

This "chapter" has been in development for many months. We attempt in the following sections to show clearly how the TR2 and TR3 body shells are assembled from components, and we bring products together from a number of sources to provide a fairly complete service, although this goal has not yet been completely realized. We would like to enable customers to resurrect virtually any car from a barn or a field. The parts cars of the past may be turned into the concours winners and daily drivers of the future.

Several levels of components have been available. When TRF started business in 1978, a number of repro panels were available at fairly reasonable prices. Things like floors, inner and outer sills, trunk floors, rear quarters, etc. All of these panels were fairly flat, and they were manufactured by a now-defunct company on inexpensive tooling using a "rubber press." Attempts were also made to produce fenders and aprons using some tools that had been produced earlier in California to make fenders sold by J.C. Whitney. These tools were problematic, and eventually, they were lost. Other attempts were made in the early 1980s in England to produce rear fenders and other panels, and these were used to save many cars there, but they were unacceptable in the U.S. market since they required a high level of skill to fit to a car. In the U.S., used panels were the preferred choice for outer body panels as long as they lasted, and some used parts remain available today.

Making body shells for sports cars is a cottage industry in England, and companies exist which make body panels by hand from flat sheet metal using the skills handed down from their fathers and grandfathers. The photo above shows a complete body shell produced in this fashion by North Devon Metal Products. TRF will continue to supply low volume components produced by hand. These are usually produced for specific orders, and lead time is a factor.

Over the past couple of years a European source has begun to produce a new range of popular inner and outer panels with the goal of reaching the standard of original Triumph parts or better. We are listing these among the parts in the following sections. Generally, we add the suffix "BP" to the part numbers of these components. We are also including a page of photos of these better panels at the end of this chapter, on page 138. All of them come well-packaged and presented in high-quality primer. Generally we will try to maintain stocks of these, and they are supplied fairly quickly even when we run out.

Parts illustrations and descriptions included in this chapter attempt to provide an understanding of original details of specific components as they were developed for the TR2, TR3, TR3A, and TR3B range of cars. This presentation is limited by the confines of a parts catalogue. A book could be written on this subject, but in the space we have here, we have tried to aid enthusiasts to avoid mixing model variations on one car, a problem which has reared its ugly head many times in the past.

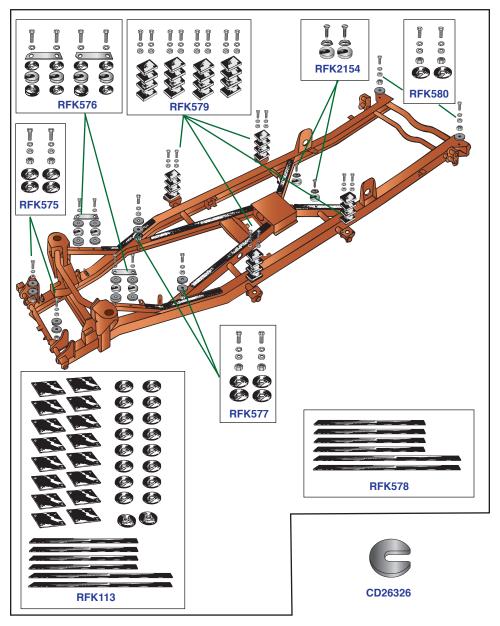
We hope you find these listings to be useful in restoring or improving examples of the TR2, TR3, TR3A, and TR3B range of cars.

BODY MOUNTING KITS

"Packaged in Subkits for Easy Identification"

TRF's first real catalogue written and printed in Spring 1979 listed the same body mounting components you will find here. Replacing body pads is an essential part of any complete restoration and it provides a solid feel to the car you can't have without replacing old pads and hardware. Body pads are also useful in aligning body panels when the body is being installed on the chassis frame after a major rebuild. Increasing or decreasing pads in various locations will adjust door gaps and other problems. TRF body mounting kit as listed below includes all components required to mount the body to the chassis frame as it came from the factory

