

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:-

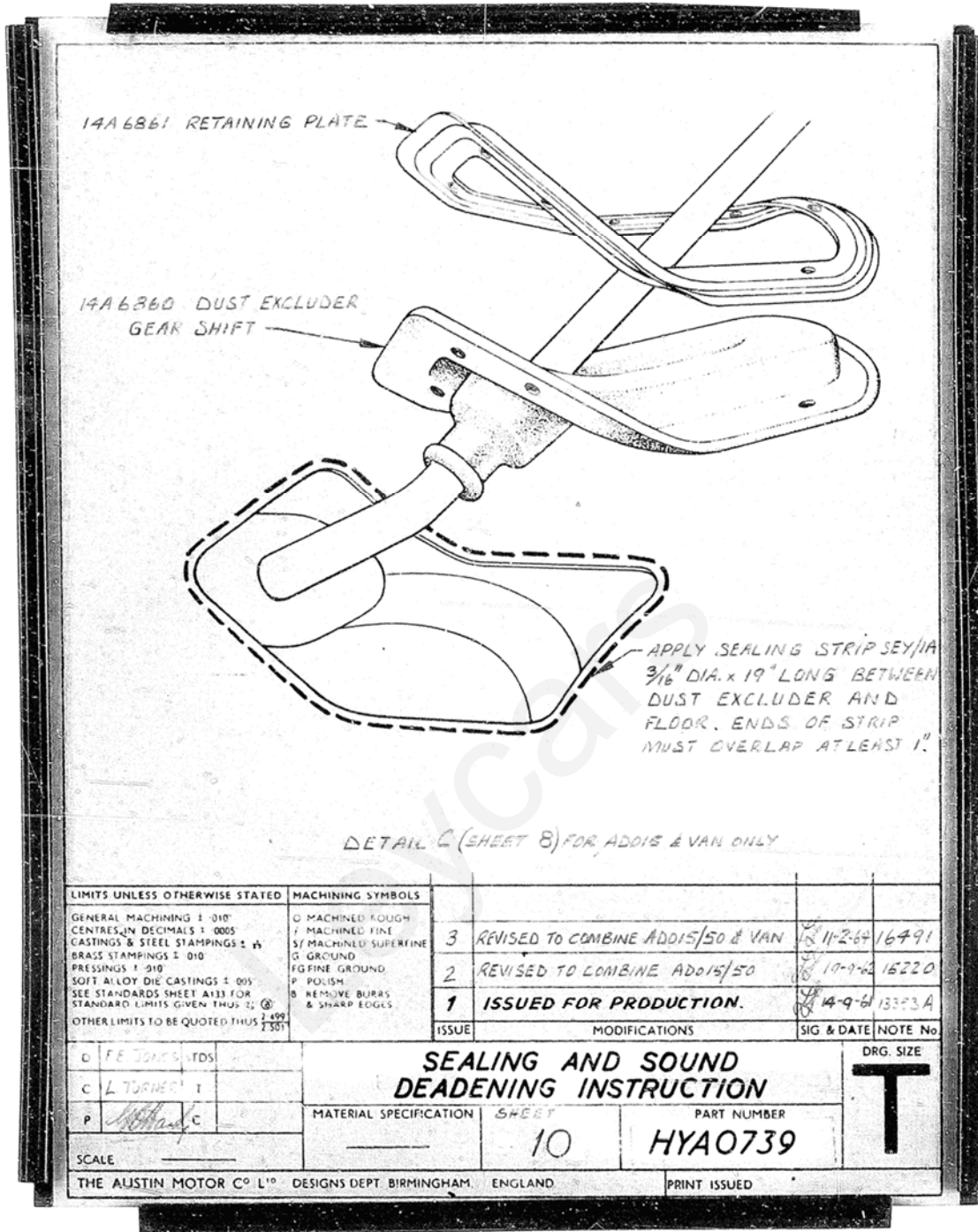
- A-A & C-C REFER SHEET 17
- B-B & D-D REFER SHEET 18
- E-E & F-F REFER SHEET 18

