DRAWING NOT TO BE SCALED

OFFSIDE.

VIEW LOOKING FROM INSIDE OF BODY.

SECTION AT DATUM G

NEARSIDE.

SECTION AT TOP OF CANT CHANNEL

MOD NO	BEFORE ✓	AFTER ✓	PART Nº	DESCRIPTION	MTL	SPEC	Nº PER ASSY
			RT 010 F 1	REAR FRAME STRUCTURE U.S.			1
			RT 010 F 2	GUSSET, CANT RAIL N.S.	*		1
			RT 010 F 3	GUSSET, CANT RAIL O.S.	*		1
			RT 010 F 4	STRESS PANEL N.S.	*		1
			RT 010 F 5	STRESS PANEL O.S.	*		1
			RT 010 F 6	GUSSET	*		1
			RT 010 F 7	SUB PILLAR, O.S.	*		1
115			RT 010 F 8	BOTTOM RAIL	*		1
			RT 010 F 9	TOP PACKING, REAR CANT RAIL	*		1
			RT 010 F 10	FILLET, DESTINATION GLASS	*		2
			RT 010 F 11	PACKING, N.S. PILLAR	*		1
			RT 010 F 12	PACKING, O.S. PILLAR	*		1
			RT 010 F 13	BRACKET, DESTINATION BOX, N.S.	*		1
			RT 010 F 14	BRACKET, DESTINATION BOX, O.S.	*		1
1/16			RT 010 F 16	WAIST RAIL PACKING	*		1
			RT 010 F 17	ANGLE, REAR N.S. CORNER	*		1
			RT 010 F 18	FILLET, PILLAR FINISHER, N.S.	*		1
			RT 010 F 19	FILLET, PILLAR FINISHER O.S.	*		1
			RT 010 F 20	GUSSET, REAR PILLAR, N.S.	*		1
			RT 010 F 21	GUSSET, REAR PILLAR, O.S.	*		1
			RT 010 F 22	TOP PACKING, O.S. CORNER, REAR	*		1
			RT 010 F 23	TOP PACKING, O.S. CORNER, FOR'D	*		1
			RT 010 F 24	REINFORCING PLATE	*		1
			RT 010 F 25	PANEL, FILLET, R.H.	*		1
			RT 010 F 26	PACKING, DESTINATION BOX	*		1
			RT 010 F 27	BOTTOM PACKING, O.S. CORNER, REAR	*		1
			RT 010 F 28	BOTTOM PACKING, O.S. CORNER, FOR'D	*		1
			RT 010 F 29	TOP PACKING, N.S. CORNER, FOR'D	*		1
			RT 010 F 30	TOP PACKING, N.S. CORNER, REAR	*		1
			RT 010 F 31	BOTTOM PACKING, N.S. CNR. FORD	*		1
			RT 010 F 32	BOTTOM PACKING, N.S. CNR. REAR	*		1
			RT 010 F 33	BUFFER BLOCK, O/S	*		1
			RT 010 F 34	BOTTOM GUSSET	*		1
3/16			RT 010 F 47	WAIST RAIL PACKING 5/32	*		1
3/16			RT 010 F 48	WAIST RAIL PACKING 5/32	*		1
			RT 024 F 1	CANT CHANNEL ASSY.	*		1
1&2			RT 037 F 10	CORNER BRACKET	*		2
			RT 056 F 1	REAR WAIST PILLAR U.S.	*		2
			RT 057 F 1	REAR WAIST ANGLE ASSY	*		1
			RT 058 F 1	PACKING, N.S. WAIST.	*		1
			RT 059 F 1	PACKING, O.S. WAIST.	*		1
			RT 060 F 1	REAR PILLAR ASSY. N.S.	*		1
			RT 061 F 1	REAR PILLAR ASSY. O.S.	*		1
			RT 064 F 1	BUFFER BLOCK ASSY. N.S.	*		1
			RT 080 F 1	BOTTOM CANT PACKING ASSY.	*		1
1&2			RT 56 F 1	REAR CANT CHANNEL ASSY N.S.	*		1
1&2			RT 561 F 1	REAR CANT CHANNEL ASSY O/S	*		1
1&2			RT 024 F 6	CANT CHANNEL - CENTRE	*		1
			RT 010 F 35	WAIST FILLET, FORWARD N.S.	BS1CR		1
			RT 010 F 36	WAIST FILLET, REAR N.S.	BS1CH		1
			RT 010 F 37	WAIST FILLET, FORWARD O.S.	BS1CH		1
			RT 010 F 38	WAIST FILLET, REAR O.S.	BS1CH		1
			RT 010 F 39	PANEL PACKING, FORWARD O.S.	BS1CH		1
			RT 010 F 40	PANEL PACKING, REAR O.S.	BS1CH		1
			RT 010 F 41	SEAT TIMING BLOCK	BS1CH		1
1&2			RT 010 F 42	VERTICAL PACKING CANT RAIL	✱		2
115			RT 010 F 43	BOTTOM RAIL	✱		1
5&6			RT 010 F 44	VERTICAL PACKING - CANT RAIL	✱		2
5&6			RT 010 F 45	CONNECTING ANGLE - N/S	✱		1
5&6			RT 010 F 46	CONNECTING ANGLE - O/S	✱		1
			SS 38-9	HEX. HD. BOLT ¼ B.S.F. x 1⅜ LG.	H.T.S.		1
			SS 28-32	HEX. HD. BOLT 2 B.A. x ¾ LG.	H.T.S.		5
3/16			SS 28-36	HEX. HD. BOLT 2 B.A. x 1¼ LG.	H.T.S.		9
			SS 28-35	HEX. HD. BOLT 2 B.A. x 1⅛ LG.	H.T.S.		1
			SS 28-38	HEX. HD. BOLT 2 B.A. x 1½ LG.	H.T.S.		24
			SS 28-39	HEX. HD. BOLT 2 B.A. x 1⅝ LG.	H.T.S.		2
			SS 28-41	HEX. HD. BOLT 2 B.A. x 1¾ LG.	H.T.S.		10
			SS 28-45	HEX. HD. BOLT 2 B.A. x 2¼ LG.	H.T.S.		3
				CSK. HD. BOLT 2 B.A. x 1⅜ LG.	H.T.S.		8
			SS 85-32	HEX. NUT ¼ B.S.F.	M.S.		1
3/16			SS 149-14	HEX. NUT 2 B.A.	M.S.		62
			SS 133-32	GROVER SPRING WASHER ¼ DIA.			1
3/16			SS 135-31	GROVER SPRING WASHER 3/16 DIA.			62
			SS 134-1	PLAIN WASHER 3/16 DIA.	M.S.		43
			SS 134-2	PLAIN WASHER ¼ DIA.	M.S.		1
			SS 113-7	FLAT HD. RIVET 3/16 DIA. x ½ LG.	IRON		16
			SS 114-3	SNAP HD. RIVET 3/16 DIA. x ½ LG.	IRON		AS REQ'D
				SNAP HD. RIVET 3/16 DIA. x ⅝ LG.	IRON		30
				CSK. HD. RIVET 3/16 DIA. x ⅝ LG.	IRON		18
			SS 114-1	SNAP HD. RIVET 3/16 DIA. x ⅞ LG.	IRON		1
			21172-012	CSK. WOODSCREW N°6 x ¾ LG.			AS REQ'D
			21172-007	CSK. WOODSCREW N°8 x 1⅛ LG.			AS REQ'D
			21172-092	CSK. WOODSCREW N°10 x 1" LG.			AS REQ'D
			21172-093	CSK. WOODSCREW N°10 x 1¼" LG.			AS REQ'D
			21171-089	RD. HD. WOODSCREW N°10 x ⅝ LG.			AS REQ'D
			21171-092	RD. HD. WOODSCREW N°10 x 1" LG.			AS REQ'D
			21171-067	RD. HD. WOODSCREW N°8 x 1⅛ LG.			AS REQ'D
			21172-027	CSK. WOODSCREW N°8 x ⅞ LG.			AS REQ'D
			21172-088	CSK. WOODSCREW N°8 x 1⅛ LG.			AS REQ'D
			21171-098	RD. HD. WOODSCREW N°10 x 2" LG.			AS REQ'D
3/16			SS 28-36	HEX HD BOLT 2 B.A. x 1¼ LG.	H.T.S.		10
3/16			SS 134-1	PLAIN WASHER 3/16 DIA.	M.S.		44
3/16			SS 135-31	GROVER SPRING WASHER 3/16 DIA.	SPRING		63
3/16			SS 149-14	HEX NUT 2 B.A.	M.S.		63

