

# TRUCK UTILITY MEDIUM (HS) HT W/VPK

## BODY AND ASSOCIATED EQUIPMENT

### MODIFICATION INSTRUCTION No. 6

Sponsor: SUV IPT  
Project No.: UOR IO4125  
File Ref: SUV8/32/4

Publication Authority: TES TIG Andover

### AMENDMENT RECORD

Amdt No.	Incorporated By (Signature)	Date
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Amdt No.	Incorporated By (Signature)	Date
4		
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**SUBJECT:** Fitment of upgraded anti roll bar and bracket

### INTRODUCTION

1 This modification introduces a new anti roll bar and bracket to improve specification on all SNATCH 2 vehicle variants.

1.1 Limitations on use of equipment. Nil.

### APPLICABILITY

2 Truck Utility Medium (HS) W/VPK (SNATCH 2A).

2.1 Fitted to listed VRM's held by user units and unmodified stock, held at all levels of technical storage:

25KK51, 25KK52, 25KK53, 25KK60, 25KK61, 25KK65, 25KK69, 25KK76, 25KK88, 25KK91, 25KK92, 25KK93, 26KK00, 26KK01, 26KK06, 26KK08, 26KK13, 26KK17, 26KK18, 26KK26, 26KK27, 26KK30, 26KK36, 26KK37, 26KK55, 26KK56, 26KK57, 26KK60, 26KK64, 26KK67, 26KK70, 26KK71, 26KK72, 26KK73, 26KK74, 26KK77, 26KK80, 26KK84, 26KK88, 26KK90, 26KK94, 26KK95, 26KK96, 27KK01, 27KK04, 27KK05, 27KK07, 27KK11, 27KK19, 27KK24, 27KK29, 27KK30, 27KK31, 27KK33, 27KK34, 27KK35, 27KK37, 27KK42, 27KK43, 27KK44, 27KK51, 27KK58, 27KK59, 27KK61, 27KK67, 27KK76, 27KK80, 27KK83, 27KK86, 27KK88, 27KK91, 27KK92, 27KK97, 28KK01, 28KK04, 28KK07, 28KK08, 28KK09, 28KK14, 28KK20, 28KK22, 28KK26, 28KK38, 28KK39, 28KK40, 28KK46, 28KK50, 28KK53, 28KK55, 28KK66, 28KK67, 28KK68, 28KK72, 28KK73, 28KK77, 28KK80, 28KK82, 28KK85, 28KK86, 28KK94, 29KK00, 29KK15, 29KK16, 29KK21, 29KK29, 29KK34, 29KK40, 29KK46, 29KK49, 29KK51, 29KK55, 29KK58, 29KK62, 29KK96, 30KK02, 30KK11, 30KK16, 30KK17, 30KK27, 30KK34, 30KK38, 30KK43, 30KK48, 30KK57, 30KK63, 30KK64, 30KK78, 30KK82, 30KK83, 30KK91, 30KK98, 31KK02, 31KK05, 31KK10, 31KK18, 31KK20, 31KK58, 31KK64, 31KK70, 31KK72, 31KK73, 31KK84, 31KK87, 31KK89, 31KK92, 31KK94, 31KK96, 32KK04, 32KK13, 32KK21, 32KK31, 32KK32, 32KK35, 32KK42, 32KK53, 32KK55, 32KK59, 32KK60, 32KK77, 32KK86, 32KK88, 33KK07, 33KK12, 33KK14, 33KK22, 33KK27, 33KK28, 33KK33, 33KK34, 33KK55, 33KK70, 33KK74, 33KK80, 33KK84, 33KK94, 33KK96, 33KK98, 34KK04, 34KK11, 34KK14, 34KK47, 34KK55, 34KK57, 34KK64, 34KK66, 34KK89, 34KK91, 35KK00, 35KK01, 35KK02, 35KK09, 35KK10, 35KK16, 35KK28, 35KK32, 35KK34, 35KK38.

