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Dear John,

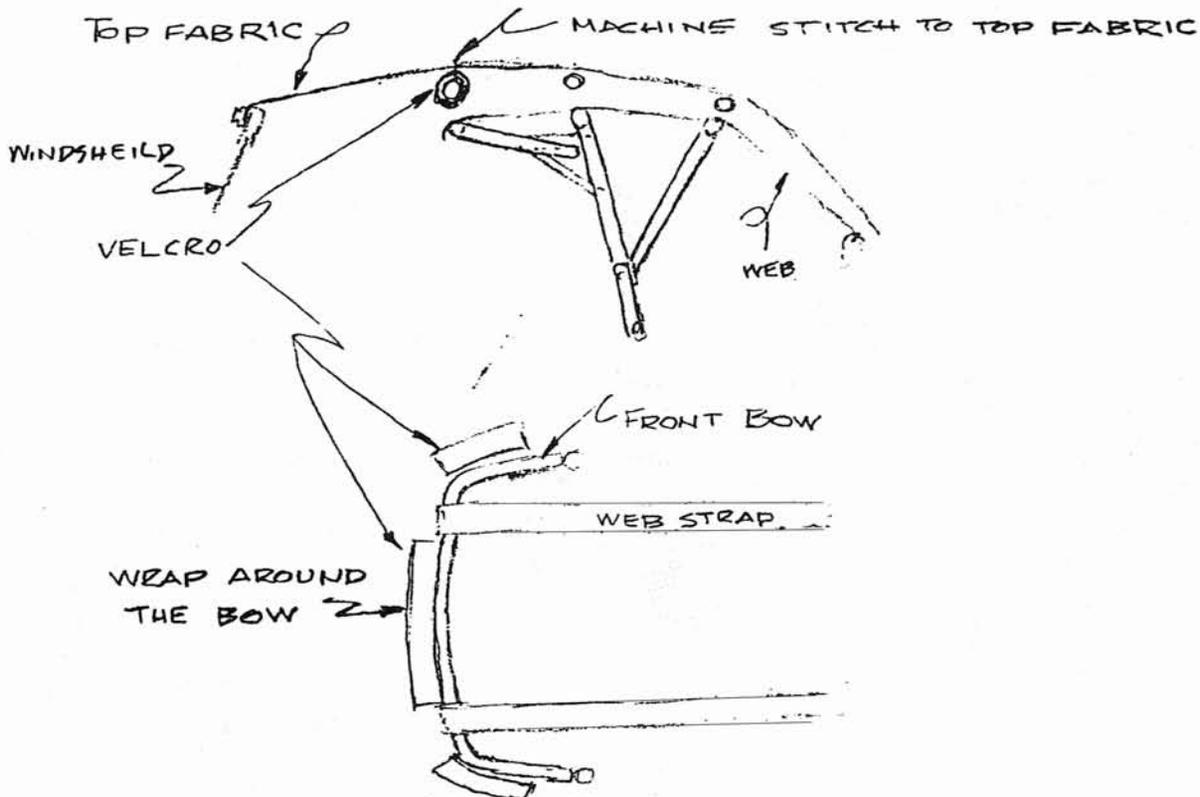
The TR3 top has always been an annoyance with its penchant for ballooning up away from the front top bow. That takes all the pressure off the front bow and it can rattle its little head off, besides the stretching of the top fabric does not promote long life.

About six years ago I had my upholstery friend stitch lengths of VELCRO strips across the under side of the top and when up and fastened it very effectively prevents the ballooning and maintains pressure on the bow and stops the rattling. The sketch shows the detail of the fix.

Bob Schaller
20 June 1994

TR 2-3 ANTI-BALLOON FIX

BOB SCHALLER





Occasional Seat TR3A Pre 60,000

OCCASIONAL SEAT

The accessories section of STANDARD TRIUMPH MOTOR COMPANY TR 2-3 SPARE PARTS CATALOG lists such options as heater, rear wheel cover kit (fender skirts), fitted suitcase and occasional seat. Now that the TR 3 is near 40 years old, the occasional seat like some of the other options that were offered are desired by many because they are somewhat unique, improve the appearance of the car, and are functional. The occasional seat is appreciated most by passengers who are less than 3 feet, 6 inches tall, otherwise, they are a little cramped. They do, however, improve the appearance of the interior, especially on the pre TS-60000 cars with the slant rear floor. The wider gas tanks used on TR 2 models prevented the use of a rear seat, but they were available for all TR 3 thru TR 3B models.

There are three different types used: The TR 3 (TS 8637 to TS 22013), which had a paper board front gas tank casing (cover), consisted of a cushion board to sit on and a squab board to protect the not so stiff paperboard gas tank cover. The TR 3A pre TS-60000 had a different set of mounting brackets and used only a cushion board. The upholstered front gas tank casing, which was more rigid than the early cars, served as the squab (back rest). The later bodied TR 3A and the TR3B had a boxed shelf for the rear floor and did not require brackets or a squab. Although many used this later floor style as an occasional set, there was a padded cushion board available to provide some comfort and further reduce head room with the hood (top) in place.

