

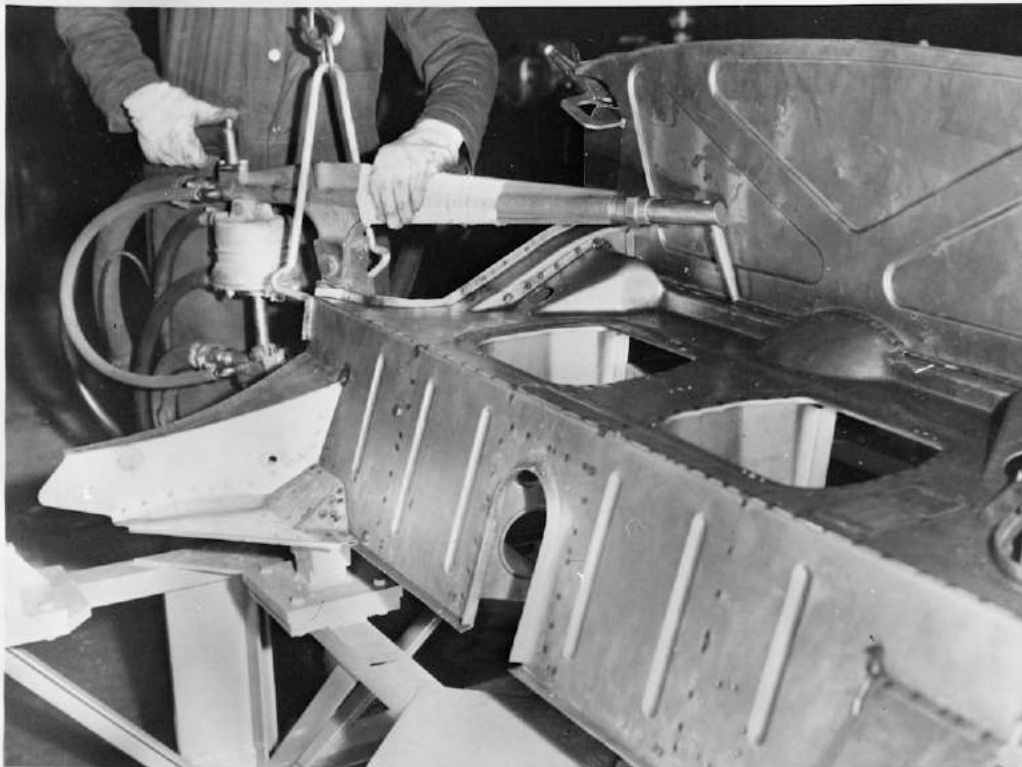


NUFFIELD (BMC) EXPORTS LIMITED

MGB CKD ASSEMBLY MANUAL

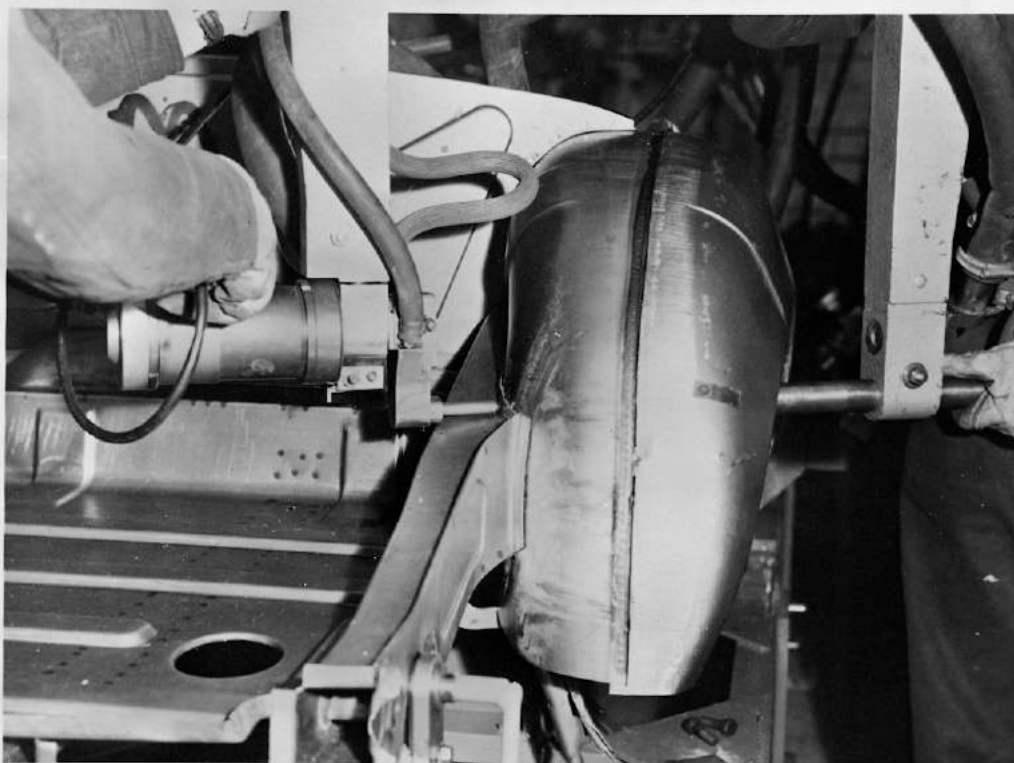
KDM 198 A

Reproduction



