

BENTLEY 'R' TYPE

SECTION E

ENGINE

Containing:-

| | | |
|-------|----|----------------------------|
| GROUP | 1. | CONNECTING RODS & PISTONS. |
| " | 2. | CRANKCASE. |
| " | 3. | CRANKSHAFT. |
| " | 4. | CYLINDER HEAD. |
| " | 5. | FLYWHEEL. |
| " | 6. | OIL PUMP & RELIEF VALVE . |
| " | 7. | SPRING DRIVE. |
| " | 8. | VALVE MECHANISM. |
| " | 9. | WHEELCASE. |

KEY TO CHASSIS NOTES.

| | | | | |
|----------------------|--|---|---|---|
| Used on | R Series | = | K | |
| Used on | S Series onwards | = | L | |
| Used on | R Series | } | = | M |
| Used on chassis B-SR | All chassis | | | |
| Used on chassis B-SP | 1-165, 169, 187-201, 207, 255 | | | |
| Used on BC-A | 1-16, 18 to end | } | = | N |
| Used on BC-B | 1-12 | | | |
| Used on B-SP | 167, 171-185, 203, 205, 209-253 & onwards | } | = | O |
| Used on BC-A | 17 | | | |
| Used on BC-B | 14 onwards | | | |
| Used on | R Series | } | = | O |
| Used on chassis B-SR | 2-444, 458, 460, 470-478 482, 486, 488, 498 | | | |
| Used on chassis B-SP | 1, 7, 9, 41-57 | | | |
| Used on chassis BC-A | 1-16, 18-25 | | | |
| Used on chassis BC-B | 1-3, 5 | | | |

KEY TO CHASSIS NOTES.(Cont'd)

| | | | | |
|--------------------------|--|---|---|----|
| Used on chassis B-SR | 446-456, 464-468, 480 | } | = | P |
| | 484, 490-496, 500 | | | |
| Used on chassis B-SF | 3, 5, 11-39, 59 & onwards | | | |
| Used on chassis EC-A | 17 | | | |
| Used on chassis EC-B | 4, 6 and onwards |) | | |
| Used on | R/S Series | } | = | R |
| Used on chassis B-TO | 1-9, 21-35, 39-47, 89, 91 | | | |
| Used on chassis B-TO | 11, 15, 17, 19, 37, 49-87, 93 & onwards |) | = | S |
| Used on chassis B-WH | 226, 228, 230, 326 on S/S 24 on. on C/B |) | = | X |
| Used on chassis EC-A | All chassis | } | = | FF |
| Used on chassis EC-B | All chassis | | | |
| Used on chassis EC-C | 1-3 | | | |
| Used on chassis EC-C | 4 onwards |) | = | GG |
| Used on | R.S.T. Series | } | = | HH |
| Used on B-UL | 1-49, 61-125, 129-149, 153-161, 169 | | | |
| Used on Continental | A & B Series | | | |
| Used on EC-C | 39 |) | | |
| Used on B-UL | 51-59, 127, 151, 163-167 171 & onwards | } | = | JJ |
| Used on Continental EC-C | 40 (L) onwards. | | | |
| Used on | R.S.T.U.W. Series | } | = | KK |
| Used on B-YA | All chassis, | | | |
| Used on B-YD | 2-256, 308-318, 324, 328 | | | |
| Used On Continental | A.B.C. Series | | | |
| Used on EC-D | 1-42 | | | |
| Used on B-YD | 258-306, 320, 322, 326, 330 | } | = | LL |
| Used on B-ZX | 1 & onwards | | | |
| Used on Continental | EC-D. 43 onwards | | | |

SCHEDULE OF SPARE PARTS

REF. NO. PART NO. QUANTITY GROUP ASS'LY NOTES

GROUP E.1. CONNECTING RODS & PISTONS.

Comprising:-

| | | | | |
|---|---|-----------|----|----|
| BUSH, connecting rod, large end, pair of | 1 | RE.3236 | 6 | |
| BUSH, connecting rod, large end, pair of .005" u/s in bore | | RE.4850 | | |
| BUSH, connecting rod, large end, pair of .010" u/s in bore | | RE.9906 | | |
| BUSH, connecting rod, large end, pair of .020" u/s in bore | | RE.15121 | | |
| BUSH, connecting rod, large end, pair of .030" u/s in bore | | RE.19999 | | |
| BUSH, connecting rod, small end | 2 | EB.5211 | 6 | |
| PIN, split, connecting rod bolt | 3 | E.84689 | 12 | |
| PISTON, assembly, consisting of | 4 | see below | 6 | |
| Pin, gudgeon with caps | | RE.11304 | 1 | |
| Piston | | See below | 1 | |
| Ring, compression | | See below | 1 | |
| Ring, tapered | | See below | 1 | |
| Ring, scraper, Slotted | | See below | 1 | |
| ROD, connecting, assembly, consisting of:- | 5 | RE.9469 | 6 | Kx |
| Bolt | | EB.2701 | 12 | + |
| Bush, small end | | EB.5211 | 6 | |
| +Cap | | RE.9439 | 6 | |
| Nut | | EB.2220 | 12 | |
| +Rod | | RE.9438 | 6 | |
| ROD, connecting, assembly, consisting of:- | | RE.17457 | 6 | Lo |
| Bolt | | RE.13414 | 12 | = |
| Bush, small end | | EB.5211 | 6 | |
| +Cap | | RE.13413 | 6 | |
| Nut | | RE.14185 | 12 | |
| +Rod | | RE.13412 | 6 | |

| Size. | Piston Assy. | Piston. | Compression Ring | Taper Ring. | Scraper Ring. |
|----------|--------------|----------|------------------|-------------|---------------|
| Standard | RE.14773 | RE.14761 | RE.15787 | RE.15788 | RE.13605 |
| + .005" | RE.15789 | RE.15778 | RE.15798 | RE.15807 | RE.13766 |
| + .010" | RE.15790 | RE.15779 | RE.15799 | RE.15808 | RE.13767 |
| + .015" | RE.15791 | RE.15780 | RE.15800 | RE.15809 | RE.13768 |
| + .020" | RE.15792 | RE.15781 | RE.15801 | RE.15810 | RE.13769 |
| + .025" | RE.15793 | RE.15782 | RE.15802 | RE.15811 | RE.13770 |
| + .030" | RE.15794 | RE.15783 | RE.15803 | RE.15812 | RE.13771 |
| + .035" | RE.15795 | RE.15784 | RE.15804 | RE.15813 | RE.13772 |
| + .040" | RE.15796 | RE.15785 | RE.15805 | RE.15814 | RE.13773 |
| + .045" | RE.15797 | RE.15786 | RE.15806 | RE.15815 | RE.13774 |

SCHEDULE OF SPARE PARTS

REF. NO. PART NO.