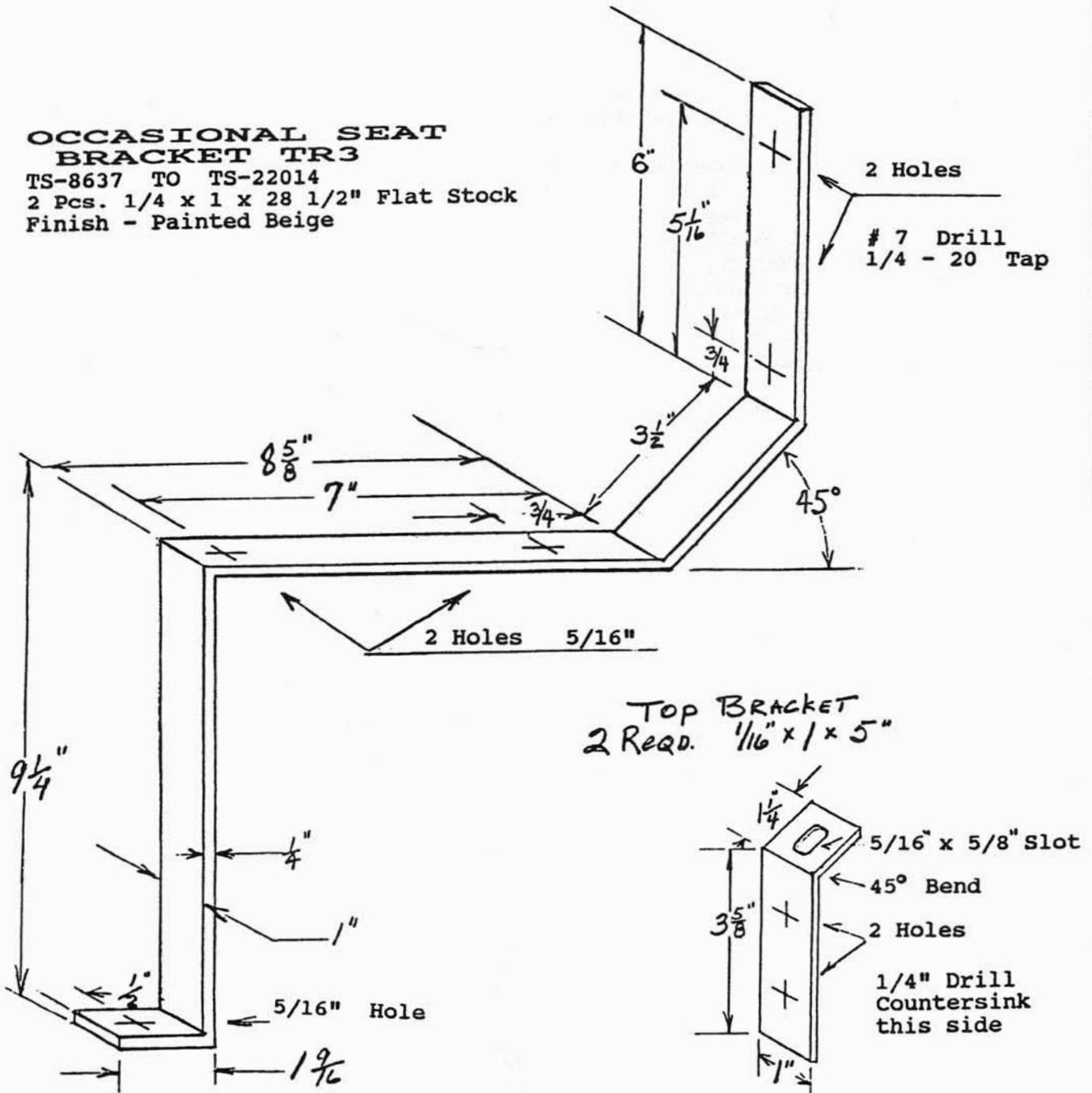
Here are the plans to make an occasional seat for your TR. It will be easy enough to construct with readily available materials. Probably the most difficult task will be finding a vinyl or leather covering to match your existing interior.

Good luck, call if you have any questions and let us know how it turns out.

Joe Richards

**OCCASIONAL SEAT
BRACKET TR3**

TS-8637 TO TS-22014
2 Pcs. 1/4 x 1 x 28 1/2" Flat Stock
Finish - Painted Beige



The 1/4 x 1" flat stock will probably require some heat from a torch to make the bends required. Even then the corners will not be as sharp as the drawing illustrates, and they are not supposed to be.

OCCASIONAL SEAT SQUAB (BACK) TS-8637 TO TS-22014 TR-3

The seat back is constructed of 3/8" plywood, 14" x 33 7/8". this size is slightly larger than is needed but will make construction easier. The 33 7/8" dimension is critical, measure it carefully.