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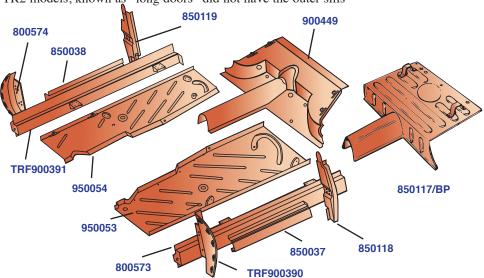


BODY MOUNTING KITS—Continued

RFK574 BODY MOUNTING KIT, complete; includes all sub-kits indented below RFK575 Front Sub-Kit, mounting front inner fenders to brackets on chassis frame RFK578 Protection Strip Sub-Kit, includes six rubber strips cemented to chassis frame front and rear X-members and side braces RFK576 Side-Brace Sub-Kit, mounting inner front fenders to suspension braces; includes thin, thick, and alloy mounting pads, reinforcing plates, set screws, and lock washers RFK577 Front Cruciform Sub-Kit, mounting fronts of main floor panels to chassis frame front X-member; includes thin pads, bolts, and washers RFK2154 Rear Cruciform Sub-Kit, mounting rears of main floor panels to chassis frame rear X-member; includes alloy pads, special washers, and screws with countersunk heads RFK579 Sill-Mounting Sub-Kit; fitted between outrigger brackets welded to insides of outer sill assemblies; includes square
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outer sill assemblies; includes square
pads, bolts, and washers RFK580 Rear Sub-Kit, mounting brackets at rear 1
of body to chassis frame, includes
thin round pads, set screws, washers,
and nuts
RFK113 BODY PAD AND STRIP KIT, includes a 1
complete set of rubber pads and strips,
but no hardware, includes extra pads
for shimming
601994 Pad, rubber, thin round, body mounting A/R
608836 Pad, rubber, thick round, body M/R mounting
611732 Pad, rubber square, body mounting A/R
601995/1 Protection Strip , 18-inches A/R
601995/2 Protection Strip, 18-inches A/R
CD26326 Pad, alloy, slotted, not included in kit A/R

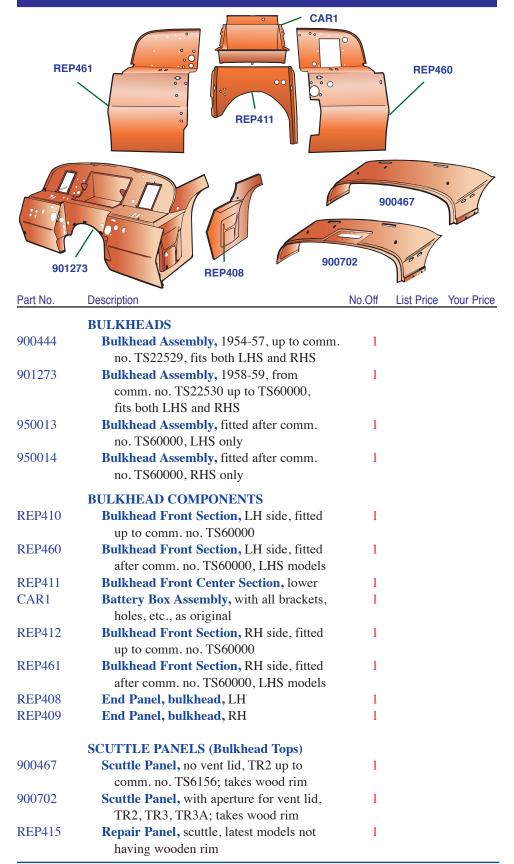
CENTER BODY STRUCTURE, TR2, TR3

Late main floor panels supplied may be a teeny bit longer than on earlier versions, as the toe board flanges turn rearward under the floors on earlier models and they turn forward over the floors on models after comm. no. TS60000. Trim only after taking careful measurements. TRF inner sills are made to match original dimensions, including pressings to locate door posts. They retain sheet metal of the original gauge and other specifications which more than justify their slightly higher price. Very early TR2 models, known as "long doors" did not have the outer sills



