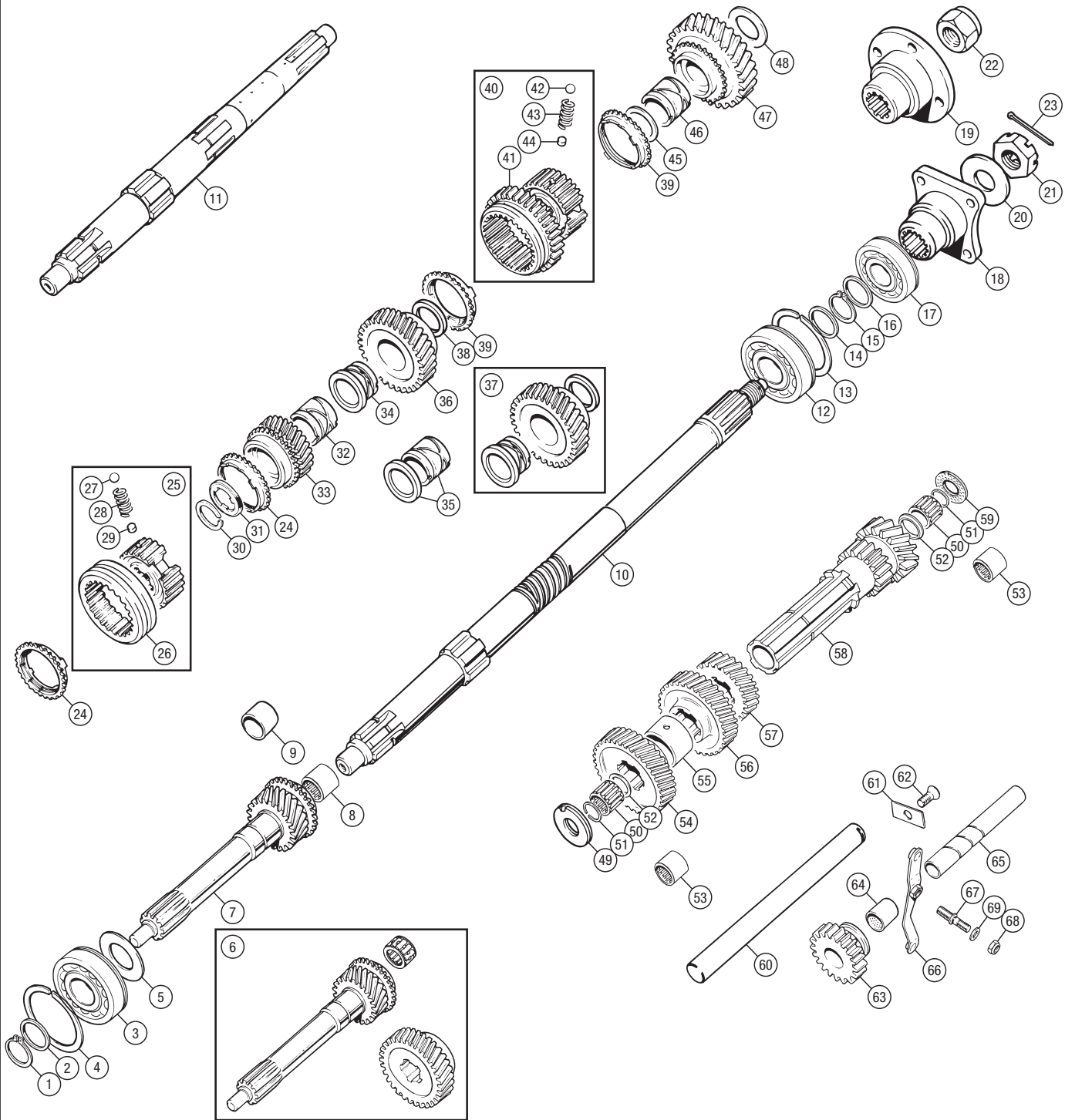
The internal components of the 4 synchro gearbox changed hardly at all during TR3B, TR4, TR4A, TR5 and TR250 production. The problems of which replacement parts to fit really arise if you find you have a TR6 gearbox in your car - in which case the internal components changed several times during production. Changes that are crucial are those that mean whole running assemblies must be changed rather than individual components. Below is a table showing the gearboxes by serial number and the changes to internal components. The four basic sets of gears are interchangeable as sets, the mainshaft will of course govern their use ultimately if overdrive is used. The most significant and frequent changes were to the helix or tooth angle of the gears - 3 in the life of the TR6! The spigot size on the mainshaft changed from imperial to metric which required matching constant pinion gears.

| Illus. No. | Description                 | Type 1 TR3B-TR6<br>(g)CT prefixes<br>& to (g)CD20281 | Type 2 TR6<br>(g)CD20282<br>to (g)CD21768 | Type 3 TR6<br>(g)CD21769<br>to (c)CR5000 | Type 4 TR6<br>from (c)CR5001<br>(J type overdrive) |
|------------|-----------------------------|--|---|--|--|
| 7          | Constant Pinion Shaft       | *  | 216044                                    | 219126                                   | 219126   |
| 8          | Constant Pinion Shaft Bush  | 145008   | -   | -  | -  |
| 9          | Constant Pinion Shaft Bush  | (see note on page 91, reference part no. 9)          |   |  |  |
| -          | Constant Pinion Shaft Bush  | -  | 150989                                    | 150989                                   | 150989   |
| 10         | Mainshaft Non O/D           | 208051   | TKC824                                    | TKC824                                   | TKC824   |
| 11         | Mainshaft O/D Models        | 208052   | UKC1933                                   | UKC1933                                  | -  |
| -          | Mainshaft O/D Models        | -  | -   | -  | TKC832   |
| 25         | Synchro Hub Ass'y 3/4       | 509649   | 153844                                    | 153844                                   | 153844   |
| 32         | Third Gear Bush             | 129940   | 129940                                    | 129940                                   | 153238   |
| 33         | Third Gear                  | 105630   | 152772                                    | 152772                                   | 152772   |
| 34         | Second Gear Bush            | 129939   | 129939                                    | 129939                                   | UKC956   |
| 36         | Second Gear                 | 105629   | 152771                                    | 216802                                   | TKC454   |
| 40         | Synchro Hub Ass'y 1/2       | 515650   | 153843                                    | 153843                                   | 153843   |
| 46         | First Gear Bush             | 129940   | 129940                                    | 129940                                   | 153238   |
| 47         | First Gear                  | 128100   | 152770                                    | 152803                                   | 152803   |
| 54         | Constant Gear, Countershaft | *  | 142434                                    | 159621                                   | 159621   |
| 57         | Countershaft Gear, Second   | 140508   | 140508                                    | 155047                                   | 155047   |
| 60         | Countershaft                | 128107   | 128107                                    | UKC662                                   | UKC662   |

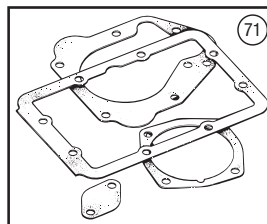
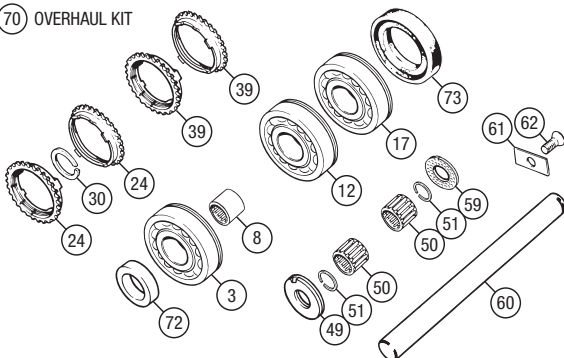
\*Part of kit 148949.



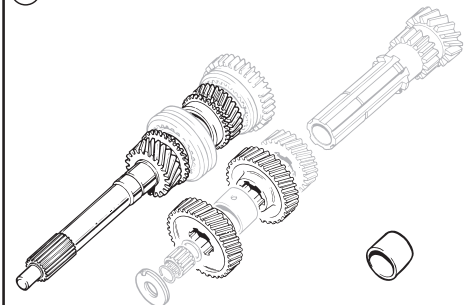




**(70) OVERHAUL KIT**



**(74) CLOSE RATIO GEAR SET**





## ALL MODELS

## OVERDRIVE

An overdrive conversion is among the most useful. The 'A' Type overdrive unit that was fitted as an option as a rule operates in 2nd, 3rd and 4th gears. The only exception to the rule is for the overdrive unit originally fitted to TR2s up to TS5979, which operates in 4th gear only. Overdrive provides a 22% reduction ratio to the engine speed for a given road speed when engaged. The reduction ratio is signified by the serial number prefix of the Laycock unit. In the case of the TR 'A' Type this is 22; other cars used a different ratio unit, notably the Standard Vanguard at 28%, whose serial number begins 28/..... Overdrive gives useful additional gear ratios, for use under all driving conditions. Creeping about in town, the use of 2nd overdrive and 2nd gear saves on the continual 2nd to 3rd to 2nd gear changes. It nicely bridges that 2nd to 3rd speed ratio gap. The 4th gear overdrive provides effortless high speed long distance touring economy. The 3rd gear gives that little extra help for high speed overtaking when an upward gear change could best be ignored.

## Overdrive

## TR2 to TS5979; Serial No. 22/61275

|  |   |               |
|--|---|---------------|
| 1 OVERDRIVE UNIT, 'A' type, reconditioned exchange | 1 | 305063R-EARLY |
|--|---|---------------|

## TR2 from TS5980, TR3, TR3A, TR3B, TR4 to Oct. 1964; Serial No. 22/61374

|  |   |              |
|--|---|--------------|
| OVERDRIVE UNIT, 'A' type, reconditioned exchange | 1 | 305063R-LATE |
|--|---|--------------|

## TR4 from Oct. 1964, TR4A solid axle; Serial No. 22/61712

|  |   |              |
|--|---|--------------|
| OVERDRIVE UNIT, 'A' type, reconditioned exchange | 1 | 305063R-LATE |
|--|---|--------------|

## TR4A IRS, TR5, TR250; Serial No. 22/61753

|  |   |         |
|--|---|---------|
| OVERDRIVE UNIT, 'A' type, reconditioned exchange | 1 | 309159R |
|--|---|---------|

Notes: Depending upon availability the type of annulus fitted to reconditioned exchange overdrives may differ from original, necessitating recalibration of the speedometer.

After initialisation, it is important to set up the actuation valve lever accurately to ensure correct operation. Ensure gearbox is clean internally before fitting overdrive - avoid cross-contamination from dirty oil.

|   |   |          |
|---|---|----------|
| 2 GASKET, adaptor plate to gearbox          | 1 | 132465   |
| 3 MAINSHAFT, overdrive;                     |   |          |
| TR2, TR3, TR3A to TS26824                   | 1 | 110736   |
| TR3A from TS26825, TR3B TSF series          | 1 | 204044   |
| TR3B TCF series, TR4, TR4A, TR5, TR250      | 1 | 208052   |
| 4 SOLENOID, overdrive operating             | 1 | 109521   |
| 5 PLUNGER ONLY                              | 1 | 109521PL |
| 6 COVER, rubber, solenoid wiring            | 1 | 112946   |
| 7 BOOT, solenoid plunger                    | 1 | 105921   |
| 8 GASKET, solenoid to bracket               | 1 | 7H8196   |
| 9 SCREW, solenoid to bracket                | 2 | HU504    |
| 10 WASHER, locking                          | 2 | WL105001 |
| 11 GEAR & SPINDLE ASSEMBLY                  | 1 | 147965   |
| 12 'O' RING, housing to extension           | 1 | RTC1949  |
| 13 BEARING HOUSING, speedo gear             | 1 | 146542   |
| 14 OIL SEAL, spindle to bearing housing     | 1 | NKC105A  |
| 15 SCREW, special, locating bearing housing | 1 | 506071   |
| 16 WASHER, copper, sealing screw            | 1 | 500469   |
| 17 ANGLE DRIVE, TR4A, TR5, TR250            | 1 | 120694   |
| 18 WASHER, sealing, TR4A, TR5, TR250        | 1 | 538532   |

ANGLE DRIVE - 120694



## Speedometer Cables

## 19 SPEEDOMETER CABLE (overdrive);

TR2, TR3, TR3A, TR3B

84" RH steering 1 504611

96" LH steering 1 504609

TR4, TR4A, TR5, TR250

69" RH/LH steering 1 GSD169

The 69" long speedometer cable is the one preferred for RH steering cars as it allows that little extra length when routing. Remember all cables must be securely clipped to prevent chaffing or snagging.

## Adaptor Plate &amp; Casings

## 20 ADAPTOR PLATE, overdrive to gearbox 1 208098

21 SCREW;

Locwel 6 155542

plain, (Alternative) 6 HU857

22 WASHER, plain (use with 'Locwel' screw) 6 GHF301

23 WASHER, locking (use with plain screw) 6 GHF332

24 GASKET, adaptor plate to overdrive 1 502556

25 CASING ASSEMBLY, front 1 503159

26 NAMEPLATE, black, brass 1 CRST264

27 NAMEPLATE, black, aluminium 1 CRST265

28 SCREW, drive, securing nameplate 2 FAS2

29 PLUG, welch 1 500570

30 STUD, 2 5/8" long 2 500576

31 STUD, 1" long 1 500666

32 STUD, 1 1/4" long 3 FHS2510

33 NUT 6 GHF201

34 WASHER, locking 6 GHF332

35 SHAFT, operating 1 513908

36 LEVER, adjustment setting 1 513909

37 MILLS PIN, adjustment lever 1 513888

38 CAM, on shaft 1 513910

39 PIN, cam to shaft 1 500593

40 GASKET, solenoid bracket to casing 1 500645

41 BRACKET, solenoid mounting 1 502566

42 DOWEL PIN 1 UKC1937

43 STUD, bracket assembly 2 TE605111

44 WASHER, locking 2 GHF332

45 NUT 2 GHF201

46 SCREW, bracket to body 2 103268

47 WASHER, locking 2 GHF332

48 WASHER, plain 2 GHF301

49 STONE SHIELD 1 502569

50 'O' RING, operating shaft 2 500594

51 COLLAR, for shaft 1 502567

52 LEVER, actuating 1 502568

53 BOLT, clamping, lever to shaft 1 SH604091

54 WASHER, plain 1 WP127

55 NUT 1 503164

56 SCREW, adjusting, solenoid stop 1 513918

57 NUT, locking 1 513919

58 REAR CASING ASSEMBLY 1 500655

59 STUD, rear casing, upper 4 112907

60 STUD, rear casing, lower 2 500579

61 NUT 6 GHF201

62 WASHER, locking 6 GHF332

## Operating Valve, Oil Pump &amp; Filter

63 VALVE, operating 1 500658

64 BALL, operating valve 1 BLS110

65 PLUNGER, operating valve 1 500591

66 SPRING, operating valve 1 506070

67 WASHER, sealing 1 3H693

68 PLUG, operating valve 1 268095

69 CAM, overdrive oil pump driving 1 500627

70 PLUNGER ASSEMBLY, oil pump 1 513891

71 SPRING, pump plunger 1 500633

72 GUIDE, peg 1 268112

73 BODY, oil pump 1 505507

74 WASHER, locking 2 WL105001

75 SCREW, oil pump to body 2 PX505

76 PLUG, in pump body 1 513902

77 FILTER 1 509884

78 MAGNET 1 513205

79 WASHER, fibre 1 500641

## TR2, TR3, TR3A, TR3B, TR4, TR4A solid axle

80 DISTANCE TUBE 1 505551

81 WASHER, plain 1 WP5

82 WASHER, locking 1 WL105001

83 BOLT 1 103270

84 CAP, oil drain 1 500620

Note: The 500620 drain cap can be replaced by the later 513904 or 521814, but only if the distance tube, washers and bolt are removed.

## TR4A IRS, TR5, TR250 IRS axle

85 CAP, oil drain;

original 1 513904

replacement 1 521814

86 SPANNER, oil drain cap 1 TMG4901

87 BALL, pump valve;

Not TR4A IRS, TR5, TR250 1 BLS110

TR4A IRS, TR5, TR250 1 BLS108

88 PLUNGER, pump valve 1 500591

89 SPRING, pump valve 1 506070

90 WASHER, sealing 1 3H693

91 PLUG, pump valve 1 268095

## Accumulator Pistons

## TR2, TR3, TR3A, TR3B, TR4, TR4A solid axle

92 ACCUMULATOR PISTON, with ring 1 502565

93 PISTON RING 1 500605

94 SPRING, accumulator, outer 1 500634

95 SPRING, accumulator, inner 1 503167

- SPRING SET, outer &amp; inner 1 500634K

## TR4A IRS, TR5, TR250 IRS axle

96 HOUSING, accumulator 1 501864

97 'O' RING 1 501910

98 ACCUMULATOR PISTON, with rings 1 501909

99 PISTON RING SET 1 505555

100 SPACING TUBE 1 502563

101 SPRING, accumulator 1 518601

102 WASHER, packing A/R 513900

The renewal of the overdrive accumulator spring often revitalises the sluggish operation of a previously condemned overdrive unit, the original spring having lost some of its strength and tension after years of operating in temperature extremes.

103 BREATHER 1 502560

This breather is always fitted to TR overdrives. Triumph saloon models 2000 and 2.5 always had a an 3/8" AF squared headed plug. This is another clue to the origin of your overdrive.

## Operating Piston

## TR2 to TS5979

104 OPERATING PISTON, with rings,

1 1/8" dia., set of 2 1 503161

105 RING SET 2 503162

## TR2 from TS5980, TR3, TR3A, TR3B, TR4, TR4A, TR5, TR250

104 OPERATING PISTON, with 'O' ring,

1 3/8" dia., set of 2 1 513890

105 'O' RING 2 513912

## Sunwheel &amp; Planet Carrier

106 SUNWHEEL ASSEMBLY 1 505549

107 WASHER, thrust 1 500610

108 WASHER, adjusting;

0.113/0.114 A/R 500588A

0.107/0.108 A/R 500588B

0.101/0.102 A/R 500588C

0.095/0.096 A/R 500588D

0.089/0.090 A/R 500588E

0.083/0.084 A/R 500588F

0.077/0.078 A/R 500588G

109 CARRIER ASSEMBLY, planet gears 1 505545

110 BEARING, SHAFT &amp; THRUST WASHER KIT,

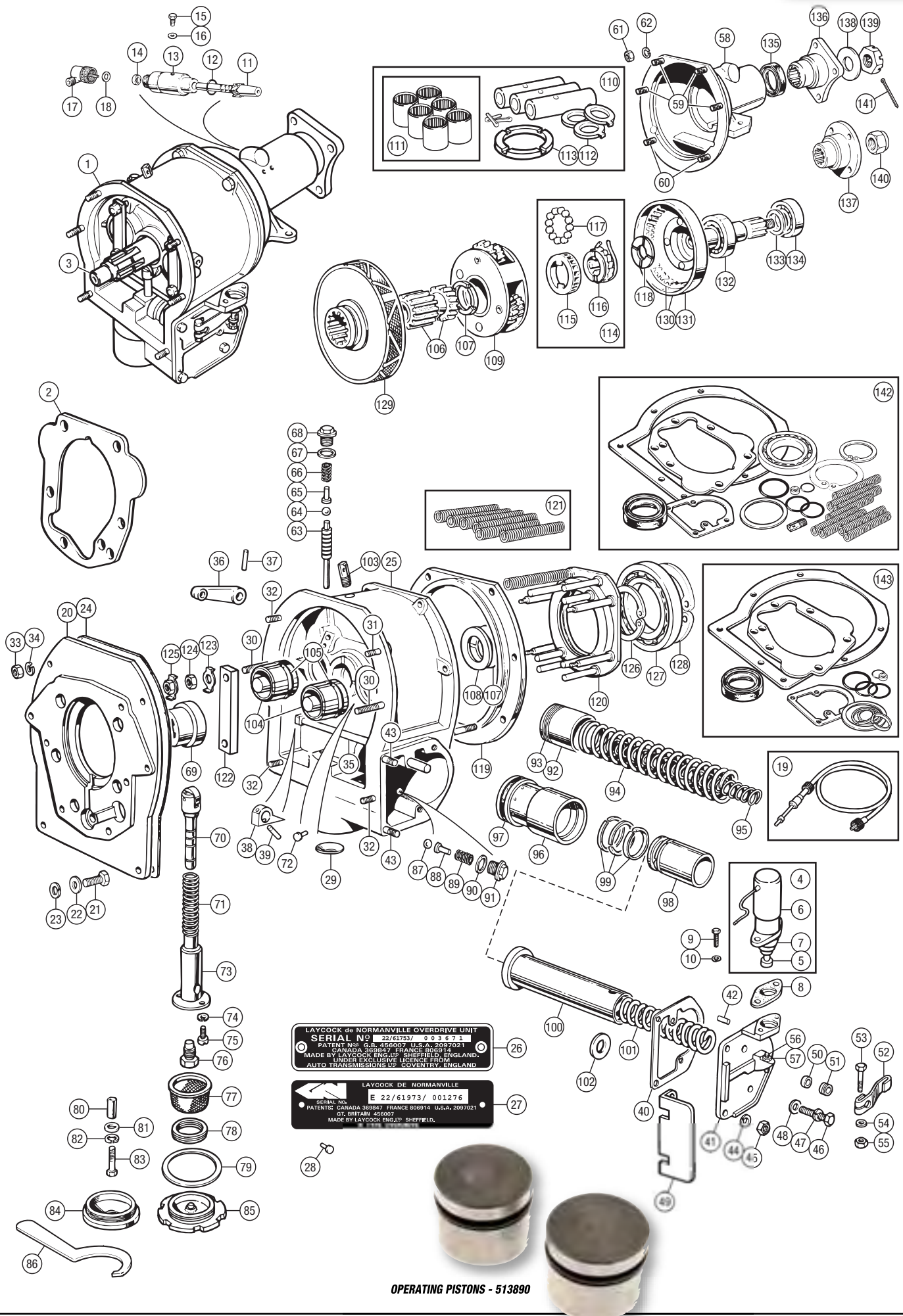
planet gears 1 505546

111 BEARING SET 1 513224

112 THRUST WASHER 3 513914

113 THRUST WASHER 1 505548







## ALL MODELS

GEARBOX - OVERDRIVE - ALL MODELS

### Directional Clutch

|                                      |   |          |
|--------------------------------------|---|----------|
| 114 CLUTCH ASSEMBLY, uni-directional | 1 | BAU2061A |
| 115 CAGE, roller retaining           | 1 | 502559   |
| 116 SPRING, cage locating            | 1 | 513208   |
| 117 ROLLER SET, (set of 12)          | 1 | 506063A  |
| 118 THRUST WASHER, 0.125"            | 1 | 500613   |

### Brake Ring & Clutch Sliding Member

|  |   |        |
|--|---|--------|
| 119 BRAKE RING                               | 1 | 502555 |
| 120 RING ASSEMBLY, clutch thrust with pins   | 1 | 500660 |
| 121 SPRING SET, clutch operating, (set of 8) | 1 | 502554 |
| 122 BRIDGE PIECE                             | 2 | 500587 |
| 123 WASHER, tab, locking nut                 | 4 | 500642 |
| 124 NUT                                      | 4 | GHF200 |
| 125 NUT, locking                             | 4 | JS616A |

*Alternative to plain nut and tab washer.  
Always inspect the thrust ring (ill. no. 120) assembly for loose pins. If the pins are found to be loose they can be tightened in their location by peening the swaged area on the back of the ring where the pin protrudes through.*

|  |   |         |
|--|---|---------|
| 126 CIRCLIP, ball bearing retaining      | 1 | 500636  |
| 127 BEARING ASSEMBLY, clutch thrust ring | 1 | 500640  |
| 128 CIRCLIP, ball bearing retaining      | 1 | 500637  |
| 129 CLUTCH ASSEMBLY, sliding member;     |   |         |
| new                                      | 1 | 500661  |
| reconditioned exchange                   | 1 | 500661R |
| new (Alternative)                        | 1 | 520975  |
| reconditioned exchange (Alternative)     | 1 | 520975R |
| new (Alternative)                        | 1 | 518107  |
| reconditioned exchange (Alternative)     | 1 | 518107R |

### Annulus & Rear Flange

|   |     |         |
|---|-----|---------|
| 130 ANNULUS ASSEMBLY                    | 1   | 500602  |
| 131 RING, outer, uni-directional clutch | 1   | 500602X |
| 132 BEARING ASSEMBLY, annulus front     | 1   | SP74G   |
| 133 WASHER, adjusting;                  |     |         |
| 0.146"                                  | A/R | 500623E |
| 0.151"                                  | A/R | 500623F |
| 0.156"                                  | A/R | 500623G |
| 0.161"                                  | A/R | 500623H |
| 0.166"                                  | A/R | 500623J |
| 134 BEARING ASSEMBLY, annulus rear      | 1   | 513897  |
| 135 OIL SEAL                            | 1   | 146129  |
| 136 FLANGE, mainshaft, square           | 1   | 58948   |
| <i>Original fitment.</i>                |     |         |
| 137 FLANGE, mainshaft, round            | 1   | 518109  |
| <i>Alternative to square flange.</i>    |     |         |
| 138 WASHER, plain                       | 1   | WP24    |
| 139 NUT, slotted                        | 1   | 57868   |
| 140 NUT, nyloc                          | 1   | 157642  |
| <i>Alternative to slotted nut.</i>      |     |         |
| 141 SPLIT PIN                           | 1   | PC12    |
| <i>Use with slotted nut.</i>            |     |         |

### OVERDRIVE HINTS

The correct operating pressure (o.p.) range is 380-400PSI. On an otherwise good overdrive our new springs should increase this by 20PSI (i.e. 400-420PSI). The overdrive ceases to be of any use below 360PSI. Padding the spring will increase the operating pressure. Never add more than 0.040", which may produce an extra 20-40PSI, though the engagement will be fiercer. Packing a worn spring will make no difference. The pressure should be measured using a suitable gauge reading up to at least 500PSI, screwed in place of illustration no. 68 in the operating valve port.

#### Fault Diagnosis:

- Most work requires removal of the gearbox from the car and the overdrive from the gearbox.
- Jumping out of overdrive when warm/under load is usually due to worn accumulator piston rings and often the bore.
- A stuck pump piston may be accessed from the underneath by removing illustration no. 84/85, the illustration no. 76 and pushing upwards on the revealed base of the plunger (illustration no. 70). If it sticks again, you're wasting your time, go back to '1'.
- A sudden cessation is often caused by the circlip (illustration no. 126) breaking - go back to '1'.
- Intermittent working may be cured by dumping gearbox and overdrive oil and cleaning the filter (illustration no. 77) and the magnetic collectors (illustration no. 78). Refill with 20/50 multigrade oil, run for an hour or so (up to 50 miles) and dump the oil again. Refill this time with hypoid oil (XPG041L).
- Air trapped in the system can often be bled out by removal of plug illustration no. 68. Place a catch tank under the car below the valve. With the back wheels jacked off the ground, start the engine, engage 4th gear and allow air to pump out of the port for 1 to 2 minutes. Replace the plug and top up to correct the oil level.
- If the overdrive does not disengage, don't even think about using reverse gear. Again, remove plug illustration no. 68, then illustration nos. 67 to 63. Inspect valve illustration no. 63 and you'll see a tiny hole about midway from either end. Scrupulously clean the whole valve and check the hole by sucking or blowing through it, then carefully replace illustration nos. 63 to 68. Don't forget to reseat ball illustration no. 64 into the casing. Check the engagement again. Sometimes the clutch linings (illustration no. 129) stick to the brake ring. A sharp tap or two with an iron hammer often releases the bond. Failure of these two suggestions to cure the lack of disengagement usually requires a return to no. 1 above.
- That clutch slip feeling under load or while engaging overdrive is probably due to a worn illustration no. 129, especially if the overdrive feels hot and the oil smells. Replacement of no. 129 is the only answer (via no. 1).
- The above hints assume there is no other problem associated with electrics (wiring/switches), which should of course be checked first if the overdrive fails to operate correctly.

## Overdrive Overhaul & Seal/Gasket Kits

*Overdrive overhaul kits contain the following selection of parts. Everything that you will want to service during any rebuild.*

|   |     |         |
|---|-----|---------|
| <b>TR2, TR3, TR3A, TR3B, TR4, TR4A solid axle</b>   |     |         |
| 142 OVERDRIVE OVERHAUL KIT                          | 1   | RW3066  |
| <i>The following items are included in the kit:</i> |     |         |
| 2 GASKET, adaptor plate to gearbox                  | 1   | 132465  |
| 12 'O' RING, housing to extension                   | 1   | RTC1949 |
| 14 OIL SEAL, spindle to bearing housing             | 1   | NKC105A |
| 24 GASKET, adaptor plate to overdrive               | 1   | 502556  |
| 40 GASKET, solenoid bracket to casing               | 1   | 500645  |
| 79 WASHER, fibre                                    | 1   | 500641  |
| 93 PISTON RING                                      | 1   | 500605  |
| 94 SPRING, accumulator, outer                       | 1   | 500634  |
| 95 SPRING, accumulator, inner                       | 1   | 503167  |
| 103 BREATHER  | 1   | 502560  |
| 105 RING SET, TR2 to TS5979                         | 2   | 503162  |
| 'O' RING, Not TR2 to TS5979                         | 2   | 513912  |
| 118 THRUST WASHER                                   | 1   | 500613  |
| 121 SPRING SET, clutch operating, Set of 8.         | 1   | 502554  |
| 126 CIRCLIP, ball bearing retaining                 | 1   | 500636  |
| 128 CIRCLIP, ball bearing retaining                 | 1   | 500637  |
| 132 BEARING ASSEMBLY, annulus front                 | 1   | SP74G   |
| 133 WASHER, adjusting 0.166                         | A/R | 500623J |
| 134 BEARING ASSEMBLY, annulus rear                  | 1   | 513897  |
| 135 OIL SEAL  | 1   | 146129  |

|   |     |         |
|---|-----|---------|
| <b>TR4A IRS, TR5, TR250</b>                         |     |         |
| 142 OVERDRIVE OVERHAUL KIT                          | 1   | RR1517  |
| <i>The following items are included in the kit:</i> |     |         |
| 2 GASKET, adaptor plate to gearbox                  | 1   | 132465  |
| 12 'O' RING, housing to extension                   | 1   | RTC1949 |
| 14 OIL SEAL, spindle to bearing housing             | 1   | NKC105A |
| 24 GASKET, adaptor plate to overdrive               | 1   | 502556  |
| 40 GASKET, solenoid bracket to casing               | 1   | 500645  |
| 79 WASHER, fibre                                    | 1   | 500641  |
| 97 'O' RING   | 1   | 501910  |
| 99 PISTON RING SET                                  | 1   | 505555  |
| 101 SPRING, accumulator                             | 1   | 518601  |
| 103 BREATHER  | 1   | 502560  |
| 105 'O' RING  | 2   | 513912  |
| 118 THRUST WASHER                                   | 1   | 500613  |
| 121 SPRING SET, clutch operating Set of 8.          | 1   | 502554  |
| 126 CIRCLIP, ball bearing retaining                 | 1   | 500636  |
| 128 CIRCLIP, ball bearing retaining                 | 1   | 500637  |
| 132 BEARING ASSEMBLY, annulus front                 | 1   | SP74G   |
| 133 WASHER, adjusting 0.166                         | A/R | 500623J |
| 134 BEARING ASSEMBLY, annulus rear                  | 1   | 513897  |
| 135 OIL SEAL  | 1   | 146129  |

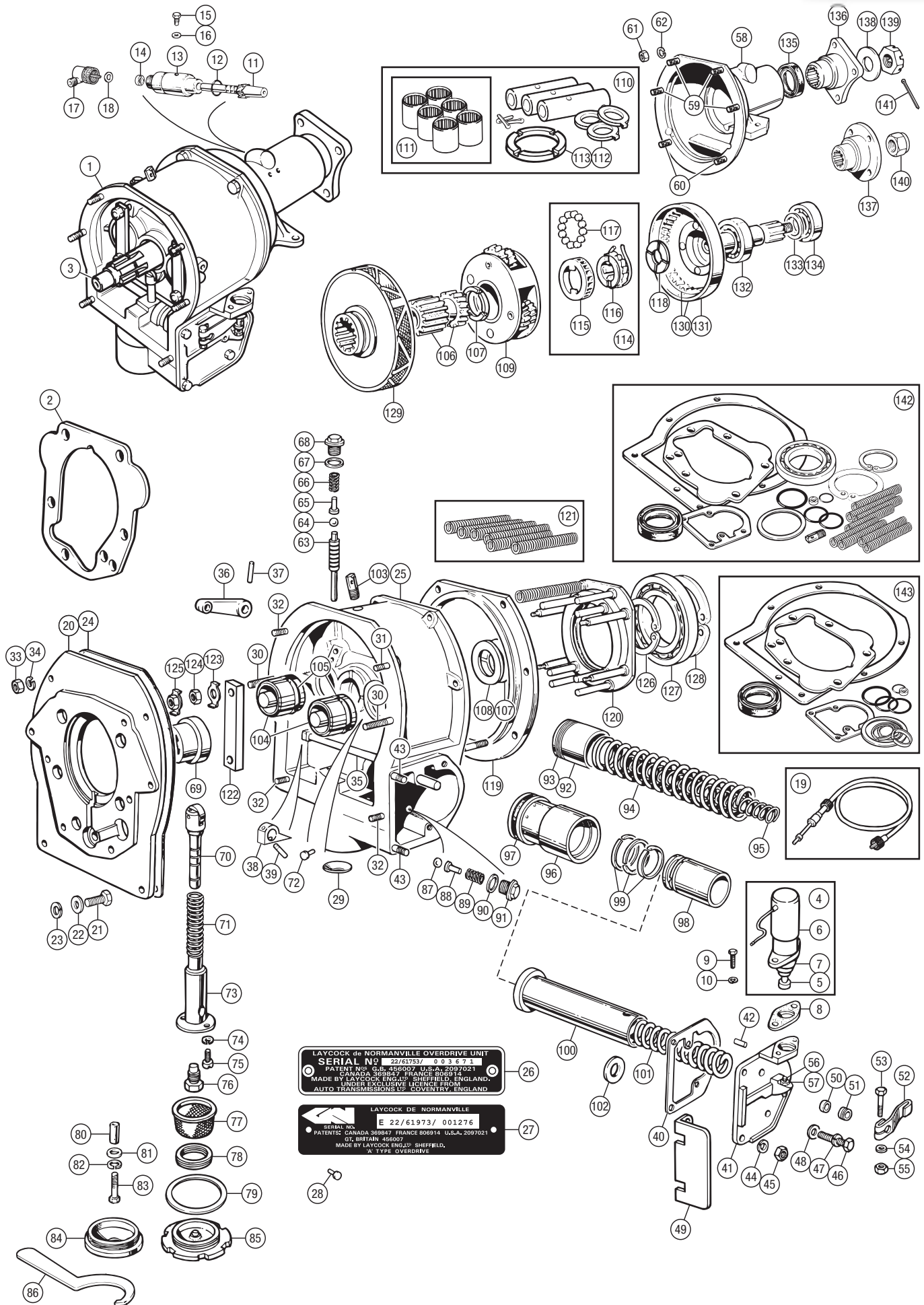
|   |   |         |
|---|---|---------|
| <b>TR2, TR3, TR3A, TR3B, TR4, TR4A solid axle</b>   |   |         |
| 143 OVERDRIVE SEAL & GASKET KIT                     | 1 | RW3067  |
| <i>The following items are included in the kit:</i> |   |         |
| 2 GASKET, adaptor plate to gearbox                  | 1 | 132465  |
| 12 'O' RING, housing to extension                   | 1 | RTC1949 |
| 14 OIL SEAL, spindle to bearing housing             | 1 | NKC105A |
| 24 GASKET, adaptor plate to overdrive               | 1 | 502556  |
| 40 GASKET, solenoid bracket to casing               | 1 | 500645  |
| 79 WASHER, fibre                                    | 1 | 500641  |
| 93 PISTON RING                                      | 1 | 500605  |
| 105 RING SET, TR2 to TS5979                         | 2 | 503162  |
| 'O' RING, Not TR2 to TS5979                         | 2 | 513912  |
| 135 OIL SEAL  | 1 | 146129  |

|   |   |         |
|---|---|---------|
| <b>TR4A IRS, TR5, TR250</b>                         |   |         |
| 143 OVERDRIVE SEAL & GASKET KIT                     | 1 | RR1518  |
| <i>The following items are included in the kit:</i> |   |         |
| 2 GASKET, adaptor plate to gearbox                  | 1 | 132465  |
| 12 'O' RING, housing to extension                   | 1 | RTC1949 |
| 14 OIL SEAL, spindle to bearing housing             | 1 | NKC105A |
| 24 GASKET, adaptor plate to overdrive               | 1 | 502556  |
| 40 GASKET, solenoid bracket to casing               | 1 | 500645  |
| 79 WASHER, fibre                                    | 1 | 500641  |
| 97 'O' RING   | 1 | 501910  |
| 105 'O' RING  | 2 | 513912  |
| 135 OIL SEAL  | 1 | 146129  |



OVERDRIVE OVERHAUL KIT - RR1517





LAYCOCK de NORMANVILLE OVERDRIVE UNIT  
SERIAL N° 22/61753/ 003671  
PATENT N°S G.B. 456007 U.S.A. 2097021  
CANADA 368847 FRANCE 806914  
MADE BY LAYCOCK ENGLD SHEFFIELD, ENGLAND.  
UNDER EXCLUSIVE LICENCE FROM  
AUTO TRANSMISSIONS LTD COVENTRY, ENGLAND

LAYCOCK de NORMANVILLE  
SERIAL N° E 22/61973/ 001276  
PATENT N°S CANADA 368847 FRANCE 806914 U.S.A. 2097021  
G.B. 456007  
MADE BY LAYCOCK ENGLD SHEFFIELD,  
A TYPE OVERDRIVE



## ALL MODELS

### A Type Overdrive Conversion Kit

#### 3 SYNCHROMESH GEARBOX

##### TR2, TR3, TR3A, TR3B TSF series

The overdrive in this kit operates in 2nd, 3rd and 4th gears, so would not strictly be original for a pre-TS5980 TR2 (4th speed operation only was correct). You could, by modifying the inhibitor switch wiring, set your overdrive up to run on 4th speed only, but really the greatly enhanced flexibility should be more than enough compensation for loss of originality!

|   |   |                          |
|---|---|--------------------------|
| 1   | OVERDRIVE CONVERSION KIT;<br>Supplied with a choice of dash switches.<br>RH steering<br>LH steering | 1RW3205RHD<br>1RW3205LHD |
| <b>This kit includes the following parts (items 2-34):</b>  |   |                          |
| 2   | GEARBOX & OVERDRIVE UNIT ASS'Y,<br>reconditioned exchange   | 1 RW3063R                |
| <i>See text for exchange requirements.<br/>Supplied less clutch operating ancillaries, gear lever and retainer (swap over from old gearbox).<br/>Note: depending on availability, the type of overdrive annulus fitted may differ from the original necessitating recalibration of the speedometer.</i> |   |                          |
| 3   | GEAR & SPINDLE ASSEMBLY   | 1 147965                 |
| 4   | 'O' RING, housing to extension  | 1 RTC1949                |
| 5   | BEARING HOUSING, speedo gear  | 1 146542                 |
| 6   | OIL SEAL, spindle to bearing housing  | 1 NKC105A                |
| 7   | SCREW, special,<br>locating bearing housing   | 1 506071                 |
| 8   | WASHER, copper, sealing screw   | 1 500469                 |
| 9   | SPEEDOMETER CABLE;<br>84" RH steering<br>96" LH steering  | 1 504611<br>1 504609     |
| 10  | FLANGE, mainshaft, square   | 1 58948                  |
| 11  | FLANGE, mainshaft, round (alternative)  | 1 518109                 |
| 12  | WASHER, plain   | 1 WP24                   |
| 13  | NUT, slotted  | 1 57868                  |
| 14  | NUT, nyloc (alternative to slotted nut)   | 1 157642                 |
| 15  | SPLIT PIN (use with slotted nut)  | 1 PC12                   |

### Overdrive Electrics

#### 3 SYNCHROMESH GEARBOX

##### TR2, TR3, TR3A, TR3B TSF series

|   |   |            |
|---|---|------------|
| 16  | SOLENOID ASS'Y, overdrive operating   | 1 109521   |
| 17  | GASKET, solenoid to bracket   | 1 7H8196   |
| 18  | SCREW, solenoid to bracket  | 2 HU504    |
| 19  | WASHER, locking   | 2 WL105001 |
| 20  | LOOM, overdrive, gearbox  | 1 131339   |
| 21  | CONNECTOR, loom, single line  | 4 104618   |
| 22  | LOOM, overdrive, body   | 1 131338   |
| 23  | GROMMET, body loom  | 1 600396   |
| 24  | 'P' CLIP, gearbox loom to top cover   | 1 AEU1581A |
| 25  | SWITCH, isolator, overdrive operation   | 2 BAU1074A |
| <i>Lucar terminals.<br/>TR2s, TR3s and TR3As up to TS60000 originally had switches with screw terminals for the wiring. The Lucar spade terminal switch listed may be used, so long as the ring terminals on the wiring are replaced with Lucar 1/4" wide spade types (part no. RTC220A).</i> |   |            |
| 26  | WASHER, switch sealing/adjusting  | A/R 502146 |
| 27  | SWITCH, overdrive, push/pull<br>TR2 to TS6265.  | 1 BHA4280  |
| 28  | KNOB, switch<br>TR2 to TS6265.  | 1 108437   |
| 29  | SWITCH, overdrive, toggle<br>TR2 from TS6266; TR3, TR3A, TR3B TSF series.   | 1 112474   |
|   | MECHANISM, switch (incl. in switch)<br>TR2 from TS6266; TR3, TR3A, TR3B TSF series.   | 1 109122   |
| 30  | RELAY<br>Lucar terminals.<br>TR2s, TR3s and TR3As up to TS60000 will need the ring terminals on the wiring replaced with Lucar 1/4" wide spade types (part no. RTC220A) in order to use this relay. | 1 142169A  |
| 31  | SCREW, relay attachment   | 2 PX505    |
| 32  | WASHER, plain   | 2 WP5      |
| 33  | WASHER, locking   | 2 WL105001 |
| 34  | NUT   | 2 HN2005   |

FIBREGLASS GEARBOX COVER  
- 713569FG

### A Type Overdrive Conversion Kit

#### 4 SYNCHROMESH GEARBOX

##### TR3B TCF series, TR4, TR4A, TR5, TR250

If by chance there are 4 synchro TR3B owners out there wishing to fit overdrive to their cars, this kit will suffice so long as the TR3A style switch, body harness and speedometer cable are substituted. Please contact us for details.

|   |   |                            |
|---|---|----------------------------|
| 35  | OVERDRIVE CONVERSION KIT;<br>RH steering<br>LH steering   | 1 RR1521RHD<br>1 RR1521LHD |
| <b>This kit includes the following parts (items 36-70):</b>   |   |                            |
| 36  | GEARBOX & OVERDRIVE UNIT ASS'Y,<br>reconditioned exchange | 1 RR1164R                  |
| <i>See text for exchange requirements.<br/>Supplied less clutch operating ancillaries, gear lever and retainer (swap over from old gearbox).<br/>Note: depending on availability, the type of overdrive annulus fitted may differ from the original necessitating recalibration of the speedometer.</i> |   |                            |
| 37  | GEAR & SPINDLE ASSEMBLY                                   | 1 147965                   |
| 38  | 'O' RING, housing to extension                            | 1 RTC1949                  |
| 39  | BEARING HOUSING, speedo gear                              | 1 146542                   |
| 40  | OIL SEAL, spindle to bearing housing                      | 1 NKC105A                  |
| 41  | SCREW, special,<br>locating bearing housing               | 1 506071                   |
| 42  | WASHER, copper, sealing screw                             | 1 500469                   |
| 43  | ANGLE DRIVE<br>Not required on TR3B TCF series, TR4.      | 1 120694                   |
| 44  | WASHER, sealing<br>Not required on TR3B TCF series, TR4.  | 1 538532                   |
| 45  | SPEEDOMETER CABLE, 69"                                    | 1 GSD169                   |
| 46  | FLANGE, mainshaft, square                                 | 1 58948                    |
| 47  | FLANGE, mainshaft, round<br>Alternative.                  | 1 518109                   |
| 48  | WASHER, plain   | 1 WP24                     |
| 49  | NUT, slotted  | 1 57868                    |
| 50  | NUT, nyloc<br>Alternative to slotted nut.                 | 1 157642                   |
| 51  | SPLIT PIN<br>Use with slotted nut.                        | 1 PC12                     |

### Overdrive Electrics

#### 4 SYNCHROMESH GEARBOX

##### TR3B TCF series, TR4, TR4A, TR5, TR250

|    |   |  |
|----|---|--|
| 52 | SOLENOID ASS'Y, overdrive operating   | 1 109521   |
| -  | SOLENOID PLUNGER ONLY   | 1 109521PL   |
| 53 | GASKET, solenoid to bracket   | 1 7H8196   |
| 54 | SCREW, solenoid to bracket  | 2 HU504  |
| 55 | WASHER, locking   | 2 WL105001   |
| 56 | LOOM, overdrive, gearbox  | 1 131339   |
| 57 | CONNECTOR, loom, single line  | 4 104618   |
| 58 | LOOM, overdrive, body   | 1 148696   |
| 59 | GROMMET, body loom  | 1 600396   |
| 60 | 'P' CLIP, gearbox loom to top cover   | 1 AEU1581A   |
| 61 | SWITCH, isolator, overdrive operation   | 2 BAU1074A   |
| 62 | WASHER, switch sealing/adjusting  | A/R 502146   |
| 63 | SWITCH, overdrive;<br>RH steering, chrome, TR4<br>LH steering, chrome, TR4<br>RH steering, chrome, TR4A<br>LH steering, chrome, TR4A<br>RH steering, black, TR5<br>LH steering, black, TR5, TR250 | 1 132424<br>1 132423<br>1 139793<br>1 139794<br>1 147280<br>1 147281 |
| 64 | WASHER, locking   | 1 WN715  |
| 65 | ESCUTCHEON, overdrive switch  | 1 611974   |
| 66 | RELAY   | 1 142169A  |
| 67 | SCREW, relay attachment   | 2 PX505  |
| 68 | WASHER, plain   | 2 WP5  |
| 69 | WASHER, locking   | 2 WL105001   |
| 70 | NUT   | 2 HN2005   |

### OVERDRIVE CONVERSIONS

**NOTE: AVAILABILITY.** Whilst our conversion kits list everything that you should need to convert your car to overdrive spec, in reality we often struggle to supply a complete kit due to old core gearbox shortages. Therefore, use this section to work out what is involved, and ensure you have all the parts required (sometimes a serviceable secondhand gearbox is a good starting point) before you commit to the project.

An overdrive conversion is among the most useful modifications that can be carried out on your TR and it is relatively straightforward to do. Overdrive provides useful additional gear ratios, for use under all driving conditions. Creeping about in town the use of 2nd overdrive and 2nd gear saves on the continual 2nd to 3rd to 2nd gear changes. It nicely bridges that 2nd to 3rd speed ratio gap.

The 3rd gear gives that little extra help for high speed overtaking when an upward gear change could best be ignored. The 4th gear overdrive provides effortless high-speed cruising improving long distance touring fuel economy.

The A type overdrive unit operating in 2nd, 3rd, and 4th gears was fitted as an option to later TR2s and all subsequent TRs up to 1972 model TR6s. It provides a 22% reduction to the engine speed for a given road speed when engaged. Overdrive-fitted early TR2s used an A type unit which operated in 4th gear only - it may be replaced by a later, more flexible unit if originality is not important. 1973-onwards TR6s, incidentally, used the J type overdrive which operated on 3rd and 4th gears only. The J type provides a 25% reduction to the engine speed for a given road speed when engaged. All of the subject TRs in this catalogue were designed to accept the A type overdrive; it is possible however to fit a J type overdrive and gearbox if desired to a TR4A, TR5 or TR250 using a conversion bracket kit for the chassis mounting (for details, see the end of this page).

To simply 'Bolt-On' an overdrive to your non-overdrive box is not possible since the mainshaft (output shaft) at the rear of the gearbox, is different. Whilst it is possible to adapt your existing gearbox for overdrive fitment, this does mean that a strip down is required to change the mainshaft. This, in effect, results in overhauling the gearbox (at least replacing bearings, synchro's etc. - see Gearbox Reconditioning Kits) prior to fitting the overdrive. This also assumes that your existing non-overdrive gearbox is to original specification (i.e. it has not been changed or rebuilt to a difficult specification by a previous owner) and that the overdrive mainshaft purchased is compatible with your unit. In real terms it is easier (and usually more economical) to buy a complete reconditioned gearbox and overdrive assembly which when purchased with a conversion kit saves all the trouble.

Our conversion kits not only include the gearbox/overdrive unit assembly, but also wiring, column switch, solenoid, drive flange, speedo pinion, angle drive (where appropriate) and speedo cable. Just about everything you will need! You should also consider replacing as a matter of course (purchasing separately), the clutch assembly and engine/gearbox rubber mountings whilst carrying out the conversion (refer to relevant sections). The propshaft is the same for all applications and may be re-used if serviceable. Please note that our conversion kits are based on receiving and old gearbox in exchange - either a TR non-overdrive unit or a saloon (2500), Sprint or Stag type gearbox/overdrive assembly.

### Overdrive Gearbox Cover

#### TR2, TR3, TR3A, TR3B

|    |   |                      |
|----|---|----------------------|
| 71 | GEARBOX COVER, steel;<br>TR2, TR3, TR3A to TS60000<br>TR3A from TS60001, TR3B | 1 900392<br>1 901550 |
| 72 | SCREW   | 16 GHF117            |
| 73 | WASHER, plain   | 16 GHF300            |

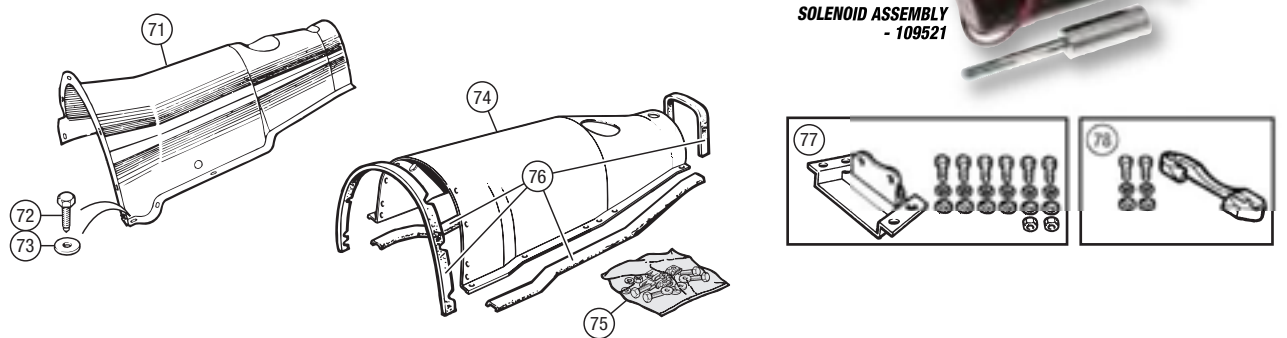
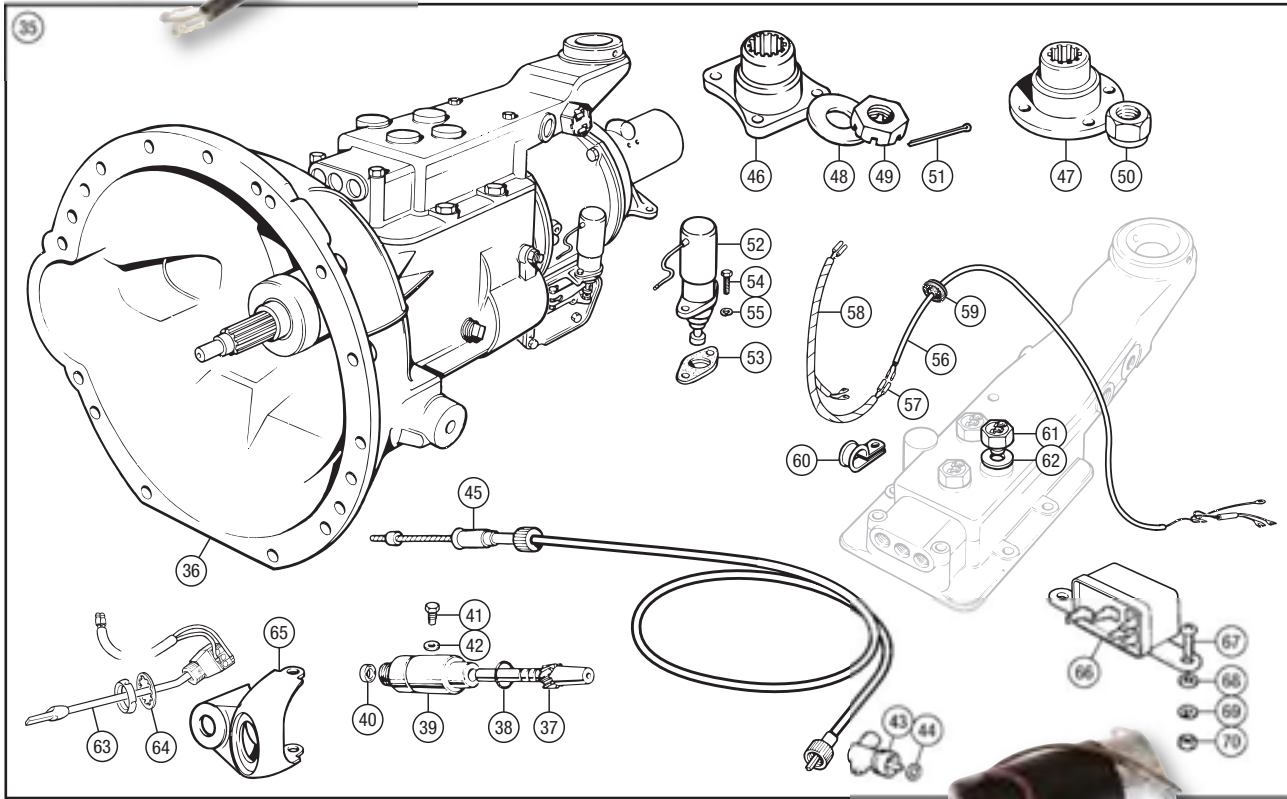
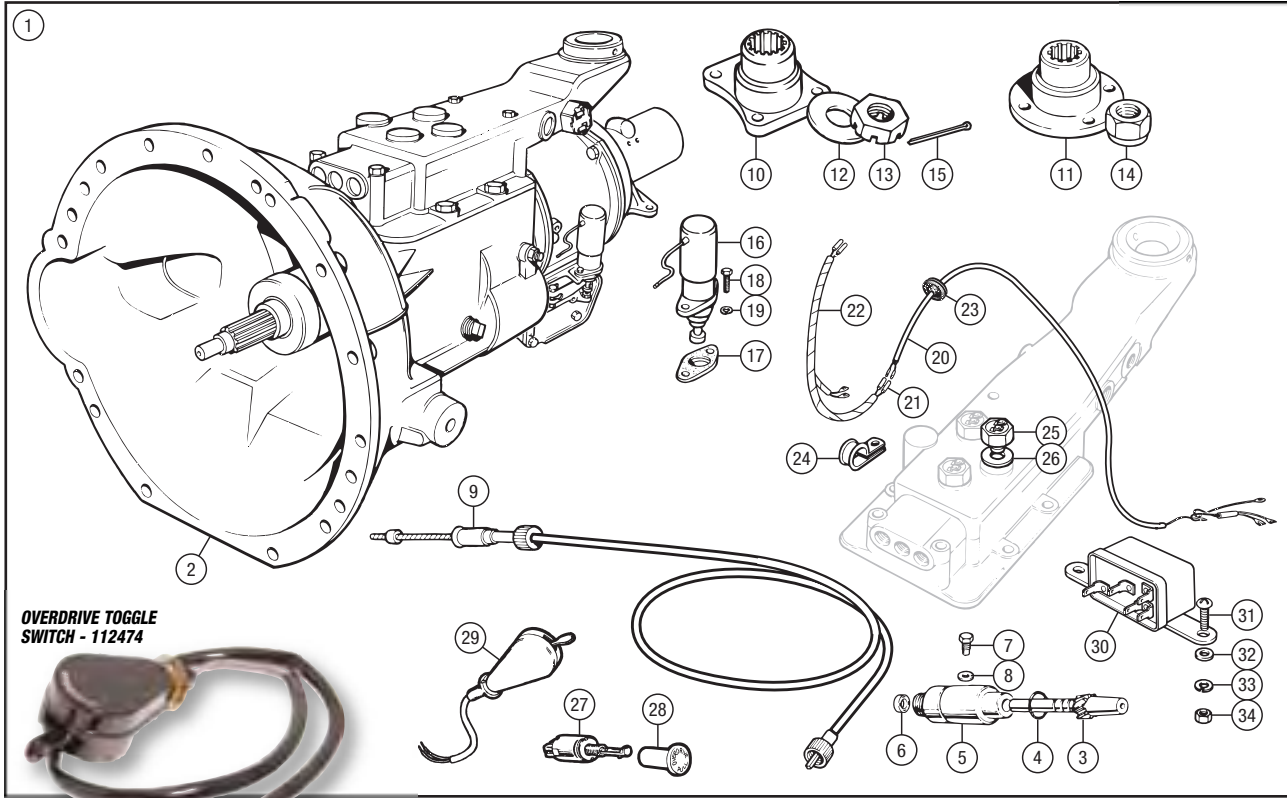
#### TR4, TR4A, TR5, TR250

|    |  |                          |
|----|--|--------------------------|
| 74 | GEARBOX COVER, replacement;<br>fibreglass<br>plastic | 1 713569FG<br>1 713569PL |
| 75 | FITTING KIT, gearbox cover                           | 1 713569FK               |
| 76 | SEAL, gearbox cover                                  | 1 713569SK               |

### Overdrive Conversion Bracket Kits

|    |   |           |
|----|---|-----------|
| 77 | BRACKET & FITTING KIT<br>Allows J type overdrive to fit A type chassis (TR4A, TR5, TR250 models) without modification. Comes complete with mounting.  | 1 211361X |
| 78 | BRACKET & FITTING KIT,<br>Saloon A type adaptor<br>Allows a saloon (2000/2.5) A type overdrive casing to fit the TR gearbox mounting 104086. Minor rear casing alterations are required. Includes chassis bracket, solenoid bracket, gasket & accumulator spring. | 1 RR1314  |







# TR2-3

# LOCKHEED (SOLID) REAR AXLE TR2, TR3 to TS13045

# REAR AXLE - SOLID - LOCKHEED - TR2-3



RECONDITIONED LOCKHEED AXLE

## Reconditioned Exchange Axles - Lockheed Type

### SQUARE END AXLE TUBES

### LESS BRAKES AND AXLE SHAFTS

|   |                       |   |         |
|---|-----------------------|---|---------|
| 1 | AXLE ASS'Y, exchange; |   |         |
|   | 3.7:1 ratio           | 1 | 502153R |
|   | 4.1:1 ratio           | 1 | 505017R |

## Axle Components - Lockheed Type

|    |  |     |         |
|----|--|-----|---------|
| 2  | AXLE CASING ASSEMBLY                           | 1   | 105515  |
|    | <i>Includes items 3-10.</i>                    |     |         |
| 3  | BOLT, cap to casing                            | 4   | 100878  |
| 4  | WASHER, locking                                | 4   | GHF333  |
| 5  | BREATHER, axle                                 | 1   | 56894   |
| 6  | WASHER, fibre, breather to axle                | 1   | WF509   |
| 7  | PLUG, drain                                    | 1   | 22G2115 |
| 8  | BRACKET AND BOSS ASS'Y, hand brake compensator | 1   | 113193  |
| 9  | GREASE NIPPLE, compensator                     | 1   | 144825  |
| 10 | GREASE NIPPLE, rear hub bearing                | 2   | 56934   |
| 11 | BEARING, diff. carrier to case                 | 2   | 110515  |
| 12 | SHIM, carrier bearing;                         |     |         |
|    | 0.003"   | A/R | 100894  |
|    | 0.005"   | A/R | 100895  |
|    | 0.010"   | A/R | 100896  |
| 13 | CARRIER, diff. and crown wheel                 | 1   | 301607  |
|    | <i>Uses 3/8" diameter bolts.</i>               |     |         |
| 14 | SUN GEAR, side differential                    | 2   | 102800  |
| 15 | THRUST WASHER                                  | 2   | 102801  |
|    | <i>Fit in pairs.</i>                           |     |         |
| 16 | PLANET GEAR, pinion                            | 2   | 134074  |
| 17 | THRUST WASHER, (Fit in pairs);                 |     |         |
|    | 0.0465"-0.0495"                                | 2   | 56793   |
|    | 0.051"-0.053"                                  | 2   | 139951  |
|    | 0.055"-0.057"                                  | 2   | 139952  |
|    | 0.059"-0.061"                                  | 2   | 139953  |
|    | 0.063"-0.065"                                  | 2   | 139954  |
|    | 0.065"-0.067"                                  | 2   | 160375  |
|    | 0.067"-0.069"                                  | 2   | 139955  |
|    | 0.071"-0.073"                                  | 2   | 139956  |
| 18 | CROSS SHAFT, planet gears                      | 1   | 100844  |
| 19 | PIN, cross shaft to carrier;                   |     |         |
|    | TR2 to TS6259                                  | 1   | 105436  |
|    | TR2 from TS6260, TR3 to TS13045                | 1   | 111215  |



