Despatched
29.5.62 ch
19.6.62 dy

4.7.62
21-8-62

Chassis No: L.SAE.507

HISTORY BOOK

30

INSPECTION & TEST PROGRESS RECORD

	Date	Signature
1. CHASSIS ASSEMBLY	26/4/62	G Walker.
2. BODY MOUNTING	30/4/62	* G Walker
3. BODY ASSEMBLY	2.5.62	* A. Daniels
4. BODY FINAL	2.5.62	* A. Daniels
5. ELECTRICAL CHECK	2.5.62	*
Customs Check		
6. MECHANICAL TEST	8.5.62.	J.A. Sadler.
7. ELECTRICAL TEST	9.5.62	V F Stanley.
8. REFRIGERATION		
9. BODY TEST	11-5-62	* J Sutcliffe
10. FINAL TEST	11-5-62	J Sutcliffe 147 mls.
11. FINAL BODY INSPECTION	23.5.62	* W R Gregory
12. FINAL INSPECTION	23.5.62	* W R Gregory

* Note: These sections are not applicable to Coachbuilders Chassis

This book is to remain with the car/chassis throughout its life in the Factory

RR. 461. A

SAE507

ORDER REF. CR 6647.

SERIAL No.

CHASSIS SPECIFICATION

Rota No.

Chassis Type SILVER CLOUD II Engine No. 254.E8 Chassis No. LSAE.507

W/O 3230 Series FL.9613/E Body No. CT.5338

Battery charged Body Style Silver Cloud II Saloon C/Builder Rolls-Royce.

L.H. Rear Spring UR.3022 R.H. Rear Spring UR.3021

Steering Position Left Hand.

Lock No. BH/L. 587 Radio No. Model 622.T. No.A.024562

PAINTING DETAILS & LINES. Single Deep Blue line.

SHELL GREY. ICI. M.151-2582

TRIMMING DETAILS.

Blue Hide. Vi.3244 with Blue piping. Vi.3244

Grey Bandcloth. R.6517 Ambassador Blue Carpet. 3022

CAR REQUIRED Home Dely 2nd JULY. Red Labels to FS/Hws.

SPECIAL FEATURE FOR USE IN U.S.A.

To be built to the U.S.A. Specification issue 3 - plus.

R.R. Electric Windows.

UD.5293 Electric Aerial - Weld up roof Aerial hole.

Split bench type front seat.

Dunlop White sided tubeless tyres UC.4114

Plain Sundym glass throughout.

Single bolt fixing for safety belts front & rear to 5750/REL.

Vent Mirror to driver's door.
Supply Blue Lambskin rug UB.3784 to rear compartment.
Supply and fit Blue Rubber mat to front compartment only.
Fit UD.4597 mirror to driver's vent frame.
Fit Blue Irvin Lap Belts as UB.2656 but fitted with Irvin lugs 2796 for single bolt fixing to front seats only. W/O.5999/L. E.507

CUSTOMER J.S. Inskip for A. Hutchinson. SF. 20.3.62.

RR. 091

SAE507

☐ ☐ ☐ ☐ Set Tabulator Stops.

Modifications incorporated, additional to Series Specification.

5519/REL
5699/REL
5750/REL
5429/REL
5687/REL
5762/REL
5800/REL
5831/REL
4579/RNL
3662/RNL
4490/RNL
4550/RNL
4638/RNL
4528/RNL

Rear Springs. Poundage & Serial Nos. LH 9575/1233 RH 24143/1127

Front Springs. Poundage & Washers. LH 1690/3 RH 1685/3

Gearbox No. T.5163 Mods. 1-36

Axle. No. 5084 Ratio. 13/40 Gears. DG.440

Master Cylinders. VL.410 - SL.564

Brake Linings. Front. D.S.2 Rear. D.S.2

Engine Sequence No. P.5146

Cylinder Bores.

A1	A2	A3	A4	B1	B2	B3	B4
J	J	J	J	J	J	J	J

Crankshaft. Journals. Standard. /—.005

Pins. Standard. /—.0005

Valve Guide Bores.

Exhaust. Standard/+.005

Inlet. Standard/+.005

RR.093.S.