QUANTITY
GROUP ASSEMBLY

NOTES

GROUP E.1. CONNECTING RODS & PISTONS (Cont'd)

Comprising:-

NOTES:- + - .002" o/s on fitting diameter - RE.13832
 .004" o/s on fitting diameter - RE.8435
 = - .002" o/s on fitting diameter - RE.17708
 .004" o/s on fitting diameter - RE.17705
 * - B.S.F. thread
 ø - Unified thread.

GROUP E.2. CRANKCASE.

Comprising:-

ADAPTOR, Crankcase, Oil Feed Assembly,

Consisting of:-

Adaptor, Oil pressure switch (Solenoid) RE.21688 1 LL
 Casing RE.13894 1
 Plug, core, top CS.8629 1
 Plug, front (when pressure gauge connection
 is taken from rear end of crankcase) RE.13938 1 HH
 Plug, side RE.13273 1 KK
 Washer, joint plug (When pressure gauge
 connection is taken from rear end of
 crankcase) KB.1078 1
 Washer, joint, core plug KB.1089 1
 Washer, joint, plug KB.1096 1

ADAPTOR, Coolant pump to crankcase assembly.

Consisting of:-

Adaptor RE.7484A 1 M
 Stud RE.7484 1
 KB.409/Z 4

ADAPTOR, Coolant pump to crankcase assembly,

as above, except

Adaptor RE.16322A 1 N
 RE.16322 1

ADAPTOR, cylinder drain tap

RE.4808 1 O

ADAPTOR, cylinder drain tap

3 RE.17083 1 P

ARM, swivel, dynamo belt adjusting

4 RE.13825 1

BAFFLE, oil, crankcase, lower half

5 EB.4063 1

BOLT, .250" dia. wheelcase retaining

X.10 K.209/Z 2

BOLT, .312" dia. dynamo belt, swivel arm

X.5 KB.8551 1

BOLT, .312" dia. dynamo to bracket

X.5 KB.8559/Z 2

BOLT, .312" dia. fitting wheelcase

6 RE.13424 2

BOLT, .312" dia. fitting wheelcase

7 RE.13425 1

E2/11/54.

SCHEDULE OF SPARE PARTS

REF. NO. PART NO.

QUANTITY
GROUP ASSEMBLY

NOTES

GROUP E.2. CRANKCASE. (Continued)

Comprising:-

| | | | | |
|---|----|----------|---|---|
| BOLT, Steady Bracket, Starter Motor. | 8 | RE.21292 | 1 | X |
| BRACKET, dynamo assembly | 9 | RE.19726 | 1 | |
| BRACKET, petrol pipe (RC) | 10 | RE.9290 | 1 | |
| BRACKET, steady starter motor | 11 | RE.21290 | 1 | X |
| BRACKET, support, exhaust, RC. | 12 | RE.13395 | 1 | |
| BUSH, camshaft, bearing, front | 13 | RE.210 | 1 | |
| BUSH, camshaft bearing, intermediate | 14 | EB.3892 | 2 | |
| BUSH, camshaft bearing, rear | 15 | EB.4146 | 1 | |
| BUSH, crankshaft bearing, centre, lower half standard size | 16 | RE.3241 | 1 | |
| .005 u/s in bore | | RE.4845 | | |
| .010 u/s in bore | | RE.9913 | | |
| .020 u/s in bore | | RE.15125 | | |
| .030 u/s in bore | | RE.15133 | | |
| .040 u/s in bore | | RE.15141 | | |
| .050 u/s in bore | | RE.20336 | | |
| .060 u/s in bore | | RE.15149 | | |
| BUSH, crankshaft bearing, centre, upper half standard size | 17 | RE.3240 | 1 | |
| .005 u/s in bore | | RE.4844 | | |
| .010 u/s in bore | | RE.9912 | | |
| .020 u/s in bore | | RE.15124 | | |
| .030 u/s in bore | | RE.15132 | | |
| .040 u/s in bore | | RE.15140 | | |
| .050 u/s in bore | | RE.20335 | | |
| .060 u/s in bore | | RE.15148 | | |
| BUSH, crankshaft bearing, front, lower half standard size | 18 | RE.12852 | 1 | |
| .005 u/s in bore | | RE.15988 | | |
| .010 u/s in bore | | RE.15906 | | |
| .020 u/s in bore | | RE.15910 | | |
| .030 u/s in bore | | RE.15914 | | |
| .040 u/s in bore | | RE.15918 | | |
| .050 u/s in bore | | RE.20342 | | |
| .060 u/s in bore | | RE.15922 | | |
| BUSH, crankshaft bearing, front, upper half standard size | 19 | RE.12851 | 1 | |
| .005 u/s in bore | | RE.15987 | | |
| .010 u/s in bore | | RE.15905 | | |
| .020 u/s in bore | | RE.15909 | | |
| .030 u/s in bore | | RE.15913 | | |
| .040 u/s in bore | | RE.15917 | | |
| .050 u/s in bore | | RE.20341 | | |
| .060 u/s in bore | | RE.15921 | | |

SCHEDULE OF SPARE PARTS

REF. NO. PART NO.