✱ SEE SEPARATE DRAWING.

SEE SHEET 3 FOR AFTER ALT. ADV. BF 185

RT 3 TYPE	RT 009 F 1 ASS'D ON	TYPE	ASS'D ON	TYPE	ASS'D ON
ISSUE Nº	1	2	3	4	5
MOD Nº	CLEAR	—	BF 185	ADV BF 216	
DATE	11-7-63	16-3-65	24-6-66	8-12-66	
DRAWN	RC/JW	AR	M.H.C.B.	P.M.E.	P.N.H.C.
CHECKED	L.C.S.	RC	W.V.B.	P.M.E.	
PASSED	L.C.S.	✓	P.M.E.	P.M.E.	
ISSUE Nº					
DATE					
DRAWN					
CHECKED					
PASSED					

DEPARTMENT OF THE CHIEF MECHANICAL ENGINEER (ROAD SERVICES)
L.T. CHISWICK WORKS, LONDON, W.4.

PROCESS SPECIFICATION	TITLE	PART Nº
SEE DATA SHEET 10 FOR PROCESS DURING ASSEMBLY	REAR FRAME STRUCTURE U.S.	RT 010 F 1
		SHEET 1 OF 3 SHEETS
	ALL PARTS MUST BE MARKED WITH DATE LETTER & PART Nº	

ALTERATIONS
ISSUE 1 7-5-63 RC
MODIFY ALTERATION
ISSUE 2 16-3-65 RC
MAKE ADDITIONAL HOLES
ISSUE 3 24-6-66 RC
BF 185 ADDED THUS
PART NO. RT 010 F 43 ADDED
PART NO. RT 010 F 47 ADDED
RT 010 F 48 ADDED
ISSUE 4 8-12-66 RC
ADVICE BF 216 ADDED
OFF PART NO. 56 - 58 - 561 - 024 F 6
SS 135-31 & SS 149-14
-16" INCREASED BY
-1/16" DIA
1/64 DIA HOLE
ADDED