Chassis N° LSAE 507

ENGINE BUILD CARD

MODIFICATIONS additional to Engine Specification					
RNL4490	RNL4550	REL5800	A	Gearbox	C450
RNL4638	RNL4528	REL5831.			

Engine Sequence Number T5146

Specification L.H R.R U.S.A

Cylinder Liner Bore Grade

A1	A2	A3	A4	B1	B2	B3	B4
J	J	J	J	J	J	J	J

Crankcase Number HB 445 VE-8283 CC

Cyl. Head Nos. 'A' bank L11593 'B' bank L11594

Camshaft Number C330 CC73

Oil Pump Number

Crankshaft Journals : Standard/~~-.005~~

Carburettors 'A' U7. UE8974 'B' U6 UE8975

" Pins : Standard/~~-.005~~

Dynamo Serial Number C48

Valve Guide Bores Exhaust : Standard/+.005

Starter Motor Serial Number V

" " " Inlet : Standard/+.005

Distributor Serial Number 7356

Crankshaft Serial No. XN3137

Gearbox Serial Number T.5163.

SALVAGE SCHEMES INCORPORATED

P.A.S. fitted 700

Lucas Lamid

SNAGS — Corrected by

SHORTAGES — Fitted by

Lines Nut Crankshaft ✓ Air Ducts, Control Rod ✓ APP.

Date to Test 16.4.62 INSPECTOR TO TEST SIGN HERE

SNAGS AFTER TEST — Corrected by

SHORTAGES AFTER TEST — Fitted by

Oil Cooler

Date to Chassis 18/4/62 INSPECTOR TO CHASSIS

Sign here after making out and attaching engine label complete with all outstanding snags and shortages.

RR 196A

SAE507

CHASSIS ASSEMBLY - Operations to be signed for by the Fitter.

Fit Battery Cable	MAH	Identify Engine	
Brackets & Tinning	DH	Fit & Set Brake Servo	
Fit Rear Springs	DH DR	Prop. Shaft—Front 75 lb. ft. Torque	
Z BAR TORQUE	EC	—Rear 45-50 lb. ft. Torque	
Axle U Bolts 60-65 lb. ft. Torque	WG EC	Set Ram for Alignment	
Rear Assembly	DH	Check Ram Clearance	
Stabiliser	DR	Fit Petrol Tank	
Torque tighten Yoke Pin Nuts 250 lb. ft. Torque	WG		
		Fit Gear Control Linkages	RH
Fit Front Shock Dampers	DR		
Toe In LH .070 RH .051	MMSA	Fit Brake Hoses	
Caster LH .045 RH .040	MMSA	Bleed Brakes	
Camber LH .044 RH .041	MMSA	Set Brakes	
Ball Pin Height LH 1 2 3 4 5 6 / 11 10 9 8 7 6 RH +2 flutes NS 1-6	MM	Fit Exhaust System & Earth Straps	RH
Front Susp. Friction LH 31 lbs RH 31 lbs	MMSA		
		Fit Wiring Looms	EDM
Front Sub-assembly	WG EC		
Front Springs & Washers	MM SA	Blow out Exhaust System	RH
Front Stabilizer Bar	MM SA		
Freedom of Centre Steering Lever	MM	Fit Radiator & check all studs	
Rear Shock Dampers	WG. EC		
Locking & Sealing of Front Hubs	SFF		
DS2			
Fit Steering Column & Box	(a)		
Fit Petrol Pump & Pipes VB/954	EC	COACHBUILT	
Fit Master Cylinders		Fit & Set Handbrake	
Grease all points		Fit Wiring	
Fit Brake Equaliser			

SAE 507

Brave Made Ute-Van

CHASSIS ASSEMBLY

MODIFICATIONS					
5429 REL	5687 REL				
5761 REL	5800 REL				

Rear Springs. Poundage & Serial No. LH	9575 — 1233	RH	24143 — 1127
Front Springs. Poundage & Washers. LH	1690 — 3	RH	1685 — 3
Gearbox No. T5163 Mods. 1 To 36	Axle Serial No. 5044	Ratio 13/40	Gears DG 440
Master Cylinders VL 410 — 5L 5 CC	Brake Linings. Front	DS - 2	
Engine Seq. No. P 5146	254ES	Rear	DS - 2
Rear Dampers. LH S2 - 5090	RH S2 - 5091	Steering Box	S2 - 5135
Front Dampers LH S2 - 10206	RH S2 - 10209	Brake Servo	P 4886
Chassis Seq. No. X 3051	Frame No. 4259	Petrol Pump	U8 - 967
Rad. Matrix Nos. P111	6H	5040	