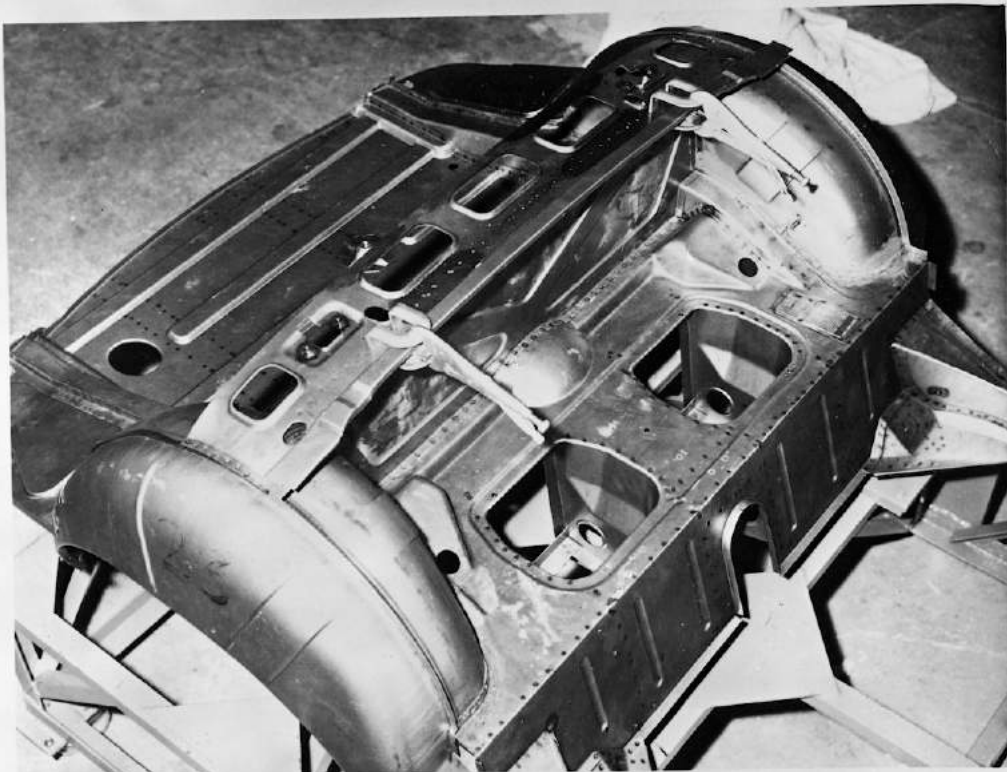
NO. 6.
FACING SHEET NO. 2.
KGB. ADO. 23
KDM. 198

SHOWS SPOTWELDING OF REAR BULKHEAD PANEL H2A.167 TO
REAR FLOOR ASSY. USING GUN KDG.127. SEQUENCE NO. 5.



