

Despatched

20-2-64

140



Chassis No. L.SFU.223

HISTORY BOOK



TO: Steve Partman

Date: 10/1/04

FROM: Lorraine Hofheinz
Vantage Motorworks

No. of Pages: 1

* * * * *

Dear Steve:

History from our files:

Irwin Fransis - owner from approximately 1977 - 1994
(So. Orange NJ)

1994 sold by Vantage Motorworks to Atilla Eagleman - Boynton Beach, FL

Returned to Vantage 12/2003

Then sold to the famous Steve Partman of Chicago!

VANTAGE Motorworks Inc. 1898 N.E. 151 St. No. Miami, Florida 33162
305-940-1161 Fax 305-949-7481



ROLLS-ROYCE ENTHUSIASTS' CLUB
for Rolls-Royce & Bentley Owners
The Hunt House Paulerspury Towcester Northants NN12 7NA

2 PAGE'S

1

Chassis No. <u>LSFU 223</u>	
Chassis Type <u>Silver Cloud III.</u>	Series <u>F.</u> Order Ref. <u>ex 4429</u>
Territory <u>O'Donnell-Mackie Ltd.</u>	Country <u>Canada</u>
Retailer <u>Rolls-Royce of Canada Ltd.</u>	
Sub-retailer or Trader <u>O'Donnell-Mackie Ltd.</u>	
Owner <u>Mr. R. C. P. Webster</u>	
<u>Maitland, Ontario</u>	
Body Style <u>Silver Cloud III Saloon.</u>	Coachbuilder <u>Rolls-Royce Ltd.</u>
Colour(s) <u>Black Pearl, Valspar. 173/10034</u>	Body No. <u>7678</u>
	Upholstery <u>Beige. vm 3224</u>
Chassis <u>To</u>	Springs <u>LH UR. 3022.</u>
Delivery Date <u>Car</u>	<u>To Salford for shipment.</u> RH UR. 3021.
Delivery Date <u>20.2.64</u>	Date of Issue of Guarantee <u>15.7.64.</u>
Engine No. <u>SU. III. F.</u>	Lock No. <u>510.</u>
Battery <u>phonged.</u>	Radio No. <u>H. 119081.</u> Manual No. <u>SC. III.</u>
	<u>Model 922T.</u>

LSFU 223

~~Mr. R C P Webster
Maitland,
Ontario.
Guar. 15 7 64.~~

John W Blair
185 South Orange Avenue
South Orange
New Jersey 07079
USA

per Zage - 9 8 73

INSPECTION & TEST PROTOCOL SHEET

Boat No. LSEU. 223

Generator No. T. 2159/2

MOE 88

Built to the USA Specification issue 4 - plus:

Radio 922T.

R.R. Electric windows

Roof aerial.

Plain Sunblym glass throughout.

Insignia on boat door NOT required.

Firestone white sided tubeless tyres UG 9122.

to be delivered to No. 9 Dock South, Aubrey St. Gate, Salford. ²⁰/₆₄

to be shipped per the "MANCHESTER MARINER" 22.244 to St. John NB.

Special Features

INSPECTION & TEST PROGRESS RECORD

	Date	Signature
✓ 1. CHASSIS ASSEMBLY	2/1/64	H Walker
2. BODY MOUNTING	6/1/64	H Walker
3. BODY ASSEMBLY	8-1-64	W. H. ...
4. BODY FINAL	8-1-64	D Daniels
5. ELECTRICAL CHECK	8-1-64	W. H. ...
6. MECHANICAL TEST	15-1-64	B. Dickenson
7. ELECTRICAL TEST ^{readings ok}	20/1/64	H. Eborner
8. REFRIGERATION		
9. BODY TEST	17-1-64	J. G. ...
10. FINAL TEST	17-1-64	J. G. ... 140 m/s
11. FINAL BODY INSPECTION		R. W. ...
12. FINAL INSPECTION	23-1-64	R. W. ...

* Note: These sections are not applicable to Coachbuilders Chassis

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

ORDER REF.

SERIAL No.