QUANTITY
GROUP ASS'LY

NOTES

GROUP E.2. CRANKCASE (Cont'd)

Comprising:-

| | | | | |
|---|----|----------|---|---|
| BUSH, crankshaft bearing, intermediate, lower half standard size | 20 | RE.3243 | 4 | |
| .005 u/s in bore | | RE.4847 | | |
| .010 u/s in bore | | RE.9915 | | |
| .020 u/s in bore | | RE.15127 | | |
| .030 u/s in bore | | RE.15135 | | |
| .040 u/s in bore | | RE.15143 | | |
| .050 u/s in bore | | RE.20338 | | |
| .060 u/s in bore | | RE.15151 | | |
| BUSH, crankshaft bearing, intermediate, upper half standard size | 21 | RE.3242 | 4 | |
| .005 u/s in bore | | RE.4846 | | |
| .010 u/s in bore | | RE.9914 | | |
| .020 u/s in bore | | RE.15126 | | |
| .030 u/s in bore | | RE.15134 | | |
| .040 u/s in bore | | RE.15142 | | |
| .050 u/s in bore | | RE.20337 | | |
| .060 u/s in bore | | RE.15150 | | |
| BUSH, crankshaft bearing, rear, lower half standard size | 22 | RE.12854 | 1 | |
| .005 u/s in bore | | RE.15990 | | |
| .010 u/s in bore | | RE.15908 | | |
| .020 u/s in bore | | RE.15912 | | |
| .030 u/s in bore | | RE.15916 | | |
| .040 u/s in bore | | RE.15920 | | |
| .050 u/s in bore | | RE.20344 | | |
| .060 u/s in bore | | RE.15924 | | |
| BUSH, crankshaft bearing, rear, upper half standard size | 23 | RE.12853 | 1 | |
| .005 u/s in bore | | RE.15989 | | |
| .010 u/s in bore | | RE.15907 | | |
| .020 u/s in bore | | RE.15911 | | |
| .030 u/s in bore | | RE.15915 | | |
| .040 u/s in bore | | RE.15919 | | |
| .050 u/s in bore | | RE.20343 | | |
| .060 u/s in bore | | RE.15923 | | |
| CLIP, breather to crankcase | 24 | RE.5467 | 1 | |
| CLIP, cylinder drain pipe | 25 | RE.4811 | 1 | P |
| CONNECTION, swivel plug, pressure gauge | | RE.5721 | 1 | |
| CONNECTION, banjo, pressure gauge | 26 | RE.4830 | 1 | |
| CONNECTION, rocker oil feed | 27 | E.85380 | 1 | |
| COVER, blanking, breather face | 28 | RE.5466 | 1 | |
| COVER, rear camshaft bearing | | EB.4147 | 1 | M |

SCHEDULE OF SPARE PARTS

REF. NO. PART NO.

QUANTITY
GROUP ASSEMBLY

NOTES

GROUP E.2. CRANKCASE (Cont'd)

| | | | | |
|---|------|-----------|----|---|
| COVER, rear, camshaft bearing | 29 | RE.14028 | 1 | N |
| COVER, tappet | 30 | RE.19140 | 2 | |
| CRANKCASE, lower half, assembly, Consisting of | 31 | RE.10417A | 1 | |
| Crankcase, lower half | | RE.10417 | 1 | |
| Adaptor | | KB.6107/Z | 2 | |
| Stud, 2 BA, Oil baffle | X.62 | KB.299/Z | 4 | |
| CRANKCASE, upper half assembly, Consisting of | | RE.16911 | 1 | M |
| Cap, main bearing, centre | | RE.4026 | 1 | |
| Cap, main bearing, front | | RE.12877 | 1 | |
| Cap, main bearing, intermediate | | RE.186 | 1 | |
| Cap, main bearing, rear assembly, Consisting of | | RE.13836A | 1 | |
| Cap | | RE.13836 | 1 | |
| Disc, expanding | | RE.3228 | 1 | |
| Cover, coolant jacket (RC) | | EW.1431 | 3 | |
| Cover, coolant jacket (LC) | | EW.1431 | 2 | |
| Cover, coolant jacket (LC) | | RE.8257 | 1 | |
| Cover, rear, coolant jacket | | RE.4910 | 1 | |
| Crankcase, upper half | | RE.16911 | 1 | |
| Gallery, coolant assembly, Consisting of | | RE.10475 | 1 | |
| Cap | | RE.10473 | 1 | |
| Gallery | | RE.10474 | 1 | |
| Strip, support | | RE.14508 | 1 | |
| Guide, valve exhaust | | RE.5890 | 6 | |
| Insert, cylinder bore | | RE.10967 | 6 | |
| Insert, distributor oil feed | | RE.3634 | 1 | |
| Joint, coolant jacket cover | | RE.4864 | 3 | |
| Joint, rear coolant jacket cover | | RE.4911 | 1 | |
| Nut, full, .375 dia. main bearing caps | X.21 | K.4010/Z | 14 | |
| Plug, corehole, coolant pump facing | | RE.9016 | 1 | |
| Plug, corehole, distributor feed | | CS.8628 | 1 | |
| Plug, corehole, end faces, front & rear | | RE.16302 | 2 | |
| Plug, corehole, oil gallery, front face | | CS.8628 | 1 | |
| Plug, corehole, oil gallery, rear face | | CS.8628 | 1 | |
| Plug, corehole, tappet chamber | | RE.4782 | 2 | |
| Plug, corehole, water jacket | | RE.20740 | 2 | |
| Screw, countersunk, 2 BA, coolant jacket cover | X.50 | K.2804/Z | 27 | |
| Screw, hex.head, 2 BA, seal petrol pipe bracket holes (LC) | | KC.151/Z | 2 | |
| Stud, adaptor, casing | X.66 | KB.359/Z | 4 | |
| Stud, blanking cover, breather face | X.66 | KB.751/Z | 2 | |
| Stud, breather clip | X.65 | KB.3826/Z | 1 | |
| Stud, tappet cover | | RE.329 | 4 | |
| Stud, 2 BA, petrol pipe bracket (RC) | X.61 | KB.650/Z | 2 | |

SCHEDULE OF SPARE PARTS

REF. NO. PART NO.

QUANTITY
GROUP ASS'LY

NOTES

GROUP E.2. CRANKCASE. (Cont'd).