Part No.	Description	No.Off	List Price	Your Price
	SILLS (ROCKER PANELS)			
TRF900390	Sill, inner, LH; read above	1		
TRF900391	Sill, inner, RH; read above	1		
850037	Sill, outer (Rocker Panel), LH	1		
850038	Sill, outer (Rocker Panel), RH	1		
	FLOOR PANELS			
950053	Main Floor Panel, LH	1		
950054	Main Floor Panel, RH	1		
900449	Rear Floor Assembly, with drive shaft	1		
	tunnel, fitted up to comm. no. TS60000)		
850117/BP	Rear Floor Assembly, with drive shaft	1		
	tunnel, fitted after comm. no. TS60000)		
	FRONT AND REAR DOOR POSTS			
800573	Door Post, front (aka "A" Post), LH	1		
800574	Door Post, front (aka "A" Post), RH	1		
REP459	Bracket, pivot, door check strap, included	2		
	with door post, also supplied for repair	'S		
850118	Door Post, rear (aka "B" Post), LH, fitted	1		
	after comm. no. TS60000; use for all			
	replacements			
850119	Door Post, rear (aka "B" Post), RH, fitted	. 1		
	after comm. no. TS60000; use for all			
	replacements			

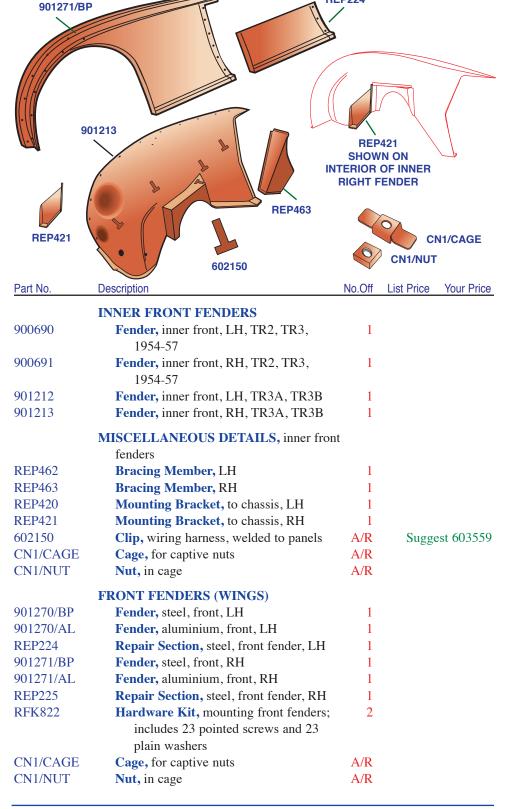
BODY SHELL-BULKHEAD AND SCUTTLE REPAIR



REP224

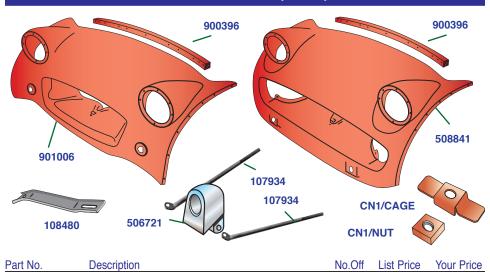
BODY SHEET METAL COMPONENTS

BODY SHELL—FRONT FENDERS (WINGS), INNER AND OUTER



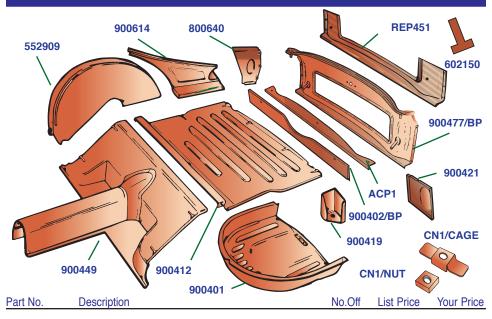
Part No.