**REASON FOR MODIFICATION**

3

- 3.4 Code 2 - To improve operational performance.

**PRIORITY**

4

- 4.3 ARMY: Routine.

- 4.4 RAF: Class 3.

**ESTIMATED TIME REQUIRED**

5

- |     |             |                 |
|-----|-------------|-----------------|
| 5.1 | Dismantling | 1.0 man-hours.  |
| 5.2 | Embodiment: | 2.50 man-hours. |
| 5.3 | Testing     | 0.50 man-hours. |

**IMPLEMENTATION PLAN**

6

- 6.1 This instruction is to be implemented by:
- 6.1.1 ARMY – Units authorized to carry out levels 2, 3 or 4 maintenance.
- 6.2 Associated instructions. Nil.

**ACTION REQUIRED BY**

7

- 7.1 Units and establishments holding equipment.
- 7.1.1 Examine equipment documents to see if modification is applicable.
- 7.1.2 Examine equipment or modification record plate to see if modification is embodied and where necessary Units with 1st line REME Support demand the stored required.
- 7.1.3 ARMY – On receipt of stores, request REME to modify equipment.
- 7.1.4 ARMY - Record the AESP and instruction number in equipment documents.
- 7.2 Army units authorized to carry out levels 2, 3 and 4 maintenance and RAF units.
- 7.2.1 ARMY - When requested by units or during overhaul of equipment on charge without REME 1st Line Support, obtain the items listed in Para 8 and carry out this modification.
- 7.2.2 Record completion details of modification against appropriate entry in vehicle documents. A further record of vehicle reg, VIN No and Odometer reading on completion of modification is to be forwarded to SUV IPT DLO Andover Project Manager, either by email; [REDACTED], or fax [REDACTED].
- 7.3 All recipients of this instruction. Add particulars to 2320-D-132-811 Instr Index.



# STORES, TOOLS AND EQUIPMENT

8

## 8.1 Stores to be demanded.

8.1.1 The following item is to be demanded quoting this instruction as the authority.

8.1.2 Registration/Serial Number of vehicle/engine/assembly for equipment held by user units.

Refer to Item No.	DMC	NSN/Part No.	Designation	Qty per equipment
	7RU	2530-99-231-4008	Mod set: comprising	
38	7XD	2590-99-212-9342	LH Axle Bracket	1
39	7XD	2590-99-666-6606	RH Axle Bracket	1
40	7RU	2510-99-147-9328	Anti-Roll Bar	1
41	7RU	5365-99-904-0387	Anti Roll Bar Bush	2
42	7RU	5306-99-188-5504	Screw M10 X 30	4
43	7RU	5310-99-842-0637	Nylock Nuts	4

8.2 Stores or suitable equivalent to be obtained locally (if required). Nil.

8.3 Tools and stores to be manufactured. Nil.

8.4 Stores to be removed and reduced to scrap.

Refer to Item No.	DMC	NSN/Part No.	Designation	Qty per equipment
7	7XD	2510995773837	Anti-Roll Bar	1
8	7XD	5365991525237	Anti Roll Bar Bush	2
9	7XD	5310992158626	Screw M10 X 30	4
10	G1	5306991228669	Nylock Nuts	4

8.5 Items/stores to be modified. Nil.

8.6 Special tools and test equipment required.

Refer to Item No.	DMC	NSN/Part No.	Designation	Qty per equipment
11	WTE	4910-99-839-2791	Ball joint remover	1
12			Mig Welder 170 Amp (Min)	1

## SEQUENCE OF OPERATIONS

9

## WARNING

**PERSONAL INJURY: BEFORE ANY ELECTRICAL CIRCUITS ARE DISTURBED OR DISCONNECTED, ALL POWER SUPPLIES, TO AND FROM THE VEHICLE ARE TO BE DISCONNECTED. POWER SUPPLIES ARE TO BE RECONNECTED ONLY WHEN THE PERSON RESPONSIBLE FOR EMBODYING OR INSPECTING THE MODIFICATION IS SATISFIED THAT ALL ACTIONS HAVE BEEN TAKEN TO MAKE THE VEHICLE SAFE FOR RECONNECTION.**

The item numbers of Para 8 are used as reference throughout this instruction.