CRANKCASE, upper half assembly, Consisting of (Cont'd)

| | | | | |
|--|------|----------|----|--|
| Stud, 2 BA, oil pressure valve, retaining | X.61 | KB.660/Z | 3 | |
| Stud, .250" dia. camshaft thrust plate retaining | X.66 | KB.750/Z | 3 | |
| Stud, .250" dia., wheelcase | X.66 | KB.751/Z | 6 | |
| Stud, .250" dia., distributor housing retaining | X.66 | KB.765/Z | 2 | |
| Stud, .250" dia. exhaust manifold | X.68 | KB.359 | 12 | |
| Stud, .312" dia. dynamo bracket | X.73 | KB.400/Z | 4 | |
| Stud, .312" dia. front face engine mounting | X.71 | KB.820/Z | 3 | |
| Stud, .312" dia. coolant pump, adaptor retaining | X.71 | KB.802/Z | 5 | |
| Stud, .312" dia. oil filter retaining | X.71 | KB.800/Z | 4 | |
| Stud, .312" dia. oil pump retaining | X.71 | KB.804/Z | 1 | |
| Stud, .375" dia. cylinder head, long | | RE.10427 | 9 | |
| Stud, .375" dia. cylinder head, short | | RE.10425 | 30 | |
| Stud, .375" dia. main bearing cap, retaining | | RE.14982 | 14 | |
| Washer, aluminium, .750" dia. core plug, oil gallery | X.83 | KB.1082 | 2 | |
| Washer, aluminium, .750" dia. insert RE.3634 | | KB.1091 | 1 | |
| Washer, aluminium, 1.00" dia. core plug tappet chamber | X.83 | KB.1092 | 2 | |
| Washer, lock, bearing cap | X.89 | KB.7108 | 14 | |

| | | | | |
|---|------|-----------|----|---|
| CRANKCASE, upper half assembly, as above except | 32 | RE.16217 | 1 | N |
| Crankcase | | RE.16217 | 1 | |
| Cover, rear, coolant jacket | | RE.20845 | 1 | |
| Gallery, coolant assembly, consisting of | | RE.16345 | 1 | |
| Cap | | RE.16085 | 1 | |
| Gallery | | RE.16324 | 1 | |
| Strip, support | | RE.14508 | 1 | |
| Joint, rear, coolant jacket cover | | RE.14031 | 1 | |
| Plate, end, water gallery | | UE.524 | 1 | |
| Plug, oil pressure gauge connection rear end (when connection is made to adaptor) | | KC.300/Z | 1 | |
| Plug, core, inclined holes, coolant jacket | | RE.9016 | 2 | |
| Screw, countersunk head 2 BA, coolant jacket cover | X.50 | K.2804/Z | 18 | |
| Screw, set, end plate to crankcase | X.54 | KC.170/Z | 1 | |
| Screw, set, rear coolant jacket cover | X.55 | KC.203/Z | 6 | |
| Washer, screw, rear coolant jacket cover | X.82 | KB.1076 | 6 | |
| Washer, plug (KC.300/Z) when fitted | X.83 | KB.1078/Z | 1 | |
| Washer, plug, core, inclined holes | X.83 | KB.1094 | 2 | |
| Washer, tab, screw, end plate to crankcase | X.89 | KB.7104 | 1 | |
| Core plug RE.20740 deleted. | | | | |

SCHEDULE OF SPARE PARTS

REF. NO. PART NO. QUANTITY GROUP ASS'Y NOTES

GROUP E.2. CRANKCASE (Cont'd)

| | | | | |
|---|------|----------|----|-----|
| DIPSTICK, oil level, assembly | 33 | RE.4783 | 1 | |
| DOWEL, clutch housing | 34 | RE.319 | 2 | |
| DOWEL, cylinder head, centre | 35 | E.50362 | 1 | |
| DOWEL, locating crankcase, lower half | 36 | RE.10416 | 2 | |
| FULCRUM, TV controls (Automatic Gearbox) (LC) | | RE.19988 | 1 | |
| HOUSING, distributor, assembly, consisting of | 37 | RE.9829 | 1 | |
| Housing | | RE.3558 | 1 | |
| Stud, .250" dia. | X.68 | KB.352/Z | 1 | |
| JET, distributor, oil feed | | RE.14428 | 1 | |
| JOINT, breather blanking cover | 38 | EB.4055 | 1 | |
| JOINT, coolant pump adaptor to crankcase | 39 | EB.4219 | 1 | M |
| JOINT, coolant pump adaptor to crankcase | | RE.16323 | 1 | N |
| JOINT, coolant pump to adaptor | 40 | RE.5772 | 1 | |
| JOINT, cork, tappet cover | 41 | RE.5427 | 2 | |
| JOINT, cylinder head to crankcase | 42 | RE.14764 | 1 | |
| JOINT, distributor housing to crankcase | 43 | EB.4042 | 1 | |
| JOINT, exhaust manifold to crankcase | 44 | EB.4039 | 6 | |
| JOINT, oil relief valve to crankcase | 45 | EB.3953 | 1 | |
| JOINT, rear, camshaft bearing cover | 46 | EB.4179 | 1 | M |
| JOINT, rear, camshaft bearing cover | | RE.14292 | 1 | N |
| JOINT, upper to lower crankcase | 47 | RE.10419 | 1 | |
| JOINT, wheelcase to crankcase | 48 | RE.6341 | 1 | |
| JOINT, adaptor to casing | 49 | RE.9425 | 1 | |
| NUT, full, .500" dia. steady bracket | | K.4012/Z | 1 | X * |
| NUT, full, 2 BA oil baffle (4) oil relief valve (3) | X.21 | K.4006/Z | 7 | |
| NUT, full, 2 BA petrol pipe bracket (RC) | | K.4006/Z | 2 | |
| NUT, .250" dia. exhaust manifold retaining | 50 | EW.1833 | 12 | |
| NUT, full, .375" dia. cylinder head to crankcase | X.21 | K.4010/Z | 37 | |
| NUT, reach, .375" dia. cylinder head to crankcase | 50A | RE.11531 | 2 | |
| NUT, full, engine mountings tud, front face (3) & oil pump stud (1) | X.21 | K.4009/Z | 4 | |
| NUT, full, .250" dia. support plate steady bracket | | K.4008/Z | 2 | X * |
| NUT, half, .250" dia. adaptor casing (4)breather blanking cover (2) camshaft thrust plate (3) breather clip (1) distributor housing and clamping (3) Wheelcase facing studs and bolts (8) | X.24 | K.4310/Z | 21 | |
| NUT, half, .312" dia. coolant pump adaptor (5) coolant pump to adaptor (4) dynamo to bracket (2) dynamo bracket stud (4) wheelcase fitting bolts (3) dynamo swivel arm (1) oil filter (4) | X.24 | K.4313/Z | 23 | |
| NUT, half .500 dia. support plate | | K.4322/Z | 1 | X * |
| NUT, pipe cylinder drain | 51 | RE.3593 | 1 | P |
| NUT, sleeve, tappet cover retaining | 52 | RE.5189 | 4 | |
| NUT, reach, strap starter motor | 53 | RE.14511 | 1 | X * |
| PIECE, distance, strap starter motor | 54 | RE.21293 | 2 | X * |

