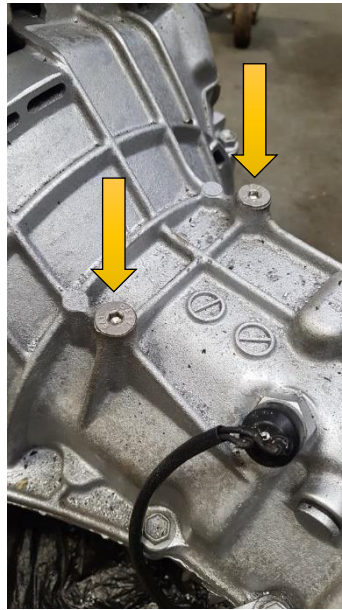


## R7ME FITTING KIT

Read thoroughly prior to assembly. This document provides a guide to prepare a Suzuki R7ME gearbox for use in an MG Midget or Austin Healey Sprite using a Barratt Engineering conversion kit.

### CLEARANCE BOLTS




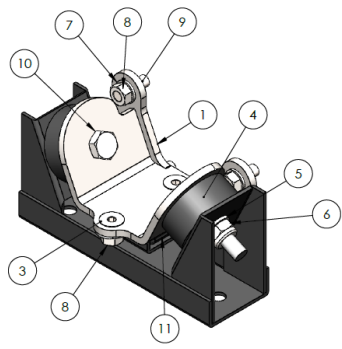
**FIGURE 1: COUNTERSUNK SCREWS**

2x countersunk screws are necessary to get clearance between the transmission and the heater tray during installation.

1. Remove 2x M8 bolts from the top of the casing.
2. Countersink the holes using a 90 degree countersink in a drill.
3. Remove swarf from the holes. Note the holes are blind so debris will not enter the transmission.
4. Fit 2x M8x120 countersunk screws (00188). Tighten to 23Nm.

**INSTALLING MOUNT**

		REV	DESCRIPTION	BY	DATE
		1	INITIAL RELEASE	JCCB	15/02/2022

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	00158	GEARBOX MOUNTING BRACKET ASSY	1
2	00088	BOLT, COUNTERSUNK, M8X20, DIN7991, A4-80	2
3	00235	BOLT, COUNTERSUNK, M8X16, DIN7991, A4-80	2
4	00084	AV Mount	2
5	00055	WASHER, PLAIN, M10, DIN125A	2
6	00057	NUT, NYLOC, M10, DIN985	2
7	00053	WASHER, PLAIN, M8, DIN125A	4
8	00054	NUT, HEX, M8, DIN934	4
9	00183	STUD, M8X25, DIN976-1, A4	2
10	00184	BOLT, HEX HEAD, M10X12, DIN933, A4-80	2
11	00185	2A5420 GEARBOX STEADY BUSH	1
12	00188	BOLT, COUNTERSUNK, M8X120, DIN7991, A4	2
13	00241	51MM RUBBER BLANK	1
14	2A5552	CROSSMEMBER MOUNTING BRACKET	1

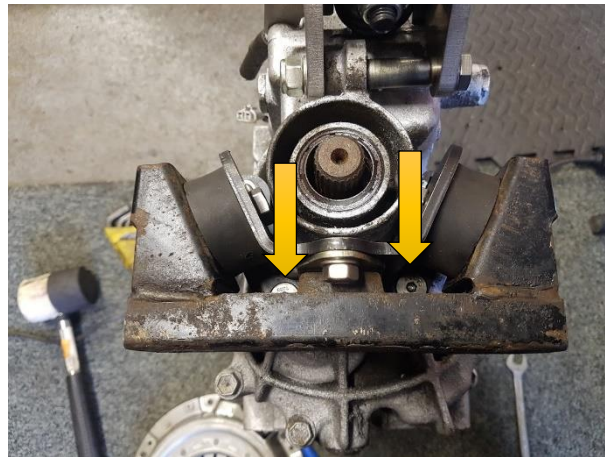
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS ANGLES ARE IN DEGREES TOLERANCES FINISHES MATERIALS SURFACE TREATMENTS DO NOT SCALE FROM DRAWINGS DEBURR AND BREAK SHARP EDGES -R IN LOCUST- ASSE-	PART NUMBER	00176
	DESCRIPTION	R7ME REAR MOUNT KIT
	MATERIAL	SEE PARTS
	SCALE	1:2