CA. 7729

CHASSIS SPECIFICATION

Chassis Type SILVER CLOUD 111 Engine No. SU.111.P Rota No. _____
 W/O 3010 Series PL. 10053/P Chassis No. 1. SPU. 223 Body No. 7678
 Battery charged Body Style Silver Cloud 111 C/Builder Rolls-Royce,
Saloon
 L.H. Rear Spring UR. 3022 R.H. Rear Spring UR. 3021
 Steering Position Left Hand,
 Lock No. PH/L. 510 Radio No. Model. 922.1. H. 119051

PAINTING DETAILS & LINES.

Single Gold line.

BLACK PEARL Valspar. 173/10034.

TRIMMING DETAILS.

Beige Hide. Vi. 3234 with Beige piping. Vi. 3234

Fawn Headcloth. 10236 AS. Cumberland Stone Carpet. 732

SPECIAL FEATURE

NOR USE IN CANADA.

To be built to the U.S.A. Specification issue 4 - plus.

R.R. Electric Windows.

Roof Aerial.

Firestone White sided tubeless tyres U.4122

Plain Sundym glass throughout.

Insignia on boot door not required.

CUSTOMER Rolls-Royce of Canada Ltd.

SF.

4.12.63.

ENGINE BUILD CARD

Operations to be signed for by Fitter and Inspector

CRANKCASE UNIT	Fitter	Inspector	ENGINE BUILD (continued)	Fitter	Inspector
Check crankcase clean and oilways clear		gpb	Set timing marks. Fit timing gear (10 lb. ft.)	gpb	
Check all stud holes free from swarf			Check timing gear backlash (.001/0035)	gpb	
Fit core plugs to c'case (Wellsal)	WHT		Check dist. drive backlash (.002/.004)	JH	
Fit helicoils to c'case. Last coil to be below counterbore $\frac{1}{4}$ of a pitch	WHT		Check oil pump backlash (.0012/.006)	JH	
Fit inner cylinder head studs (to gauge 3.775-.025)	HJ		Check piston rings correct and not fractured Check circlips fitted correctly	JH	(11)
Fit centre cylinder head studs (to gauge 2.725-.025)	HJ		Fit piston assy. with bolt shields. Check co-relation nos. Tighten conn-rod bolts (32.5 lb. ft.)	gpb	
Fit outer cylinder head studs (to gauge 1.925-.025)	HJ				
			Check sealing rubbers for coolant pump and lower casing fitted correctly	gpb	
Selectively fit cylinder liners (.002/.003 nip)	gpb		Oil test c'shaft, camshaft and tappet blocks	gpb	
Fit cylinder liner rubbers	gpb		Oil test internal oil pipes Check locking of filter and pipes	gpb	
Fit cylinder head dowels - 4 off (to gauge .200-.015)	gpb				
Fit tappet block dowels - 12 off (to gauge .125-.015)	gpb		Blue and check flywheel and crankshaft faces. Check run out on torus hub (.007 max.)	JH	
			Balance crankshaft assy. in crankcase	gpb	
ENGINE BUILD	Fitter	Inspector	Fit cylinder heads. Tighten cylinder head nuts (40 lb. ft.)	gpb	
Fit camshaft and thrust plate. Check float (.002/.006) Check locking of thrust plate	gpb				
Check flywheel housing bore to main line bore when requested (.005 max.)	gpb		Fit rocker arms, push rods and tappets (graded). Oil test. Tappets to fall under own weight	gpb	
Fit and check locking of tappet blocks	gpb		Check ignition timing	gpb	
Fit crankshaft and thrust washers. Check float (.002/.006) Tighten main bearing nuts (45 lb. ft.)	gpb		Fit dynamo, starter, carbs and controls	gpb	
Tighten oil pump gear retaining nut	gpb		Fit torus cover. Check clearance. Tighten and lock gearbox nut (50 lb. ft.)	gpb	
Check float of distributor gear with distributor fitted (.010/.125)			Fit gearbox to engine	gpb	
			Plug Torus. Band Check		