BODY SHELL-FRONT APRONS, TR2, TR3



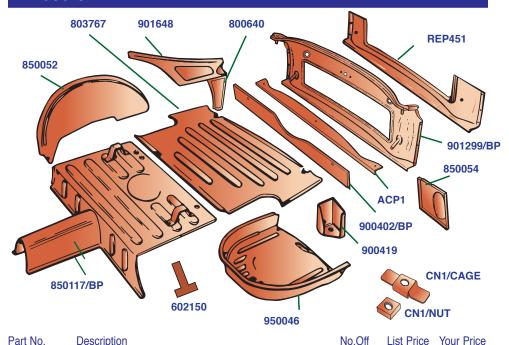
900458	Front Apron Assembly, TR2, up to comm. no. TS8636	1
901006	Front Apron Assembly, narrow grille, TR3,	1
	from comm. no. TS8637 up to TS22013	
508841	Front Apron Assembly, wide grille, TR3A,	1
	TR3B, after comm. no. TS22013	
900396	Tie-member, between inner finders	1
RFK824	Hardware Kit, securing front apron to tie	1
	member and tie-member to brackets on	
	inner fenders, bolts, washers, nuts, 36 piece	es
108480	Stay, front apron to chassis frame, fitted from	1
	comm. no. TS1 up to TS?	
RFK2186	Hardware Kit, securing stay to front apron	1
	and to chassis frame, includes two set	
	screws, washers, and nuts, 8 pieces	
RFK823	Hardware Kit, securing front apron to outer	1
	fenders, includes 12 pointed bolts and 12	
	plain washers	
CN1/CAGE	Cage, for captive nuts	A/R
CN1/NUT	Nut, in cage	A/R
RFK2187	Hardware Kit, securing lower platform	1
	panel inside front apron to inner front	
	fenders; includes two styles of fasteners,	
	either of which may have been used,	
	instruction sheet, TR3A, TR3B only	
506721	Bracket, hand crank guide; chromed on	1
	earlier cars, body colour, or possibly	
	self finish on later cars	
JN2108	Jam Nut, securing guide bracket to apron	2
WL207	Washer, lock, securing jam nuts	2
107934	Stay, supporting hand crank guide from	2
	cross-tube on chassis frame	
RFK2188	Hardware Kit, securing stays to hand crank	1
	guide and to chassis frame; includes bolt,	
	lock washer, and nuts, 7 pieces	© The Roadster Factory

BODY SHELL—REAR BODY SECTION, TR2, TR3, 1954-59



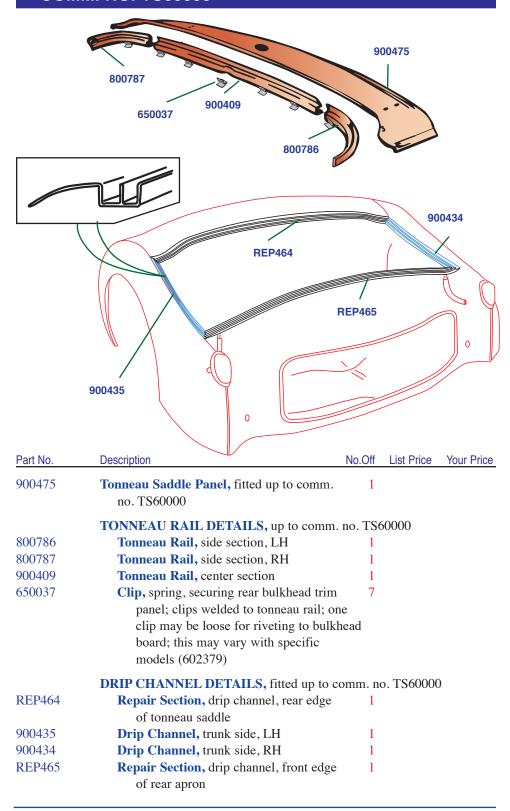
	REAR BODY DETAILS, from comm. no.		
	TS1 up to TS60000		
900449	Rear Floor Assembly, with drive shaft	1	
	tunnel		
900412	Trunk Floor Assembly	1	
552908	Wheel Arch, LH	1	
900615	Trunk Side, with trunk floor section, LH	1	
552909	Wheel Arch, RH	1	
900614	Trunk Side, with trunk floor section, RH	1	
900401	Container, spare wheel	1	
900477/BP	REAR APRON , outer panel, fitted up to	1	
	comm. no. TS16473 on some cars and		
	later on others		
901299/BP	REAR APRON , outer panel, with separate	1	
	signal lamp pressings, fitted to some cars		
	for U.S. market after comm. no. TS16473		
	all cars by TS18913		
ACP1	Repair Panel, rear apron bottom flange	1	
REP451	Repair Panel, rear apron bottom section,	1	
	bottom flange and half way up spare		
	tire opening		
900402/BP	Rail, back bottom	1	
900421	Panel, closing, rear apron, front, LH	1	
900422	Panel, closing, rear apron front, RH	1	
800639	Panel, closing, rear apron, side, LH	1	
800640	Panel, closing, rear apron, side, RH	1	
900419	Bracket, body mounting, LH	1	
900420	Bracket, body mounting, RH	1	
CN1/CAGE	Cage, for captive nuts	A/R	
CN1/NUT	Nut, in cage	A/R	
602150	Clip, wiring harness, welded to panels	A/R	Suggest 603559

