

TECHNICAL INFORMATION



Repairing Body Mount Damage

No: 76/08/03/NAS
Ref:
Issue: 1
Date: 03/21/03

AFFECTED VEHICLE RANGE:

Discovery Series II (LT)

Up to 1A727700

SITUATION:

CRACKS DETECTED IN NUMBER TWO BODY MOUNT

Manufacturing process variability can result in cracks appearing in the number 2 body mount bracket along the top face or at the radius of the top face if a vehicle is subjected to strenuous use.

RESOLUTION:

REPLACE CRACKED BODY MOUNTS

If cracks are found in the specified locations, follow the steps outlined in the Repair Procedure section of this TIB to install new specification body mounts.

PARTS INFORMATION:

KVU100361Chassis bracket Qty 1

Locally Sourced:

- Weld-thru coating (3M #5913, SEM#39283, or equivalent)
- Rustoleum "Hard Hat" coating process
 - Adhesive Primer #2102
 - Zinc Spray (Galva) #2185
 - Flat Black Top Coat #2178

Alternate coating material

- Satin Black "Marhyde" #3811

WARRANTY CLAIMS:

76.11.89/58Time 1.00 hrs.

Install body mount onto frame

FAULT CODE: E

Normal warranty policy and procedures apply.

Material allowance is included in labor operation.

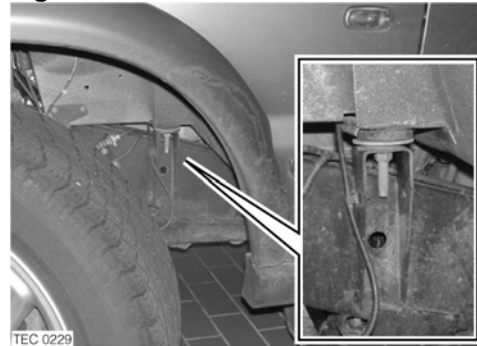
TIB 76/08/03/NAS	CIRCULATE: TO	Service Mgr X	Warranty X	Workshop X	Body Shop X	Parts X
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REPAIR PROCEDURE

INSTALL REPLACEMENT BODY MOUNT

1. Position the vehicle on a lift.
2. Raise the vehicle on the appropriate side and support on stand for access to the weld site.
3. Remove the front road wheel.
4. Mark the vertical fitted position of the existing number 2 body mounting chassis bracket, on the chassis side member.
5. Remove the nut securing the body to the chassis bracket.
6. If the LH side bracket is to be replaced, perform the following:
 - Remove and retain the clip securing the front axle breather tube to the chassis bracket.
 - Move breather pipe aside for access.

Figure 1



LH side number 2 body bracket shown for illustration purposes



WARNING: Prepare for welding and observe all Health and Safety guidelines in accordance with local requirements.



CAUTION: The battery must be disconnected prior to welding and any nearby chassis fittings such as brake pipes and the body mount rubber must be protected from weld spatter and heat to prevent corrosion or damage.

7. Disconnect battery and shield all components around weld area.
8. Remove and discard the damaged bracket from the frame side member.
9. Grind the frame side member until all traces of the original weld have been removed.
10. Spray the weld site with 'Weld-Thru' primer, and allow to dry.
11. Position the new bracket to the vehicle.
12. Install the body stud nut and tighten sufficiently to clamp the chassis bracket to the body mounting.
13. Align the body-mounting bracket to the frame and tack weld in position.
14. Weld a 3mm continuous bead between the outside faces of the bracket and the frame.
15. Remove any weld spatter and contamination from the weld area.
16. Etch prime bare metal, repair paint finish internally and externally as required.
17. Tighten body mount nut to **45Nm (33 lbf.ft)**.
18. If the LH side is under repair, position the front axle breather pipe to the chassis bracket and secure in clip.
19. Install road wheel and tighten nuts to **140Nm (103 lbf.ft)**.
20. Remove stand and lower vehicle.