Chassis No. LSFU 223

ENGINE BUILD CARD

MODIFICATIONS additional to Engine Specification							
REL6245		5237 ANL					
REL6245							
Engine Sequence Number S2214				Specification L.H. Bentley			
Cylinder Liner Bore Grade				Crankcase Number KB145 UE 30198			
A1 A2 A3 A4		B1 B2 B3 B4		Cyl. Head Nos. 'A' bank H32 'B' bank H5			
J K K K		J K K J		Camshaft Number C187 C181			
				Oil Pump Number 4276 4276			
Crankshaft Journals : Standard / - .005				Carburettors 'A' AS UE 9815 'B' AS UE 5748			
" Pins : Standard / - .005				Dynamo Serial Number C18			
" Guide Bores Exhaust : Standard / + .005				Starter Motor Serial Number ✓			
" " " Inlet : Standard / + .005				Distributor Serial Number 11.63			
Crankshaft Serial No. XW6780				Gearbox Serial Number T2159/3			
SALVAGE SCHEMES INCORPORATED							
S164. A+B Cylinders Heads				Lucca bail Spark Plugs N164 P.A.S Pump			
SNAGS							Corrected by
SHORTAGES							Fitted by
P.A.S Pump							
Date to Test 30.12/63 Bentley				INSPECTOR TO TEST SIGN HERE			
SNAGS AFTER TEST							Corrected by
SHORTAGES AFTER TEST							Fitted by
Dynamo - P.A.S Pump							
oil correct							
Date to Chassis 1.1.64		INSPECTOR TO CHASSIS OR DESPATCH		Sign here after making out and attaching engine label complete with all outstanding snags and shortages.			
							Bentley

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

BODY MOUNTING STATION

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

BODY ASSEMBLY

Front Wings fitted and adjusted		Rear Light Glass	
Front Doors fitted and adjusted		Front Door Glasses	RH Lin LH 70
Rear Doors fitted and adjusted		Rear Door Glasses	RH Lin LH 50
Door Conduits - Electrical Windows		Door Waist Rail Finishers	
Door Check Straps			
Door Locks and Striker Plates			
Boot Locks			
Bonnet	W.B.		
Door Frames	L.H.F.R.A. W		
Window Winders (Hand/Electric)			

Date of manufacture of Hicle: 12-11-63

Quality: 32

BODY ASSEMBLY

MODIFICATIONS	Body Sequence No.
	3 Y 1842
REC 6121/6154/6175/6225/5961 SNAGS OS Bonnet Fowl Wing	Panel Beat lower
OS Bonnet Fowl Rad	OSF Rectify Fit of Wing to Sill
NS	OSF Trim Wing at T.F. Bolt
NS Bonnet Rectify Clearance	OSFD Fowl Tread Plate
Book lid High of NSTops Rectify	OSFD Improve line on Wing
Rectify Top of Balance	NSFD Increase Clearance on Sill
SHORTAGES	NSFD Window Vent loose Rectify
	Brake Fluid NSRD Dinchor Frame loose fit on D Post Rectify
	NSFD Window Glass Shift Rectify

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 *Walker*

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. 3 *Daniel*

ORDER REF.

52214

SERIAL No.

CX. 7729

CHASSIS SPECIFICATION

Chassis Type SILVER CLOUD 11 Engine No. SU. 111.7 Rota No. Chassis No. L. SFU. 223
1/ESJ. 13-12-63.

W/O 3010 Series PL. 10053/F Body No. 7678

Battery charged Body Style Silver Cloud 111 C/Builder Rolls-Royce.
Saloon

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

Steering Position Left Hand.

Lock No. EM/L. 510V Radio No. Model. 922.T. H 119051V
1/ESJ 13-12-63 6/ESJ 3-1-64

PAINTING DETAILS & LINES. Single Gold line.

BLACK PEARL. Val spar. 173/10034.

TRIMMING DETAILS.

Beige Hide. VM. 3234 with Beige piping. VM. 3234
Fawn Headcloth. 10236 AS. Cumberland Stone Carpet. 732

SPECIAL FEATURE

FOR USE IN CANADA.

- To be built to the U.S.A. Specification issue 4 - plus. ✓
- R.R. Electric Windows. ✓
- Roof Aerial. ✓
- Firestone White sided tubeless tyres UG. 4122 ✓
- Plain Sundym glass throughout. ✓
- Insignia on boot door not required. ✓

OK 3-2-64

CUSTOMER Rolls-Royce of Canada Ltd.

SF. 4.12.63.