SCHEDULE OF SPARE PARTS

REF. NO. PART NO.

QUANTITY
GROUP ASSY LY

NOTES

GROUP E.2. CRANKCASE (Cont'd)

| | | | | |
|--|------|-----------|----|-----|
| PIECE, distance, downtake support (LC) | | RF.513 | 1 | |
| PIN, taper relief valve overflow pipe retaining | X.32 | K.4846 | 1 | |
| PIECE, distance, fulcrum T.V. controls (Automatic Gearbox LC) | | RE.19989 | 1 | |
| PIPE, cylinder drain assembly. (complete with clip, nipple and nut) | | RE.4809 | 1 | O |
| PIPE, cylinder drain assembly. (complete with nipple) | 55 | RE.19800 | 1 | P |
| PIPE, oil relief valve overflow | 56 | EP.4041 | 1 | |
| PIPE, oil return, rear bearing cap | 57 | EP.4032 | 1 | |
| PLATE, support, starter motor | 58 | RE.21291 | 1 | X * |
| PLATE, camshaft thrust | 59 | RE.142 | 1 | |
| PLATE, filter mounting | | RE.15087 | 1 | |
| PLUG, boss, T.V. controls | | KB.1052/Z | 1 | = |
| PLUG, oil gallery, rear | | KC.300/Z | 1 | Z |
| PLUG, oil drain, lower half crankcase | 60 | RG.3744 | 1 | |
| SCREW, adjusting, steady bracket, starter motor | 61 | RE.14510 | 1 | X * |
| SCREW, cheesehead, 3 BA, oil level unit | X.45 | K.1807/Z | 6 | |
| SCREW, countersunk head 2 BA rear camshaft bearing cover | X.50 | K.2810/Z | 4 | M |
| SCREW, hex head .250" dia., distributor | 55A | RE.3559 | 1 | |
| SCREW, hex head .250" dia. wheelcase facings(2) & oil feed pipe (2) | X.55 | KC.231/Z | 4 | |
| SCREW, hex head .312" dia. filter to mounting plate | X.56 | KC.277/Z | 2 | |
| SCREW, hex head .312" dia. lower half crankcase | X.56 | KC.281/Z | 18 | |
| SCREW, hex head .312" dia. drain pipe clip (1) & exhaust pipe stay (1) | X.56 | KC.282/Z | 2 | |
| SCREW, hex head, .4375" dia. clutch casing (RC) | | KC.376/Z | 2 | |
| SCREW, hex head, .4375" dia. clutch casing (LC) (synchromesh gearbox) | | KC.372/Z | 2 | |
| SCREW, hex head, .4375" dia. clutch casing (LC) (Automatic gearbox) | | KC.376/Z | 2 | |
| SCREW, hex head, .250" dia. sealing water jacket No.2. & 5 cylinders (RC) | X.55 | KC.901 | 2 | |
| SCREW set, .250" dia. rear camshaft bearing cover | X.55 | KC.905/Z | 4 | N |
| SCREW set, .250" dia. support plate steady bracket | | KC.214/Z | 2 | X * |
| SCREW set, 2 BA, T.V. fulcrum (LC. automatic gearbox) | X.54 | KC.152/Z | 1 | |
| SCREW set, .500" dia. support plate | | KC.412/Z | 1 | X * |
| SEAL, oil, rear crankshaft bearing | 62 | RE.7144 | 2 | |
| SHAFT, distributor, driving, assembly with dog RE.4921 | 63 | RE.4920 | 1 | |
| SPACER, strap, starter motor | 64 | RE.21294 | 2 | X * |
| STAY, downtake support (LC)(2.375" long) | | RE.8310 | 1 | |
| STAY, downtake support (LC)(2.750" long) | | RE.8311 | 1 | |

SCHEDULE OF SPARE PARTS

REF. NO. PART NO. QUANTITY
GROUP ASS'Y NOTES

GROUP E.2. CRANKCASE (Cont'd)