Carry out this instruction as follows:

- 9.1 Stop the vehicle and turn off the ignition, apply the handbrake and place wheel chocks.
- 9.2 Disconnect the vehicle battery negative terminal.
- 9.3 Working underneath the vehicle, remove the 2 bolts that locate the steering arm guard and remove the guard, see fig 1.

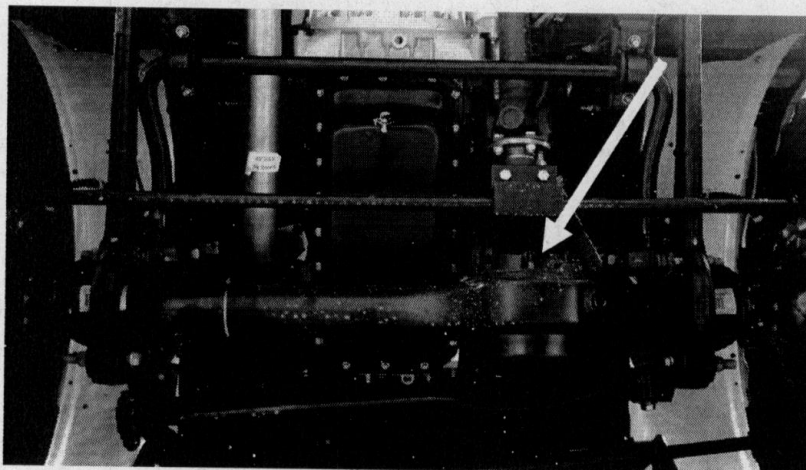


Fig 1.

- 9.4 Remove left hand track rod end using tool (item 11), turn the track rod around the ball joint to the right swivel and secure it safely away from the work area.
- 9.5 Remove 2 X M10 nuts and washers from Anti Roll Bar bush brackets on each side, see fig 2. Remove both brackets.



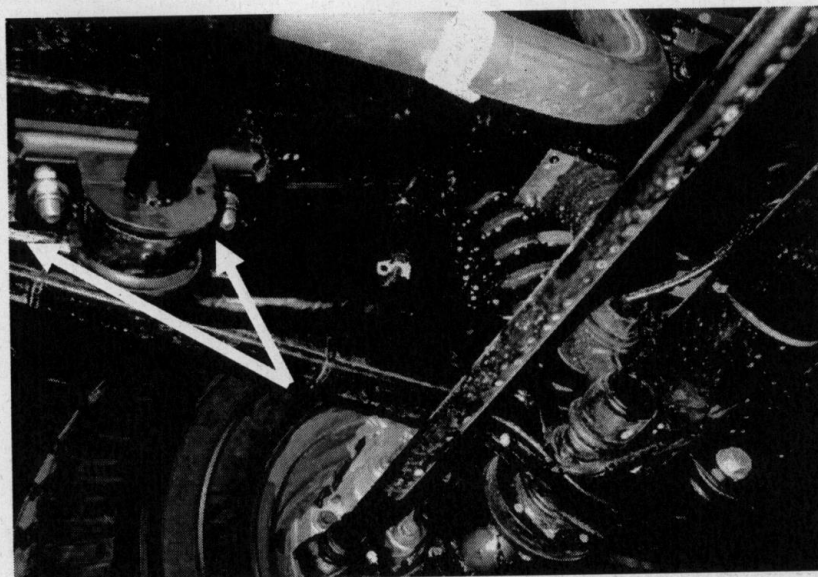


Fig 2.

- 9.6 Pull roll bar rearwards to allow access to front fixings.
- 9.7 Remove the two nuts from the front ends of the roll bar.
- 9.8 Push the bolts through sufficiently to free the end of the anti roll bar, remove the anti roll bar.
- 9.9 Remove the split pin and bolt from the drop link on each side of the vehicle, see fig 3.