SFU223

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

Fit Battery Cable		j.m.e	Identify Engine	
Brackets & Tinning		b.s.	Fit & Set Brake Servo	Red
Fit Rear Springs		b.s.w.	Prop. Shaft—Front 75 lb. ft. Torque	B
2 Bars		JP	—Rear 45-50 lb. ft. Torque	
Axle U Bolts 60-65 lb. ft. Torque		JP	Set Ram for Alignment	B
Rear Assembly		b.s.	Check Ram Clearance	
Stabiliser		wr	Fit Petrol Tank	OK
Torque tighten Yoke Pin Nuts 250 lb. ft. Torque		P		
			Fit Gear Control Linkages	B
Fit Front Shock Dampers		D.R.K.		
Toe In LH .031 RH 092		my SA	Fit Brake Hoses	
Caster LH .054 RH 051		my SA	Bleed Brakes	+
Camber LH .041 RH 048		my SA	Set Brakes	+
Ball Pin Height LH 9 RH 7		JP	Fit Exhaust System & Earth Straps	RP
Front Susp. Friction LH 35 lbs RH 30 lbs		my SA		
			Fit Wiring Looms	
Front Sub-assembly				
Front Springs & Washers		my	Blow out Exhaust System	RP
Front Stabilizer Bar		JP		
Freedom of Centre Steering Lever			Fit Radiator & check all studs	RAO
Rear Shock Dampers		JP		
Locking & Sealing of Front Hubs		JP		
Fit Steering Column & Box		@		
Fit Petrol Pump & Pipes A/3861			COACHBUILT	
Fit Master Cylinders		my	Fit & Set Handbrake	
Grease all points		JP	Fit Wiring	
Fit Brake Equaliser		JP		

FINISHING LINE

SHORTAGES	Fitted by
FIT AND SECURE BONNETS	<i>[Signature]</i>
CHECK ALL SEAL RUBBERS	<i>[Signature]</i>
BUILD UP BOOT LID ETC	<i>[Signature]</i>
FIT GROMMET TO BOOT RAIL	<i>[Signature]</i>
FIT R/LIGHT PULPS	<i>[Signature]</i>
FIT K/RUBBERS	<i>[Signature]</i>
White Tape w/PA Door Glass	<i>[Signature]</i>
Front Bumper Scratch	
Rear Bumper Scratch	
Stack Seals	
27-1-64	
Tire Pressure wheels & Rad checked	AO
Tire set	
(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.	<i>[Signature]</i>
FINAL PRODUCTION OPERATIONS Car thoroughly clean internally and externally, and in a finished state ready for final inspection.	REMARKS <div data-bbox="1294 1603 1560 1727" style="border: 1px solid black; padding: 2px;"> Production Foreman or Chargehand. <i>[Signature]</i> </div>
FINAL INSPECTION Car complete to specification, up to standard in all respects, and ready to be passed into Bond.	REMARKS <i>[Signature]</i> / bushes
INSPECTOR - Sign here and inside Front Cover.	<i>[Signature]</i>

BODY ASSEMBLY

MODIFICATIONS					
<p>SNAGS</p> <p>OP/F adjust slam plate ✓ OP/R adjust slam plate ✓ " Edge S/Door in T/Pad ✓ " C/Washers proud ✓ " C/Washers proud ✓ " Secure Seal on B/C Post ✓ " Gap top of Volume & Wing ✓ " End of Door sill Rubber fouling ✓ " Secure Seal on B/C Post ✓ " Gap on Reqs Pull ✓ " Blind S/Channel on A/Post ✓ " Top of T/Pad ✓</p>					Corrected by
<p>SHORTAGES</p> <p>Rect distorted S/Channel over Vents Remove surplus Bostik ✓ " Gaps on Boot sill strip ✓ Connect Boot Light ✓ " End of Wing proud on A/Post ✓ Fit Rubber on B/ Glass Panel ✓ " Fl Seal Spring fouling ✓ Form clip fouling B/H Panel ✓ " Vents fouling A/ Cloth ✓</p>					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.				 Corrected by
<p>SNAGS</p> <p>NP/F Bolt up Wing stay ✓ NP/R adjust slam plate ✓ " Gap top of Volume & Wing ✓ " Rect distorted S/Channel ✓ " adjust slam plate ✓ " Improve seal w/ frame of the ✓ " Edge S/Door in T/Pad ✓ " Clearance w/ frame of R/S ✓ " Rect end of P/Pad ✓ " Rect Chipped edge of Glass ✓ " Screw proud in T/Frame ✓ " End of D/Sill Rubber fouling ✓</p>					Corrected by
<p>SHORTAGES</p> <p>Fit thinner S/Plate F/ Doors ✓ " screw up R/Right switch ✓ " " " OP/R Door ✓ " Rect channel D/ Finishes & D/ Post ✓ Rect fit of Roof Lamp ✓ " Rect dist end of D/ Finishes 16 SH ✓</p>					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.				 Corrected by