CROWN WHEEL & PINION - 502127

Crown wheels are available to the later Girling axle specification only. To fit a new crown wheel to a Lockheed axle, some modification is necessary to the bolt holes on the carrier to which the crown wheel is to be attached. Alternatively, a later, Girling type carrier may be substituted.

|    |   |   |        |
|----|---|---|--------|
| 20 | CROWN WHEEL & PINION;                   |   |        |
|    | <i>Use with solid spacer and shims.</i> |   |        |
|    | 3.7:1                                   | 1 | 502127 |
|    | 3.45:1                                  | 1 | 516398 |
|    | 4.1:1                                   | 1 | 505014 |

*Collapsible spacer type crown wheel and pinion sets were used on later TR models and can be fitted in the earlier axle assemblies with the correct type bearing spacer:*

|  |                                     |   |        |
|--|-------------------------------------|---|--------|
|  | CROWN WHEEL & PINION;               |   |        |
|  | <i>Use with collapsible spacer.</i> |   |        |
|  | 3.7:1                               | 1 | UKC548 |
|  | 3.45:1                              | 1 | UKC547 |
|  | 4.1:1                               | 1 | UKC546 |

*Crown wheel and pinion sets of varying ratios were offered by the Competition Department at Triumph as follows:*

|  |  |   |        |
|--|--|---|--------|
|  | CROWN WHEEL & PINION ASS'Y, solid spacer type; |   |        |
|  | 4.3:1  | 1 | 502523 |
|  | 4.55:1   | 1 | 503924 |
|  | 4.875:1  | 1 | 515709 |

|    |  |     |         |
|----|--|-----|---------|
| 21 | BOLT, 3/8", crown wheel to carrier                               | 10  | 110737  |
|    | <i>Use 'Loctite' to secure bolt if tab washers are not used.</i> |     |         |
| 22 | WASHER, plain  | 10  | WP20    |
| 23 | TAB WASHER, original fitment                                     | 2   | 109736  |
| 24 | TAB WASHER, original fitment                                     | 2   | 109737  |
| 25 | WASHER, locking  | 10  | GHF333  |
|    | <i>Replaces plain washers and tab washers.</i>                   |     |         |
| 26 | BEARING, rear pinion (large)                                     | 1   | 100897A |
| 27 | SHIM, adjusting pinion height;                                   |     |         |
|    | 0.003"   | A/R | 100965  |
|    | 0.005"   | A/R | 100966  |
|    | 0.010"   | A/R | 100967  |
| 28 | SPACER, solid, original fitment                                  | 1   | 100846  |

|    |                             |     |        |
|----|-----------------------------|-----|--------|
| 29 | SHIM, front pinion bearing; |     |        |
|    | 0.003" (original)           | A/R | 100562 |
|    | 0.005" (original)           | A/R | 100563 |
|    | 0.010" (original)           | A/R | 100564 |
|    | 0.003" (alternative)        | A/R | 140793 |
|    | 0.005" (alternative)        | A/R | 140792 |
|    | 0.010" (alternative)        | A/R | 140791 |

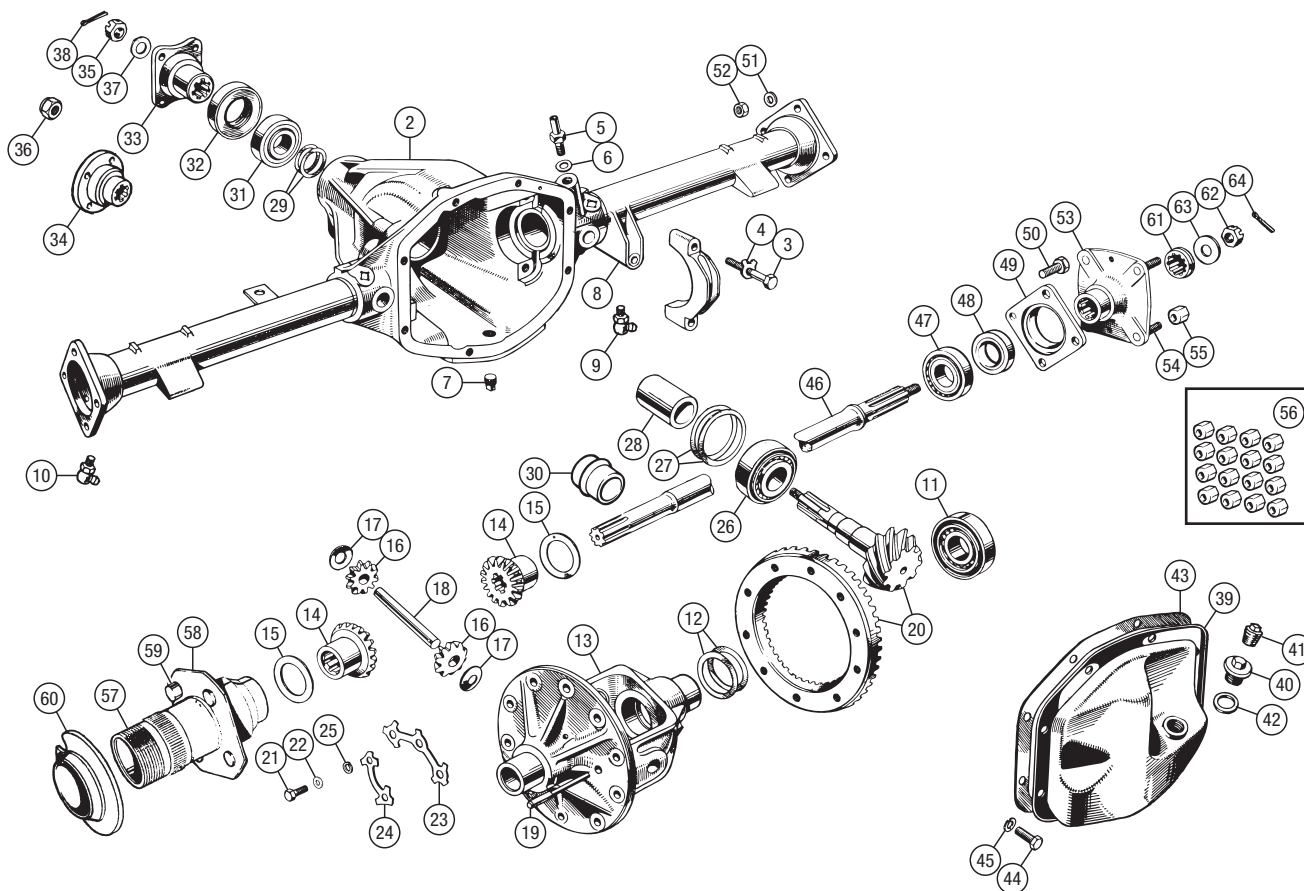
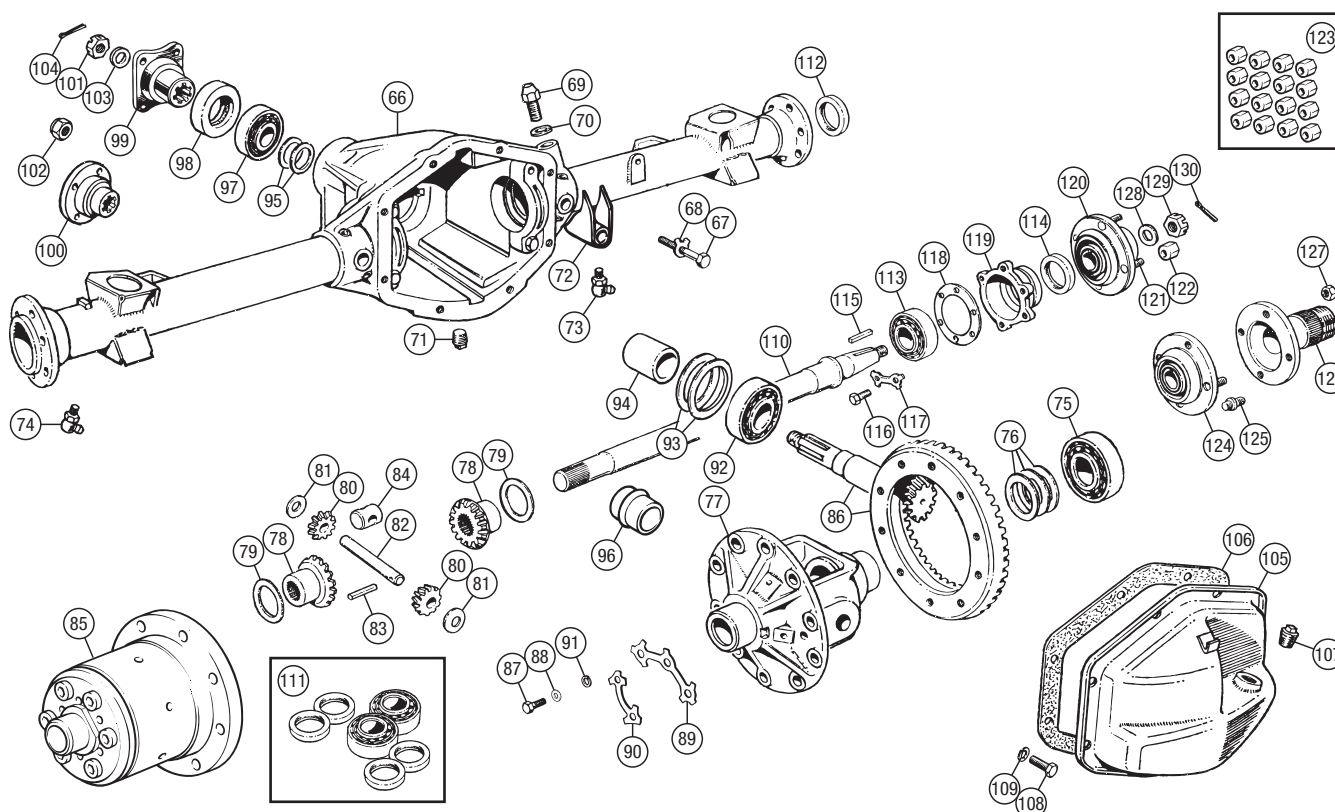
|    |                                |   |         |
|----|--------------------------------|---|---------|
| 30 | SPACER, collapsible, if fitted | 1 | 156903  |
| 31 | BEARING, front pinion (small)  | 1 | 100422  |
| 32 | OIL SEAL, pinion               | 1 | 100898  |
| 33 | DRIVE FLANGE, square           | 1 | 107947  |
|    | <i>Original type.</i>          |   |         |
| 34 | DRIVE FLANGE, round            | 1 | 138105  |
|    | <i>Alternative.</i>            |   |         |
| 35 | NUT, slotted                   | 1 | 100892  |
|    | <i>Original type.</i>          |   |         |
| 36 | NUT, nyloc                     | 1 | 510618A |
| 37 | WASHER, pinion flange          | 1 | 142333  |
| 38 | SPLIT PIN                      | 1 | PC45    |
|    | <i>Use with slotted nut.</i>   |   |         |
| 39 | REAR COVER ASSEMBLY;           |   |         |
|    | original Lockheed axle type    | 1 | 201918  |
|    | replacement Girling axle type  | 1 | 203660  |

*The later Girling cover will replace the Lockheed cover if a 114774 filler plug is fitted as well.*

|    |   |   |          |
|----|---|---|----------|
| 40 | FILLER PLUG, flanged  | 1 | 62058    |
|    | <i>For original Lockheed axle rear cover.</i>                                   |   |          |
| 41 | FILLER PLUG, tapered  | 1 | 114774   |
|    | <i>For replacement Girling axle rear cover.</i>                                 |   |          |
| 42 | WASHER, fibre   | 1 | 56912    |
|    | <i>Use with 62058 flanged plug only.</i>  |   |          |
| 43 | GASKET, rear cover to axle  | 1 | 101359   |
| 44 | SCREW, attaching cover  | 8 | SH605051 |
| 45 | WASHER, locking   | 8 | GHF332   |
| 46 | AXLE SHAFT  | 2 | 201933   |
| 47 | BEARING, rear hub   | 2 | 513897   |
| 48 | OIL SEAL, rear hub;   |   |          |
|    | TR2 to TS5555   | 2 | 103811   |
|    | TR2 from TS5556, TR3 to TS13045   | 2 | 109543   |
|    | <i>Check seal area diameter in hub to ensure getting the correct size seal.</i> |   |          |
| 49 | HOUSING, for bearing  | 2 | 200194   |
| 50 | BOLT, bearing housing and   |   |          |
|    | brake backplate attaching   | 8 | 107960   |
| 51 | WASHER, plain   | 8 | GHF302   |
| 52 | NUT, nyloc  | 8 | GHF223   |
| 53 | HUB, steel wheel  | 2 | 109553   |
|    | <i>Steel wheels; includes item 54.</i>  |   |          |
| 54 | STUD, fitted to rear hub  | 8 | 100869   |
|    | <i>Steel wheels.</i>  |   |          |
| 55 | WHEEL NUT   | 8 | 109586   |
|    | <i>Steel wheels.</i>  |   |          |
| 56 | WHEEL NUT SET (car set of 16)   | 1 | 109586K  |
|    | <i>Steel wheels.</i>  |   |          |
| 57 | HUB ASSEMBLY, wire wheels;  |   |          |
|    | <i>Wire wheels; includes items 58-60.</i>                                       |   |          |
|    | LH  | 1 | 109550   |
|    | RH  | 1 | 109551   |
| 58 | PEG, drum to hub, short,  |   |          |
|    | supporting taper collar   | 6 | 107950   |
|    | <i>Wire wheels.</i>   |   |          |
| 59 | PEG, drum to hub, long,   |   |          |
|    | locating notch in taper collar  | 2 | 109457   |
|    | <i>Wire wheels.</i>   |   |          |
| 60 | COLLAR, taper, notched,   |   |          |
|    | wire wheel seating  | 2 | 107942   |
|    | <i>Wire wheels.</i>   |   |          |
| 61 | COLLAR, tapered, internally splined,  |   |          |
|    | hub to half shaft   | 2 | 108608   |
| 62 | NUT, slotted, hub to axle shaft   | 2 | 112635   |
| 63 | WASHER, plain   | 2 | WC600121 |
| 64 | SPLIT PIN   | 2 | PC45     |





**1 LOCKHEED AXLE (LESS AXLE SHAFTS & HUBS)****65 GIRLING AXLE (LESS AXLE SHAFTS & HUBS)**



# TR3-4A

# GIRLING (SOLID) REAR AXLE TR3 from TS13046, TR3A, TR3B, TR4, TR4A

# REAR AXLE - SOLID - GIRLING - TR3-4A



## Reconditioned Exchange Axles - Girling Type

### ROUND END AXLE TUBES

### LESS BRAKES AND AXLE SHAFTS

|    |                              |   |         |
|----|------------------------------|---|---------|
| 65 | AXLE ASS'Y, exchange;        |   |         |
|    | 3.7:1 ratio                  |   |         |
|    | TR3 from TS13046, TR3A, TR3B | 1 | 503833R |
|    | TR4                          | 1 | 510922R |
|    | TR4A rigid axle              | 1 | 514754R |
|    | 4.1:1 ratio                  |   |         |
|    | TR3 from TS13046, TR3A, TR3B | 1 | 505018R |
|    | TR4                          | 1 | 510923R |
|    | TR4A rigid axle              | 1 | 514755R |

### WITH LIMITED SLIP DIFFERENTIAL AND NEW CROWN WHEEL & PINION;

|  |                              |   |             |
|--|------------------------------|---|-------------|
|  | AXLE ASS'Y, exchange;        |   |             |
|  | 3.7:1 ratio                  |   |             |
|  | TR3 from TS13046, TR3A, TR3B | 1 | 503833RNCWP |
|  | TR4                          | 1 | 510922RNCWP |
|  | TR4A rigid axle              | 1 | 514754RNCWP |
|  | 4.1:1 ratio                  |   |             |
|  | TR3 from TS13046, TR3A, TR3B | 1 | 505018RNCWP |
|  | TR4                          | 1 | 510923RNCWP |
|  | TR4A rigid axle              | 1 | 514755RNCWP |

## Axle Components - Girling

|    |   |     |        |
|----|---|-----|--------|
| 66 | AXLE CASING ASSEMBLY;                             |     |        |
|    | TR3 from TS13046, TR3A, TR3B                      | 1   | 503832 |
|    | includes items 67-74.                             |     |        |
|    | TR4   | 1   | 304854 |
|    | includes items 67-74.                             |     |        |
|    | TR4A rigid axle                                   | 1   | 307147 |
|    | includes items 67-71, 74.                         |     |        |
| 67 | BOLT, cap to casing                               | 4   | 100878 |
| 68 | WASHER, locking                                   | 4   | GHF333 |
| 69 | BREATHER, in axle                                 | 1   | 56894  |
| 70 | WASHER, fibre, breather to axle                   | 1   | WF509  |
| 71 | PLUG, drain                                       | 1   | 114774 |
| 72 | BRACKET AND BOSS ASSEMBLY, hand brake compensator | 1   | 113193 |
|    | TR3 from TS13046, TR3A, TR3B, TR4.                |     |        |
| 73 | GREASE NIPPLE, compensator                        | 1   | 144825 |
|    | TR3 from TS13046, TR3A, TR3B, TR4.                |     |        |
| 74 | GREASE NIPPLE, rear hub bearing                   | 2   | 56934  |
| 75 | BEARING, diff. carrier to case                    | 2   | 110515 |
| 76 | SHIM, carrier bearing;                            |     |        |
|    | 0.003"  | A/R | 100894 |
|    | 0.005"  | A/R | 100895 |
|    | 0.010"  | A/R | 100896 |
| 77 | CARRIER, diff. and crown wheel                    | 1   | 302155 |
| 78 | SUN GEAR, side differential;                      |     |        |
|    | fit in pairs with 113188 planet gear              | 2   | 113187 |
|    | fit in pairs with 153385 planet gear              | 2   | 153384 |
| 79 | THRUST WASHER                                     | 2   | 102801 |
| 80 | PLANET GEAR, pinion;                              |     |        |
|    | fit in pairs with 113187 sun gear                 | 2   | 113188 |
|    | fit in pairs with 153384 sun gear                 | 2   | 153385 |
| 81 | THRUST WASHER, (Fit in pairs);                    |     |        |
|    | 0.0465" - 0.0495"                                 | A/R | 56793  |
|    | 0.051" - 0.053"                                   | A/R | 139951 |
|    | 0.055" - 0.057"                                   | A/R | 139952 |
|    | 0.059" - 0.061"                                   | A/R | 139953 |
|    | 0.063" - 0.065"                                   | A/R | 139954 |
|    | 0.065" - 0.067"                                   | A/R | 160375 |
|    | 0.067" - 0.069"                                   | A/R | 139955 |
|    | 0.071" - 0.073"                                   | A/R | 139956 |

RECONDITIONED GIRLING AXLE

- |    |                                       |   |        |
|----|---------------------------------------|---|--------|
| 82 | CROSS SHAFT, planet gears             | 1 | 100844 |
| 83 | PIN, cross shaft to carrier           | 1 | 111215 |
| 84 | BUTTON, thrust, half shaft inner ends | 1 | 109566 |
| 85 | LIMITED SLIP DIFFERENTIAL ASS'Y;      |   |        |
- This design of torque sensing differential makes it a worthwhile addition to any competition or fast road car. Allowing maximum drive to both rear wheels giving more grip under hard acceleration. These differentials (crown wheel carriers) are for fitting inside your own axle. Alternatively, purchase one of our exchange rear axles - fully reconditioned, complete with brand new limited slip diff and crownwheel & pinion. See 'Rear Axle Unit Assy'.*



LIMITED SLIP DIFF - RKC2026Q

- |    |                                  |   |        |
|----|----------------------------------|---|--------|
| 86 | CROWN WHEEL & PINION;            |   |        |
|    | Use with solid spacer and shims. |   |        |
|    | 3.7:1                            | 1 | 502127 |
|    | 3.45:1                           | 1 | 516398 |
|    | 4.1:1                            | 1 | 505014 |

Collapsible spacer type crown wheel and pinion sets were used on later TR models and can be fitted in the earlier axle assemblies with the correct type bearing spacer.

- |  |                              |   |        |
|--|------------------------------|---|--------|
|  | CROWN WHEEL & PINION;        |   |        |
|  | Use with collapsible spacer. |   |        |
|  | 3.7:1                        | 1 | UKC548 |
|  | 3.45:1                       | 1 | UKC547 |
|  | 4.1:1                        | 1 | UKC546 |

Crown wheel and pinion sets of varying ratios were offered by the Competition Department at Triumph as follows:

- |  |  |   |        |
|--|--|---|--------|
|  | CROWN WHEEL & PINION ASS'Y, solid spacer type; |   |        |
|  | 4.3:1  | 1 | 502523 |
|  | 4.55:1   | 1 | 503924 |
|  | 4.875:1  | 1 | 515709 |

- |    |   |     |         |
|----|---|-----|---------|
| 87 | BOLT, 3/8", crown wheel to carrier                        | 10  | 110737  |
|    | Use 'Loctite' to secure bolt if tab washers are not used. |     |         |
| 88 | WASHER, plain   | 10  | WP20    |
| 89 | TAB WASHER (original fitment)                             | 2   | 109736  |
| 90 | TAB WASHER (original fitment)                             | 2   | 109737  |
| 91 | WASHER, locking   | 10  | GHF333  |
|    | Replaces plain washers and tab washers.                   |     |         |
| 92 | BEARING, rear pinion (large)                              | 1   | 100897A |
| 93 | SHIM, adjusting pinion height;                            |     |         |
|    | 0.003"  | A/R | 100965  |
|    | 0.005"  | A/R | 100966  |
|    | 0.010"  | A/R | 100967  |
| 94 | SPACER, solid, original fitment                           | 1   | 100846  |
| 95 | SHIM, front pinion bearing (solid spacer);                |     |         |
|    | 0.003"  | A/R | 100562  |
|    | 0.005"  | A/R | 100563  |
|    | 0.010"  | A/R | 100564  |
|    | 0.003" (alternative)                                      | A/R | 140793  |
|    | 0.005" (alternative)                                      | A/R | 140792  |
|    | 0.010" (alternative)                                      | A/R | 140791  |

- |     |   |   |          |
|-----|---|---|----------|
| 96  | SPACER, collapsible, if fitted            | 1 | 156903   |
| 97  | BEARING, front pinion (small)             | 1 | 100422   |
| 98  | OIL SEAL, pinion;                         |   |          |
|     | TR3 from TS13046, TR3A, TR3B, TR4         | 1 | 100898   |
|     | TR4A rigid axle                           | 1 | 140337   |
| 99  | DRIVE FLANGE, square                      | 1 | 107947   |
|     | Original type.                            |   |          |
| 100 | DRIVE FLANGE, round                       | 1 | 138105   |
|     | Alternative.                              |   |          |
| 101 | NUT, slotted                              | 1 | 112635   |
|     | Original type.                            |   |          |
| 102 | NUT, nyloc                                | 1 | 510618A  |
|     | Replacement.                              |   |          |
| 103 | WASHER, pinion flange                     | 1 | 142333   |
| 104 | SPLIT PIN                                 | 1 | PC45     |
|     | Use with slotted nut.                     |   |          |
| 105 | REAR COVER ASSEMBLY                       | 1 | 203660   |
| 106 | GASKET, rear cover                        | 1 | 101359   |
| 107 | FILLER PLUG, tapered                      | 1 | 114774   |
| 108 | SCREW, attaching cover                    | 8 | SH605051 |
| 109 | WASHER, locking                           | 8 | GHF332   |
| 110 | AXLE SHAFT;                               |   |          |
|     | TR3 from TS13046, TR3A, TR3B              | 2 | 203200   |
|     | with tapered keyway and outer end flange. |   |          |
|     | TR4, TR4A rigid axle; forged              | 2 | 207613   |
|     | TR4A rigid axle; with collar              | 2 | 208390   |



HUB BEARING KIT - GHK1144

- |     |                                     |     |          |
|-----|-------------------------------------|-----|----------|
| 111 | HUB BEARING KIT                     | 2   | GHK1144  |
|     | Includes items 112-114.             |     |          |
| 112 | OIL SEAL, axle tube                 | 2   | GHS185   |
| 113 | BEARING, axle shaft                 | 2   | GHB166   |
| 114 | OIL SEAL, hub                       | 2   | GHS162   |
| 115 | KEY                                 | 2   | 134591   |
| 116 | BOLT, casing to bearing housing     | 12  | 112653   |
| 117 | TAB WASHER                          | 6   | 36567    |
| 118 | SHIM, rear hub bearing;             |     |          |
|     | 0.006"                              | A/R | 36583    |
|     | 0.008"                              | A/R | 38264    |
|     | 1/64"                               | A/R | 36582    |
|     | 1/32"                               | A/R | 36581    |
| 119 | HOUSING, bearing                    | 2   | 58773    |
| 120 | HUB ASSEMBLY                        | 8   | 113175   |
|     | Steel wheels; includes item 121.    |     |          |
| 121 | STUD, long (Steel wheels)           | 8   | 100869   |
| 122 | WHEEL NUT (Steel wheels)            | 8   | 109586   |
| 123 | WHEEL NUT SET (car set of 16)       | 1   | 109586K  |
|     | Steel wheels.                       |     |          |
| 124 | HUB ASSEMBLY                        | 2   | 113175   |
|     | Wire wheels; includes item 125.     |     |          |
| 125 | STUD, short (Wire wheels)           | 8   | 110365   |
| 126 | SPLINED EXTENSION;                  |     |          |
|     | RH (Wire wheels)                    | 1   | 217602   |
|     | LH (Wire wheels)                    | 1   | 217603   |
| 127 | NUT, extension to hub (Wire wheels) | 8   | RSRN716  |
| 128 | WASHER, axle nut                    | 2   | WC600121 |
| 129 | NUT, hub to axle shaft              | 2   | 58784    |
| 130 | SPLIT PIN                           | 2   | PC15     |



This exploded view diagram illustrates the components of a rear axle assembly. The central part is the axle housing (2), which contains the axle tube (3) and the axle shaft (4). The axle shaft is supported by the axle nut (5) and the axle nut lock (6). The axle shaft is connected to the axle hub (7) and the axle hub nut (8). The axle hub is connected to the axle hub nut (9) and the axle hub lock (10). The axle hub is connected to the axle hub nut (11) and the axle hub lock (12). The axle hub is connected to the axle hub nut (13) and the axle hub lock (14). The axle hub is connected to the axle hub nut (15) and the axle hub lock (16). The axle hub is connected to the axle hub nut (17) and the axle hub lock (18). The axle hub is connected to the axle hub nut (19) and the axle hub lock (20). The axle hub is connected to the axle hub nut (21) and the axle hub lock (22). The axle hub is connected to the axle hub nut (23) and the axle hub lock (24). The axle hub is connected to the axle hub nut (25) and the axle hub lock (26). The axle hub is connected to the axle hub nut (27) and the axle hub lock (28). The axle hub is connected to the axle hub nut (29) and the axle hub lock (30). The axle hub is connected to the axle hub nut (31) and the axle hub lock (32). The axle hub is connected to the axle hub nut (33) and the axle hub lock (34). The axle hub is connected to the axle hub nut (35) and the axle hub lock (36). The axle hub is connected to the axle hub nut (37) and the axle hub lock (38). The axle hub is connected to the axle hub nut (39) and the axle hub lock (40). The axle hub is connected to the axle hub nut (41) and the axle hub lock (42). The axle hub is connected to the axle hub nut (43) and the axle hub lock (44). The axle hub is connected to the axle hub nut (45) and the axle hub lock (46). The axle hub is connected to the axle hub nut (47) and the axle hub lock (48). The axle hub is connected to the axle hub nut (49) and the axle hub lock (50). The axle hub is connected to the axle hub nut (51) and the axle hub lock (52). The axle hub is connected to the axle hub nut (53) and the axle hub lock (54). The axle hub is connected to the axle hub nut (55) and the axle hub lock (56). The axle hub is connected to the axle hub nut (57) and the axle hub lock (58). The axle hub is connected to the axle hub nut (59) and the axle hub lock (60). The axle hub is connected to the axle hub nut (61) and the axle hub lock (62). The axle hub is connected to the axle hub nut (63) and the axle hub lock (64).

This exploded view diagram illustrates the assembly of a rear axle. The central component is the axle housing (66), which is shown in its assembled state with the axle tube (67) and axle shaft (68) inserted. The axle tube is secured with a nut (69) and a washer (70). The axle shaft is secured with a nut (71) and a washer (72). The axle tube is also secured with a nut (73) and a washer (74). The axle shaft is secured with a nut (75) and a washer (76). The axle tube is also secured with a nut (77) and a washer (78). The axle shaft is secured with a nut (79) and a washer (80). The axle tube is also secured with a nut (81) and a washer (82). The axle shaft is secured with a nut (83) and a washer (84). The axle tube is also secured with a nut (85) and a washer (86). The axle shaft is secured with a nut (87) and a washer (88). The axle tube is also secured with a nut (89) and a washer (90). The axle shaft is secured with a nut (91) and a washer (92). The axle tube is also secured with a nut (93) and a washer (94). The axle shaft is secured with a nut (95) and a washer (96). The axle tube is also secured with a nut (97) and a washer (98). The axle shaft is secured with a nut (99) and a washer (100). The axle tube is also secured with a nut (101) and a washer (102). The axle shaft is secured with a nut (103) and a washer (104). The axle tube is also secured with a nut (105) and a washer (106). The axle shaft is secured with a nut (107) and a washer (108). The axle tube is also secured with a nut (109) and a washer (110). The axle shaft is secured with a nut (111) and a washer (112). The axle tube is also secured with a nut (113) and a washer (114). The axle shaft is secured with a nut (115) and a washer (116). The axle tube is also secured with a nut (117) and a washer (118). The axle shaft is secured with a nut (119) and a washer (120). The axle tube is also secured with a nut (121) and a washer (122). The axle shaft is secured with a nut (123) and a washer (124). The axle tube is also secured with a nut (125) and a washer (126). The axle shaft is secured with a nut (127) and a washer (128). The axle tube is also secured with a nut (129) and a washer (130).

Inset boxes show small components:

- Box 1 (top right): 12 small washers/nuts.
- Box 2 (bottom left): 4 large washers/nuts.
- Box 3 (bottom center): 4 small washers/nuts.



## TR4A-5-250

## INDEPENDENT REAR AXLE (IRS) TR4A, TR5, TR250

# REAR AXLE - INDEPENDENT - IRS - TR4A-5-250

The original part numbers and ratios of independent rear suspension axle units fitted to Triumph TRs is shown here in the chart. The simple way to check the ratio is by counting the crown wheel and pinion teeth. For example, if the crown wheel has 38 teeth and the pinion 11, the ratio of 3.45:1 is arrived at by dividing the quantity of teeth on the pinion into the quantity of teeth on the crown wheel.

Petrol injected Triumph TR sports cars were the only ones to have the 3.45:1 ratio axle as standard fitment. Carburetted TR250s and TR6s were fitted with the 3.7:1 ratio, along with TR4A (which also had an option for 4.1:1). On the road, the difference between the 3.45 and 3.7 ratio is barely noticeable (unless you are using 60 series low profile tyres on 15" rims) whilst a 4.1 on a 6 cylinder TR feels as though you have run out of gears!

As there were no ratio changes during the production periods of the TR4A, TR5/TR6 PI and the TR250/TR6 Carb. axles they are assumed to be interchangeable between model years. This is true if entire units are replaced. If the internals of a certain model year are used to repair another axle of a different model year, problems may be encountered with non-compatible parts. The major significant change was the replacement of the solid, shim adjusted pinion bearing spacer for a collapsible type, part way through TR6 production. The other items to change internally were the sun and planet gear sets. The early type had plain teeth, the later ones had a groove machined into their tooth edge to aid identification, and so should be fitted in sets of four when interchanged.

| ORIGINAL No. | RATIO  | APPLICATIONS:                                      |
|--------------|--------|--|
| (514608)     | 3.7:1  | TR4A standard fitment                              |
| (514609)     | 4.1:1  | TR4A optional fitment                              |
| (312061)     | 3.45:1 | TR5, TR6 PI to CP52867                             |
| (516629)     | 3.7:1  | TR250 to rear axle CTC6241                         |
| (312060)     | 3.7:1  | TR250 from rear axle CTC6242, TR6 Carb. to CC61570 |
| (313130)     | 3.45:1 | TR6 PI from CP52868                                |
| (313129)     | 3.7:1  | TR6 Carb. from CC61571                             |

## Rear Axle Unit Assembly

### RECONDITIONED EXCHANGE

We supply from stock, a range of fully reconditioned, ready to fit axle units on a strict exchange basis. These are available (depending upon your requirements and budget) with either a 3.45:1 or 3.7:1 ratio, with optional brand new crown wheel and pinion, and finally with a limited slip differential option (supplied only with a new crown wheel and pinion).

Old exchange units returned to us should be complete and assembled, drained of oil, and be externally clean with no irreparable damage.

Note that the front mounting plate and the rear aluminium housing (complete with 4 lugs) must be returned. Failure to comply with these requirements will result in retention of part or all of the exchange surcharge.

## Reconditioned Exchange Axles - IRS

Availability of the TR4A IRS and early TR250 axles is sometimes limited. It is possible to fit the later TR5/6 axle providing the mounting kit (RR1390) is also purchased. Alternatively, you can swap over your existing backplate (you will need gasket 134480) to the unit we supply and simply return the backplate with your old unit.

|   |                              |   |             |
|---|------------------------------|---|-------------|
| 1 | REAR AXLE ASS'Y;             |   |             |
|   | 3.7:1, TR4A IRS standard     | 1 | 514752R     |
|   | 4.1:1, TR4A IRS optional     | 1 | 514753R     |
| 2 | REAR AXLE ASS'Y, 3.7:1;      |   |             |
|   | TR250 to rear axle CTC6241   | 1 | 516629R3.7  |
|   | TR250 from rear axle CTC6242 | 1 | RR1112R3.7  |
| 3 | REAR AXLE ASS'Y, 3.45:1, TR5 | 1 | RR1112R3.45 |

### WITH NEW CROWN WHEEL & PINION

|   |                              |   |                |
|---|------------------------------|---|----------------|
| 1 | REAR AXLE ASS'Y;             |   |                |
|   | 3.7:1, TR4A IRS standard     | 1 | 514752RNCWP3-7 |
|   | 4.1:1, TR4A IRS optional     | 1 | 514753RNCWP4-1 |
| 2 | REAR AXLE ASS'Y, 3.7:1;      |   |                |
|   | TR250 to rear axle CTC6241   | 1 | 516629RN3.7    |
|   | TR250 from rear axle CTC6242 | 1 | RR1112RN3.7    |
| 3 | REAR AXLE ASS'Y, 3.45:1, TR5 | 1 | RR1112RN3.45   |

### WITH LIMITED SLIP DIFFERENTIAL AND NEW CROWN WHEEL & PINION

|   |                              |   |               |
|---|------------------------------|---|---------------|
| 1 | REAR AXLE ASS'Y;             |   |               |
|   | 3.7:1, TR4A IRS standard     | 1 | 514752RNL3.7  |
|   | 4.1:1, TR4A IRS optional     | 1 | 514753RNL4.1  |
| 2 | REAR AXLE ASS'Y, 3.7:1;      |   |               |
|   | TR250 to rear axle CTC6241   | 1 | 516629RNL3.7  |
|   | TR250 from rear axle CTC6242 | 1 | RR1112RNL3.7  |
| 3 | REAR AXLE ASS'Y, 3.45:1, TR5 | 1 | RR1112RNL3.45 |

## Axle Components - IRS

### REAR COVER;

#### TR4A, TR250 to Rear Axle CTC6241

|    |  |   |        |
|----|--|---|--------|
| 4  | COVER ASSEMBLY, rear                                   | 1 | 141360 |
| 5  | BRACKET, rear axle mounting TR4A IRS                   | 1 | 212047 |
| 6  | BRACKET, rear axle mounting TR250 to rear axle CTC6241 | 1 | 308223 |
| 7  | STUD   | 4 | 143712 |
| 8  | WASHER, plain  | 4 | WM184  |
| 9  | WASHER, plain  | 4 | WP48   |
| 10 | NUT, nyloc   | 4 | GHF223 |

### REAR COVER;

#### TR5, TR250 from Rear Axle CTC6242

|    |  |   |         |
|----|--|---|---------|
| 11 | COVER & AXLE MOUNTING, rear  | 1 | 149826  |
| 12 | PLUG, core, breather   | 1 | 104449  |
| 13 | SPLIT PIN, in breather plug  | 1 | PC34    |
| 14 | SCREW, rear cover to axle casing   | 8 | GHF103  |
| 15 | WASHER, locking  | 8 | GHF332  |
| 16 | GASKET, rear cover to axle casing  | 1 | 134480  |
| 17 | HOUSING ASSEMBLY, rear axle<br><i>Includes bearing caps and retaining bolts.</i> | 1 | 305815  |
| 18 | BOLT, bearing cap retaining  | 4 | 100878  |
| 19 | WASHER, locking  | 4 | GHF333  |
| 20 | DOWEL, rear cover locating   | 2 | 140419  |
| 21 | PLUG, oil filler and level;  |   |         |
|    | original   | 1 | 114774  |
|    | alternative  | 1 | 2262115 |

FRONT MOUNTING  
PLATE ASSEMBLY - 211793  
(REMANUFACTURED)

22 PLATE ASSEMBLY, axle mounting 1 211793  
This is one of the weakest parts of the TR. This pressed steel plate can be thin in certain areas, one of which coincides with a very high stress area, just inboard of the RH front mounting area. It can be welded and reinforced but should only be repaired by a truly competent welder. Only sound brackets will be accepted for exchange differentials, though it will be possible to repair a cracked bracket at extra cost.

|    |                                     |   |         |
|----|-------------------------------------|---|---------|
| 23 | WASHER, distance,                   |   |         |
|    | welded to plate ass'y               | 1 | 140007  |
| 24 | BOLT, mounting plate to axle casing | 4 | 132856  |
| 25 | WASHER, shakeproof                  | 4 | GHF324  |
| 26 | PLUG, oil drain;                    |   |         |
|    | original                            | 1 | 114774  |
|    | alternative                         | 1 | 2262115 |

The axle is not provided originally with a drain plug for the lubricating oil. Many axles have been modified by owners or restorers to incorporate an oil drain plug. From a maintenance point of view the provision of a drain plug is desirable. Having to remove the axle rear cover to drain and change the oil periodically is inconvenient bordering on painful.

TR5 RECONDITIONED  
REAR AXLE ASSEMBLY -  
RR1112R3.45

### 27 CROWN WHEEL & PINION ASS'Y;

Use with solid spacer and shims.

|        |   |        |
|--------|---|--------|
| 3.45:1 | 1 | 516398 |
| 3.7:1  | 1 | 502127 |
| 4.1:1  | 1 | 505014 |

Collapsible spacer type crown wheel and pinion sets were used on later TR models and can be fitted in the earlier axle assemblies with the correct type bearing spacer:

### CROWN WHEEL & PINION ASS'Y;

Use with collapsible spacer.

|        |   |        |
|--------|---|--------|
| 3.45:1 | 1 | UKC547 |
| 3.7:1  | 1 | UKC548 |

Crown wheel and pinion sets of varying ratios were offered by the Competition Department at Triumph as follows:

|  |   |        |
|--|---|--------|
| CROWN WHEEL & PINION ASS'Y, solid spacer type; |   |        |
| 4.3:1  | 1 | 502523 |
| 4.55:1   | 1 | 503924 |
| 4.875:1  | 1 | 515709 |

|                                    |   |        |
|------------------------------------|---|--------|
| 28 SPACER, solid, original fitment | 1 | 100846 |
|------------------------------------|---|--------|

|   |     |        |
|---|-----|--------|
| 29 SHIM, front pinion bearing (solid spacer); |     |        |
| 0.003"  | A/R | 100562 |
| 0.005"  | A/R | 100563 |
| 0.010"  | A/R | 100564 |
| 0.003" (alternative)                          | A/R | 140793 |
| 0.005" (alternative)                          | A/R | 140792 |
| 0.010" (alternative)                          | A/R | 140791 |

|                                   |   |        |
|-----------------------------------|---|--------|
| 30 SPACER, collapsible, if fitted | 1 | 156903 |
|-----------------------------------|---|--------|

|                                     |   |         |
|-------------------------------------|---|---------|
| 31 BEARING ASS'Y, pinion head, rear | 1 | 100897A |
|-------------------------------------|---|---------|

|                          |     |        |
|--------------------------|-----|--------|
| 32 SHIM, pinion bearing; |     |        |
| 0.003"                   | A/R | 100965 |
| 0.005"                   | A/R | 100966 |
| 0.010"                   | A/R | 100967 |

|                              |     |            |
|------------------------------|-----|------------|
| 33 WASHER, adjusting, (.040) | A/R | 516398SHIM |
|------------------------------|-----|------------|

The shims used to correctly position and pre-load the crown wheel and pinion bearings did not change from TR2 to TR6 (including Stag, Sprint and Innsbrook saloons). The IRS axles require a single spacer, in addition, between the pinion and the pinion head bearing. It is argued that this spacer could be replaced with an equivalent number of shims between the pinion and head bearing as both achieve the same net result. Rebuilding of many hundreds of differentials has only ever-revealed spacers 0.040 thick. No parts book listed this spacer though a Triumph service release seems to indicate a range of thickness' (0.030 to 0.051) was available, part numbers 140643 to 140657.

In the absence of full engineering drawings it can only be guessed that the internal machining of the differential casings between solid axle TRs and IRS versions is different. With the introduction of the 3.45 to 1 ratio in 1967 the pinion teeth would foul the casing in some circumstances due to the larger pinion diameter, but that doesn't explain the spacers presence from 1965 in the TR4A differential which used 3.7 and 4.1 to 1 ratios.

If the spacer is left in place and the contents of an IRS differential are fitted to a solid axle, the pinion face will usually foul the hub (or crown wheel carrier) as it rotates.

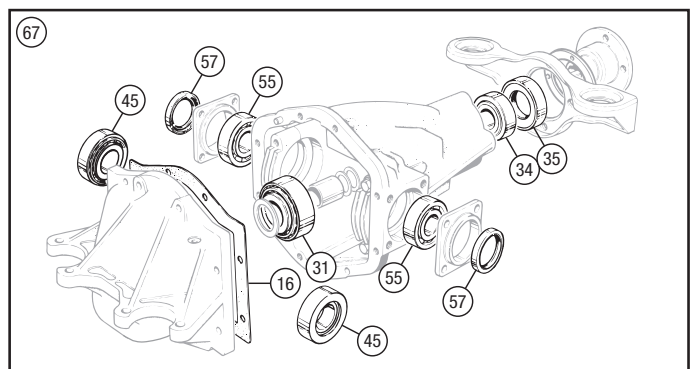
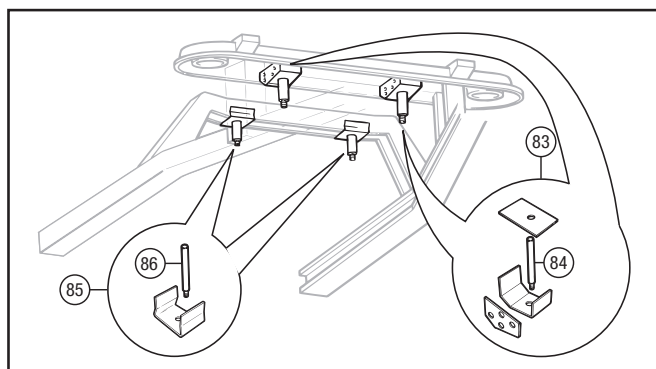
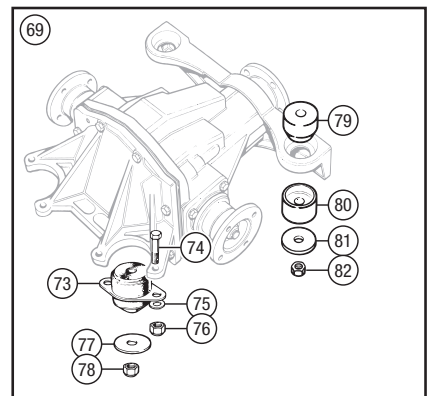
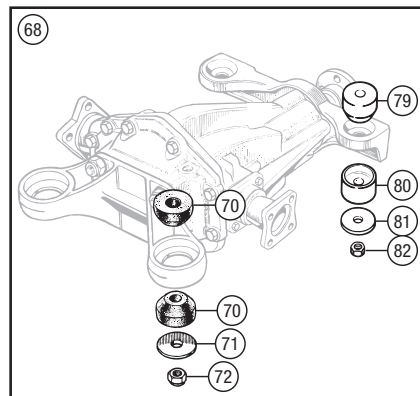
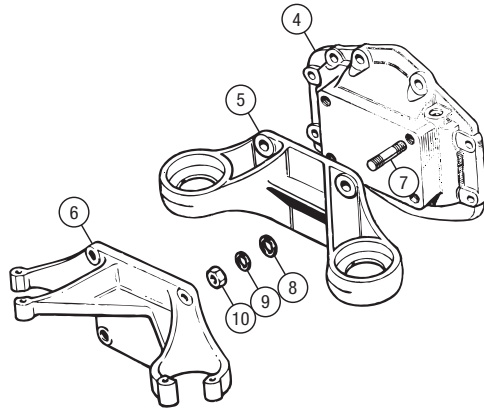
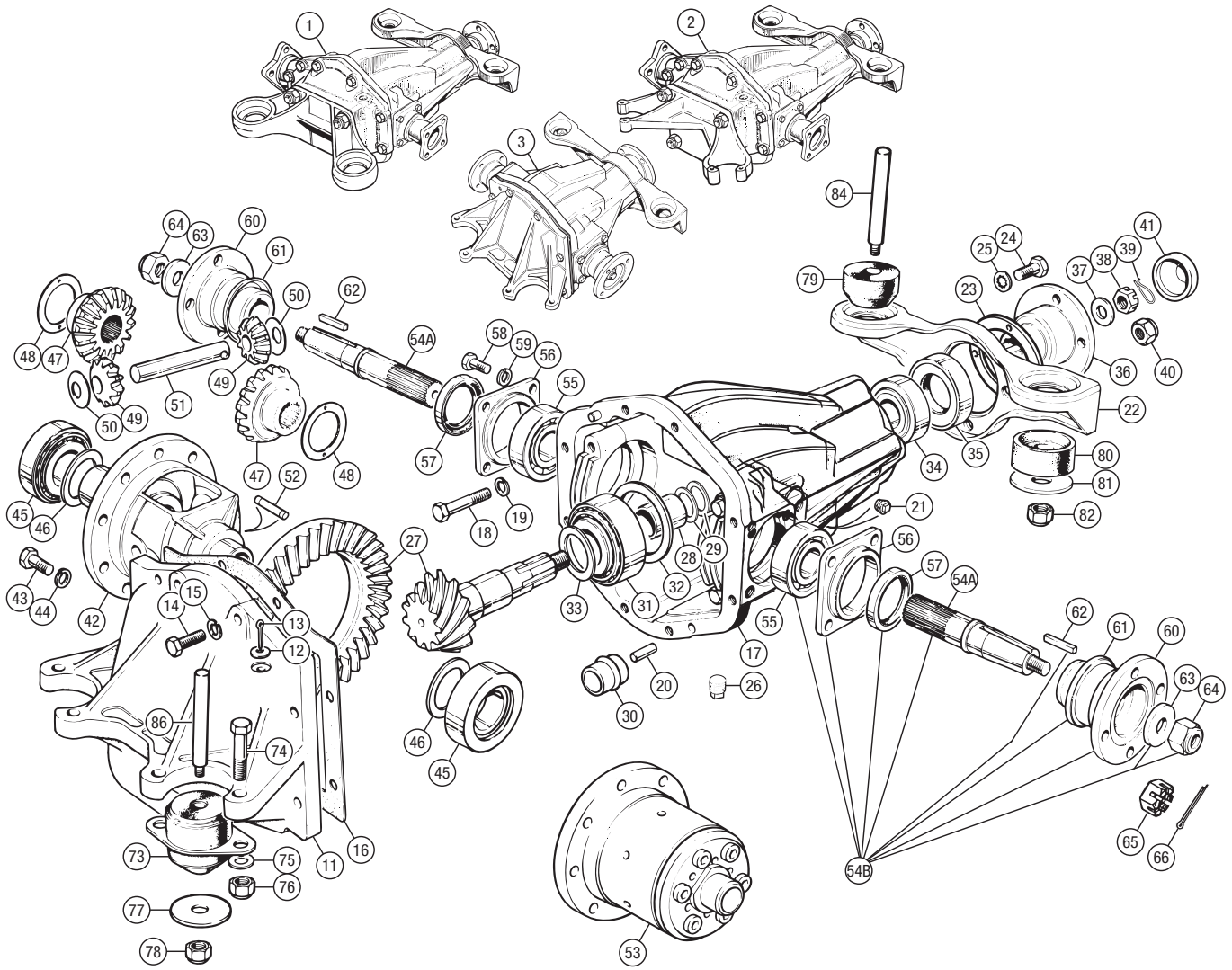
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|--------------------------------------|---|--------|
| 34 BEARING ASS'Y, pinion tail, front | 1 | 100422 |
|--------------------------------------|---|--------|

|                              |   |         |
|------------------------------|---|---------|
| 35 SEAL, oil, pinion, front; |   |         |
| leather                      | 1 | 140337  |
| rubber (alternative)         | 1 | 140337P |

Leather varies in hardness and is susceptible to leakage. A change to our alternative rubber oil seal is an excellent and economic improvement.









## TR4A-5-250

## INDEPENDENT REAR AXLE (IRS) TR4A, TR5, TR250

REAR AXLE - INDEPENDENT - IRS - TR4A-5-250

### Drive Flange - IRS

#### SOLID SPACER PINION

|    |   |   |        |
|----|---|---|--------|
| 36 | FLANGE, pinion<br><i>For solid spacer pinion.</i>   | 1 | 138105 |
| 37 | WASHER, pinion flange<br><i>For solid spacer pinion.</i>  | 1 | 142333 |
| 38 | NUT, slotted, pinion flange<br><i>For solid spacer pinion.</i>  | 1 | 112635 |
| 39 | WIRE, soft iron, locking slotted nut<br><i>For solid spacer pinion.</i><br><i>The fitment of a slotted nut that is positively locked by wire threaded through a drilled hole in the pinion threaded shank should indicate that an axle is fitted with the original type crown wheel and pinion set that has a solid bearing spacer adjusted by shims.</i> | 1 | 514773 |

#### COLLAPSIBLE SPACER PINION

|    |  |   |         |
|----|--|---|---------|
| 36 | FLANGE, pinion<br><i>For collapsible spacer pinion.</i>  | 1 | 160275  |
| 37 | WASHER, pinion flange<br><i>For collapsible spacer pinion.</i>   | 1 | 142333  |
| 40 | NUT, nyloc, pinion flange<br><i>For collapsible spacer pinion.</i>   | 1 | 510618A |
| 41 | SHIELD, cap, over pinion nut<br><i>For collapsible spacer pinion.</i><br><i>The lack of a lock wire drilling in the pinion threaded shank and the resultant use of a nyloc nut instead of a slotted nut should indicate that an axle is fitted with the later TR6 type crown wheel and pinion set that has a collapsible bearing spacer without shims.</i> | 1 | UKC725  |

### Carrier & Differential Gears - IRS

|  |   |     |        |
|--|---|-----|--------|
| 42   | CARRIER, crown wheel & differential   | 1   | 302155 |
| 43   | BOLT, crown wheel to carrier  | 10  | 110737 |
| 44   | WASHER, locking   | 10  | GHF333 |
| <i>The crown wheel to carrier attachment bolts must be fitted using 'Loctite' or similar thread locking engineering adhesive (GAC100). The use of the locking washers alone is insufficient. All the bolts must be tightened to the torque of 46 ft. lbs. as specified in the workshop manual.</i> |   |     |        |
| 45   | BEARING ASS'Y, differential carrier   | 2   | 110515 |
| 46   | SHIM, adjusting bearing;  |     |        |
|  | 0.003"  | A/R | 100894 |
|  | 0.005"  | A/R | 100895 |
|  | 0.010"  | A/R | 100896 |
| 47   | GEAR, side differential, sun wheel,<br>16 teeth, plain<br><i>Fit in pairs, alternative to 153384.</i> | 2   | 113187 |
|  | 16 teeth, with machined groove<br><i>Fit in pairs, alternative to 113187.</i>                         | 2   | 153384 |
| 48   | WASHER, thrust, differential side gear  | 2   | 102801 |
| 49   | GEAR, differential pinion, planet;<br>10 teeth, plain<br><i>Fit in pairs, alternative to 153385.</i>  | 2   | 113188 |
|  | 10 teeth, with machined groove<br><i>Fit in pairs, alternative to 153188.</i>                         | 2   | 153385 |
| 50   | THRUST WASHER;  |     |        |
|  | (0.046/0.049)   | A/R | 56793  |
|  | (0.049/0.051)   | A/R | 142165 |
|  | (0.051/0.053)   | A/R | 139951 |
|  | (0.053/0.055)   | A/R | 142166 |
|  | (0.055/0.057)   | A/R | 139952 |
|  | (0.057/0.059)   | A/R | 160373 |
|  | (0.059/0.061)   | A/R | 139953 |
|  | (0.061/0.063)   | A/R | 160374 |
|  | (0.063/0.065)   | A/R | 139954 |
|  | (0.065/0.067)   | A/R | 160375 |
|  | (0.067/0.069)   | A/R | 139955 |
|  | (0.069/0.071)   | A/R | 160376 |
|  | (0.071/0.073)   | A/R | 139956 |
| 51   | PIN, cross, differential planet gears   | 1   | 100844 |
| 52   | PIN, locating cross pin in carrier  | 1   | 111215 |

10 TEETH GEAR - 113188



### Limited Slip Differential - IRS

*This design of torque sensing differential makes it a worthwhile addition to any competition or fast road car. Allowing maximum drive to both rear wheels giving more grip under hard acceleration. These differentials (crown wheel carriers) are for fitting inside your own axle. Alternatively, purchase one of our exchange rear axles - fully reconditioned, complete with brand new limited slip diff and crown wheel & pinion. See 'Rear Axle Unit Assy'. The traditional type of limited slip differential was the plate type (as opposed to the Quaife geared type, a newer design), manufactured originally by GKN and sold as the Powrlok differential.*

|    |                            |   |            |
|----|----------------------------|---|------------|
| 53 | LIMITED SLIP DIFFERENTIAL; |   |            |
|    | Quaife                     | 1 | RKC2026Q   |
|    | GKN                        | 1 | RKC2026GKN |

### Inner Axle Shaft - IRS

|     |  |   |         |
|-----|--|---|---------|
| 54A | INNER AXLE SHAFT;                        |   |         |
|     | TR4A IRS; uses nyloc nut                 |   |         |
|     | LH                                       | 1 | 134440  |
|     | RH                                       | 1 | 134441  |
|     | TR5, TR250; uses nyloc nut               |   |         |
|     | LH                                       | 1 | 149378  |
|     | RH                                       | 1 | 149379  |
|     | TR5, TR250 alternative; uses slotted nut |   |         |
|     | LH                                       | 1 | UKC4862 |
|     | RH                                       | 1 | UKC4863 |

|     |  |   |            |
|-----|--|---|------------|
| 54B | INNER AXLE SHAFT ASSEMBLY;               |   |            |
|     | <i>Includes items 54A - 57, 60 - 64.</i> |   |            |
|     | LH                                       | 1 | 149378ASSY |
|     | RH                                       | 1 | 149379ASSY |

|    |  |   |        |
|----|--|---|--------|
| 55 | BEARING ASS'Y, ball, axle shaft  | 2 | 134465 |
| 56 | HOUSING, oil seal  | 2 | 128638 |
| 57 | SEAL, oil, inner axle shaft  | 2 | 138523 |
| 58 | SCREW, inner axle to axle casing   | 8 | GHF120 |
| 59 | WASHER, locking  | 8 | GHF332 |
| 60 | FLANGE ASS'Y, driving, inner;  |   |        |
|    | TR4A IRS   | 2 | 138726 |
|    | TR5, TR250   | 2 | 149409 |
| 61 | STONEGUARD, welded to flange   | 2 | 134450 |
| 62 | KEY, inner flange to inner axle shaft;                                       |   |        |
|    | TR4A IRS   | 2 | 136842 |
|    | TR5, TR250   | 2 | 143280 |
| 63 | WASHER   | 2 | 142333 |
| 64 | NUT, nyloc, flange to inner axle shaft                                       | 2 | 138563 |
| 65 | NUT, slotted, flange to inner axle shaft<br><i>Alternative to nyloc nut.</i> | 2 | 21A79  |
| 66 | SPLIT PIN, locking slotted nut   | 2 | PC13   |

### Rear Axle Overhaul Kit - IRS

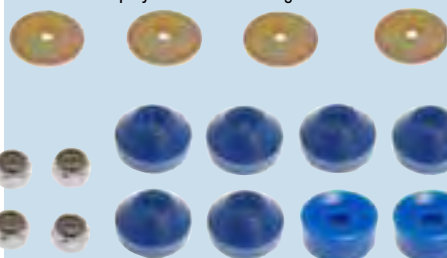
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|-------------------------------------|--|---|---------|
| 67                                  | REAR AXLE OVERHAUL KIT                       | 1 | RR1389  |
| <i>Items in kit RR1389 include:</i> |  |   |         |
| 16                                  | GASKET, rear cover to axle casing            | 1 | 134480  |
| 31                                  | BEARING ASS'Y, pinion head, rear             | 1 | 100897A |
| 34                                  | BEARING ASS'Y, pinion tail, front            | 1 | 100422  |
| 35                                  | SEAL, oil, pinion flange, axle front, rubber | 1 | 140337P |
| 45                                  | BEARING ASS'Y, differential carrier          | 2 | 110515  |
| 55                                  | BEARING ASS'Y, ball, axle shaft              | 2 | 134465  |
| 57                                  | SEAL, oil, inner axle shaft                  | 2 | 138523  |



REAR AXLE OVERHAUL KIT - RR1389

### Rear Axle Mountings - IRS

|    |                                       |   |         |
|----|---------------------------------------|---|---------|
| 68 | REAR AXLE MOUNTING KIT;               |   |         |
|    | TR4A IRS; includes items 70-72, 79-82 |   |         |
|    | with rubber mountings                 | 1 | RF4140  |
|    | with polyurethane mountings           | 1 | RF4140P |



REAR AXLE MOUNTING KIT, TR4A IRS - RF4140P

|    |                                  |   |            |
|----|----------------------------------|---|------------|
| 69 | REAR AXLE MOUNTING KIT;          |   |            |
|    | TR5, TR250; includes items 73-82 |   |            |
|    | with rubber mountings            | 1 | RR1390     |
|    | with polyurethane mountings      | 1 | RR1390POLY |



REAR AXLE MOUNTING KIT, TR5, TR250 - RR1390

#### REAR MOUNTING; TR4A

|    |  |   |            |
|----|--|---|------------|
| 70 | MOUNTING (CONE), rear, axle to chassis, rubber | 4 | 134235     |
|    | polyurethane                                   | 4 | 134235POLY |
| 71 | WASHER, special, axle mounting                 | 2 | 134234     |
| 72 | NUT, nyloc, axle mounting to chassis           | 2 | TN3209     |

#### REAR MOUNTING; TR5, TR250

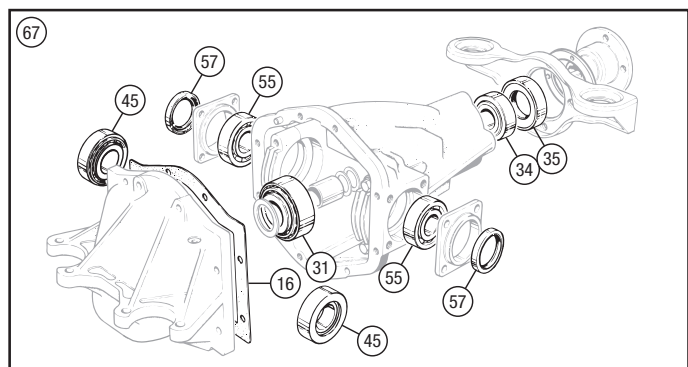
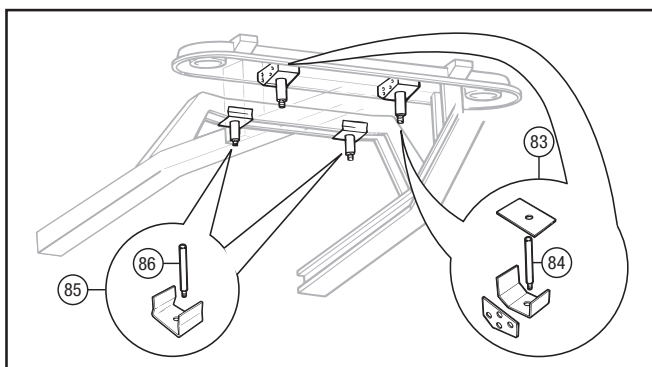
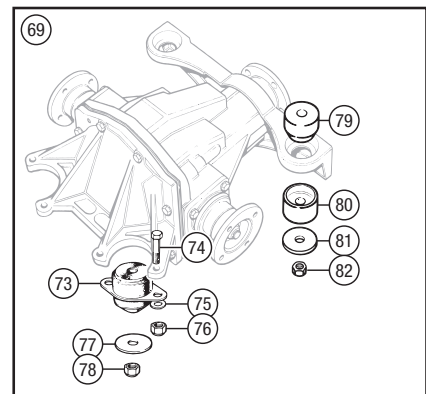
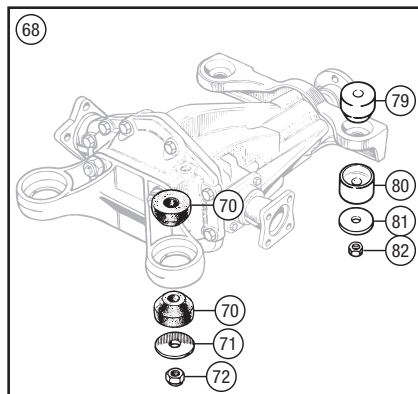
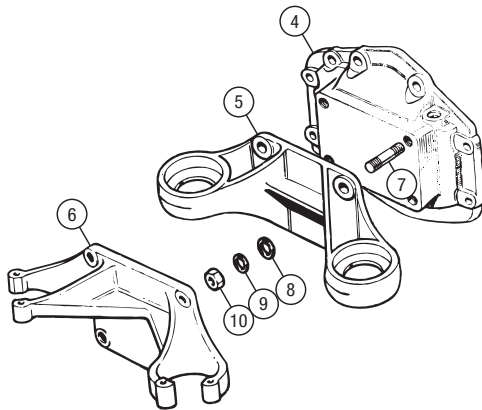
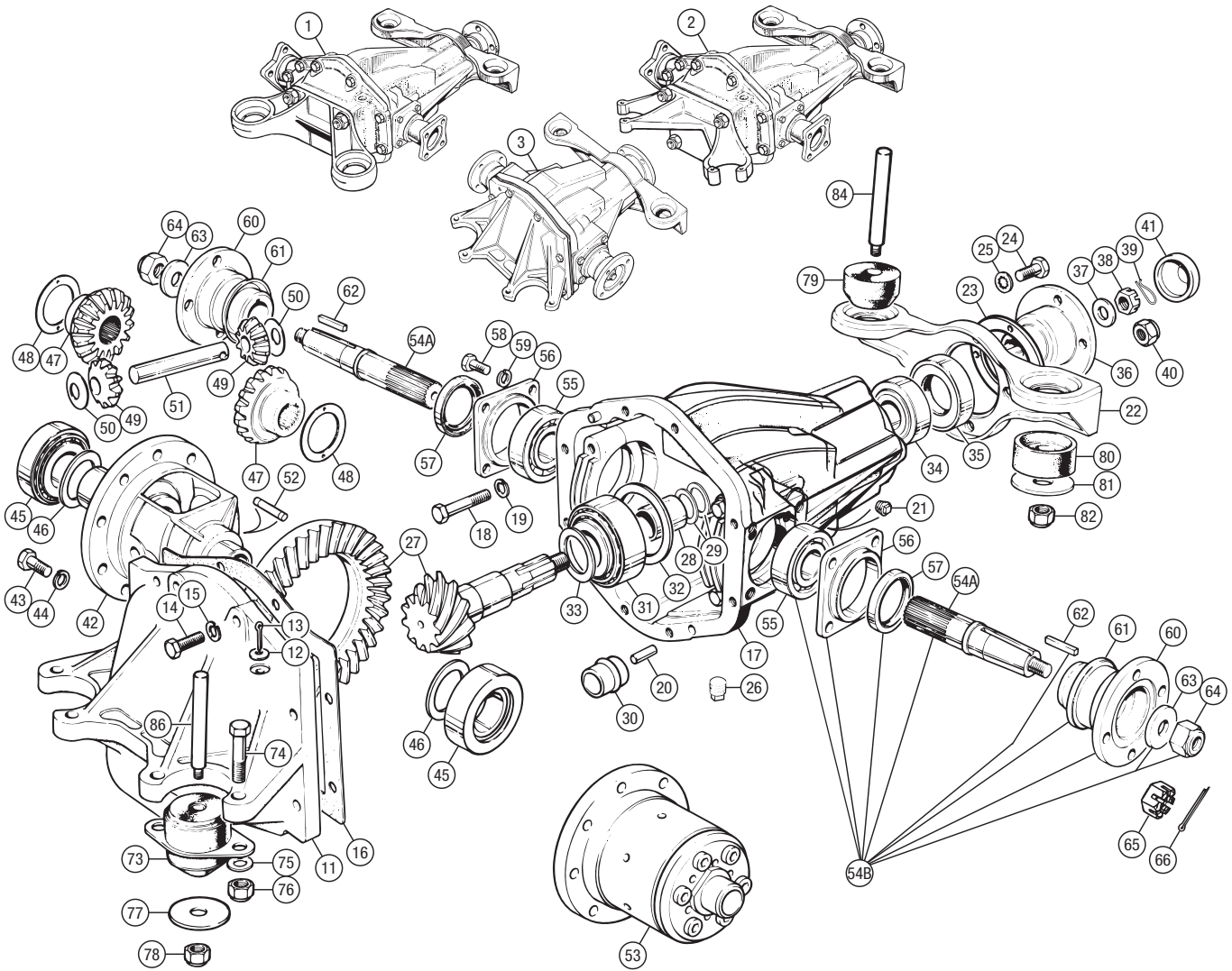
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|----|---|---|------------|
| 73 | MOUNTING, rear, axle to chassis; rubber | 2 | 147783     |
|    | polyurethane                            | 2 | 147783POLY |
| 74 | BOLT, mounting rubber to axle cover     | 4 | BH605111   |
| 75 | WASHER, plain                           | 4 | WM58       |
| 76 | NUT, nyloc                              | 4 | GHF272     |
| 77 | WASHER, special, axle mounting          | 2 | 134234     |
| 78 | NUT, nyloc, axle mounting to chassis    | 2 | TN3209     |

#### FRONT MOUNTING; TR4A, TR5, TR250

|    |   |   |            |
|----|---|---|------------|
| 79 | MOUNTING (CONE), upper front, axle to chassis; rubber | 2 | 134235     |
|    | polyurethane  | 2 | 134235POLY |
| 80 | MOUNTING (CUP), lower front, axle to chassis; rubber  | 2 | 134236     |
|    | polyurethane  | 2 | 134236POLY |
| 81 | WASHER, special, axle mounting                        | 2 | 134234     |
| 82 | NUT, nyloc, axle mounting to chassis                  | 2 | TN3209     |

|    |   |   |          |
|----|---|---|----------|
| 83 | BRACKET KIT, axle mounting front<br><i>Includes reinforcements and stud pins - car set.</i> | 1 | 140009K  |
| 84 | STUD ONLY, axle mounting, front   | 2 | 147671   |
| 85 | BRACKET KIT, axle mounting, rear<br><i>Includes studs and brackets - car set.</i>           | 1 | 147400RK |
| 86 | STUD ONLY, axle mounting, rear  | 2 | 147400   |







## ALL MODELS

### PROPSHAFTS

The engineers at Triumph were clever enough when they designed the TR2-6 series of sports cars to produce a gearbox that when fitted with overdrive was virtually the same length as the non-overdrive version. This is an absolute bonus for spares stockists of propeller shafts as 'one size fits all'. From a vehicle engineering point of view it shows skill and understanding of the various options that could have been offered.