NO. 8
FACING SHEET NO. 2
M.G.B. ADO. 23
KDM. 198

SHOWS SPOTWELDING OF TOP OF FLOOR ASSY. TO WHEELARCH ASSY.
R. & L.H. SIDES WITH GUN KDG.115
SEQUENCE 7



NO. 10
FACING SHEET NO. 3
M.G.B. ADO.23

SHOWS REINFORCEMENT - TRUNK OPENING - FRONT - HZA.463
CLAMPED IN POSITION WITH SPECIAL CLAMP 771 TF

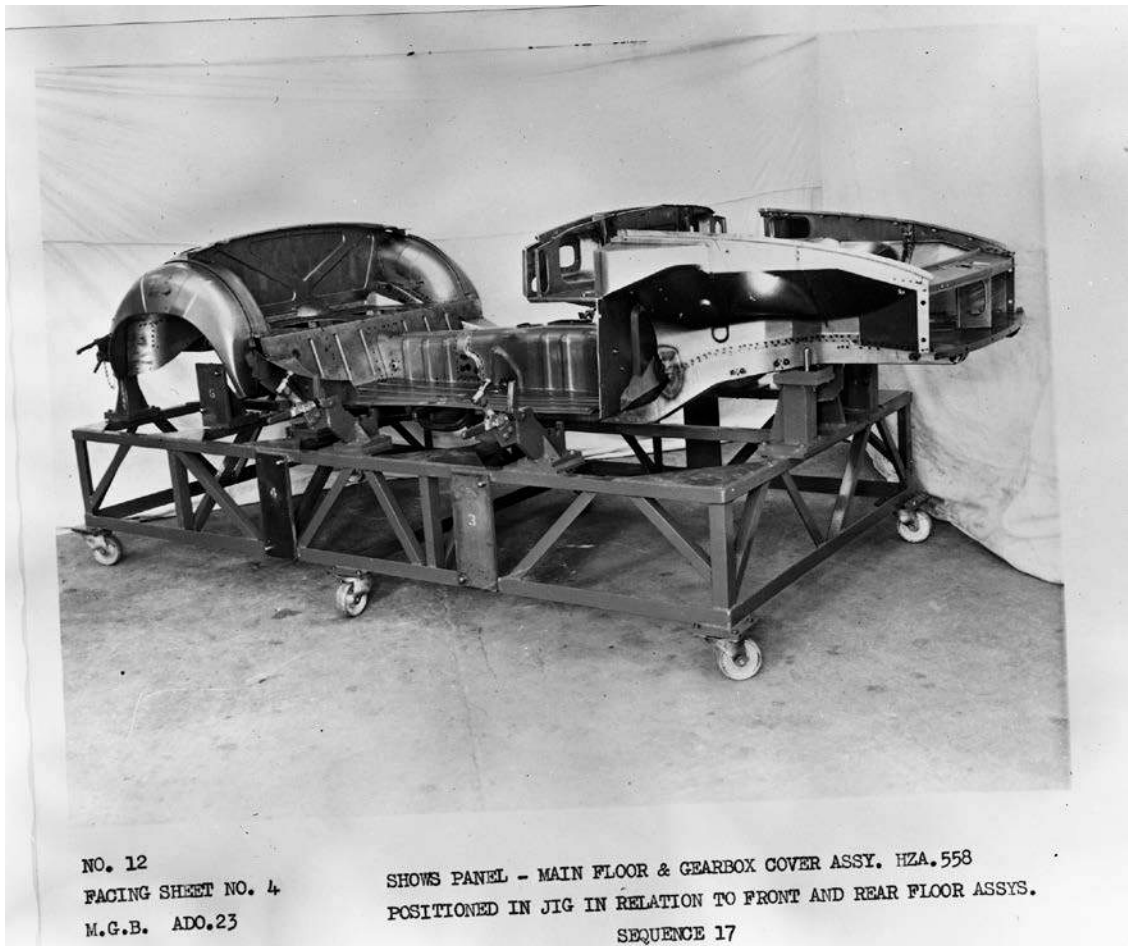
SEQUENCE 12

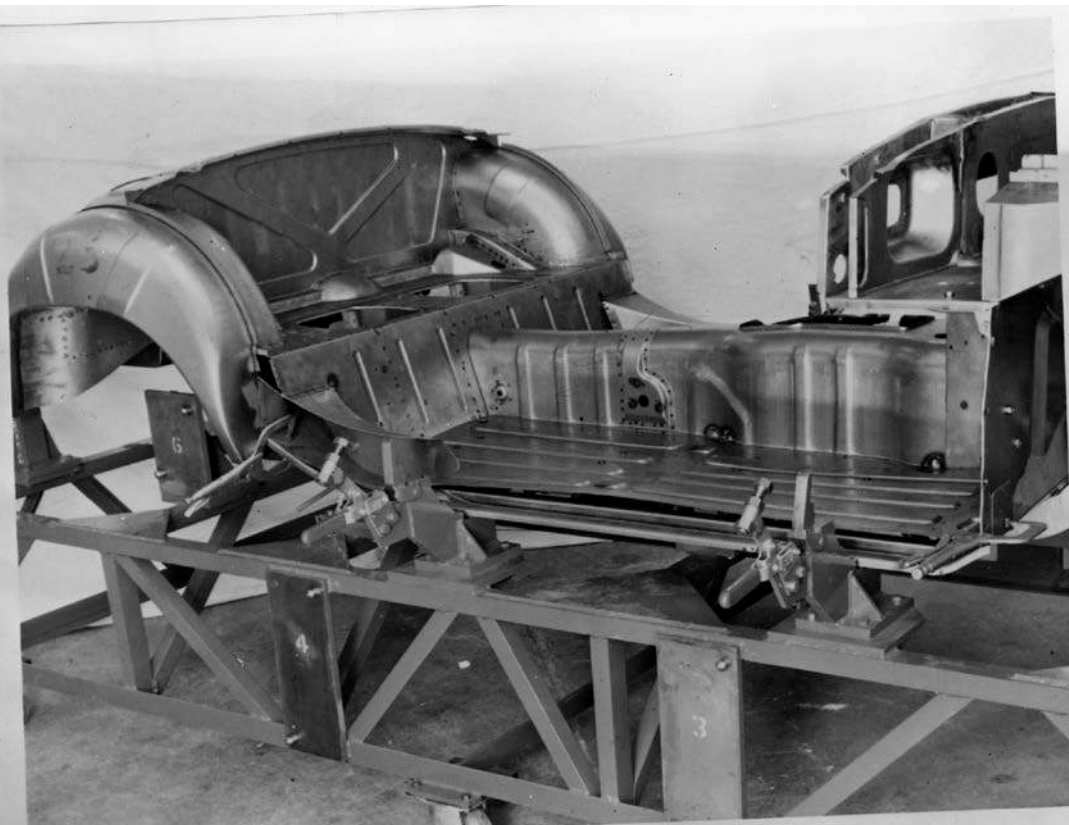


NO. 11
FACING SHEET NO. 4
MGB ADO.23
KDM 198

SHOWS FRONT END ASSEMBLY HZA.554 IN JIG IN
RELATION TO REAR FLOOR ASSY.

SEQUENCE 16.