| | REF. NO. | PART NO. | QUANTITY GROUP ASS'Y | NOTES |
|---|----------|-----------|-------------------------|-------|
| STRAP, steady starter motor | 65 | RE.21288 | 1 | X * |
| SWITCH, oil pressure, choke solenoid | | RE.21917 | 1 | LL |
| TAB, locking, rear camshaft bearing cover | | RE.14029 | 2 | N |
| TAP, cylinder drain | | RE.5150 | 1 | O |
| TAP, cylinder drain | 66 | RE.16535 | 1 | P |
| TRUNNION, pin, strap, starter motor | 67 | RE.21289 | 1 | X * |
| UNIT, oil level recording (with washer RE.8404) | 68 | DB.1870 | 1 | |
| UNION, adaptor casing | 69 | RE.6240 | 2 | |
| WASHER, aluminium, .750" core plug, oil gallery | X.83 | KB.1082 | 1 | |
| WASHER, aluminium, .215" dia. sealing petrol pipe bracket holes LC. | X.83 | KB.1075 | 2 | |
| WASHER, aluminium, 1.000" dia. oil drain plug | X.83 | KB.1084 | 1 | |
| WASHER, aluminium, 1.045" adaptor casing unions | X.83 | KB.1186 | 2 | |
| WASHER, aluminium, .830" cylinder drain tap | X.83 | KB.1098 | 1 | O |
| WASHER, aluminium, connection rocker oil feed | | RE.3523 | 2 | |
| WASHER, aluminium, oil pressure gauge connections (2) tappet cover nut (4) | | RE.3274 | 6 | |
| WASHER, C & A, cylinder drain tap | 71 | RE.4787 | 1 | |
| WASHER, locking oil baffle | X.89 | KB.7104 | 4 | |
| WASHER, locking, oil feed pipe (2) & thrust plate (3) | X.89 | KB.7106 | 5 | |
| WASHER, locking, oil pump (1), dynamo bolt (2) | X.89 | KB.7107 | 3 | |
| WASHER, plain, .312" dia. bolt swivel arm (dynamo) to back plate | X.84 | KB.3906/Z | 1 | |
| WASHER, plain, .312" dia. TV fulcrum (LC. auto- matic gearbox) | X.85 | K.4405/Z | 1 | |
| WASHER plain, .312" dia. dynamo bolt | X.86 | K.8807/Z | 4 | |
| WASHER, plain, .312" dia. oil filter (4) and filter to mounting plate (2) | X.85 | K.4410/Z | 6 | |
| WASHER, plain, .375" dia. cylinder head to crankcase | X.85 | K.4413/Z | 39 | |
| WASHER, plain, exhaust manifold studs (12) and breather blanking cover (2) | X.85 | K.4407/Z | 14 | |
| WASHER, spring, 3 BA, sump oil level unit screw | X.87 | K.9005/Z | 6 | |
| WASHER, spring, 2 BA oil relief stud | X.87 | K.9006/Z | 3 | |
| WASHER, spring TV, fulcrum (LC. automatic gearbox) | | K.9006/Z | 1 | |
| WASHER, spring, 2 BA, petrol pipe bracket stud (RC) | | K.9006/Z | 2 | |
| WASHER, spring, .250" dia. distributor clamping, housing studs & retaining screw (4) breather blanking cover studs (2) wheelcase facing studs, screw & bolt (10) oil feed adaptor casing (4), breather clip (1) | X.87 | K.9008/Z | 21 | |
| WASHER, spring, .250" dia. TV fulcrum to crankcase (LC. automatic gearbox) | | K.9008/Z | 1 | |
| WASHER, spring steady bracket support plate | | K.9012/Z | 2 | X * |
| WASHER, spring, support plate | | K.9008/Z | 2 | X * |

SCHEDULE OF SPARE PARTS

REF. NO. PART NO.

QUANTITY
GROUP ASS'LY

NOTES

GROUP B.2. CRANKCASE (Cont'd)

| | | | | |
|---|------|----------|----|---|
| WASHER, spring, .312" dia. dynamo swivel arm bolt (1), dynamo bracket bolt (2), dynamo bracket stud (4), engine mounting stud, front face (3), lower half crankcase retaining screw (20) oil filter stud (4) coolant pump to adaptor stud (4) coolant pump adaptor to crankcase stud (5) wheelcase fitting bolts (3) oil filter mounting plate (2) | X.87 | K.9009/Z | 48 | |
| WASHER, spring, .437" dia. clutch casing retaining screw | X.87 | K.9011/Z | 2 | |
| WASHER, thrust, centre main bearing lower half | 72 | RE.14390 | 2 | |
| WASHER, thrust, centre main bearing, upper half | 73 | RE.14389 | 2 | |
| WASHER, boss, TV controls | X.83 | KB.1076 | 1 | = |

NOTE: '=' to be used when TV controls are not fitted.

* Fitted with Automatic Transmission

GROUP B.3. CRANKSHAFT,

Comprising:-

| | | | | |
|--|------|-----------|----|---|
| CAP, oil retaining, crankpins | 1 | RE.14143 | 12 | |
| CAP, oil retaining, journals | 2 | RE.14142 | 12 | * |
| CAP, oil retaining, journals | 3 | RE.13449 | 1 | * |
| CAP, oil retaining, journals | | RE.14142 | 13 | |
| CRANKSHAFT, standard assembly, consisting of | 4 | RE.11561A | 1 | |
| + Crankshaft | | RE.11561 | 1 | |
| + Dowel, balance weights | | E.56890 | 6 | |
| + Nut, full, .375" dia. balance weights | | K.4010/Z | 12 | |
| + Stud, .375" dia. balance weights | | EW.1465 | 12 | |
| + Washer, lock, .375" dia. balance weights | | BB.1031 | 12 | |
| + Weight, balance | | RE.4056 | 6 | |
| KEY, Woodruff, .125" x .625" | X.18 | KC.505 | 3 | A |
| KEY, Woodruff, .1255" x .625" | | KC.506 | 3 | A |
| KEY, Woodruff, .126" x .625" | | KC.507 | 3 | A |
| KEY, Woodruff, .1265" x .625" | | KC.508 | 3 | A |
| NUT, castellated, 2 BA crankpin studs | X.20 | K.4206/Z | 6 | |
| NUT, castellated, .250" journal studs | X.20 | KB.3581/Z | 7 | |
| PIN, split, .062" dia. crankpin studs | | KA.4602/Z | 6 | |
| PIN, split, .062" dia. journal studs | | K.4602/Z | 7 | |
| STUD, 2 BA, crankpin oil cap Nos. 2, 3, 4 & 5 (with nut K.4307/Z) | | RE.9443 | 4 | |
| STUD, 2 BA, crankpin oil cap Nos. 1 & 6 (with nut K.4307/Z) | 5 | RE.11629 | 2 | |
| STUD, .250" dia. centre journal oil cap (with nut K.4310/Z) | 6 | RE.9444 | 1 | |

SCHEDULE OF SPARE PARTS

REF. NO. PART NO. QUANTITY
GROUP ASS'LY NOTES

| | | | | |
|---|------|----------|----|---|
| STUD, front journal bore assembly, consisting of | 7 | RE.15104 | 1 | |
| + Cap | | RE.14654 | 1 | |
| + Collar | | RE.3953 | 1 | |
| + Stud | | RE.3951 | 1 | |
| STUD, .250" dia. intermediate journal oil caps (with nut K.4310/Z) | 8 | RE.9442 | 4 | |
| STUD, .250" dia. rear journal oil cap (with nut K.4310/Z) | 9 | RE.9441 | 1 | |
| STUD, .250" dia. rear journal oil cap (with nut K.4310/Z) | | RE.13450 | 1 | * |
| WASHER, aluminium, 2 BA crankpin oil cap studs | | RE.6976 | 17 | |
| WASHER, aluminium, .250" dia. journal oil cap studs | X.83 | KB.1076 | 20 | |

NOTE: * Fitted with automatic transmission.