- Step 1. Mark plywood with pencil as shown on illustration "D". Points 1 & 2 are center points for 1 7/8' Radius.
- Step 2. Use a compass or trace the 1 7/8" radius. Drive in a Locating Pin as shown in illustration "E". (Note: 1" finishing nails work well, only drive them in about half way so that they hold the yardstick secure and are easy to remove). Take a flexible yardstick, place the 18" mark on the locating pin and bow both ends (similar to a kite stick) to blend with the corner Radius on both corners. With a helper trace along the inside edge to meet both rounded corners. THIS WILL NOT BE EXACT, but will be close enough to freehand a graceful top edge.
- Step 3. Layout and drill the 4 - 1/8" holes (illus. E). These are pilot holes for 4 flat head wood screws to fasten the upper bracket to squab.
- Step 4. Layout and drill the 4 - 1/4" holes (illus. E). Now countersink these holes to accept a 1/4" - 20 flat head machine screw.
- Step 5. Layout the 3/8" Radius on lower corners to avoid ripping cover material when installed. (Drawing a 3/8" Radius on plywood is better done by using a copper Penny and tracing around it.
- Step 6. Cut out squab with a jig saw or whatever else you may have. Sand rough edges and paint both sides flat black.
- Step 7. Fasten Squab board to iron brackets using 4 flat head 1/4"x20 screws. The iron brackets will be on the upholstered side of the board.
- Step 8. Spot cement a 2" foam cushion cut to size to the board, and install vinyl or leather seat cover with tacks or staples. Iron brackets are installed to board before padding and cover is installed. You must upholster around iron brackets. Install the 2 upper brackets with appropriate flat head wood screws.