FINISHING LINE

<p>MARKING UP FOR FINAL SPRAY</p> <p>All body panel work up to standard. Paintwork marked up and ready to spray.</p> <p><i>PL 201 164</i></p>	<p>REMARKS</p> <p><i>P.L. BONNET. F/WINGS F/DOORS BOOT LID. F/WING B/OPENING</i></p> <p><i>Bad Damage BONNET. F/DOORS B/LID. Top</i></p> <p>Inspector</p>
<p>INSPECTION AFTER PAINT RECTIFICATION</p> <p>Paint satisfactory and car ready for final polish.</p>	<p>REMARKS</p> <p>Inspector</p>
<p>FINAL POLISH</p> <p>All paintwork polishing up to standard.</p>	<p>REMARKS</p> <p>Inspector</p>
<p>FINAL BODY INSPECTION</p>	
<p>SNAGS</p>	<p>Corrected by</p>
<p><i>POLISH N/S/R FRAME</i></p>	<p><i>Les</i></p>
<p><i>STRIP FOR P/BENT. FRONT DOORS, BONNET.</i></p>	<p><i>ER</i></p>
<p>ELECTRICAL CHECK</p>	<p></p>
<p>ALUMINIUM PAINT</p>	<p></p>
<p>REGISTRATION</p>	<p></p>
<p>BODY CHECK</p>	<p></p>
<p>WAXING</p>	<p></p>
<p>INSPECTION</p>	<p></p>
<p></p>	<p></p>
<p></p>	<p></p>

ROAD TEST

MODIFICATIONS				
PRELIMINARY CHECK Car checked over, oiled etc., and in satisfactory condition for First Road Test.	<i>Routined Engine gear box PSP</i> <i>glycol checked.</i>	Sign. <i>WJ AN</i> Date <i>9. 1 64</i> As per Schedule No. <i>1</i>		
FIRST ROAD TEST Car given First Road Test, and all matters requiring attention entered on Test Card.		Sign. <i>K. Bradha</i> Date <i>9-1-64</i>		
SHOP WORK AFTER FIRST ROAD TEST All matters requiring attention as per Test Card attended to.	Routine adjustments carried out in accordance with Schedule No.	Sign. <i>K. Bradha</i> Date <i>10-1-64</i> <i>3</i>		
SECOND ROAD TEST Car given Second Road Test. All matters requiring attention after First Road Test checked and satisfactory.		Sign. <i>K. Bradha</i> Date <i>10-1-64</i>		
SHOP WORK AFTER SECOND ROAD TEST All matters requiring attention as per Test Card attended to.		Sign. <i>K. Bradha</i> Date <i>14-1-64</i>		
FINAL ROAD TEST Car road tested, and up to standard in all respects mechanically. All matters entered on Test Card satisfactory.		Sign. <i>S. Dickerson</i> Date <i>15-1-64</i>		
FLUID LEVELS All fluid levels checked, and topped up if necessary.	in accordance with Schedule No.	Sign. <i>J. Hales</i> Date <i>15-1-64</i> <i>1A.</i>		
ELECTRICAL CHECK All electrical fittings & wiring up to standard. All electrical items mentioned on Test Card attended to.	<i>Structural checks after panel test.</i> <i>head lamps set</i>	Sign. <i>L. E. Jones</i> Date <i>20/1/64</i>		
REFRIGERATION All Refrigeration checked, and satisfactory after charging, to Schedule No.		Sign. <i>8.</i> Date		
BODY CHECK All body fittings checked. All body creaks, rattles, etc., eliminated.	<i>Not electrically checked</i>	Sign. <i>J. Bolster</i> Date <i>12-1-64</i>		
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.	All danger points checked in accordance with Inspection Instruction No.	Sign. <i>J. W. King</i> Date <i>18-1-64</i> <i>5/1</i>		

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

TEST CARD

Chassis No. *1SF4223*

Engine No. *Quality*

Works O/N.