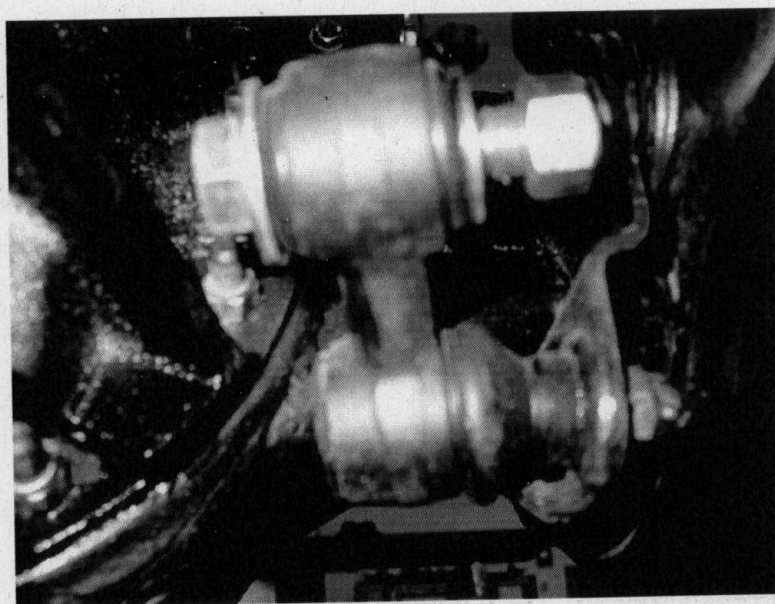


Fig 3.

- 9.10 Remove the drop links.
- 9.11 Remove the front axle breather from the retaining clips.
- 9.12 Remove the front axle breather.
- 9.13 Clean, sand edges of brackets (items 1 & 2) to ensure good clean surface to weld.
- 9.14 Clean/sand area where the brackets are to be welded on the axle, see fig 4.

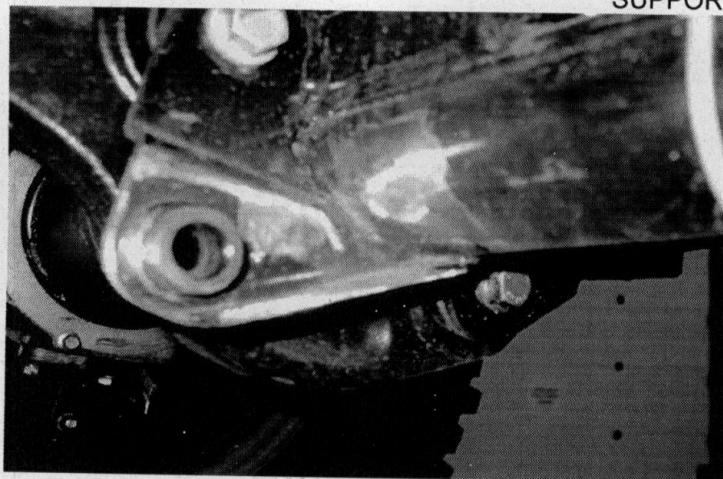


Fig 4.

9.15 Use a locator M12 bolt, nut and two penny washers, bolt the bracket to the axle ensuring that it is located straight, see fig 5.