### Propshaft All models

|   |                                      |     |        |
|---|--------------------------------------|-----|--------|
| 1 | PROPELLER SHAFT ASS'Y                | 1   | 207391 |
| 2 | UNIVERSAL JOINT ASS'Y                | 2   | GUJ102 |
| 3 | NIPPLE, grease (if fitted)           | 2   | 144825 |
| 4 | FLANGE, yoke                         | 2   | 211137 |
| 5 | NIPPLE, grease, straight (if fitted) | A/R | 234532 |
| 6 | NIPPLE, grease, 45° (if fitted)      | A/R | UHN445 |
| 7 | BOLT, propeller shaft attachment     | 8   | 107960 |
| 8 | NUT;                                 |     |        |

|  |                          |   |        |
|--|--------------------------|---|--------|
|  | nyloc                    | 8 | TN3209 |
|  | 'Cleveloc' (alternative) | 8 | GHF243 |

|    |                         |   |           |
|----|-------------------------|---|-----------|
| 52 | STUDLOC, 'Loctite', 3ml | 1 | GAC1003ML |
|----|-------------------------|---|-----------|

The TR suffers periodically from loosening of the nuts and bolts that attach the propeller shaft to the gearbox or axle drive flanges. Overdrive models are perhaps more prone to this than those with standard transmission. An engineering adhesive such as 'Loctite' (GAC100) can be used when assembling the propeller shaft bolts and nuts. Alternative nuts such as the 'Cleveloc' all steel type do prove more positive than the original nylon form. Whenever the propeller shaft bolts are undone it is recommended that the nuts be replaced as a full set. Loose bolts can be identified by the noise of the propeller shaft rattling or an unbalanced vibration. If the bolts have been run loose it will invariably mean that the bolts will be damaged or worse still the holes in the flange yokes or drive flanges are elongated.



UNIVERSAL JOINT ASSEMBLY - GUJ102

### Drive Shafts & Hub Units TR4A IRS, TR5, TR250

|    |   |   |         |
|----|---|---|---------|
| 9A | OUTER AXLE SHAFT & HUB ASS'Y, reconditioned exchange Ready to install (less studs). | 2 | RKC454R |
|----|---|---|---------|

|    |   |   |          |
|----|---|---|----------|
| 9B | OUTER AXLE SHAFT & HUB ASS'Y; new, uprated - outright sale CV joint type with ball bearing sliding shaft & improved stub axle design. | 2 | RKC454CV |
|----|---|---|----------|

|     |   |  |        |
|-----|---|--|--------|
| 10A | OUTER AXLE SHAFT, replacement type 2 Less hub & flanges. Outright sale. |  | TKC853 |
|-----|---|--|--------|

|     |   |   |          |
|-----|---|---|----------|
| 10B | OUTER AXLE SHAFT, UPRATED, replacement type Includes inner drive flange & heavy duty UJ's. Features non-stick, Rilsan coated, heavy duty splines for increased durability & efficient operation. Ready to fit to hub assembly. Outright sale. | 2 | TKC853UR |
|-----|---|---|----------|

|    |  |   |        |
|----|--|---|--------|
| 11 | INNER YOKE & SHAFT                     | 2 | 140749 |
| 12 | OUTER YOKE & SHAFT                     | 2 | 142437 |
| 13 | FLANGE, yoke, inner                    | 2 | 211137 |
| 14 | BOOT, PVC, protecting inner joint      | 2 | 213844 |
| 15 | BOOT, rubber, protecting sliding joint | 2 | 140753 |
| 16 | WIRE, binding, large end of boot       | 2 | 512781 |
| 17 | WIRE, binding, small end of boot       | 2 | 512781 |
| 18 | UNIVERSAL JOINT ASS'Y                  | 4 | GUJ102 |
| 19 | NIPPLE, grease (if fitted)             | 4 | 144825 |



REAR HUB UNIT - TKC897R

|    |   |   |         |
|----|---|---|---------|
| 20 | REAR HUB UNIT; new - outright sale reconditioned exchange Wheel studs not included. | 2 | TKC897  |
|    |   | 2 | TKC897R |

|    |   |   |        |
|----|---|---|--------|
| 21 | FLANGE ASSEMBLY, driving; Wheel studs not included. |   |        |
|    | steel wheel fitment                                 | 2 | 210979 |
|    | wire wheel fitment                                  | 2 | 212403 |

|    |                    |   |        |
|----|--------------------|---|--------|
| 22 | STUD; steel wheels | 8 | 132317 |
|    | wire wheels        | 8 | 142799 |

|    |                                   |   |         |
|----|-----------------------------------|---|---------|
| 23 | BEARING KIT Includes items 24-28. | 2 | GHK1015 |
|----|-----------------------------------|---|---------|

|    |                     |   |        |
|----|---------------------|---|--------|
| 24 | SEAL, grease, outer | 2 | GHS133 |
|----|---------------------|---|--------|

|    |                         |   |        |
|----|-------------------------|---|--------|
| 25 | BEARING ASSEMBLY, outer | 2 | GHB265 |
|----|-------------------------|---|--------|

|    |                     |   |        |
|----|---------------------|---|--------|
| 26 | SPACER, collapsible | 2 | 138272 |
|----|---------------------|---|--------|

|    |                         |   |        |
|----|-------------------------|---|--------|
| 27 | BEARING ASSEMBLY, inner | 2 | GHB101 |
|----|-------------------------|---|--------|

|    |                     |   |        |
|----|---------------------|---|--------|
| 28 | SEAL, grease, inner | 2 | GHS131 |
|----|---------------------|---|--------|

|    |                   |   |        |
|----|-------------------|---|--------|
| 29 | HOUSING, rear hub | 2 | 137496 |
|----|-------------------|---|--------|

|    |                         |   |         |
|----|-------------------------|---|---------|
| 30 | ADJUSTING SPACER, solid | 2 | ULC2188 |
|----|-------------------------|---|---------|

|    |            |   |        |
|----|------------|---|--------|
| 31 | STONEGUARD | 2 | 137497 |
|----|------------|---|--------|

|    |                |   |        |
|----|----------------|---|--------|
| 32 | NUT, adjusting | 2 | 138861 |
|----|----------------|---|--------|

|    |             |   |        |
|----|-------------|---|--------|
| 33 | WASHER, tab | 2 | 139057 |
|----|-------------|---|--------|

|    |              |   |        |
|----|--------------|---|--------|
| 34 | NUT, locking | 2 | 134585 |
|----|--------------|---|--------|

|    |                                    |   |        |
|----|------------------------------------|---|--------|
| 35 | YOKE & STUB AXLE; original fitment | 2 | 137478 |
|    | later TR6 replacement              | 2 | UKC643 |

The yoke and stub axle UKC643 is manufactured to safety critical specifications and should be used for all replacements.

|    |                                   |   |        |
|----|-----------------------------------|---|--------|
| 36 | KEY, axle shaft to driving flange | 2 | 134591 |
|----|-----------------------------------|---|--------|

|    |  |   |        |
|----|--|---|--------|
| 37 | NUT, nyloc, driving flange to axle shaft Use on original stub axles. | 2 | 138563 |
|----|--|---|--------|

|    |   |  |       |
|----|---|--|-------|
| 38 | NUT, slotted, driving flange to axle shaft Use on replacement stub axles. |  | 21A79 |
|----|---|--|-------|

|    |   |   |      |
|----|---|---|------|
| 39 | SPLIT PIN, locking slotted nut Use on replacement stub axles. | 2 | PC13 |
|----|---|---|------|

|    |                               |   |      |
|----|-------------------------------|---|------|
| 40 | WASHER, nut to driving flange | 2 | WM63 |
|----|-------------------------------|---|------|

|    |                                     |    |       |
|----|-------------------------------------|----|-------|
| 41 | STUD, rear hub unit to trailing arm | 12 | TD812 |
|----|-------------------------------------|----|-------|

|    |               |    |        |
|----|---------------|----|--------|
| 42 | WASHER, plain | 12 | GHF301 |
|----|---------------|----|--------|

|    |            |    |        |
|----|------------|----|--------|
| 43 | NUT, nyloc | 12 | GHF222 |
|----|------------|----|--------|

|    |  |   |        |
|----|--|---|--------|
| 44 | BOLT, drive shaft inner yoke to flange | 8 | 107960 |
|----|--|---|--------|

|    |                          |   |        |
|----|--------------------------|---|--------|
| 45 | NUT; nyloc               | 8 | TN3209 |
|    | 'Cleveloc' (alternative) | 8 | GHF243 |

|    |                         |    |        |
|----|-------------------------|----|--------|
| 46 | WHEEL NUT, steel wheels | 16 | 109586 |
|----|-------------------------|----|--------|

|    |  |    |         |
|----|--|----|---------|
| 47 | WHEEL NUT SET, steel wheels Car set of 16. | 16 | 109586K |
|----|--|----|---------|

|    |                                |    |         |
|----|--------------------------------|----|---------|
| 48 | NUT, special, extension to hub | 16 | RSRN716 |
|----|--------------------------------|----|---------|

|    |                                   |   |        |
|----|-----------------------------------|---|--------|
| 49 | SPLINED EXTENSION, wire wheel; LH | 1 | 217603 |
|    | RH                                | 1 | 217602 |



OUTER AXLE SHAFT & HUB - RKC454R



OUTER AXLE SHAFT - TKC853



OUTER AXLE SHAFT UPRATED - TKC853UR

## Drive Shaft Rebuild Kit

|    |                         |   |        |
|----|-------------------------|---|--------|
| 50 | DRIVE SHAFT REBUILD KIT | 2 | RS2005 |
|----|-------------------------|---|--------|

Note: Photo and illustration shows one kit. The kits are supplied singularly - 2 required per vehicle.

The kit includes the following items:

|    |  |   |         |
|----|--|---|---------|
| 14 | BOOT, PVC, protecting inner joint        | 1 | 213844  |
| 15 | BOOT, rubber, protecting sliding joint   | 1 | 140753  |
| 16 | WIRE, binding                            | 1 | 512781  |
| 17 | WIRE, binding                            | 1 | 512781  |
| 18 | UNIVERSAL JOINT ASS'Y                    | 2 | GUJ102  |
| 23 | BEARING KIT                              | 1 | GHK1015 |
| 31 | STONEGUARD                               | 1 | 137497  |
| 33 | WASHER, TAB                              | 1 | 139057  |
| 37 | NUT, nyloc, driving flange to axle shaft | 1 | 138563  |
| 38 | NUT, slotted, driving flange             | 1 | 21A79   |
| 39 | SPLIT PIN, locking slotted nut           | 1 | PC13    |



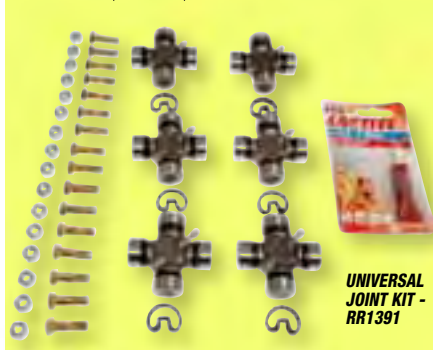
DRIVE SHAFT REBUILD KIT - RS2005

## Universal Joint Kit

|    |                                       |   |        |
|----|---------------------------------------|---|--------|
| 51 | UNIVERSAL JOINT KIT (one kit per car) | 1 | RR1391 |
|----|---------------------------------------|---|--------|

The kit includes the following items:

|    |  |   |           |
|----|--|---|-----------|
| 2  | UNIVERSAL JOINT ASS'Y                  | 2 | GUJ102    |
| 7  | BOLT, propeller shaft attachment       | 8 | 107960    |
| 8  | NUT, nyloc                             | 8 | TN3209    |
| 18 | UNIVERSAL JOINT ASS'Y                  | 4 | GUJ102    |
| 44 | BOLT, drive shaft inner yoke to flange | 8 | 107960    |
| 45 | NUT, nyloc                             | 8 | TN3209    |
| 52 | STUDLOC, 'Loctite', 3ml                | 1 | GAC1003ML |

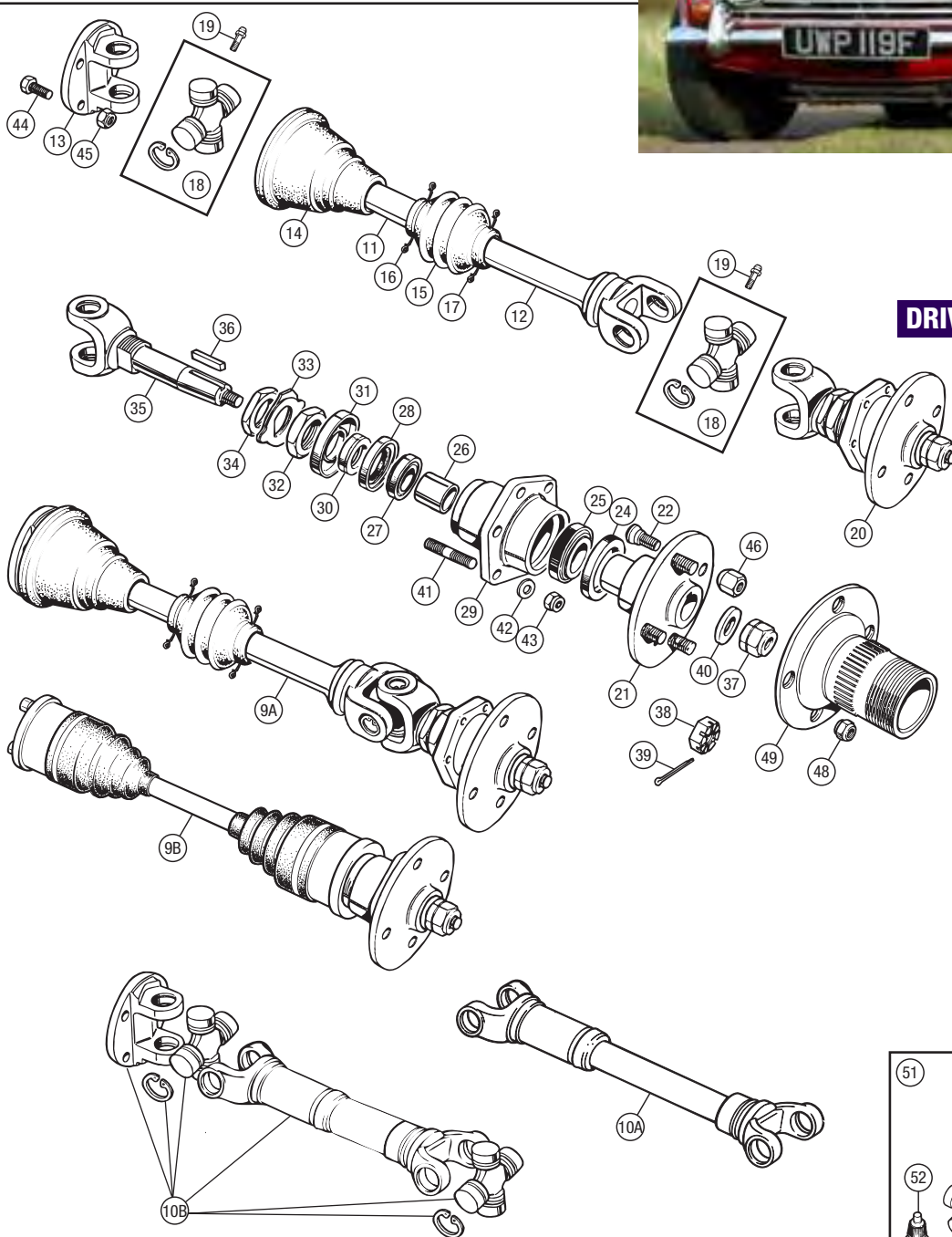
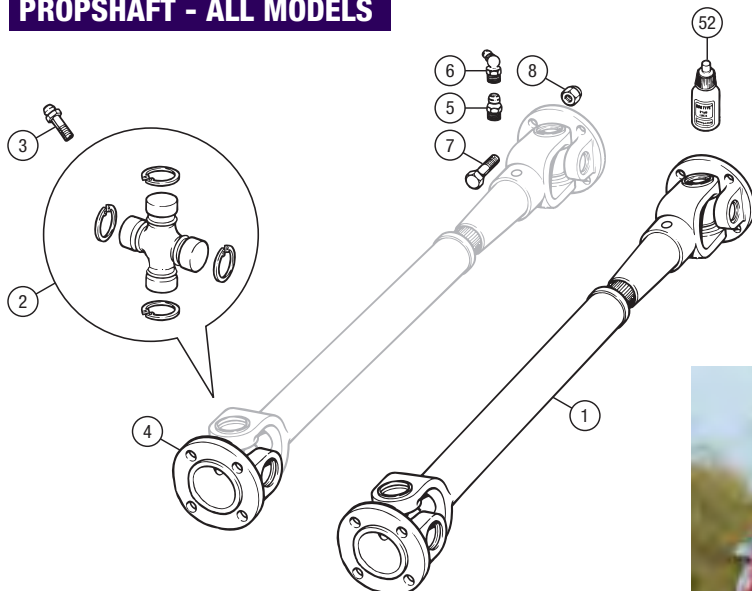


UNIVERSAL JOINT KIT - RR1391

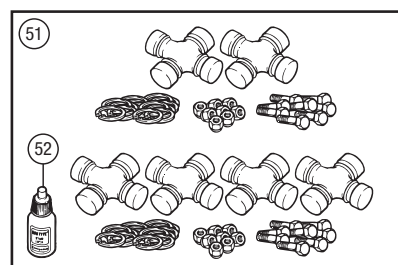
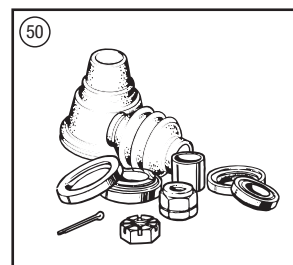
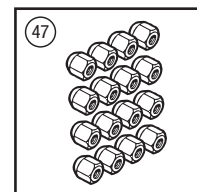
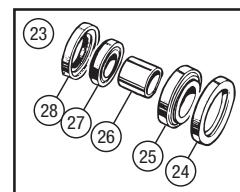


# PROPSHAFT - ALL MODELS

ALL MODELS



## DRIVE SHAFT - IRS MODELS





# TR2-4

## FRONT SUSPENSION - TR2-4

It is a fair bet that if there is any knocking noise from the front suspension or tendency for your car to wander at speed it will be traceable to worn front suspension components. The suspension is not delicate; it is just fitted with bushes that wear rapidly when they become impregnated with dirt.

We offer a full range of individual components and comprehensive kits to overhaul your front suspension. The kits are convenient to order and they save you money!

### Fulcrum Pin & Ball Joint

|    |  |   |          |
|----|--|---|----------|
| 1  | FULCRUM PIN, upper                               | 2 | 200659   |
| 2  | BUSH;  |   |          |
|    | rubber, upper wishbone                           | 8 | 102228   |
|    | polyurethane, upper wishbone                     | 4 | 102228P  |
|    | <i>1 bush replaces 2 original rubber bushes.</i> |   |          |
| 3  | WASHER   | 4 | WM69     |
| 4  | SPLIT PIN  | 4 | PC10     |
| 5  | NUT;   |   |          |
|    | slotted  | 4 | LN2210   |
|    | nyloc (Alternative to slotted nut)               | 4 | GHF274   |
| 6  | SCREW, fulcrum to chassis                        | 4 | GHF105   |
| 7  | BOLT, fulcrum to chassis                         | 4 | BH606141 |
| 8  | NUT  | 4 | GHF203   |
| 9  | WASHER, locking                                  | 8 | GHF333   |
| 10 | WASHER, plain                                    | 4 | GHF302   |

### TR2, TR3, TR3A, TR4 to CT6343 (WIRE WHEELS) AND CT6389 (STEEL WHEELS)

|    |                                    |   |        |
|----|------------------------------------|---|--------|
| 11 | WISHBONE ARM, upper                | 2 | 100695 |
|    | <i>RH rear &amp; LH front.</i>     |   |        |
| 12 | WISHBONE ARM, upper                | 2 | 100696 |
|    | <i>RH front &amp; LH rear.</i>     |   |        |
| 13 | UPPER BALL JOINT ASSEMBLY          | 2 | 200772 |
|    | <i>Includes items 14, 15.</i>      |   |        |
| 14 | GREASE NIPPLE                      | 2 | 56934  |
| 15 | GAITER                             | 2 | 100726 |
|    | NUT, slotted                       | 2 | 61302  |
| 16 | NUT, nyloc                         | 2 | 252165 |
|    | <i>Alternative to slotted nut.</i> |   |        |
| 17 | SPLIT PIN                          | 2 | PC12   |
|    | <i>Use with slotted nut.</i>       |   |        |
| 18 | WASHER                             | 2 | WP12   |
| 19 | DISTANCE PIECE                     | 2 | 100697 |

UPPER BALL JOINT ASSEMBLY - 200772



### TR4 from CT6344 (WIRE WHEELS) AND CT6390 (STEEL WHEELS)

|    |                              |   |          |
|----|------------------------------|---|----------|
| 20 | WISHBONE ARM, upper rear     | 2 | 133507   |
| 21 | WISHBONE ARM, upper front    | 2 | 133504   |
| 22 | BALL JOINT ASSEMBLY          | 2 | GSJ131   |
|    | <i>Includes items 23-25.</i> |   |          |
| 23 | CLIP, gaiter retaining       | 2 | 138869   |
| 24 | GAITER                       | 2 | UKC3466  |
| 25 | GREASE NIPPLE                | 2 | UHN445   |
| 26 | BOLT, ball joint to wishbone | 4 | 112347   |
| 27 | NUT, nyloc                   | 4 | GHF223   |
| 28 | WASHER, plain                | 4 | WB110061 |

BALL JOINT ASSEMBLY - GSJ131



|    |                                     |   |          |
|----|-------------------------------------|---|----------|
| 29 | WASHER, ball joint to vertical link | 2 | WC112081 |
| 30 | SPLIT PIN                           | 2 | PC10     |
|    | <i>Use with slotted nut.</i>        |   |          |
| 31 | NUT, slotted                        | 2 | LN2211   |
| 32 | NUT, nyloc                          | 2 | GHF225   |
|    | <i>Alternative to slotted nut.</i>  |   |          |

VERTICAL LINK - 201803



### Vertical Link & Tie Rod Lever

|    |   |     |          |
|----|---|-----|----------|
| 33 | VERTICAL LINK;  |     |          |
|    | + 1.0° camber, std  | 2   | 201803   |
|    | - 1.5° camber   | 2   | RW3206   |
| 34 | LEVER, tie rod;   |     |          |
|    | TR2, TR3, TR3A  |     |          |
|    | RH  | 1   | 106576   |
|    | LH  | 1   | 106575   |
|    | <i>TR4 to CT6343 (wire wheels) and CT6389 (steel wheels)</i>                          |     |          |
|    | RH  | 1   | 127830   |
|    | LH  | 1   | 127831   |
|    | <i>TR4 from CT6344 to CT16462 (wire wheels) and CT6390 to CT16349 (steel wheels).</i> |     |          |
|    | RH  | 1   | 129836   |
|    | LH  | 1   | 129837   |
|    | <i>TR4 from CT16463 (wire wheels) &amp; CT16350 (steel wheels)</i>                    |     |          |
|    | RH  | 1   | 134542   |
|    | LH  | 1   | 134541   |
| 35 | DI STANCE PIECE, lever to link  | 4   | 107106   |
| 36 | PLATE, caliper mounting;  |     |          |
|    | TR3 from TS13046, TR3A, TR4 to CT4689 (wire wheels) or CT4387 (steel wheels)          |     |          |
|    | RH  | 1   | 113124   |
|    | LH  | 1   | 113123   |
|    | <i>TR4 from CT4690 (wire wheels) or CT4388 (steel wheels)</i>                         |     |          |
|    | RH  | 1   | 133499   |
|    | LH  | 1   | 133500   |
| 37 | TAB WASHER  | 4   | 106641   |
| 38 | BOLT, tie rod lever to vertical link, front   | 2   | BH606221 |
| 39 | BOLT, tie rod lever to vertical link, rear  |     |          |
|    | TR2, TR3 to TS13045   | 2   | BH606261 |
|    | TR3 from TS13046, TR3A, TR4   | 2   | 112032   |
| 40 | SCREW;  |     |          |
|    | backing plate to vertical link, front   |     |          |
|    | TR2, TR3 to TS13045   | 2   | SH606061 |
|    | caliper mount to vertical link, front   |     |          |
|    | TR3 from TS13046, TR3A, TR4   | 2   | SH606065 |
| 41 | SCREW, backing plate to vertical link, rear   |     |          |
|    | TR2, TR3 to TS13045   | 2   | SH606061 |
|    | BOLT, caliper mount to vertical link, rear  |     |          |
|    | TR3 from TS13046, TR3A, TR4   | 2   | 118324   |
| 42 | NUT   | 4/6 | GHF223   |
|    | <i>6 required on TR3 from TS13046, TR3A, TR4.</i>                                     |     |          |

### Front Hubs

|    |  |   |          |
|----|--|---|----------|
| 43 | STUB AXLE                                    | 2 | 115763   |
| 44 | NUT, stub axle to vertical link              | 2 | GHF275   |
| 45 | WASHER, stub axle to vertical link           | 2 | WC112081 |
| 46 | BEARING KIT (Includes 2 bearings and a seal) | 2 | GHK1021  |
|    | <i>Includes items 47-50.</i>                 |   |          |
| 47 | GREASE SEAL, felt with steel backing         | 2 | GHS110   |
| 48 | BEARING, inner                               | 2 | GHB111   |
| 49 | BEARING, outer                               | 2 | GHB110   |
| 50 | SPLIT PIN                                    | 2 | PC20     |
| 51 | 'D' WASHER                                   | 2 | 102690   |
| 52 | NUT, slotted                                 | 2 | LN2211   |
| 53 | CAP, grease retaining                        | 2 | 102689   |

### STEEL WHEEL HUBS; TR2, TR3 to TS13045

|    |  |   |        |
|----|--|---|--------|
| 54 | HUB ASSEMBLY, steel wheels                     | 2 | 109975 |
|    | <i>Includes studs.</i>                         |   |        |
| 55 | STUD, fitted in hub, steel wheel               | 8 | 100869 |
|    | GREASE NIPPLE, front wheel bearing lubricating | 2 | 144825 |
|    | <i>As fitted.</i>                              |   |        |

### STEEL WHEEL HUBS; TR3 from TS13046, TR3A, TR4

|    |                                  |   |         |
|----|----------------------------------|---|---------|
| 56 | HUB ASSEMBLY, steel wheels;      |   |         |
|    | standard (Includes studs)        | 2 | 114284  |
|    | alloy (Includes studs)           | 2 | 114284A |
| 57 | STUD, fitted in hub, steel wheel | 8 | 114282  |
| 58 | WHEEL NUT, steel wheel           | 8 | 109586  |
| 59 | WHEEL NUT SET, steel wheel       | 8 | 109586K |
|    | <i>Car set of 16.</i>            |   |         |

### WIRE WHEEL HUBS; TR2, TR3 to TS13045

|    |  |   |        |
|----|--|---|--------|
| 60 | HUB, wire wheel, (Includes items 61-63);               |   |        |
|    | RH   | 1 | 108277 |
|    | LH   | 1 | 108278 |
| 61 | PEG, drum to hub, long, locating notch in taper collar | 2 | 109457 |
| 62 | PEG, drum to hub, short, supporting taper collar       | 6 | 107950 |
| 63 | COLLAR, taper, notched, wire wheel seating             | 2 | 107942 |

### WIRE WHEEL HUBS; TR3 from TS13046, TR3A, TR4

|    |                                 |    |         |
|----|---------------------------------|----|---------|
| 64 | HUB ASSEMBLY, wire wheels       | 2  | 114283  |
|    | <i>Includes studs.</i>          |    |         |
| 65 | STUD, fitted in hub, wire wheel | 8  | 114281  |
| 66 | SPLINED EXTENSION;              |    |         |
|    | RH                              | 1  | 217602  |
|    | LH                              | 1  | 217603  |
| 67 | NUT, extension to hub           | 16 | RSRN716 |

SPLINED EXTENSION RH - 217602

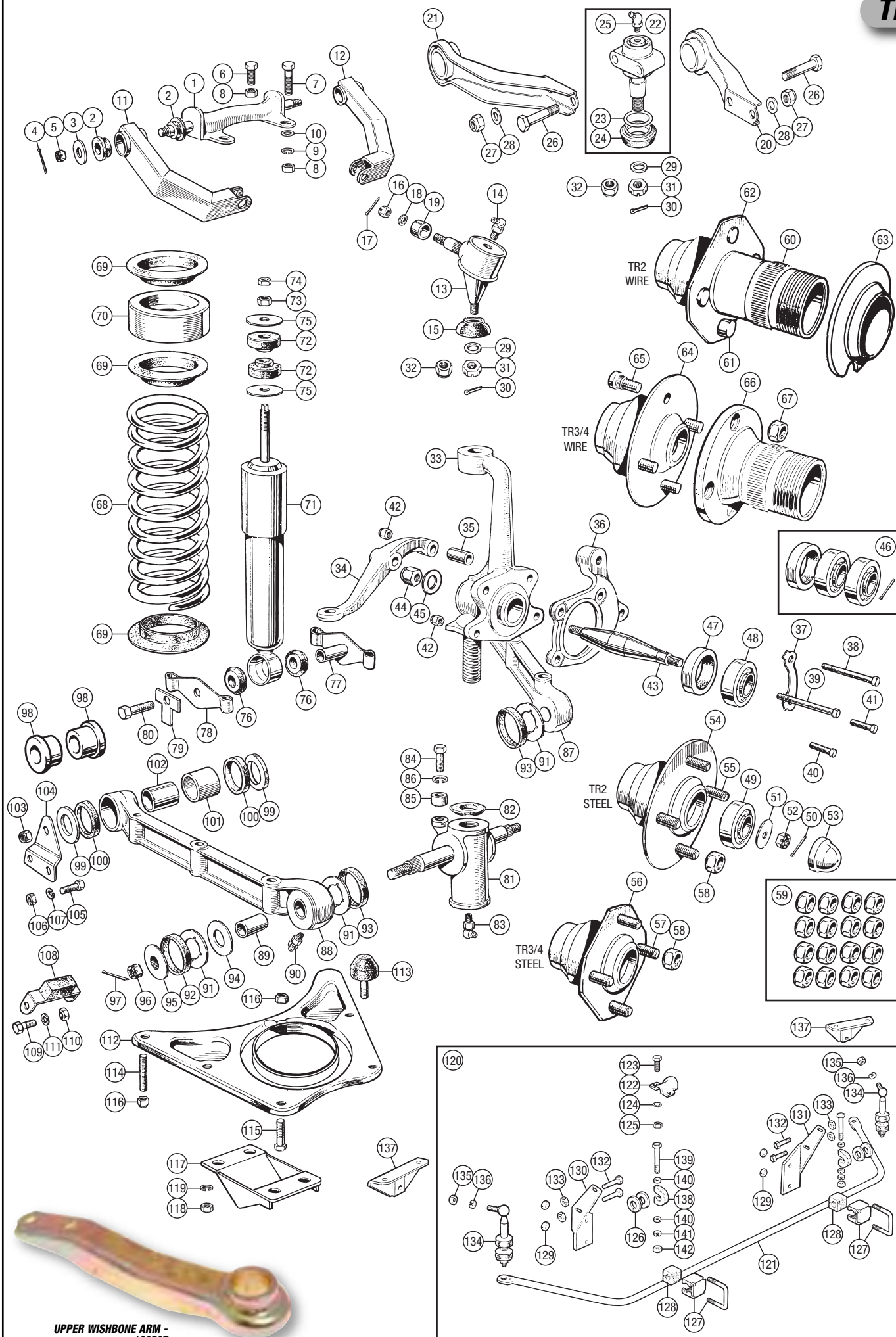


COIL SPRING - 210903

### Coil Springs & Shock Absorbers

|    |  |     |            |
|----|--|-----|------------|
| 68 | COIL SPRING;   |     |            |
|    | approx 9 3/4" free length  | 2   | 201898     |
|    | TR2, TR3, TR3A, TR4 to CT29984; use with aluminium packing piece.                    |     |            |
|    | approx 11" free length   | 2   | 210903     |
|    | TR4 from CT29985; may be used on earlier cars if aluminium packing piece is deleted. |     |            |
|    | uprated  | 2   | 210903UR   |
|    | <i>Use with aluminium packing piece.</i>   |     |            |
| -  | COIL SPRING COMPRESSOR TOOL  | 1   | GAC5076    |
|    | <i>Not shown.</i>  |     |            |
| 69 | INSULATOR, spring seating;   |     |            |
|    | <i>Quantity reduces when aluminium packing piece is not used.</i>                    |     |            |
|    | rubber   | 6/4 | 100751     |
|    | polyurethane   | 6/4 | 100751POLY |
| 70 | PACKING PIECE, aluminium   | 2   | 107682     |
|    | <i>Use with 201898 spring.</i>   |     |            |
| 71 | SHOCK ABSORBER, includes bushes;   |     |            |
|    | standard type, each  | 2   | RF4038     |
|    | Spax, adjustable, pair   | 1   | RF4038SPAX |
|    | Koni, adjustable, pair   | 1   | RF4038KONI |
|    | Gaz, adjustable, pair  | 1   | RF4038GAZ  |
| 72 | MOUNTING BUSH, upper;  |     |            |
|    | rubber,  | 4   | 152588     |
|    | polyurethane (Alternative)   | 4   | 152588POLY |
| 73 | NUT, plain   | 2   | GHF202     |
| 74 | NUT;   |     |            |
|    | half   | 2   | NT606041   |
|    | nyloc (Alternative)  | 2   | GHF223     |
| 75 | WASHER, cupped   | 4   | 142356     |
| 76 | MOUNTING BUSH;   |     |            |
|    | rubber, lower  | 4   | 102987     |
|    | polyurethane, lower (Alternative)  | 4   | 102987POLY |
| 77 | PIN & BRACKET  | 2   | 106841     |
| 78 | BRACKET  | 2   | 106843     |
| 79 | TAB WASHER   | 2   | 101229     |
| 80 | SCREW  | 2   | SH607081   |







**ANTI-ROLL BAR KIT - 510584****TR4 OPTIONAL FITMENT**

*For uprated anti-roll bars, please see 'Suspension & Steering Improvements'.*

|           |  |   |   |
|-----------|--|---|---|
| <b>81</b> | <b>BOTTOM TRUNNION ASSEMBLY;</b><br><i>TR2, TR3, TR3A, TR4 to CT6343 (wire wheels)</i><br><i>and CT6390 (steel wheels)</i><br>0 deg. castor<br><i>TR4 from CT6344 (wire wheels)</i><br><i>and CT6391 (STEEL WHEELS)</i><br>3 deg. castor<br>RH<br>LH | 2<br><br><br><br><br><br><br><br>1<br>1 | <b>101557</b><br><br><br><br><br><br><br><br><b>133838</b><br><b>133839</b> |
| <b>82</b> | <b>SEAL, trunnion to vertical link;</b><br>original<br><i>Use with original trunnions.</i><br>uprated design<br><i>Use with new trunnions.</i>   | 2<br><br><br>2                          | <b>58224</b><br><br><br><b>142402</b>                                       |
| <b>83</b> | <b>GREASE NIPPLE</b>   | 2                                       | <b>56934</b>  |
| <b>84</b> | <b>SCREW, lock stop to trunnion</b>  | 2                                       | <b>GHF120</b>   |
| <b>85</b> | <b>STOP, steering lock</b>   | 2                                       | <b>101407</b>   |
| <b>86</b> | <b>WASHER, locking</b>   | 2                                       | <b>GHF332</b>   |
| <b>87</b> | <b>ARM, lower wishbone,</b><br>RH front and LH rear  | 2                                       | <b>106577</b>   |
| <b>88</b> | <b>ARM, lower wishbone,</b><br>LH front and RH rear  | 2                                       | <b>106578</b>   |
| <b>89</b> | <b>BUSH, wishbone arm</b><br><i>Ream after fitting in wishbone arm.</i>  | 4                                       | <b>101615</b>   |
| <b>90</b> | <b>GREASE NIPPLE</b>   | 4                                       | <b>56934</b>  |
| <b>91</b> | <b>THRUST WASHER</b>   | 8                                       | <b>101533</b>   |
| <b>92</b> | <b>SEAL, wishbone, outer side, 3/8" wide</b><br><i>TR2, TR3, TR3A, TR4 to CT7218</i>   | 8                                       | <b>115702</b>   |
| <b>93</b> | <b>SEAL, wishbone, trunnion side, 5/16" wide</b><br><i>TR4 from CT7219</i>   | 4                                       | <b>134319</b>   |
| <b>94</b> | <b>SHIM, for seal - TR4 from CT7219</b>  | 16                                      | <b>134293</b>   |
| <b>95</b> | <b>WASHER, lock;</b><br><i>TR2, TR3, TR3A, TR4 to CT7218</i><br><i>TR4 from CT7219</i>   | 4<br>4                                  | <b>115701</b><br><b>134320</b>  |

|            |  |          |                                    |
|------------|--|----------|------------------------------------|
| <b>96</b>  | <b>NUT;</b><br>slotted <i>(Use with original trunnions)</i><br>nyloc <i>(Use with new trunnions)</i>   | 4<br>4   | <b>LN2210</b><br><b>GHF274</b>     |
| <b>97</b>  | <b>SPLIT PIN</b> <i>(Use with slotted nut)</i>   | 4        | <b>PC10</b>                        |
| <b>98</b>  | <b>BUSH, TR2, TR3 to TS9120;</b><br>rubber, lower wishbone<br>polyurethane, lower wishbone<br><i>1 bush replaces 2 original rubber bushes.</i>         | 8<br>4   | <b>102228</b><br><b>102228P</b>    |
| <b>99</b>  | <b>WASHER, nylon</b><br>TR3 from TS9121, TR3A, TR4   | 8        | <b>110697</b>                      |
| <b>100</b> | <b>SEAL - TR3 from TS9121, TR3A, TR4</b>   | 8        | <b>115702</b>                      |
| <b>101</b> | <b>BUSH, nylon</b><br>TR3 from TS9121, TR3A, TR4   | 4        | <b>110696</b>                      |
| <b>102</b> | <b>BUSH, - TR3 from TS9121, TR3A, TR4;</b><br>steel<br>polyurethane, lower wishbone<br><i>Alternative to rubber or nylon/steel bushes.</i>             | 4<br>4   | <b>110695</b><br><b>102228POLY</b> |
| <b>103</b> | <b>NUT, lower fulcrum pin</b>  | 4        | <b>GHF274</b>                      |
| <b>104</b> | <b>BRACKET, lower fulcrum support</b>  | 4        | <b>107430</b>                      |
| <b>105</b> | <b>SCREW, bracket to frame</b>   | 8        | <b>SH605051</b>                    |
| <b>106</b> | <b>NUT</b>   | 8        | <b>GHF201</b>                      |
| <b>107</b> | <b>WASHER, locking</b>   | 8        | <b>GHF332</b>                      |
| <b>108</b> | <b>REBOUND STOP RUBBER ASSEMBLY</b>  | 2        | <b>100175</b>                      |
| <b>109</b> | <b>SCREW,</b><br>attaching rebound rubber to chassis   | 4        | <b>GHF120</b>                      |
| <b>110</b> | <b>NUT</b>   | 4        | <b>GHF201</b>                      |
| <b>111</b> | <b>WASHER, locking</b>   | 4        | <b>GHF332</b>                      |
| <b>112</b> | <b>SPRING PAN</b>  | 2        | <b>200193</b>                      |
| <b>113</b> | <b>BUMP STOP RUBBER ASSEMBLY</b><br>STUD, at inner end of lower wishbones<br><i>Drilled for split pins.</i>  | 4<br>4   | <b>106845</b><br><b>107350</b>     |
| <b>114</b> | <b>STUD, at inner end of lower wishbones</b><br><i>Use with nyloc nuts.</i><br>BOLT, spring pan to wishbone<br><i>Drilled for split pins.</i>          | 4<br>8   | <b>143712</b><br><b>107351</b>     |
| <b>115</b> | <b>BOLT, spring pan to wishbone</b><br><i>Use with nyloc nuts.</i><br>NUT, slotted, spring pan to wishbone<br><i>Use with drilled studs and bolts.</i> | 8<br>12  | <b>BH606161</b><br><b>LN2209</b>   |
| <b>116</b> | <b>NUT, nyloc, spring pan to wishbone</b><br><i>Use when studs and bolts are not drilled.</i><br>SPLIT PIN<br><i>Use with slotted nuts.</i>            | 12<br>12 | <b>TN3209</b><br><b>PC10</b>       |
| <b>117</b> | <b>BRACKET, rebound abutment</b>   | 2        | <b>106844</b>                      |
| <b>118</b> | <b>NUT, bracket and shock absorber</b><br>to spring pan  | 8        | <b>GHF202</b>                      |
| <b>119</b> | <b>WASHER, locking</b>   | 8        | <b>GHF333</b>                      |

|            |   |          |                 |
|------------|---|----------|-----------------|
| <b>120</b> | <b>ANTI-ROLL BAR KIT</b>                | <b>1</b> | <b>510584</b>   |
|            | <i>Includes items 121-136.</i>          |          |                 |
| <b>121</b> | <b>BAR, anti-roll, 9/16" diameter</b>   | <b>1</b> | <b>208571</b>   |
| <b>122</b> | <b>CLAMP, bar locating</b>              | <b>4</b> | <b>AHH6546</b>  |
| <b>123</b> | <b>SCREW</b>                            | <b>4</b> | <b>PX505</b>    |
| <b>124</b> | <b>WASHER, locking</b>                  | <b>4</b> | <b>WL105001</b> |
| <b>125</b> | <b>NUT</b>                              | <b>4</b> | <b>HN2005</b>   |
| <b>126</b> | <b>WASHER, locating</b>                 | <b>4</b> | <b>122231</b>   |
| <b>127</b> | <b>RETAINER ASSEMBLY</b>                | <b>2</b> | <b>121792</b>   |
| <b>128</b> | <b>BLOCK, rubber</b>                    | <b>2</b> | <b>121791</b>   |
| <b>129</b> | <b>NUT, retainer assembly</b>           | <b>4</b> | <b>GHF222</b>   |
| <b>130</b> | <b>BRACKET, RH</b>                      | <b>1</b> | <b>131964</b>   |
| <b>131</b> | <b>BRACKET, LH</b>                      | <b>1</b> | <b>131963</b>   |
| <b>132</b> | <b>SCREW, bracket to bumper bracket</b> | <b>4</b> | <b>SH606071</b> |
| <b>133</b> | <b>NUT, nyloc</b>                       | <b>4</b> | <b>GHF223</b>   |
| <b>134</b> | <b>LINK ASSEMBLY</b>                    | <b>2</b> | <b>121797</b>   |
| <b>135</b> | <b>NUT, link to bracket</b>             | <b>2</b> | <b>FNZ507</b>   |
| <b>136</b> | <b>WASHER, locking</b>                  | <b>2</b> | <b>WA600071</b> |

**137** BRACKET, attachment 2 **131479**  
Not included in kit.

**The following is the alternative clamp design to 122.  
It is not supplied in kit.**

|                               |   |                 |
|-------------------------------|---|-----------------|
| <b>138</b> CLAMP bar locating | 2 | <b>122230</b>   |
| <b>139</b> BOLT               | 2 | <b>BH604141</b> |
| <b>140</b> WASHER, plain      | 4 | <b>GHF300</b>   |
| <b>141</b> WASHER, locking    | 2 | <b>GHF331</b>   |
| <b>142</b> NUT, plain         | 2 | <b>GHF200</b>   |









# TR2-4



FRONT SUSPENSION OVERHAUL KIT - RW3071POLY

## Front Suspension Kits

TR2, TR3, TR3A, TR4 to CT6343 (WIRE WHEELS)  
AND CT6389 (STEEL WHEELS)

|   |    |            |
|---|----|------------|
| <b>143 COMPLETE FRONT SUSPENSION OVERHAUL KIT;</b>                |    |            |
| with rubber bushes  | 1  | RW3071     |
| with polyurethane bushes  | 1  | RW3071POLY |
| <i>The following parts are included:</i>                          |    |            |
| <b>145 UPPER SUSPENSION OVERHAUL KIT;</b>                         |    |            |
| included in RW3071  | 2  | RW3068     |
| included in RW3071POLY  | 2  | RW3068POLY |
| <b>147 LOWER INNER SUSPENSION OVERHAUL KIT;</b>                   |    |            |
| included in RW3071  | 2  | RF4091     |
| included in RW3071POLY  | 2  | RF4091POLY |
| <b>148 COMPLETE TRUNNION OVERHAUL KIT</b>                         | 1  | RW3069     |
| <b>13 TOP BALL JOINT ASSEMBLY</b>                                 | 2  | 200772     |
| <b>46 WHEEL BEARING KIT</b>                                       | 2  | GHK1021    |
| <b>69 INSULATOR, spring seating;</b>                              |    |            |
| rubber (included in RW3071)                                       | 6  | 100751     |
| polyurethane (included in RW3071POLY)                             | 6  | 100751POLY |
| <b>108 REBOUND STOP ASSEMBLY</b>                                  | 2  | 100175     |
| <b>109 SCREW, rebound rubber and wishbone brackets to chassis</b> | 12 | GHF120     |
| <b>110 NUT, plain</b>   | 12 | GHF201     |
| <b>111 WASHER, locking</b>  | 12 | GHF332     |
| <b>113 BUMP STOP ASSEMBLY</b>                                     | 2  | 106845     |
| <b>115 BOLT, spring pan to lower wishbones</b>                    | 8  | BH606161   |
| <b>116 NUT, nyloc, spring pan to lower wishbones</b>              | 10 | TN3209     |
| <b>WASHER, plain, spring pan to lower wishbones</b>               | 12 | WP20X      |

TR4 from CT6344 (WIRE WHEELS)  
AND CT6390 (STEEL WHEELS)

|   |    |            |
|---|----|------------|
| <b>144 COMPLETE FRONT SUSPENSION OVERHAUL KIT;</b>                |    |            |
| with rubber bushes  | 1  | RW3072     |
| with polyurethane bushes  | 1  | RW3072POLY |
| <i>The following parts are included:</i>                          |    |            |
| <b>146 UPPER SUSPENSION OVERHAUL KIT;</b>                         |    |            |
| included in RW3072  | 2  | RR1260     |
| included in RW3072POLY  | 2  | RR1260POLY |
| <b>147 LOWER INNER SUSPENSION OVERHAUL KIT;</b>                   |    |            |
| included in RW3072  | 2  | RF4091     |
| included in RW3072POLY  | 2  | RF4091POLY |
| <b>149 COMPLETE TRUNNION OVERHAUL KIT</b>                         | 1  | RW3074     |
| <b>22 TOP BALL JOINT ASSEMBLY</b>                                 | 2  | GSJ131     |
| <b>46 WHEEL BEARING KIT</b>                                       | 2  | GHK1021    |
| <b>69 INSULATOR, spring seating;</b>                              |    |            |
| rubber (included in RW3072)                                       | 4  | 100751     |
| polyurethane (included in RW3072POLY)                             | 4  | 100751POLY |
| <b>108 REBOUND STOP ASSEMBLY</b>                                  | 2  | 100175     |
| <b>109 SCREW, rebound rubber and wishbone brackets to chassis</b> | 12 | GHF120     |
| <b>110 NUT, plain</b>   | 12 | GHF201     |
| <b>111 WASHER, locking</b>  | 12 | GHF332     |
| <b>113 BUMP STOP ASSEMBLY</b>                                     | 2  | 106845     |
| <b>115 BOLT, spring pan to lower wishbones</b>                    | 8  | BH606161   |
| <b>116 NUT, nyloc, spring pan to lower wishbones</b>              | 10 | TN3209     |
| <b>WASHER, plain, spring pan to lower wishbones</b>               | 12 | WP20X      |

TR2, TR3, TR3A, TR4 to CT6343 (WIRE WHEELS)  
AND CT6389 (STEEL WHEELS)

|   |   |            |
|---|---|------------|
| <b>145 UPPER SUSPENSION OVERHAUL KIT;</b>     |   |            |
| with rubber bushes                            | 2 | RW3068     |
| with polyurethane bushes                      | 2 | RW3068POLY |
| <i>The following parts are included:</i>      |   |            |
| <b>2 BUSH, upper inner wishbone;</b>          |   |            |
| rubber (included in RW3068)                   | 4 | 102228     |
| polyurethane (included in RW3068POLY)         | 2 | 102228POLY |
| <b>3 WASHER, fulcrum pin</b>                  | 2 | WM69       |
| <b>4 SPLIT PIN, fulcrum nut</b>               | 2 | PC10       |
| <b>5 NUT, slotted, fulcrum pin</b>            | 2 | LN2210     |
| <b>16 NUT, nyloc, ball joint to wishbones</b> | 1 | 252165     |

TR4 from CT6344 (WIRE WHEELS)  
AND CT6390 (STEEL WHEELS)

|   |   |            |
|---|---|------------|
| <b>146 UPPER SUSPENSION OVERHAUL KIT;</b> |   |            |
| with rubber bushes                        | 2 | RR1260     |
| with polyurethane bushes                  | 2 | RR1260POLY |
| <i>The following parts are included:</i>  |   |            |
| <b>2 BUSH, upper inner wishbone;</b>      |   |            |
| rubber (included in RR1260)               | 4 | 102228     |
| polyurethane (included in RR1260POLY)     | 2 | 102228POLY |
| <b>3 WASHER, fulcrum pin</b>              | 2 | WM69       |
| <b>4 SPLIT PIN, fulcrum nut</b>           | 2 | PC10       |
| <b>5 NUT, slotted, fulcrum pin</b>        | 2 | LN2210     |
| <b>26 BOLT, ball joint to wishbone</b>    | 2 | 112347     |
| <b>27 NUT, nyloc, ball joint bolt</b>     | 2 | GHF223     |
| <b>28 WASHER, plain</b>                   | 2 | WB110061   |



LOWER INNER SUSPENSION OVERHAUL KIT - RF4091

TR2, TR3, TR3A, TR4

|   |   |            |
|---|---|------------|
| <b>147 LOWER INNER SUSPENSION OVERHAUL KIT;</b>     |   |            |
| with nylon and steel bushes                         | 2 | RF4091     |
| with polyurethane bushes                            | 2 | RF4091POLY |
| <i>The following parts are included:</i>            |   |            |
| <b>99 WASHER, nylon (included in RF4091)</b>        | 4 | 110697     |
| <b>100 SEAL (included in RF4091)</b>                | 4 | 115702     |
| <b>101 BUSH, nylon (included in RF4091)</b>         | 2 | 110696     |
| <b>102 BUSH, lower inner wishbone;</b>              |   |            |
| steel (included in RF4091)                          | 2 | 110695     |
| polyurethane (included in RF4091POLY)               | 2 | 102228POLY |
| <b>103 NYLOC NUT, lower wishbone to chassis pin</b> | 2 | GHF274     |

TR2, TR3, TR3A and TR4 to CT6343 (WIRE WHEELS)  
AND CT6389 (STEEL WHEELS)

|   |   |        |
|---|---|--------|
| <b>148 COMPLETE TRUNNION OVERHAUL KIT</b> | 1 | RW3069 |
| <i>The following parts are included:</i>  |   |        |
| <b>81 BOTTOM TRUNNION ASSEMBLY</b>        | 2 | 101557 |
| <b>83 GREASE NIPPLE</b>                   | 2 | 56934  |
| <b>84 SCREW, lock stop to trunnion</b>    | 2 | GHF120 |
| <b>150 TRUNNION BUSH KIT</b>              | 2 | RF4090 |

TR4 from CT6344 (WIRE WHEELS)  
AND CT6390 (STEEL WHEELS)

|   |   |        |
|---|---|--------|
| <b>149 COMPLETE TRUNNION OVERHAUL KIT</b> | 1 | RW3074 |
| <i>The following parts are included:</i>  |   |        |
| <b>81 BOTTOM TRUNNION ASSEMBLY;</b>       |   |        |
| RH  | 1 | 133838 |
| LH  | 1 | 133839 |
| <b>83 GREASE NIPPLE</b>                   | 2 | 56934  |
| <b>84 SCREW, lock stop to trunnion</b>    | 2 | GHF120 |
| <b>150 TRUNNION BUSH KIT</b>              | 2 | RF4090 |



TRUNNION BUSH KIT - RF4090

TR2, TR3, TR3A, TR4

|   |   |        |
|---|---|--------|
| <b>150 TRUNNION BUSH KIT</b>              | 2 | RF4090 |
| <i>The following parts are included:</i>  |   |        |
| <b>82 SEAL, trunnion to vertical link</b> | 1 | 142402 |
| <b>89 BUSH, wishbone arm</b>              | 2 | 101615 |
| <b>91 THRUST WASHER</b>                   | 4 | 101533 |
| <b>92 SEAL, wishbone, outer side,</b>     | 4 | 115702 |
| <b>93 SEAL, wishbone, trunnion side</b>   | 2 | 134319 |
| <b>96 NUT, nyloc</b>                      | 2 | GHF274 |

## Suspension Bush Kits

Standard bush kits are a direct replacement for the original bushes. Polyurethane gives improved suspension location with greater wear resistance compared to their rubber equivalents. This makes these bushes ideally suited to road cars. A worthwhile addition to any car, the polyurethane bushes are supplied with a steel sleeve where necessary. They are available individually or as kits.

FRONT SUSPENSION BUSH KIT;

|              |   |            |
|--------------|---|------------|
| standard     | 1 | RW3208     |
| polyurethane | 1 | RW3208POLY |

Bushes included:

8 Upper Wishbone (4 supplied in polyurethane\*)

4 Lower Inner Wishbone

\*Please see note under item 29 on page 127.