SNAGS	Corrected by
Left Ear at Jacking BKT.	AM

SHORTAGES	Fitted by
Filler Cap	AM.
Hot Air Pipe UE 8233	AM

INSPECTOR. Sign here and inside Front Cover after inspecting to current Inspection Instruction, and checking that all recordable modifications have been entered, and all snags and shortages cleared. I. Walker

RR. 461. C/G.

BODY ASSEMBLY - Operations to be signed for by the Operator.

BODY MOUNTING STATION

Split Steering Column Etc.	AHS	Valance Plates	
Mount Body	AHS	Brake Reservoirs	
Remesh, check freedom & alignment	AHS	Reservoir Pipes & Clips	
Brake Pedal & Gap Plate	AHS	Brake Fluid Level	
Accelerator Pedal & Linkage	AHS	A.C.U.—Black Box	
Speedometer Cable	AHS	—Pipes	
Undersheets	AHS	Oil in Transfer Box & P.A.S. Pump	
Lower Blower Motor	AHS		

BODY ASSEMBLY

Front Wings fitted and adjusted	AHSTW	Rear Light Glass	
Front Doors fitted and adjusted	AHSTW	Front Door Glasses	
Rear Doors fitted and adjusted	AHSTW	Rear Door Glasses	
Door Conduits - Electrical Windows		Door Waist Rail Finishers	
Door Check Straps	AHSTW		
Door Locks and Striker Plates			
Boot Locks			
Bonnet			
Door Frames			
Window Winders (Hand/Electric)			

LHR LD

Fit Safety Belts.
ORANGE.

BODY ASSEMBLY

MODIFICATIONS	Body Sequence No. Y 2710				

SNAGS	Corrected by

SHORTAGES	Fitted by
Brake Fluid	

INSPECTOR	Sign here and inside Front Cover after inspecting to current Inspection Instruction, and checking that all recordable modifications have been entered and all snags and shortages cleared.	2

SNAGS	Corrected by
03 Bonnet Locking Wing	

SHORTAGES	Fitted by

INSPECTOR	Sign here and inside Front Cover after inspecting to current Inspection Instruction, and checking that all recordable modifications have been entered and all snags and shortages cleared.	3 D. Daniels

BODY ASSEMBLY - Operations to be signed for by the Operator.

FINAL BODY ASSEMBLY

Handbrake Assembly		Snags OSRD Adjust Slam Plate	✓
Bonnet Handles		NSRD Stick-Hide at D Post	✓
Seats		NSRD Adjust Slam Plate	✓
		NSFD Improve Wing fit inside Door Shut.	✓
		NSFD Stick Vent Seal.	✓
		NSFD Adjust on Wing	✓
		NSFD Improve Line wing & Sill	✓
		NSFD Adjust Slam Plate	✓
		NS Improve A Post Draughting	✓
		Rectify Sun Visor N/S	✓

ELECTRICAL

Charging Plug Socket Polarity		Map light switch faulty	
Direction Indicators			
Electric Window Lifts — LH Front			
— RH Front			
— LH Rear			
— RH Rear			
A.C.U. Flap Actuators			
A.C.U. Water Tap Actuator			

BODY ASSEMBLY

MODIFICATIONS RHL/4579/3662/

RHL/5519/5699/5750/

SNAGS

	Corrected by
Improve Top of Valance Plate.	
Seal Boot lid	
Stick Boot Seal	
Boot lid Tools.	
Stick Petrol lid Seal	
Stick Dags Legs in Boot	
OSFD Stick Vent Seal.	
OSFD Adjust to Aperture	
OSFD Remove Rattle	
OSFD Adjust Slam Plate	
OSRD Improve Pad to Finish	
OSRD Remove Rattle	

SHORTAGES

	Fitted by

INSPECTOR Sign here and inside Front Cover after inspecting to current Inspection Instruction, and checking that all recordable modifications have been entered and all snags and shortages cleared. 4 A. Daniels

SNAGS

	Corrected by

SHORTAGES

	Fitted by

INSPECTOR Sign here and inside Front Cover after inspecting to current Inspection Instruction, and checking that all recordable modifications have been entered and all snags and shortages cleared. 5

RR. 461 E.