OCCASIONAL SEAT SQUAB

TS-8637 TO TS-22014 TR 3

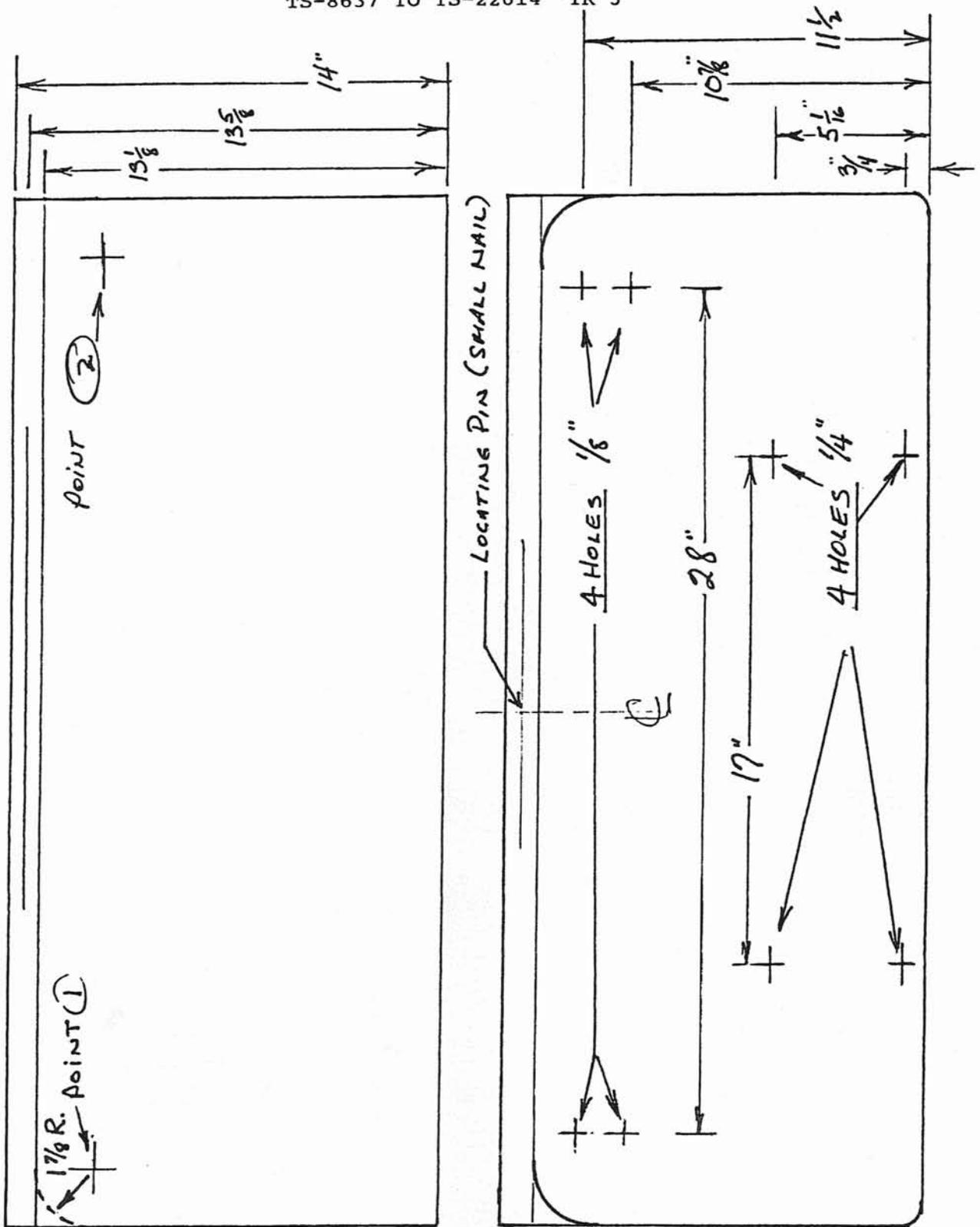
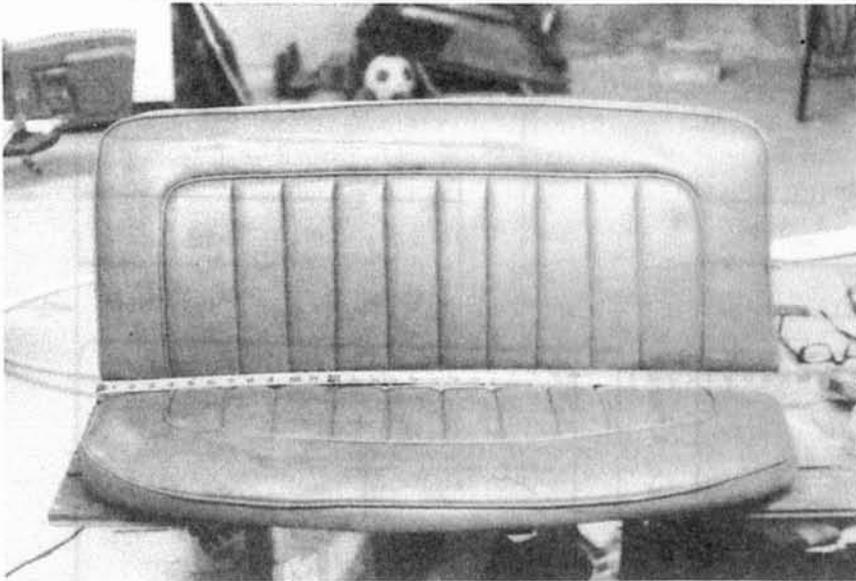
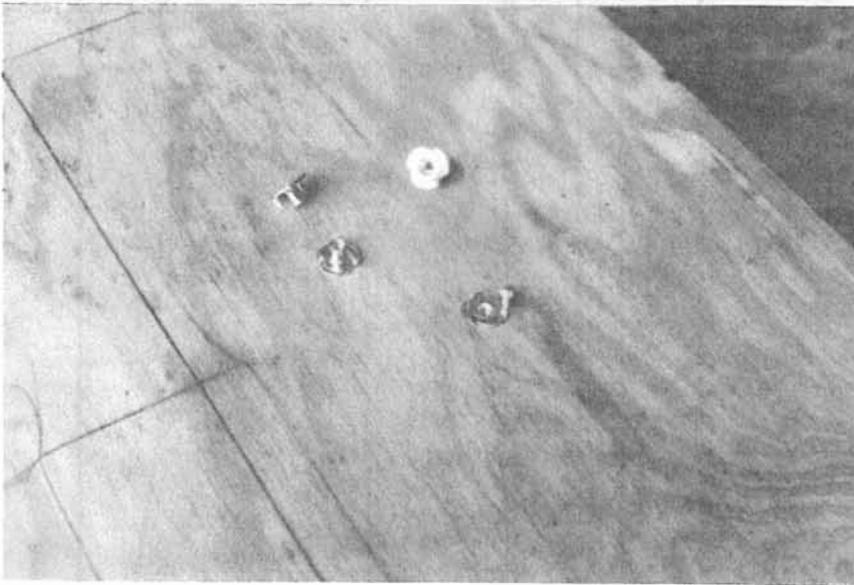


ILLUSTRATION D

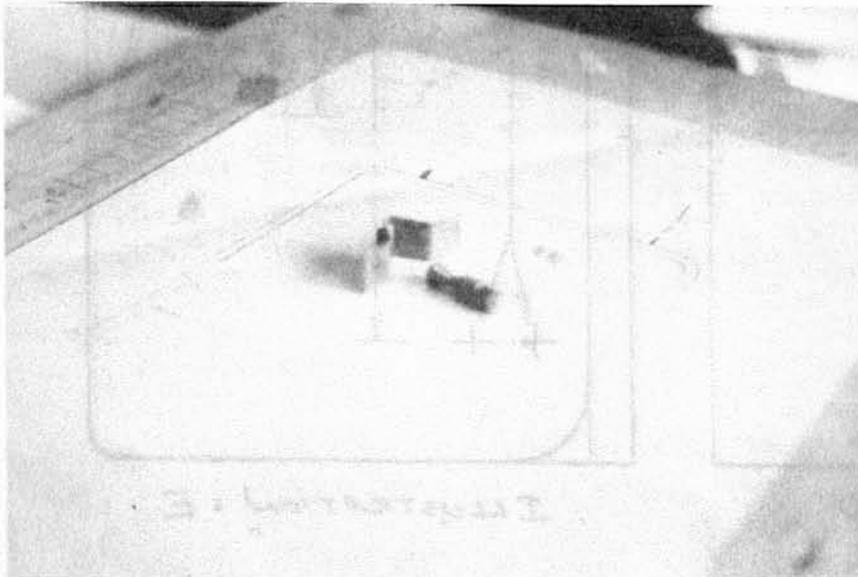
ILLUSTRATION E



TR3 rear occasional seat with squab.