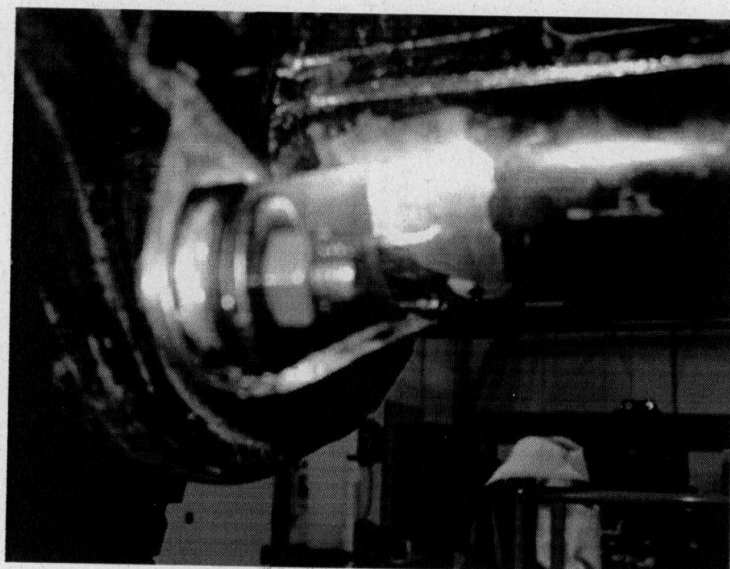


Fig 5.

9.16 Tack the three main contact points as shown in fig 6.



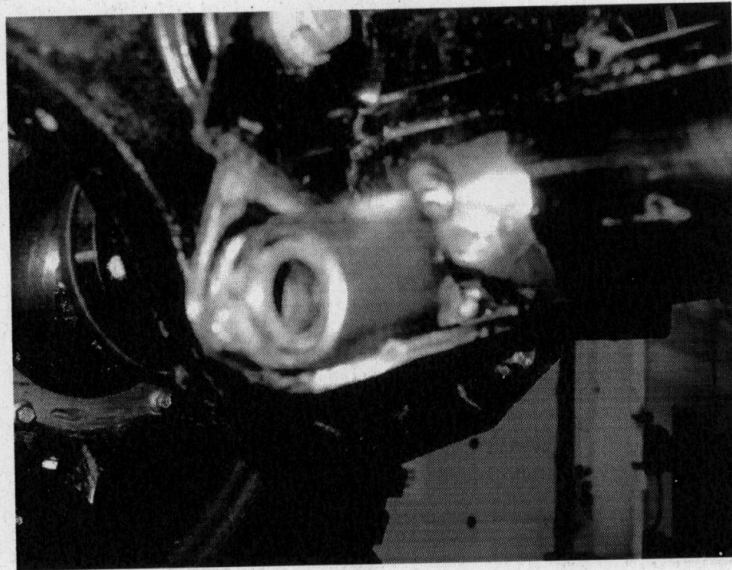


Fig 6.

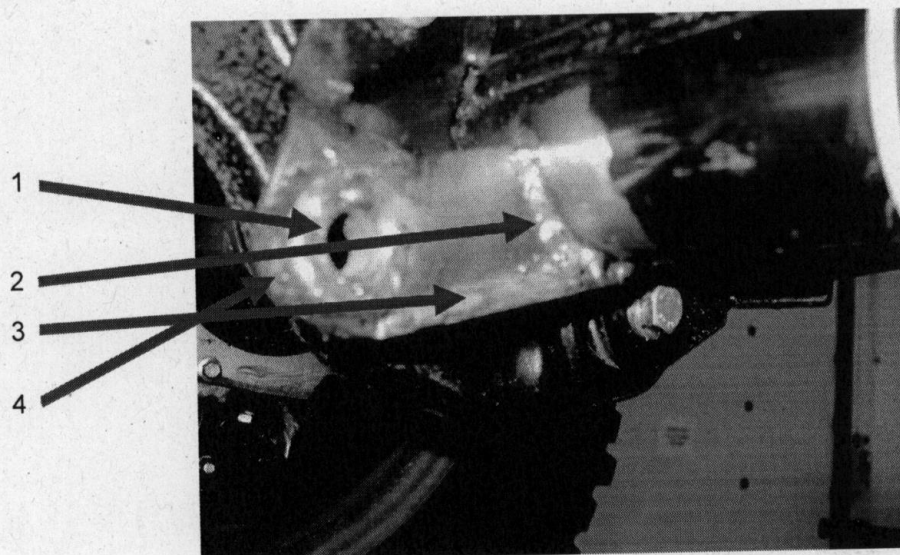
9.17 Remove the locator bolt and washer, then continue to weld the bracket using item 12 as indicated below:

9.17.1 Starting around the hole as indicated in fig 7 point 1.

9.17.2 Weld the axle edge and over the top of the bracket as indicated in fig 7 point 2.

9.17.3 Bottom of bracket as indicated in fig 7 point 3.

9.17.4 Round the front of the bracket and the boss as indicated in fig 7 point 4.



9.18 Dress back the excess weld, clean and coat with anti-rust paint, see fig 8.

**IMPORTANT  
CHECK WELDING  
OVER THE TOP OF  
THE BRACKET**

Use angle  
grinder for face.

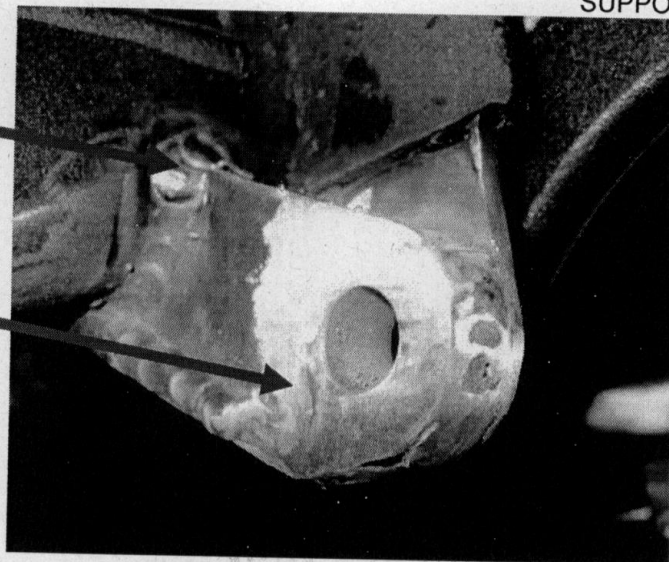


Fig 8

- 9.19 Reattach drop links, tighten bolts and insert new split pins.
- 9.20 Attach new anti roll bar (item 3).
- 9.21 Place new anti roll bar bushes (item 4) over roll bar with slit facing rearwards.
- 9.22 Fit new anti roll bar bracket fixings (items 5 & 6) into anti roll bar brackets.
- 9.23 Rotate the track rod back into position, refit nut and tighten, fit new split pin.
- 9.24 Reattach steering arm guard with original bolts.
- 9.25 Re clip and reconnect axle breather pipe to axle.
- 9.26 Reconnect battery earth.
- 9.27 Apply Waxoil liberally to undercoated areas, axle brackets, linkages and anti roll bar.

#### **TESTING AFTER EMBODIMENT**

10. As follows:

Drive the vehicle for approximately five miles.

Check security of anti roll bar brackets and bolts.

#### **EFFECT ON WEIGHT**

11 Negligible.

#### **PUBLICATION AMENDMENTS**

12 NOTE

Necessary amendments will be issued separately.



