

Workshop Series



THE MORRIS MINI RANGE
SEALING AND SOUND DEADENING
INSTRUCTION

Tony Cripps

Preface

In modern times, it is rare indeed to find a Morris Mini which is in original condition, with nearly all having being restored at some time in their lives. For the restorer and modern-day owner, this circumstance had led to some confusion about just how the factory applied sealers and sound deadening to the body shell – these materials and parts having often been removed or deteriorated. Detailed information about these items is not usually found in workshop manuals and service parts lists. In this book, the factory Sealing and Sound Deadening Instructions are presented along with specifications of the compounds used, and also drawings of those associated parts like sealing strips, windscreen sealing rubbers and the like.

Note

The Morris Mini range is broadly divided into ADO15/ADO50, the original Morris 850 and Cooper largely of UK specification, and YDO4/YDO5/YDO6 – the Australian models for Morris Mini Minor, Morris Mini Deluxe, and Morris Cooper S. Details of the sealing arrangements differ in these two groups on account of the use of wind-up windows and local specifications in compared to the sliding windows and general UK specifications of the early models. Details for both groups are included in this book.

Acknowledgements

A very special thanks to three company stalwarts Peter Davis (dec), Bruce Elson and Ron Moss (dec) who have unfailingly provided first-hand knowledge of the vehicle and the factory for our benefit.

Disclaimer and Warning

The intention of this book is to allow identification of the correct part which was fitted at the time of manufacture to a vehicle of Australian specification.

The drawings shown in this book should not be used to manufacture a part. Do not use the information in this book in such a way that might affect the safety, reliability or value of a motor vehicle or part thereof.

The author and publisher make no representation as to the accuracy of the information presented and accepts no responsibility for any damage, loss, injury or any other event arising from the use of the information in this book.

References

The Part Numbers used in this book are predominantly those found in service parts lists for the vehicles concerned. A part is usually drawn on a drawing which has the same number as the Part Number but may also be found on a drawing with a different number, especially when that drawing contains drawings for several parts.

Part 1. Sealing and Sound Deadening Instruction

1.1 Introduction

The Sealing and Sound Deadening Instructions presented here apply to those sealers and sound deadening materials applied to the body after final painting. There are other sealers applied to the body before body assembly, and also after priming and phosphate. Those instructions are not presented in this book.