Tee nuts should be secured with small screw before covering.



Clips used to hold TR3A 60,000 + seat from sliding.

SEAT CUSHION TS-8637 TO TS-60000

The Seat Cushion for TS 8637 through TS 60000 is the same except for the location of the Tee Nuts on the TR3A (See NOTE). Dimensions shown on PATTERN "A" are for TR3. The cushion is constructed of 3/8" plywood, 12" x 34". This size is slightly larger than needed but will make construction easier.

- Step 1. Cut out PATTERN "A" and trace on plywood as shown on illustration "B".
 - Step 2. Locate center of plywood and mark 2-3/8" Radius. This should be 1-1/8" deep and 4" wide as per illus. "B".
 - Step 3. A flexible yardstick will help to complete the pattern for the Cushion board. Drive 3 small nails into the plywood (Note: 1" finishing nails work well, only drive them in about half way so that they hold the yardstick secure and are easy to remove). Bow the yardstick around the 3 nails to complete the pattern for the front edge of the seat. With a helper trace along the inside edge of the yardstick to meet the edges of pattern "A". THIS WON'T BE EXACT, but will be close enough to freehand a graceful front edge.
 - Step 4. Cut out plywood with jig saw or whatever else will work. Be sure to round corners of plywood, (approx. 3/8" Radius), to avoid ripping vinyl or leather cover. Sand rough edges, and paint both sides flat black.
 - Step 5. Illustration "C": Mark location of the 4 TEE NUT holes and drill to appropriate size, probably 3/8". The head of the TEE NUT should be on the upholstered side of the plywood. It is a good idea to place a small screw next to the head to keep them in place after board is covered.
- NOTE:** On the TR3A seat the 3/4" dimension (Seat Cushion Figure "C") should be 3 1/4", and the 7" dimension should be 7 1/2".
- Step 6. Cut 2" foam rubber to fit outline of seat cushion but allow 1 1/2" excess at rear of cushion. When upholstered this will fill the irregular floor surfaces behind seat.



Using yardstick as an adjustable French curve.

Helper marks the cut line.

SEAT CUSHION

TS-8637 TO TS-60000
TR 3 & TR 3A

PATTERN "A"

Pattern "A" is to scale and should be traced or copied carefully. Check height & width dimensions as shown in Fig. "B".
8" width x 9 1/2" height

FIGURE "B"