4 Front Damper Upper, 2 Front Damper Lower & 6 Front Spring Seat.

REAR SUSPENSION BUSH KIT;

|              |   |            |
|--------------|---|------------|
| standard     | 1 | RW3207     |
| polyurethane | 1 | RW3207POLY |

Bushes included: 8 Rear Spring Shackle & 2 Rear Axle Buffer.

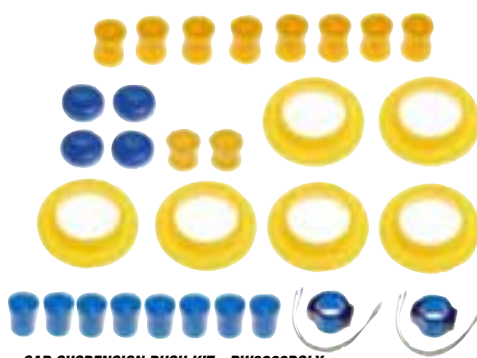
CAR SET SUSPENSION BUSH KIT;

|              |   |            |
|--------------|---|------------|
| standard     | 1 | RW3209     |
| polyurethane | 1 | RW3209POLY |

Includes front and rear bush kits as listed above.

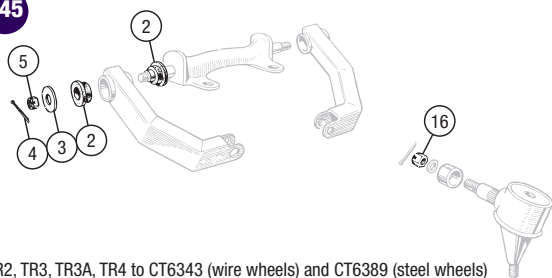


CAR SUSPENSION BUSH KIT - RW3209

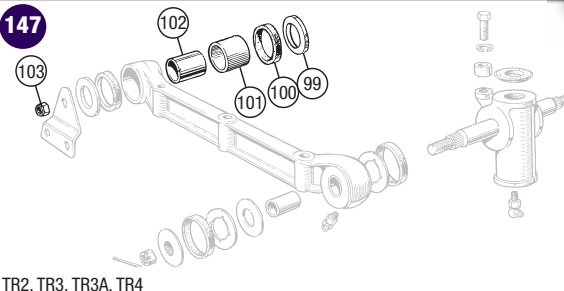


CAR SUSPENSION BUSH KIT - RW3209POLY

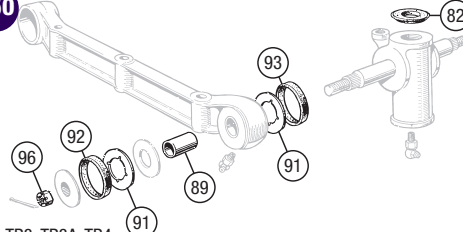


**143**
**145**


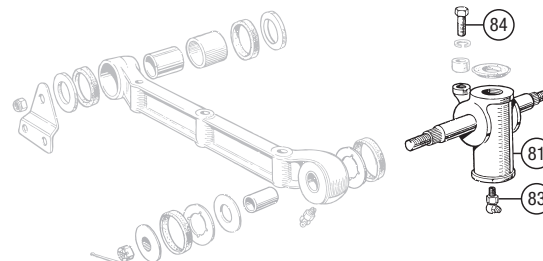
TR2, TR3, TR3A, TR4 to CT6343 (wire wheels) and CT6389 (steel wheels)  
UPPER SUSPENSION OVERHAUL KIT - 2 Required

**147**


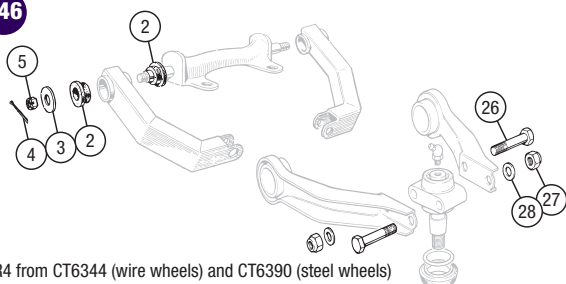
TR2, TR3, TR3A, TR4  
LOWER INNER SUSPENSION OVERHAUL KIT - 2 Required

**148**
**150**


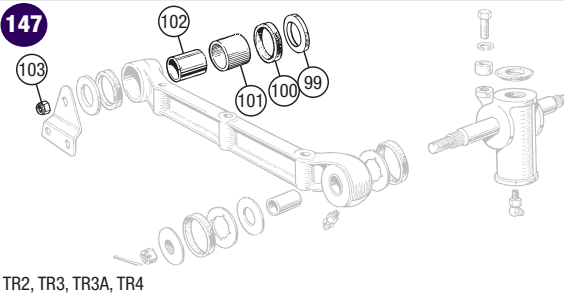
TR2, TR3, TR3A, TR4  
TRUNNION BUSH KIT - 2 Required



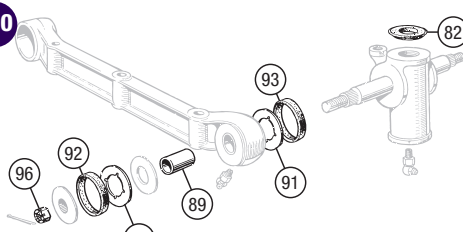
TR2, TR3, TR3A and TR4 to CT6343 (wire wheels) and CT6389 (steel wheels)  
COMPLETE TRUNNION OVERHAUL KIT - 1 Required

**144**
**146**


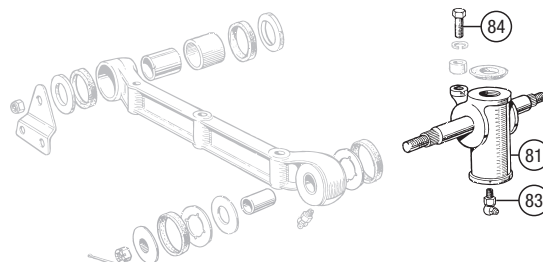
TR4 from CT6344 (wire wheels) and CT6390 (steel wheels)  
UPPER SUSPENSION OVERHAUL KIT - 2 Required

**147**


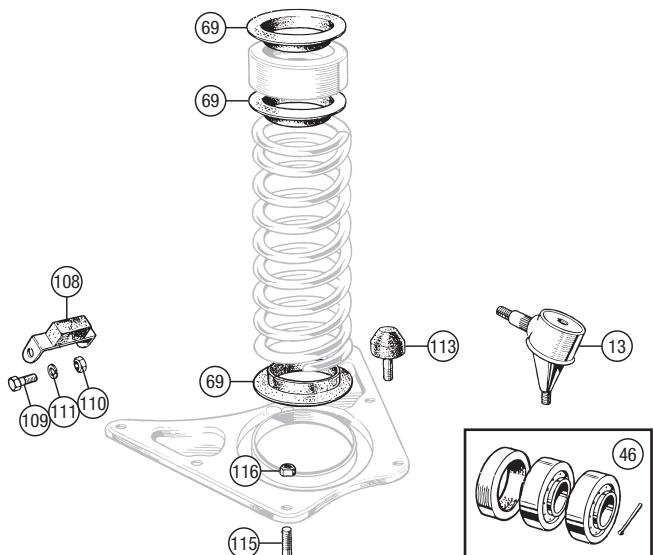
TR2, TR3, TR3A, TR4  
LOWER INNER SUSPENSION OVERHAUL KIT - 2 Required

**149**
**150**


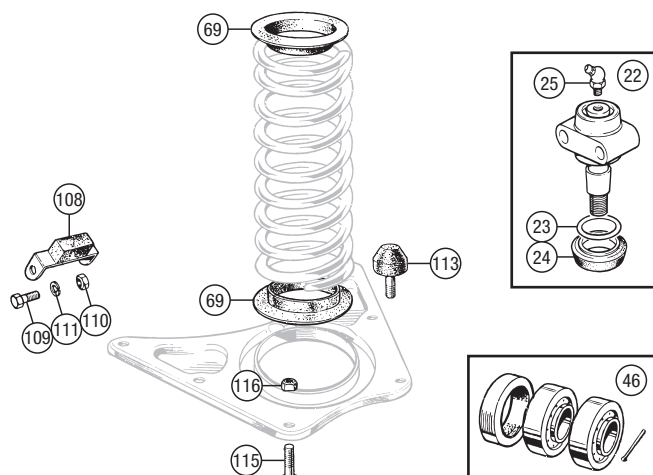
TR2, TR3, TR3A, TR4  
TRUNNION BUSH KIT - 2 Required



TR4 from CT6344 (wire wheels) and CT6390 (steel wheels)  
COMPLETE TRUNNION OVERHAUL KIT - 1 Required



TR2, TR3, TR3A, TR4 to CT6343 (wire wheels) and CT6389 (steel wheels)  
COMPLETE FRONT SUSPENSION OVERHAUL KIT RH & LH - 1 Required



TR4 from CT6344 (wire wheels) and CT6390 (steel wheels)  
COMPLETE FRONT SUSPENSION OVERHAUL KIT RH & LH - 1 Required



## TR4A-5-250

It is a fair bet that if there is any knocking noise from the front suspension or tendency for your car to wander at speed it will be traceable to worn front suspension components. The suspension is not delicate; it is just fitted with bushes that wear rapidly when they become impregnated with dirt.

We offer a full range of individual components and comprehensive kits to overhaul your front suspension. The kits are convenient to order and they save you money!

## Fulcrum Pin &amp; Ball Joint

|    |  |        |                      |
|----|--|--------|----------------------|
| 1  | FULCRUM PIN, upper   | 2      | 200659               |
| 2  | SCREW, fulcrum pin   | 8      | GHF105               |
| 3  | WASHER, locking  | 8      | GHF333               |
| 4  | ARM, wishbone upper front  | 2      | 133504               |
| 5  | ARM, wishbone upper rear   | 2      | 133507               |
| 6  | BUSH, upper inner wishbone; rubber polyurethane<br><i>Each replaces 2 original bushes.</i> | 8<br>4 | 102228<br>102228POLY |
| 7  | WASHER, fulcrum pin  | 4      | WM69                 |
| 8  | NUT, slotted, fulcrum pin  | 4      | LN2210               |
| 9  | SPLIT PIN, fulcrum nut   | 4      | PC10                 |
| 10 | NUT, nyloc <i>(Alternative)</i>  | 4      | TN3210               |
| 11 | BALL JOINT, top<br><i>Incl. gaiter, clip, washer &amp; nut.</i>                            | 2      | GSJ131               |
| 12 | GAITER, ball joint   | 2      | 138509               |
| 13 | CLIP, ball joint gaiter  | 2      | 138869               |
| 14 | WASHER, plain  | 2      | WC112081             |
| 15 | NUT, slotted, ball joint to vertical link  | 2      | LN2211               |
| 16 | SPLIT PIN, ball joint nut  | 2      | PC10                 |
| 17 | NUT, nyloc <i>(Alternative)</i>  | 2      | GHF225               |
| 18 | GREASE NIPPLE <i>(As fitted)</i>   | 2      | 234532               |
| 19 | BOLT, ball joint to wishbone   | 4      | 112347               |
| 20 | WASHER, plain  | 4      | WB110061             |
| 21 | NUT, nyloc, ball joint bolt  | 4      | GHF223               |

## Vertical Link &amp; Tie Rod Lever

|    |   |   |          |
|----|---|---|----------|
| 22 | VERTICAL LINK;<br>LH  | 1 | 307216   |
|    | RH  | 1 | 307215   |
| 23 | GREASE NIPPLE, vertical post                                    | 2 | 56934    |
| 24 | TIE ROD LEVER, steering;<br>LH                                  | 1 | 307212   |
|    | RH  | 1 | 307211   |
| 25 | PLATE, mounting brake caliper;<br>LH                            | 1 | 133500   |
|    | RH  | 1 | 133499   |
| 26 | BOLT, mounting plate, lower rear                                | 2 | 118324   |
| 27 | BOLT, mounting plate, lower front                               | 2 | 113144   |
|    | SCREW, mounting plate, lower front<br><i>Alternative.</i>       | 2 | SH606065 |
| 28 | BOLT, plate & tie rod lever, upper rear                         | 2 | GHF126   |
| 29 | BOLT, plate & tie rod lever, upper front                        | 2 | 112032   |
| 30 | WASHER, tab, locking bolt heads                                 | 4 | 106641   |
| 31 | DISTANCE PIECE, mounting plate & tie rod lever to vertical link | 4 | 107106   |
| 32 | NUT, nyloc  | 4 | GHF223   |
| 33 | NUT, nyloc, brake shield attachment                             | 2 | TN3209   |
| 34 | WASHER, plain, nut to disc shield                               | 2 | WB110061 |

## Front Hubs

|    |   |   |         |
|----|---|---|---------|
| 35 | STUB AXLE                                       | 2 | 115763  |
| 36 | WHEEL BEARING KIT<br><i>2 required per car.</i> | 2 | GHK1021 |
| 37 | SEAL ASSEMBLY, felt in steel retainer           | 2 | GHS110  |
| 38 | BEARING, inner                                  | 2 | GHB111  |
| 39 | BEARING, outer                                  | 2 | GHB110  |
| 40 | SPLIT PIN                                       | 2 | PC20    |

## STEEL WHEEL FITTED CARS

|    |  |   |         |
|----|--|---|---------|
| 41 | HUB, steel wheel (includes studs)                    | 2 | 114284  |
| 42 | STUD, steel wheel                                    | 8 | 114282  |
| 43 | WHEEL NUT, steel wheels                              | 8 | 109586  |
| 44 | WHEEL NUT SET, steel wheels<br><i>Car set of 16.</i> | 8 | 109586K |

| No.                           | DESCRIPTION                          | QTY REQ. | PART No. |
|-------------------------------|--------------------------------------|----------|----------|
| <b>WIRE WHEEL FITTED CARS</b> |                                      |          |          |
| 45                            | HUB, wire wheel (includes studs)     | 2        | 114283   |
| 46                            | STUD, hub to wire wheel adaptor      | 8        | 114281   |
| 47                            | NUT, special, extension to hub       | 8        | RSRN716  |
| 48                            | SPLINED EXTENSION, wire wheel;<br>LH | 1        | 217603   |
|                               | RH                                   | 1        | 217602   |

|    |                              |   |          |
|----|------------------------------|---|----------|
| 49 | WASHER, 'D' special          | 2 | 102690   |
| 50 | NUT, slotted, hub attachment | 2 | LN2211   |
| 51 | CAP, grease retaining        | 2 | 102689   |
| 52 | NUT, stub axle retaining     | 2 | GHF275   |
| 53 | WASHER, stub axle            | 2 | WC112081 |

## Coil Springs &amp; Shock Absorbers

|    |   |   |            |
|----|---|---|------------|
| 54 | FRONT COIL SPRING;<br>original  | 2 | 213165     |
|    | uprated (420lb/1" lowered)  | 2 | 213165UR   |
| -  | COIL SPRING COMPRESSOR TOOL<br><i>Not shown.</i>  | 1 | GAC5076    |
| 55 | INSULATOR;<br>rubber  | 4 | 100751     |
|    | polyurethane  | 4 | 100751POLY |
| 56 | SHOCK ABSORBER<br><i>Includes mounting rubbers (standard), washer &amp; nuts.</i>                             | 2 | GSA272     |
| 57 | SHOCK ABSORBER SET,<br>SPAX adjustable<br><i>Includes 1 pair of shock absorbers &amp; standard mountings.</i> | 1 | GSA272SPAX |
| 58 | SHOCK ABSORBER SET,<br>KONI adjustable<br><i>Includes 1 pair of shock absorbers &amp; standard mountings.</i> | 1 | GSA272KONI |
| 59 | SHOCK ABSORBER SET,<br>GAZ adjustable<br><i>Includes 1 pair of shock absorbers &amp; standard mountings.</i>  | 1 | GSA272GAZ  |
| 60 | BUSH, upper;<br><i>Included with shock absorber.</i><br>rubber  | 4 | 152588     |
|    | polyurethane <i>(Alternative)</i>   | 4 | 152588POLY |
| 61 | WASHER, plain, upper  | 2 | 140479     |
| 62 | WASHER, plain, lower  | 2 | 140416     |
| 63 | NUT, plain  | 2 | GHF202     |
| 64 | NUT, half   | 2 | NT606041   |
| 65 | NUT, nyloc <i>(Alternative)</i>   | 2 | GHF223     |
| 66 | BUSH, lower;<br>rubber  | 2 | 119450     |
|    | polyurethane <i>(Alternative)</i>   | 2 | 119450POLY |
| 67 | BRACKET, shock absorber, lower  | 4 | 106843     |
| 68 | BOLT, shock absorber to bracket   | 2 | BH607201   |
| 69 | NUT, nyloc, shock absorber to bracket   | 2 | GHF274     |
| 70 | WASHER, plain   | 8 | GHF333     |
| 71 | NUT, bracket to spring pan  | 8 | GHF202     |

## Trunnions &amp; Lower Wishbones

|  |   |   |          |
|--|---|---|----------|
| 72   | BOTTOM TRUNNION ASSEMBLY;<br>LH         | 1 | 142378   |
|  | RH                                      | 1 | 142377   |
| <i>When the trunnion is installed on the vertical link it should be lubricated with hypoid gear oil (EP90) not grease. The trunnion and vertical link assembly should be lubricated regularly to preserve long service life.</i> |   |   |          |
| 73   | SEAL, trunnion to vertical link         | 2 | 142402   |
| 74   | SCREW, lock stop attaching              | 2 | SH605121 |
| 75   | WASHER, locking                         | 2 | GHF332   |
| 76   | STOP, steering lock                     | 2 | 156111   |
| 77   | WISHBONE, lower, LH front & RH rear     | 2 | 307209   |
| 78   | WISHBONE, lower, RH front & LH rear     | 2 | 307210   |
| 79   | BOLT, pivot, trunnion to lower wishbone | 2 | 139835   |
| 80   | DISTANCE PIECE                          | 4 | 139832   |



SHOCK ABSORBER - GSA272

|    |   |          |                      |
|----|---|----------|----------------------|
| 81 | BEARING, nylon, top hat shaped  | 8        | 139833               |
| 82 | WASHER, plain steel, thrust   | 8        | 142388               |
| 83 | RING, rubber, sealing   | 8        | 142387               |
| 84 | SHIELD, water   | 8        | 139834               |
| 85 | NUT, slotted  | 2        | LN2212               |
| 86 | SPLIT PIN   | 2        | PC15                 |
| 87 | BOLT, wishbone to bracket   | 4        | HB1121               |
| 88 | BUSH, inner wishbone;<br>rubber   | 4        | 141481               |
|    | polyurethane <i>(Alternative)</i>   | 4        | 141481POLY           |
| 89 | NUT, nyloc  | 4        | GHF225               |
| 90 | BRACKET, lower fulcrum  | 4        | 148691               |
| 91 | SHIM, adjusting, bracket to chassis   | A/R      | 139727               |
| 92 | WASHER, plain   | 8        | WM59                 |
| 93 | NUT, nyloc  | 8        | GHF223               |
| 94 | LOWER SPRING PAN ASSEMBLY   | 2        | 140951               |
| 95 | BOLT;<br>spring pan to wishbone<br><i>Qty. decreases when anti-roll bar is fitted.</i><br>spring pan and roll bar bracket to wishbone<br><i>When anti-roll bar is fitted.</i> | 8/6<br>2 | BH606161<br>BH606221 |
| 96 | STUD, spring pan to wishbone  | 4        | 143712               |
| 97 | NUT, nyloc  | 12       | GHF223               |
| 98 | WASHER, plain   | 12       | WP20X                |

## Lower Wishbone Arm Strengthening Brackets

The lower front inner wishbone brackets which are welded to the chassis, are considered weak points of the front suspension as they are often found to be cracked or even broken away from the chassis. This is usually caused by running into pot holes or hitting kerbs. These brackets are easily replaced by a competent chassis repair workshop, and represent a considerable improvement to the earlier TR2, TR3, TR3A and TR4 design. It's a good idea to periodically check these brackets, and have them replaced or reinforced if they are cracked or broken, as this condition presents a severe safety hazard.

We have followed a design from Triumph themselves and produced a strengthening kit which comprises three plates that are welded to the inner wishbone bracket and the chassis.

|     |   |   |             |
|-----|---|---|-------------|
| 99  | REINFORCEMENT PLATE SET,<br>for lower wishbone brackets;<br>RH        | 1 | RR1422RH    |
|     | LH  | 1 | RR1422LH    |
| 100 | PLATE WASHER, reinforcement<br><i>Aftermarket or competition use.</i> | 4 | 139580PLATE |



REINFORCEMENT PLATE SET - RR1422RH

## Anti-Roll Bar

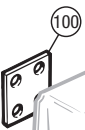
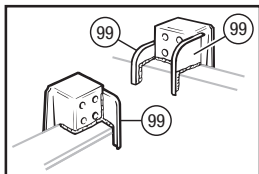
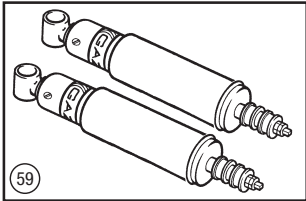
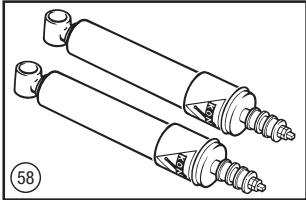
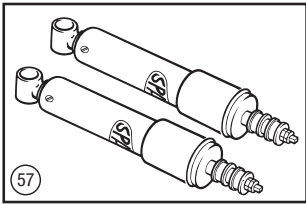
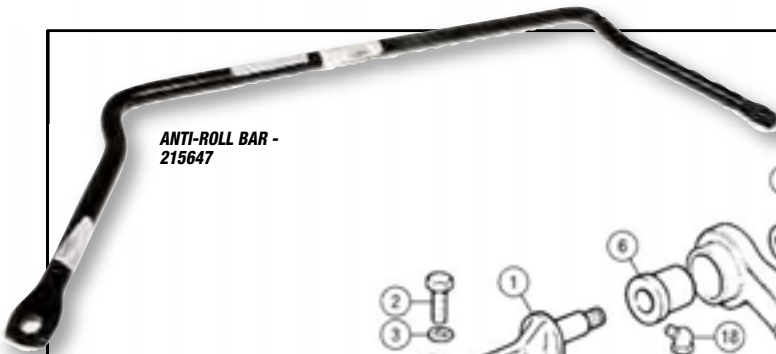
## TR4A, TR5, TR250 OPTIONAL FITMENT

If you intend to fit an anti-roll bar for the first time to your TR4A, TR5 or TR250, please see 'Suspension & Steering Improvements' for information concerning mounting points on your car and also for uprated anti-roll bars.

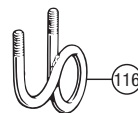
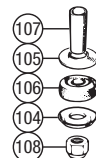
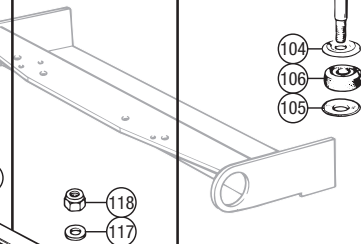
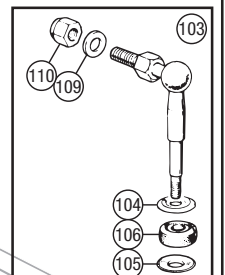
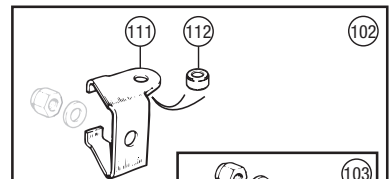
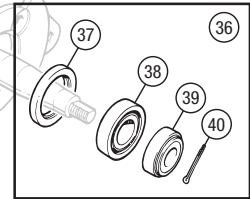
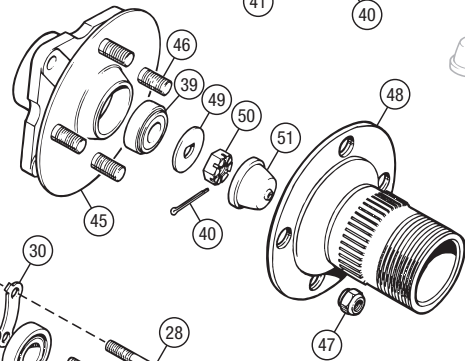
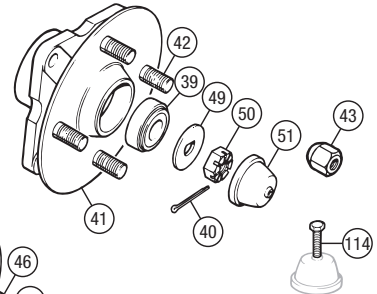
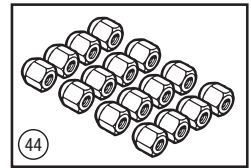
|     |  |        |                        |
|-----|--|--------|------------------------|
| 101 | ANTI-ROLL BAR  | 1      | 215647                 |
| 102 | FITTING KIT, anti-roll bar<br><i>Includes 103-115, 117, 118.</i>   | 1      | 215647FK               |
| 103 | LINK ASS'Y, anti-roll bar to wishbones   | 2      | 152143A                |
| 104 | WASHER   | 4      | 517983                 |
| 105 | WASHER   | 4      | 517984                 |
| 106 | MOUNTING BUSH;<br>rubber <i>(Included in item 102)</i><br>polyurethane <i>(Alternative)</i>                | 4<br>4 | 517985<br>517985POLY   |
| 107 | TUBE, distance   | 2      | 517986                 |
| 108 | NUT, nyloc   | 2      | GHF223                 |
| 109 | WASHER, plain  | 4      | WA600071               |
| 110 | NUT, nyloc   | 2      | GHF224                 |
| 111 | BRACKET, mounting, link to wishbone  | 2      | 152144                 |
| 112 | PACKING PIECE, bracket to wishbone   | 2      | 152145                 |
| 113 | BUSH, locating anti-roll bar;<br>rubber <i>(Included in item 102)</i><br>polyurethane <i>(Alternative)</i> | 2<br>2 | 123998<br>123998POLYTR |
| 114 | BRACKET, clamp, securing anti-roll bar   | 2      | 123502                 |
| 115 | 'U' BOLT, plain, anti-roll bar bracket   | 2      | 123694                 |
| 116 | 'U' BOLT, with towing eyes <i>(Alternative)</i>  | 2      | 139126                 |
| 117 | WASHER, plain  | 4      | GHF301                 |
| 118 | NUT, nyloc   | 4      | GHF222                 |



ANTI-ROLL BAR -  
215647



BOTTOM TRUNNION ASSEMBLY -  
142378





## TR4A-5-250

## Front Suspension Kits

Quantities listed for kits are per vehicle, quantities listed for components are per kit.

| No.                                      | DESCRIPTION   | QTY REQ. | PART No.     |
|--|---|----------|--------------|
| <b>119</b>                               | <b>COMPLETE SUSPENSION OVERHAUL KIT;</b>                        |          |              |
|  | with rubber bushes  | 1        | RR1259       |
|  | with polyurethane bushes  | 1        | RR1259POLY   |
| <i>The following parts are included:</i> |   |          |              |
| <b>6</b>                                 | BUSH, upper inner wishbone;                                     |          |              |
|  | rubber (Included in RR1259)                                     | 8        | 102228       |
|  | polyurethane (Included in RR1259POLY)                           | 4        | 102228POLY   |
| <b>7</b>                                 | WASHER, fulcrum pin   | 4        | WM69         |
| <b>8</b>                                 | NUT, slotted, fulcrum pin                                       | 4        | LN2210       |
| <b>9</b>                                 | SPLIT PIN, fulcrum nut  | 4        | PC10         |
| <b>11</b>                                | BALL JOINT, top   | 2        | GSJ131       |
| <b>19</b>                                | BOLT, ball joint to wishbone                                    | 4        | 112347       |
| <b>20</b>                                | WASHER, plain   | 4        | WB110061     |
| <b>21</b>                                | NUT, nyloc, ball joint bolt                                     | 4        | GHF223       |
| <b>27</b>                                | SCREW, mounting plate, lower front                              | 2        | SH606065     |
| <b>29</b>                                | BOLT, plate & tie rod lever, upper front                        | 2        | 112032       |
| <b>31</b>                                | DISTANCE PIECE, mounting plate & tie rod lever to vertical link | 4        | 107106       |
| <b>32</b>                                | NUT, nyloc  | 4        | GHF223       |
| <b>37</b>                                | SEAL ASSEMBLY, felt in steel retainer                           | 2        | GHS110       |
| <b>38</b>                                | BEARING, inner  | 2        | GHB111       |
| <b>39</b>                                | BEARING, outer  | 2        | GHB110       |
| <b>40</b>                                | SPLIT PIN   | 2        | PC20         |
| <b>52</b>                                | NUT, stub axle retaining  | 2        | GHF275       |
| <b>53</b>                                | WASHER, stub axle   | 2        | WC112081     |
| <b>55</b>                                | INSULATOR;  |          |              |
|  | rubber (Included in RR1259)                                     | 4        | 100751       |
|  | polyurethane (Included in RR1259POLY)                           | 4        | 100751POLY   |
| <b>66</b>                                | BUSH, lower;  |          |              |
|  | rubber (Included in RR1259)                                     | 2        | 119450       |
|  | polyurethane (Included in RR1259POLY)                           | 2        | 119450POLY   |
| <b>68</b>                                | BOLT, shock absorber to bracket                                 | 2        | BH607201     |
| <b>69</b>                                | NUT, nyloc, shock absorber to bracket                           | 2        | GHF274       |
| <b>70</b>                                | WASHER, plain   | 8        | GHF333       |
| <b>71</b>                                | NUT, bracket to spring pan                                      | 8        | GHF202       |
| <b>72</b>                                | BOTTOM TRUNNION ASSEMBLY;                                       |          |              |
|  | LH  | 1        | 142378       |
|  | RH  | 1        | 142377       |
| <b>73</b>                                | SEAL, trunnion to vertical link                                 | 2        | 142402       |
| <b>74</b>                                | SCREW, lock stop attaching                                      | 2        | SH605121     |
| <b>79</b>                                | BOLT, pivot, trunnion to wishbone                               | 2        | 139835       |
| <b>80</b>                                | DISTANCE PIECE  | 4        | 139832       |
| <b>81</b>                                | BEARING, nylon, top hat shaped                                  | 8        | 139833       |
| <b>82</b>                                | WASHER, plain steel, thrust                                     | 8        | 142388       |
| <b>83</b>                                | RING, rubber, sealing   | 8        | 142387       |
| <b>84</b>                                | SHIELD, water   | 8        | 139834       |
| <b>85</b>                                | NUT, slotted  | 2        | LN2212       |
| <b>86</b>                                | SPLIT PIN   | 2        | PC15         |
| <b>87</b>                                | BOLT, wishbone to bracket                                       | 4        | HB1121       |
| <b>88</b>                                | BUSH, inner wishbone;   |          |              |
|  | rubber (Included in RR1259)                                     | 4        | 141481       |
|  | polyurethane (Included in RR1259POLY)                           | 4        | 141481POLY   |
| <b>89</b>                                | NUT, nyloc  | 4        | GHF225       |
| <b>95</b>                                | BOLT;   |          |              |
|  | spring pan to wishbone  | 6        | BH606161     |
|  | spring pan and roll bar bracket to wishbone                     | 2        | BH606221     |
| <b>96</b>                                | STUD, spring pan to wishbone                                    | 4        | 143712       |
| <b>103</b>                               | LINK ASSEMBLY,  |          |              |
|  | anti-roll bar to wishbones                                      | 2        | 152143A      |
| <b>113</b>                               | BUSH, anti-roll bar;  |          |              |
|  | rubber (Included in RR1259)                                     | 2        | 123998       |
|  | polyurethane (Included in RR1259POLY)                           | 2        | 123998POLYTR |
| <b>114</b>                               | CLAMP, securing anti-roll bar                                   | 2        | 123502       |
| <b>115</b>                               | 'U' BOLT, plain, anti-roll bar bracket                          | 2        | 123694       |
| <b>117</b>                               | WASHER, plain   | 4        | GHF301       |
| <b>118</b>                               | NUT, nyloc  | 4        | GHF222       |



| No.                                      | DESCRIPTION                           | QTY REQ. | PART No.   |
|--|---------------------------------------|----------|------------|
| <b>120</b>                               | <b>UPPER SUSPENSION OVERHAUL KIT;</b> |          |            |
|  | with rubber bushes                    | 2        | RR1260     |
|  | with polyurethane bushes              | 2        | RR1260POLY |
| <i>The following parts are included:</i> |                                       |          |            |
| <b>6</b>                                 | BUSH, upper inner wishbone;           |          |            |
|  | rubber (Included in RR1260)           | 4        | 102228     |
|  | polyurethane (Included in RR1260POLY) | 2        | 102228POLY |
| <b>7</b>                                 | WASHER, fulcrum pin                   | 2        | WM69       |
| <b>8</b>                                 | NUT, slotted, fulcrum pin             | 2        | LN2210     |
| <b>9</b>                                 | SPLIT PIN, fulcrum nut                | 2        | PC10       |
| <b>19</b>                                | BOLT, ball joint to wishbone          | 2        | 112347     |
| <b>20</b>                                | WASHER, plain                         | 2        | WB110061   |
| <b>21</b>                                | NUT, nyloc, ball joint bolt           | 2        | GHF223     |

|  |   |   |            |
|--|---|---|------------|
| <b>121</b>                               | <b>LOWER INNER SUSPENSION OVERHAUL KIT;</b> |   |            |
|  | with rubber bushes                          | 2 | RR1261     |
|  | with polyurethane bushes                    | 2 | RR1261POLY |
| <i>The following parts are included:</i> |   |   |            |
| <b>66</b>                                | BUSH, lower;                                |   |            |
|  | rubber (Included in RR1261)                 | 1 | 119450     |
|  | polyurethane (Included in RR1261POLY)       | 1 | 119450POLY |
| <b>68</b>                                | BOLT, shock absorber to bracket             | 1 | BH607201   |
| <b>69</b>                                | NUT, nyloc, shock absorber to bracket       | 1 | GHF274     |
| <b>87</b>                                | BOLT, wishbone to bracket                   | 2 | HB1121     |
| <b>88</b>                                | BUSH, inner wishbone;                       |   |            |
|  | rubber (Included in RR1260)                 | 2 | 141481     |
|  | polyurethane (Included in RR1260POLY)       | 2 | 141481POLY |
| <b>89</b>                                | NUT, nyloc                                  | 2 | GHF225     |

|  |  |   |              |
|--|--|---|--------------|
| <b>122</b>                               | <b>FRONT ANTI-ROLL BAR OVERHAUL KIT;</b> |   |              |
|  | with rubber bushes                       | 1 | RR1262       |
|  | with polyurethane bushes                 | 1 | RR1262POLY   |
| <i>The following parts are included:</i> |  |   |              |
| <b>103</b>                               | LINK ASSEMBLY,                           |   |              |
|  | anti-roll bar to wishbones               | 2 | 152143A      |
| <b>113</b>                               | BUSH, locating anti-roll bar;            |   |              |
|  | rubber (Included in RR1262)              | 2 | 123998       |
|  | polyurethane (Included in RR1262POLY)    | 2 | 123998POLYTR |
| <b>114</b>                               | CLAMP, securing anti-roll bar            | 2 | 123502       |
| <b>115</b>                               | 'U' BOLT, plain, anti-roll bar bracket   | 2 | 123694       |
| <b>117</b>                               | WASHER, plain                            | 4 | GHF301       |
| <b>118</b>                               | NUT, nyloc                               | 4 | GHF222       |

|  |                                       |   |          |
|--|---------------------------------------|---|----------|
| <b>123</b>                               | <b>COMPLETE TRUNNION OVERHAUL KIT</b> | 1 | RR1263   |
| <i>The following parts are included:</i> |                                       |   |          |
| <b>72</b>                                | BOTTOM TRUNNION ASSEMBLY;             |   |          |
|  | LH                                    | 1 | 142378   |
|  | RH                                    | 1 | 142377   |
| <b>73</b>                                | SEAL, trunnion to vertical link       | 2 | 142402   |
| <b>74</b>                                | SCREW, lock stop attaching            | 2 | SH605121 |
| <b>79</b>                                | BOLT, pivot, trunnion to wishbone     | 2 | 139835   |
| <b>80</b>                                | DISTANCE PIECE                        | 4 | 139832   |
| <b>81</b>                                | BEARING, nylon, top hat shaped        | 8 | 139833   |
| <b>82</b>                                | WASHER, plain steel, thrust           | 4 | 142388   |
| <b>83</b>                                | RING, rubber, sealing                 | 8 | 142387   |
| <b>84</b>                                | SHIELD, water                         | 8 | 139834   |
| <b>85</b>                                | NUT, slotted                          | 2 | LN2212   |
| <b>86</b>                                | SPLIT PIN                             | 2 | PC15     |

|  |                                |   |        |
|--|--------------------------------|---|--------|
| <b>124</b>                               | <b>TRUNNION BUSH KIT</b>       | 2 | RR1094 |
| <i>The following parts are included:</i> |                                |   |        |
| <b>80</b>                                | DISTANCE PIECE                 | 2 | 139832 |
| <b>81</b>                                | BEARING, nylon, top hat shaped | 4 | 139833 |
| <b>83</b>                                | RING, rubber, sealing          | 4 | 142387 |
| <b>84</b>                                | SHIELD, water                  | 4 | 139834 |



|  |                                   |   |          |
|--|-----------------------------------|---|----------|
| <b>125</b>                               | <b>TRUNNION OVERHAUL KIT, RH</b>  | 1 | RR1264   |
| <i>The following parts are included:</i> |                                   |   |          |
| <b>72</b>                                | BOTTOM TRUNNION ASS'Y, RH         | 1 | 142377   |
| <b>73</b>                                | SEAL, trunnion to vertical link   | 1 | 142402   |
| <b>74</b>                                | SCREW, lock stop attaching        | 1 | SH605121 |
| <b>79</b>                                | BOLT, pivot, trunnion to wishbone | 1 | 139835   |
| <b>82</b>                                | WASHER, plain steel, thrust       | 2 | 142388   |
| <b>85</b>                                | NUT, slotted                      | 1 | LN2212   |
| <b>86</b>                                | SPLIT PIN                         | 1 | PC15     |

|  |                                   |   |          |
|--|-----------------------------------|---|----------|
| <b>125</b>                               | <b>TRUNNION OVERHAUL KIT, LH</b>  | 1 | RR1265   |
| <i>The following parts are included:</i> |                                   |   |          |
| <b>72</b>                                | BOTTOM TRUNNION ASS'Y, LH         | 1 | 142378   |
| <b>73</b>                                | SEAL, trunnion to vertical link   | 1 | 142402   |
| <b>74</b>                                | SCREW, lock stop attaching        | 1 | SH605121 |
| <b>79</b>                                | BOLT, pivot, trunnion to wishbone | 1 | 139835   |
| <b>82</b>                                | WASHER, plain steel, thrust       | 2 | 142388   |
| <b>85</b>                                | NUT, slotted                      | 1 | LN2212   |
| <b>86</b>                                | SPLIT PIN                         | 1 | PC15     |

## Suspension Bush Kits - Front &amp; Rear

|                            |            |
|----------------------------|------------|
| FRONT SUSPENSION BUSH KIT; |            |
| standard material          | RR1418     |
| polyurethane material      | RR1418POLY |

|  |   |
|--|---|
| <i>Includes:</i>                                   |   |
| Upper Wishbone Bush                                | 8 |
| 4 supplied in polyurethane (1 replaces 2 original) |   |
| Lower Inner Wishbone Bush                          | 4 |
| Anti Roll Bar Mounting Bush                        | 2 |
| For standard bar:                                  |   |
| Anti Roll Bar End Link Bush                        | 4 |
| Front Damper Upper Bush                            | 4 |
| Front Damper Lower Bush                            | 2 |
| Steering Rack Mounting Bush                        | 2 |

|                          |            |
|--------------------------|------------|
| REAR SUSPENSION BUSH KIT |            |
| standard material        | RR1419     |
| polyurethane material    | RR1419POLY |

|  |   |
|--|---|
| <i>Includes:</i>                       |   |
| Trailing Arm Bush                      | 4 |
| Rear Axle Front mounting Cone/Cup Bush | 4 |
| Rear Damper (Lever) Link Bush          | 4 |

|   |            |
|---|------------|
| CAR SET SUSPENSION BUSH KIT;  |            |
| standard material   | RR1420     |
| polyurethane material   | RR1420POLY |
| <i>Includes front and rear bush kits as listed above (see photo).</i> |            |



## Suspension Bolt Kits - Front &amp; Rear

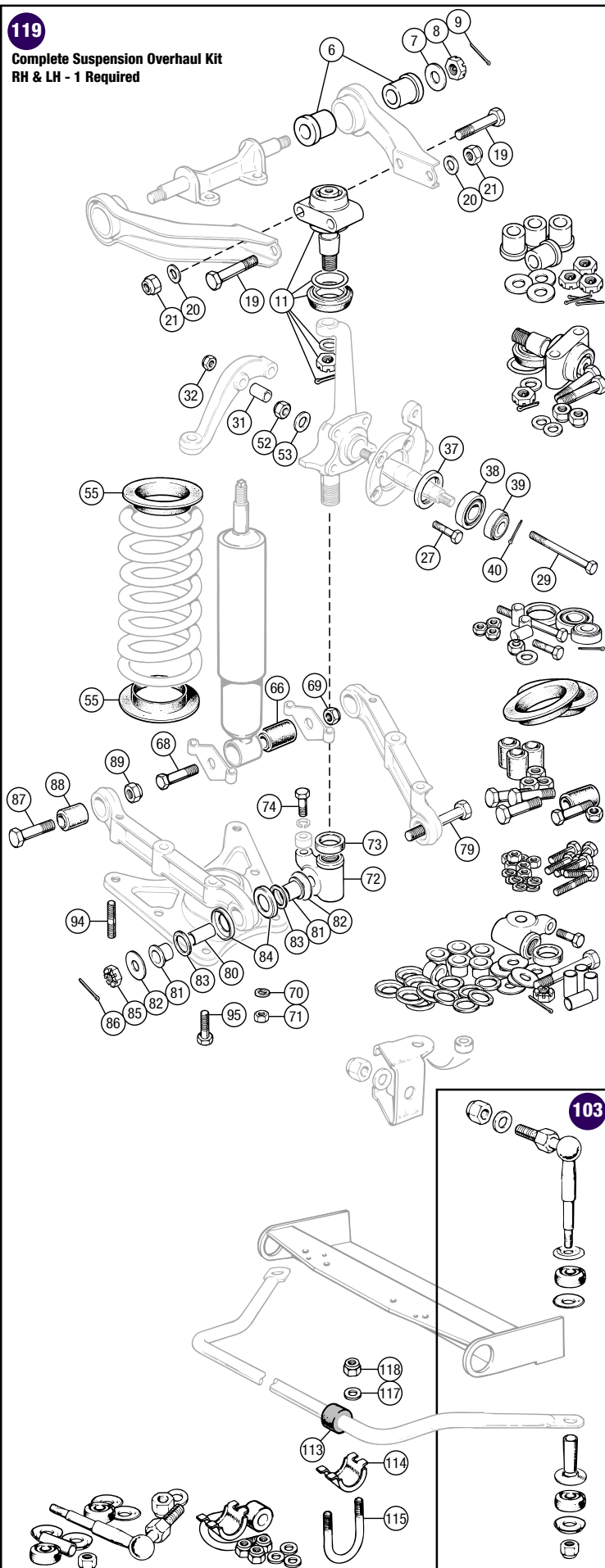
These kits include all necessary bolts, nuts and washers to install the bush kits listed above (N.B. excludes special washers which are assumed to be re-used).

|                                   |          |
|-----------------------------------|----------|
| SUSPENSION BOLT KIT;              |          |
| front                             | RR1418FK |
| rear                              | RR1419FK |
| car set, front & rear (see photo) | RR1420FK |



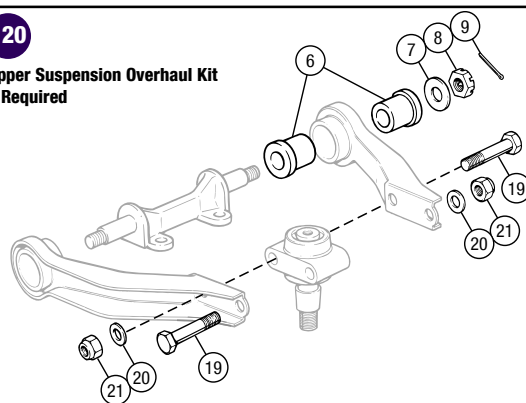
119

**Complete Suspension Overhaul Kit**  
RH & LH - 1 Required



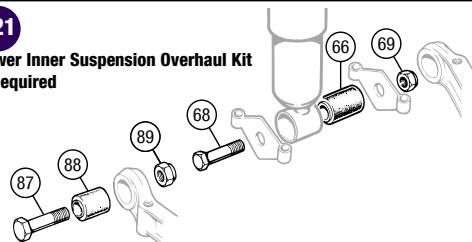
120

**Upper Suspension Overhaul Kit**  
2 Required



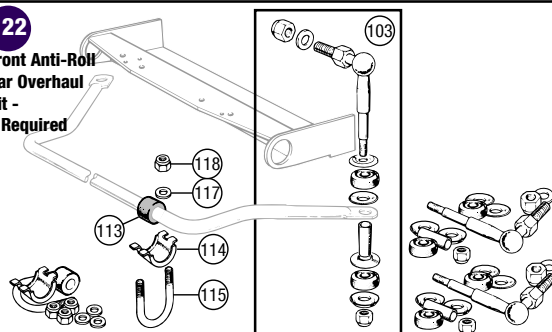
121

**Lower Inner Suspension Overhaul Kit**  
2 Required



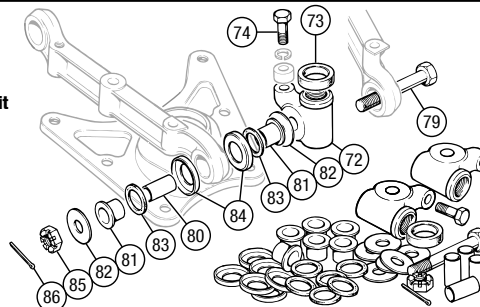
122

**Front Anti-Roll Bar Overhaul Kit - 1 Required**



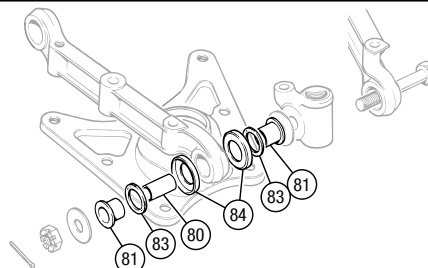
123

**Complete Trunion Overhaul Kit**  
1 Required



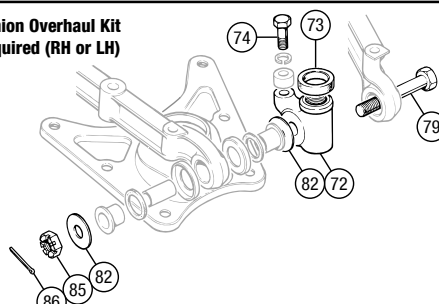
124

**Trunion Bush Kit**  
2 Required



125

**Trunion Overhaul Kit**  
2 Required (RH or LH)





| No. | DESCRIPTION | QTY REQ. | PART No. |
|-----|-------------|----------|----------|
|-----|-------------|----------|----------|

| No. | DESCRIPTION | QTY REQ. | PART No. |
|-----|-------------|----------|----------|
|-----|-------------|----------|----------|

| No. | DESCRIPTION | QTY REQ. | PART No. |
|-----|-------------|----------|----------|
|-----|-------------|----------|----------|

## TR2-4A SOLID AXLE

COMPETITION LEAF SPRING ASSEMBLY -  
208636UR

### Leaf Springs TR2, TR3, TR3A, TR4

|   |   |   |          |
|---|---|---|----------|
| 1 | LEAF SPRING ASSEMBLY;<br>TR2, TR3, TR3A, TR4 to CT23382<br>original | 2 | 208636   |
|   | competition   | 2 | 208636UR |
|   | TR4 from CT23383<br>deep dish                                       | 2 | 209964   |
| 2 | BUSH, in front spring eye<br><i>Included in leaf spring.</i>        | 2 | 107769   |

### Spring Attachments TR2, TR3, TR3A, TR4

|    |   |   |            |
|----|---|---|------------|
| 3  | PIN, front attachment;<br>original  | 2 | 106231     |
|    | stainless steel alternative   | 2 | 106231SS   |
| 4  | 'D' WASHER  | 2 | 102690     |
| 5  | NUT, slotted  | 2 | LN2211     |
| 6  | SPLIT PIN   | 2 | PC10       |
| 7  | 'U' BOLT;<br>Lockheed axle<br>TR2, TR3 to TS13045.<br>Girling Axle<br>TR3 from TS13046, TR3A, TR4 to CT23382. | 4 | 107688     |
|    |   | 4 | 113194     |
| 8  | 'U' BOLT, deep dish spring<br>TR4 from CT23383  | 4 | 136865     |
| 9  | PLATE, rear spring;<br>TR2, TR3 to TS13045<br>LH  | 1 | 105929     |
|    | RH  | 1 | 105928     |
|    | TR3 from TS13046, TR3A, TR4 to CT23382<br>LH  | 1 | 113181     |
|    | RH  | 1 | 113191     |
| 10 | PLATE, rear spring - TR4 from CT23383   | 2 | 139489     |
| 11 | SPACER - TR4 from CT23383;<br>L/H   | 1 | 137634     |
|    | R/H   | 1 | 137635     |
| 12 | WASHER, plain   | 8 | GHF302     |
| 13 | NUT, nyloc  | 8 | GHF223     |
| 14 | BUSH, rear shackle pin;<br>rubber   | 8 | 112503     |
|    | polyurethane  | 8 | 112503POLY |
| 15 | SHACKLE PIN ASSEMBLY  | 2 | 107535     |
| 16 | SHACKLE PLATE   | 2 | AHH5019    |
| 17 | WASHER, locking   | 4 | GHF333     |
| 18 | NUT   | 4 | GHF202     |

### Buffers & Check Straps TR2, TR3, TR3A, TR4

|    |  |   |            |
|----|--|---|------------|
| 19 | BUFFER, rear axle;<br>TR3 from TS13046, TR4; may be adapted to fit earlier models.<br>rubber | 2 | 115456     |
|    | polyurethane   | 2 | 115456POLY |
| 20 | WIRE, rubber buffer to axle  | 4 | 512781     |
|    | CABLE TIE, polyurethane buffer to axle   | 4 | 510969     |
| 21 | CHECK STRAP<br>TR2, TR3, TR3A, TR4 to CT23382  | 2 | 107476     |
| 22 | NUT<br>TR2, TR3, TR3A, TR4 to CT23382  | 4 | NT606041   |
| 23 | WASHER, locking<br>TR2, TR3, TR3A, TR4 to CT23382  | 4 | GHF333     |
| 24 | BOLT, mounting check strap<br>TR2, TR3, TR3A, TR4 to CT23382                                 | 2 | BH606321   |
| 25 | CHECK STRAP - TR4 from CT23383   | 2 | 137338     |
| 26 | NUT, nyloc - TR4 from CT23383  | 4 | GHF223     |
| 27 | SCREW - TR4 from CT23383   | 4 | GHF103     |
| 28 | BRACKET, anchor, check strap<br>TR4 from CT23383   | 2 | 137339     |

### Shock Absorbers (Lever) TR2, TR3, TR3A, TR4

|    |   |         |          |
|----|---|---------|----------|
| 29 | SHOCK ABSORBER, rear;<br>RH, new        | 1       | 202388   |
|    | LH, new                                 | 1       | 202389   |
|    | RH, reconditioned, exchange             | 1       | 202388R  |
|    | LH, reconditioned, exchange             | 1       | 202389R  |
| -  | FLUID (OIL), shock absorber (500ml) a/r | AAA149M |          |
| 30 | SCREW, shock absorber to frame          | 4       | SH606101 |
| 31 | WASHER, plain                           | 4       | WP20X    |
| 32 | NUT, nyloc                              | 4       | GHF223   |
| 33 | LINK, shock absorber                    | 2       | 105925   |
| 34 | WASHER, locking, link to arm            | 2       | GHF333   |
| 35 | NUT, link to arm                        | 2       | GHF202   |
| 36 | WASHER, link to spring plate            | 2       | WD600071 |
| 37 | NUT, nyloc, link to spring plate        | 2       | GHF274   |

### Leaf Springs & Attachments TR4A Solid Axle (North American option)

|    |                                  |   |            |
|----|----------------------------------|---|------------|
| 38 | LEAF SPRING                      | 2 | 212113     |
| 39 | BUSH, front spring eye           | 2 | 107769     |
| 40 | SHACKLE PLATE, with pins         | 2 | 142273     |
| 41 | BUSH, shackle pins;<br>rubber    | 8 | 112503     |
|    | polyurethane                     | 8 | 112503POLY |
| 42 | SHACKLE PLATE                    | 2 | 142275     |
| 43 | WASHER, locking                  | 4 | GHF333     |
| 44 | NUT, shackle plate               | 4 | GHF202     |
| 45 | 'U' BOLT, axle housing to spring | 4 | 136865     |
| 46 | DISTANCE PIECE                   | 2 | 142277     |
| 47 | PLATE, U-bolt mounting           | 2 | 139489     |
| 48 | WASHER, plain                    | 8 | GHF302     |
| 49 | NYLOC NUT, 'U' bolt securing     | 8 | GHF223     |
| 50 | BRACKET, front eye;<br>RH        | 1 | 142427     |
|    | LH                               | 1 | 142426     |
| 51 | BOLT, bracket to frame           | 4 | GHF126     |
| 52 | WASHER                           | 4 | WM59       |
| 53 | NYLOC NUT                        | 4 | GHF223     |
| 54 | BOLT, front eye to bracket       | 2 | BH610281   |
| 55 | NYLOC NUT                        | 2 | 138563     |

### Shock Absorbers (Lever) TR4A Solid Axle (North American option)

|    |   |         |          |
|----|---|---------|----------|
| 56 | SHOCK ABSORBER, rear;<br>RH, new        | 1       | GSA286   |
|    | LH, new                                 | 1       | GSA287   |
|    | RH, reconditioned, exchange             | 1       | GSA286R  |
|    | LH, reconditioned, exchange             | 1       | GSA287R  |
| -  | FLUID (OIL), shock absorber (500ml) a/r | AAA149M |          |
| 57 | SCREW, shock to chassis                 | 4       | SH607101 |
| 58 | WASHER                                  | 4       | WB600070 |
| 59 | SHOCK ABSORBER LINK, rear;<br>RH        | 1       | 142155   |
|    | LH                                      | 1       | 142156   |
| 60 | NUT, shock link to shock                | 2       | GHF203   |
| 61 | WASHER, locking, shock link to shock    | 2       | WL600071 |
| 62 | NYLOC NUT, link to distance piece       | 2       | GHF275   |
| 63 | WASHER, plain                           | 2       | GHF302   |

### Buffers & Rebound Rubbers TR4A Solid Axle (North American option)

|    |   |   |        |
|----|---|---|--------|
| 64 | BUMP RUBBER<br><i>Fitted to body.</i>       | 2 | 140290 |
| 65 | SPACER BLOCK, bump rubber                   | 2 | 142159 |
| 66 | REBOUND RUBBER<br><i>Fitted to chassis.</i> | 2 | 140290 |
| 67 | BUFFER, pinion housing                      | 1 | 136758 |
| 68 | WASHER, locking                             | 1 | GHF333 |
| 69 | NUT   | 1 | GHF202 |

## Telescopic Rear Shock Absorber Conversions

### TR2, TR3, TR3A

|    |   |   |            |
|----|---|---|------------|
| 70 | TELESCOPIC SHOCK CONVERSION<br>BRACKET SET<br><i>All fitting hardware included.</i> | 1 | RW3077     |
| 71 | REAR SHOCK ABSORBERS, Spax<br><i>Sold as a pair.</i>                                | 1 | RW3079SPAX |
| 72 | REAR SHOCK ABSORBERS, Koni<br><i>Sold as a pair.</i>                                | 1 | RW3079KONI |

### TR4 to CT23382

|    |   |   |             |
|----|---|---|-------------|
| 70 | TELESCOPIC SHOCK CONVERSION<br>BRACKET SET<br><i>All fitting hardware included.</i> | 1 | RW3077      |
| 71 | REAR SHOCK ABSORBERS, Spax<br><i>Sold as a pair.</i>                                | 1 | GDA4011SPAX |
| 72 | REAR SHOCK ABSORBERS, Koni<br><i>Sold as a pair.</i>                                | 1 | GDA4011KONI |

### TR4 from CT23383

|    |   |   |            |
|----|---|---|------------|
| 70 | TELESCOPIC SHOCK CONVERSION<br>BRACKET SET<br><i>All fitting hardware included.</i> | 1 | RW3077     |
| 71 | REAR SHOCK ABSORBERS, Spax<br><i>Sold as a pair.</i>                                | 1 | RW3079SPAX |
| 72 | REAR SHOCK ABSORBERS, Koni<br><i>Sold as a pair.</i>                                | 1 | RW3079KONI |

### TR4A RIGID AXLE

|    |   |   |            |
|----|---|---|------------|
| 70 | TELESCOPIC SHOCK CONVERSION<br>BRACKET SET<br><i>All fitting hardware included.</i> | 1 | RW3077     |
| 71 | REAR SHOCK ABSORBERS, Spax<br><i>Sold as a pair.</i>                                | 1 | RW3079SPAX |
| 72 | REAR SHOCK ABSORBERS, Koni<br><i>Sold as a pair.</i>                                | 1 | RW3079KONI |

## Rear Suspension Kits

### TR2, TR3, TR3A, TR4

|  |  |   |            |
|--|--|---|------------|
| 73                                       | REAR SPRING BUSH KIT;<br>with rubber bushes                      | 1 | RW3075     |
|  | with polyurethane bushes   | 1 | RW3075POLY |
| <b>The following parts are included:</b> |  |   |            |
| 2  | BUSH, in front spring eye  | 2 | 107769     |
| 3  | PIN, front spring eye attachment                                 | 2 | 106231     |
| 4  | D' WASHER, front spring eye                                      | 2 | 102690     |
| 5  | NUT, slotted   | 2 | LN2211     |
| 6  | SPLIT PIN  | 2 | PC10       |
| 12                                       | WASHER, plain, 'U' bolt to plate                                 | 8 | GHF302     |
| 13                                       | NUT, nyloc, 'U' bolt to spring plate                             | 8 | GHF223     |
| 14                                       | BUSH, rear shackle pin;<br>rubber ( <i>Included in RW3075</i> )  | 8 | 112503     |
|  | polyurethane ( <i>Included in RW3075POLY</i> )                   | 8 | 112503POLY |
| 15                                       | SHACKLE PIN ASSEMBLY   | 2 | 107535     |
| 16                                       | SHACKLE PLATE  | 2 | AHH5019    |
| 17                                       | WASHER, locking  | 4 | GHF333     |
| 18                                       | NUT  | 4 | GHF202     |
| 19                                       | BUFFER, rear axle;<br>rubber ( <i>Included in RW3075</i> )       | 2 | 115456     |
|  | polyurethane ( <i>Included in RE3075POLY</i> )                   | 2 | 115456POLY |
| 20                                       | WIRE, buffer stop to axle<br><i>Included in RW3075.</i>          | 4 | 512781     |
|  | CABLE TIE, buffer stop to axle<br><i>Included in RW3075POLY.</i> | 4 | 510969     |

## Suspension Bush Kits

Standard bush kits are a direct replacement for the original bushes. Polyurethane gives improved suspension location with greater wear resistance compared to their rubber equivalents. This makes these bushes ideally suited to road cars. A worthwhile addition to any car, the polyurethane bushes are supplied with a steel sleeve where necessary. They are available individually or as kits.

### FRONT SUSPENSION BUSH KIT;

|              |   |            |
|--------------|---|------------|
| standard     | 1 | RW3208     |
| polyurethane | 1 | RW3208POLY |

Bushes included:  
8 Upper Wishbone (4 supplied in polyurethane\*)  
4 Lower Inner Wishbone

\*Please see note under item 29 on page 127.  
4 Front Damper Upper, 2 Front Damper Lower  
& 6 Front Spring Seat.

### REAR SUSPENSION BUSH KIT;

|              |   |            |
|--------------|---|------------|
| standard     | 1 | RW3207     |
| polyurethane | 1 | RW3207POLY |

Bushes included: 8 Rear Spring Shackle & 2 Rear Axle Buffer.