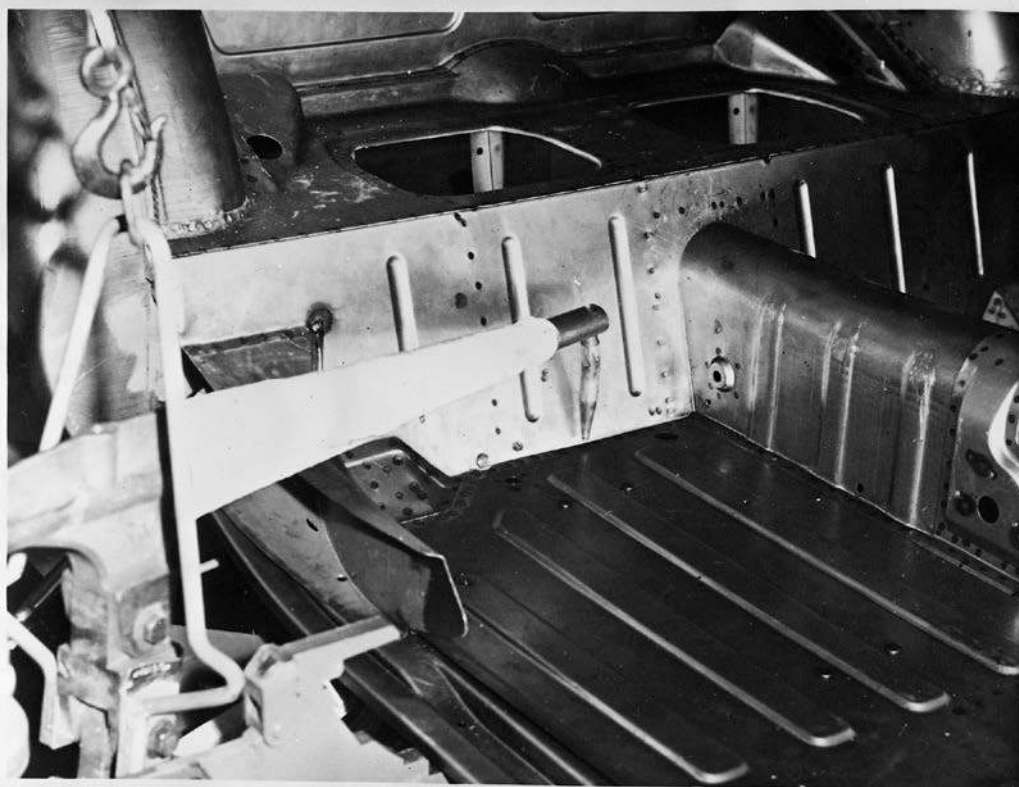




NO. 15
FACING SHEET NO. 4
MGB ADO.23.
KDM 198

SHOWS HZA.482/3 R & LH SIDEMEMBER - BOTTOM (RH SHOWN) IN RELATION
TO MAIN FLOOR - REAR FLOOR & FRONT ENDS.

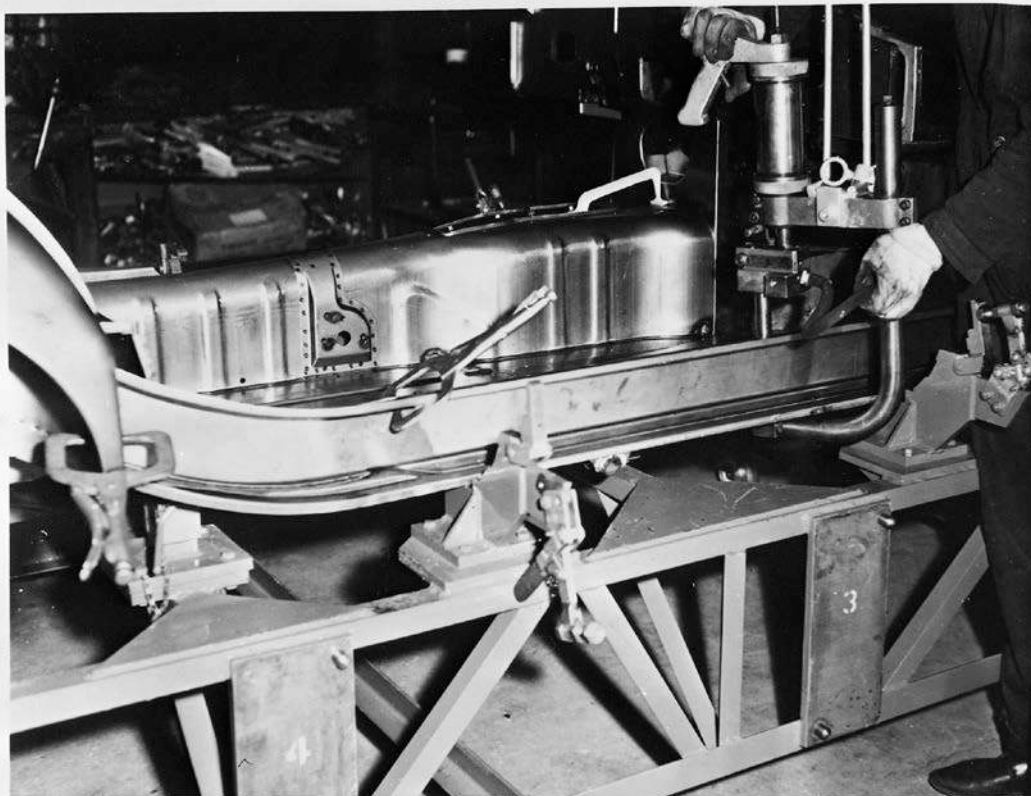
SEQUENCE 18.



NO. 16
FACING SHEET NO. 4
MGB ADO.23
KDM 198

SHOWS GUN KDG.127 IN USE - SPOTWELDING MAIN FLOOR TO
HEELBOARD ET.

SEQUENCE 19.