SEALING AFTER FINAL PAINT

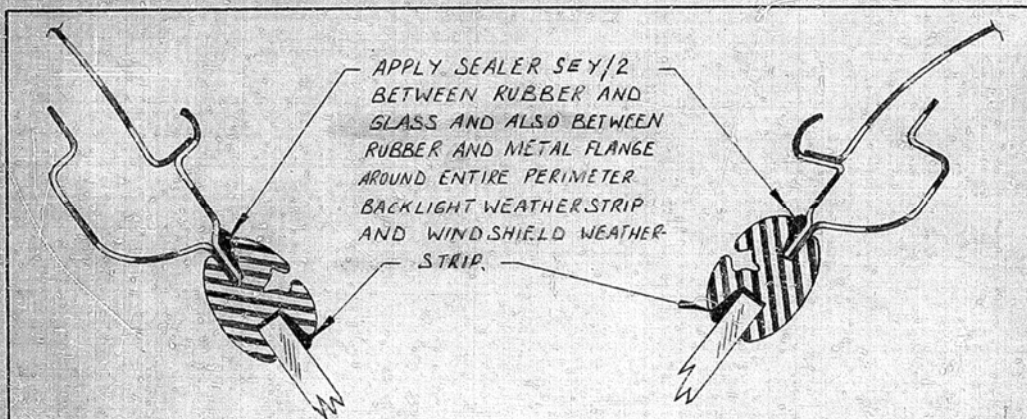
					16491	4	REVISED TO COMBINE ADDB/508 VAN		14-2-64
					15220	3	REVISED TO CENTRE LINE ADDB/508 VAN		17-9-62
					14136	2 ²	DETAIL LOCATION & NOTE DELETED		5-3-62
					14080	1 ²	DETAIL LOCATION & NOTE ADDED		29-12-61
					13353A	-	RELEASE		14-9-61

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.					
			1 OF 41	HYA0739					

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



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: .001				ISSUE	MODIFICATIONS	SIG & DATE NOTE No.
D FE JONES STDS		SEALING AND SOUND DEADENING INSTRUCTION			DRG. SIZE T	
C L TURNER I						
P [Signature] C						
SCALE		MATERIAL SPECIFICATION	SHEET	10	PART NUMBER	HYA0739
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 WEATHER-
STRIP.

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

SECTION C-C (SHEET 1)
ALL VERSIONS

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

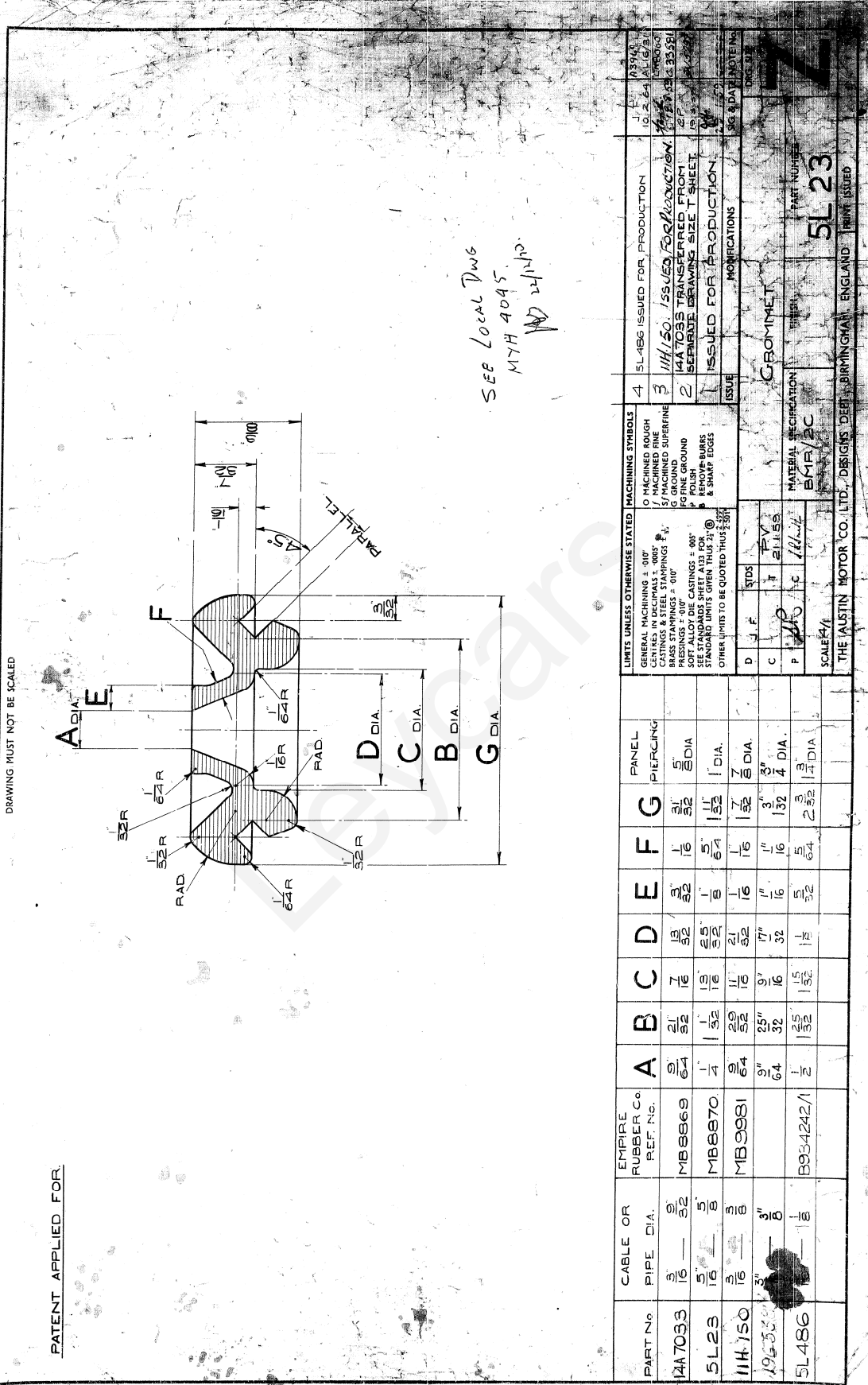
JOINTS OF FILLER STRIPS TO BE
ON CENTRE LINE AT BOTTOM OF
BACK-LIGHT AND WINDSHIELD
WEATHER-STRIPS.

