MANIFOLD FITMENT BULLETIN (C006/B012)

MG used a number of different inlet manifolds of varying thickness throughout production of the MGB and matched this with a cast manifold of equal thickness during assembly. The change in specification tends to apply between 18G and 18V series engines. The 18G series having a slightly thicker inlet and exhaust manifold of 14mm with the 18V series engine having a thinner inlet and exhaust manifold of 11mm. This is only a loose catchall as given the age of MGBs many will have undergone component changes throughout their lives which may have included swapping of the inlet and exhaust manifolds, usefully inlet manifolds were stamped with casting numbers which can help identify whether thick or thin manifolds have been used.

The issue of 'Thin or Thick' inlet manifolds can present a problem with aftermarket MGB three branch manifolds (Mild & Stainless Steel) where the flange material of the exhaust manifold may appear thinner when fitted with thicker 9/16" (14mm) inlet manifolds. This bulletin has been produced to highlight the issue and provide fitting advice should the issue be encountered during fit-up.

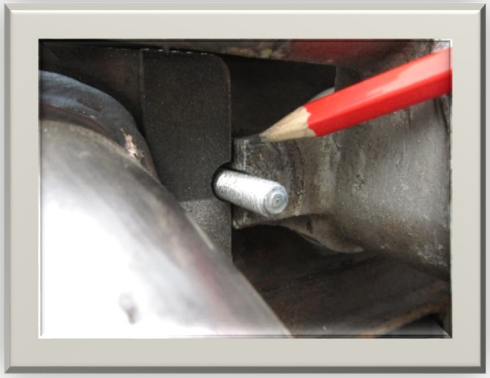

Figure 1- Thick Carburettor Inlet

Figure 2- Manifold washer does not seat

To overcome the issue you may need to use up to six 5/16" i.d x 1 ¼" repair washers (Part Number **GHF315**), cut in half and located on the four inner manifold studs for an even seat. These may be put in a vice and cut in half with a hack saw, then deburred with a file. The amount of half washers required depends upon the exhaust manifold (see installed examples over leaf). Use contact adhesive to help locate the washers in position prior to manifold fit-up. Failure to achieve even clamping pressure across the head may result in rough running and/or blowing of the exhaust. Overtightening of the brass exhaust manifold nuts will cause them to fail also causing the manifold to blow.

Fitting Guide

Figure 3- GHF315 5/16" Repair Washers

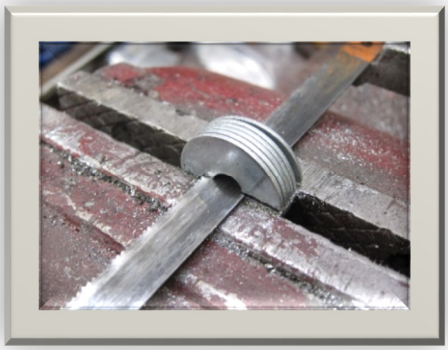

Figure 4- Cut washers (GHF315) in half

Figure 5- Tip, use contact adhesive

Figure 6- Half washers in situ

Installed Examples

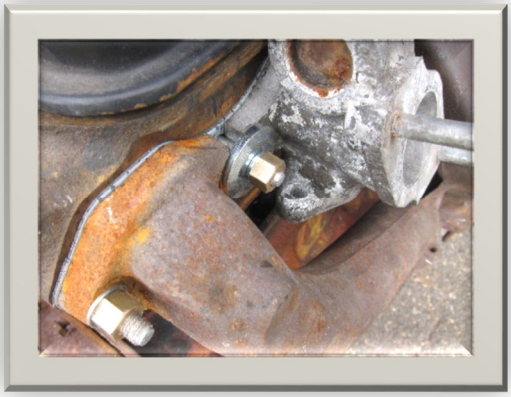

Figure 7- Original cast manifold required 1 spacer

Figure 8- Stainless Manifold required 3 spacers

Figure 9- Mild Steel Manifold required 2 spacers