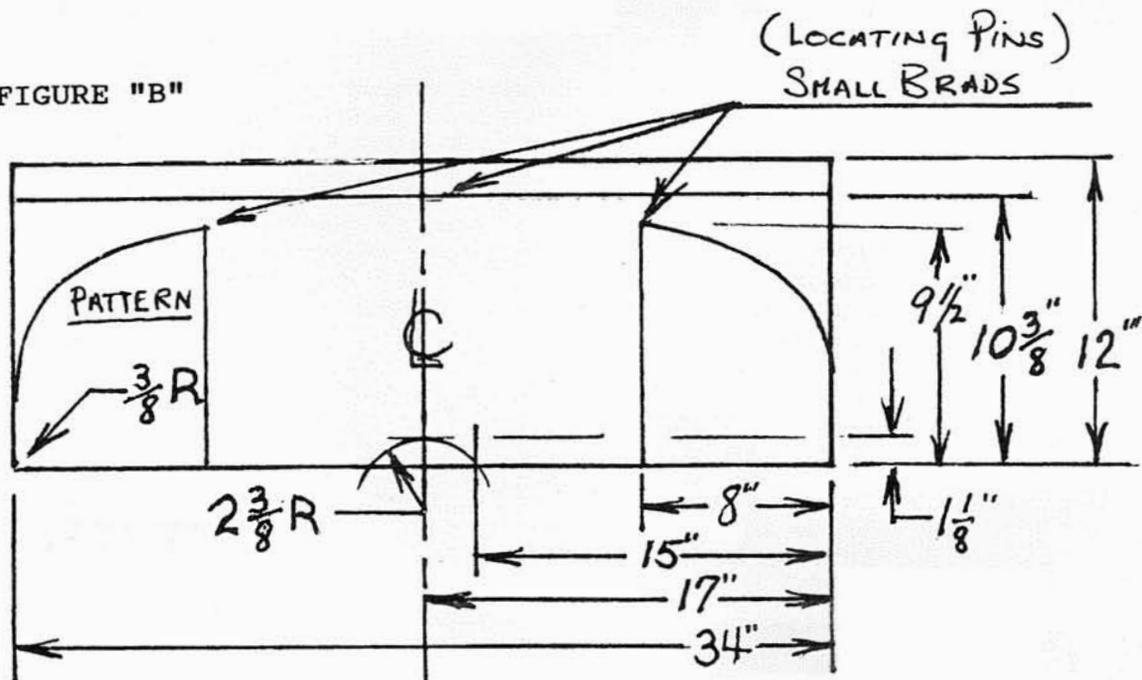
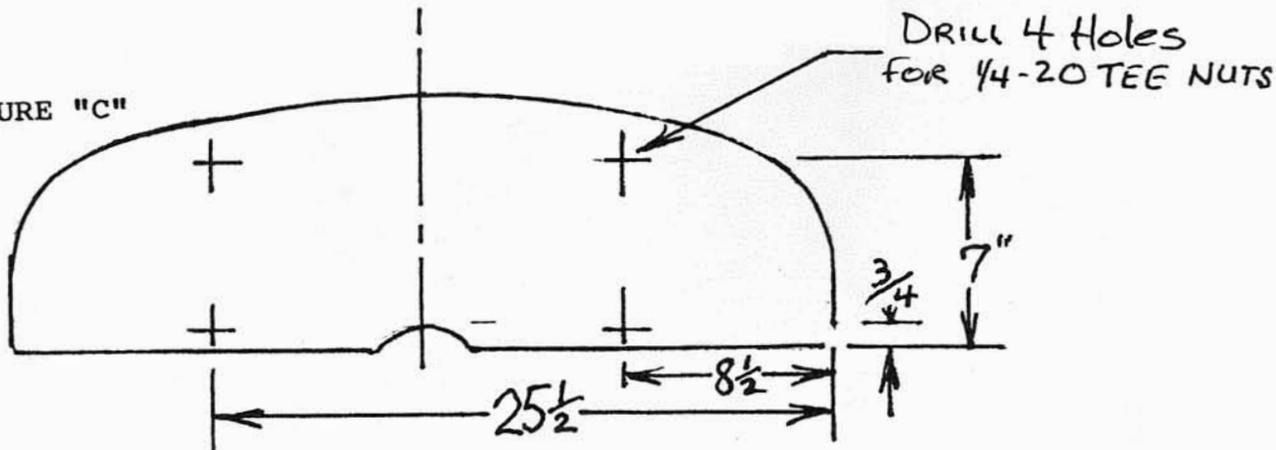
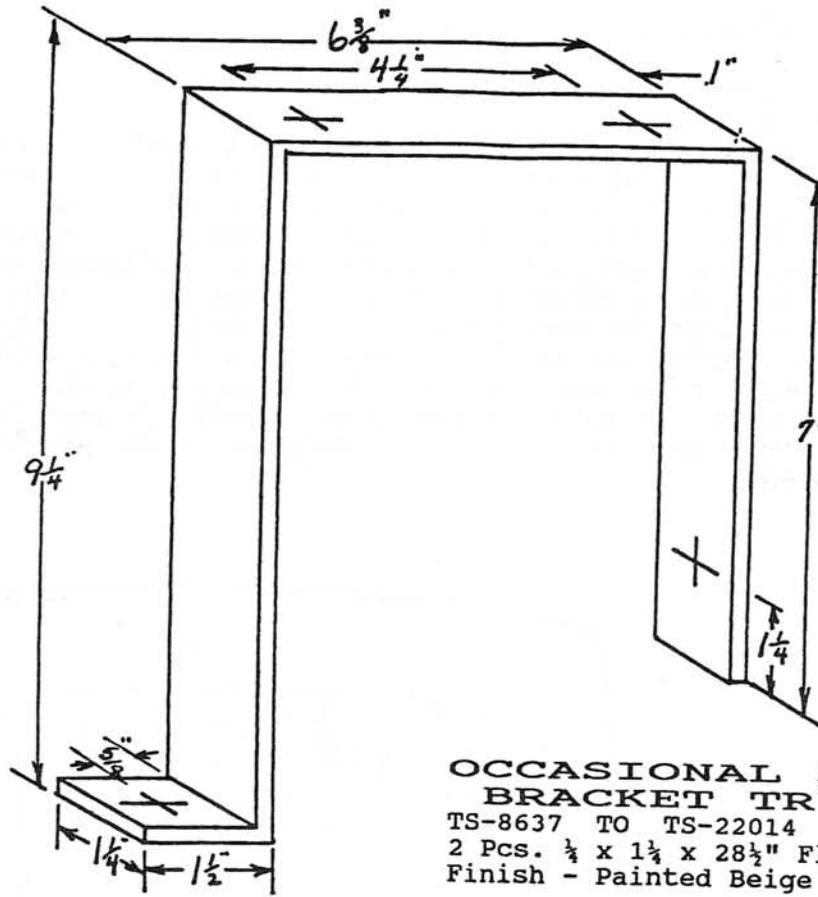