Date	MATTERS REQUIRING ATTENTION	Rectified		Fitter's/Tester's Signature
		Adj.	Changed	
<i>30-1-64</i>	<i>Edges, Polishing & Overspray Paint boot catches & petrol filler flange Wood stain fall table & finishes</i>			
<i>R112</i>	<i>o/s/r wing through ✓</i>			
<i>"</i>	<i>but o/s screen filler ✓</i>			
<i>"</i>	<i>o/s/r centre filler shot through ✓</i>			
<i>"</i>	<i>o/s/r door sill through ✓</i>			
<i>"</i>	<i>Score spot o/s/r steel arch ✓</i>			
<i>"</i>	<i>Di holes & mottled o/s/r wing ✓</i>			
<i>"</i>	<i>Excess on boot lid ✓</i>			
<i>"</i>	<i>Score spot petrol filler lid ✓</i>			
<i>"</i>	<i>n/s quarter panel through ✓</i>			
<i>"</i>	<i>n/s/r door through ✓</i>			
	<i>Ready to polish 7.55 31-1-64 <i>(Signature)</i></i>			

Date	MATTERS REQUIRING ATTENTION	Rectified		Fitter's/Tester's Signature
		Adj.	Changed	
	Annual Test & Body Labels			
	* Water Leak bottom of Vent Glass to frame?	OK		EMC
	* Loose object NS sill.			EMC
	* ASF of Summit fouling Radiator			EMC
	RAF Door Head to Glass			EMC
	ASF Sill seal loose			EMC
	01 B post. Wand seal loose			EMC
	front door fouling at peg			EMC
	2nd Rear nut box			EMC
	7th Post Handle			EMC
	7th Post door. Foam pad			EMC
	NSR: Sill seal loose			EMC
	NSF Sill & NS B post needs loose			EMC
	Slam plates			EMC
	Roof Check			EMC
	ASF Beam Rest			EMC

10
31.1.64
EMC

CHASSIS
TEST CARD

LSFU

Chassis No.

223

Engine No.

Works O/N.

MB

Date	MATTERS REQUIRING ATTENTION	Rectified		Fitter's/Tester's Signature
		Adj.	Changed	
9-1-64	Paint etc			J.S.
	Worship Tighten road wheels.	✓		
9-1-64	Check tyre pressures.	✓		
30mils.	Engine Improve T.O.		✓	
	Gearbox/Changer hanging on K.D too easy.		✓	
	Steering No pre load		✓	
	No springs on right lock		✓	
	PS pump mounts on lock. ? SEE OVERSEER.		✓	
	Spide cable noisy		✓	
	Valances fouling chassis.		✓	
	Carry out L.Hed 3.		✓	
	Gearbox filled with oil.			J.S.
	Brake sponge 2"		✓	
	Standing height 1-250.		✓	
	Ignition reset to 2° BTDC		✓	
	F1 reset at 2000		✓	

Date	MATTERS REQUIRING ATTENTION	Rectified		Fitter's/Tester's Signature
		Adj.	Changed	
10-1-64	Steering, Rattle in centre postion K Roadster hot. Check gearbox. Transfer gears adjusted 2 miles. Something fouling steering column when braking hard, or accelerating. More wheel pos. 2 air right. PS pump leaking, at front seal Gearbox, K P still too easy. Repository control lever.	✓	✓	K Braith
+ 12 miles 13-1-64	PS pump howls at high revs to Bonk cylinder drain tap leaking.	✓	✓	
14-1-64	244g/100 in 18% rev 20 miles Ducina's base pedal not returning K Roadster. Engine tinkering worse than before. Check ignition timing change petrol in tank.	✓	✓	
12 13/1/64	Generally satisfactory with exception of temperature, but thermostat for foreign matter Inspect oil seals. Check carb jets Hand to Gheen Body section.	✓	✓	GA