NO. 18

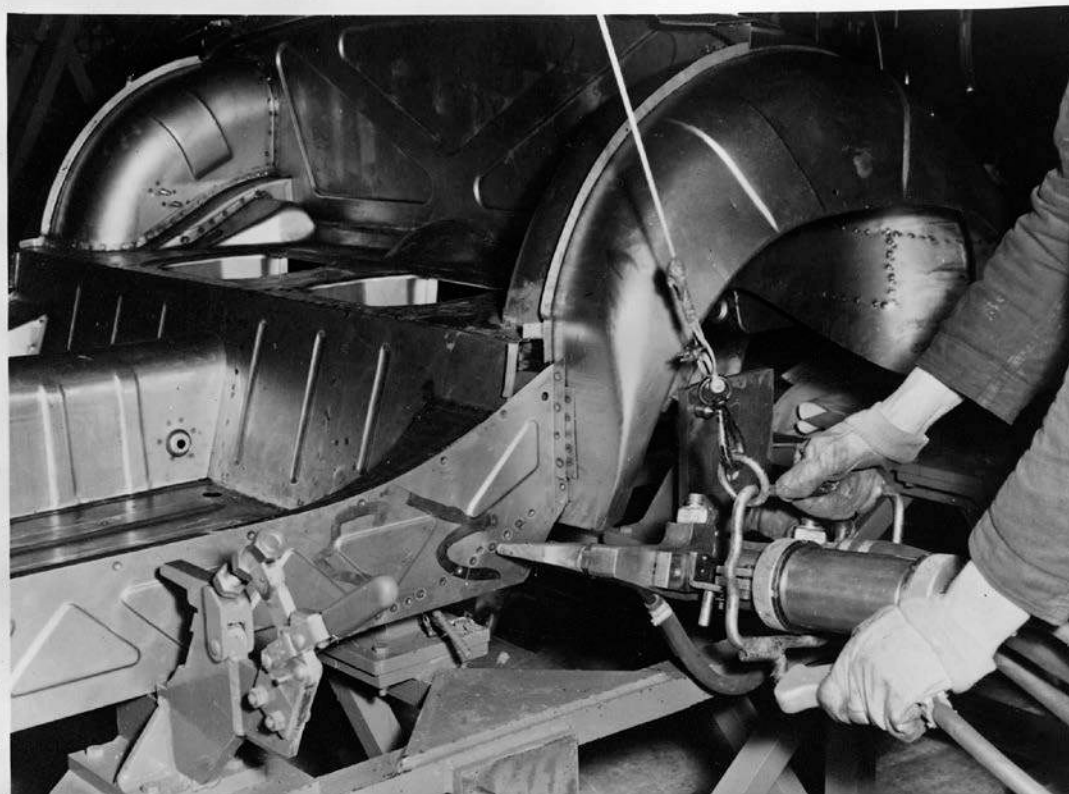
FACING SHEET NO. 5

M.G.B. ADO.23

KIM.198

SHOWS HZA.236/7 SIDEMEMBER - INNER - IN POSITION (R.H. SHOWN)

SEQUENCE 23



NO. 21

FACING SHEET NO. 7

M.G.B. ADO.23

KIM.198

SHOWS SPOTWELDING OF SILL CLOSING PANELS AND SILL
FILLER PIECES AT REAR WHEELARCHES.