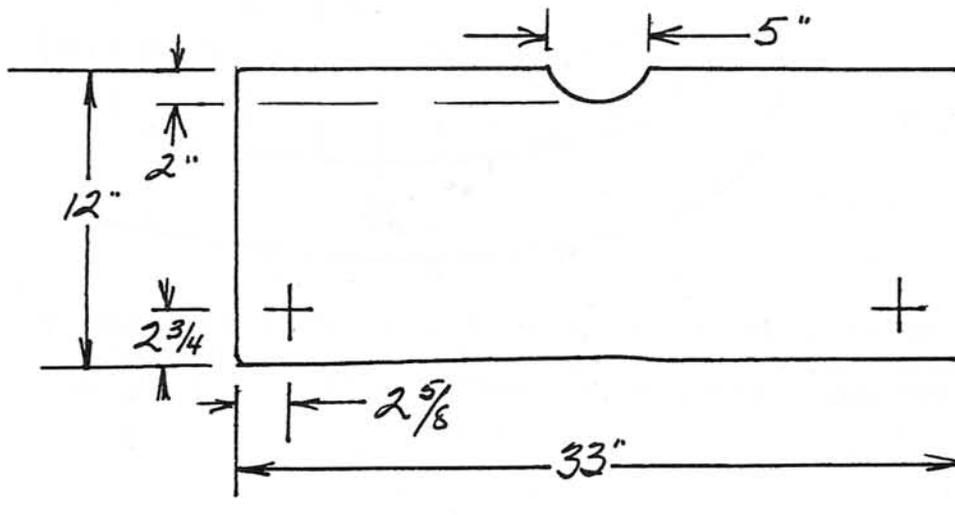
FIGURE "C"





**OCCASIONAL SEAT
BRACKET TR3**
 TS-8637 TO TS-22014
 2 Pcs. $\frac{3}{4}$ " x $1\frac{1}{2}$ " x $28\frac{1}{2}$ " Flat Stock
 Finish - Painted Beige

TR3 A Post TS 60000, TR3 B
 Seat frame is constructed from $\frac{3}{4}$ " plywood 12" x 33". The corners are rounded slightly to prevent the sharp corners from tearing the upholstery fabric. The relief for the floor hump at the rear of the seat is 5" wide and 2" deep. It has 2 - 1" holes bored to receive the spring hold down clamps. A strip of velcro tacked to the bottom of the seat board grips the carpet well enough to hold the seat in place while driving. The Foam rubber pad is cut about an inch oversize on the front and both sides, and 1 1/2" on the rear edge.



SEAT COVERS

Illustrations Not to Scale: Top view of seat and back panels are to show pattern of upholstered covers. Allowances must be made for stitching parts together. End pieces must be wide enough to accommodate the 2" foam padding, stitching, and enough material to tack or staple material to plywood frame. Allowances must also be made for the foam rubber overhang at the rear of the seat. This overhang must not be compressed too tightly when stretching cover over plywood frame as it is necessary to fill the gap between the seat bottom and the back panel. All beading used is 1/8", and the color scheme is the same as the other seats in your model car. All center inserts are "Rolled and Pleated". Edge bands "A & B" are lightly padded.