### CAR SET SUSPENSION BUSH KIT;

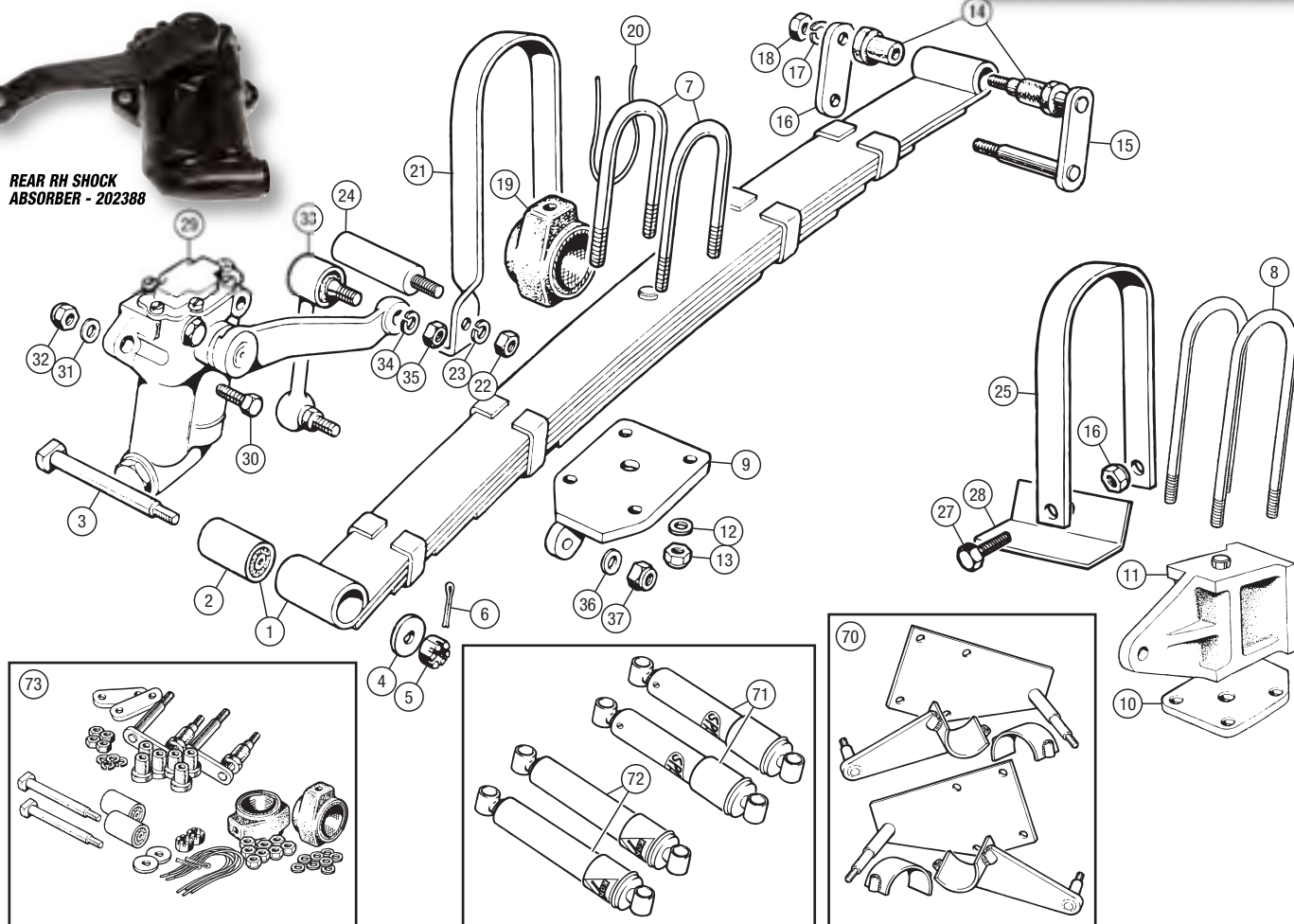
|              |   |            |
|--------------|---|------------|
| standard     | 1 | RW3209     |
| polyurethane | 1 | RW3209POLY |

Includes front and rear bush kits as listed above.

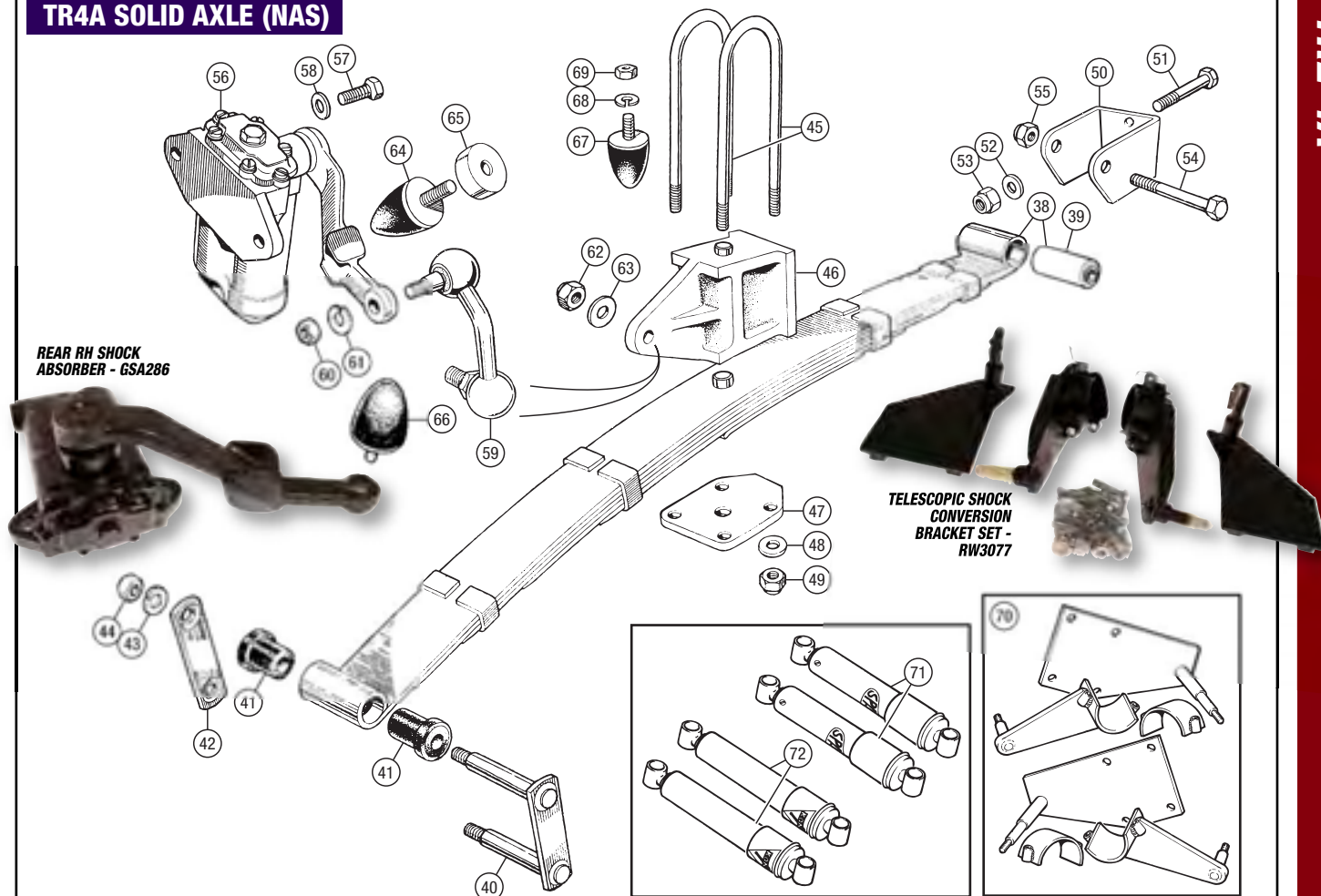


## TR2-4A SOLID AXLE

## REAR SUSPENSION - SOLID AXLE - TR2-4A



**REAR RH SHOCK  
ABSORBER - GSA286**



**TELESCOPIC SHOCK  
CONVERSION  
BRACKET SET -  
BW3077**

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## TR4A-5-250

### Trailing Arm

|   |           |                   |  |
|---|-----------|-------------------|--|
| <b>1 TRAILING ARM ASSEMBLY;</b><br><i>TR5, TR250; use as replacement on TR4A.</i>   |           |                   |  |
| RH  | 1         | <b>308268</b>     |  |
| LH  | 1         | <b>308267</b>     |  |
| <i>These trailing arms are in fact the later design used on TR5, TR250 and TR6. They differ in one aspect from original TR4A items in that a different bump stop is designed to be fitted to the trailing arm, replacing the original fitted to the wheel arch. Therefore, TR4A owners should purchase the later TR5, TR250 bump stop at the same time as their new trailing arm.</i> |           |                   |  |
| <b>2 PLUG, blanking, 7/8"</b>   | <b>4</b>  | <b>138801</b>     |  |
| <b>3 PLUG, blanking, 1 1/8"</b>   | <b>4</b>  | <b>138532</b>     |  |
| <b>4 BUSH, trailing arm;</b><br>rubber, standard  | <b>4</b>  | <b>137599</b>     |  |
| polyurethane, uprated   | <b>4</b>  | <b>137599POLY</b> |  |
| <i>Alternative.</i>   |           |                   |  |
| <b>5 STUD, rear hub unit to trailing arm</b>  | <b>12</b> | <b>TD812</b>      |  |
| <b>6 WASHER, plain</b>  | <b>12</b> | <b>GHF301</b>     |  |
| <b>7 NUT, nyloc</b>   | <b>12</b> | <b>GHF222</b>     |  |



|  |          |               |  |
|--|----------|---------------|--|
| <b>8 BRACKET, support, inner;</b><br>1 notch<br><i>Use with original rear springs.</i> | <b>2</b> | <b>141399</b> |  |
| inner, 3 notch<br><i>Use with replacement rear springs.</i>                            | <b>2</b> | <b>155502</b> |  |
| <b>9 BRACKET, support, outer;</b><br>2 notch<br><i>Use with original rear springs.</i> | <b>2</b> | <b>141398</b> |  |
| 1 notch<br><i>Use with replacement rear springs.</i>                                   | <b>2</b> | <b>141399</b> |  |

The support bracket fitment changes with the type of rear coil springs fitted. The brackets must be fitted in sets in the positions specified to ensure the correct rear suspension geometry is maintained. The later type of TR6 rear spring (216275) is supplied as a replacement for all TR4A, TR5 and TR250 installations as it is slightly stronger than those originally specified.

|  |            |                 |  |
|--|------------|-----------------|--|
| <b>10 BOLT, support bracket to chassis;</b><br>when up to 3 shims are fitted | <b>8</b>   | <b>BH606261</b> |  |
| when 3 to 8 shims are fitted   | <b>8</b>   | <b>112032</b>   |  |
| <b>11 WASHER, plain</b>  | <b>8</b>   | <b>WP9</b>      |  |
| <b>12 NUT, nyloc</b>   | <b>8</b>   | <b>GHF223</b>   |  |
| <b>13 BOLT, trailing arm to support bracket</b>                              | <b>4</b>   | <b>BH607321</b> |  |
| <b>14 WASHER, plain</b>  | <b>4</b>   | <b>WC600071</b> |  |
| <b>15 NUT, nyloc</b>   | <b>4</b>   | <b>GHF274</b>   |  |
| <b>16 SHIM, adjusting, bracket to chassis</b>                                | <b>A/R</b> | <b>139363</b>   |  |



### Coil Springs

See note under support brackets nos. 8 & 9.

|  |          |                   |  |
|--|----------|-------------------|--|
| <b>17 REAR COIL SPRING;</b><br>replacement | <b>2</b> | <b>216275</b>     |  |
| uprated, 420lb., 3/4" lowered              | <b>2</b> | <b>216275UR</b>   |  |
| <b>18 SPRING INSULATOR;</b><br>rubber      | <b>4</b> | <b>138823</b>     |  |
| polyurethane                               | <b>4</b> | <b>138823POLY</b> |  |

### Shock Absorbers (Lever)

|  |          |                   |  |
|--|----------|-------------------|--|
| <b>19 SHOCK ABSORBER, rear;</b><br>RH, new             | <b>1</b> | <b>GSA286</b>     |  |
| LH, new  | <b>1</b> | <b>GSA287</b>     |  |
| RH, reconditioned exchange                             | <b>1</b> | <b>GSA286R</b>    |  |
| LH, reconditioned exchange                             | <b>1</b> | <b>GSA287R</b>    |  |
| <b>- FLUID (OIL), shock absorber (500ml) a/r</b>       |          | <b>AAA149M</b>    |  |
| <b>20 SCREW, shock absorber to chassis</b>             | <b>4</b> | <b>SH607101</b>   |  |
| <b>21 WASHER, special</b>                              | <b>4</b> | <b>WB600070</b>   |  |
| <b>22 LINK ASSEMBLY, shock absorber</b>                | <b>2</b> | <b>GZS806</b>     |  |
| <b>23 WASHER, locking</b>                              | <b>2</b> | <b>WL600071</b>   |  |
| <b>24 NUT, plain</b>                                   | <b>2</b> | <b>HN2010</b>     |  |
| <b>25 MOUNTING, link to trailing arm;</b><br>rubber    | <b>4</b> | <b>152588</b>     |  |
| polyurethane, uprated                                  | <b>4</b> | <b>152588POLY</b> |  |
| <i>Alternative.</i>                                    |          |                   |  |
| <b>26 WASHER, plain, upper</b>                         | <b>2</b> | <b>140416</b>     |  |
| <b>27 WASHER, lower, link to arm</b>                   | <b>2</b> | <b>140479</b>     |  |
| <b>28 NUT, plain</b>                                   | <b>2</b> | <b>GHF202</b>     |  |
| <b>29 NUT, half, locking plain nut</b>                 | <b>2</b> | <b>NT606041</b>   |  |
| <b>30 BUMP STOP;</b><br>on wheel arch                  | <b>2</b> | <b>140290</b>     |  |
| TR4A; use with original trailing arm.                  |          |                   |  |
| on trailing arm  | <b>2</b> | <b>136758</b>     |  |
| TR5, TR250; use with replacement trailing arm on TR4A. |          |                   |  |
| <b>31 REBOUND STOP, on chassis</b>                     | <b>2</b> | <b>136758</b>     |  |

### Telescopic Rear Shock Absorber Conversions

#### KONI, SPAX OR GAZ TELESCOPIC SHOCK ABSORBER CONVERSION KIT

Converting to telescopic damper units will improve the ride and suspension making the handling more stable and predictable under pressure. Kits are supplied complete with brackets, dampers and full instructions. (Uses Type 1 brackets).

|  |          |                     |  |
|--|----------|---------------------|--|
| <b>32 REAR TELESCOPIC CONVERSION KIT</b><br>Koni | <b>1</b> | <b>GSA286-7KONI</b> |  |
| <b>33 REAR TELESCOPIC CONVERSION KIT</b><br>Spax | <b>1</b> | <b>GSA286-7SPAX</b> |  |
| <b>34 REAR TELESCOPIC CONVERSION KIT</b><br>Gaz  | <b>1</b> | <b>GSA286-7GAZ</b>  |  |

#### BUILD YOUR OWN KONI, SPAX OR GAZ TELESCOPIC SHOCK ABSORBER CONVERSION

Buy a pair of Koni, Spax or Gaz shock absorbers, then choose the type of mounting bracketry (type 1, 2 or 3) to suit your requirements.

#### SHOCK ABSORBERS

|                                      |          |                   |  |
|--------------------------------------|----------|-------------------|--|
| <b>35 REAR SHOCK ABSORBERS, Koni</b> | <b>1</b> | <b>RR1401KONI</b> |  |
| <i>Sold as a pair.</i>               |          |                   |  |
| <b>36 REAR SHOCK ABSORBERS, Spax</b> | <b>1</b> | <b>RR1401SPAX</b> |  |
| <i>Sold as a pair.</i>               |          |                   |  |
| <b>37 REAR SHOCK ABSORBERS, Gaz</b>  | <b>1</b> | <b>RR1401GAZ</b>  |  |
| <i>Sold as a pair.</i>               |          |                   |  |

#### REAR TELESCOPIC SHOCK ABSORBER BRACKETS - TYPE 1

These brackets mount to the inner wing and require minimal bodywork modification to be carried out. Ideal for road applications.

|  |          |               |  |
|--|----------|---------------|--|
| <b>38 TELESCOPIC SHOCK CONVERSION</b><br>BRACKET SET | <b>1</b> | <b>RR1402</b> |  |
| <i>All fitting hardware included.</i>                |          |               |  |

#### REAR TELESCOPIC SHOCK ABSORBER BRACKETS - TYPE 2

These one piece brackets mount to the lever arm chassis point and outside inner wheel arch. They are easy to install, but certain combinations of tyre and wheel sizes may cause problems if the bodysell is not aligned to the chassis correctly.

|  |          |                 |  |
|--|----------|-----------------|--|
| <b>39 TELESCOPIC SHOCK CONVERSION</b><br>BRACKET SET | <b>1</b> | <b>RR1403</b>   |  |
| <b>40 SCREW, bracket to chassis</b>                  | <b>4</b> | <b>SH607101</b> |  |
| <b>41 WASHER, special</b>                            | <b>4</b> | <b>WB600070</b> |  |

#### REAR TELESCOPIC SHOCK ABSORBER BRACKETS - TYPE 3

A set of six stepped brackets and fittings to mount up through body-work and out to inner wheel arch, creating a new damper mounting point. Brackets take a little longer to install but do strengthen and stiffen the rear of the bodysell and will cope with a greater variety of wheel and tyre variables. This kit may have to be used when an abnormal combination of wheels/tyres are fitted. Kit contains fittings and instructions.

|  |          |               |  |
|--|----------|---------------|--|
| <b>42 TELESCOPIC SHOCK CONVERSION</b><br>BRACKET SET | <b>1</b> | <b>RR1404</b> |  |
| <i>All fitting hardware included.</i>                |          |               |  |

### Suspension Bush Kits - Front & Rear

|   |          |                   |  |
|---|----------|-------------------|--|
| <b>SUSPENSION BUSH KITS - Front;</b><br>standard material | <b>1</b> | <b>RR1418</b>     |  |
| polyurethane material                                     | <b>1</b> | <b>RR1418POLY</b> |  |

#### Includes:

|   |          |  |  |
|---|----------|--|--|
| <i>Upper Wishbone Bush</i><br><i>1 replaces 2 original, 4 supplied in polyurethane.</i> | <b>8</b> |  |  |
| <i>Lower Inner Wishbone Bush</i>  | <b>4</b> |  |  |
| <i>Anti Roll Bar Mounting Bush</i><br><i>For standard bar.</i>                          | <b>2</b> |  |  |
| <i>Anti Roll Bar End Link Bush</i>  | <b>4</b> |  |  |
| <i>Front Damper Upper Bush</i>  | <b>4</b> |  |  |
| <i>Front Damper Lower Bush</i>  | <b>2</b> |  |  |
| <i>Steering Rack Mounting Bush</i>  | <b>2</b> |  |  |

|  |          |                   |  |
|--|----------|-------------------|--|
| <b>SUSPENSION BUSH KITS - Rear;</b><br>standard material | <b>1</b> | <b>RR1419</b>     |  |
| polyurethane material                                    | <b>1</b> | <b>RR1419POLY</b> |  |

#### Includes:

|   |          |  |  |
|---|----------|--|--|
| <i>Trailing Arm Bush</i>                | <b>4</b> |  |  |
| <i>Rear Axle Mounting Cone/Cup Bush</i> | <b>4</b> |  |  |
| <i>Rear Damper (Lever) Link Bush</i>    | <b>4</b> |  |  |

|   |          |                   |  |
|---|----------|-------------------|--|
| <b>SUSPENSION BUSH KITS - Car Set;</b><br><i>Includes front and rear bush kits as listed above (see photo).</i> | <b>1</b> | <b>RR1420</b>     |  |
| standard material   | <b>1</b> | <b>RR1420POLY</b> |  |
| polyurethane material   | <b>1</b> | <b>RR1420POLY</b> |  |



STANDARD SUSPENSION BUSH KIT - CAR SET - RR1420



POLYURETHANE SUSPENSION BUSH KIT - CAR SET - RR1420POLY

### Suspension Bolt Kits - Front & Rear

These kits include all necessary bolts, nuts and washers to install the bush kits listed above (N.B. excludes special washers which are assumed to be re-used).

|   |          |                 |  |
|---|----------|-----------------|--|
| <b>SUSPENSION BOLT KITS;</b><br>front   | <b>1</b> | <b>RR1418FK</b> |  |
| rear                                    | <b>1</b> | <b>RR1419FK</b> |  |
| car set, front & rear (see photo below) | <b>1</b> | <b>RR1420FK</b> |  |

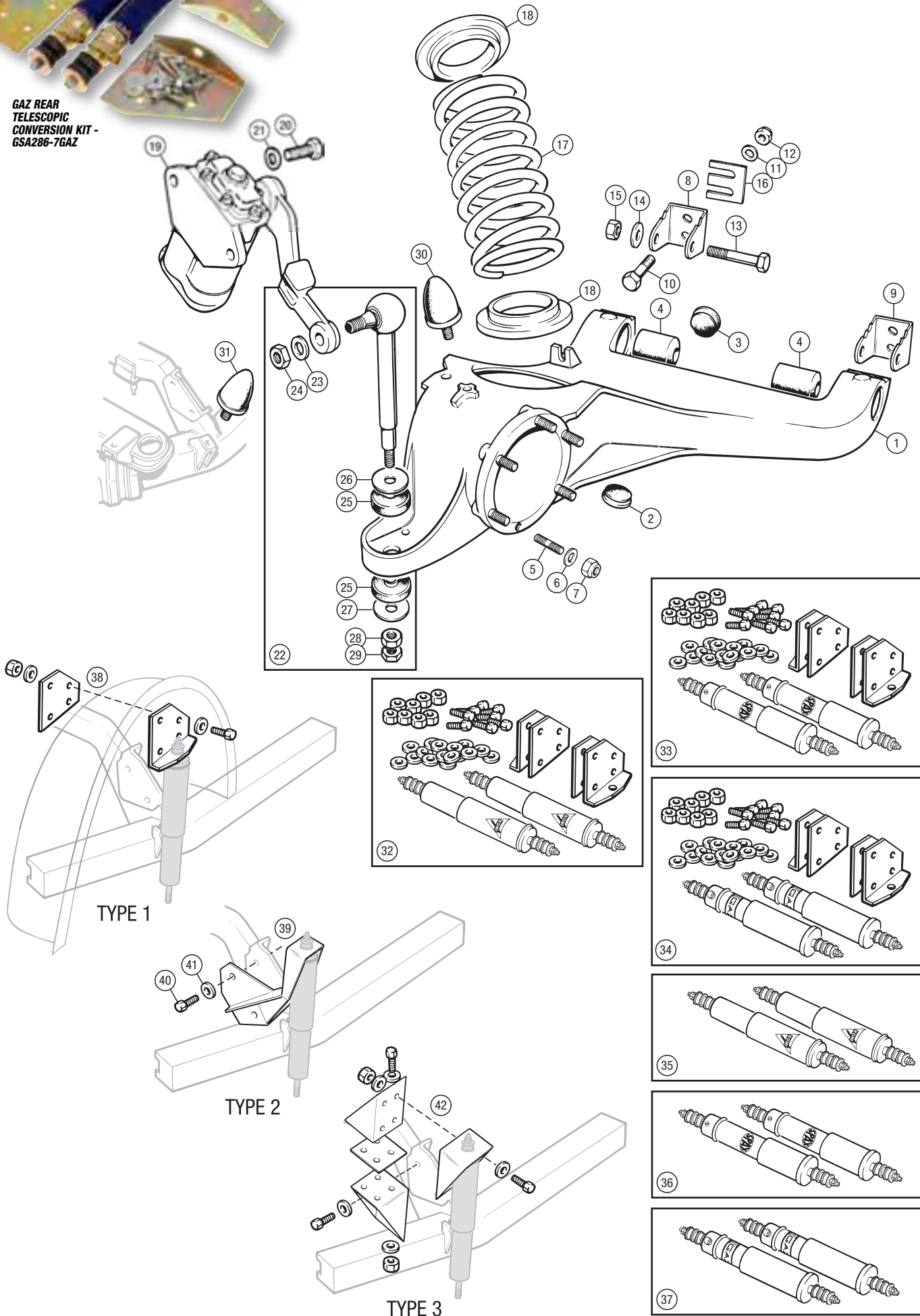


SUSPENSION BOLT KIT - RR1420FK





GAZ REAR  
TELESCOPIC  
CONVERSION KIT -  
GSA286-7GAZ




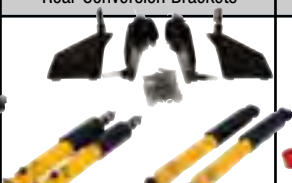
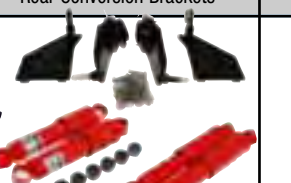










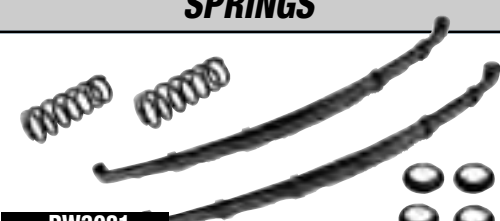
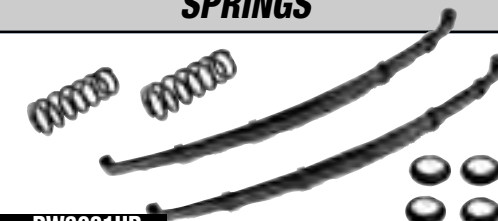




## TR2-4A (SOLID AXLE)

# SUSPENSION PACKAGES - SOLID AXLE

We have assembled a selection of shock absorber and spring packages to suit your requirements - they save you money, too. These range from standard front and rear (lever) shock absorbers to either Spax, Koni or Gaz (with rear telescopic conversion brackets - refer to 'Rear Suspension - Solid Axle' for details). You can then choose either standard springs or uprated and lowered springs.

### SOLID REAR AXLE MODELS

|   |  |  |  |   |
|---|--|--|--|---|
| <div>SOLID<br/>REAR AXLE<br/>MODELS</div>   | <div>STANDARD<br/>SPECIFICATION<br/>SHOCK ABSORBERS<br/>Front - Telescopic<br/>Rear - Lever (new, outright.)</div> | <div>SPAX<br/>ADJUSTABLE<br/>SHOCK ABSORBERS<br/>Front - Telescopic<br/>Rear - Telescopic<br/>Rear Conversion Brackets</div> | <div>KONI<br/>ADJUSTABLE<br/>SHOCK ABSORBERS<br/>Front - Telescopic<br/>Rear - Telescopic<br/>Rear Conversion Brackets</div> | <div>GAZ<br/>ADJUSTABLE<br/>SHOCK ABSORBERS<br/>Front - Telescopic<br/>Rear - Telescopic<br/>Rear Conversion Brackets</div> |
| TR2, TR3, TR3A<br>2 Front & 2 Rear<br>Shock Absorbers   | <br>RW3076                        | <br>RW3080SPAX                              | <br>RW3080KONI                             | NOT<br>AVAILABLE  |
| TR4 to CT23382<br>2 Front & 2 Rear<br>Shock Absorbers   | <br>RW3076                        | <br>RF4141SPAX                              | <br>RF4141KONI                             | <br>RF4141GAZ                            |
| TR4 from CT23383<br>2 Front & 2 Rear<br>Shock Absorbers   | <br>RW3076                      | <br>RW3080SPAX                            | <br>RW3080KONI                           | NOT<br>AVAILABLE  |
| TR4A Solid Axle (NAS)<br>2 Front & 2 Rear<br>Shock Absorbers  | <br>RW3078                      | <br>RW3080SPAX                            | <br>RW3080KONI                           | NOT<br>AVAILABLE  |
|   | STANDARD<br>SPRINGS  | UPRATED/LOWERED<br>SPRINGS   |  |   |
| TR2, TR3, TR3A,<br>TR4 to CT23382<br>2 Front Springs, 2 Rear Springs<br>4/6 Spring Insulators<br>(6 for uprated front springs)<br>2 Packing Pieces<br>(for uprated front springs) | <br>RW3081                      | <br>RW3081UR                            |  |   |
| TR4 from CT23383<br>2 Front Springs<br>2 Deep Dish Rear Springs<br>4 Spring Insulators  | <br>RF4142                      | NOT<br>AVAILABLE<br><br>Uprated deep dish rear springs not available -<br>cannot fit early profile rear springs to chassis.  |  |   |
| TR4A Solid Axle (NAS)<br>2 Front Springs<br>2 Deep Dish Rear Springs<br>4 Spring Insulators   | <br>RF4143                      | NOT<br>AVAILABLE<br><br>Uprated deep dish rear springs not available -<br>cannot fit early profile rear springs to chassis.  |  |   |





# SUSPENSION PACKAGES - INDEPENDENT AXLE

We have assembled a selection of shock absorber and spring packages to suit your requirements - they save you money, too. These range from standard front and rear (lever) shock absorbers to either Spax, Koni or Gaz (with rear telescopic conversion brackets - refer to 'Rear Suspension - Independent Axle' for details). These are then offered with either standard springs or uprated and lowered springs.

## INDEPENDENT REAR AXLE MODELS

|   | <b>STANDARD SPECIFICATION SHOCK ABSORBERS</b><br>Front - Telescopic<br>Rear - Lever (recon. exch.) or<br>Rear - Lever (new, outright) | <br><b>SPAX ADJUSTABLE SHOCK ABSORBERS</b><br>Front & Rear Telescopic<br>(Type 1 rear body mounted conversion brackets) | <br><b>KONI ADJUSTABLE SHOCK ABSORBERS</b><br>Front & Rear Telescopic<br>(Type 1 rear body mounted conversion brackets) | <br><b>GAZ ADJUSTABLE SHOCK ABSORBERS</b><br>Front & Rear Telescopic<br>(Type 1 rear body mounted conversion brackets) |
|---|---|--|---|---|
| <b>TR4A IRS, TR5, TR250</b><br>2 Front & 2 Rear Shock Absorbers   | <br><b>RR1405 or RR1405N</b>                         | <br><b>RR1300</b>   | <br><b>RR1406</b>   | <br><b>RR1300GAZ</b>   |
| <b>TR4A IRS, TR5, TR250</b><br>4 Shock Absorbers (front/rear)<br>4 Standard Springs (front/rear)<br>8 Spring Insulators   | <br><b>RR1407 or RR1407N</b>                        | <br><b>RR1408</b>  | <br><b>RR1409</b>  | <br><b>RR1408GAZ</b>  |
| <b>TR4A IRS, TR5, TR250</b><br>4 Shock Absorbers (front/rear)<br>4 Uprated/Lowered Springs (front 420lb./1" lowered)<br>(rear 420lb./3/4" lowered)<br>8 Spring Insulators | <br><b>RR1410 or RR1410N</b>                       | <br><b>RR1411</b>   | <br><b>RR1412</b>   | <br><b>RR1411GAZ</b>   |

|  | <b>STANDARD SPRINGS</b>  | <b>UPRATED/LOWERED SPRINGS</b><br>(front 420lb./1" lowered) (rear 420lb./3/4" lowered)                |
|--|--|---|
| <b>TR4A IRS, TR5, TR250</b><br>2 Front Springs,<br>2 Rear Springs<br>8 Spring Insulators | <br><b>RR1413</b> | <br><b>RR1414</b> |

## TECH SPEC



### ADJUSTABLE (ON CAR)

28 point adjustment, (also available with adjustable front spring seat) dyno tested. Handbuilt, matching units. Designed and developed by Motorsports Engineers. 2 year warranty.



### ADJUSTABLE (OFF CAR)

Specifically designed for each application. Individually tested until optimum in handling and comfort is reached. Will usually outlive your car.



### ADJUSTABLE (ON CAR)

36 point fine tune settings (also available with adjustable front spring seat). Zinc plated bodies. Double lip seal + O' ring on piston rod. Fully rebuildable. Top quality. Each unit tested and supplied with individual dyno read-out. 3 year warranty. British made.



| No. | DESCRIPTION | QTY REQ. | PART No. | No. | DESCRIPTION | QTY REQ. | PART No. | No. | DESCRIPTION | QTY REQ. | PART No. |
|-----|-------------|----------|----------|-----|-------------|----------|----------|-----|-------------|----------|----------|
|-----|-------------|----------|----------|-----|-------------|----------|----------|-----|-------------|----------|----------|

## TR2-4



FRONT ANTI-ROLL BAR KIT - RW3082

### Front Anti-Roll Bar

#### TR2, TR3, TR3A

Sidescreeen TRs did not benefit from a publicly available factory anti-roll bar option. However, for owners considering fast road or competition use with their car who wish to make good this deficit in the chassis department, we are able to offer a complete installation kit containing a 3/4" diameter bar.

- |   |                         |   |        |
|---|-------------------------|---|--------|
| 1 | FRONT ANTI-ROLL BAR KIT | 1 | RW3082 |
|   | 3/4" dia. bar.          |   |        |



FRONT ANTI-ROLL BAR KIT - 510584

### Factory Option Front Anti-Roll Bar

#### TR4

The TR4 was offered by the factory with or without a front anti-roll bar; for owners with cars lacking the feature this means that fitting an anti-roll bar is a painless operation, since all the components are available 'off the shelf' and factory-designed to fit straight onto existing mounting points on the vehicle. It gives greatly increased stability when cornering, with little adverse effect on the quality of ride.

- |   |                                  |   |        |
|---|----------------------------------|---|--------|
| 2 | FRONT ANTI-ROLL BAR KIT          | 1 | 510584 |
|   | Factory option (9/16" dia. bar). |   |        |

#### The above installation kit includes:

- |    |                                  |   |          |
|----|----------------------------------|---|----------|
| 3  | FRONT ANTI-ROLL BAR, 9/16" dia.  | 1 | 208571   |
| 4  | CLAMP, bar locating              | 4 | AHH6546  |
| 5  | SCREW                            | 4 | PX505    |
| 6  | WASHER, locking                  | 4 | WL105001 |
| 7  | NUT                              | 4 | HN2005   |
| 8  | WASHER, locating                 | 4 | 122231   |
| 9  | RETAINER ASSEMBLY                | 2 | 121792   |
| 10 | MOUNTING, rubber                 | 2 | 121791   |
| 11 | NUT, retainer assembly           | 4 | GHF222   |
| 12 | BRACKET, RH                      | 1 | 131964   |
| 13 | BRACKET, LH                      | 1 | 131963   |
| 14 | SCREW, bracket to bumper bracket | 4 | SH606071 |
| 15 | NUT, nyloc                       | 4 | GHF223   |
| 16 | LINK ASSEMBLY                    | 2 | 121797   |
| 17 | NUT, link to bracket             | 2 | FNZ507   |
| 18 | WASHER, locking                  | 2 | WA600071 |

- |    |  |   |        |
|----|--|---|--------|
| 19 | BRACKET, attachment (not incl. in kit) | 2 | 131479 |
|----|--|---|--------|

### Upated Front Anti-Roll Bar

#### TR4

We offer an uprated front anti-roll bar installation with a larger diameter (3/4" as opposed to 9/16" standard) which further reduces the amount of body roll when cornering. Offered as a complete installation kit.

- |    |                         |   |        |
|----|-------------------------|---|--------|
| 20 | FRONT ANTI-ROLL BAR KIT | 1 | RF4144 |
|    | Upated (3/4" dia. bar). |   |        |

### Radiator Shield Anti-Roll Bar Mounting

#### TR4

While the anti roll bar may be mounted centrally to the bumper irons as Triumph originally intended, a better alternative is to mount it to the optional radiator shield, significantly increasing the strength of the mountings and the operation of the anti roll bar. Originally the radiator shield was not pierced for anti roll bar mountings - in this instance, you would have to drill the mounting points yourself - but the radiator shield now available is supplied with the correct piercings ready for use.

- |    |                           |   |        |
|----|---------------------------|---|--------|
| 21 | RADIATOR SHIELD, optional | 1 | 301644 |
|----|---------------------------|---|--------|

### Rear Anti-Roll Bar

TRs were never fitted with a rear anti-roll bar, so this bar once fitted improves the rear end stability considerably allowing a progressive induction of pressure.

- |    |                                |   |        |
|----|--------------------------------|---|--------|
| 22 | REAR ANTI-ROLL BAR KIT;        |   |        |
|    | TR2, TR3, TR3A (5/8" dia. bar) | 1 | RW3084 |
|    | TR4 (5/8" dia. bar)            | 1 | RF4145 |

### Steering Rack Conversion Kit

#### TR2, TR3, TR3A

The biggest and most significant improvement to the steering of the TR2, TR3, TR3A models is the fitment of a steering rack. This bolt-on kit gives instant improvement with lighter steering for easier parking and driving control. Due to low clearance, the kits should only be used with the 4 blade fan or Kenlowe Cooling Fan Kit.

- |    |                               |   |           |
|----|-------------------------------|---|-----------|
| 23 | STEERING RACK CONVERSION KIT; |   |           |
|    | RH Steering                   | 1 | RW3085    |
|    | LH Steering                   | 1 | RW3085LHD |

#### The kit includes items 24:

- |    |            |   |        |
|----|------------|---|--------|
| 24 | GAITER SET | 1 | RW3086 |
|----|------------|---|--------|

An upper steering column assembly will also be required for TR2 & TR3 cars originally fitted with a steering box with a long column.

- |    |                                 |   |         |
|----|---------------------------------|---|---------|
| 25 | UPPER STEERING COLUMN ASSEMBLY; |   |         |
|    | RH Steering                     | 1 | 121154R |
|    | LH Steering                     | 1 | 121154L |

### Quick Racks

#### TR4

A quick rack for TR4 models has a high ratio pinion giving you lock-to-lock in only 2.5 turns, compared to the standard of 3.5 turns. Made for competition use, it features a stronger outer casing and a higher grade of steel rack for increased durability. The rack is designed to be used with special solid rack mounts, included in the fitting kit. Track rod ends are not included.

- |    |  |   |          |
|----|--|---|----------|
| 26 | QUICK RACK ASSEMBLY (including fitting kit); |   |          |
|    | RH steering                                  | 1 | 306829HR |
|    | LH steering                                  | 1 | 306830HR |

## Polyurethane Suspension Bush Kits

Polyurethane gives improved suspension location with greater wear resistance compared to their rubber equivalents. This makes these bushes ideally suited to road cars. A worthwhile addition to any car, the polyurethane bushes are supplied with a steel sleeve where necessary. They are available individually or as kits.

- |                            |   |            |  |
|----------------------------|---|------------|--|
| FRONT SUSPENSION BUSH KIT, |   |            |  |
| polyurethane               | 1 | RW3208POLY |  |

#### Includes bushes for:

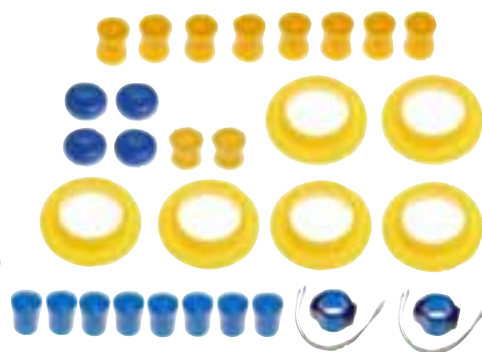
- |                                    |   |  |
|------------------------------------|---|--|
| Upper Wishbone                     | 4 |  |
| Each replaces two original bushes. |   |  |
| Lower Inner Wishbone               | 4 |  |
| Please see note under item 29.     |   |  |
| Front Damper Upper                 | 4 |  |
| Front Damper Lower                 | 2 |  |
| Front Spring Seat                  | 6 |  |

- |                           |   |            |  |
|---------------------------|---|------------|--|
| REAR SUSPENSION BUSH KIT, |   |            |  |
| polyurethane              | 1 | RW3207POLY |  |

#### Includes bushes for:

- |                     |   |  |
|---------------------|---|--|
| Rear Spring Shackle | 8 |  |
| Rear Axle Buffer    | 2 |  |

- |  |  |            |  |
|--|--|------------|--|
| CAR SET SUSPENSION BUSH KIT,                       |  |            |  |
| polyurethane                                       |  | RW3209POLY |  |
| Includes front and rear bush kits as listed above. |  |            |  |



CAR SUSPENSION BUSH KIT - RW3209POLY

## Polyurethane Individual Bushes

- |    |                                    |   |            |
|----|------------------------------------|---|------------|
| 28 | POLYURETHANE BUSH, upper wishbone  | 4 | 102228POLY |
|    | Each replaces two original bushes. |   |            |

- |    |   |   |            |
|----|---|---|------------|
| 29 | POLYURETHANE BUSH, lower inner wishbone | 4 | 102228POLY |
|----|---|---|------------|

Each polyurethane lower inner wishbone bush replaces two original bushes on TR2s and TR3s to TS9120. On later TR3s, TR3As and TR4s each polyurethane bush replaces two nylon washers, two seals, one nylon bush and one steel bush.

- |    |  |   |            |
|----|--|---|------------|
| 30 | POLYURETHANE BUSH, rear spring shackle pin | 8 | 112503POLY |
|----|--|---|------------|

- |    |                                |   |            |
|----|--------------------------------|---|------------|
| 31 | POLYURETHANE BUFFER, rear axle | 2 | 115456POLY |
|----|--------------------------------|---|------------|

- |    |  |   |            |
|----|--|---|------------|
| 32 | POLYURETHANE BUSH, front damper, upper | 4 | 152588POLY |
|----|--|---|------------|

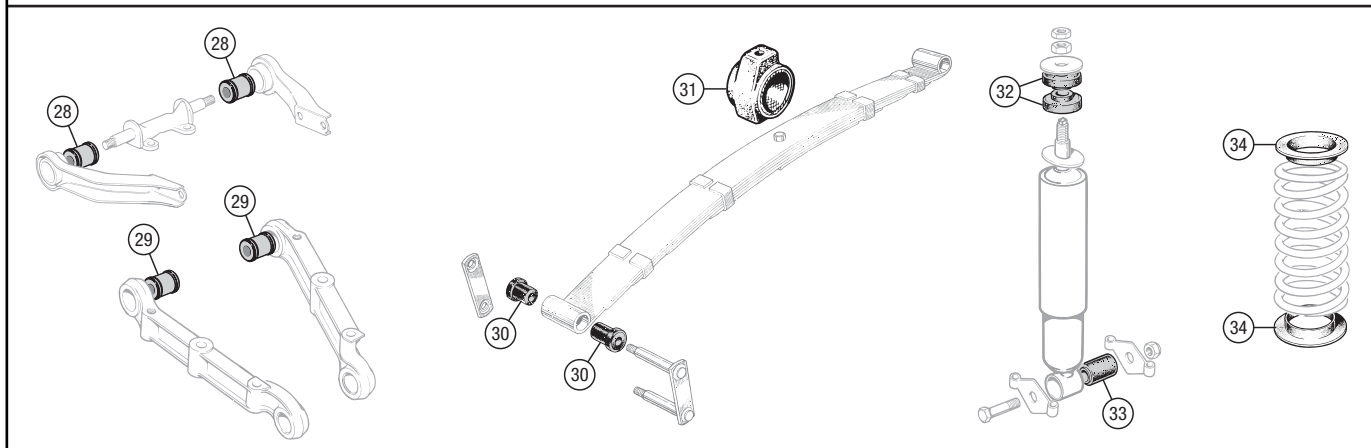
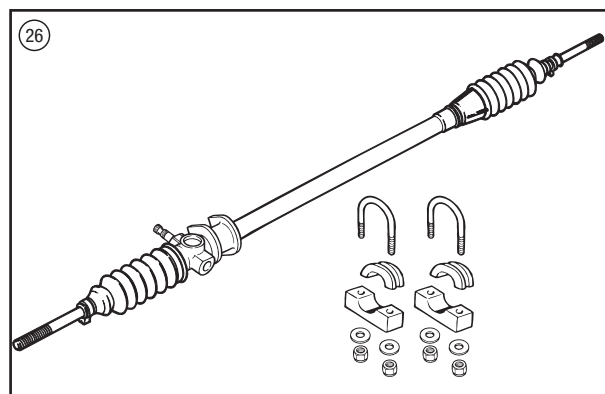
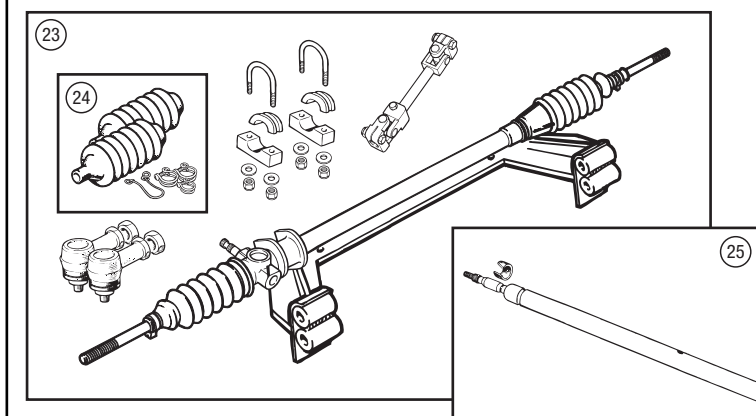
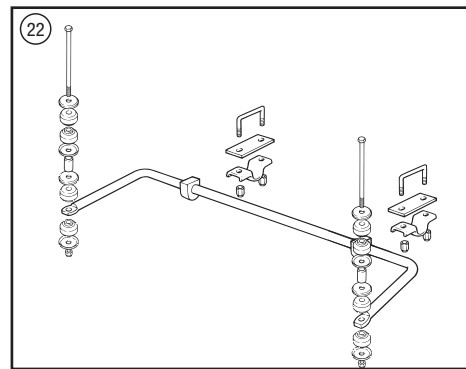
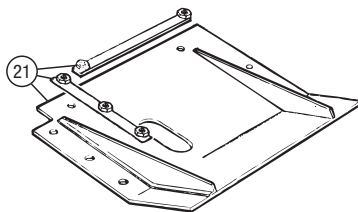
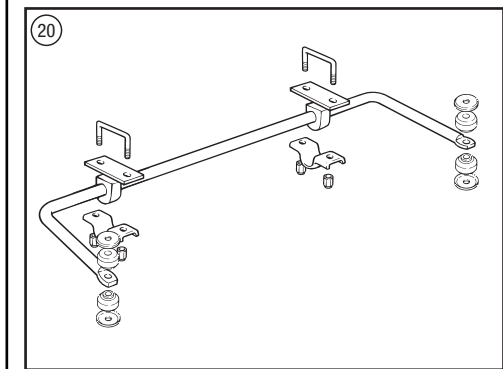
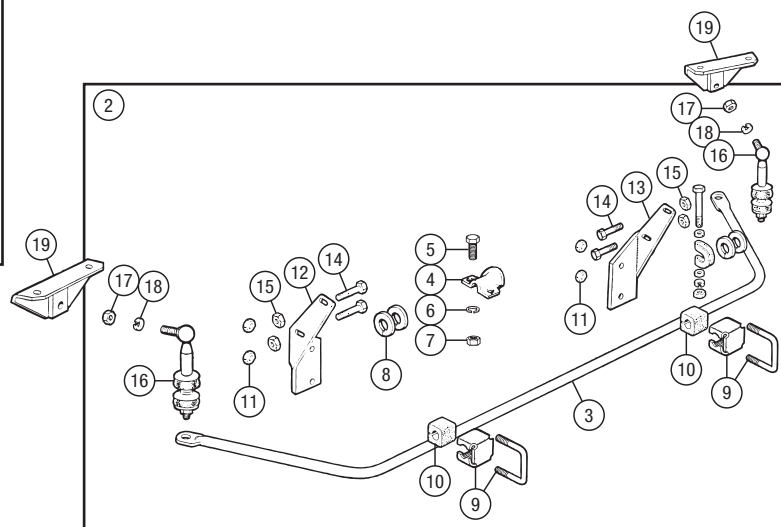
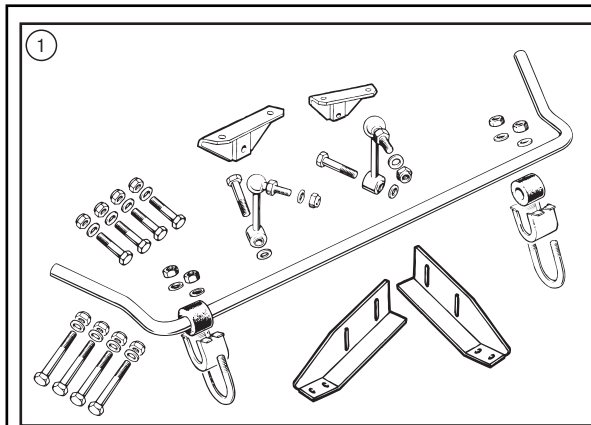
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|----|--|---|------------|
| 33 | POLYURETHANE BUSH, front damper, lower | 2 | 102987POLY |
|----|--|---|------------|

- |    |                                 |     |            |
|----|---------------------------------|-----|------------|
| 34 | POLYURETHANE SPRING SEAT, front | 6/4 | 100751POLY |
|----|---------------------------------|-----|------------|



QUICK RACK ASSEMBLY - 306829HR







| No. | DESCRIPTION | QTY REQ. | PART No. | No. | DESCRIPTION | QTY REQ. | PART No. | No. | DESCRIPTION | QTY REQ. | PART No. |
|-----|-------------|----------|----------|-----|-------------|----------|----------|-----|-------------|----------|----------|
|-----|-------------|----------|----------|-----|-------------|----------|----------|-----|-------------|----------|----------|

## TR4A-5-250



FRONT ANTI-ROLL BAR - 215647

### Factory Option Front Anti-Roll Bar

Fitting the optional anti-roll bar assembly, which became a standard fitment on TR6, is a very worthwhile conversion to carry out on TR4As, TR5s and TR250s not equipped with it already. These models of course share in every other respect exactly the same suspension as their later TR stablemate, making the conversion incredibly easy. The only adaptation of the car that may be required is for the mounting U bolts. Some cars may still be fitted with the earlier style of radiator shield (to which the mountings attach), which is correct in shape but requires piercing to accept the U bolts. Alternatively, the early shield may be swapped for either of the later ready-pierced items (part no. 213021 - see 'Chassis' for details - or TKC1972, the very late TR6 variant). However it's likely that on the majority of cars the piercings will already be present, due to radiator shields being swapped between models over the years.

|  |   |   |              |
|--|---|---|--------------|
| 1                                      | FRONT ANTI-ROLL BAR, 0.75" dia.               | 1 | 215647       |
|  | Standard diameter.                            |   |              |
| 2                                      | INSTALLATION KIT, standard dia. anti-roll bar | 1 | 215647FK     |
| <b>The above fitting kit includes:</b> |   |   |              |
| 3                                      | LINK ASS'Y, anti-roll bar to wishbones        | 2 | 152143A      |
| 4                                      | WASHER  | 4 | 517983       |
| 5                                      | WASHER  | 4 | 517984       |
| 6                                      | MOUNTING BUSH; rubber                         | 4 | 517985       |
|  | polyurethane (Alternative - not in kit)       | 4 | 517985POLY   |
| 7                                      | TUBE, distance                                | 2 | 517986       |
| 8                                      | NUT, nyloc                                    | 2 | GHF223       |
| 9                                      | WASHER, plain                                 | 4 | WA600071     |
| 10                                     | NUT, nyloc                                    | 2 | GHF224       |
| 11                                     | BRACKET, mounting, link to wishbone           | 2 | 152144       |
| 12                                     | PACKING PIECE, bracket to wishbone            | 2 | 152145       |
| 13                                     | BUSH, locating anti-roll bar; rubber          | 2 | 123998       |
|  | polyurethane (Alternative - not in kit)       | 2 | 123998POLYTR |
| 14                                     | BRACKET, clamp, securing anti-roll bar        | 2 | 123502       |
| 15                                     | 'U' BOLT, plain, anti-roll bar bracket        | 2 | 123694       |
| 16                                     | 'U' BOLT, with towing eyes                    | 2 | 139126       |
|  | Alternative - not in kit.                     |   |              |
| 17                                     | WASHER, plain                                 | 4 | GHF301       |
| 18                                     | NUT, nyloc                                    | 4 | GHF222       |

### Upated Front Anti-Roll Bar

We offer an uprated version with a larger diameter (0.875" as opposed to 0.75" standard) which reduces the amount of body roll when cornering. To install you will require the fitting kit which includes the larger diameter bushes, clamps, U bolts and links listed below.

|  |   |   |                |
|--|---|---|----------------|
| 19                                     | FRONT ANTI-ROLL BAR, 0.875" dia.                        | 1 | 215647UR       |
|  | Upated diameter.  |   |                |
| 20                                     | FITTING KIT, uprated dia. anti-roll bar                 | 1 | 215647URFK     |
| <b>The above fitting kit includes:</b> |   |   |                |
| 3                                      | LINK ASS'Y, anti-roll bar to wishbones                  | 2 | 152143A        |
| 7                                      | TUBE, distance  | 2 | 517986         |
| 21                                     | POLYURETHANE BUSH (0.875" internal dia.), anti-roll bar | 2 | 155310POLYSPIT |
| 22                                     | BRACKET, clamp, anti-roll bar                           | 2 | 155308         |
| 23                                     | 'U' BOLT, plain, anti-roll bar bracket                  | 2 | 155307         |
| 24                                     | WASHER, plain   | 4 | GHF301         |
| 25                                     | NUT, nyloc  | 4 | GHF222         |

### Polyurethane Anti-Roll Bar Bush Kits (front)

|    |   |   |        |
|----|---|---|--------|
| 26 | POLYURETHANE BUSH KIT, front, anti-roll bar; Includes 2 mounting and 4 end link bushes. |   |        |
|    | standard (0.75" dia)  | 1 | RR1416 |
|    | uprated (0.875" dia)  | 1 | RR1417 |

### Rear Anti-Roll Bar

TRs were never fitted with a rear anti-roll bar, so this bar once fitted improves the rear end stability considerably allowing a progressive induction of pressure. Replacement bushes are available for servicing purposes.

|    |                             |   |            |
|----|-----------------------------|---|------------|
| 27 | REAR ANTI-ROLL BAR KIT      | 1 | RR1415     |
|    | CLAMP & POLY BUSH ASS'Y     | 2 | RR1539     |
|    | POLYURETHANE BUSH, end link | 4 | 517985POLY |

### Polyurethane Steering Rack Mounts

As an alternative to solid rack mounts these polyurethane mounts offer increased strength and a more responsive feel than the original rubber. These should be used with standard rack mounting clamps and plates.

|    |                                  |   |            |
|----|----------------------------------|---|------------|
| 28 | POLYURETHANE BUSH, steering rack | 2 | 139386POLY |
| 29 | CLAMP BRACKET                    | 2 | 156024     |
| 30 | SUPPORT PLATE                    | 2 | 133875     |
| 31 | WASHER, plain                    | 4 | GHF301     |
| 32 | NUT, nyloc                       | 4 | GHF282     |

### Solid Steering Rack Mounts

Solid steering rack mount kit is designed to retain the steering rack and prevent movement when in use. The standard rubber mounts allow movement even when correctly clamped. These aluminium mountings retain the rack giving more responsive steering and greater control. Supplied as a kit with 'U' bolts ready to install. Only suitable for cars with original steering racks (not suitable for 'Quick Racks').

|    |                               |   |        |
|----|-------------------------------|---|--------|
| 33 | SOLID STEERING RACK MOUNT KIT | 1 | RR1370 |
|----|-------------------------------|---|--------|



SOLID STEERING RACK MOUNTING KIT - RR1370

### Quick Racks

The new Quick Rack has a high ratio pinion giving you lock-to-lock in only 2.5 turns, compared to the standard of 3.5 turns. Made for competition use, with stronger outer casing and a higher grade of steel rack for increased durability. The rack is designed to be used with special solid rack mounts, (included in fitting kit). Track rod ends not included.

|    |  |   |          |
|----|--|---|----------|
| 34 | QUICK RACK ASS'Y (includes fitting fit); |   |          |
|    | RH steering                              | 1 | 306829HR |
|    | LH steering                              | 1 | 306830HR |



QUICK RACK ASSEMBLY - 306829HR

## Polyurethane Suspension Bush Kits

Polyurethane gives improved suspension location with greater wear resistance compared to their rubber equivalents. This makes these bushes ideally suited to road cars. A worthwhile addition to any car, the polyurethane bushes are supplied with a steel sleeve where necessary. They are available individually or as kits.

|  |   |            |
|--|---|------------|
| SUSPENSION BUSH KITS - Polyurethane, Front | 1 | RR1418POLY |
|--|---|------------|

|                                  |   |  |
|----------------------------------|---|--|
| <b>Includes bushes for:</b>      |   |  |
| Upper Wishbone                   | 4 |  |
| Each replaces 2 original bushes. |   |  |
| Lower Inner Wishbone             | 4 |  |
| Anti-Roll Bar Mounting           | 2 |  |
| For standard bar.                |   |  |
| Anti-Roll Bar End Link           | 4 |  |
| Front Damper Upper               | 4 |  |
| Front Damper Lower               | 2 |  |
| Steering Rack Mounting           | 2 |  |

|   |   |            |
|---|---|------------|
| SUSPENSION BUSH KITS - Polyurethane, Rear | 1 | RR1419POLY |
|---|---|------------|

|                                   |   |  |
|-----------------------------------|---|--|
| <b>Includes bushes for:</b>       |   |  |
| Trailing Arm                      | 4 |  |
| Rear Axle Front Mounting Cone/Cup | 4 |  |
| Rear Damper (Lever) Link          | 4 |  |

|   |  |            |
|---|--|------------|
| SUSPENSION BUSH KITS - Polyurethane Car Set (see photo) |  | RR1420POLY |
| Includes front and rear bush kits as listed above.      |  |            |



CAR SET SUSPENSION BUSH KIT - RR1420POLY

### Suspension Bolt Kits

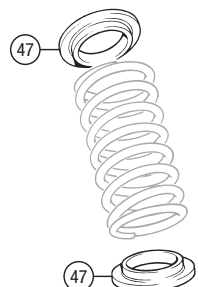
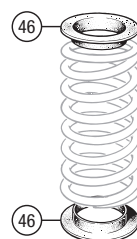
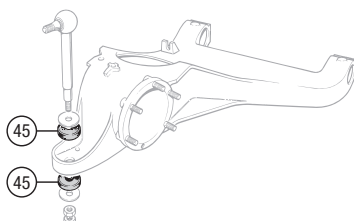
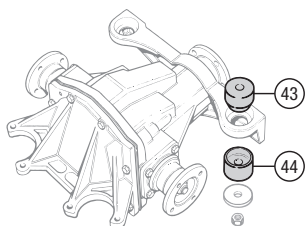
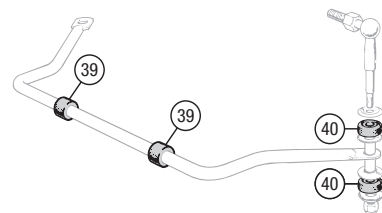
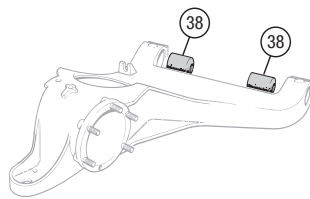
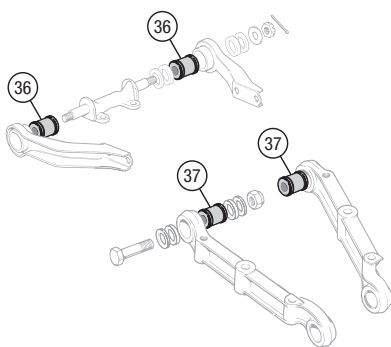
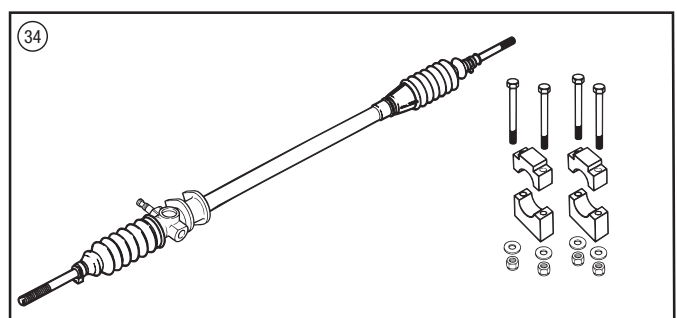
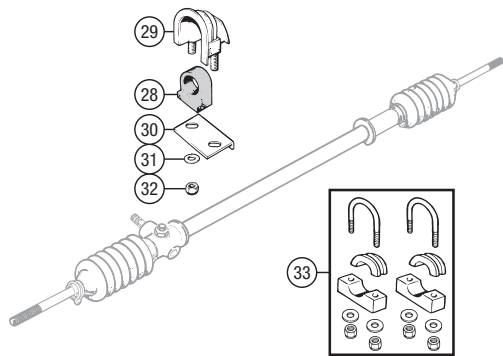
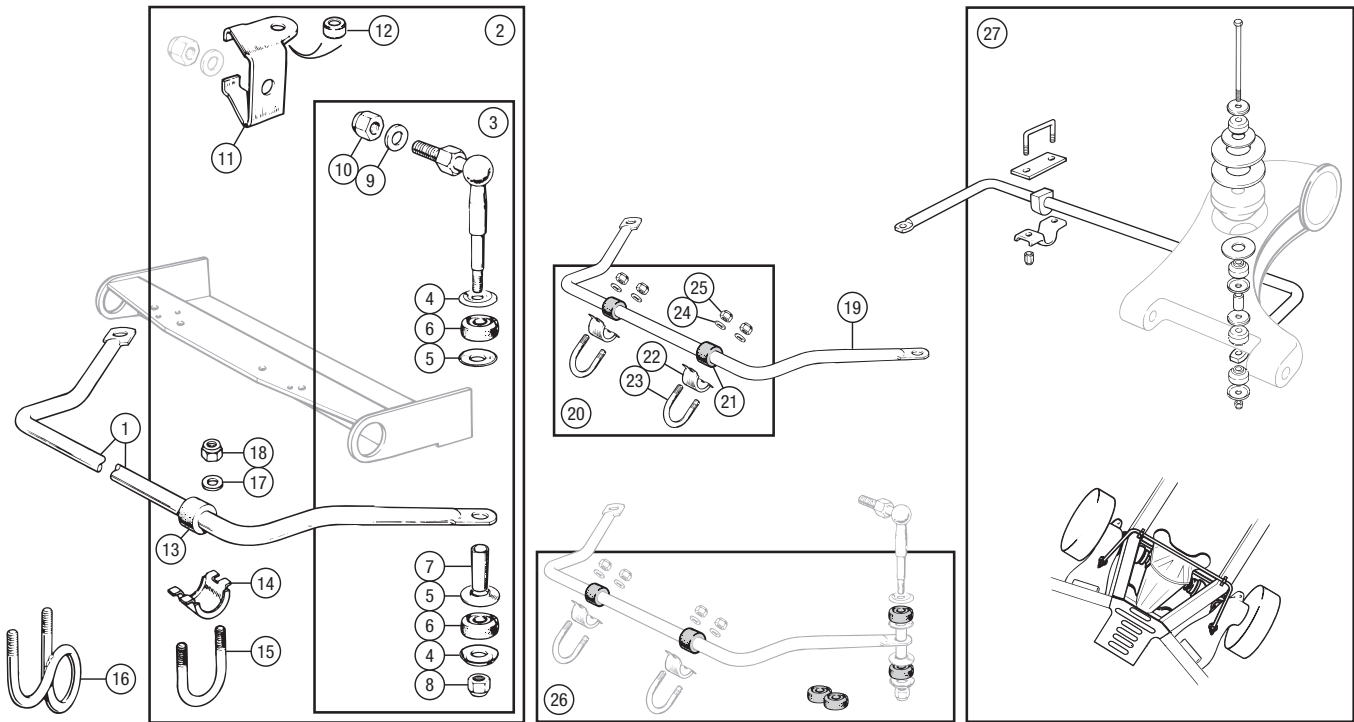
These kits include all necessary bolts, nuts and washers to install poly bush kits listed above (N.B. excludes special washers which are assumed to be re-used).

