

Patton Machine, July 2017
Triumph Trailing Arm 3/8" Stud Conversion Jig Instructions
For illustrated instructions see:

<http://www.pattonmachine.com/TAK-Set-Up.htm>

This kit is for direct threading of coarse thread 3/8"-18 studs into stock Triumph railing arms. No thread repair inserts are required. This update can be done without removing the trailing arm from the car although the hub assembly and brake backing plate must be removed. This kit is designed for use with a hand held power drill. Note, the kit contains a jig plate and two guides, the tall one for drilling and the short for tapping. Be sure you have the proper guide set, a 2" long drill guide for a 5/16" drill bit and a shorter tapping guide for a 3/8" tap.

1. Clean the TA casting face before starting the job so the guide plate lays flat.
2. Rotate the guide plate around until it slips down over all six studs and lays flat against the housing. You may have to try the plate in several locations to find the best fit as original studs are not always perfectly aligned. Mark three studs to replace then remove the guide plate. Remove those three studs and reinstall the guide plate.
3. Using the smallest holes in the plate (5/16"), bolt the guide plate on the remaining studs using 5/16" flat washers and 5/16-24 fine thread nuts. Due to very tight tolerances, a drop of oil will allow the steel guides to slip easily into the base plate.
4. Wear gloves and eye protection as small aluminum chips will be flying.
5. When drilling or tapping, hold the guide insert firmly against the plate. Use a quality lube like Tap Magic for aluminum for drilling and tapping. Use caution when drilling not to go too deep.
6. Drill and Tap all three of the stud holes before moving the guide plate.
7. Screw the three new 3/8" studs leaving them finger tight.
8. Repeat steps 4 – 8 using the 3/8" holes in the jig plate.
9. Remount the brakes and axle hubs and tighten the nuts to the torque specified for your car.
10. Before storing the tool steel guides coat them with oil or grease to prevent rust and corrosion.