Sponsor: SUV IPT  
Project No.: UOR IO4125  
File Ref: SUV8/32/4

Publication Authority: TES TIG Andover

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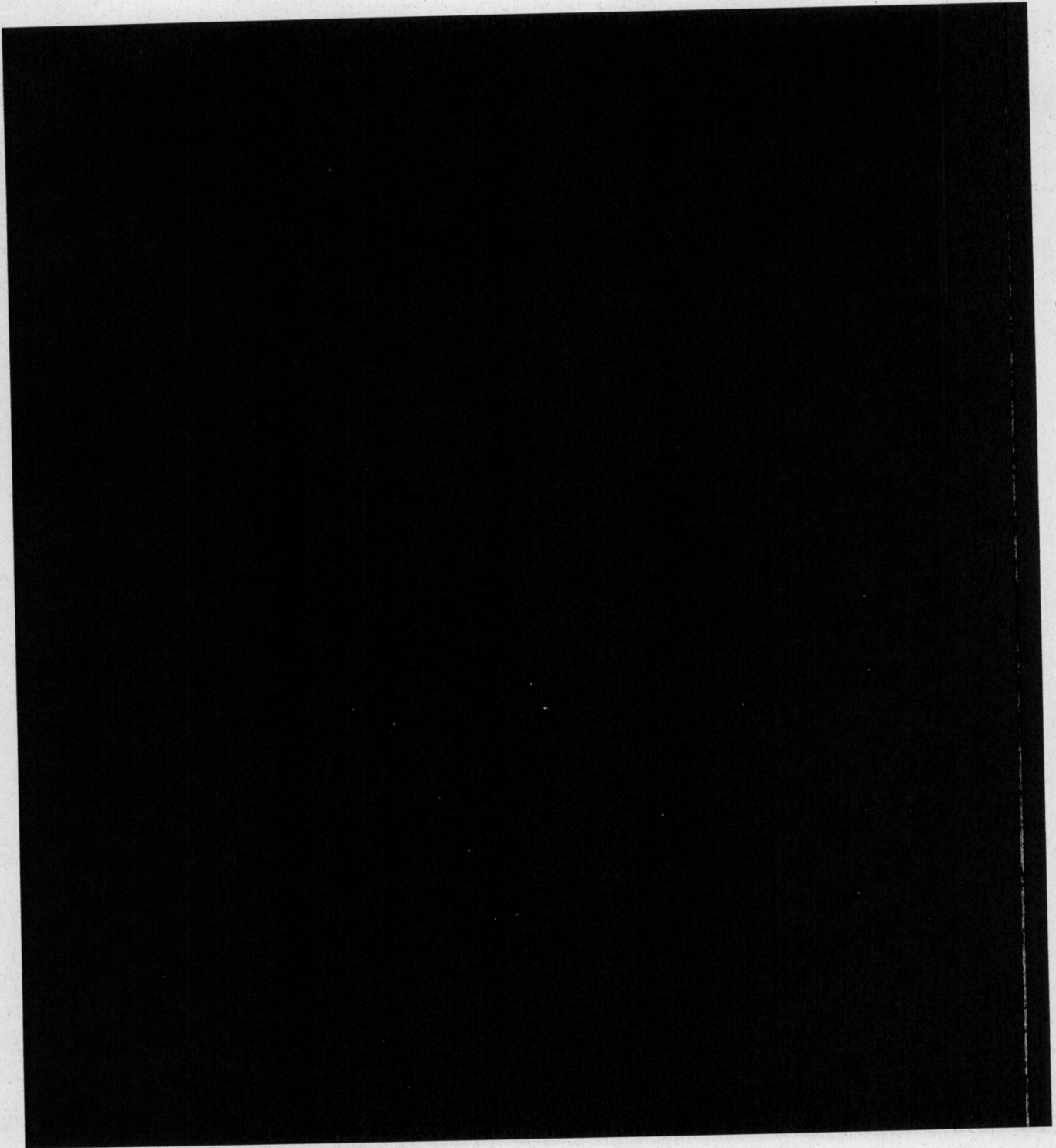
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## MODIFICATION INSTRUCTION No 9

## AMENDMENT RECORD

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TRUCK UTILITY MEDIUM (HS) HT W/ VPK2 24V (WITH ACU) REFURBISHED  
2005 [REDACTED]

MODIFIED NUMBER PLATE, RELOCATION OF THE NUMBER PLATE LIGHT AND  
INSTALLATION OF A KICK PLATE

MODIFICATION INSTRUCTION No. 10

Sponsor: Protected Mobility Team  
Project No.: UOR A01431  
File Ref: PMT/8/32/7/1