|                                   |  |          |
|-----------------------------------|--|----------|
| SUSPENSION BOLT KIT;              |  |          |
| Front                             |  | RR1418FK |
| Rear                              |  | RR1419FK |
| Car Set, front & rear (see photo) |  | RR1420FK |

### Polyurethane Individual Bushes

|                                  |   |   |                |
|----------------------------------|---|---|----------------|
| 36                               | POLYURETHANE BUSH, upper wishbone                                   | 4 | 102228POLY     |
| Each replaces 2 original bushes. |   |   |                |
| 37                               | POLYURETHANE BUSH, lower inner wishbone                             | 4 | 141481POLY     |
| 38                               | POLYURETHANE BUSH, rear trailing arm                                | 4 | 137599POLY     |
| 39                               | POLYURETHANE BUSH, front anti-roll bar; for standard 0.75" dia. bar | 2 | 123998POLYTR   |
|                                  | for uprated 0.875" dia. bar   | 2 | 155310POLYSPIT |
| 40                               | POLYURETHANE BUSH, anti-roll bar end link                           | 4 | 517985POLY     |
| 41                               | POLYURETHANE BUSH, front damper, upper                              | 4 | 152588POLY     |
| 42                               | POLYURETHANE BUSH, front damper, lower                              | 2 | 119450POLY     |
| 43                               | POLYURETHANE BUSH, cone, rear axle mount, front                     | 2 | 134235POLY     |
| 44                               | POLYURETHANE BUSH, cup, rear axle mount, front                      | 2 | 134236POLY     |
| 45                               | POLYURETHANE BUSH, rear shock link                                  | 4 | 152588POLY     |
| 46                               | POLYURETHANE SPRING SEAT, front                                     | 4 | 100751POLY     |
| 47                               | POLYURETHANE SPRING SEAT, rear                                      | 4 | 138823POLY     |







| No. | DESCRIPTION | QTY REQ. | PART No. |
|-----|-------------|----------|----------|
|-----|-------------|----------|----------|

| No. | DESCRIPTION | QTY REQ. | PART No. |
|-----|-------------|----------|----------|
|-----|-------------|----------|----------|

| No. | DESCRIPTION | QTY REQ. | PART No. |
|-----|-------------|----------|----------|
|-----|-------------|----------|----------|

## ALL MODELS

### Steel Wheels

|    |   |        |                  |
|----|---|--------|------------------|
| 1  | STEEL ROAD WHEEL;<br>4 J x 15"<br>TR2, TR3 to TS13045   | 5      | 301672           |
|    | 4 1/2 J x 15"<br>TR3 from TS13046, TR3A, TR4, TR4A  | 5      | 302262           |
|    | 5 J x 15"<br>TR5, TR250.  | 5      | 308288           |
| 2  | NUT, road wheel attachment  | 16     | 109586           |
| 3  | NUT SET, wheel, car set of 16   | 1      | 109586K          |
| 4  | HUB CAP,<br>TR2, TR3, TR3A, TR4, TR4A   | 4      | 201870           |
| 5  | BADGE, hub cap;<br>TR2, TR3, early TR3A; includes nut and washer.<br>enamelled finish<br>painted finish | 4<br>4 | 101042<br>113256 |
| 6  | NUT, badge securing,<br>TR2, TR3, TR3A, TR4, TR4A   | 4      | HN2005           |
| 7  | WASHER, locking,<br>TR2, TR3, TR3A, TR4, TR4A   | 4      | WL105001         |
| 8  | WHEEL TRIM, hub cap, TR5, TR250   | 4      | 811974           |
| 9  | STUD, wheel;<br>front hub<br>TR2, TR3 to TS13045<br>TR3 from TS13046, TR3A, TR4,<br>TR4A, TR5, TR250    | 8<br>8 | 100869<br>114282 |
|    | rear hub<br>TR2, TR3, TR3A, TR4,<br>TR4A rigid axle   | 8      | 100869           |
|    | TR4A IRS, TR5, TR250  | 8      | 132317           |
| 10 | TRIM RING, chrome<br>TR2, TR3, TR3A, TR4, TR4A optional   | 4      | 502160           |

### Wire Wheels

#### TR2, TR3 to TS13045; 4 J x 15"

|    |                                  |   |        |
|----|----------------------------------|---|--------|
| 11 | WIRE WHEEL;<br>painted, 48 spoke | 5 | XW450S |
|    | chrome, 48 spoke                 | 5 | XW450C |

#### TR3 from TS13046, TR3A, TR4, TR4A, TR5, TR250; 4 1/2 J x 15"

|    |                                  |   |        |
|----|----------------------------------|---|--------|
| 11 | WIRE WHEEL;<br>painted, 60 spoke | 5 | XW452S |
|    | chrome, 60 spoke                 | 5 | XW452C |

#### Optional TR5, TR250; 5 1/2 J x 15"

|    |                                  |   |        |
|----|----------------------------------|---|--------|
| 11 | WIRE WHEEL;<br>painted, 72 spoke | 5 | XW457S |
|    | chrome, 72 spoke                 | 5 | XW457C |

#### Optional TR5, TR250; 5 1/2 J x 15" Centrelace

|    |                                  |   |         |
|----|----------------------------------|---|---------|
| 11 | WIRE WHEEL;<br>painted, 70 spoke | 5 | XW5720S |
|    | chrome, 70 spoke                 | 5 | XW5720C |

|    |   |   |  |
|----|---|---|--|
| 12 | SPOKE;<br>48 spoke wheels<br>outer, painted<br>inner, painted<br>outer, chrome<br>inner, chrome<br>60 spoke wheels<br>outer, painted<br>inner, painted<br>outer, chrome<br>inner, chrome<br>72 spoke wheels<br>outer, painted<br>inner, painted<br>outer, chrome<br>inner, chrome | A/R<br>A/R<br>A/R<br>A/R<br>A/R<br>A/R<br>A/R<br>A/R<br>A/R<br>A/R<br>A/R<br>A/R<br>A/R<br>A/R<br>A/R | 7H1805<br>7H1806<br>7H1805C<br>7H1806C<br>512161<br>512162<br>159411<br>159410<br>27H8503<br>27H8502<br>37H3650<br>37H3649 |
| 13 | NIPPLE, spoke;<br>painted<br>chrome   | A/R<br>A/R  | 149961<br>159397   |
| 14 | TWO-EARED KNOCK CAP/SPINNER;<br>LH<br>RH  | 2<br>2  | KC4282L<br>KC4282R   |
| 15 | OCTAGONAL KNOCK-CAP/SPINNER;<br>LH<br>RH  | 2<br>2  | KC4280L<br>KC4280R   |

|     |  |                  |   |
|-----|--|------------------|---|
| 16  | THREE-EARED KNOCK CAP/SPINNER;<br>LH<br>RH                                   | 2<br>2           | KC4282L-3<br>KC4282R-3                  |
| 17A | SPANNER, octagonal knock-off nut   | 1                | KAS42                                   |
| 17B | SPANNER (WOOD),<br>2 eared knock-off nut<br>Avoids damage from hammer blows. | 1                | AHH5839W                                |
| 18  | HAMMER, knock cap/spinner<br>copper/hide<br>lead<br>copper                   | 1<br>1<br>1<br>1 | KACH100<br>88G329<br>11B5166<br>KACB101 |
| 19  | CLEANER BRUSH  | 1                | KACB101                                 |

#### TR2, TR3 to TS13045

|    |   |                  |                                      |
|----|---|------------------|--------------------------------------|
| 20 | HUB ASSEMBLY, wire wheel;<br>front, LH<br>front, RH<br>rear, LH<br>rear, RH | 1<br>1<br>1<br>1 | 108278<br>108277<br>109550<br>109551 |
| 21 | TAPER COLLAR, wire wheel  | 4                | 107942                               |

#### TR3 from TS13046, TR3A, TR4, TR4A, TR5, TR250

|    |  |             |                            |
|----|--|-------------|----------------------------|
| 22 | SPLINED EXTENSION, wire wheel;<br>LH<br>RH   | 2<br>2      | 217603<br>217602           |
| 23 | NUT, special, chamfered  | 16          | RSRN716                    |
| 24 | STUD, wheel;<br>front hub<br>rear hub<br>TR3 from TS13046, TR3A, TR4,<br>TR4A rigid axle<br>TR4A IRS, TR5, TR250 | 8<br>8<br>8 | 114281<br>110365<br>142799 |

|    |   |        |                    |
|----|---|--------|--------------------|
| 25 | INNER TUBE;<br>165 x 15" tyre<br>185 x 15" tyre | 5<br>5 | 452-755<br>452-765 |
| 26 | RIM BAND, 15"                                   | 5      | 452-750            |

## Wire Wheel Conversion Kits

You can easily convert your TR to wire wheels with these conversion kits. Note: Lockheed-braked TR2s and TR3s to TS13045 require complete hub changes and therefore can only be converted by purchasing the individual parts required. The 60spoke wheels fitted to later cars are 1/2" wider than the TR2 & TR3 48 spoke wheels. 60 spoke wheels (with correspondingly wider tyres) may be fitted to TR2 & TR3 Lockheed axle cars, but the Lockheed rear hub seal design is weaker than the Girling design and may become prone to more frequent failure (with resultant oil ingress to the rear brakes) with wider wheels and tyres fitted. For later TRs, certain EC countries do not allow the 2-eared knock caps; the octagonal option should be purchased. When fitting wire wheels, check the length of the wheel studs (shorten or purchase the alternative studs) to ensure they do not foul the backs of the wheels.

### WITH 2-EARED SPINNERS

These wire wheel conversion kits, finished in chrome or traditional silver paint, are sold as a set of five wheels complete with splined hubs, bevelled nuts, 2-eared knock caps, hide hammer and a cleaning brush. Note: 3-eared knock caps can be supplemented at additional cost.

|    |   |        |                    |
|----|---|--------|--------------------|
| 27 | WIRE WHEEL KIT;<br>60 spoke wire wheels, 4 1/2 J x 15"<br>CHROME<br>PAINTED | 1<br>1 | RF4093C<br>RF4093P |
|    | 72 spoke wire wheels, 5 1/2 J x 15"<br>CHROME<br>PAINTED                    | 1<br>1 | RR1004C<br>RR1004P |
|    | 70 spoke wire wheels (Centrelace), 5 1/2 J x 15"<br>CHROME<br>PAINTED       | 1<br>1 | RR1383C<br>RR1383P |

### WITH OCTAGONAL SPINNERS

These wire wheel conversion kits, finished in chrome or traditional silver paint, are sold as a set of five wheels complete with splined hubs, bevelled nuts, octagonal knock caps, hide hammer, spanner and a cleaning brush.

|    |   |        |                        |
|----|---|--------|------------------------|
| 28 | WIRE WHEEL KIT;<br>60 spoke wire wheels, 4 1/2 J x 15"<br>CHROME<br>PAINTED | 1<br>1 | RF4093CEC<br>RF4093PEC |
|    | 72 spoke wire wheels, 5 1/2 J x 15"<br>CHROME<br>PAINTED                    | 1<br>1 | RR1004CEC<br>RR1004PEC |
|    | 70 spoke wire wheels (Centrelace), 5 1/2 J x 15"<br>CHROME<br>PAINTED       | 1<br>1 | RR1383CEC<br>RR1383PEC |

## Wire Wheels & Fittings



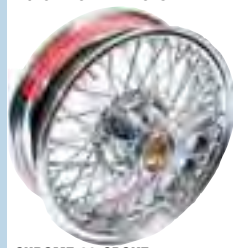
PAINTED 60-SPOKE  
4 1/2 J x 15" - XW452S



PAINTED 72-SPOKE  
5 1/2 J x 15" - XW457S



PAINTED 70-SPOKE 5 1/2 J x 15"  
CENTRELACE - XW5720S



CHROME 60-SPOKE  
4 1/2 J x 15" - XW452C



CHROME 72-SPOKE  
5 1/2 J x 15" - XW457C



CHROME 70-SPOKE 5 1/2 J x 15"  
CENTRELACE - XW5720C



2 EARED (LH)  
KNOCK CAP - KC4282L



3 EARED (LH)  
KNOCK CAP (OPTIONAL)  
- KC4282L-3



OCTAGONAL (LH)  
KNOCK CAP - KC4280L



SPLINED EXTENSION  
(LH) - 217603

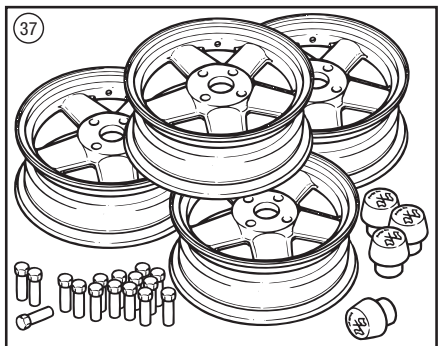
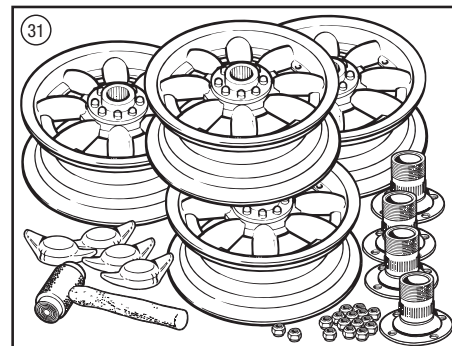
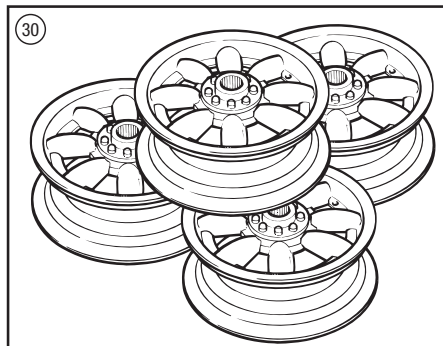
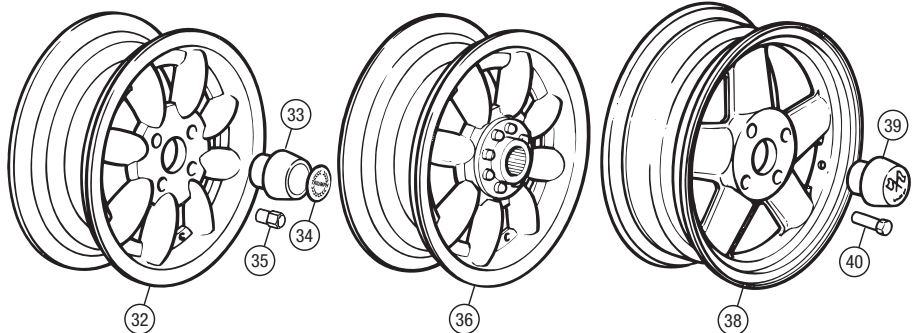
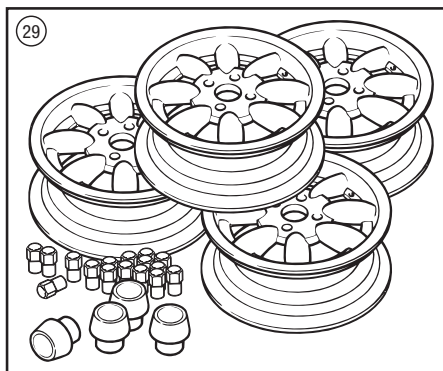
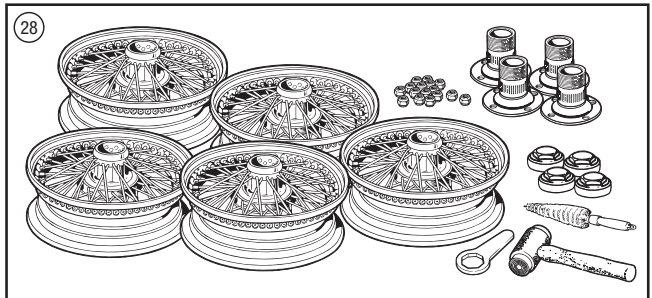
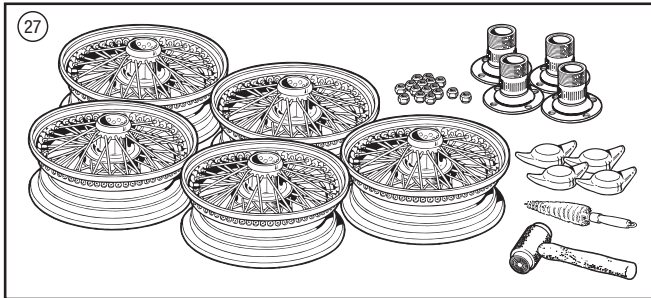
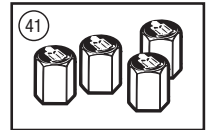
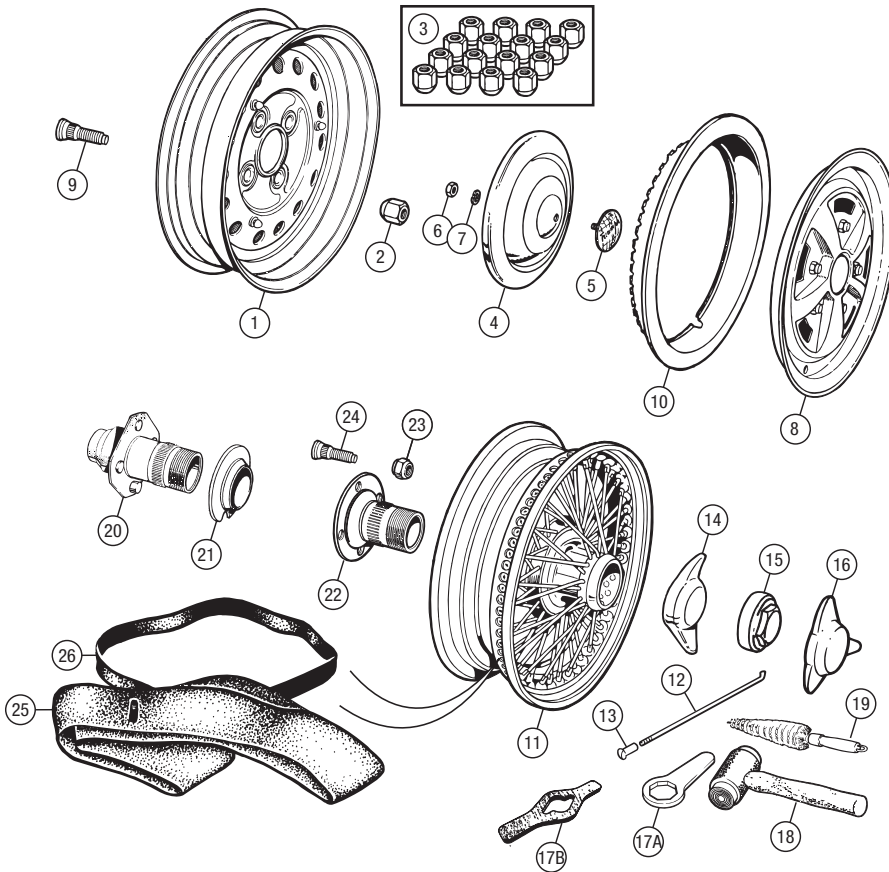


WIRE WHEEL CHROME  
CONVERSION KIT  
(5 1/2 J x 15") WITH  
2-EARED KNOCK CAPS  
& FITTINGS - RR1004C



ALL MODELS

ROAD WHEELS - ALL MODELS



ORDER BY PHONE: 01522 568000 / ON LINE: [www.rimmerbros.co.uk](http://www.rimmerbros.co.uk) / E-MAIL: [sales@rimmerbros.co.uk](mailto:sales@rimmerbros.co.uk)



## ALL MODELS

# ROAD WHEELS - ALL MODELS

## Classic 8 Spoke Alloy Road Wheels

As an attractive alternative to the standard steel wheels or wire wheels, consider a set of Classic 8 Spoke alloy road wheels. Made from aluminium, the bolt-on wheels (available as 5.5J x 15" or 6J x 15") will fit directly in place of the steel wheels (with corresponding wheel nuts). The centre-lock type (available as 5.5J x 15") will fit existing wire wheel splines and centre-knock caps and can also be purchased as a conversion kit if so desired.

### BOLT-ON ALLOY WHEEL SET

Includes 4 silver alloy wheels, centres and nuts.

|               |   |               |
|---------------|---|---------------|
| 29 WHEEL SET; |   |               |
| 5.5J x 15"    | 1 | RR1344-5.5X15 |
| 6J x 15"      | 1 | RR1344-6X15   |

### CENTRE-LOCK ALLOY WHEEL SET

Includes 4 silver centre-lock alloy wheels only.

Direct replacement for fitted wire wheels

|                          |   |        |
|--------------------------|---|--------|
| 30 WHEEL SET, 5.5J x 15" | 1 | RR1345 |
|--------------------------|---|--------|

### CENTRE-LOCK ALLOY WHEEL CONVERSION KITS

Includes 4 silver centre-lock alloy wheels, splined hubs, bevelled nuts, 2-eared or octagonal knock caps and hide hammer. The octagonal kits also include a spanner.

|                                      |   |           |
|--------------------------------------|---|-----------|
| 31 WHEEL CONVERSION SET, 5.5J x 15"; |   |           |
| with 2-eared knock caps              | 1 | RR1346S   |
| with octagonal knock caps            | 1 | RR1346ECS |

### INDIVIDUAL ITEMS:

|  |    |               |
|--|----|---------------|
| 32 ALLOY WHEEL, Classic 8 Spoke, silver, bolt-on, includes centre; |    |               |
| 5.5J x 15"   | 5  | RR1347-5.5X15 |
| 6J x 15"   | 5  | RR1347-6X15   |
| 33 WHEEL CENTRE, bolt-on alloy wheel;                              |    |               |
| metal version  | 5  | RL1472ALLOY   |
| plastic alternative  | 5  | RL1472PLASTIC |
| 34 BADGE, 'Triumph', wheel centre                                  | 5  | RL1472BADGE   |
| Self adhesive.   |    |               |
| 35 WHEEL NUT;  |    |               |
| bolt-on alloy wheel  | 16 | RR1343        |
| locking (set of 4)   | 1  | GAC8225XLN    |
| 36 ALLOY WHEEL, Classic 8 Spoke, 5.5J x 15", silver, centre-lock   | 5  | RR1348S       |

Note: for individual splined hubs, bevelled nuts, centre-lock nuts, please refer to 'Wire Wheels'.

## Revolution Alloy Road Wheels

These superb 5 spoke alloy road wheels will complement any TR. The spokes are finished in black, while the rims are diamond-turned for a mirror finish. We supply as standard 6J x 15" for all road uses, although 7J x 15" are also available to special order for modified applications and are not, therefore, a direct fit to standard cars.

### BOLT-ON ALLOY WHEEL SET

Includes 4 wheels, centres and nuts.

|                        |   |        |
|------------------------|---|--------|
| 37 WHEEL SET, 6J x 15" | 1 | RR1523 |
|------------------------|---|--------|

### INDIVIDUAL ITEMS:

|  |    |            |
|--|----|------------|
| 38 ALLOY WHEEL, Revolution, 6J x 15", includes centre. | 5  | RR1524     |
| 39 WHEEL CENTRE  | 5  | RR1525     |
| 40 WHEEL NUT;  |    |            |
| bolt-on alloy wheel                                    | 16 | RR1526     |
| locking (set of 4)                                     | 1  | GAC8225XLN |

## Accessories

|  |   |            |
|--|---|------------|
| 41 VALVE CAP SET, Triumph logo               | 1 | HMP190129  |
| 42 TYRE TRIM SET, 15", white wall (set of 4) | 1 | GLZ227WWX4 |
| 43 TYRE TRIM, 15";                           |   |            |
| white wall (each)                            | 4 | GLZ227WW   |
| red line (set of 4)                          | 1 | GLZ227RLX4 |
| red line (each)                              | 4 | GLZ227RL   |

## Classic 8 Spoke Wheels



**BOLT-ON ALLOY WHEEL**  
5.5J x 15" OR  
6J x 15" SIZES  
- RR1347

**CENTRE LOCK ALLOY WHEEL**  
5.5J x 15"  
- RR1348

**BOLT-ON ALLOY WHEEL SET INC. NUTS & CENTRES**  
5.5J x 15" OR  
6J x 15" SIZES  
- RR1344

**CENTRE LOCK ALLOY WHEEL CONVERSION KIT INC. ALL FITTINGS**  
- RR1346  
AVAILABLE WITH  
EITHER 2-EARED  
KNOCK CAPS  
OR OCTAGONAL  
KNOCK CAPS.

**ALSO AVAILABLE AS 4 WHEELS ONLY**  
- RR1345  
IF WIRE WHEELS ARE  
ALREADY FITTED.  
5.5J x 15".



**BOLT-ON ALLOY WHEEL**  
6J x 15"  
- RR1524

## Revolution Alloy Road Wheels

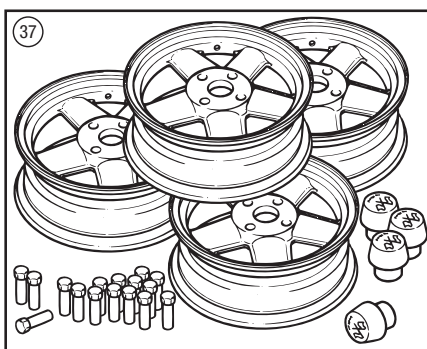
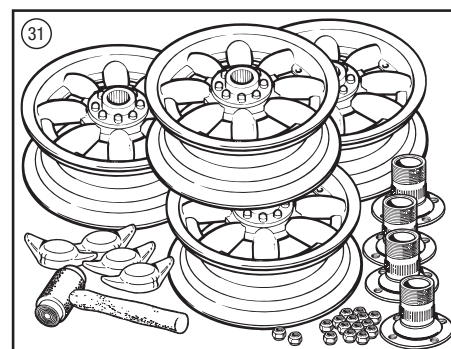
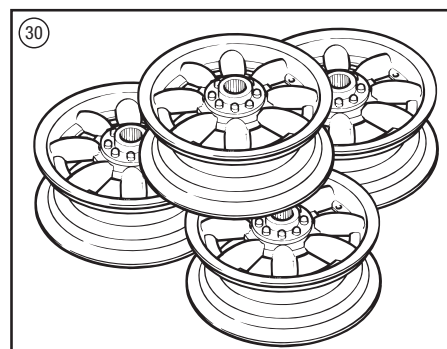
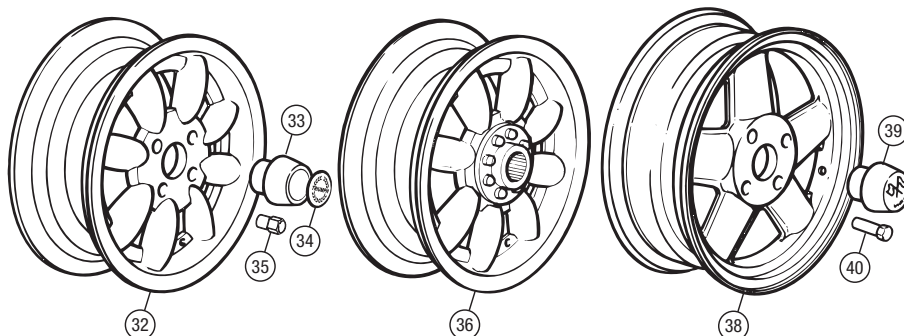
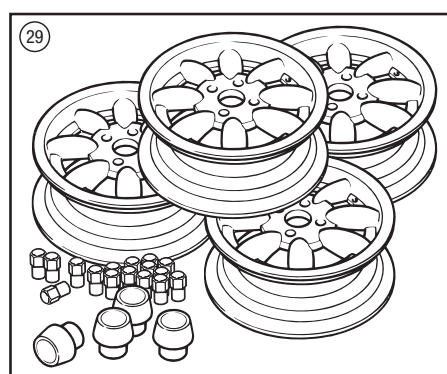
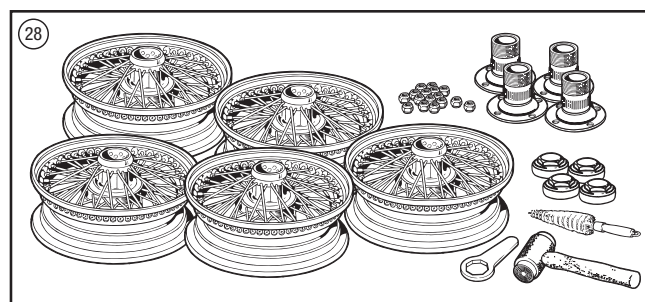
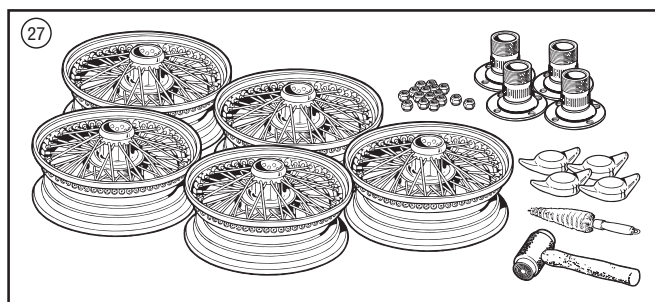
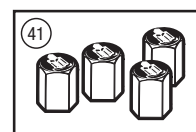
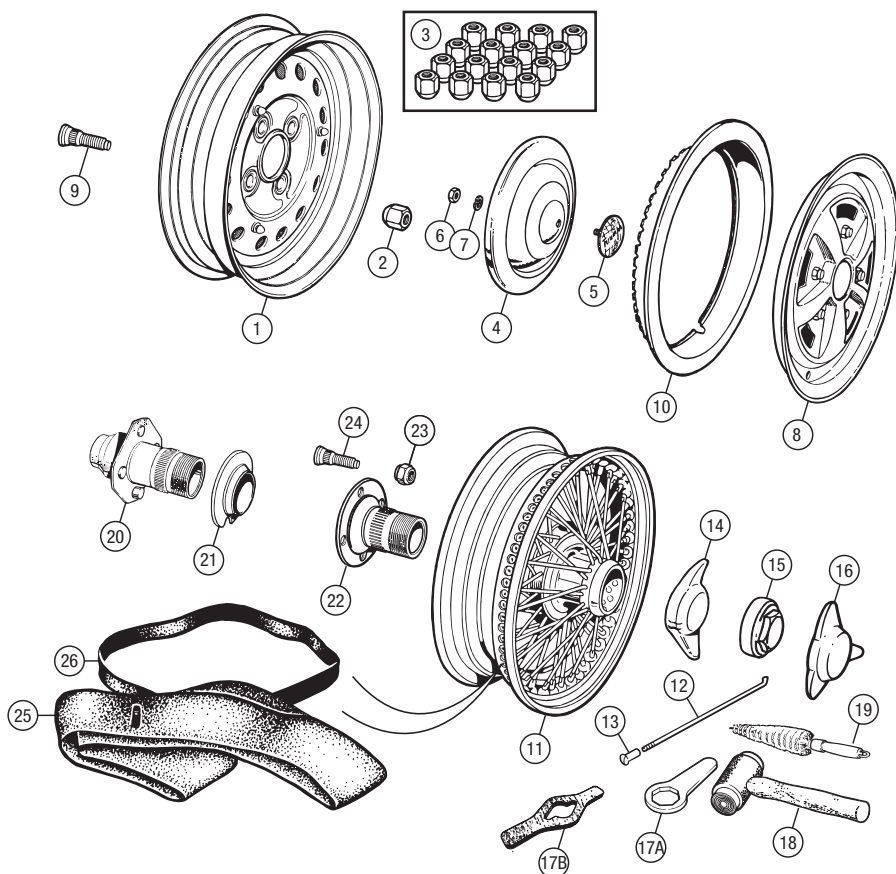


**BOLT-ON ALLOY WHEEL SET INC. NUTS & CENTRES**  
6J x 15"  
- RR1523



ALL MODELS

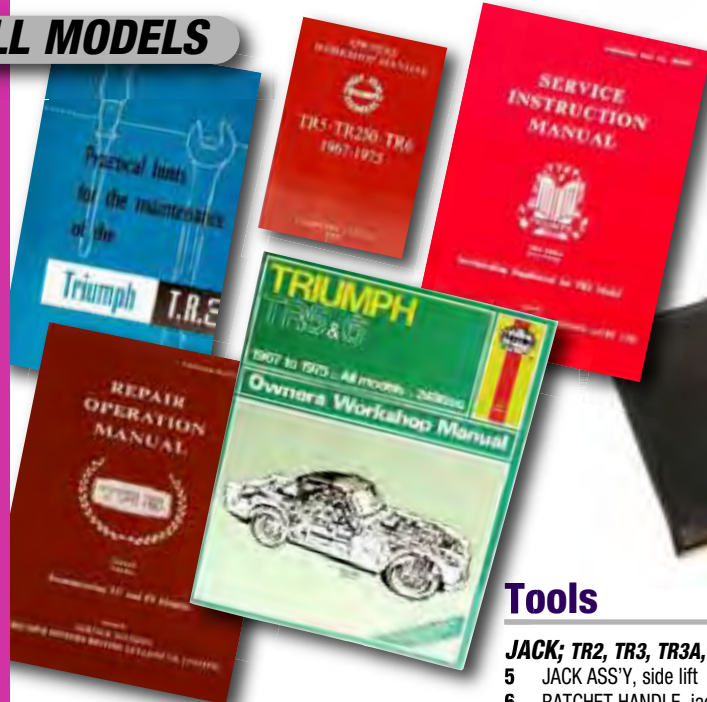
ROAD WHEELS - ALL MODELS





## ALL MODELS

# MANUALS & TOOLS - ALL MODELS



SEE  
ACCESSORIES  
FOR  
MORE TOOLS



JACK, HANDLE, WHEEL BRACE  
& HARDURA BAG KIT - RS2014



## Manuals

|   |  |   |           |
|---|--|---|-----------|
| 1 | DRIVER'S HANDBOOK;<br>TR2                            | 1 | 501528/1  |
|   | TR3  | 1 | 501528/2  |
|   | TR3A   | 1 | 501528/3  |
|   | TR4  | 1 | 510326    |
|   | TR4A   | 1 | 512916    |
|   | TR5  | 1 | 545034    |
|   | TR250  | 1 | 545033    |
| 2 | WORKSHOP MANUAL, factory;<br>TR2, TR3, TR3A          |   |           |
|   | hard cover   | 1 | 502602    |
|   | paperback  | 1 | 502602SC  |
|   | TR4, TR4A  | 1 | 510322    |
|   | WORKSHOP MANUAL SUPPLEMENT,<br>factory, TR5          | 1 | 545053    |
|   | WORKSHOP MANUAL;<br>factory, TR250, TR6 Carb, TR6 PI | 1 | 545277    |
|   | Haynes   |   |           |
|   | TR2, TR3, TR3A, TR4, TR4A                            | 1 | RF4128    |
|   | TR6  | 1 | RR1020    |
|   | SU carburettors                                      | 1 | RO1135    |
|   | Weber, Zenith,<br>Stromberg carburettors             | 1 | RX1412    |
| 3 | WORKSHOP MANUAL, pocket size<br>TR5, TR250, TR6      | 1 | 545277HBS |
| 4 | SPARE PARTS CATALOGUE, factory;<br>TR2, TR3, TR3A    |   |           |
|   | hard cover   | 1 | 501653    |
|   | paperback  | 1 | 501653SC  |
|   | TR4  | 1 | 510978    |
|   | TR4A   | 1 | 514837    |
|   | TR5  | 1 | 516915    |
|   | TR250  | 1 | 516914    |

## Tools

### JACK; TR2, TR3, TR3A, TR4

|   |                       |   |        |
|---|-----------------------|---|--------|
| 5 | JACK ASS'Y, side lift | 1 | 110774 |
| 6 | RATCHET HANDLE, jack  | 1 | 121790 |

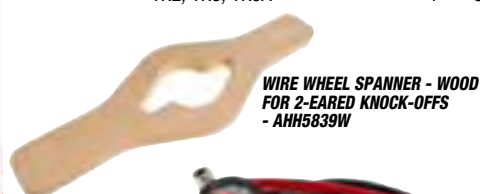
### JACK; TR4A, TR5, TR250

|    |  |   |        |
|----|--|---|--------|
| 7  | JACK, HANDLE, WHEEL BRACE<br>& HARDURA BAG KIT<br><i>Kit comprises 311346 jack (with handle),<br/>138514 brace and RX1364 Hardura bag.</i> | 1 | RS2014 |
| 8  | SCISSOR JACK ASS'Y, replacement<br><i>Includes handle.</i>   | 1 | 311346 |
| 9  | WHEEL BRACE, simple type   | 1 | 138514 |
| 10 | WHEEL BRACE, combination type<br>TR2, TR3, TR3A, TR4, TR4A   | 1 | 516677 |
| 11 | WHEEL BRACE, combination type<br>TR5, TR250  | 1 | 59428  |
| 12 | COMBINATION TOOL, hubcap removal<br>TR2, TR3, TR3A, TR4, TR4A  | 1 | 509816 |
| 13 | COMBINATION TOOL, hubcap removal<br>TR5, TR250   | 1 | 129833 |
| 14 | TOOL & JACK BAG, 'Hardura'   | 1 | RX1364 |
| 15 | TOOL POUCH, 'Hardura'  | 1 | 725793 |



COPPER/HIDE WHEEL  
HAMMER - KACH100

|    |  |   |         |
|----|--|---|---------|
| 16 | WHEEL HAMMER, copper/hide                    | 1 | KACH100 |
| 17 | WHEEL HAMMER, lead                           | 1 | 88G329  |
| 18 | WHEEL HAMMER, copper                         | 1 | 11B5166 |
| 19 | SPANNER, octagonal knock-off removal         | 1 | KAS42   |
| 20 | STARTING HANDLE;<br>TR2, TR3                 | 1 | 107863  |
|    | TR3A   | 1 | 118366  |
|    | TR4  | 1 | 131818  |
| 21 | SCREW, front hub grease cap removal          | 1 | HU508   |
| 22 | SPARK PLUG SPANNER                           | 1 | GAT140  |
| 23 | 'T' HANDLE, Dzus fasteners<br>TR2, TR3, TR3A | 1 | 650161  |



WIRE WHEEL SPANNER - WOOD  
FOR 2-EARED KNOCK-OFFS  
- AHH5839W

## Misc Tools

### WHEELS & BOOT

|     |  |   |          |
|-----|--|---|----------|
| 24  | WIRE WHEEL SPANNER, improved<br><i>Octagonal knock-offs.</i>                                 | 1 | RX1499   |
| 25A | WIRE WHEEL SPANNER, improved<br><i>2-eared knock-offs.</i>                                   | 1 | RX1498   |
| 25B | WIRE WHEEL SPANNER (WOOD)<br><i>2-eared knock-offs.<br/>Avoids damage from hammer blows.</i> | 1 | AHH5839W |
| 26  | CLOTH COVER, wire wheel spanner<br><i>For wire wheel spanners RX1499 &amp; RX1498.</i>       | 1 | RX1434   |
| 27  | BRUSH, wire wheel cleaning   | 1 | KACB101  |
| 28  | SPOKE SPANNER, wire wheel  | 1 | RX1435   |
| 29  | TYRE FOOT PUMP, double barrel  | 1 | GAT347   |
| -   | AIR COMPRESSOR;<br><i>Plugs into cigar lighter.<br/>standard</i>                             | 1 | RX1580   |
|     | heavy duty   | 1 | RX1580HD |
| 30  | STRAP, tyre lifting  | 1 | JRC7954  |
| 31  | GREASE GUN   | 1 | RX1423   |

### ENGINE, CLUTCH & GEARBOX

|    |                                 |   |           |
|----|---------------------------------|---|-----------|
| 32 | JUG SET, three sizes, 'Castrol' | 1 | RX1398    |
| 33 | OIL JUG, 1/2 pint, 'Castrol'    | 1 | RX1395    |
| 34 | OIL JUG, 1 pint, 'Castrol'      | 1 | RX1396    |
| 35 | OIL JUG, 2 pints, 'Castrol'     | 1 | RX1397    |
| 36 | CLUTCH ALIGNMENT TOOL           | 1 | RX1389    |
| 37 | VALVE SPRING COMPRESSOR         | 1 | RX12260HV |

CLUTCH ALIGNMENT  
TOOL - RX1389



### SUSPENSION

|    |                              |   |         |
|----|------------------------------|---|---------|
| 38 | FRONT COIL SPRING COMPRESSOR | 1 | GAC5076 |
|----|------------------------------|---|---------|

### TRIM & BODY

|    |  |   |          |
|----|--|---|----------|
| 39 | TWO PIECE HOOD BUTTON TOOL<br><i>To fit male and female 'Durable Dot' fasteners to hoods<br/>and tonneau covers.</i> | 1 | RX1342   |
| 40 | TWO PIECE SAIL EYELET TOOL<br><i>To fit sail eyelets to tonneau covers.</i>  | 1 | RX1384   |
| 41 | TENAX FASTENER TOOL<br><i>To fit 'Tenax' fasteners to hoods.</i>   | 1 | GAC5063X |



TWO PIECE HOOD  
BUTTON TOOL -  
RX1342

### SAFETY ITEMS

|    |                                |   |          |
|----|--------------------------------|---|----------|
| 42 | REFLECTIVE SAFETY TRIANGLE     | 1 | RX1344   |
| 43 | FIRST AID KIT                  | 1 | RX1399   |
| 44 | FIRE EXTINGUISHER              | 1 | GAC9904X |
| 45 | SAFETY JACKET, high visibility | 1 | GAC2999  |

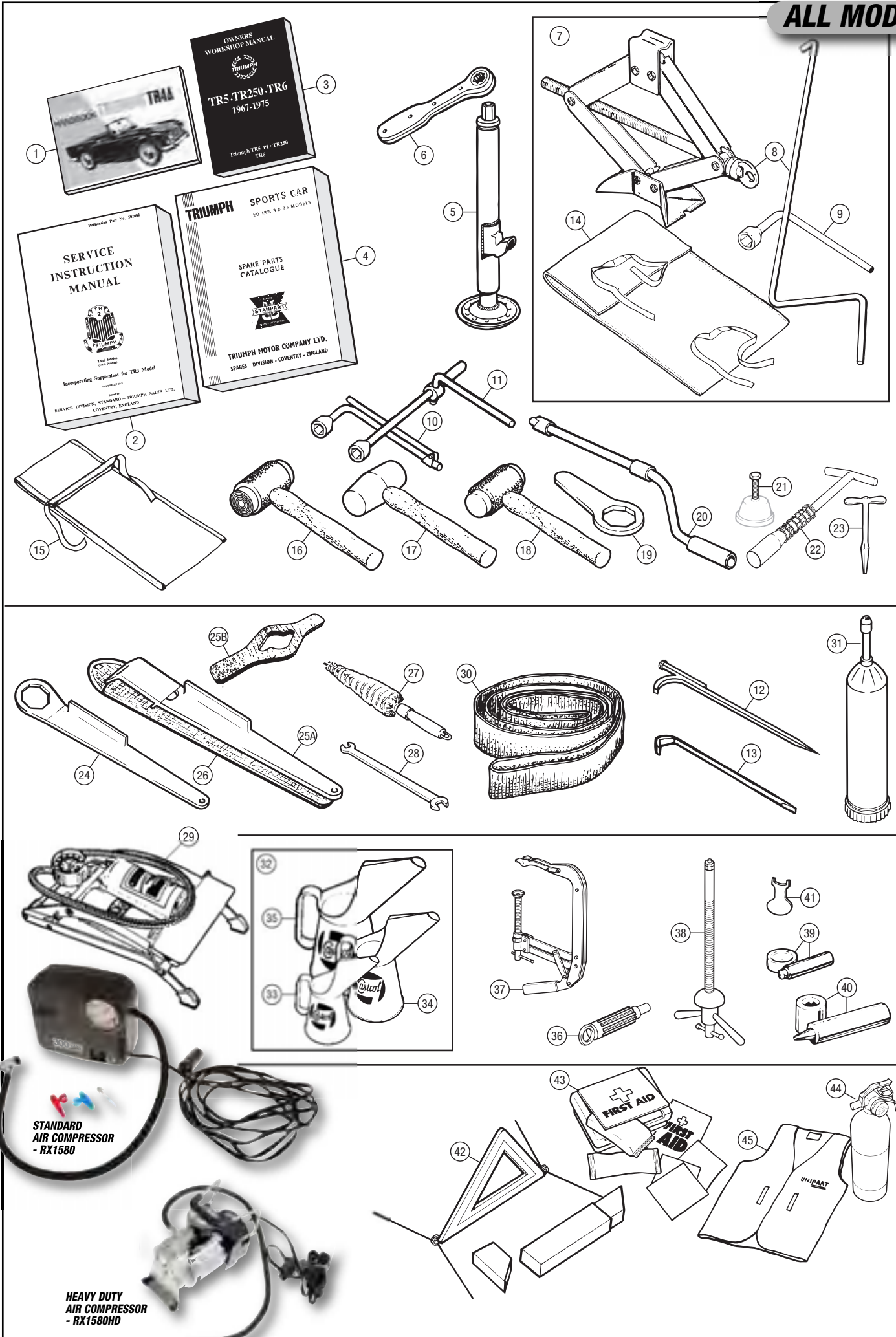


REFLECTIVE SAFETY  
TRIANGLE - RX1344



FOOT PUMP  
(DOUBLE BARREL)  
- GAT347







| No. | DESCRIPTION | QTY REQ. | PART No. |
|-----|-------------|----------|----------|
|-----|-------------|----------|----------|

| No. | DESCRIPTION | QTY REQ. | PART No. |
|-----|-------------|----------|----------|
|-----|-------------|----------|----------|

| No. | DESCRIPTION | QTY REQ. | PART No. |
|-----|-------------|----------|----------|
|-----|-------------|----------|----------|

## ALL MODELS

## Front Drum Brakes

## LOCKHEED DRUM BRAKES

## TR2, TR3 to TS13045

|    |  |   |           |
|----|--|---|-----------|
| 1  | BRAKE DRUM, front, 10" (Sold each)   | 2 | 301126    |
| 2  | AI-FIN BRAKE DRUM, 10"<br><i>Circumferential fins; sold each.</i>  | 2 | 301590    |
| 3  | SCREW, drum retaining  | 4 | V5435     |
| 4  | SHOE SET, front, 10"<br><i>Reconditioned exchange.</i>   | 1 | LKKB1010R |
| 5  | SPRING, brake return   | 4 | 7H7936    |
| 6  | WHEEL CYLINDER;<br>RH  | 2 | GWC110    |
|    | LH   | 2 | GWC111    |
| 7  | REPAIR KIT   | 4 | 8G8245    |
| 8  | PISTON ASSEMBLY  | 4 | 7H7941    |
| 9  | SCREW, 5/16"   | 4 | SH605051  |
| 10 | WASHER, locking, 5/16"   | 4 | GHF332    |
| 11 | SCREW, 1/4"  | 4 | SH604031  |
| 12 | WASHER, locking, 1/4"  | 4 | GHF331    |
| 13 | BLEED NIPPLE   | 2 | 3H2428    |
| 14 | ADJUSTER   | 4 | 7H7931    |
| 15 | MASK, adjuster   | 4 | AAA421    |
| 16 | BRIDGE PIPE, between cylinders<br><i>The bridge pipe is part of the brake pipe kit - see 'Brake Pipes and Clutch Pipes' section.</i> | 2 | -         |
| 17 | SCREW, grease catcher retaining  | 8 | TR6504    |
| 18 | NUT, plain   | 8 | HN2005    |
| 19 | WASHER, locking  | 8 | WL105001  |
| 20 | BACKPLATE;<br>RH   | 1 | 201768    |
|    | LH   | 1 | 201769    |
| 21 | GREASE CATCHER   | 2 | 106542    |

## Brake Discs

|    |  |     |           |
|----|--|-----|-----------|
| 22 | BRAKE DISC - STANDARD;<br>11"  | 2   | 203189    |
|    | <i>Use with Type A solid or Type B split calipers.</i>   |     |           |
|    | 10 13/16"  | 2   | 209327    |
|    | <i>Use with Type 16P, 16PB or M16P calipers.</i>   |     |           |
| 23 | UPRATED BRAKE DISC SET;<br>10 13/16", uprated  | 1   | 209327UR  |
|    | <i>EBC Turbo Groove. Sold as matched pair; use with Type 16P, 16PB or M16P calipers.</i>         |     |           |
|    | 10 13/16", uprated   | 1   | 209327ROS |
|    | <i>Rossini Performance Type. Sold as matched pair; use with Type 16P, 16PB or M16P calipers.</i> |     |           |
| 24 | BOLT, disc to front hub  | 8   | 113150    |
| 25 | WASHER, locking, for bolt  | 8   | GHF333    |
| 26 | BOLT, caliper mounting;<br>imperial (all caliper types except M16P)                              | 4   | 113142    |
|    | metric (M16P calipers only)  | 4   | 158668    |
| 27 | WASHER, locking caliper bolt:<br>all caliper types except M16P                                   | 4   | WL600071  |
|    | M16P calipers only   | 4   | GHF335    |
| 28 | LOCKTAB  | 2   | 560199    |
|    | <i>Alternative to locking washer for all caliper types except M16P.</i>                          |     |           |
| 29 | SHIM, caliper mounting<br><i>Use to centralize the calipers to disc.</i>                         | A/R | 115682    |

## DUST COVERS;

## TR3, TR3A, TR4 to CT4689 (wire wheels) and CT4387 (steel wheels)

|    |  |   |        |
|----|--|---|--------|
| 30 | DUST COVER ASSEMBLY;<br>RH   | 1 | 204378 |
|    | LH   | 1 | 204379 |
|    | <i>TR4 from CT4690 to CT16462 (wire wheels) and CT4388 to CT16249 (steel wheels)</i> |   |        |
| 30 | DUST COVER ASSEMBLY;<br>RH   | 1 | 211804 |
|    | LH   | 1 | 211805 |
|    | <i>TR4 from CT16463 on (wire wheels) and CT16250 on (steel wheels)</i>               |   |        |
| 30 | DUST COVER ASSEMBLY;<br>RH   | 1 | 209325 |
|    | LH   | 1 | 209326 |
|    | <i>TR4A, TR5, TR250</i>  |   |        |
| 30 | DUST COVER ASSEMBLY;<br>RH   | 1 | 307226 |
|    | LH   | 1 | 307227 |
| 31 | BRACKET, brake hose  | 2 | 141124 |

The TR has what can be best described as interchangeable brakes. It is not uncommon for TR2s and TR3s to have been modified with disc brakes, or a TR3A to be fitted with TR6 brakes. If in any doubt, do not just go by the commission number of your car, have a look at what is fitted before you order spares.

## Brake Calipers

We advise very strongly against splitting calipers for any reason by anyone other than a brake specialist with the correct reassembly specifications to hand.

## GIRLING TYPE 'A' SOLID CALIPERS - FIRST TYPE

## TR3 from TS13046, TR3A to TS56376 (wire wheels) TS56383 (steel wheels)

|    |  |   |          |
|----|--|---|----------|
| 32 | CALIPER ASSEMBLY, reconditioned, exchange;<br><i>TR3 from TS13046, TR3A to TS56376.</i>            |   |          |
|    | RH   | 1 | 203544R  |
|    | LH   | 1 | 203543R  |
| 33 | REPAIR KIT (Repairs 2 calipers)  | 1 | 601960   |
| 34 | PAD SET (Car set of pads);<br>standard   | 1 | GBP172   |
|    | uprated (EBC green stuff)  | 1 | GBP172GS |
| 35 | PISTON;<br>standard  | 4 | 510792   |
|    | stainless steel (Alternative)  | 4 | 510792SS |
| 36 | PLATE, pad retaining   | 4 | 504833   |
| 37 | SPRING, anti-rattle  | 4 | 119245   |
| 38 | SCREW, for plate & spring  | 4 | SH604041 |
| 39 | WASHER, locking  | 4 | GHF331   |
| 40 | BLEED NIPPLE   | 2 | 601959   |
| 41 | CAP, bleed nipple  | 2 | STC1913  |
| 42 | BRIDGE PIPE, across caliper  | 2 | -        |
|    | <i>The bridge pipe is part of the brake pipe kit - see 'Brake Pipes and Clutch Pipes' section.</i> |   |          |

## GIRLING TYPE 'B' SPLIT CALIPERS - SECOND TYPE

## TR3A from TS56377 (wire wheels) and TS56384 (steel wheels), TR3B, All TSF series, TR4 to CT4689 (wire wheels) and CT4387 (steel wheels)

New Type B split calipers are available, alongside reconditioned items. It is important to note that the new calipers are replacement items and while they appear on the surface to be faithful reproductions of the originals, they are in fact designed to accept and are built with later TR6 16PB/M16P caliper type pistons and seals. When the time eventually comes to repair or rebuild them, they will not accept original Type B split caliper pistons and seals and must once again be fitted with later TR6 items. To identify what's on your car, withdraw the brake pads and look at the dust covers around the pistons - large bellows type dust covers indicate original Type B calipers, whereas more compact dust covers retained by steel clips indicate the replacement calipers (see illustration for further clarification).

|    |  |   |         |
|----|--|---|---------|
| 43 | CALIPER ASSEMBLY;<br>RH, new replacement | 1 | 205396  |
|    | RH, reconditioned, exchange              | 1 | 205396R |
|    | LH, new replacement                      | 1 | 205395  |
|    | LH, reconditioned, exchange              | 1 | 205395R |

Historically speaking, the above part numbers are not the correct ones for the Type B split calipers. If you're fond of poring through original factory parts books you'll know that 205395/6 were listed (quite correctly) by Triumph as a second version of Type A non-split calipers and 206506/7 were listed as the Type B split variety. Unfortunately after several decades of most of the classic car marketplace erroneously referring to the Type B split calipers as 205395/6 it's become set in stone and that's the way it will have to stay. If you are still concerned about getting the right calipers for your TR after this explanation, please contact us with details of your car and a description of the calipers fitted and we will ensure the right ones are sent to you.

|    |   |   |          |
|----|---|---|----------|
| 44 | REPAIR KIT;<br>repairs 2 original calipers  | 1 | 601960   |
|    | repairs 2 replacement calipers  | 1 | 519731   |
| 45 | PISTON;<br>for original calipers<br>standard  | 4 | 510792   |
|    | stainless steel (Alternative)   | 4 | 510792SS |
|    | for replacement calipers<br>standard  | 4 | 157685   |
|    | stainless steel (Alternative)   | 4 | 157685SS |
|    | <i>See illustration and note under heading for identification of original and replacement calipers.</i> |   |          |
| 46 | PAD SET (Car set of pads);<br>standard  | 1 | GBP172   |
|    | uprated (EBC green stuff)   | 1 | GBP172GS |
| 47 | PLATE, pad retaining  | 4 | 509051   |
| 48 | SPRING, anti-rattle   | 4 | 509049   |
| 49 | SCREW   | 4 | SH604041 |
| 50 | WASHER, locking   | 4 | GHF331   |
| 51 | BLEED NIPPLE  | 2 | 601959   |
| 52 | CAP, bleed nipple   | 2 | STC1913  |

## GIRLING TYPE 16P CALIPERS - THIRD TYPE

## TR3B, All TCF series, TR4 from CT4690 (wire wheels) &amp; CT4388 (steel wheels), TR4A, TR5, TR250

**Original fitment.** Identified by bellows type dust covers around caliper pistons (see illustration) and imperial threaded mounting bolts.

|    |   |   |          |
|----|---|---|----------|
| 53 | CALIPER ASSEMBLY;<br>RH, new, replacement   | 1 | 307976   |
|    | RH, reconditioned, exchange   | 1 | 307976R  |
|    | LH, new, replacement  | 1 | 307977   |
|    | LH, reconditioned, exchange   | 1 | 307977R  |
| 54 | REPAIR KIT<br>repairs 2 original calipers   | 1 | 601960   |
|    | repairs 2 replacement calipers  | 1 | 519731   |
| 55 | PISTON;<br>for original calipers<br>standard  | 4 | 510792   |
|    | stainless steel (Alternative)   | 4 | 510792SS |
|    | for replacement calipers<br>standard  | 4 | 157685   |
|    | stainless steel (Alternative)   | 4 | 157685SS |
|    | <i>See illustration and note under 'Girling Type B' Split Calipers - Type B' heading for identification of original and replacement calipers.</i> |   |          |
| 56 | PAD SET (Car set of pads);<br>standard  | 1 | GBP132   |
|    | uprated (EBC green stuff)   | 1 | GBP132GS |
| 57 | PAD FITTING KIT (Includes 58, 60)   | 1 | GRPFK1   |
| 58 | SHIM SET, anti-squeal (Includes 59)   | 1 | GRSP2750 |
| 59 | SHIM, anti-squeal   | 4 | 27H2953  |
| 60 | PAD RETAINING KIT (Includes 61, 62)   | 1 | GBK1003  |
| 61 | PIN, pad retaining, 1/4" dia.   | 4 | QP2000   |
| 62 | CLIP, for pin   | 4 | UKC7840  |
| 63 | BLEED NIPPLE  | 2 | 556508A  |
| 64 | CAP, bleed nipple   | 2 | STC1913  |

## GIRLING TYPE 16PB REPLACEMENT CALIPERS

## (TR6 imperial calipers with later seal design)

## TR3B, All TCF series, TR4 from CT4690 (wire wheels) &amp; CT4388 (steel wheels), TR4A, TR5, TR250

**Not original fitment.** Identified by dust covers retained by steel clips around caliper pistons (see illustration) & imperial threaded mounting bolts.

|    |  |   |          |
|----|--|---|----------|
| 65 | CALIPER ASSEMBLY;<br>RH, new           | 1 | 310189   |
|    | RH, reconditioned, exchange            | 1 | 310189R  |
|    | LH, new                                | 1 | 310188   |
|    | LH, reconditioned, exchange            | 1 | 310188R  |
| 66 | REPAIR KIT (Repairs 2 calipers)        | 1 | 519731   |
| 67 | PISTON;<br>standard                    | 4 | 157685   |
|    | stainless steel (Alternative)          | 4 | 157685SS |
| 68 | PAD SET (Car set of pads);<br>standard | 1 | GBP132   |
|    | uprated (EBC green stuff)              | 1 | GBP132GS |
| 69 | PAD FITTING KIT (Includes 70, 72)      | 1 | GRPFK1   |
| 70 | SHIM SET, anti-squeal (Includes 71)    | 1 | GRSP2750 |
| 71 | SHIM, anti-squeal                      | 4 | 27H2953  |
| 72 | PAD RETAINING KIT (Includes 73, 74)    | 1 | GBK1003  |
| 73 | PIN, pad retaining, 1/4" dia.          | 4 | QP2000   |
| 74 | CLIP, for pin                          | 4 | UKC7840  |
| 75 | BLEED NIPPLE                           | 2 | 556508A  |
| 76 | CAP, bleed nipple                      | 2 | STC1913  |

## GIRLING TYPE M16P REPLACEMENT CALIPERS

## (TR6 metric calipers with later seal design)

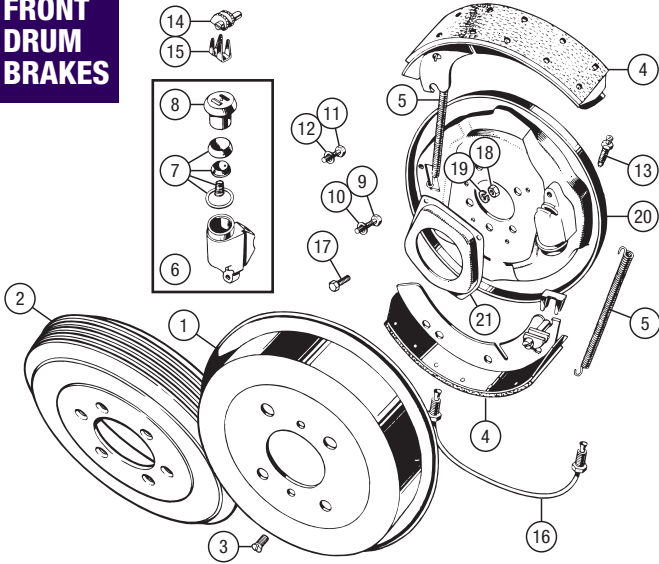
## TR3B, All TCF series, TR4 from CT4690 (wire wheels) &amp; CT4388 (steel wheels), TR4A, TR5, TR250

**Not original fitment.** Identified by dust covers retained by steel clips around caliper pistons (see illustration) & metric threaded mounting bolts.