1. Fit 2x M8x25 studs (00183) with Loctite or thread lock. Fit with 13mm protrusion and allow thread lock to cure.
2. Trial fit Gearbox Mounting Bracket (00158) to the gearbox. In some cases it may be necessary to remove some material from the web under the propshaft shroud. See **Error! Reference source not found.**



**FIGURE 2: MATERIAL MAY NEED TO BE REMOVED TO CLEAR MOUNTING BRACKET**

3. Fit 2x rubber mounts to the crossmember mounting bracket (2A5420, not included – original BMC part to be reused or sourced). In some instances the holes may require opening to 10mm.
4. Assemble as per drawing above. Ensure the crossmember mounting bracket is fitted the correct way round.
5. It is advisable to use thread lock as an extra precaution on these components as they are not accessible after the gearbox is fitted.
6. Fitting the 2x M8x20 (00088) lower mounting screws is made easier with the gearbox laid on its front, as per the image below.

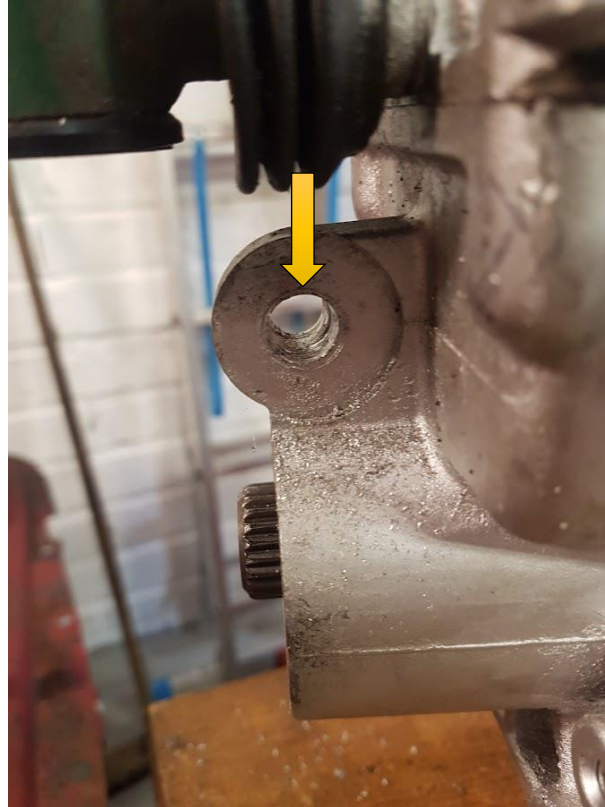


**FIGURE 3: CROSSMEMBER MOUNTING BRACKET**

## GEAR SHIFT MECHANISM

The Barratt Engineering Gear Shift Mechanism replaces the original Suzuki assembly to relocate the gearstick to the correct position for the Midget or Sprite.

1. Remove the Suzuki assembly including universal joint.
2. Open the lower mounting hole up to 11mm.



3. Remove the 2x rear screws from the casing, shown below, and fit the Gearshift Bracket with the 2x M8 screws and washers supplied. Do not tighten at this stage.
4. Fit the nylon spacer between the Gearshift Bracket with the M10 bolt and nyloc nut.

## OIL FILL HOLE

The transmission tunnel must be drilled to provide access for the oil fill plug.

A 50mm holesaw should be used. After drilling the hole should be deburred and the exposed steel painted to prevent corrosion. The hole can be capped with the rubber bung provided.



**FIGURE 4: OIL FILL HOLE**