FINISHING LINE

MARKING UP FOR FINAL SPRAY	REMARKS
All body panel work up to standard. Paintwork marked up and ready to spray.	BAD DAMAGE. N/S/F WING. N/S/R/WING. " " BONNET. O/S/F. DOOR. " " F. WING TO SILL. O/S/F WING TOP GAP. O/S/D/POST. MOULDING & HOLE. Inspector

INSPECTION AFTER PAINT RECTIFICATION	REMARKS
Paint satisfactory and car ready for final polish.	ROOF, DOOR & QUARTERS SOKE. JL 10.5.62. Inspector

FINAL POLISH	REMARKS
All paintwork polishing up to standard.	Inspector

FINAL BODY INSPECTION

SNAGS G.- LOK	2.30pm WED. 9-5-62	Corrected by
EASE N/S/F DOOR, FINISHER FOULS 'B' POST.	STICK N/S 'B' POST SEAL WAIST.	DO
N/S/R WINDOW NOT FOULS LOOM	STICK PETROL LID SEAL	DO
SCREWS LOOSE IN BOOT PANELS	RATTLE IN O/S/F DOOR	MG
STICK O/S 'C' POST SEAL. 'A' POST SEAL (TOP)	RTW O/S SUN VISOR, PANEL ADEPT, SCUFFS MIRROR	
R/HAND GLASS SCRAP RB.		
INST PANEL FOULS SCREEN RAIL. LOOSE OBJECT IN O/S SILL. RATTLE O/S/F DOOR HANDLE. MIRROR FOULS WINDOW. N/S/F WIDE STRAY FOULS WHEEL. VIBRATION N/S/F WINDOW GLASS.	TEST
Fit O/S Post Moulding & Finishers	CH
" Lock Screws.	CH
" Rubber Mats.	CH
" O/S Sun Visor	CH
" Boot Handle.	CH
Fit Vinyl Mitts -	CH
Lambskin Rug Supplied	CH.

FINISHING LINE

SHORTAGES		Fitted by
Safety Belts		
o/s 'D' Post Moulding - Finisher		AH
o/s Sun Visor		CB
D/S Rear glass scratched	*	MP
N/S F/D inside Handle scratched Orange		RW
No Roof light		RW
Boot floor rail grommett.		RW
O/S D/O glass scratched	*	DH
O/S F/D " marked.	*	DH
O/S F/D " "	*	DH
Repl-S/Lamp		TM.
Discs		RW
Seam Bonnet.		RW.
N/S F door Tread plate scrap.		RW.
Weld + Polish Drodwork.		JB
Stick Door seal rubbers		RW
Lambskin Lugs Rear + Rubber mat to front Offs.		
Polish W/Frame		SC

INSPECTOR Sign here and inside Front Cover after inspecting all body trimmings, fittings, woodwork, etc., to current Inspection Instruction, and checking that all snags and shortages have been cleared. | II.

FINAL PRODUCTION OPERATIONS

Car thoroughly clean internally and externally, and in a finished state ready for final inspection.

REMARKS

Production Foreman or Chargehand.

H. Dale

FINAL INSPECTION

Car complete to specification, up to standard in all respects, and ready to be passed into Bond.

REMARKS Less Rubber mat.
Less Safety Belts. (NOT AVAILABLE)

INSPECTOR Sign here and inside Front Cover. | 13 Wellington

23-5-62
Type Pressuma wheels & Roof cleaned
Time Tech set Car Complete

RSL 461 F.