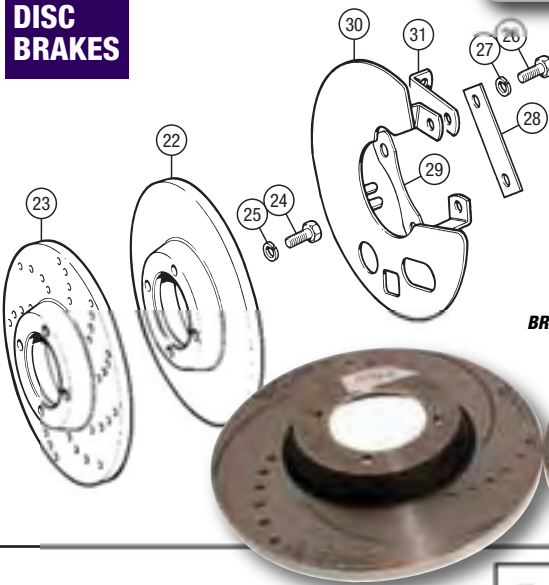
|    |  |   |          |
|----|--|---|----------|
| 65 | CALIPER ASSEMBLY;<br>RH, new           | 1 | 159027   |
|    | RH, reconditioned, exchange            | 1 | 159027R  |
|    | LH, new                                | 1 | 159026   |
|    | LH, reconditioned, exchange            | 1 | 159026R  |
| 66 | REPAIR KIT (Repairs 2 calipers)        | 1 | 519731   |
| 67 | PISTON;<br>standard                    | 4 | 157685   |
|    | stainless steel (Alternative)          | 4 | 157685SS |
| 68 | PAD SET (Car set of pads);<br>standard | 1 | GBP216   |
|    | uprated (EBC green stuff)              | 1 | GBP216GS |
| 69 | PAD FITTING KIT (Includes 70, 72)      | 1 | GRPFK2   |
| 70 | SHIM SET, anti-squeal (Includes 71)    | 1 | GBK1019  |
| 71 | SHIM, anti-squeal                      | 4 | UKC951   |
| 72 | PAD RETAINING KIT (Includes 73, 74)    | 1 | GBK1002  |
| 73 | PIN, pad retaining, 3/16" dia.         | 4 | 521121   |
| 74 | CLIP, for pin                          | 4 | 511032   |
| 75 | BLEED NIPPLE                           | 2 | RTC1115A |
| 76 | CAP, bleed nipple                      | 2 | STC1913  |



## FRONT DRUM BRAKES

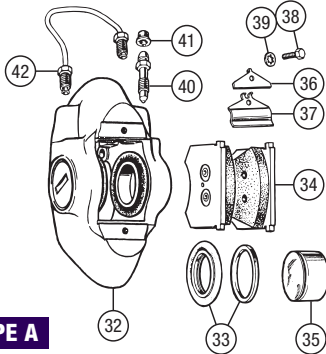


## FRONT DISC BRAKES

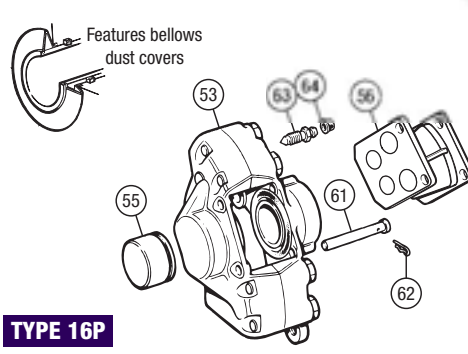


UPDATED  
BRAKE DISC SET -  
209327ROS

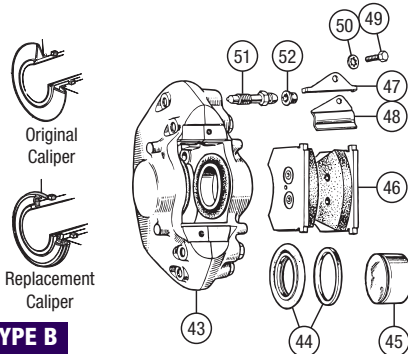
## TYPE A



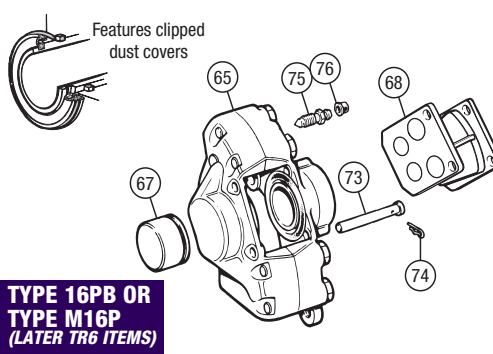
## TYPE 16P



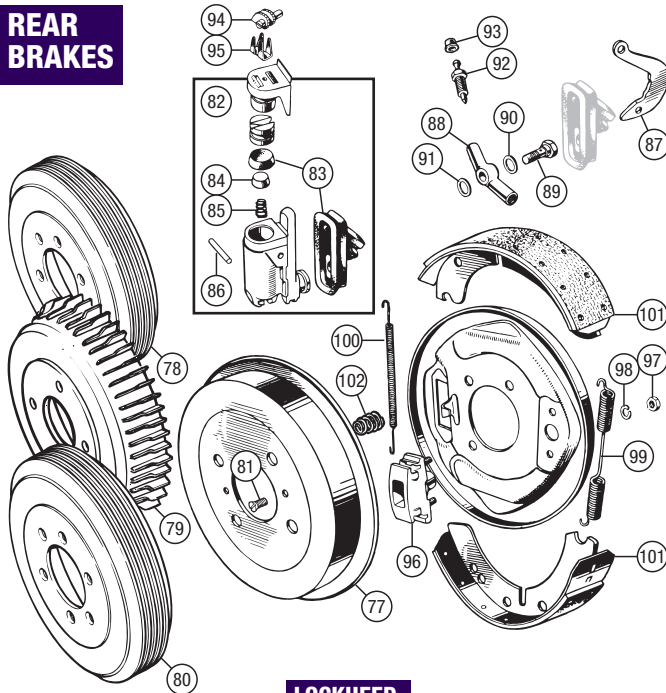
## TYPE B



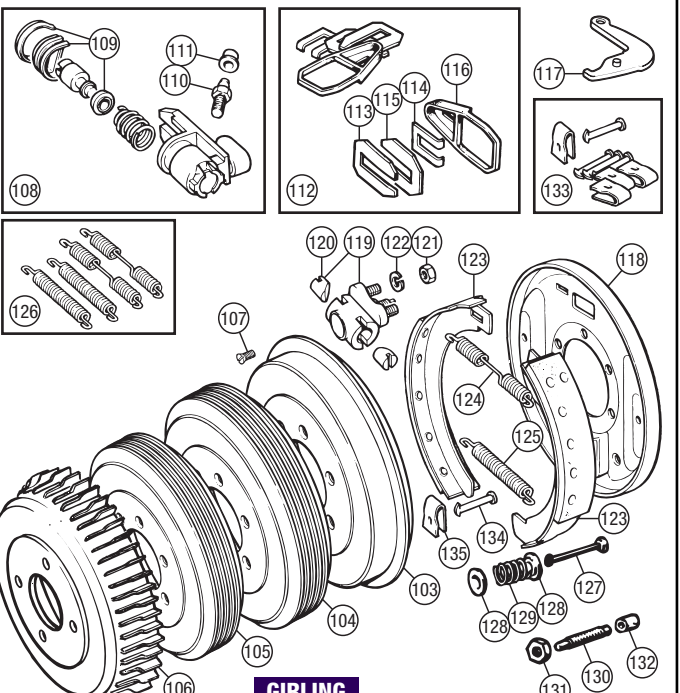
## TYPE 16PB OR TYPE M16P (LATER TR6 ITEMS)



## REAR BRAKES



## LOCKHEED

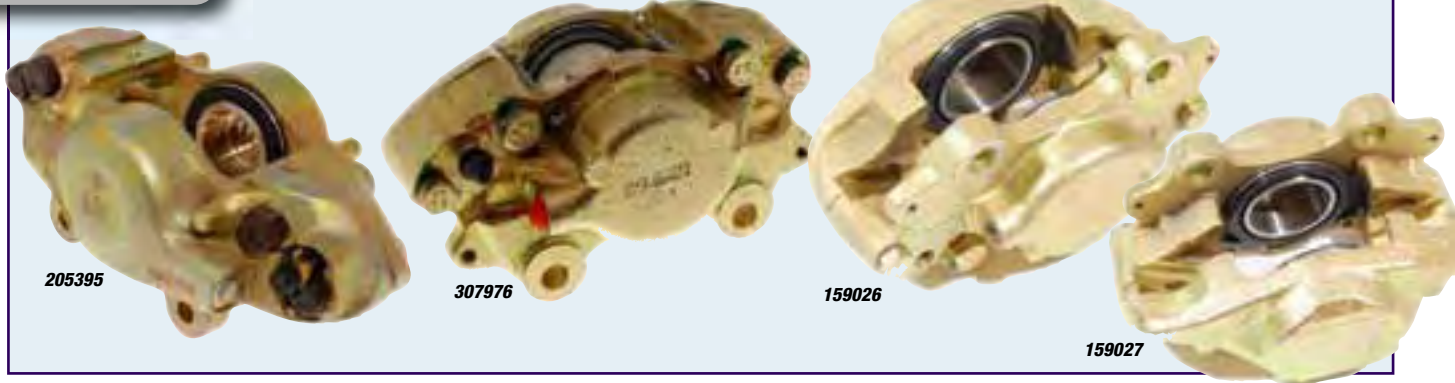


## GIRLING



## ALL MODELS

## NEW BRAKE CALIPERS



## Rear Drum Brakes

### LOCKHEED DRUM BRAKES

#### TR2, TR3 to TS13045

The history: Lockheed 9" x 1 3/4" brakes were fitted to the rear up to TS5442. From TS5443 to TS13045 Lockheed 10" x 2 1/4" were fitted. (Same size as the front)

|     |  |   |           |
|-----|--|---|-----------|
| 77  | BRAKE DRUM, rear;  |   |           |
|     | 9" TR2 to TS5442   | 2 | 210578    |
|     | 10" TR2 from TS5443, TR3 to TS13045  | 2 | 301126    |
| 78  | AI-FIN BRAKE DRUM, 9"  | 2 | 202267    |
|     | TR2 to TS5442. Circumferential fins; sold each.  |   |           |
| 79  | AI-FIN BRAKE DRUM SET, 9"  | 1 | 210578UR  |
|     | TR2 to TS5442. Radial fins; sold as a pair.  |   |           |
| 80  | AI-FIN BRAKE DRUM, 10"   | 2 | 301590    |
|     | TR2 from TS5443, TR3 to TS13045. Circumferential fins; sold each.  |   |           |
| 81  | SCREW, drum retaining  | 4 | V5435     |
| 82  | WHEEL CYLINDER ASSEMBLY  | 2 | GWC1111   |
|     | Gaiter for lever is not included.  |   |           |
|     | Both designs of rear wheel cylinder for Lockheed braked cars have been replaced by GWC1111; as a result, wheel cylinders should always be replaced in pairs. |   |           |
| 83  | REPAIR KIT, wheel cylinder   | 2 | 8G8243    |
|     | Includes gaiter for lever.   |   |           |
| 84  | EXPANDER   | 2 | 102735    |
| 85  | SPRING   | 2 | 102736    |
| 86  | PIN  | 2 | 59263     |
| 87  | LEVER, handbrake cable;  |   |           |
|     | TR2 to TS5442  | 2 | 106240    |
|     | TR2 from TS5443, TR3 to TS13045  | 2 | 110684    |
| 88  | CONNECTOR  | 2 | 59258     |
| 89  | BOLT, banjo  | 2 | 7H7847    |
| 90  | WASHER, bolt to connector  | 2 | 538532    |
| 91  | WASHER, connector to cylinder  | 2 | 233220A   |
| 92  | BLEED NIPPLE   | 2 | 27H7166   |
| 93  | CAP, bleed nipple  | 2 | STC1913   |
| 94  | ADJUSTER   | 2 | 7H7931    |
| 95  | MASK, for adjuster   | 2 | 7H7930    |
| 96  | ABUTMENT ASSEMBLY  | 2 | 7H7932    |
| 97  | NUT, plain   | 4 | AJD8105Z  |
| 98  | WASHER, locking  | 4 | GHF332    |
| 99  | SPRING, abutment end   | 2 | 17H7499   |
| 100 | SPRING, wheel cylinder end   | 2 | 7H7936    |
| 101 | SHOE SET;  |   |           |
|     | 9" dia., rear, new   | 1 | RW3008    |
|     | TR2 to TS5442.   |   |           |
|     | 10" dia., rear, relined  | 1 | LKKB1010R |
|     | TR2 from TS5443, TR3 to TS13045.   |   |           |
| 102 | SPRING, shoe retaining   | 4 | AAA4714   |
|     | TR2 from TS5443, TR3 to TS13045.   |   |           |



AL-FIN BRAKE DRUM SET -  
210578UR (RADIAL FINES)

### GIRLING DRUM BRAKES

#### TR3 from TS13046, TR3A, TR4, TR4A, TR5, TR250

The history: TR3 from TS13046 and TR3A to TS 56376 (approx) was fitted with Girling 10" x 2 1/4" brakes at the rear. From TR3A TS56377 (approx) Girling 9" x 1 3/4" brakes were fitted. The latter remained constant through TR3B, TR4, TR4A, TR250, TR5, TR6. Wheel cylinder piston diameters changed from 3/4" to 5/8" to 0.7". Always ensure cylinder piston diameters match left to right to ensure balanced braking. The diameter of wheel cylinders is changed to vary the force applied to the brake shoes compared to the effort on the front brakes (brake balance). The other variable in this is the shoe friction material performance.

|     |  |   |          |
|-----|--|---|----------|
| 103 | BRAKE DRUM, rear;  |   |          |
|     | 10"  | 2 | 301126   |
|     | TR3 from TS13046, TR3A to TS56376.   |   |          |
|     | 9"   | 2 | 210578   |
|     | TR3A from TS56377, TR3B, TR4, TR4A, TR5, TR250.                                  |   |          |
| 104 | AI-FIN BRAKE DRUM, 10"   | 2 | 301590   |
|     | TR3 from TS13046, TR3A to TS56376. Circumferential fins; sold each.              |   |          |
| 105 | AI-FIN BRAKE DRUM, 9"  | 2 | 202267   |
|     | TR3A from TS56377, TR3B, TR4, TR4A, TR5, TR250. Circumferential fins; sold each. |   |          |
| 106 | AI-FIN BRAKE DRUM SET, 9"  | 1 | 210578UR |
|     | TR3A from TS56377, TR3B, TR4, TR4A, TR5, TR250. Radial fins; sold as a pair.     |   |          |
| 107 | SCREW, drum retaining  | 4 | V5435    |
|     | TR3 from TS13046, TR3A to TS15331; 0.75" bore, flat piston.                      |   |          |
| 108 | WHEEL CYLINDER ASSEMBLY  | 2 | GWC1112  |
| 109 | REPAIR KIT (axle set)  | 1 | 18G9065  |
|     | TR3 from TS15332, TR3A to TS34403; 0.75" bore, slotted piston                    |   |          |
| 108 | WHEEL CYLINDER ASSEMBLY  | 2 | GWC1118  |
| 109 | REPAIR KIT (axle set)  | 1 | 18G9065  |
|     | TR3A from TS34404 to TS56376; original 0.625" bore                               |   |          |
| 108 | WHEEL CYLINDER ASSEMBLY;   |   |          |
|     | original 0.625" bore   | 2 | 119600   |
|     | replacement 0.70" bore   | 2 | GWC1154  |
|     | Note: replace in pairs.  |   |          |
| 109 | REPAIR KIT (axle set) ;  |   |          |
|     | original 0.625" bore   | 1 | GRSP2030 |
|     | replacement 0.70" bore   | 1 | 512351   |
|     | TR3A from TS56377, TR3B TSF Series, TR4 to CT4387; 0.75" bore                    |   |          |
| 108 | WHEEL CYLINDER ASSEMBLY  | 2 | GWC1112  |
| 109 | REPAIR KIT (axle set)  | 1 | 18G9065  |
|     | TR3B TCF Series, TR4 from CT4388, TR4A, TR5, TR250; 0.70" bore                   |   |          |
| 108 | WHEEL CYLINDER ASSEMBLY  | 2 | GWC1154  |
| 109 | REPAIR KIT (axle set)  | 1 | 512351   |

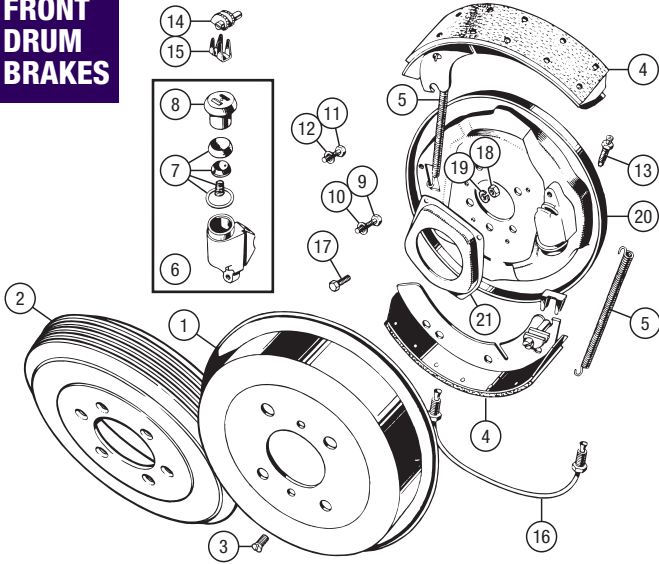
#### TR3B TCF Series, TR4 from CT4388, TR4A, TR5, TR250; 0.70" bore

Varying rear wheel cylinder bore will have the effect of altering front to rear brake balance. When replacing rear wheel cylinders make sure to fit in pairs.

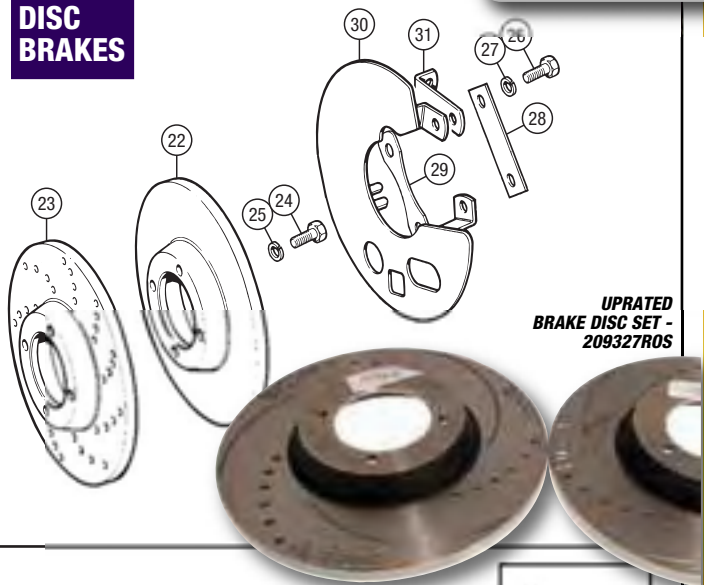
|     |   |   |          |
|-----|---|---|----------|
| 110 | BLEED NIPPLE  | 2 | 556508A  |
| 111 | CAP, bleed nipple   | 2 | STC1913  |
| 112 | KIT, cylinder retaining, (axle set)                               | 1 | RR1177   |
| 113 | SPRING PLATE, cylinder retaining                                  | 2 | 505091A  |
| 114 | PLATE, locking wheel cylinder                                     | 2 | 505092   |
| 115 | DISTANCE WASHER, boot retaining                                   | 2 | 505094   |
| 116 | BOOT, rubber, dust excluding                                      | 2 | 505093A  |
| 117 | LEVER, handbrake cable  | 2 | 157672   |
| 118 | BACK PLATE ASSEMBLY;  |   |          |
|     | TR3 from TS13046, TR3A to TS15331                                 |   |          |
|     | RH  | 1 | 203244   |
|     | LH  | 1 | 203243   |
|     | TR3 from TS15332, TR3A to TS56376                                 |   |          |
|     | RH  | 1 | 203935   |
|     | LH  | 1 | 203934   |
|     | TR3A from TS56377, TR4, TR4A (non-IRS)                            |   |          |
|     | RH  | 1 | 206502   |
|     | LH  | 1 | 206501   |
|     | TR4A (IRS), TR5, TR250  |   |          |
|     | RH  | 1 | 212059   |
|     | LH  | 1 | 212058   |
| 119 | ADJUSTER ASSEMBLY;  |   |          |
|     | TR3 from TS13046, TR3A to TS56376                                 | 2 | 7H4997   |
|     | TR3A from TS56377, TR3B, TR4, TR4A, TR5, TR250                    | 2 | 519762   |
| 120 | WEDGE;  |   |          |
|     | TR3 from TS13046, TR3A to TS56376                                 | 4 | 505084   |
|     | TR3A from TS56377, TR3B, TR4, TR4A, TR5, TR250                    | 4 | 111054   |
| 121 | NUT, plain;   |   |          |
|     | TR3 from TS13046, TR3A to TS56376                                 | 4 | GHF201   |
|     | TR3A from TS56377, TR3B, TR4, TR4A, TR5, TR250                    | 4 | GHF200   |
| 122 | WASHER, shakeproof  |   |          |
|     | TR3 from TS13046, TR3A to TS56376                                 | 4 | GHF322   |
|     | TR3A from TS56377, TR3B, TR4, TR4A, TR5, TR250                    | 4 | GHF321   |
| 123 | SHOES, 10" dia., rear   | 4 | 505351   |
|     | TR3 from TS13046, TR3A to TS56376; sold each.                     |   |          |
| 123 | SHOES, 9" dia., rear;   |   |          |
|     | TR3A from TS56377, TR3B, TR4, TR4A, TR5, TR250; sold as set of 4. |   |          |
|     | new   | 1 | GBS778   |
|     | uprated   | 1 | GBS778UR |
| 124 | RETURN SPRING, cylinder end                                       | 2 | 505081   |
| 125 | RETURN SPRING, adjuster end;                                      |   |          |
|     | TR3 from TS13046, TR3A to TS56376                                 | 2 | FRC3234  |
|     | TR3A from TS56377, TR3B, TR4, TR4A, TR5, TR250                    | 2 | 508817   |
| 126 | KIT, pull off springs, per axle                                   | 1 | GRSRS8   |
|     | TR3A from TS56377, TR3B, TR4, TR4A, TR5, TR250.                   |   |          |
| 127 | PIN, brake shoe retaining   | 4 | 120124   |
|     | TR3 from TS13046 to TS15331.                                      |   |          |
| 128 | WASHER (TR3 from TS13046 to TS15331)                              | 8 | 17H4374  |
| 129 | SPRING (TR3 from TS13046 to TS15331)                              | 4 | 504877   |
| 130 | STEADY POST, brake shoe   | 4 | 505349   |
|     | TR3 from TS15332, TR3A to TS56376.                                |   |          |
| 131 | NUT (TR3 from TS15332, TR3A to TS56376)                           | 4 | GHF201   |
| 132 | FELT BUSH   | 4 | 7H4429   |
|     | TR3 from TS15332, TR3A to TS56376.                                |   |          |
| 133 | KIT, shoe hold down (axle set)                                    | 1 | BAU1420A |
|     | TR3A from TS56377, TR3B, TR4, TR4A, TR5, TR250.                   |   |          |
| 134 | PIN, shoe hold down (Included in 130)                             | 4 | 122505   |
| 135 | SPRING, shoe hold down (Included in 130)                          | 4 | 508818   |



## FRONT DRUM BRAKES

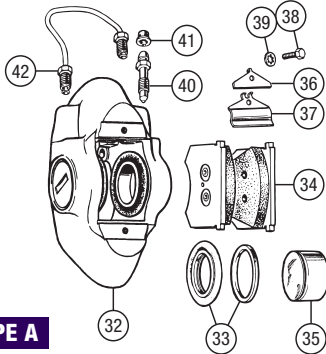


## FRONT DISC BRAKES

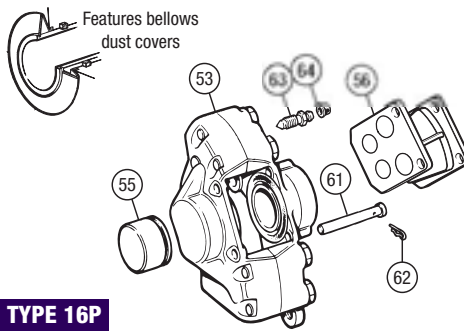


UPDATED  
BRAKE DISC SET -  
209327ROS

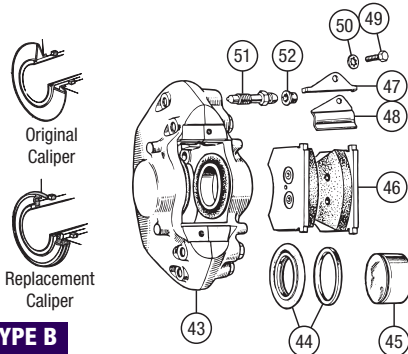
### TYPE A



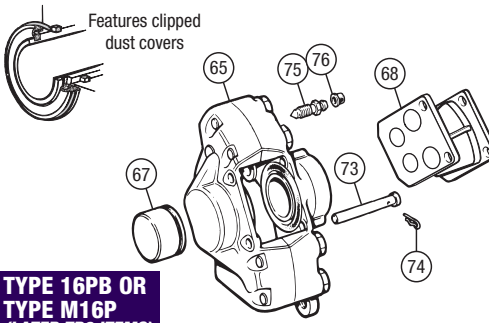
### TYPE 16P



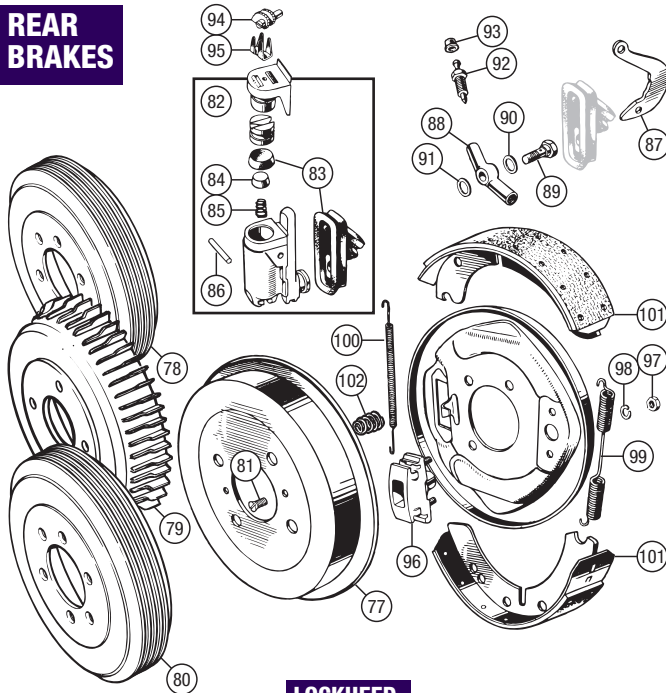
### TYPE B



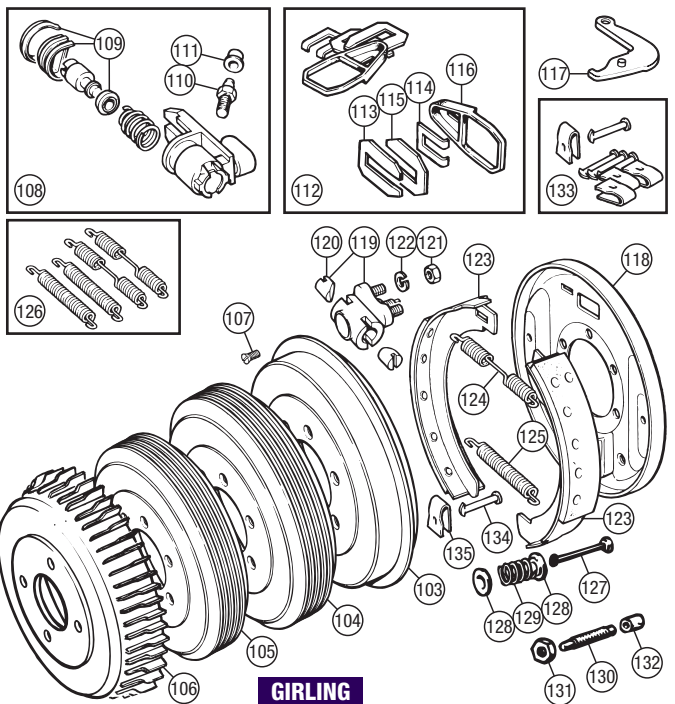
### TYPE 16PB OR TYPE M16P (LATER TRG ITEMS)



## REAR BRAKES



### LOCKHEED



### GIRLING



# ALL MODELS

## Brake Kits & Improvements - All Models

### Brake Overhaul Kits - Full

Including (front drum-braked cars): shoes, fitting kits, wheel cylinders and brake hoses.

Including (front disc-braked cars): discs, pads, shoes, fitting kits, caliper pistons, seals, wheel cylinders and brake hoses.

#### TR2 to TS5442

##### Lockheed 10" Front Drums, 9" Rear Drums

1A BRAKE OVERHAUL KIT 1 RW3210

The following parts are included:

|    |  |   |           |
|----|--|---|-----------|
| 2  | WHEEL CYLINDER ASSEMBLY, front, RH             | 2 | GWC110    |
| 3  | WHEEL CYLINDER ASSEMBLY, front, LH             | 2 | GWC111    |
| 4  | SHOE SET, front brake, reconditioned, exchange | 1 | LKKB1010R |
| 5  | SPRING, return, front brake                    | 4 | 7H7936    |
| 6  | HOSE, flexible, front                          | 2 | 108595    |
| 7  | WHEEL CYLINDER ASSEMBLY, rear                  | 2 | GWC1111   |
| 8  | SPRING, abutment end, rear brake               | 2 | 17H7499   |
| 9  | SPRING, cylinder end, rear brake               | 2 | 7H7936    |
| 10 | SHOE SET, rear brake, new                      | 1 | RW3008    |
| 11 | HOSE, flexible, rear                           | 1 | 108596    |

#### TR2 from TS5443, TR3 to TS13045

##### Lockheed 10" Front Drums, 10" Rear Drums

1B BRAKE OVERHAUL KIT 1 RW3087

The following parts are included:

|    |  |   |           |
|----|--|---|-----------|
| 2  | WHEEL CYLINDER ASSEMBLY, front, RH             | 2 | GWC110    |
| 3  | WHEEL CYLINDER ASSEMBLY, front, LH             | 2 | GWC111    |
| 4  | SHOE SET, front brake, reconditioned, exchange | 1 | LKKB1010R |
| 5  | SPRING, return, front brake                    | 4 | 7H7936    |
| 6  | HOSE, flexible, front                          | 2 | 108595    |
| 7  | WHEEL CYLINDER ASSEMBLY, rear                  | 2 | GWC1111   |
| 8  | SPRING, abutment end, rear brake               | 2 | 17H7499   |
| 9  | SPRING, cylinder end, rear brake               | 2 | 7H7936    |
| 10 | SHOE SET, rear brake, reconditioned, exchange  | 1 | LKKB1010R |
| 11 | HOSE, flexible, rear                           | 1 | 108596    |
| 12 | SPRING, shoe retaining, rear brake             | 4 | AAA4714   |

#### TR3 from TS13046, TR3A to TS15331

##### Girling 11" Front Discs with Type B Solid Calipers, 10" Rear Drums with 3/4" Flat Piston Wheel Cylinders

13A BRAKE OVERHAUL KIT 1 RW3088

The following parts are included:

|    |                                     |   |          |
|----|-------------------------------------|---|----------|
| 14 | BRAKE DISC, 11"                     | 2 | 203189   |
| 15 | BOLT, disc to front hub             | 8 | 113150   |
| 16 | WASHER, locking, for bolt           | 8 | GHF333   |
| 17 | PISTON                              | 4 | 510792   |
| 18 | SEAL SET, caliper, car set          | 1 | 601960   |
| 19 | PAD SET, standard                   | 1 | GBP172   |
| 20 | PLATE, pad retaining                | 4 | 504833   |
| 21 | SPRING, anti-rattle                 | 4 | 119245   |
| 22 | SCREW, for plate & spring           | 4 | SH604041 |
| 23 | WASHER, locking                     | 4 | GHF331   |
| 24 | SCREW, bleed nipple                 | 2 | 601959   |
| 25 | HOSE, flexible, front               | 2 | GBH206   |
| 26 | WHEEL CYLINDER ASSEMBLY, rear       | 2 | GWC1112  |
| 27 | FITTING KIT, cylinder to back plate | 1 | RR1177   |
| 28 | RETURN SPRING, cylinder end         | 2 | 505081   |
| 29 | RETURN SPRING, adjuster end         | 2 | FRC3234  |
| 30 | PIN, shoe retaining                 | 4 | 120124   |
| 31 | WASHER                              | 8 | 17H4374  |
| 32 | SPRING                              | 4 | 504877   |
| 33 | BRAKE SHOE, rear, standard          | 4 | 505351   |
| 34 | HOSE, flexible, rear                | 1 | GBH122   |

#### TR3 from TS15332, TR3A to TS34403

##### Girling 11" Front Discs with Type B Solid Calipers, 10" Rear Drums with 3/4" Slotted Piston Wheel Cylinders

13B BRAKE OVERHAUL KIT 1 RW3089

The following parts are included:

|    |                                     |   |          |
|----|-------------------------------------|---|----------|
| 14 | BRAKE DISC, 11"                     | 2 | 203189   |
| 15 | BOLT, disc to front hub             | 8 | 113150   |
| 16 | WASHER, locking, for bolt           | 8 | GHF333   |
| 17 | PISTON                              | 4 | 510792   |
| 18 | SEAL SET, caliper, car set          | 1 | 601960   |
| 19 | PAD SET, standard                   | 1 | GBP172   |
| 20 | PLATE, pad retaining                | 4 | 504833   |
| 21 | SPRING, anti-rattle                 | 4 | 119245   |
| 22 | SCREW, for plate & spring           | 4 | SH604041 |
| 23 | WASHER, locking                     | 4 | GHF331   |
| 24 | SCREW, bleed nipple                 | 2 | 601959   |
| 25 | HOSE, flexible, front               | 2 | GBH206   |
| 26 | WHEEL CYLINDER ASSEMBLY, rear       | 2 | GWC1118  |
| 27 | FITTING KIT, cylinder to back plate | 1 | RR1177   |
| 28 | RETURN SPRING, cylinder end         | 2 | 505081   |
| 29 | RETURN SPRING, adjuster end         | 2 | FRC3234  |
| 33 | BRAKE SHOE, rear, standard          | 4 | 505351   |
| 34 | HOSE, flexible, rear                | 1 | GBH122   |
| 35 | NUT                                 | 4 | GHF201   |
| 36 | FELT BUSH                           | 4 | 7H4429   |

#### TR3A from TS34404 to TS56376

##### Girling 11" Front Discs With Type B Solid Calipers, 10" Rear Drums with Replacement 0.70" Bore Wheel Cylinders (Original Cylinders are 0.625" Bore)

13C BRAKE OVERHAUL KIT 1 RW3090

The following parts are included:

|    |   |   |          |
|----|---|---|----------|
| 14 | BRAKE DISC, 11"                                       | 2 | 203189   |
| 15 | BOLT, disc to front hub                               | 8 | 113150   |
| 16 | WASHER, locking, for bolt                             | 8 | GHF333   |
| 17 | PISTON  | 4 | 510792   |
| 18 | SEAL SET, caliper, car set                            | 1 | 601960   |
| 19 | PAD SET, standard                                     | 1 | GBP172   |
| 20 | PLATE, pad retaining                                  | 4 | 504833   |
| 21 | SPRING, anti-rattle                                   | 4 | 119245   |
| 22 | SCREW, for plate & spring                             | 4 | SH604041 |
| 23 | WASHER, locking                                       | 4 | GHF331   |
| 24 | SCREW, bleed nipple                                   | 2 | 601959   |
| 25 | HOSE, flexible, front                                 | 2 | GBH206   |
| 26 | WHEEL CYLINDER ASSEMBLY, rear Replacement; 0.70" bore | 2 | GWC1154  |
| 27 | FITTING KIT, rear cylinder to back plate              | 1 | RR1177   |
| 28 | RETURN SPRING, cylinder end                           | 2 | 505081   |
| 29 | RETURN SPRING, adjuster end                           | 2 | FRC3234  |
| 33 | BRAKE SHOE, standard, exchange                        | 4 | 505351   |
| 34 | HOSE, flexible, rear                                  | 1 | GBH122   |
| 35 | NUT   | 4 | GHF201   |
| 36 | FELT BUSH   | 4 | 7H4429   |

#### TR3A from TS56377, TR3B TSF Series, TR4 to CT4387

##### Girling 11" Front Discs with Type B Split Calipers, 9" Rear Drums

37 BRAKE OVERHAUL KIT 1 RW3091

The following parts are included:

|    |  |   |          |
|----|--|---|----------|
| 38 | BRAKE DISC, 11"                            | 2 | 203189   |
| 39 | BOLT, disc to front hub                    | 8 | 113150   |
| 40 | WASHER, locking, for bolt                  | 8 | GHF333   |
| 41 | PISTON                                     | 4 | 510792   |
| 42 | SEAL SET, caliper, car set                 | 1 | 601960   |
| 43 | PAD SET, standard                          | 1 | GBP172   |
| 44 | PLATE, pad retaining                       | 4 | 509051   |
| 45 | SPRING, anti-rattle                        | 4 | 509049   |
| 46 | SCREW, for plate & spring                  | 4 | SH604041 |
| 47 | WASHER, locking                            | 4 | GHF331   |
| 48 | SCREW, bleed nipple                        | 2 | 601959   |
| 49 | HOSE, flexible, front                      | 2 | GBH206   |
| 50 | WHEEL CYLINDER ASSEMBLY, rear              | 2 | GWC1112  |
| 51 | FITTING KIT, cylinder to back plate        | 1 | RR1177   |
| 52 | FITTING KIT, brake shoe hold down, car set | 1 | BAU1420A |
| 53 | FITTING KIT, brake shoe return springs     | 1 | GRSRS8   |
| 54 | BRAKE SHOE SET, standard                   | 1 | GBS778   |
| 55 | HOSE, flexible, rear                       | 1 | GBH122   |

#### TR3B TCF Series, TR4 from CT4388

##### Girling 10 13/16" Front Discs with Type 16P Calipers, 9" Rear Drums

56A BRAKE OVERHAUL KIT 1 RW3092

The following parts are included:

|    |  |   |          |
|----|--|---|----------|
| 57 | BRAKE DISC, 10 13/16"                      | 2 | 209327   |
| 58 | BOLT, disc to front hub                    | 8 | 113150   |
| 59 | WASHER, locking, for bolt                  | 8 | GHF333   |
| 60 | PISTON                                     | 4 | 510792   |
| 61 | SEAL SET, caliper, car set                 | 1 | 601960   |
| 62 | PAD FITTING KIT                            | 1 | GBK1003  |
| 63 | SCREW, bleed nipple                        | 2 | 556508A  |
| 64 | BRAKE PAD SET, standard                    | 1 | GBP132   |
| 65 | SHIM SET, anti-squeal                      | 1 | GRSP2750 |
| 66 | HOSE, flexible, front                      | 2 | GBH206   |
| 67 | WHEEL CYLINDER ASSEMBLY, rear              | 2 | GWC1154  |
| 68 | FITTING KIT, cylinder to back plate        | 1 | RR1177   |
| 69 | FITTING KIT, brake shoe hold down, car set | 1 | BAU1420A |
| 70 | FITTING KIT, brake shoe return springs     | 1 | GRSRS8   |
| 71 | BRAKE SHOE SET, standard                   | 1 | GBS778   |
| 72 | HOSE, flexible, rear                       | 1 | GBH122   |

#### TR4A, TR5, TR250 Original Fitment

##### Girling 10 13/16" Front Discs with Type 16P Calipers, 9" Rear Drums

If you have a rigid axle TR4A, you will need one GBH216 rear brake hose substituted for the two usually offered with this kit. Please call to arrange.

56B BRAKE OVERHAUL KIT 1 RR1424

The following parts are included:

|    |  |   |          |
|----|--|---|----------|
| 57 | BRAKE DISC, 10 13/16"                      | 2 | 209327   |
| 58 | BOLT, disc to front hub                    | 8 | 113150   |
| 59 | WASHER, locking, for bolt                  | 8 | GHF333   |
| 60 | PISTON                                     | 4 | 510792   |
| 61 | SEAL SET, caliper, car set                 | 1 | 601960   |
| 62 | PAD FITTING KIT                            | 1 | GBK1003  |
| 63 | SCREW, bleed nipple                        | 2 | 556508A  |
| 64 | BRAKE PAD SET, standard                    | 1 | GBP132   |
| 65 | SHIM SET, anti-squeal                      | 1 | GRSP2750 |
| 66 | HOSE, flexible, front                      | 2 | GBH203   |
| 67 | WHEEL CYLINDER ASSEMBLY, rear              | 2 | GWC1154  |
| 68 | FITTING KIT, cylinder to back plate        | 1 | RR1177   |
| 69 | FITTING KIT, brake shoe hold down, car set | 1 | BAU1420A |
| 70 | FITTING KIT, brake shoe return springs     | 1 | GRSRS8   |
| 71 | BRAKE SHOE SET, standard                   | 1 | GBS778   |
| 72 | HOSE, flexible, rear, RH                   | 1 | GBH177   |
| 73 | HOSE, flexible, rear, LH                   | 1 | GBH178   |

#### TR4A, TR5, TR250 with Later Seal Design Imperial TR6 Calipers

##### Girling 10 13/16" Front Discs With Type 16PB Calipers, 9" Rear Drums

If you have a rigid axle TR4A, you will need one GBH216 rear brake hose substituted for the two usually offered with this kit. Please call to arrange.

56C BRAKE OVERHAUL KIT 1 RR1425

The following parts are included:

|    |  |   |          |
|----|--|---|----------|
| 57 | BRAKE DISC, 10 13/16"                      | 2 | 209327   |
| 58 | BOLT, disc to front hub                    | 8 | 113150   |
| 59 | WASHER, locking, for bolt                  | 8 | GHF333   |
| 60 | PISTON                                     | 4 | 157685   |
| 61 | SEAL SET, caliper, car set                 | 1 | 519731   |
| 62 | PAD FITTING KIT                            | 1 | GBK1003  |
| 63 | SCREW, bleed nipple                        | 2 | 556508A  |
| 64 | BRAKE PAD SET, standard                    | 1 | GBP132   |
| 65 | SHIM SET, anti-squeal                      | 1 | GRSP2750 |
| 66 | HOSE, flexible, front                      | 2 | GBH203   |
| 67 | WHEEL CYLINDER ASSEMBLY, rear              | 2 | GWC1154  |
| 68 | FITTING KIT, cylinder to back plate        | 1 | RR1177   |
| 69 | FITTING KIT, brake shoe hold down, car set | 1 | BAU1420A |
| 70 | FITTING KIT, brake shoe return springs     | 1 | GRSRS8   |
| 71 | BRAKE SHOE SET, standard                   | 1 | GBS778   |
| 72 | HOSE, flexible, rear, RH                   | 1 | GBH177   |
| 73 | HOSE, flexible, rear, LH                   | 1 | GBH178   |

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**RIMMER**  
BROS

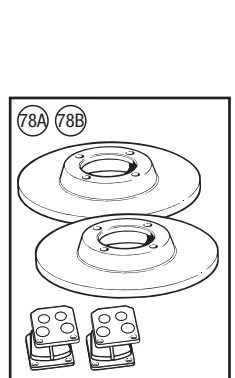
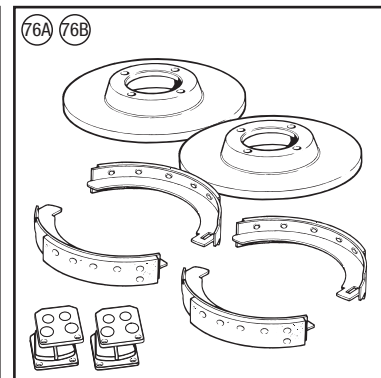
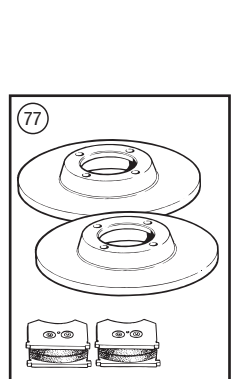
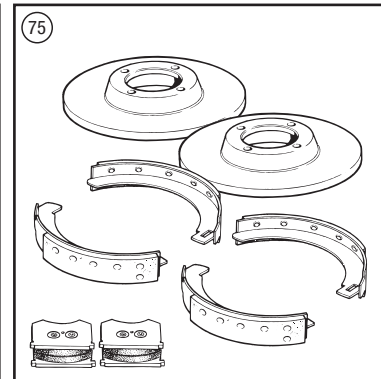
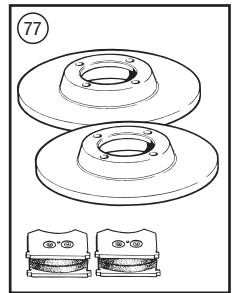
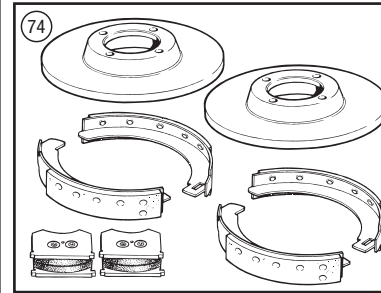
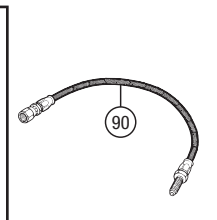
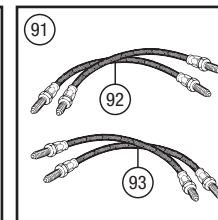
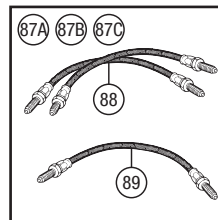
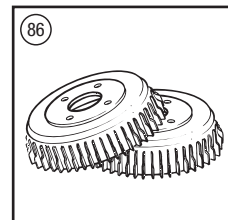
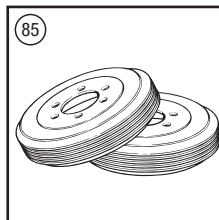
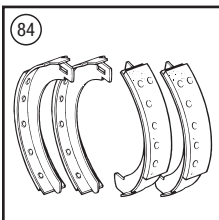
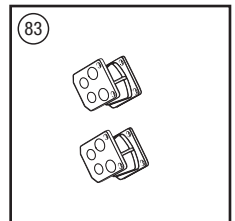
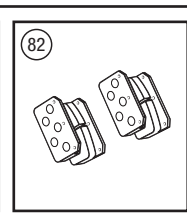
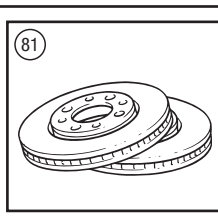
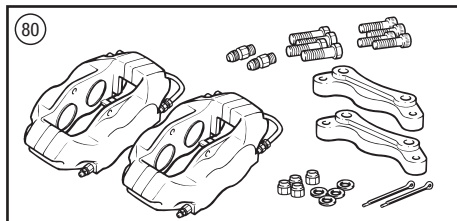
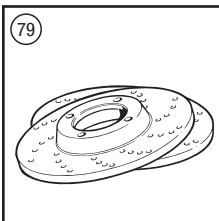
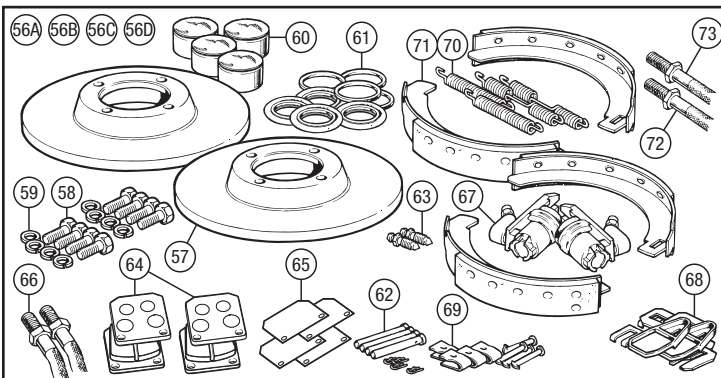
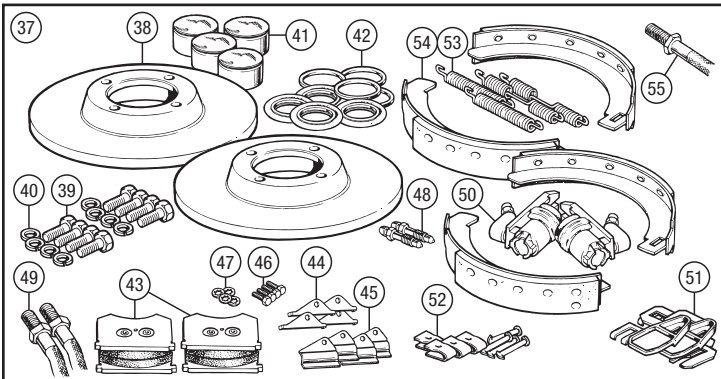
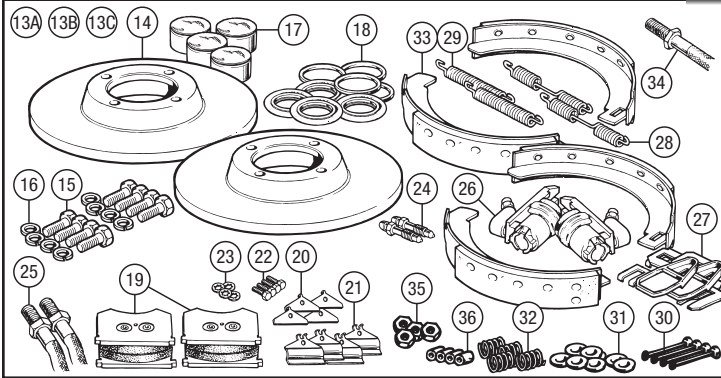
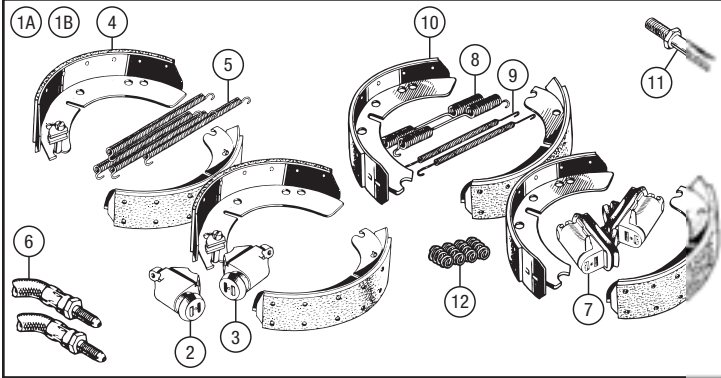
STANDARD BRAKE  
PAD SET - GBP172





**ALL MODELS**

**BRAKE KITS & IMPROVEMENTS - ALL MODELS**





## ALL MODELS

## Brake Overhaul Kits - Full Cont'd

TR4A, TR5, TR250  
with Later Seal Design Metric TR6 Calipers

## Girling 10 13/16" Front Discs

## with Type M16P Calipers, 9" Rear Drums

If you have a rigid axle TR4A, you will need one GBH216 rear brake hose substituted for the two usually offered with this kit. Please call to arrange.

|   |   |          |
|---|---|----------|
| 56D BRAKE OVERHAUL KIT                        | 1 | RR1426   |
| <b>The following parts are included:</b>      |   |          |
| 57 BRAKE DISC, 10 13/16"                      | 2 | 209327   |
| 58 BOLT, disc to front hub                    | 8 | 113150   |
| 59 WASHER, locking, for bolt                  | 8 | GHF333   |
| 60 PISTON                                     | 4 | 157685   |
| 61 SEAL SET, caliper, car set                 | 1 | 519731   |
| 62 PAD FITTING KIT                            | 1 | GBK1002  |
| 63 SCREW, bleed nipple                        | 2 | RTC1115A |
| 64 BRAKE PAD SET, standard                    | 1 | GBP216   |
| 65 SHIM SET, anti-squeal                      | 1 | GBK1019  |
| 66 HOSE, flexible, front                      | 2 | GBH203   |
| 67 WHEEL CYLINDER ASSEMBLY, rear              | 2 | GWC1154  |
| 68 FITTING KIT, rear cylinder to back plate   | 1 | RR1177   |
| 69 FITTING KIT, brake shoe hold down, car set | 1 | BAU1420A |
| 70 FITTING KIT, brake shoe return springs     | 1 | GRSRS8   |
| 71 BRAKE SHOE SET, standard                   | 1 | GBS778   |
| 72 HOSE, flexible, rear, RH                   | 1 | GBH177   |
| 73 HOSE, flexible, rear, LH                   | 1 | GBH178   |

## Brake Kits - Part

## DISCS, PADS &amp; SHOES

## TR3 from TS13046, TR3A to TS56376

|  |   |        |
|--|---|--------|
| 74 BRAKE KIT                             | 1 | RW3093 |
| <b>The following parts are included:</b> |   |        |
| 14 BRAKE DISC, 11"                       | 2 | 203189 |
| 19 PAD SET, standard                     | 1 | GBP172 |
| 33 BRAKE SHOE, rear, standard            | 4 | 505351 |

## TR3A from TS56377, TR3B TSF Series, TR4 to CT4387

|  |   |        |
|--|---|--------|
| 75 BRAKE KIT                             | 1 | RW3094 |
| <b>The following parts are included:</b> |   |        |
| 39 BRAKE DISC, 11"                       | 2 | 203189 |
| 44 PAD SET, standard                     | 1 | GBP172 |
| 55 BRAKE SHOE SET, standard              | 1 | GBS778 |

## TR3B TCF Series, TR4 from CT4388, TR4A, TR5, TR250 (With Original or TR6 Imperial Calipers)

|  |   |        |
|--|---|--------|
| 76A BRAKE KIT                            | 1 | RR1095 |
| <b>The following parts are included:</b> |   |        |
| 58 BRAKE DISC, 10 13/16"                 | 2 | 209327 |
| 65 BRAKE PAD SET, standard               | 1 | GBP132 |
| 72 BRAKE SHOE SET, standard              | 1 | GBS778 |

## TR3B TCF Series, TR4 from CT4388, TR4A, TR5, TR250 (With TR6 Metric Calipers)

|  |   |        |
|--|---|--------|
| 76B BRAKE KIT                            | 1 | RR1096 |
| <b>The following parts are included:</b> |   |        |
| 58 BRAKE DISC, 10 13/16"                 | 2 | 209327 |
| 65 BRAKE PAD SET, standard               | 1 | GBP216 |
| 72 BRAKE SHOE SET, standard              | 1 | GBS778 |

## DISCS &amp; PADS

## TR3 from TS13046, TR3A, TR3B TSF Series, TR4 to CT4387

|  |   |        |
|--|---|--------|
| 77 BRAKE KIT                             | 1 | RW3095 |
| <b>The following parts are included:</b> |   |        |
| 14 BRAKE DISC, 11"                       | 2 | 203189 |
| 19 PAD SET, standard                     | 1 | GBP172 |

## TR3B TCF Series, TR4 from CT4388, TR4A, TR5, TR250 (With Original or TR6 Imperial Calipers)

|  |   |        |
|--|---|--------|
| 78A BRAKE KIT                            | 1 | RR1122 |
| <b>The following parts are included:</b> |   |        |
| 58 BRAKE DISC, 10 13/16"                 | 2 | 209327 |
| 65 BRAKE PAD SET, standard               | 1 | GBP132 |

## TR3B TCF Series, TR4 from CT4388, TR4A, TR5, TR250 (With TR6 Metric Calipers)

|  |   |        |
|--|---|--------|
| 78B BRAKE KIT                            | 1 | RR1123 |
| <b>The following parts are included:</b> |   |        |
| 58 BRAKE DISC, 10 13/16"                 | 2 | 209327 |
| 65 BRAKE PAD SET, standard               | 1 | GBP216 |

## Brake Improvements

## UPDATED BRAKE DISC SET

These specially machined brake discs will dissipate heat and shed water quicker than the standard solid versions, assuring faster and more consistent braking under all conditions.

## 79 BRAKE DISC SET, sold as a pair (solid discs);

To replace standard 10 13/16" diameter discs on TR3Bs, TR4s, TR4As, TR5s and TR250s with 16P, 16PB or M16P calipers. Fit with appropriate updated pads listed below.

|                             |   |           |
|-----------------------------|---|-----------|
| updated EBC turbo groove    | 1 | 209327UR  |
| updated Rossini performance | 1 | 209327ROS |

## VENTED DISC CONVERSION KIT

An easy, low cost solution; the kit includes new vented discs, caliper spacers, seals, fittings & green stuff pads to convert existing calipers. Instructions provided. Please see photo on opposite page.

## - VENTED DISC CONVERSION KIT;

for type 16P/16PB (if fitted) imperial calipers.

TR3B, all TCF series, TR4 from CT4690 (wire wheels) & CT4388 (steel wheels), TR4A, TR5, TR250, TR6 (to CP76094)

NOTE: Can also be fitted to TR3 from TS13046, TR3A, TR3B, all TSF series and early TR4 (11" discs) in conjunction with a pair of 16P calipers, which are available new as an outright sale (307976 & 307977), and a pair of caliper mounting brackets (133499 & 133500) which can usually be found second hand (later TR4 to TR6).

for type M16P (if fitted) metric calipers.

TR6 from CP76095 & CC81079 (if retro fitted by a previous owner).

|  |   |          |
|--|---|----------|
|  | 1 | RR1123UR |
|--|---|----------|

## 4 POT CALIPER &amp; VENTED DISC KITS

The ultimate in braking efficiency, our 4 pot caliper and vented disc kit is supplied with 4 pot alloy calipers, adaptor plates, vented discs and fast road pads for super stopping power.

## 80 4 POT CALIPER &amp; VENTED DISC KIT;

|                                 |   |         |
|---------------------------------|---|---------|
| with plain vented discs         | 1 | RR1427  |
| with cross-drilled vented discs | 1 | RR1427X |

## 81 BRAKE DISC SET, vented, pair, replacement;

|                            |   |          |
|----------------------------|---|----------|
| plain vented discs         | 1 | RR1427D  |
| cross-drilled vented discs | 1 | RR1427DX |

## 82 BRAKE PAD SET, set of 4, replacement1

Fast road material.

|  |   |         |
|--|---|---------|
|  | 1 | RR1427P |
|--|---|---------|

## BRAKE SERVO (TR2-4A) - see following page.

## Upated Pads &amp; Shoes

Upated pads and shoes fit directly into standard calipers and drums. The greater pad area and harder linings reduce brake fade and provide more efficient braking.

## 83 BRAKE PADS ONLY, upated, Green Stuff Kevlar;

to fit TR3s, TR3As, TR3Bs and TR4s with

11" diameter discs and Type B solid or split calipers

to fit TR3Bs, TR4s, TR4As, TR5s and TR250s with 10 13/16" discs and imperial 16P or 16PB calipers

Pads only 1 GBP172GS  
Pads including fitting kit 1 GBP132GSK

to fit TR3Bs, TR4s, TR4As, TR5s and TR250s with 10 13/16" discs and metric M16P calipers

Pads only 1 GBP216GS  
Pads including fitting kit 1 GBP216GSK

## 84 BRAKE SHOE SET, upated;

to fit TR3As, TR3Bs, TR4s, TR4As, TR5s

and TR250s with Girling 9" rear drum brakes

|  |   |          |
|--|---|----------|
|  | 1 | GBS778UR |
|--|---|----------|

## Al-Fin Brake Drums

For decades the factory-optional Al-Fin brake drums with their distinctive circumferential fins were an extremely rare find on a TR. The good news for enthusiastic owners who love period accessories and tuning parts is that reproductions are available once more, in both 9" and 10" diameter sizes to suit all TR2-TR6 drum brake designs. Alternatively the 9" Al-Fin drum is also available with the attractive radial fin design so evocative of British sporting and competition car history.