1.2 Morris 850 Saloon, Morris Mini-Van and Morris Cooper

FOR VIEW IN DIRECTION OF ARROW:-

- A REFER SHEET 5
- B REFER SHEET 6
- C REFER SHEET 8
- D REFER SHEET 12
- F & G REFER SHEET 14

FOR SECTION:-

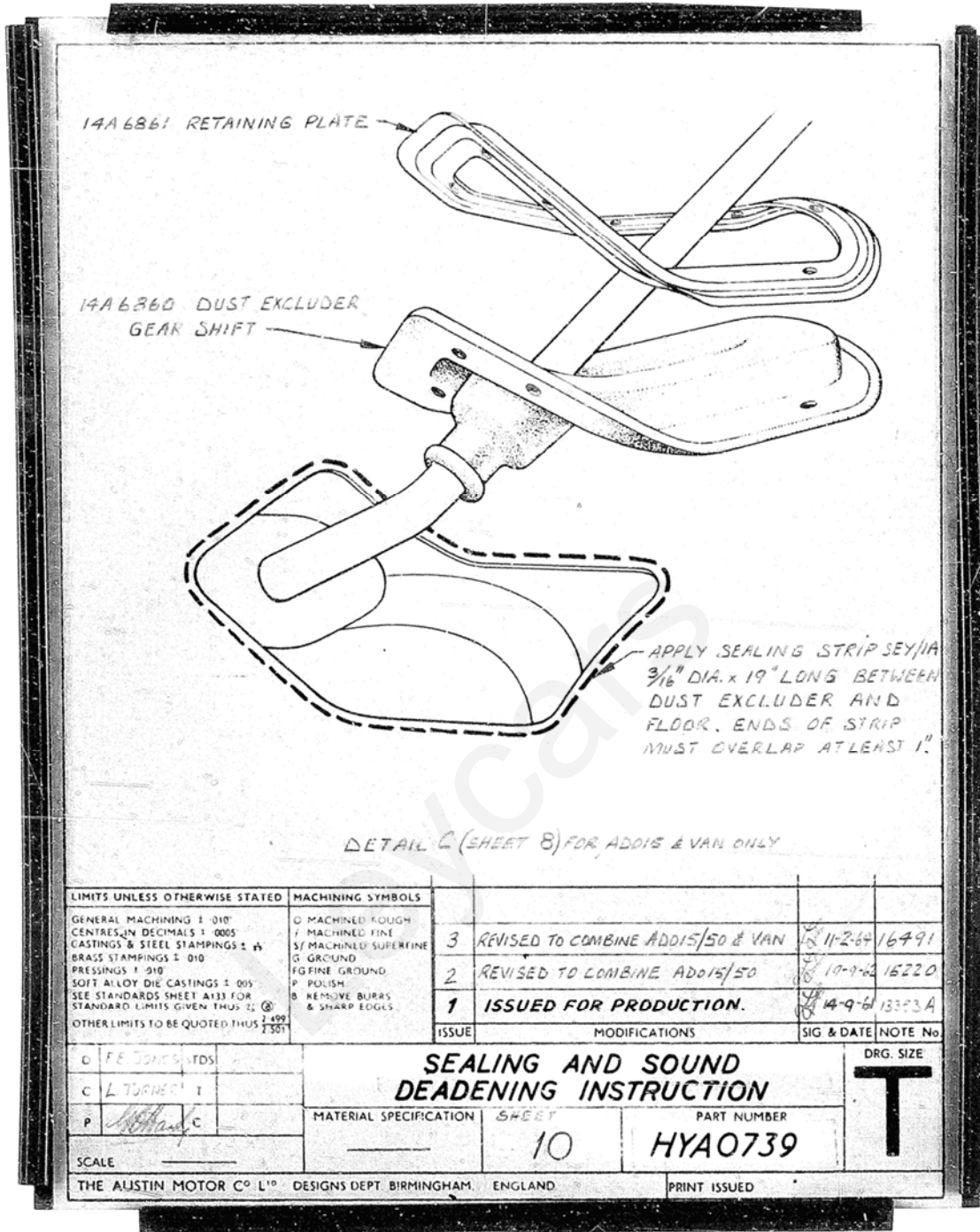
- A-A & C-C REFER SHEET 17
- B-B & D-D REFER SHEET 18
- E-E & F-F REFER SHEET 18

SEALING AFTER FINAL PAINT

				16491	4	REVISED TO COMBINE ADDB/508 VAN			14-2-64
				15220	3	REVISED TO CENTRE LINE ADDB/508 VAN			17-9-62
				14136	2 ²	DETAIL LOCATION & NOTE DELETED			5-3-62
				14080	1 ²	DETAIL LOCATION & NOTE ADDED			29-12-61
				13353A	-	RELEASE			14-9-61

AUTHY. ISSUE	REVISIONS	CHD.	DATE	AUTHY. ISSUE	REVISIONS	CHD.	DATE
DRN	14-9-61						
NAME	SEALING AND SOUND DEADENING INSTRUCTION						
CHD.							
APPD.							
FINISH							
MATERIAL		SHEET		PART NO.		T	
		1 OF 41		HYA0739			