ROAD TEST

MODIFICATIONS					

PRELIMINARY CHECK Car checked over, oiled etc., and in satisfactory condition for First Road Test. Routined Oiled OK F.S.	Sign.	A Stubbs & Grant
	Date	3-5-62
	As per Schedule No.	
FIRST ROAD TEST Car given First Road Test, and all matters requiring attention entered on Test Card. ROLLER TEST	Sign.	R Best
	Date	3-5-62
SHOP WORK AFTER FIRST ROAD TEST All matters requiring attention as per Test Card attended to.	Sign.	M Sutton
	Date	4-5-62
	Routine adjustments carried out in accordance with Schedule No.	3
SECOND ROAD TEST Car given Second Road Test. All matters requiring attention after First Road Test checked and satisfactory.	Sign.	M Sutton
	Date	7-5-62
SHOP WORK AFTER SECOND ROAD TEST All matters requiring attention as per Test Card attended to.	Sign.	M Sutton
	Date	8-5-62
FINAL ROAD TEST Car road tested, and up to standard in all respects mechanically. All matters entered on Test Card satisfactory.	Sign. 6.	A Dalton
	Date	8.5.62.
FLUID LEVELS All fluid levels checked, and topped up if necessary,	Sign.	G Hales
	Date	8-5-62
	In accordance with Schedule No.	1A.
ELECTRICAL CHECK All electrical fittings & wiring up to standard. All electrical items mentioned on Test Card attended to.	Sign. 7.	V J Saunders
	Date	9.5.62
REFRIGERATION	Sign. 8.	
	Date	
	All Refrigeration checked, and satisfactory after charging, to Schedule No.	
BODY CHECK All body fittings checked. All body creaks, rattles, etc., eliminated. G Bagley.	Sign. 9.	J Bolderston
	Date	11-5-62
INSPECTION Car inspected and complete to Specification. All modifications checked and recorded in Car History Book. All entries and spaces in Test Cards and above correctly signed for.	Sign. 10.	F Nottingham
	Date	14/5/62
	All danger points checked in accordance with Inspection Instruction No.	5/1

NOTE: 6, 7, 8, 9 & 10. Personnel signing in these spaces are to sign also inside the Front Cover.

Date	LSAE 507 MATTERS REQUIRING ATTENTION	Fitter's/Tester's Signature
	Final Test - Body Shell	
	* Burn marks Top OF Vent of Number Frame	
10/5/62	Seat pan RS Hard Bolt	
	Centre Arch Tray Slicking	
	OS A post Draught Welt away from door Top	
25/5/62	Windscreen Top + Front Seals RSF Window	
	Window Top Rear RSF Window	
	Window Top Rear OSR Window	
	Carpets / Sunblind Ring & Rear Blue Rubber Mats & Front	
	Co. Satisfactory	

CHASSIS L-SAE. 4.00 PM

TEST CARD Chassis No. 507 Engine No. 254.ES. Works O/N.

Date	MATTERS REQUIRING ATTENTION SPEEDO- 99900	Fitter's/Tester's Signature
3/5/62	ROLLER TEST SLAVE TYRES.	
RBest	ENGINE Instruments OK	
35 Kts	Valve spring clicking	MW
+ 24 MILES	Set to 2 F.T.	MW
DD		
	G/BOX Changes late, reset controls	MW
	Remove filters & set bands	MW
	Sticks in reverse	MW
	Reset G/Levers ✓	
	G/Box refilled with oil	F.S
	R/AXLE 52-70-60 - period	
	STEERING Wheel position T.D.C	
	Check preload when link is off	
	Transfer rattle slot ✓	
	Pump moan on locks	
	BRAKES Check adjustments	MW
	Free movement in accel pedals	
	Check all units for leaks	MW
	Carry out routine work	MW
	Check wheels & tyres ✓	

TEST CARD

Chassis No. SHE 507 Engine No. Quality Works O/N.

Date	MATTERS REQUIRING ATTENTION	Fitter's/Tester's Signature
	25-5-62.	
	Edges Polishing + Overlay ✓	
	Stick sealing rubber joints + blocks ✓	H.St.
	Wood stain rear fall tables. ✓	
R.I.W.	Flange Types rejected for brown staining	H. STEELE G. SALISBURY.
	Including spares.	
	Chrome fusing of aerial bank.	J.R.M.

ENGINE

TEST CARD

GEARBOX ~~Chassis~~ No. T5163 Engine No. P5146 Works O/N.