BODY SHELL—REAR BODY SECTION, TR3A, TR3B, 1959-62

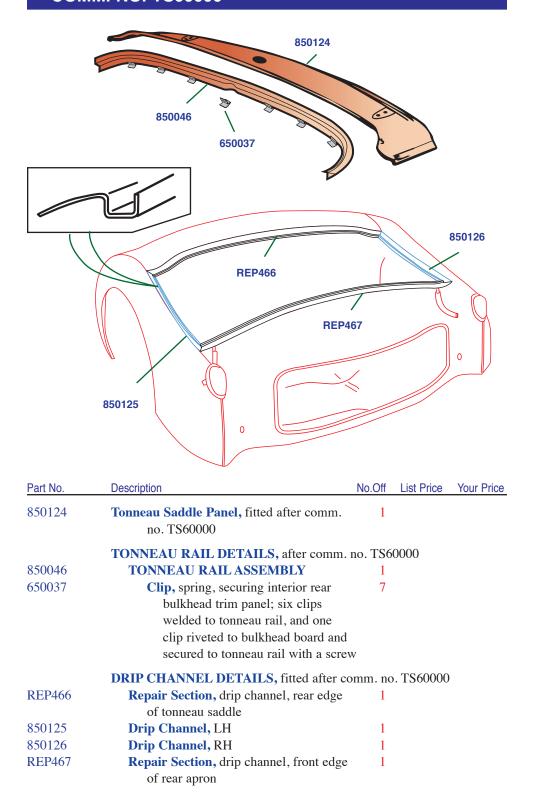


Part No.	Description	NO.OII	LIST Price Your Price
	REAR BODY DETAILS, after comm.		
	no. TS60000		
850117/BP	Rear Floor Assembly, with drive shaft	1	
	tunnel		
803767	Trunk Floor Assembly	1	
850051	Wheel Arch, LH	1	
901647	TRUNK SIDE, LH; includes lower portion	1	
	to bottom of rear apron		
800639	Repair Section, closing panel, rear	1	
	apron, LH		
850052	Wheel Arch, RH	1	
901648	TRUNK SIDE, RH; includes lower portion	1	
	to bottom of rear apron		
800640	Repair Section, closing panel, rear	1	
	apron, RH		
950046	Container, spare wheel	1	
901299/BP	REAR APRON , outer panel, with separate	1	
	signal lamp pressings		
ACP1	Repair Panel, rear apron bottom flange	1	
REP451	Repair Panel, rear apron bottom section	1	
900402/BP	Rail, back bottom	1	
850054	Panel, closing, rear apron, front, LH	1	Use 900421
850055	Panel, closing, rear apron, front, RH	1	Use 900422
900419	Bracket, body mounting, LH	1	
900420	Bracket, body mounting, RH	1	
CN1/CAGE	Cage, for captive nuts	A/R	
CN1/NUT	Nut, in cage	A/R	
602150	Clip, wiring harness, welded to panels	A/R	Suggest 603559