AUTHY.	ISSUE	REVISIONS	CHD.	DATE	AUTHY.	ISSUE	REVISIONS	CHD.	DATE
					16491	2	REVISED TO COMBINE ADO1950 & VAN		11-2-64
					15220	1	REVISED TO COMBINE ADO1950		19-7-62
					13353A	-	RELEASE		14-9-61

DRN <i>Les Turner</i>	NAME SEALING AND SOUND DEADENING INSTRUCTION	T
CHD. <i>L. TURNER</i>	SHEET 17	
APPD. <i>Houghmore</i>	PART NO. HYA0739	
FINISH	MATERIAL	
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.
<u>Application:</u>			
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



DRAWING MUST NOT BE SCALED

PATENT APPLIED FOR

SEE LOCAL DWG
MYH 4045
2/1/13

PART NO	CABLE OR PIPE DIA.	EMPIRE RUBBER CO. REF. NO.	A	B	C	D	E	F	G	PANEL PIERCING	LIMITS UNLESS OTHERWISE STATED: GENERAL MACHINING ± .010" CASTINGS & STEEL STAMPINGS ± .015" BRASS STAMPINGS ± .010" PRESSINGS ± .010" CASTINGS ± .005" SEE STANDARD SHEET A133 FOR OTHER LIMITS TO BE QUOTED THUS: ± .005	MACHINING SYMBOLS O MACHINED ROUGH S MACHINED SUPERFINE G FINE GROUND P REMOVE BURRS & SHARP EDGES	4 5L486 ISSUED FOR PRODUCTION	J. F. 10.2.64 A16751
14A7033	3/16	MB8869	9/64	21/32	7/16	13/32	3/16	1/16	3/32	5/8 DIA				
5L23	5/16	MB8870	1/4	1/2	13/16	5/8	1/2	5/16	1/2	1 DIA.				
11H.150	3/8	MB9381	9/64	25/32	11/16	21/32	1/16	1/16	7/32	7/8 DIA.				
19532	3/8		9/64	32/64	17/32	32/64	1/16	1/16	3/4	3/4 DIA.				
5L486	1/2	B934242/1	1/2	13/16	15/16	1 1/8	5/8	5/8	2 3/8	1 3/4 DIA.				

5L 23

GROMMET
MATERIAL SPECIFICATION
BMR/BC
SCALE 1/1
PART NUMBER

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