Publication Authority: TES TIG ABBEYWOOD

AMENDMENT RECORD

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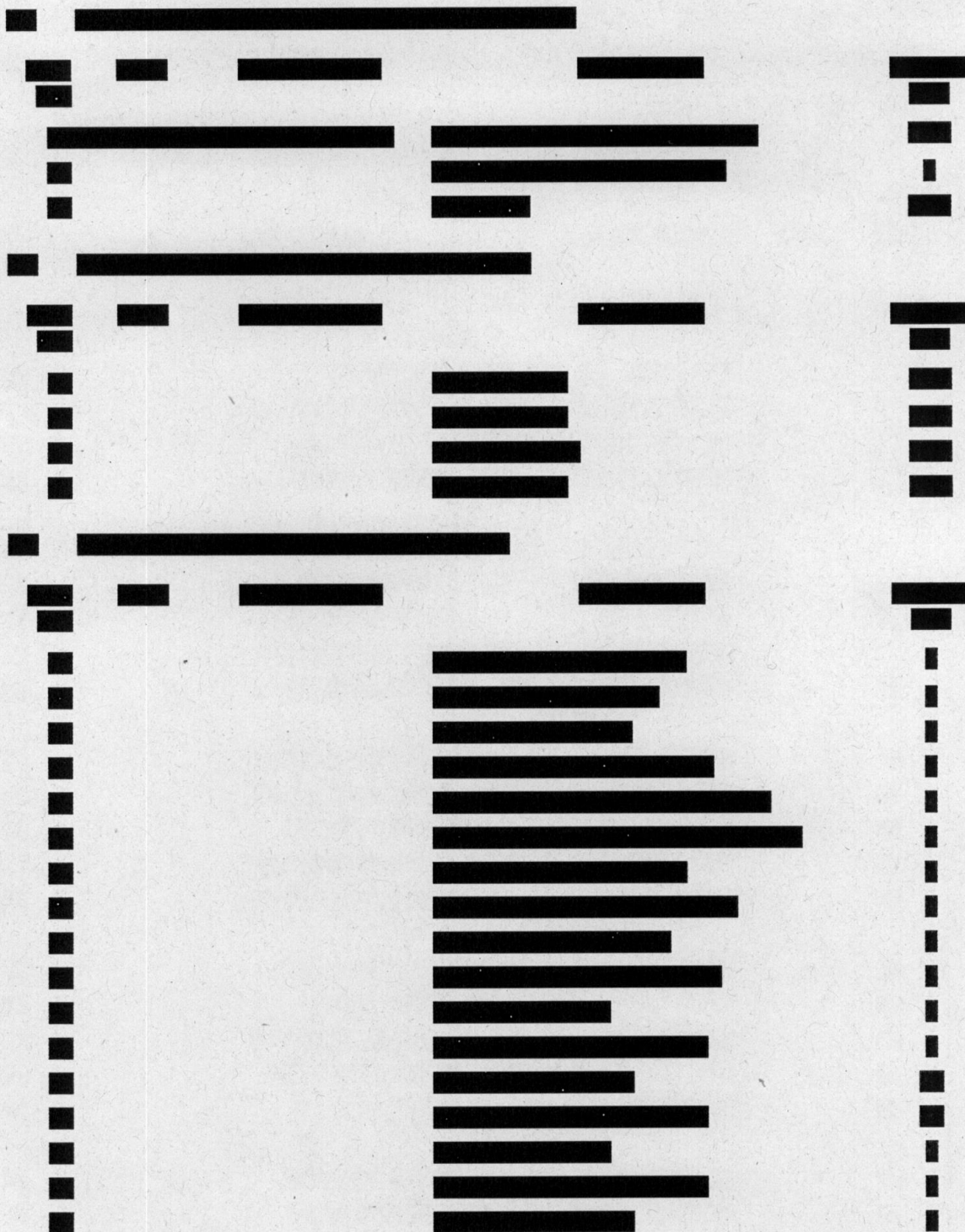
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