Date	MATTERS REQUIRING ATTENTION	Rectified		Fitter's/Tester's Signature
		Adj.	Changed	
	<u>Body Test</u>			
12/11/64	Break for centre section door H			DT
11/11/64	* Set n/s/l of frame to null			DT
	Wind noise round n/s/l of chassis			DT
	Refit floor - not central			DT
	Wind noise o/s/l top corner of chassis			DT
	work			Imper +
17/1/64	Firestone WW 8.20 X 15 Tubeless Tyres 19 H 22			} H/S
1/4	Check Wheel nuts & Grease Hubs			
1/4	" End float front Hubs			
1/4	" Tyres Pressures			
	Clean Steering Wheel & Shuttles			
	* Check End float NSF excessive ✓			H. STEELE G. GANZBURY
	Routine Check on			18
	Front & Rear standing heights - acceptable			
	Repack front containers both bottom seals leaking			
	Re position Sundj unit - moving lead to 1st test			18/1/64

BODY (7678)
TEST CARD

L.S.F.V.
Chassis No. 223 Engine No.

Works O/N.

Date	MATTERS REQUIRING ATTENTION	Rectified		Fitter's/Tester's Signature
		Adj.	Changed	
15-1-64	TIGHTEN BANNER STRAP SCREWS. SECURE W/S/B BONNET.	✓		WJ
	SET W/S/B DOOR FRAME CLOSE 'B' POST TOP.	✓		RM
	SECURE LOWER W/S/B POST TRIM PAD	✓		WJ
	CLEAR W/S/B FRAME TO CARB RAIL / GTR PISA RADIUS.	✓		WJ
	STICK TOP CORNER BOOT SEALS TO CROSS BOTTOM EDGE WIDE CAR TOP	✓		WJ
	STICK EDGE OF CLAMP BOX	✓		RM
11/64	WATER TESTS		✓	
R Bingle 15 miles	BOOT DOOR Very bad leak all along left seal		✓	WJ
	NSF DOOR BUZZ from glass if wet	✓		RM
	OSF DOOR Fill gap at mount with putty	✓		RM
	Sliding panel stiff to operate	✓		RM
	NSR DOOR Rattle if branged	✓		D
	Leaking from filler when door closed	✓		D
	Small loose object in door	✓		WJ
	Check cam rest screws	✓		RM
	* FIT PANEL	✓		WJ
	Check OS rear cam	✓		WJ
	SWITCH HANDLE BUTTON	✓		WJ
	OSR DOOR Rattle if branged	✓		RM
	Pad away from wing OSF	✓		RHS
	Check seat bolts	✓		WJ
	Widenise top front corner of frame NSF door	✓		WJ
	Break from top centre of frame	✓		WJ
(E)	Speakers balance control switch faulty			SEE OVER
	W/S/B DOOR Falls TRANS AFTER	✓		WJ

ENGINE
TEST CARD

GEARBOX T2159

Chassis No.

Engine No. 52214

Works O/N.

Date	MATTERS REQUIRING ATTENTION	Rectified		Fitter's/Tester's Signature
		Adj.	Changed	
3.12.63 <i>R. Jones</i>	ENGINE OIL PRESSURES 18 lbs sq.in. at T.O.		}	<i>R. Jones</i>
	45 lbs sq.in. at 40 MPH			
	ENGINE INHIBITED AFTER TEST DTD. 791.B.		}	<i>A. Smith</i>
	ENGINE FILLED WITH ENERGOL SAE.20.			
	GEARBOX OIL PRESSURES 80 lbs sq.in. FORWARD		}	<i>R. Jones</i>
	170 lbs sq.in. REVERSE			
	GEARBOX FILLED WITH MOBIL OIL WA.389			
	SPARKING PLUGS FITTED & GAPPED (TYPE CHAMP N16Y)			<i>A. Smith</i>
	CYLINDER HEAD FLOW CHECKED AT FOUR POINTS.		}	<i>R. Jones</i>
	TORUS PAN REMOVED & CHECK FOR OIL			
	ENGINE, GEARBOX & UNITS FREE FROM LEAKS			
	'A' 4 TAPPET COLLAPSED		✓	<i>R. Jones</i>
	'B' BANK W/TAP LEAKING		✓	<i>R. Jones</i>
	TIMING GEARS			
	OIL PUMP			
	VALVE GEAR			
	GEARBOX			

PASS

ORDER REF.

SERIAL No.