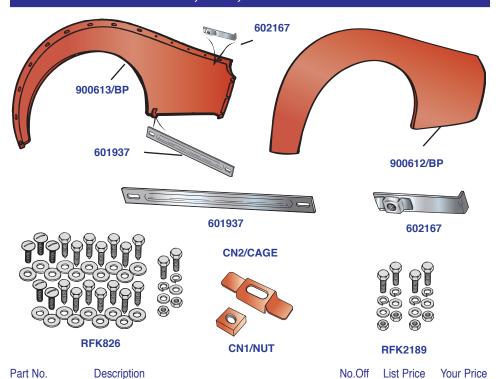
BODY SHELL—TONNEAU SADDLE AND DRIP CHANNELS, TR2, TR3, TR3A MODELS, UP TO COMM. NO. TS60000



BODY SHELL—TONNEAU SADDLE AND DRIP CHANNELS, TR3A, TR3B MODELS, AFTER COMM. NO. TS60000



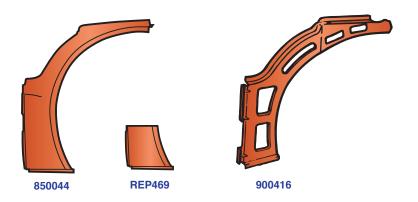
BODY SHELL—REAR WINGS (FENDERS), REAR QUARTER PANELS, TR2, TR3



	DEAD EENDEDS (WINCS), availant		
	REAR FENDERS (WINGS); excellent quality, manufactured on new tooling		
900612/BP	Rear Fender, steel replica, LH	1	
900612/AL	Rear Fender, light weight alloy, LH	1	
900613/BP	Rear Fender, steel replica, RH	1	
900613/AL	Rear Fender, light weight alloy, RH	1	
	HARDWARE, mounting rear fenders		
RFK826	HARDWARE KIT, mounting rear	2	
	fenders, including hardware for		
	support stays (forty-six pieces)		
552433	Bolt , slotted mushroom head	10	
HU706P	Screw, set, hex head	28	
WM57	Washer, body	38	
HU705	Screw, set, hex head, securing stays	4	
WP23	Washer, plain, on screws	4	
WL207	Washer, lock, on screws	4	
HN2007	Nut, hex, on screws	4	
602167	Plate, clamping, not included in kit	2	
CN2/CAGE	Cage, nut, welded to fenders	5	
CN1/NUT	Nut, in cage	5	
601937	Stay, supporting fenders to chassis	2	
RFK2189	Hardware Kit, securing support stays	1	
	(sixteen pieces)		

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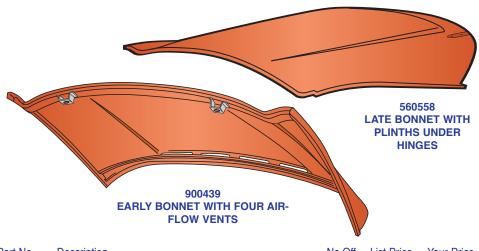
BODY SHELL—REAR WINGS (FENDERS), REAR QUARTER PANELS, TR2, TR3—Continued



Part No.	Description	No.Off	List Price	Your Price
	OUTER REAR QUARTER PANELS;			
	excellent quality, manufactured on new			
	tooling			
850043	Panel, quarter, outer, LH, steel	1		
REP468	Repair Panel, rear quarter panel, lower	1		
	portion, LH			
850044	Panel, quarter, outer, RH, steel	1		
REP469	Repair Panel, rear quarter panel, lower	1		
	portion, RH			
	INNER REAR QUARTER PANELS			
900415	Panel, quarter lining, LH, fitted up to	1		
	comm. no. TS60000			
950035	Panel, quarter lining, LH, fitted after	1		
	comm. no. TS60000			
900416	Panel, quarter lining, RH, fitted up to	1		
	comm. no. TS60000			
950036	Panel, quarter lining, RH, fitted after	1		
	comm. no. TS60000			

