

## HEADLIGHT MOUNTING CROSSBAR FOR MORGAN SLABBIES

By John Merton

The Morgan slabbies, 4/4's and Plus 4's from 1936 to the early 1950's, had separate headlights, generally mounted on a crossbar in front of the radiator. Sometimes these rust out or otherwise need replacing.

### MAKING A NEW ONE



#### Tools needed:

Vice, one old 1" Morgan king pin, angle grinder with a metal cutting blade, 50 cent coin or large washer, oxy acetylene welding equipment, drill plus 5/8" and 3/8" drill bits, flat file, ruler/measuring tape, ball peine or other hammer, and a punch for marking.

#### Material:

3 ft of 1" steel tube (I prefer 4130 chrome moly tubing which is lovely to work), 1 ft steel bar, one and five eighths inches by quarter of an inch.

#### Method:

Measure the length of the cross bar. The one on my 1936 car was 31". Cut to length. Measure 5/8" in from each end of the flat steel bar and punch a mark for drilling midway between the two sides. Drill 5/8" holes for mounting bolts. Round each end using the coin or washer as a guide and cut to shape with the angle grinder. Mark and cut these two bits of steel off about three and a half inches in from the ends. File everything off smooth. Make up a similar bit for the centre light.

Mark the cross bar for positioning purposes. On my 1936 car the centre of the two outer mounting brackets are about four and a half inches in from the ends. The one for the centre light is halfway. But check all the dimensions as some models may be different (the 1949 4/4 is at the coast where I'm not at the moment so I can't check what it is).

Position the mounting bracket on the cross bar and clamp them together tightly in the vice. The hole in the bracket should protrude downwards about 3" below the bottom of the cross bar. Using the oxy, heat the bracket and tap it around with the hammer (has to be virtually red hot) to the contour of the cross bar tube. Then weld the two together as much as you can (you can finish this off, eg underneath, later). Repeat the process for the other two mounting brackets but make sure the three are aligned. Also determine whether you want the centre bracket facing backward as per the headlights or forward.

Finish the welding and clean it all up. Turn it upside down and mark centrally on the tube under the mounting brackets with the punch. Drill longitudinally out with the 3/8" drill about 3/4" of an inch and file to make a slot. This is to fit the electrical wiring. On my 1936 car they exit on the right.

Lastly, tidy up everything and paint it, inside and out.

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