SEQUENCE 28



NO. 23
FACING SHEET NO. 8
M.G.B. ADO.23
KDM.198

SHOWS GUN KDG.127 SPOTWELDING FRONT END
OF GEARBOX COVER TO FRONT END.
SEQUENCE 31



NO. 24
FACING SHEET NO. 9
M.G.B. ADO.23
KDM.198

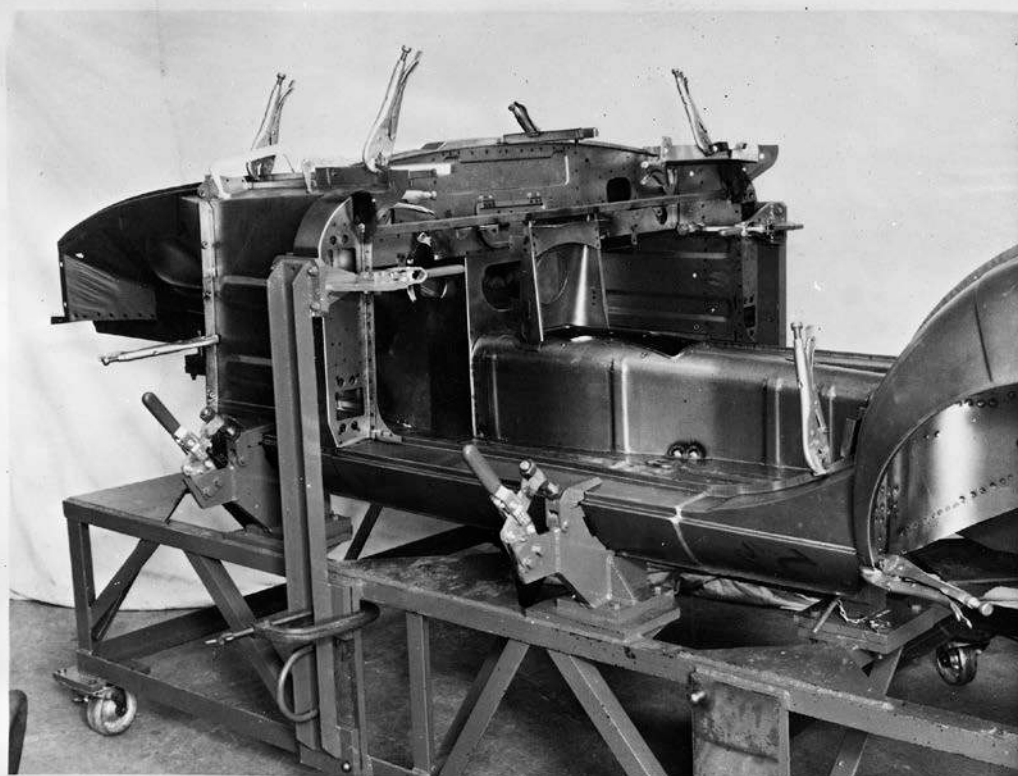
SHOWS HZA.556 PANEL - DASH SIDE ASSYS. R/H IN POSITION
WITH HZA.430 TUBE STIFFENER.
SEQUENCE 33



NO. 26
FACING SHEET NO. 9
M.G.B. ADO.23
KDM.198

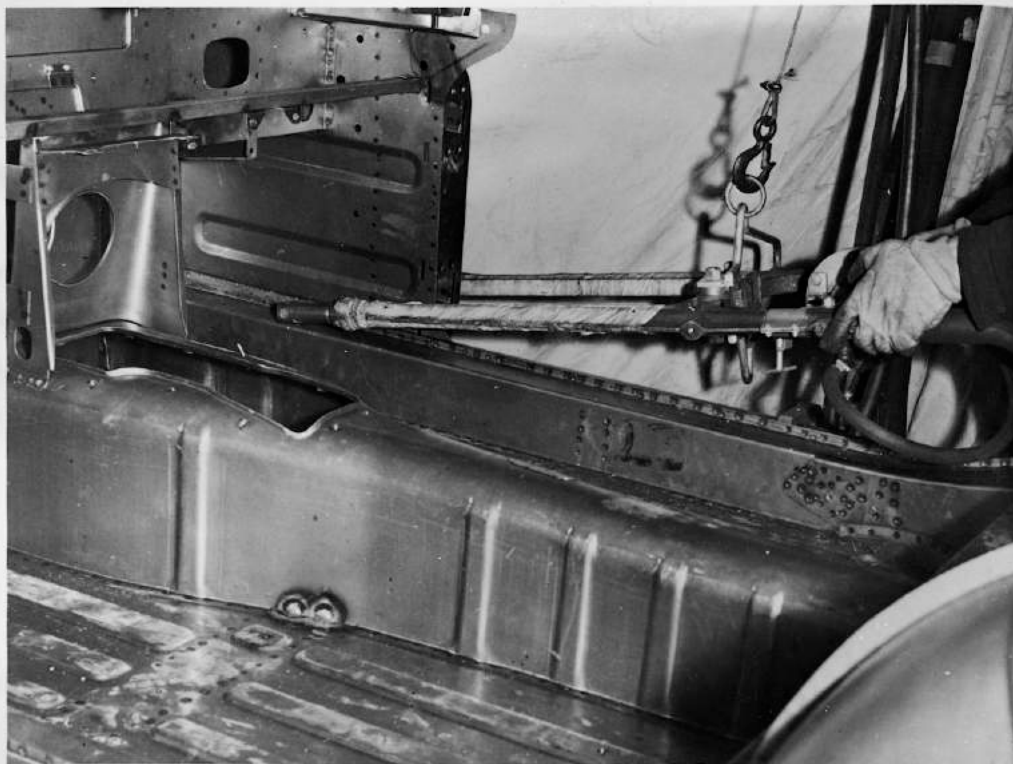
SHOWS DASH SIDE ASSYS. WITH LOCATING UNITS IN
POSITION ON MAIN JIG.