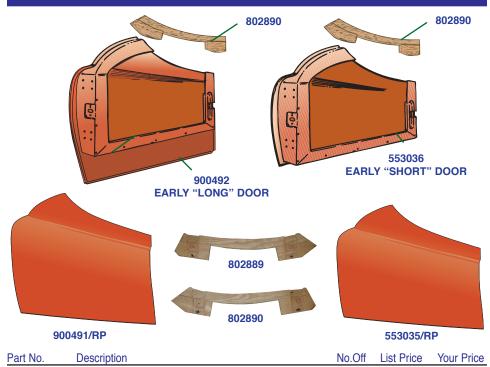
BONNETS, DOORS, TRUNK LIDS, TR2, TR3B

These listings are rather complicated in some respects, as the spare parts catalogue indicates certain nominal change points, but in actual practice on the assembly line, changes may have overlapped with existing practice so that cars with lower commission numbers may have included the change while cars after the change point may have had the earlier fitment. Also, changes may have happened to a part without actually changing the part number. An example seems to be the early TR2 bonnet in aluminium which carried the same part number as the steel version fitted later.



	EARLY BONNET WITH FOUR AIR- FLOW VENTS			
Part No.	Description	No.Off	List Price	Your Price
	BONNETS—Mr. Piggott identifies seven bonnet			
	variations, but there are only four Triumph part			
	numbers in the spare parts catalogue			
900439	Bonnet Assembly, utilizing twin cable-	1		
	operated latches, fitted from comm. no. TS1			
	up to TS4228, material was aluminium up			
	to around TS580 and steel thereafter, include	d		
	four air-flow slots on ridge across rear			
900666	Bonnet Assembly, latches utilizing Dzus	1		
	fasteners, fitted from comm. TS4229 up to			
	TS6157, material is steel, included four air-fl	low		
	slots on ridge across rear; some may have be	en		
	fitted with two rivets at rear edge			
900705	Bonnet Assembly, Dzus latching, fitted from	1		
	comm. no. TS6158 up to TS22530, material			
	is steel, included only two air-flow slots on			
	ridge across rear, rear edge included a flange			
901272	Bonnet Assembly, Dzus latching, fitted from	1		
	comm. no. TS22531 up to TS60000, materia	l		
	is steel, two air-flow slots, flange removed			
	from rear edge			
560558	Bonnet Assembly, Dzus latching, fitted after	1		
	comm. no. TS60000, material is steel, two			
	air-flow slots, "plinth" pressings added under	r		
	hinges to match corresponding plinths on the	body		
		Co	ntinued on	Next Page

BONNETS, DOORS, TRUNK LIDS, TR2, TR3B -Continued



DOORS—Full length doors were fitted to the earliest TR2 models, but shortened after comm. no. TS4001 to allow easier parking on streets with kerbs; earlier doors did not have outside handles, later ones did; brass hinges were fitted earlier and steel ones to the latest models; door skins may be used to repair many doors with rust repair or other damage

DOORS, long-door type, fitted from comm. no. TS1 up to TS4001, no outside door handles, use brass hinges

900491	DOOR ASSEMBLY, LH	1
900491/RP	Repair Panel, door skin, LH	1
802889	Door Top Rail, LH door, wooden part;	1
	includes side curtain mounting blocks	
900492	DOOR ASSEMBLY, RH	1
900492/RP	Repair Panel, door skin, RH	1
802890	Door Top Rail, RH door, wooden part;	1
	includes side curtain mounting blocks	
	DOODS short door type fitted from commune	TC400

boors, short-door type, fitted from comm. no. TS4002 up to TS22014, no outside door handles, use brass hinges

boor Assembly, LH

Repair Panel, door skin, LH

Door Top Rail, LH door, wooden part; includes side curtain mounting blocks

553036 DOOR ASSEMBLY, RH 1 553036/RP Repair Panel, door skin, RH 1

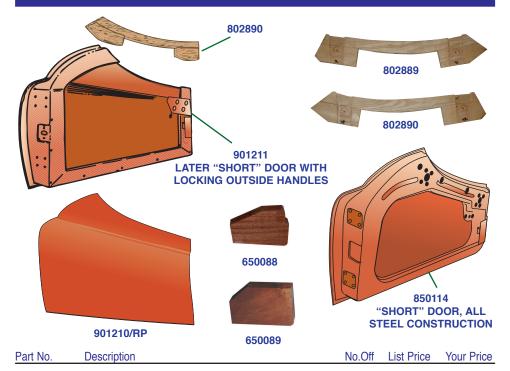
802890 **Door Top Rail,** RH door, wooden part; includes side curtain mounting blocks