GROUP B.4. CYLINDER HEAD.

Comprising :-

| | | | | |
|---|---|-----------|---|---|
| ADAPTOR, oil filler cap | 1 | RE.11318 | 1 | |
| BOLT, breather housing | 2 | RE.5465 | 1 | |
| BUSH, centre | 3 | RE.7571 | 1 | |
| BUSH, rubber, rocker cover studs | 4 | EB.3998 | 3 | |
| CAP, oil filler assembly (English) | 5 | RE.15934 | 1 | |
| CAP, oil filler assembly (French) | | RE.16819 | 1 | |
| CATCH, oil filler | 6 | E.89147 | 1 | |
| COVER, rocker assembly | 7 | RE.10479A | 1 | |
| Insert | | RE.5464 | 1 | |
| Studs | | KB.352/Z | 2 | |
| COVER, rocker assembly (when O.B. air cleaner is fitted) | | RE.14706A | 1 | |
| HEAD, cylinder, assembly, consisting of:- | | RE.10429 | 1 | R |
| Adaptor, heater feed tap | | RE.9888 | 1 | O |
| Adaptor, heater feed tap | | RE.17083 | 1 | P |
| Adaptor, sparking plug (standard) | | RE.3682 | 6 | A |
| Adaptor, sparking plug (.005" o/s external thread) | | RE.4818 | 6 | A |
| Adaptor, sparking plug (.010" o/s external thread) | | RE.4819 | 6 | A |
| Adaptor, sparking plug (.062" o/s external thread) | | RE.13502 | 6 | A |
| Covers, end rear | | EB.4002 | 1 | |
| Guide inlet valve (standard) | | RE.361 | 6 | |
| Guide, inlet valve (.002" o/s) | | RE.14507 | 6 | |
| Joint, end cover | | RE.3422 | 1 | |
| Plug, core hole, .875" dia. | | RE.9018 | 7 | |

SCHEDULE OF SPARE PARTS

REF. NO. PART NO.

QUANTITY
GROUP ASS'Y

NOTES

GROUP E.4. CYLINDER HEAD (Cont'd)

HEAD, cylinder, assembly consisting of: (Cont'd)

| | | | | |
|--|-------|------------|----|---|
| Plug, core hole, .875" dia. Nos. 4 & 6 cylinders | | RE. 9015 | 2 | |
| Plug, core hole, No. 5 cylinder | | RE. 13406 | 1 | |
| Plug, oil drilling | X. 27 | KB. 1054/Z | 1 | |
| Ring, locking, sparking plug adaptor (standard size) | | RE. 3681 | 6 | A |
| Ring, locking, sparking plug adaptor (.005" o/s) | | RE. 4816 | 6 | A |
| Ring, locking, sparking plug adaptor (.010" o/s) | | RE. 4817 | 6 | A |
| Ring, locking sparking plug adaptor (.062" o/s) | | RE. 13501 | 6 | A |
| Screw, countersunk head, 2 BA rear end cover | X. 50 | K. 2813/Z | 10 | |
| Seal, inlet valve (standard size) | | EB. 4001 | 6 | A |
| Seal, inlet valve (.002" o/s) | | RE. 14503 | 6 | A |
| Seal, inlet valve (.005" o/s) | | RE. 14504 | 6 | A |
| Seal, inlet valve (.010" o/s) | | RE. 14505 | 6 | A |
| Seal, inlet valve (.050" o/s) | | RE. 14506 | 6 | A |
| Stud, 2 BA, ignition wire conduit retaining | X. 62 | KB. 299/Z | 4 | |
| Stud, .250" dia. hotspot connection retaining | X. 68 | KB. 352/Z | 2 | |
| Stud, .250" dia. inlet manifold retaining | X. 68 | KB. 354/Z | 4 | |
| Stud, .250" dia. inlet manifold retaining | | KB. 355/Z | 4 | |
| Stud, .312" dia. thermostat casing, long | X. 73 | KB. 410/Z | 2 | |
| Stud, .312" dia. thermostat casing, short | | KB. 404/Z | 2 | |
| Stud, .312" dia. rocker cover retaining | | EB. 4006 | 3 | |
| Stud, .312" dia., rocker pedestal retaining | | EB. 3997 | 5 | |
| Washer, aluminium, oil drilling plug | X. 83 | KB. 1077 | 1 | |
| HEAD, cylinder, assembly as above except | | RE. 19451A | 1 | S |
| Head, cylinder | | RE. 19451 | 1 | |
| HEAD, cylinder, assembly as above except | 8 | RE. 19451 | 1 | * |
| Adaptor, heater feed | | RE. 18826 | 2 | |
| Plug, core, No. 2. cylinder | | RE. 9033 | 1 | |
| Plug core | | RE. 9018 | 5 | |
| JOINT, hotspot to cylinder | 9 | EB. 3581 | 1 | |
| JOINT, inlet manifold to cylinder head | 10 | EB. 4003 | 4 | |
| JOINT, rocker cover to cylinder head | 11 | RE. 10477 | 1 | |
| JOINT, water outlet connections | 12 | EB. 4004 | 1 | |
| NUT, oil filler cap | 13 | RE. 10853 | 1 | |
| NUT, cap rocker cover retaining | 14 | RE. 9032 | 3 | |
| NUT, half 2 BA, ignition conduit retaining (4) and heater pipe shield (1) | X. 24 | K. 4307/Z | 5 | |