Date	MATTERS REQUIRING ATTENTION	Fitter's/Tester's Signature
14/4/42	ENGINE OIL PRESSURES 88 lbs sq.in. at T.O.	
	44 lbs sq.in. at 40 MPH	
	ENGINE INHIBITED AFTER TEST DTD.791.B.	A.E.Stanman
	ENGINE FILLED WITH ENERGOL SAE.20.	
	GEARBOX OIL PRESSURES 44 lbs sq.in. FORWARD	
	110 lbs sq.in. REVERSE.	
	GEARBOX FILLED WITH MOBILOIL WA.389.	
	SPARKING PLUGS FITTED & GAPPED (TYPE CHAMPION RN.8.	A.E.Stanman
	CYLINDER HEAD FLOW CHECKED AT FOUR POINTS	
	TOROUS PAN REMOVED & CHECKED FOR OIL	
	ENGINE, GEARBOX & UNITS FREE FROM LEAKS.	
	G/Box - Pass, Valve Gear - Pass	
	M/Gears - Pass, Oil Pump - Pass	

Date	MATTERS REQUIRING ATTENTION	Fitter's/Tester's Signature
	Ignition reset 2° B-TDC	MH
	Brake fluid leaking from bottom	
	M/Cylinder (rectify)	MH
	Modified unions fitted to	
	Stg Boost .056	MH
	Standing Height checked 1-125	MH
7/8/62 2 MILES		
	Wheel Pos 2 MINS BTDC	MH
	Changes Satisfactory	
	R/Down easy (reset Centrals)	MH
	Brake drum noise left front Brakes	MH
	PSP noise on locks ?	
14 MILES		
	Petrol Pumps noisey (check)	MH
8.8.62	Pass units.	
16mls.	Change oils Etc.	GH
17mls.	Check auto gear	GH
	Hand to Electrics + Body Section.	

RR 372 C.

TEST CARD

LSAE504

Chassis No. Engine No. 254-ES Works O/N.

Date	MATTERS REQUIRING ATTENTION	Fitter's/Tester's Signature
	Jacking bars OK Routine check complete } Stott	
	Standing Leyland 1.050 1 gall of Petrol	
	Panic Exhaust manifold for Supply spare hose inst. for Door drain hole in Bon- Fit Plastic plug Wiring loom above Servo & rad unit- Fit Tank in body Clips mj 14/3/62.	

Date	MATTERS REQUIRING ATTENTION	Fitter's/Tester's Signature
9.5.62	Electrical Check	
	Boot hinge loom clips tightened	
	Battery cover plate screwed down properly	
	Capping rail light edge sealed	
	Panel light switch not working correctly-ok.	
	Wiper switch knob rattles – OK.	
	Flasher trip on steering centralized	
	Looms tidied LH & RH front of radiator	
	Air flaps reset in closed position	
	Actuator assembly Bracket loose - OK.	
	Wiper motor tube eased off glove box	
	Wiper motor drive greased to lessen noise	
	Time clock noisy - changed.	
	Electrical check Complete	
9.5.62	WATER TESTED	
R Bright	NO Leaks	
15 miles		
	Instrument panel fouling left mid	
	Screw found in knob of cold air control	
	Loose object in sill o/s centre	
	Leathers damaged front of o/sf seat when received at Test	
	Check seat bolts	
	Check arm rest screws.	
	Chatter from radio fascia	
	Loud fan fouling at high speed HOT	
	Bad rattle from OSF seat runners check	

PTO

RR 372 C.

BODY L.SAE. CT. 5338

TEST CARD

Chassis No. 507 Engine No. 254 ES Works O/N.

