


AUSTIN MG
DIVISION

DATE: 3/17/69

BRITISH LEYLAND MOTORS INC.
600 Willow Tree Road • Leonia • New Jersey 07605

SUBJECT:

 Fitting New Down Pipe
To Existing Muffler

MODELS:

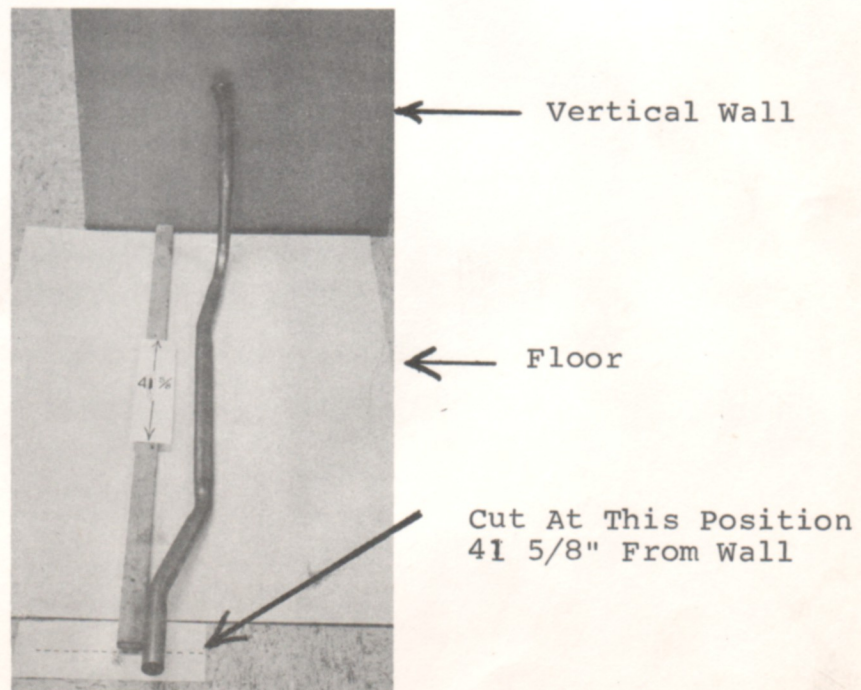
Austin America

DEALERS WHO HAVE ALREADY RECEIVED BULLETIN 2 F 29 PLEASE DESTROY IT AND REPLACE WITH THIS ONE.

Due to the possibility of incorrect alignment, with repeated system and mount failure, when welding a new down pipe into an existing muffler, the following method must be used.

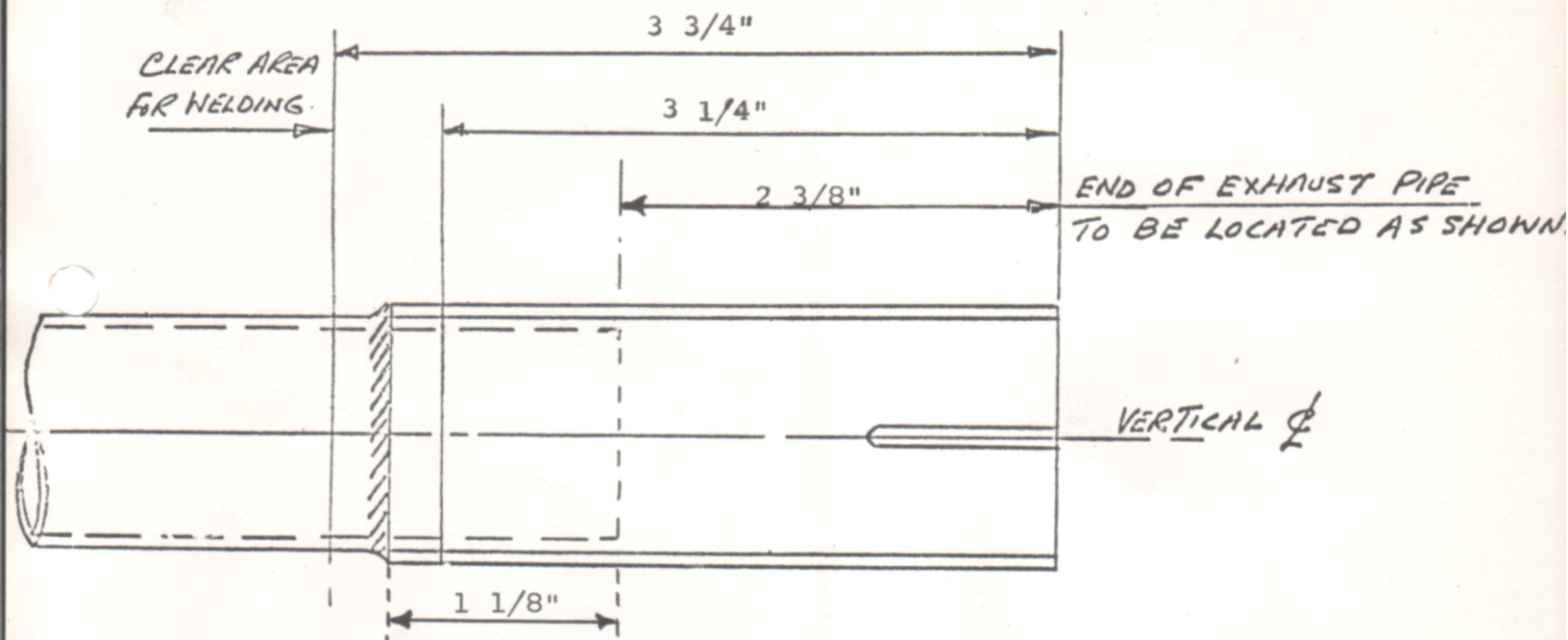
Using front pipe: ARA 2561 Automatic
 ARA 2399 Stick Shift

1. Lay on a flat floor with the pipe flange against a vertical wall. Measure from the wall along the pipe exactly $41 \frac{5}{8}$ ". Mark pipe and cut off remaining length (a length of wood cut to the above measurement will help). (Fig. A)



(Fig. A)

2. Thoroughly clean off aluminum coating from front pipe as indicated, weld sleeve part #HAC 658 to front pipe, end of sleeve $2 \frac{3}{8}$ " from end of pipe, two slots to rear in vertical plane. (i.e. slots top and bottom when pipe located on vehicle) (Fig. B)



(Fig. B)

3. Cut off old front pipe $2 \frac{1}{2}$ " forward of the muffler.
4. Assemble new front pipe with sleeve using clamp LH 2166 onto muffler. Leave approximately $\frac{1}{8}$ " of muffler pipe exposed. Do not tighten clamp at this stage.
5. Install system onto vehicle with new mounts (detailed on Bulletin 2 F 28) if necessary.
6. Tighten manifold to down pipe flange, then mountings, and finally clamp LH 2166 using a high tensile bolt so that muffler does not move and system is free from leaks.

Warranty claims may be submitted for parts and labour using labour operation #P001 1.20 hrs. (set up time already included).