SCHEDULE OF SPARE PARTS

REF. NO. PART NO. QUANTITY GROUP ASS'LY NOTES

GROUP E.4 CYLINDER HEAD (Cont'd)

| | | | | |
|---|------|-----------|----|--|
| NUT, full .250" dia. hotspot connection (2) inlet manifold (8) | X.21 | K.4008/Z | 10 | |
| NUT, half .250" dia. heater pipe clip and shield (2) and oil filter adaptor to rocker cover (2) | X.24 | K.4310/Z | 4 | |
| NUT, half .312" dia thermostat casing (4) and rocker pedestal (5) | X.24 | K.4313/Z | 9 | |
| PIN, hinge, oil filler cap | 15 | E.88941 | 2 | |
| PIN, split, oil filler cap stud | X.31 | K.4648/Z | 1 | |
| PIPE, breather, assembly | 16 | RE.13360 | 1 | |
| PLATE, rocker cover bush | 17 | EB.3999 | 3 | |
| PLATE, pressure oil filler cap | 18 | E.88931 | 1 | |
| PLUG, .250" dia., rocker cover | X.27 | KB.1052/Z | 2 | |
| SPRING, oil filler cap catch | 19 | E.89148 | 1 | |
| SPRING, pressure, oil filler cap | 20 | FB.2484 | 1 | |
| STUD, .250" dia., rocker cover | X.68 | KB.399/Z | 2 | |
| STUD, .250" dia., heater clip and shield | X.68 | KB.399/Z | 2 | |
| STUD, 2 BA, heater shield | 21 | RE.10440 | 1 | |
| TAP, heater | | RE.5150 | 1 | |
| TAP, heater | 22 | RE.16535 | 1 | |
| WASHER, assembly, oil filler cap | 23 | RE.15879 | 1 | |
| WASHER, spigot, oil filler cap | | RE.8305 | 2 | |
| WASHER, aluminium, breather bolt | 24 | KB.1092 | 1 | |
| WASHER, aluminium, rocker cover plug | | KB.1076/W | 2 | |
| WASHER, C & A, heater tap | | RE.4787 | 1 | |
| WASHER, joint, oil filler cap adaptor | 25 | RE.11319 | 1 | |
| WASHER, lock adaptor to rocker cover | | KB.7106 | 2 | |
| WASHER, plain, oil filler cap stud | X.85 | K.4401/Z | 1 | |
| WASHER, plain, 2 BA, heater pipe shield (1) and ignition conduit stud (4) | X.85 | K.4404/Z | 5 | |
| WASHER, plain, .250" dia. heater pipe clip and shield | X.85 | K.4407/Z | 2 | |
| WASHER, plain, .250" dia. Nos. 4 & 6 core plugs (when OB air cleaner is fitted) | | KB.3905/Z | 2 | |
| WASHER, plain, .312" dia., rocker pedestal stud | 26 | E.50051 | 5 | |
| WASHER, spring, 2 BA heater pipe shield (1) and ignition conduit stud (4) | X.87 | K.9006/Z | 5 | |
| WASHER, spring, .250" dia. heater pipe clip and shield (2) hotspot connection (2) inlet manifold (8) rocker cover (2) outlet connection (4) | | K.9008/Z | 18 | |
| WASHER, .875" dia. adaptor heater feed pipe | | KB.1092 | 2 | |

NOTE: * When 'B' type demister system is fitted.

E13/11/54.

O
P

SCHEDULE OF SPARE PARTS

REF. NO. PART NO.

QUANTITY
GROUP ASSEMBLY

NOTES

GROUP E.5. FLYWHEEL (Synchromesh) Comprising:

| | | | | |
|--|------|----------|----|--|
| BEARING, ball, 1st motion | 1 | RE.12055 | 1 | |
| BOLT, .312" dia. clutch cover to friction plate | | RE.19480 | 6 | |
| BOLT, .312" dia., flywheel and flexible disc to friction plate | | RE.19479 | 3 | |
| BOLT, .375" dia., flexible disc & housing to crankshaft | 2 | RE.18405 | 12 | |
| DISC, flexible, driving | 3 | GB.5292 | 1 | |
| FLYWHEEL, (RC) | 4 | RE.10694 | 1 | |
| FLYWHEEL, (LC) | | RE.9984 | 1 | |
| HOUSING, ball bearing | 5 | GB.4420 | 1 | |
| NUT, full, .312" dia., clutch cover to friction plate (6) and flywheel and flexible disc to friction plate (3) | X.24 | K.4009/Z | 9 | |
| NUT, full, .375" dia., flexible disc and housing to crankshaft | X.21 | K.4010/Z | 12 | |
| PLATE, clutch, friction | 6 | GB.5291 | 1 | |
| WASHER, Grover, .312" dia., clutch cover to friction plate | X.81 | K.4509/Z | 6 | |

GROUP E.6. OIL PUMP & RELIEF VALVE.

Comprising:

| | | | | |
|---|------|----------|---|----|
| BUSH, Driven gear | | RE.20967 | 1 | XX |
| CAP, valve, H.P. assembly, consisting of: | 1 | RE.11036 | 1 | |
| Cap | | RE.11037 | 1 | |
| Pin, guide | | RE.11044 | 1 | |
| Spring | | EB.5029 | 1 | |
| CAP, valve, L.P. assembly, consisting of: | 2 | RE.11038 | 1 | |
| Cap | | RE.11039 | 1 | |
| Pin, guide | | RE.11045 | 1 | |
| Spring | | EW.1542 | 1 | |
| CASING, relief valve, assembly, consisting of: | 3 | RE.14647 | 1 | |
| + Casing | | RE.11033 | 1 | |
| Plug, core hole | | E.84973 | 3 | |
| Seating, L.P. valve | | RE.11035 | 1 | |
| Seating, H.P. valve | | RE.11034 | 1 | |
| CASING, oil pump assembly, consisting of: | | RE.9863 | 1 | |
| Bush, driven shaft | | EB.3905 | 2 | |
| + Casing | | RE.3927 | 1 | |
| Cover | | EB.3896 | 1 | |
| Pin, taper, .156" x 1.000" long, drive chamber gear spindle | X.33 | K.4710 | 1 | |
| Spindle, drive chamber gear | | EB.3906 | 1 | |