Date	MATTERS REQUIRING ATTENTION	Fitter's/Tester's Signature
	Windows require attention	RTO
	Paint & Underseal	
	N.S.F. Door judder. Low glass going up.	
	Mirror very close to screen when set correctly	
	Front stay on N.S.F. very faulty	RHB
(E)	Cool air at upper duct, when switch fully clockwise	VJS.
	Aerial lead loose	
Retested 14/11/62	Wind noise - Sun & Frame channels	
(E)	Change clock very noisy.	VJS.
11/5/62	Wash Inspect	
	Dunlop WW Tubeless Tyres fitted	
14-5-62	Check Wheels Nuts & Grease Hubs	
	Check Tyre Pressures	
	Check Engine & Refill Trico Jar	
	Clean Steering Wheel & Shutlers	B Tagg

ENGINE BUILD CARD

Operations to be signed for by Fitter and Inspector

CRANKCASE UNIT	Fitter	Inspector
Check crankcase clean and oilways clear	M Whittaker	
Check all stud holes free from swarf		
Fit core plugs to c'case (Wellseal)	NB	
Fit helicoils to c'case. Last coil to be below counterbore ¼ of a pitch	NB	
Fit inner cylinder head studs (to gauge 3.775-.025)		
Fit centre cylinder head studs (to gauge 2.725-.025)		
Fit outer cylinder head studs (to gauge 1.925-.025)		
Selectively fit cylinder liners (.002/.003 nip)		
Fit cylinder liner rubbers		
Fit cylinder head dowels - 4 off (to gauge .200-.015)		
Fit tappet block dowels - 12 off (to gauge .125-.015)		

ENGINE BUILD	Fitter	Inspector
Fit camshaft and thrust plate. Check float (.002/.006) Check locking of thrust plate		
Check flywheel housing bore to main line bore when requested (.005 max.)		
Fit and check locking of tappet blocks		
Fit crankshaft and thrust washers. Check float (.002/.006) Tighten main bearing nuts (45 lb. ft.)		
Tighten oil pump gear retaining nut		
Check float of distributor gear with distributor fitted (.010/.125)		

ENGINE BUILD (continued)	Fitter	Inspector
Set timing marks. Fit timing gear (10 lb. ft.)		
Check timing gear backlash (.001/0035)		
Check dist. drive backlash (.002/.004)		
Check oil pump backlash (.0012/.006)		
Check piston rings correct and not fractured Check circlips fitted correctly		CW
Fit piston assy. with bolt shields. Check co-relation nos. Tighten conn-rod bolts (32.5 lb. ft.)		
Check sealing rubbers for coolant pump and lower casing fitted correctly		
Oil test c'shaft, camshaft and tappet blocks		
Oil test internal oil pipes Check locking of filter and pipes		
Blue and check flywheel and crankshaft faces. Check run out on torus hub (.007 max.)		
Balance crankshaft assy. in crankcase		
Fit cylinder heads. Tighten cylinder head nuts (40 lb. ft.)		CW
Fit rocker arms, push rods and tappets (graded). Oil test. Tappets to fall under own weight		
Check ignition timing		
Fit dynamo, starter, carbs and controls		
Fit torus cover. Check clearance. Tighten and lock gearbox nut (50 lb. ft.)		
Fit gearbox to engine		
Plug Torque. Bowl Elicott		

RR 196A

RR. 591/

WORKS NUMBER C.16647 CHASSIS NUMBER LSAE 507

REMARKS D/DW/E 7/4/62 AF 7 Hvy 7 RP 27 4 62

DATE	REF. INV. OR C/N	NAME	DESCRIPTION	INVOICE PRICE	CREDITS ON INVOICE PRICE
12/4/62	26251	Mr. Arthur Hutchinson	Silver Cloud II Saloon	£300 0 0	
		530, Abington Avenue	Elec Op Windows	65 0 0	
		Glenside	Elec Op Aerial	20 0 0	
		Pennsylvania USA	Split Bench type front seat	17 10 0	
			Main Sunvisor Glass	12 10 0	
			Lambskin Rug to rear	12 5 0	
			Safety Belts to front seats	10 0 0	
			Rubber mats front	7 10 0	
			Mirror to drivers Vent frame	1 7 6	
			Brit Regn plates	3 10 0	
			Home Dly Handling Dly Chges	33 10 0	
	C28467	R.R. Inc	Comm on Car		1262 0 0
			Comm on Extras		26 5 10
16.8.62	27424	Mr. Arthur Hutchinson	Prep for Shipment	6 0 0	
			Freight London - New York	76 10 0	Price Forces Chges
			Insurance on R Invoice £400	35 2 6	D29318 5/0/6v
11.9.62	C28634	—do—	Refund unexpired R.T. Licence		2 10 0
					Survey Fee 2374 Oct/62.