These reproduction finned drums not only look good but substantially reduce brake fade on hard-driven TRs. They feature strong finned aluminium alloy shells with cast iron inserts.

## 85 AL-FIN BRAKE DRUM, sold each;

to fit TR2s and TR3s with Lockheed 10" front drum brakes. Circumferential fins 2 301590

to fit TR2s with Lockheed 9" rear drum brakes. Circumferential fins 2 202267

to fit TR2s and TR3s with Lockheed 10" rear drum brakes. Circumferential fins 2 301590

to fit TR3s and TR3As with Girling 10" rear drum brakes. Circumferential fins 2 301590

to fit TR3As, TR3Bs, TR4s, TR4As, TR5s & TR250s with Girling 9" rear drum brakes. Circumferential fins 2 202267

## 86 AL-FIN BRAKE DRUM SET, sold as a pair

to fit TR2s with Lockheed 9" rear drum brakes.

Radial fins 1 210578UR

to fit TR3As, TR3Bs, TR4s, TR4As, TR5s & TR250s with Girling 9" rear drum brakes.

Radial fins 1 210578UR

## Brake &amp; Clutch Hoses - Standard

## TR2, TR3 to TS13045

|  |   |         |
|--|---|---------|
| 87A BRAKE HOSE SET, includes 3 brake hoses | 1 | RW3096  |
| 88 BRAKE HOSE, front                       | 2 | 108595  |
| 89 BRAKE HOSE, rear                        | 1 | 108596  |
| 90 CLUTCH HOSE                             | 1 | GVP1001 |

## TR3 from TS13046, TR3A, TR3B, TR4

|  |   |        |
|--|---|--------|
| 87B BRAKE HOSE SET, includes 3 brake hoses | 1 | RF4127 |
| 88 BRAKE HOSE, front                       | 2 | GBH206 |
| 89 BRAKE HOSE, rear                        | 1 | GBH122 |
| 90 CLUTCH HOSE                             | 1 | GBH415 |

## TR4A Solid Axle

|  |   |        |
|--|---|--------|
| 87C BRAKE HOSE SET, includes 3 brake hoses | 1 | RF4147 |
| 88 BRAKE HOSE, front                       | 2 | GBH203 |
| 89 BRAKE HOSE, rear                        | 1 | GBH216 |
| 90 CLUTCH HOSE                             | 1 | 143354 |

## TR4A IRS, TR5, TR250

|   |   |        |
|---|---|--------|
| 91 BRAKE HOSE SET, includes 4 brake hoses | 1 | RR1428 |
| 92 BRAKE HOSE, front                      | 2 | GBH203 |
| 93 BRAKE HOSE, rear; RH                   | 1 | GBH177 |
| LH  | 1 | GBH178 |
| 90 CLUTCH HOSE; TR4A IRS                  | 1 | 143354 |
| TR5, TR250                                | 1 | 140420 |

## Brake &amp; Clutch Hoses - Stainless Steel Braided

The problem of spongy feeling brakes may well be caused by old hoses which, having lost their strength, begin to expand under pressure. To stop it, simply replace the hoses with superior quality stainless steel braided equivalents. The steel braiding constricts the hose and stops expansion, forcing fluid all the way down into the calipers and cylinders giving a firmer pedal. The same theory also applies to the clutch hose which is also worth replacing. The braided hoses look good too!

## TR2, TR3 to TS13045

|  |   |           |
|--|---|-----------|
| 87A BRAKE HOSE SET, includes 3 brake hoses | 1 | RW3096GR  |
| 88 BRAKE HOSE, front                       | 2 | 108595GR  |
| 89 BRAKE HOSE, rear                        | 1 | 108596GR  |
| 90 CLUTCH HOSE                             | 1 | GVP1001SS |

## TR3 from TS13046, TR3A, TR3B, TR4

|  |   |          |
|--|---|----------|
| 87B BRAKE HOSE SET, includes 3 brake hoses | 1 | RF4127GR |
| 88 BRAKE HOSE, front                       | 2 | GBH122GR |
| 89 BRAKE HOSE, rear                        | 1 | GBH122GR |
| 90 CLUTCH HOSE                             | 1 | GBH415GR |

## TR4A Solid Axle

|  |   |          |
|--|---|----------|
| 87C BRAKE HOSE SET, includes 3 brake hoses | 1 | RF4147GR |
| 88 BRAKE HOSE, front                       | 2 | GBH203GR |
| 89 BRAKE HOSE, rear                        | 1 | GBH216GR |
| 90 CLUTCH HOSE                             | 1 | 143354GR |

## TR4A IRS, TR5, TR250

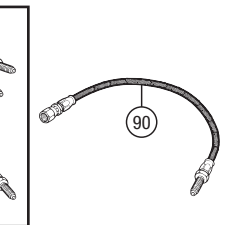
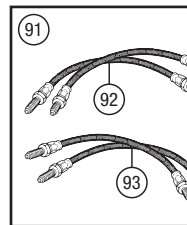
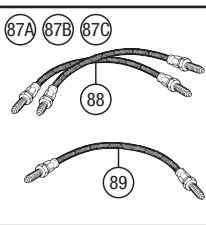
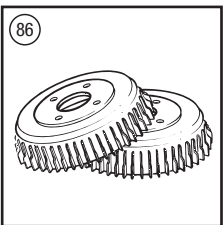
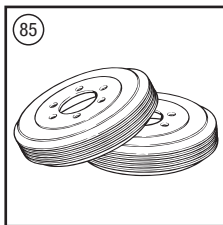
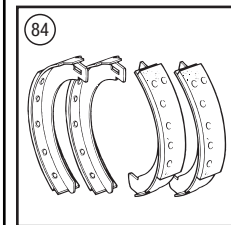
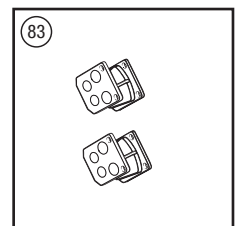
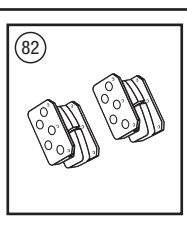
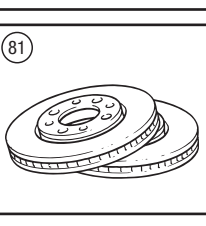
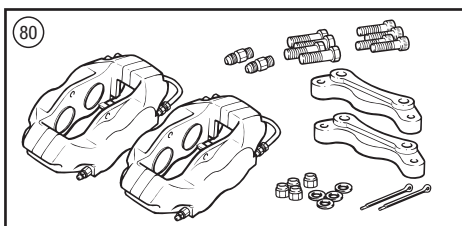
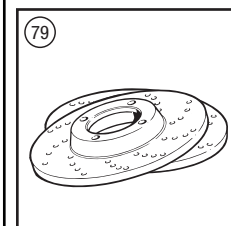
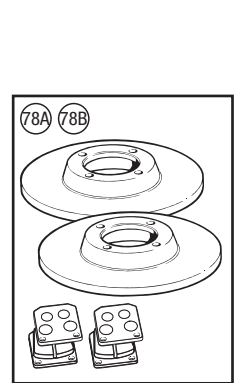
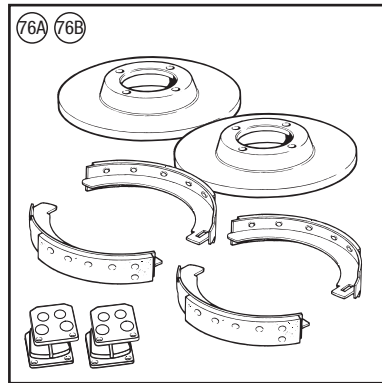
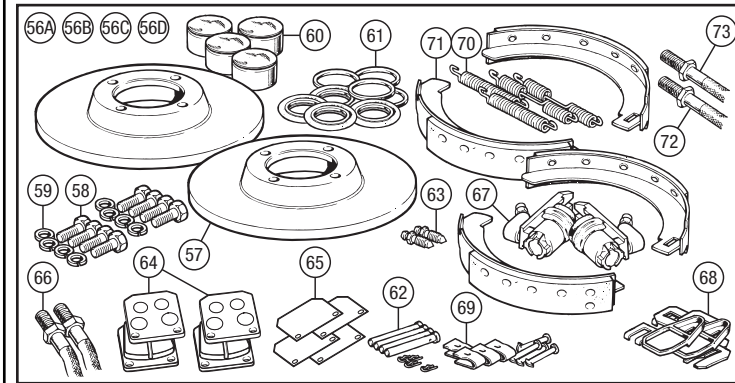
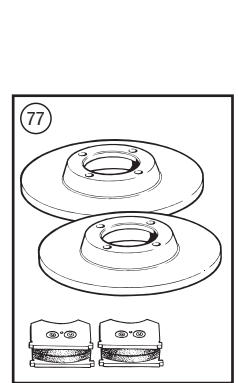
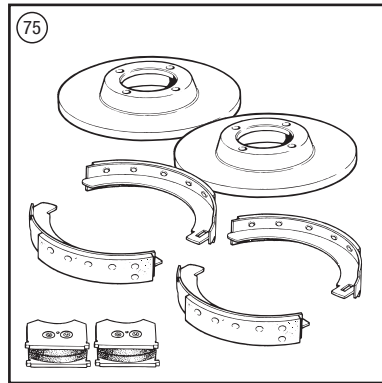
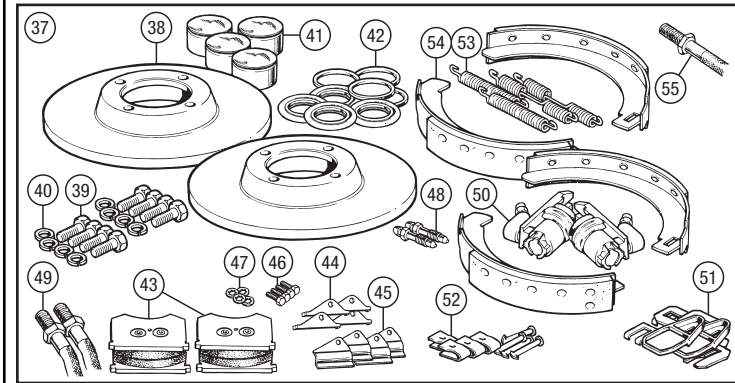
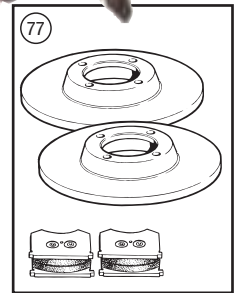
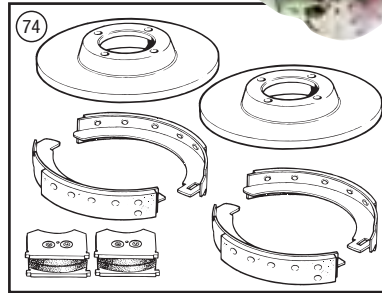
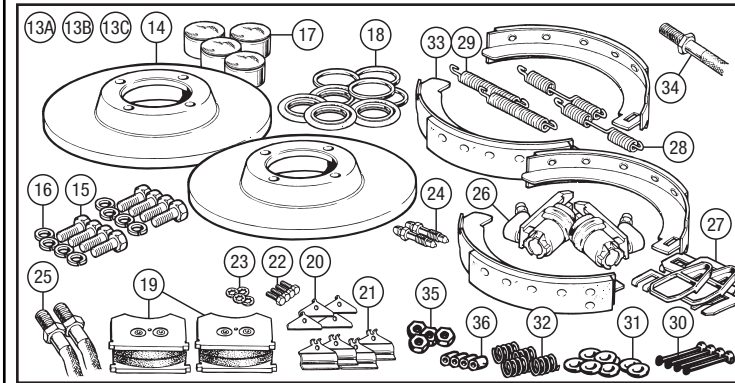
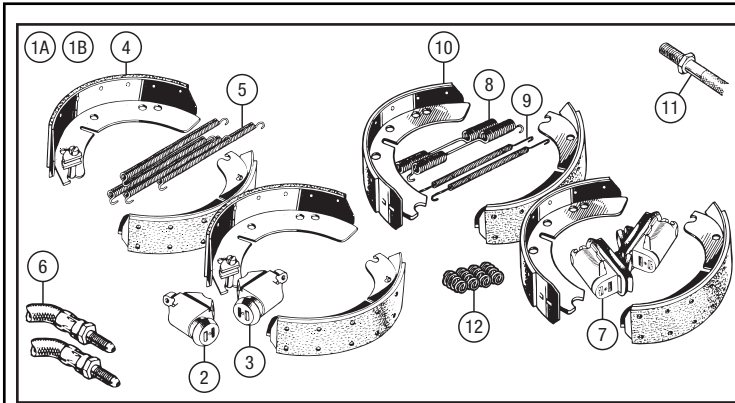
|   |   |          |
|---|---|----------|
| 91 BRAKE HOSE SET, includes 4 brake hoses | 1 | RR1428GR |
| 92 BRAKE HOSE, front                      | 2 | GBH203GR |
| 93 BRAKE HOSE, rear; RH                   | 1 | GBH177GR |
| LH  | 1 | GBH178GR |
| 90 CLUTCH HOSE; TR4A IRS                  | 1 | 143354GR |
| TR5, TR250                                | 1 | 140420GR |



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No. DESCRIPTION QTY REQ. PART No.

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**TR2-4A****REPLACEMENT MASTER CYLINDER ASSEMBLY - RW3002****Brake Master Cylinder****LOCKHEED BRAKE MASTER CYLINDER; TR2, TR3 to TS13045**

|  |  |   |         |
|--|--|---|---------|
| 1  | MASTER CYLINDER ASSEMBLY, original; BSF threaded                 | 1 | 201821  |
| 2  | MASTER CYLINDER ASSEMBLY, replacement; UNF threaded              | 1 | RW3002  |
| <i>The replacement master cylinder is supplied together with the adaptor UNF/BSF brake pipe required to attach it to the four-way union in the brake system.</i> |  |   |         |
| 3  | REPAIR KIT, services both types, less bellows                    | 1 | 8G8224  |
| 4  | FILLER CAP, metal  | 1 | 501522  |
| 5  | SEAL, filler cap,  | 1 | 501524  |
| 6  | FILLER CAP, plastic  | 1 | 513123A |
| <i>Replacement for metal cap.</i>  |  |   |         |
| 7  | ADAPTOR, master cylinder; for original cylinder; BSF male thread | 1 | 108415  |
|  | for replacement cylinder; UNF male thread                        | 1 | 21K8564 |
| 8  | WASHER, adaptor to master cylinder                               | 1 | 233220A |
| 9  | COVER, top   | 1 | 501189  |
| <i>Original master cylinder.</i>   |  |   |         |
| 10   | SCREW, top cover/front plate to body                             | 6 | 501195  |
| 11   | WASHER, star   | 6 | GHF321  |
| 12   | GASKET, cover  | 1 | 501190  |
| <i>Original master cylinder.</i>   |  |   |         |
| 13   | PLATE, front   | 1 | 501193  |
| 14   | GASKET, for plate  | 1 | AAA4757 |
| <i>Must be replaced during rebuild.</i>  |  |   |         |
| 15   | SPRING   | 2 | 59270   |
| 16   | CHECK VALVE (brake only)   | 1 | 59267   |
| 17   | BELLOW, push rod   | 2 | 501194  |

**ORIGINAL PUSHROD ASSEMBLY**

|    |                     |   |          |
|----|---------------------|---|----------|
| 18 | PUSHROD ASSEMBLY    | 2 | 501775   |
| 19 | CLEVIS PIN          | 2 | CLZ516   |
| 20 | WASHER, double coil | 2 | WS600051 |
| 21 | WASHER, plain       | 2 | GHF301   |
| 22 | SPLIT PIN           | 2 | PS103121 |

**REPLACEMENT PUSHROD ASSEMBLY**

|                               |                        |   |          |
|-------------------------------|------------------------|---|----------|
| 23                            | PUSHROD                | 2 | 504852   |
| <i>Cut to correct length.</i> |                        |   |          |
| 24                            | FORK END ASSEMBLY      | 1 | 57190    |
| <i>Includes items 25, 26.</i> |                        |   |          |
| 25                            | FORK                   | 2 | 57194    |
| 26                            | SCREW PIN, with spring | 2 | 216421A  |
| 27                            | JAM NUT for fork       | 2 | NT605041 |
| 28                            | SPLIT PIN              | 2 | PC34     |

|    |   |   |          |
|----|---|---|----------|
| 29 | BOLT, master cylinder to support and adjustment bracket | 2 | BH606261 |
| 30 | WASHER, plain   | 4 | WP9      |
| 31 | WASHER, locking   | 2 | GHF333   |
| 32 | NUT   | 2 | GHF202   |
| 33 | BRACKET ASSEMBLY, cylinder adjustment                   | 2 | 107691   |
| 34 | JAM NUT   | 4 | NT604041 |

**BRAKE SERVO KIT - RH5272****TWIN MASTER CYLINDER SUPPLY TANK - 114530****GIRLING BRAKE MASTER CYLINDER; TR3 from TS13046, TR3A**

|                                       |                                      |   |          |
|---------------------------------------|--------------------------------------|---|----------|
| 35                                    | SUPPLY TANK, twin master cylinders   | 1 | 114530   |
| 36                                    | FILLER CAP                           | 1 | 106094   |
| 37                                    | SEAL, filler cap                     | 1 | 106095   |
| 38                                    | DECAL, 'GIRLING WARNING'             | 1 | RW3039   |
| 39                                    | CLIP, tank attachment                | 1 | 113368   |
| 40                                    | SCREW                                | 2 | GHF117   |
| 41                                    | NUT, plain                           | 2 | GHF200   |
| 42                                    | WASHER, locking                      | 2 | GHF331   |
| 43                                    | PIPE, supply tank to master cylinder | 1 | 505062   |
| 44                                    | BRAKE MASTER CYLINDER                | 1 | 122167   |
| <i>Includes pushrod but not fork.</i> |                                      |   |          |
| 45                                    | REPAIR KIT, brake master cylinder    | 1 | GRK1027  |
| 46                                    | SPRING, piston return                | 1 | 510815A  |
| 47                                    | SPACER, piston to plunger            | 1 | 111163   |
| 48                                    | FORK END ASSEMBLY                    | 1 | 57190    |
| <i>Includes items 49, 50.</i>         |                                      |   |          |
| 49                                    | FORK                                 | 1 | 57194    |
| 50                                    | SCREW PIN, with spring               | 1 | 216421A  |
| 51                                    | JAM NUT for fork                     | 1 | NT605041 |
| 52                                    | SPLIT PIN                            | 1 | PC34     |
| 53                                    | PUSHROD                              | 1 | 507206   |
| 54                                    | SCREW, cylinder to support bracket   | 2 | SH605071 |
| 55                                    | NUT, plain                           | 1 | GHF201   |
| 56                                    | WASHER, locking                      | 2 | GHF332   |

**GIRLING BRAKE MASTER CYLINDER; TR4, TR4A.**

|                                      |  |   |         |
|--------------------------------------|--|---|---------|
| 57                                   | BRAKE MASTER CYLINDER; 0.75" bore; early TR4 | 1 | 131661  |
| <i>Identified by one cast ring.</i>  |  |   |         |
|                                      | 0.70" bore; late TR4, TR4A                   | 1 | 132909  |
| <i>Identified by two cast rings.</i> |  |   |         |
| 58                                   | REPAIR KIT; 0.75" bore (0.75" cylinder)      | 1 | GRK1027 |
|                                      | 0.70" bore (0.70" cylinder)                  | 1 | 18G8986 |
| 59                                   | CAP  | 1 | 510844  |
| 60                                   | SEAL, filler cap                             | 1 | 606404A |
| 61                                   | SPRING, piston return                        | 1 | 510815A |
| 62                                   | SPACER, piston to plunger                    | 1 | 111163  |
| 63                                   | PUSHROD                                      | 1 | 510197  |
| 64                                   | CLEVIS PIN                                   | 1 | CLZ516  |
| 65                                   | SPRING, anti-rattle                          | 2 | 131787  |
| 66                                   | WASHER, plain                                | 1 | GHF301  |
| 67                                   | SPLIT PIN                                    | 1 | GHF503  |
| 68                                   | SCREW, master cylinder to bracket            | 2 | GHF103  |
| 69                                   | NUT, plain                                   | 1 | GHF202  |
| 70                                   | WASHER, locking                              | 2 | GHF332  |

**CLUTCH MASTER CYLINDER - 130887****Brake Servo Kit - TR2-4A**

This remote mounted kit can be retro-fitted to any TR2-4A to boost braking effort. Suitable for all single line brake systems. Installing under the bonnet of a TR4/4A does not present a problem as there is plenty of room. For all models (and particularly TR2/3A), install the servo on the upper front of the passenger's side footwell, facing backwards with the 'nose' of the servo just protruding above the footwell top. The 2 brackets supplied can be mounted on the footwell front or inner wing, or a combination of the two.

|   |                                |   |        |
|---|--------------------------------|---|--------|
| - | REMOTE BRAKE SERVO KIT, TR2-4A | 1 | RH5272 |
|---|--------------------------------|---|--------|

**Brake & Clutch Pedals**

|  |  |   |          |
|--|--|---|----------|
| 71   | BRACKET ASSEMBLY; TR2, TR3 to TS13045 (Lockheed)   | 1 | 106668   |
|  | TR3 from TS13046, TR3A (Girling)   | 1 | 203239   |
| <i>With supply tank mounting bracket.</i>                  |  |   |          |
|  | TR4 to CT26929   | 1 | 132012   |
| <i>With hydraulic operated brake light switch.</i>         |  |   |          |
| 72   | BRACKET ASSEMBLY TR4 from CT26930, TR4A; with mechanical brake light switch on the master cylinder bracket | 1 | 138910   |
| 73   | COVER ASSEMBLY, pedal shaft  | 1 | 106670   |
| 74   | NUT, securing bracket and cover to bulkhead  | 4 | GHF201   |
| 75   | WASHER, locking  | 4 | GHF332   |
| 76   | SCREW, securing master cylinder  | 2 | GHF120   |
| <i>Attaches master cylinder and cover to the bulkhead.</i> |  |   |          |
| 77   | WASHER, locking  | 2 | GHF332   |
| 78   | SCREW, cover to bulkhead   | 2 | SH605051 |
| 79   | WASHER, locking  | 2 | GHF332   |
| 80   | SCREW, pedal stop, TR2, TR3 to TS13045   | 2 | SH604091 |
| 81   | NUT, jam, TR2, TR3 to TS13045  | 2 | GHF200   |
| 82   | BUSH, pedal pivot  | 4 | 100954   |
| 83   | SHAFT, pedal support   | 1 | 110016   |
| 84   | BRACKET, supporting pedal shaft  | 2 | 106678   |
| 85   | SCREW, securing bracket to shaft   | 2 | SH606061 |
| 86   | WASHER, locking  | 2 | GHF333   |
| 87   | CLEVIS PIN; TR2, TR3 to TS13045  | 2 | CLZ516   |
|  | screwed, TR3 from TS13046, TR3A  | 2 | 216421A  |
|  | TR4, TR4A  | 2 | CLZ516   |
| 88   | WASHER, double coil, TR2, TR3 to TS13045   | 2 | WS600051 |
| 89   | SPRING, anti-rattle; TR3 from TS13046, TR3A  | 2 | 57194    |
|  | TR4, TR4A  | 2 | 131787   |
| 90   | WASHER, plain TR2, TR3 to TS13045, TR4, TR4A   | 2 | GHF301   |
| 91   | SPLIT PIN; TR2, TR3 to TS13045   | 2 | PS103121 |
|  | TR3 from TS13046, TR3A   | 2 | PC34     |
|  | TR4, TR4A  | 2 | PC10     |
| <i>PEDAL RUBBER, ribbed</i>                                |  |   |          |
|  | TR2, TR3 to TS13045  | 2 | 105159   |
| 92   | PEDAL RUBBER, 'T' logo TR3 from TS13046, TR3A, TR4, TR4A   | 2 | 122289   |
| 93   | SPRING, pedal return   | 2 | 57950    |

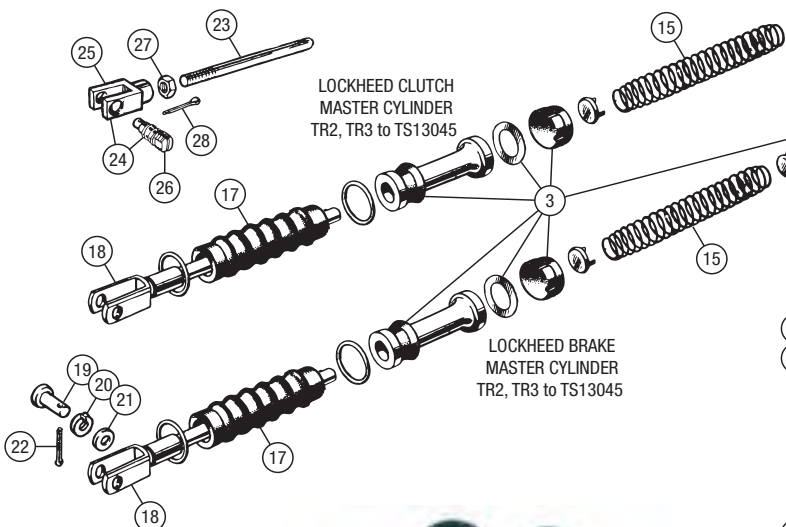
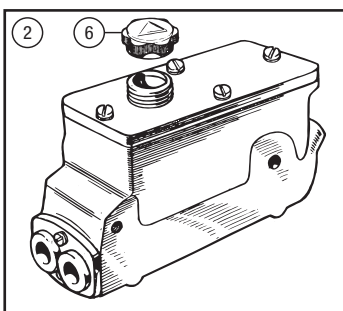
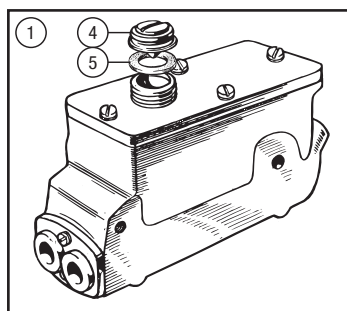
**Clutch Master Cylinder****GIRLING MASTER CYLINDER; TR3 from TS13046, TR3A**

|                                       |   |   |          |
|---------------------------------------|---|---|----------|
| 94                                    | PIPE, supply tank to master cylinder      | 1 | 505062   |
| 95                                    | CLUTCH MASTER CYLINDER                    | 1 | 122167   |
| <i>Includes pushrod but not fork.</i> |   |   |          |
| 96                                    | REPAIR KIT, clutch master cylinder        | 1 | GRK1027  |
| 97                                    | SPRING, piston return                     | 1 | 510815A  |
| 98                                    | SPACER, piston to plunger                 | 1 | 111163   |
| 99                                    | PUSHROD                                   | 1 | 507206   |
| 100                                   | NUT, locking                              | 1 | NT605041 |
| 101                                   | FORK END ASSEMBLY                         | 1 | 57190    |
| <i>Includes items 102, 103.</i>       |   |   |          |
| 102                                   | FORK END                                  | 1 | 57194    |
| 103                                   | SCREW PIN, with spring                    | 1 | 216421A  |
| 104                                   | SPLIT PIN                                 | 1 | PC34     |
| 105                                   | SCREW, master cylinder to support bracket | 2 | SH605071 |
| 106                                   | NUT, plain                                | 1 | GHF201   |
| 107                                   | WASHER, locking                           | 2 | GHF332   |

**CLUTCH MASTER CYLINDER; TR4, TR4A**

|  |  |   |         |
|--|--|---|---------|
| 108  | CLUTCH MASTER CYLINDER; 0.75" bore; includes pushrod | 1 | 130887  |
|  | 0.70" bore; does not include pushrod                 | 1 | 132909  |
| <i>The 0.70" bore master cylinder is identified as such by a marking in the casting.</i> |  |   |         |
| 109  | REPAIR KIT; 0.75" cylinder                           | 1 | GRK1027 |
|  | 0.70" cylinder                                       | 1 | 18G8986 |
| 110  | FILLER CAP   | 1 | 106094  |
| 111  | SEAL, filler cap                                     | 1 | 106095  |
| 112  | SPRING, piston return                                | 1 | 510815A |
| 113  | SPACER, piston to plunger                            | 1 | 111163  |
| 114  | PUSHROD  | 1 | 510197  |
| 115  | SCREW, master cylinder to bracket                    | 2 | GHF103  |
| 116  | NUT, plain   | 2 | GHF332  |
| 117  | WASHER, locking                                      | 2 | GHF202  |



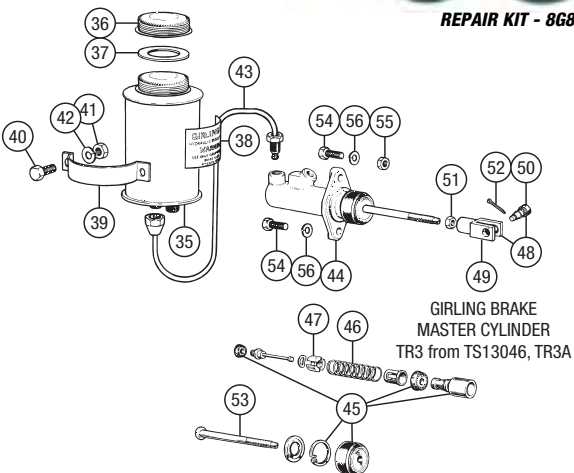


LOCKHEED CLUTCH  
MASTER CYLINDER  
TR2, TR3 to TS13045

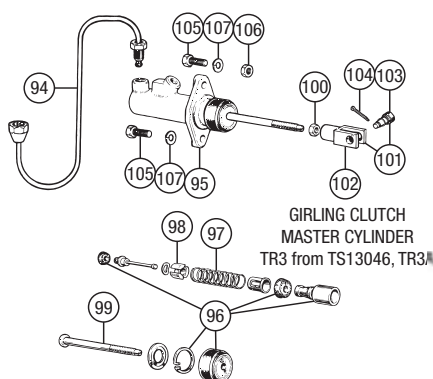
LOCKHEED BRAKE  
MASTER CYLINDER  
TR2, TR3 to TS13045



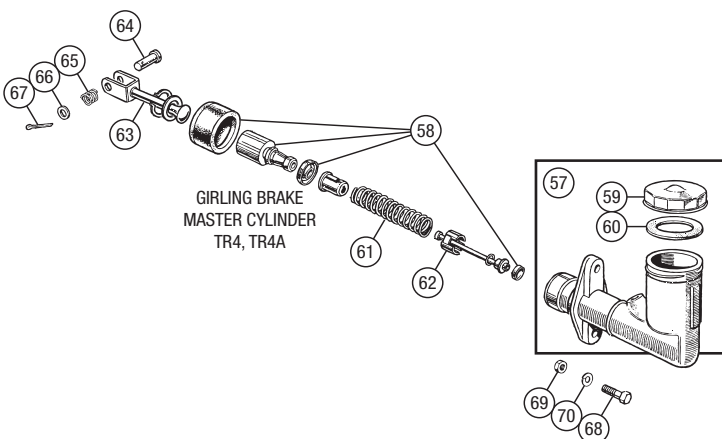
REPAIR KIT - 8G8224



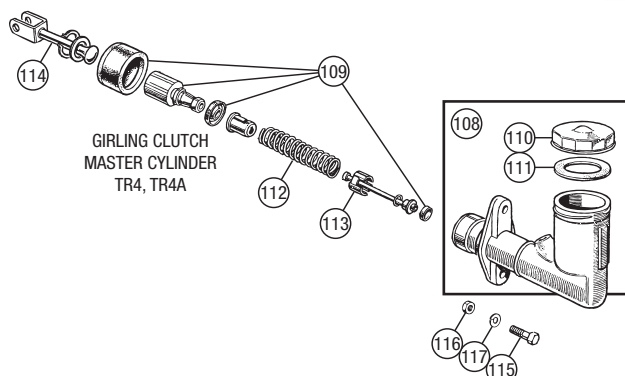
GIRLING BRAKE  
MASTER CYLINDER  
TR3 from TS13046, TR3A



GIRLING CLUTCH  
MASTER CYLINDER  
TR3 from TS13046, TR3A



GIRLING BRAKE  
MASTER CYLINDER  
TR4, TR4A



GIRLING CLUTCH  
MASTER CYLINDER  
TR4, TR4A

FORK END  
ASSEMBLY -  
57190





## TR5-250

MASTER  
CYLINDER  
ASSEMBLY -  
GMC234

## Brake Master Cylinder &amp; Servo

|    |  |   |         |
|----|--|---|---------|
| 1  | MASTER CYLINDER ASSEMBLY, cap and reservoir included                                     | 1 | GMC234  |
| 2  | FLUID RESERVOIR ASSEMBLY, replacement kit  | 1 | 517333  |
| 3  | CAP, filler  | 1 | 214912  |
| 4  | SEAL, filler cap   | 1 | 517041  |
| 5  | SCREW, reservoir to cylinder   | 4 | PX505   |
| 6  | WASHER, locking  | 4 | 517045  |
| 7  | REPAIR KIT, brake master cylinder<br><i>Includes seals for filler cap and reservoir.</i> | 1 | 517332  |
| -  | SEALS ONLY, brake master cylinder  | 1 | 517332S |
| 8  | TIPPING VALVE ASSEMBLY   | 1 | 517033  |
| 9  | SPRING   | 1 | 517028  |
| 10 | SPRING   | 1 | 517031  |

## Servo Repair Kits

All servo repair kits include the following; seal & plate assembly, dust cover, dust cover retainer and filters. The major repair kit also includes the bayonet type non-return valve and O Ring seal. None of the repair kits include the main diaphragm seal.

Construction and design of the servo fitted to the TR5, TR250 and TR6 has changed since production commenced. There are two areas that will need to be observed if the correct repair kits are obtained and used. These items are the servo air inlet non-return valve attachment and the push rod seal between the servo and the brake master cylinder. The servo air non-return valve can be either a bayonet fitting sealed with an 'O' ring or a push-in type valve with a serrated sided seal area that fits into a grommet in the servo.

The other change that is not so easy to see is the seal between the brake master cylinder and the push rod that it acts on in the servo. The easy identification for this is whether the seal is supported in a metal disc or it is a cup shape with groove grooves in it. The latter is also identifiable by a series of parallel knurls on the shank of the push rod. The servo serviced by repair kit no. 12446 is quite rare and to make matters worse it was not allocated to any particular chassis numbers. The difference between the two types of servo is internal so the servo must be dismantled to ascertain which one of the two is fitted. If the master cylinder is removed from the servo, the outside face of the seal and plate assembly will be visible through the aperture to facilitate easy identification. The actual difference is that the master cylinder end of the valve push rod and the servo requiring repair kit no. 12446 has a 3/8 diameter and parallel knurled rod. Those requiring repair kit no. 1868951A are diamond knurled and are 5/16 diameter. The correct seal for the 3/8 pushrod has 6 radially moulded ribs to identify it. (See illustrations A and B opposite)

|    |   |   |          |
|----|---|---|----------|
| 11 | SERVO UNIT ASSEMBLY   | 1 | 218072   |
| 12 | MAJOR REPAIR KIT, servo<br><i>Includes non-return valve.<br/>Servo push rod to master cylinder seal is type supported in a metal disc (ill. A).</i> | 1 | 517330   |
| 13 | REPAIR KIT, servo<br><i>Servo push rod to master cylinder seal is type supported in a metal disc (ill. A).</i>                                      | 1 | 1868951A |

SERVO  
REPAIR KIT -  
1868951A

|    |   |   |        |
|----|---|---|--------|
| 14 | FILTER, air<br><i>It is recommended that the servo air filter (516899), which is a foam seal around the pedal push rod, be changed every 40,000 miles or 3 years.<br/>The filter is part of both types of servo repair kit.</i> | 1 | 516899 |
| 15 | NON-RETURN VALVE, bayonet type  | 1 | 516907 |
| 16 | 'O' RING, non-return valve to servo   | 1 | 516906 |
| 17 | REPAIR KIT, servo<br><i>Servo push rod to master cylinder seal is cup type with grooved surface (ill.B).</i>  | 1 | 12446  |
| 18 | NON-RETURN VALVE, push-in type<br><i>Servo push rod to master cylinder seal is cup type with grooved surface (ill.B).</i>   | 1 | RTC812 |
| 19 | DIAPHRAGM, servo  | 1 | 516901 |

## ORIGINAL (IMPERIAL THREAD) SERVO UNITS

|    |   |   |          |
|----|---|---|----------|
| 20 | NUT, plain, imperial threaded, master cylinder to servo | 2 | GHF201   |
| 21 | WASHER, locking   | 2 | GHF332   |
| 22 | NUT, plain, imperial threaded, servo to pedal box       | 4 | GHF201   |
| 23 | WASHER, locking   | 4 | GHF332   |
| 24 | WASHER, plain   | 4 | WD108051 |

## LATER SUPPLY SERVO UNITS

|    |   |   |          |
|----|---|---|----------|
| 20 | NUT, plain, metric threaded, master cylinder to servo | 2 | GHF214   |
| 21 | WASHER, locking                                       | 2 | GHF383   |
| 22 | NUT, plain, metric threaded, servo to pedal box       | 4 | GHF213   |
| 23 | WASHER, locking                                       | 4 | GHF382   |
| 24 | WASHER, plain   | 4 | WD108051 |

The servo unit may be fitted with metric threaded studs to attach the brake master cylinder.

When installing a new servo ensure new nuts of the correct type are obtained with the servo to save difficulty when installing because of not having the correct fasteners.

|    |   |   |         |
|----|---|---|---------|
| 25 | SPACER, aluminium, servo to bulkhead                          | 1 | 148024  |
| 26 | PIN, clevis, pedal to push rod                                | 1 | PJ8808  |
| 27 | WASHER, plain   | 1 | GHF301  |
| 28 | SPLIT PIN   | 1 | PC10    |
| 29 | SWITCH, brake light   | 1 | 134529  |
| 30 | WASHER, shakeproof  | 1 | GHF325  |
| 31 | NUT, half, locking brake light switch                         | 1 | JN2111  |
| 32 | HOSE, servo to manifold;<br>25" long, RH Steering             | 1 | 159230  |
|    | 30" long, LH Steering   | 1 | 149330  |
| 33 | CLIP, 'Corbin', servo hose clamping                           | 2 | CC5011  |
| 34 | VALVE AND ADAPTOR, non return,<br>screwed into inlet manifold | 1 | ADU1402 |
| 35 | WASHER, fibre   | 1 | WF513   |
| 36 | CLIP, servo hose to rocker cover<br>LH Steering.              | 1 | PCR1011 |

## Brake &amp; Clutch Pedals

|    |  |   |        |
|----|--|---|--------|
| 37 | PEDAL BOX ASSEMBLY, includes pedals;<br>RH Steering                            | 1 | RR1377 |
|    | LH Steering  | 1 | RR1378 |
| 38 | PEDAL SET, RHD, includes accelerator,<br>brake & clutch pedals<br>RH Steering. | 1 | RR1337 |
| 39 | PEDAL BOX, housing only  | 1 | 308273 |
| 40 | BRAKE PEDAL ASSEMBLY;<br>RH Steering   | 1 | 148020 |
|    | LH Steering  | 1 | 148022 |
| 41 | CLUTCH PEDAL ASSEMBLY;<br>RH Steering  | 1 | 148021 |
|    | LH Steering  | 1 | 148023 |
| 42 | PEDAL RUBBER, brake and clutch   | 2 | 122289 |
| 43 | BUSH, pedal to pedal shaft<br>2 per pedal.                                     | 4 | 136611 |

Initial production of cars had plastic pedal bushes (147166), these were found to be insufficiently hard wearing so the installation was modified by the fitment of steel backed bushes. Triumph spares departments subsequently supplied the steel backed bush (136611) for all replacements.

Many cars are however still fitted with the plastic pedal bushes (or what is left of them). A clutch or brake pedal that is able to be wobbled from side to side will indicate worn pedal bushes.

|    |                                       |   |          |
|----|---------------------------------------|---|----------|
| 44 | SHAFT, pedal pivot                    | 1 | 148017   |
| 45 | WASHER, double coil;<br>original      | 2 | 44630    |
|    | alternative                           | 2 | 1A2139   |
| 46 | CIRCLIP, securing ends of pedal shaft | 2 | 506542   |
| 47 | SPRING, pedal return                  | 2 | 57950    |
| 48 | SCREW, upper, pedal box to bulkhead   | 9 | SH604051 |
| 49 | WASHER, locking                       | 9 | GHF331   |
| 50 | WASHER, plain                         | 9 | GHF300   |

## RH STEERING

The following hardware was used to blank holes in the front of the bulkhead on the passenger's side (where the pedal box would attach on LH steering models).

|    |                                     |   |          |
|----|-------------------------------------|---|----------|
| 51 | SCREW, front, pedal box to bulkhead | 2 | SH605051 |
| 52 | WASHER, locking                     | 2 | GHF332   |
| 53 | WASHER, plain                       | 2 | GHF301   |

## Clutch Master Cylinder

For more details of the clutch and its hydraulic system see 'Clutch & Hydraulics' section earlier in this catalogue.

The TR5, TR250 master cylinders were continued unchanged well into TR6 production. However on later TR6s, the bore of the clutch master cylinder assembly changed from 3/4" (0.75) to 7/10" (0.70). The change very effectively lightened the clutch pedal load; the downside was that it aggravated the problem of insufficient clutch clearance on a mechanism that was worn or had a broken tapered pin in the cross shaft. The later, smaller bore diameter, master cylinders may be used to replace earlier types.

If a repair kit is required, before placing an order the cylinder bore diameter must obviously be identified (don't assume because you have an earlier 6 cylinder TR that you have an earlier cylinder fitted). This is simply achieved by reading the size off the exterior of the cylinder.

CLUTCH MASTER CYLINDER  
ASSEMBLY - 148531

## TR5, TR250 Original Fitment (0.75" bore)

|    |  |   |         |
|----|--|---|---------|
| 54 | CLUTCH MASTER CYLINDER ASS'Y;<br>RH steering | 1 | 148531  |
| 55 | CLUTCH MASTER CYLINDER ASS'Y<br>LH steering  | 1 | 148530  |
| 56 | REPAIR KIT                                   | 1 | GRK1027 |

## Later TR6 item (0.70" bore)

May be used on earlier models (see notes)

|    |  |   |         |
|----|--|---|---------|
| 54 | CLUTCH MASTER CYLINDER ASS'Y;<br>RH steering | 1 | 154932  |
| 55 | CLUTCH MASTER CYLINDER ASS'Y;<br>LH steering | 1 | 154933  |
| 56 | CLUTCH MASTER CYLINDER ASS'Y;<br>REPAIR KIT  | 1 | 1868986 |

|    |   |   |        |
|----|---|---|--------|
| 57 | SEAL, filler cap                        | 1 | 106095 |
| 58 | FILLER CAP                              | 1 | 106094 |
| 59 | PIN, clevis, cylinder push rod to pedal | 1 | PJ8808 |
| 60 | WASHER, plain                           | 1 | GHF301 |
| 61 | SPLIT PIN                               | 1 | PC10   |

MASTER CYLINDER  
REPAIR KIT -  
GRK1027

## MASTER CYLINDER ATTACHMENTS;

## RH STEERING

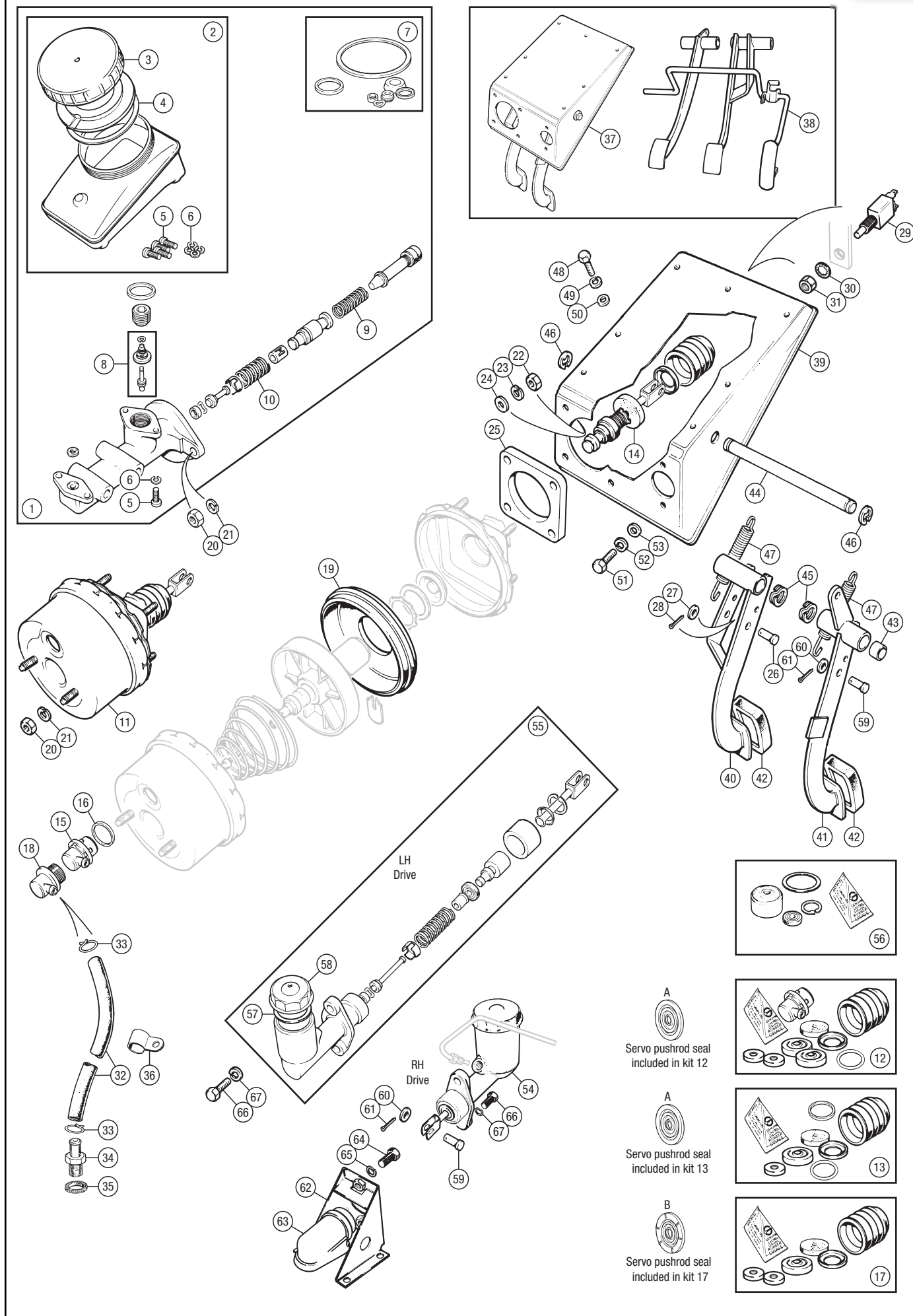
|    |  |   |          |
|----|--|---|----------|
| 62 | BRACKET, mounting clutch master cylinder;<br>painted | 1 | 146413   |
|    | stainless steel                                      | 1 | 146413SS |
| 63 | DUST COVER,<br>pedal to cylinder push rod            | 1 | 125217   |
| 64 | SCREW, cylinder attachment                           | 2 | SH605071 |
| 65 | WASHER, locking                                      | 2 | GHF332   |

## LH STEERING

|    |                            |   |        |
|----|----------------------------|---|--------|
| 66 | SCREW, cylinder attachment | 2 | GHF103 |
| 67 | WASHER, locking            | 2 | GHF332 |

CLUTCH PEDAL ASSEMBLY -  
148021







| No.  | DESCRIPTION  | QTY REQ. | PART No.  | No. | DESCRIPTION   | QTY REQ. | PART No. | No.  | DESCRIPTION  | QTY REQ. | PART No.  |
|--|--|----------|-----------|-----|---|----------|----------|--|--|----------|-----------|
| <b>TR2-4A</b>                                |  |          |           | 10  | ADAPTOR, RH   | 1        | 27H7167  | <b>Clutch Pipes</b>                          |  |          |           |
| <b>Brake Pipes</b>                           |  |          |           | 11  | CONNECTOR, banjo, LH  | 1        | 27H7189  | <b>LOCKHEED SYSTEM - TR2, TR3 to TS13045</b> |  |          |           |
| <b>LOCKHEED SYSTEM - TR2, TR3 to TS13045</b> |  |          |           | 12  | ADAPTOR, LH   | 1        | 59293    | 24   | ADAPTOR;<br>original master cylinder<br>With BSF male thread.          | 1        | 108415    |
| 1  | BRAKE PIPE SET;<br>RH steering                       | 1        | RW3010    | 13  | SWITCH, brake lamp,<br>screw connectors<br><i>Original switch.</i>                  | 1        | 13H2303  |  | replacement master cylinder<br>With UNF male thread.                   | 1        | 21K8564   |
|  | LH steering  | 1        | RW3010LHD | 14  | SWITCH, brake lamp,<br>Lucar connectors<br><i>Later alternative.</i>                | 1        | C16062A  | 25   | WASHER,<br>between master cylinder & adaptor                           | 1        | 233220A   |
| 2  | BRAKE HOSE SET;<br>includes 3 flexible rubber hoses  | 1        | RW3096    | 15  | LUCAR CONNECTOR<br><i>To convert wiring from screwed to Lucar type connections.</i> | A/R      | RTC220A  | 26   | PIPE, master cylinder to chassis bracket;<br>RH steering               | 1        | 108217    |
|  | includes 3 flexible<br>stainless steel braided hoses | 1        | RW3096GR  | 16  | GROMMET, pipe to chassis  | 2        | CD23720  |  | LH steering  | 1        | 108218    |
| 3  | HOSE, flexible;<br>front, rubber                     | 2        | 108595    | 17  | HOSE, flexible;<br>rear, rubber   | 1        | 108596   | 27   | CLIP, pipe to bulkhead<br><i>Quantity increases for RH steering.</i>   | 1/2      | 33084     |
|  | front, stainless steel braided                       | 2        | 108595GR  | 18  | CONNECTOR, 3-way, rear  | 1        | 501505   | 28   | HOSE, flexible, connector to slave cylinder;<br>original specification | 1        | GVP1001   |
| 4  | WASHER, copper, hose sealing                         | 3        | 233220A   | 19  | SCREW, connector to chassis   | 1        | SH605041 |  | stainless steel braided,<br>uprated specification                      | 1        | GVP1001SS |
| 5  | CONNECTOR, RH  | 1        | 59258     | 20  | WASHER, locking   | 1        | GHF331   | 29   | WASHER, copper   | 1        | 538532    |
| 6  | WASHER, locking                                      | 4        | WE600101  | 21  | CLIP, pipe to bulkhead  | A/R      | 59380    |  |  |          |           |
| 7  | NUT, hose to chassis                                 | 4        | 2K8686    | 22  | CLIP, pipe to chassis   | 4        | 59191    |  |  |          |           |
| 8  | WASHER, copper                                       | 3        | 233220A   | 23  | CLIP, pipes to axle housing;<br>plastic 'tie wrap' type                             | 3        | 510969   |  |  |          |           |
| 9  | WASHER, copper                                       | 2        | 538532    |     | metal band type   | 3        | CS4064   |  |  |          |           |

## Brake Pipes

### GIRLING SYSTEM - TR3 from TS13046, TR3A, TR4

|    |   |     |           |
|----|---|-----|-----------|
| 30 | BRAKE PIPE SET;<br>TR3 from TS13046, TR3A                       |     |           |
|    | RH steering   | 1   | RW3011    |
|    | LH steering   | 1   | RW3011LHD |
|    | TR4   |     |           |
|    | RH steering   | 1   | RF4046    |
|    | LH steering   | 1   | RF4046LHD |
| 31 | BRAKE HOSE SET;<br>includes 3 flexible rubber hoses             | 1   | RF4127    |
|    | includes 3 stainless steel<br>braided hoses                     | 1   | RF4127GR  |
| 32 | HOSE, flexible, front;<br>original, rubber                      | 2   | GBH206    |
|    | stainless steel braided   | 2   | GBH122GR  |
| 33 | NUT, brake hose to chassis                                      | 3   | NT606041  |
| 34 | WASHER, locking, brake hoses                                    | 3   | GHF323    |
| 35 | WASHER, copper, hose to caliper                                 | 2   | 233220A   |
| 36 | CLIP, pipe to bulkhead  | A/R | 59380     |
| 37 | CONNECTION, 5-way;<br>TR3 from TS13046, TR3A,<br>TR4 to CT26929 | 1   | 137075    |
|    | CONNECTION, 4-way<br>TR4 from CT26930                           | 1   | 565719    |
| 38 | BOLT, connector to chassis                                      | 1   | BH604101  |
| 39 | NUT, nyloc  | 1   | GHF271    |

## Brake Pipes

### TR4A IRS and Solid Axle

|    |  |     |           |
|----|--|-----|-----------|
| 64 | BRAKE PIPE SET;<br>TR4A IRS  |     |           |
|    | RH steering  | 1   | RF4047    |
|    | LH steering  | 1   | RF4047LHD |
|    | TR4A solid axle  |     |           |
|    | RH steering  | 1   | RF4146    |
|    | LH steering  | 1   | RF4146LHD |
| 65 | PIPE, hose to caliper<br><i>Included in brake pipe sets.</i>         | 2   | 309723    |
| 66 | BRAKE HOSE SET, TR4A IRS;<br>includes 4 flexible rubber hoses        | 1   | RR1428    |
|    | includes 4 flexible stainless steel<br>braided hoses                 | 1   | RR1428GR  |
| 67 | BRAKE HOSE SET, TR4A solid axle;<br>includes 3 flexible rubber hoses | 1   | RF4147    |
|    | includes 3 flexible stainless steel<br>braided hoses                 | 1   | RF4147GR  |
| 68 | HOSE, flexible;<br>front, rubber                                     | 2   | GBH203    |
|    | front, stainless steel braided                                       | 2   | GBH203GR  |
| 69 | NUT <i>(Quantity increases on TR4A IRS)</i>                          | 5/7 | NT606041  |
| 70 | WASHER, locking<br><i>Quantity increases on TR4A IRS.</i>            | 5/7 | GHF323    |
| 71 | CLIP, brake & clutch pipe to bulkhead<br><i>RH steering.</i>         | 1   | 59380     |
| 72 | CLIP, pipe to chassis  | 1   | 618386    |
| 73 | CLIP, pipe to chassis  | 2   | 59191     |
| 74 | CONNECTOR, 4-way   | 1   | 565719    |
| 75 | BOLT, connector to chassis   | 1   | BH604101  |
| 76 | NUT, nyloc   | 1   | GHF271    |

|    |   |     |          |
|----|---|-----|----------|
| 40 | WASHER, plain   | 1   | GHF300   |
| 41 | RESTRICTOR VALVE  | 1   | 116197   |
| 42 | SWITCH, brake light, hydraulic type<br>TR3 from TS13046, TR3A,<br>TR4 to CT26929  | 1   | 126845   |
|    | <i>Originally, TR3s from TS13046 and TR3As up to TS60000 used<br/>screwed wiring connections on their electrical equipment, including the<br/>brake light switch. Only the later switch with Lucar (spade) connections<br/>is now available, but this can of course be used on earlier models if the<br/>connectors on the wiring are replaced.</i> |     |          |
| 43 | LUCAR CONNECTOR<br><i>To convert wiring from screwed to Lucar type connections.</i>   | A/R | RTC220A  |
| 44 | SWITCH, brake light, mechanical type<br>TR4 from CT26930, TR4A  | 1   | 134529   |
| 45 | NUT, thin, locking switch to<br>master cylinder bracket   | 1   | JN2111   |
| 46 | WASHER, shakeproof<br>TR4 from CT26930, TR4A  | 1   | GHF325   |
| 47 | BRACKET, mounting switch<br>TR4 from CT26930, TR4A  | 1   | 138911   |
| 48 | WASHER, locking<br>TR4 from CT26930, TR4A   | 1   | GHF325   |
| 49 | NUT, thin, locking<br>TR4 from CT26930, TR4A  | 1   | JN2111   |
| 50 | GROMMET, pipe to chassis, front   | 2   | CD23720  |
| 51 | CLIP, pipe to frame   | 3   | 59191    |
| 52 | HOSE, flexible;<br>rear, rubber   | 1   | GBH122   |
|    | rear, stainless steel braided   | 1   | GBH122GR |

|                 |   |   |          |
|-----------------|---|---|----------|
| 77              | WASHER, plain   | 1 | GHF300   |
| 78              | RESTRICTOR VALVE <i>(As fitted)</i>                     | 1 | 116197   |
| 79              | SWITCH, brake light, mechanical type                    | 1 | 134529   |
| 80              | NUT, thin, locking switch to<br>master cylinder bracket | 1 | JN2111   |
| 81              | WASHER, shakeproof                                      | 1 | GHF325   |
| 82              | BRACKET, mounting switch                                | 1 | 138911   |
| 83              | WASHER, locking   | 1 | GHF325   |
| 84              | NUT, thin, locking                                      | 1 | JN2111   |
| 85              | UNION, double ended                                     | 1 | ACB5559  |
| <b>TR4A IRS</b> |   |   |          |
| 86              | CONNECTOR, 3-way  | 1 | BTB657   |
| 87              | BOLT, connector to chassis                              | 1 | BH604281 |
| 88              | NUT, nyloc  | 1 | GHF271   |
| 89              | WASHER, plain   | 1 | GHF300   |
| 90              | WASHER, copper  | 1 | 233220A  |
| 91              | HOSE, flexible, rear;<br>LH, rubber                     | 1 | GBH178   |
|                 | LH, stainless steel braided                             | 1 | GBH178GR |
| 92              | HOSE, flexible, rear;<br>RH, rubber                     | 1 | GBH177   |
|                 | RH, stainless steel braided                             | 1 | GBH177GR |
| 93              | CLIP, pipes to trailing arms                            | 2 | 615836   |

### TR4A Solid Axle

|    |   |   |          |
|----|---|---|----------|
| 94 | HOSE, flexible;<br>rear, rubber                         | 1 | GBH216   |
|    | rear, stainless steel braided                           | 1 | GBH216GR |
| 95 | WASHER, copper  | 1 | 233220A  |
| 96 | CLIP, pipes to axle housing;<br>plastic 'tie wrap' type | 2 | 510969   |
|    | metal band type   | 2 | CS4064   |

## Clutch Pipes

### GIRLING SYSTEM

#### TR3 from TS13046, TR3A, TR4

|    |  |   |          |
|----|--|---|----------|
| 59 | PIPE, master cylinder to hose bracket;<br>TR3 from TS13046, TR3A |   |          |
|    | RH steering  | 1 | 507200   |
|    | LH steering  | 1 | 507201   |
|    | TR4  |   |          |
|    | RH steering  | 1 | 305385   |
|    | LH steering  | 1 | 208531   |
| 60 | HOSE, flexible, connector to slave cylinder;<br>original rubber  | 1 | GBH415   |
|    | stainless steel braided,<br>uprated specification                | 1 | GBH415GR |
| 61 | NUT, locking, hose to bracket                                    | 1 | NT606041 |
| 62 | WASHER, shakeproof   | 1 | GHF323   |
| 63 | WASHER, sealing,<br>hose to slave cylinder                       | 1 | 233220A  |

## Clutch Pipes

### TR4A IRS and Solid Axle

|     |  |     |          |
|-----|--|-----|----------|
| 97  | PIPE, master cylinder to union;<br>RH steering                       | 1   | 308362   |
|     | LH steering  | 1   | 148816   |
| 98  | BOLT, banjo, pipe to master cylinder<br><i>RH steering.</i>          | 1   | C5192A   |
| 99  | WASHER, copper<br><i>RH steering.</i>                                | 1   | 216914   |
| 100 | BANJO UNION<br><i>RH steering.</i>                                   | 1   | BHA4310  |
| 101 | WASHER, copper<br><i>RH steering.</i>                                | 1   | 233220A  |
| 102 | ADAPTOR, pipe to master cylinder<br><i>LH steering.</i>              | 1   | 143033   |
| 103 | WASHER, copper<br><i>LH steering.</i>                                | 1   | 233220A  |
| 104 | HOSE, flexible, connector to slave cylinder;<br>original rubber      | 1   | 143354   |
|     | stainless steel braided<br><i>Upated specification</i>               | 1   | 143354GR |
| 105 | ADAPTOR, hose to slave cylinder                                      | 1   | 143033   |
| 106 | UNION, double ended, hose to pipe                                    | 1   | 598693   |
| 107 | CLIP, brake & clutch pipe to bulkhead<br><i>RH steering.</i>         | 1   | 108943   |
| 108 | SCREW, attaching clip<br><i>RH steering.</i>                         | 2   | GHF421   |
| 109 | CLIP, pipe to bulkhead<br><i>Quantity increases for RH steering.</i> | 1/2 | 149766   |
| 110 | SCREW, attaching clip<br><i>Quantity increases for RH steering.</i>  | 1/2 | YM506    |