SEQUENCE 33



NO. 30
FACING SHEET NO. 10
MGB. ADO.23
KDM.198

SHOWS HZA.474/5 - STIFFENERS - CORNER - SHROUD ASSY. R & L/H
CLAMPED IN POSITION ON OUTER CORNERS OF SHROUD PANEL. SEQUENCE 36



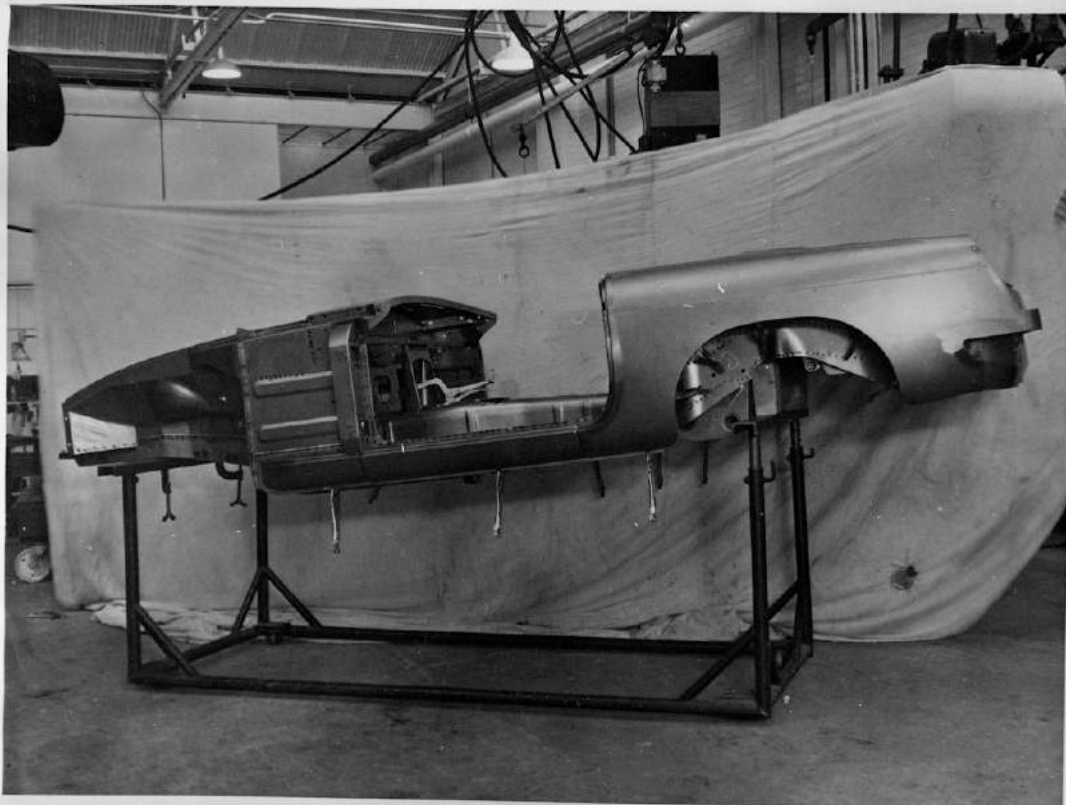
NO. 31
FACING SHEET NO. 10
MGB. ADO. 23
KDM. 198

SHOWS KDG. 127 SPOTWELDING DASH SIDE ASSY. TO SILL FLANGE &
DASH SEQUENCE 38



NO. 33
FACING SHEET NO. 12
MGB. ADO. 23
KDM. 198

SHOWS TONNEAU ASSEMBLY POSITIONED TO ASSEMBLY IN MAIN
JIG WITH LOCATING UNITS AT 'B' POST AND CLAMPED WITH
SPECIAL CLAMPS TO REINFORCEMENT AND TO BULKHEAD USING
STANDARD MOLE CLAMPS.
SEQUENCE 43



NO. 35
FACING SHEET 13
MGE. ADO. 23
KDM. 198

SHOWS BODY SHELL ON PIPE RAIL STAND SEQUENCE. 47



NO. 38
FACING SHEET No. 15
M.G.B. ADO. 23
KDM. 198

SHOWS SOME BRAZING OR GASWELDING POINTS
SEQUENCE 3 - 7 & 8

The part numbers shown may not agree with normal part numbers. These are CKD numbers allocated for CKD purposes by Nuffield (BMC) Exports.

This collection of information taken from original negatives of photographs taken by BMC Australia in 1966.

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