01.7799

CHASSIS SPECIFICATION

Chassis Type **SILVER CLOUD 111**

Engine No.

8U.111.F

Rota No.

Chassis No.

L. 871.225

W/O

3010

Series

PL. 1005/P

Body No.

7678

Battery

charged

Body Style

Silver Cloud 111 Saloon

C/Builder

Halls-Dayco

L.H. Rear Spring

UR. 3022

R.H. Rear Spring

UR. 3024

Steering Position

Left Hand.

Lock No.

510

Radio No.

Model. 77.7.

H. 118051

PAINTING DETAILS & LINES

Single Gold line.

BLACK PEARL. Valence. 173/1003.

TRIMMING DETAILS.

Beige Hide. Vts. 3234 with Beige piping. Vts. 3234

Fawn Headcloth. 10236 AS. Cumberland Stone Carpet. 72

SPECIAL FEATURE

FOR USE IN CANADA.

To be built to the U.S.A. Specification issue 4 - plus.

H.A. Electric Windows.

Hot Aerial.

Firestone White sided tubeless tyres U.4122

Plain safety glass throughout.

Antiglide on boot door not required.

CUSTOMER

Halls-Dayco of Canada Ltd.

SP

4.12.63.

SEV223

SFU223

Set Tabulator Stops.

Modifications incorporated additional to Series Specification.

- 6104/REL ✓
- 6105/REL ✓
- 6106/REL ✓
- 6107/REL ✓
- 6108/REL ✓
- 6109/REL ✓
- 6110/REL ✓
- 6111/REL ✓
- 6112/REL ✓
- 6113/REL ✓
- 6114/REL ✓
- 6115/REL ✓
- 6116/REL ✓
- 6117/REL ✓
- 6118/REL ✓
- 6119/REL ✓
- 6120/REL ✓

5237/RNL

Rear Springs - Part No. & Serial Nos.

LH 26799/1213 RH 27705/1123

Front Springs - Part No. & Washers.

LH 1105/6 RH 1105/6

Gearbox

Part No. T. 2159/3 Mod. 1-36

Axis

Part No. 7461 Ratio 13/40 Gear. PG. 854

Master Cylinders

VO. 151 - SO. 254

Brake

Rear. D. S. 2

Engine Sequence K

3. 2214

Cylinder Bore

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

Crankshaft Journals - Standard / - .002

Pin. Standard / - .002

Valve Guide Taper

Exhaust. Standard / + .006

Inlet. Standard / + .005

SA 202.1

SFU223

SFU223

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

Fit Battery Cable	j.m.e	Identify Engine	Red
Brackets & Tinning	b.s.	Fit & Set Brake Servo	
Fit Rear Springs	63.2K	Prop. Shaft—Front 75 lb. ft. Torque	B
2 Bars	JK	—Rear 45-50 lb. ft. Torque	
Axle U Bolts 60-65 lb. ft. Torque	PAK	Set Ram for Alignment	B
Rear Assembly	b.s.	Check Ram Clearance	
Stabiliser	JK	Fit Petrol Tank	OK
Torque tighten Yoke Pin Nuts 250 lb. ft. Torque	T	Fit Gear Control Linkages	B
Fit Front Shock Dampers	W.R.K.		
Toe In LH 031 RH 092	WY SA	Fit Brake Hoses	
Caster LH 054 RH 050	WY SA	Bleed Brakes	J
Camber LH 041 RH 0148	WY SA	Set Brakes	J
Ball Pin Height LH 9 RH 9	WY SA	Fit Exhaust System & Earth Straps	ALVGD
Front Susp. Friction LH 35 RH 30	WY SA	Fit Wiring Looms	
Front Sub-assembly			
Front Springs & Washers	WY	Blow out Exhaust System	ALVGD
Front Stabilizer Bar	WY		
Freedom of Centre Steering Lever		Fit Radiator & check all studs	RD
Rear Shock Dampers	WY		
Locking & Sealing of Front Hubs	WY		
Fit Steering Column & Box	(2)		
Fit Petrol Pump & Pipes AL/3861		COACHBUILT	
Fit Master Cylinders	WY	Fit & Set Handbrake	
Grease all points	WY	Fit Wiring	
Fit Brake Equaliser	WY		