BRITISH MOTOR CORPORATION (AUST) PTY. LTD. PRODUCT ENGINEERING DEPARTMENT



DETAIL C (SHEET B) FOR ADDIS & VAN ONLY

LIMITS UNLESS OTHERWISE STATED		MACHINING SYMBOLS				
GENERAL MACHINING ± .010"		O MACHINED ROUGH		3	REVISED TO COMBINE ADDIS/50 & VAN	11-2-64 16491
CENTRES IN DECIMALS ± .0005		F MACHINED FINE		2	REVISED TO COMBINE ADDIS/50	10-9-62 16220
CASTINGS & STEEL STAMPINGS ± .005		S/ MACHINED SUPERFINE		1	ISSUED FOR PRODUCTION.	14-9-61 13323A
BRASS STAMPINGS ± .010		G GROUND				
PRESSINGS ± .010		FG FINE GROUND				
SOFT ALLOY DIE CASTINGS ± .005		P POLISH				
SEE STANDARDS SHEET A133 FOR STANDARD LIMITS GIVEN THEREIN		B REMOVE BURRS & SHARP EDGES				
OTHER LIMITS TO BE QUOTED THUS: $\pm .001$				ISSUE	MODIFICATIONS	SIG & DATE NOTE No.
D FE JONES STDS		SEALING AND SOUND DEADENING INSTRUCTION			DRG. SIZE	
C L TURNER I		MATERIAL SPECIFICATION			PART NUMBER	
P <i>McHardy</i> C		SHEET			HYA0739	
SCALE		10			T	
THE AJUSTIN MOTOR CO L ^{TD} DESIGNS DEPT. BIRMINGHAM, ENGLAND				PRINT ISSUED		

APPLY SEALER SEY/2 BETWEEN RUBBER AND GLASS AND ALSO BETWEEN RUBBER AND METAL FLANGE AROUND ENTIRE PERIMETER BACKLIGHT WEATHERSTRIP AND WINDSHIELD WEATHERSTRIP.

SECTION A-A (SHEET 1)
FOR ADO15 & ADO50 ONLY

ADHERE JOINTS OF WEATHER-STRIPS ON CENTRE LINE AT TOP OF BACK-LIGHT AND WINDSHIELD WITH ADHESIVE ADY/2A. ALLOW ENOUGH RUBBER COMPRESSION TO PREVENT SHRINKING AND LEAKING.

SECTION C-C (SHEET 1)
ALL VERSIONS

JOINTS OF FILLER STRIPS TO BE ON CENTRE LINE AT BOTTOM OF BACK-LIGHT AND WINDSHIELD WEATHER-STRIPS.

				16491	2	REVISED TO COMBINE ADO15/50 & VAN	11-2-64		
				15220	1	REVISED TO COMBINE ADO15/50	19-7-62		
				13353A	-	RELEASE	14-9-61		
AUTHY.	ISSUE	REVISIONS	CHD.	DATE	AUTHY.	ISSUE	REVISIONS	CHD.	DATE
DRN	<i>Les Turner</i>		NAME		SEALING AND SOUND DEADENING INSTRUCTION			T	
CHD.	L. TURNER		SHEET						
APPD.	<i>Longmore</i>		PART NO						
FINISH			17						
BRITISH MOTOR CORPORATION (AUST) PTY. LTD.					PRODUCT ENGINEERING DEPARTMENT				

Part 2. Materials Specifications

THE BRITISH MOTOR CORPORATION (AUST.) PTY LTD. STANDARDS			
<u>ADHESIVES</u>			
		ADY 2	
ORIGIN B. M. C. AUSTRALIA -			
<u>SYNTHETIC RUBBER ADHESIVES</u>			
<u>General Requirements:</u>			
This specification covers the requirements of synthetic rubber adhesives based on Neoprene for use as a general trim adhesive (see applications).			
The test methods must be read in conjunction with this specification.			
<u>Physical Requirements:</u>			
Specification No.		Brushing ADY. 2A	Spraying ADY. 2B
Colour		Not darker than sample	the approved
Viscosity No. 4 spindle @ 10 R.P.M. (Brookfield Model R. V. T.)		3750-4500 cps.	600 - 850 cps.
Solids		28% \pm 1%	25% \pm 1%
Heat resistance		Not less than 120°C.	Not less than 120°C.
Staining		None	None
Bond strength air-dried		8 lbs min.	8 lbs min.
Stripping strength lbs/in.	After over ageing	4.0 lbs/in min.	4.0 lbs/in min.
	After humidity	5.5 lbs/in min.	5.5 lbs/in min.
	After water immersion	6.5 lbs/in min.	6.5 lbs/in min.

Application:
See page A.10

16920
19344

22.1.65

THE BRITISH MOTOR CORPORATION (AUST.) PTY LTD. ZETLAND SYDNEY.	ISSUE DATE. 17 Dec 65	PAGE NO. A 9
---	----------------------------------	--------------