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650089

BODY SHEET METAL COMPONENTS

BONNETS, DOORS, TRUNK LIDS, TR2, TR3B -Continued



DOORS—Continued

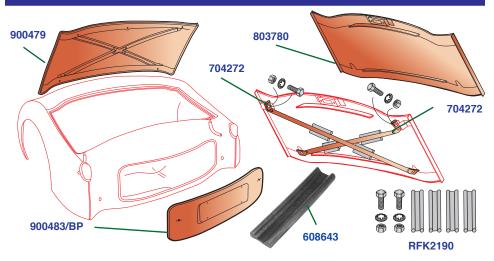
DOORS, short-door type, fitted from comm. no. TS22014 up to TS60000, locking outside handles fitted, brass hinges were used with these doors up to body no. EB54335

901210	DOOR ASSEMBLY, LH	1
901210/RP	Repair Panel, door skin, LH	1
802889	Door Top Rail, LH door, wooden part;	1
	includes side curtain mounting blocks	
901211	DOOR ASSEMBLY, RH	1
901211/RP	Repair Panel, door skin, RH	1
802890	Door Top Rail, RH door, wooden part;	1
	includes side curtain mounting blocks	
	DOORS , short-door type, fitted after comm. no.	
	TS60000, locking outside handles fitted, steel	
	hinges were used with these doors; doors were	
	all-steel construction without wood top rail;	
	wood mounting blocks for side curtains	
	remained, rounded, rather than right-angled	
	lower rear corner on inside frames	
850113	DOOR ASSEMBLY, LH	1
850114	DOOR ASSEMBLY, RH	1
901210/RP	Repair Panel, LH	1
901211/RP	Repair Panel, RH	1
650088	Block, wood, side curtain mount, front	2

Continued on Next Page

Block, wood, side curtain mount, rear

BONNETS, DOORS, TRUNK LIDS, TR2, TR3B -Continued



Part No. Description No.Off

List Price Your Price

TRUNK LIDS; aka "Boot Lids,"—Earlier trunk lids were assemblies with the reinforcements welded to the skins; a simpler design appeared at comm. no. TS60000, with bolted tubes taking the place of the welded reinforcements

900479 **Trunk Lid Assembly,** fitted from comm. no. TS1 up to TS22014 (TS23920); this type is secured with budget locks covered with flip-up escutcheons and operated with the T-handle Coach Key; a central surface-mounted key lock is also fitted for security

802637 **Trunk Lid Assembly,** fitted from comm. no.
TS22014 (TS23920) up to TS60000; budget
locks and key lock deleted in favour of a
locking handle assembly

TRUNK LID ASSEMBLY, fitted after comm. no. TS60000

	THE THE PROSERVED TO THE COMMITTEE C	. 150000
803780	Trunk Lid Skin Assembly, with hinge plinth	1
	pressing	
704272	Tube, reinforcement, LH	1
704272	Tube, reinforcement, RH	1
RFK2190	FITTING KIT, securing tubes to angles	1
	welded to rear of trunk lid skin (front	
	mountings are to trunk hinge studs); ten	
	pieces including rubber packings	
HU705	Screw, set, hex head	2
WE607	Washer, shakeproof	2
HN2007	Nut, hex	2
608643	Packing, rubber, anti-rattle, cemented	4
	to trunk lid skin	

SPARE WHEEL (TIRE) LIDS; these were manufactured in aluminium up to about comm. no. TS580, and in steel thereafter, apparently under the same part number

900483/BP Spare Wheel Lid Assembly, steel replica 1

NEW RANGE OF INNER AND OUTER PANELS

Over the past couple of years a European source has begun to produce a new range of popular inner and outer panels with the goal of reaching the standard of original Triumph parts or better. We have listed these among the other listings in the sections of this chapter. Generally, we add the suffix "BP" to the part numbers of these components. We have included photos of these better panels on this page. All of them come well-packaged and presented in high-quality primer. Generally we will try to maintain stocks of these, and they are supplied fairly quickly even when we run out.