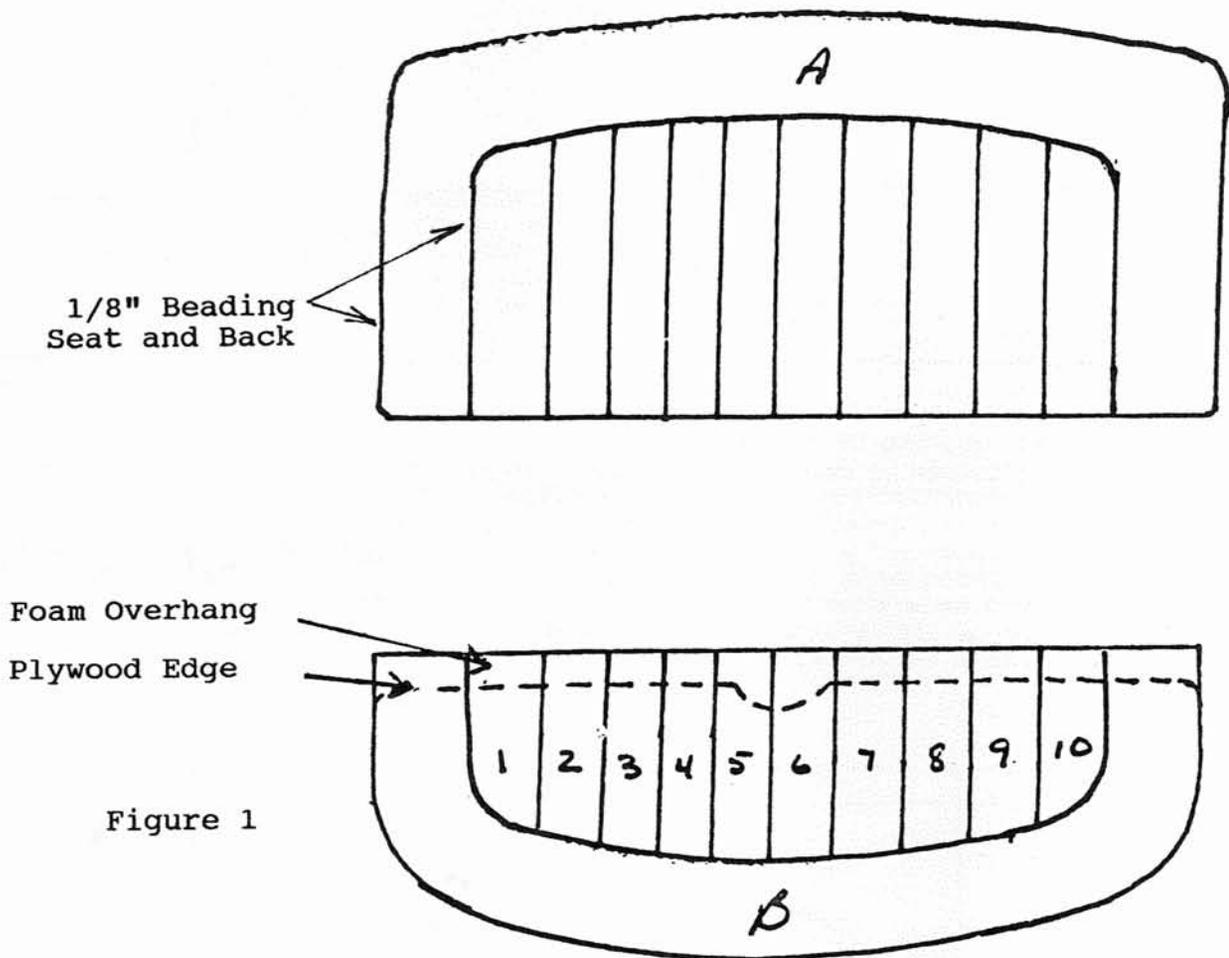


Figure 1 Inserts #1 & #10 are 3" wide when stitched to other panels (finished size). Inserts #2 thru #9 are 2½" wide when finished. The outer band on the seat and back (A & B) is 3½".

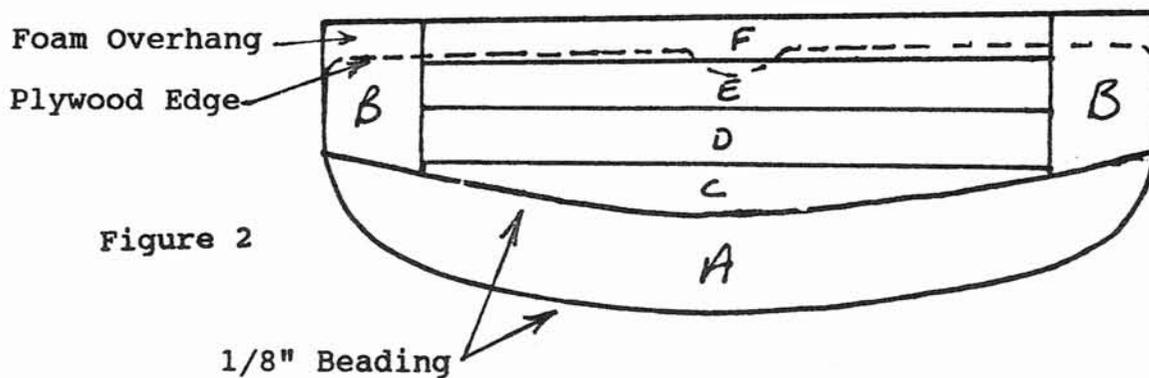


Figure 2 TR 3A to TS60000 Outer bands (A & B) are 3½" finished size and lightly padded. Panels C, D, E & F are Rolled and Pleated. Panels C, D, and E are 2" finished size, and panel F is 5" to allow for the foam overhang. Note The beading through the center of the seat is seat color while beading around the edge is white or contrasting color to match rest of interior, (See Concours and Restoration Guidelines).

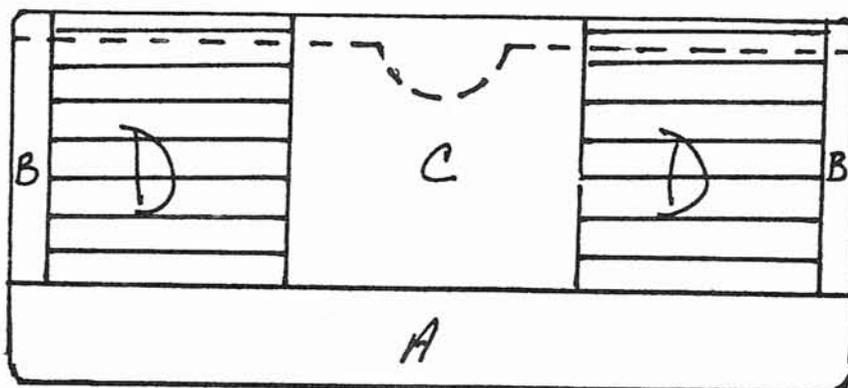


Figure 3 TR3A post TS 60000 Outer band A is 3½"x 35½" when finished. Panels B are 1½"x 12" wide when finished. Panel C is 12"x 12" when finished. Panels D are 10"x 12" and are Rolled and Pleated. Beading through the center of the seat is seat color. Beading around the outer edges may or may not be there. I have 2 occasional seats and both seem to be original and neither seat had beading around the outer edge. Other reliable sources say that there should be beading around the outer edge. If the outer beading is used it should be white.