

CHECKER MOTORS CORP. KALAMAZOO, MICH.

EFFECTIVE MODEL YEAR 1974

MODEL:	B-12 B-12E B-12W	DATE:	6-9-73
DWN.:	J. BAKER	SHEET NO.:	375 B-1
CHK.:	7/2/73	APPROVED:	GA 272416 REF MEMO 1007
APPVD.:	SUPERSEDES	DATE:	10-5-72
		CHANGES:	M1-134 Ws: M1-103

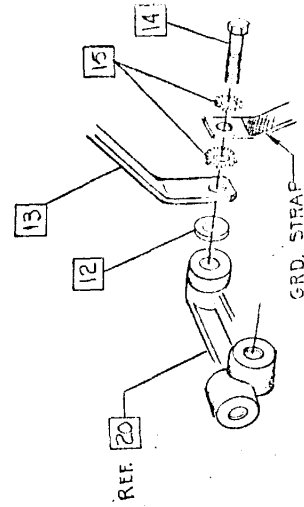
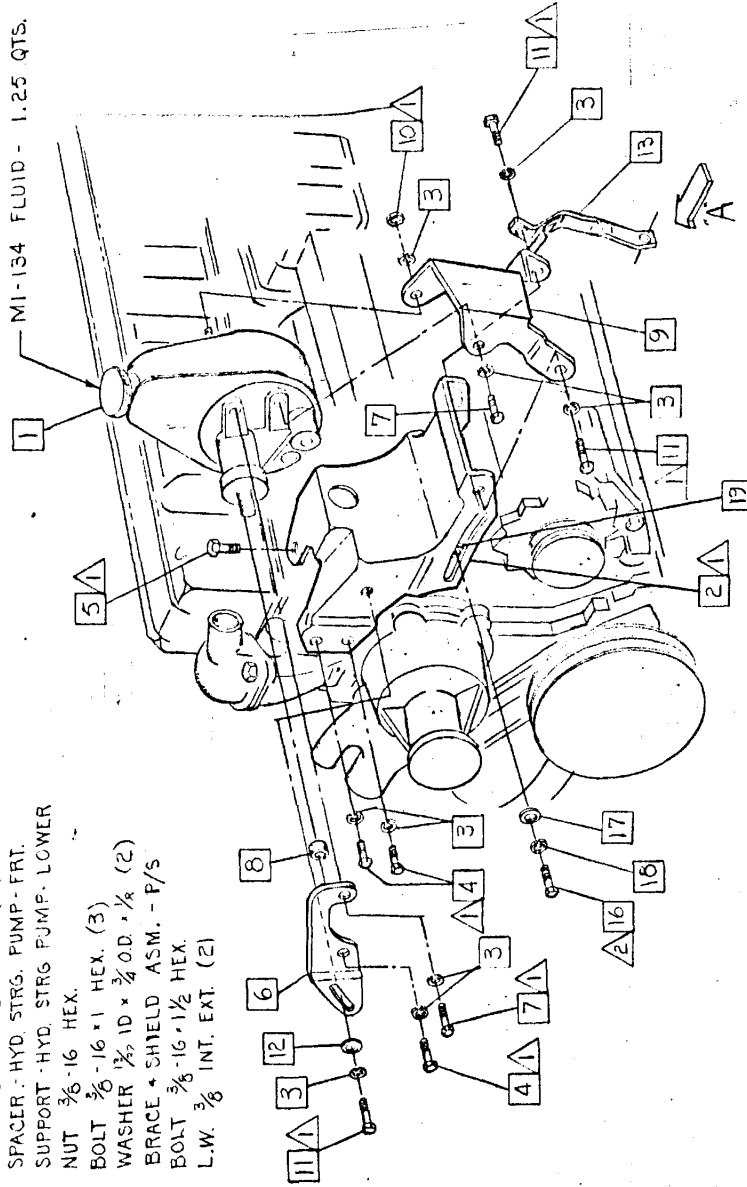
GRAPHIC ILLUSTRATION

STEERING - PUMP MTS - POWER 6 CYL.

- 1. 705165 PUMP ASM. - POWER STEERING
- 2. 703508 BRACKET ASM. - HYD. STRG. PUMP - 6 CYL.
- 3. 120382 L.W. $\frac{3}{8}$ MED. SPRING (9)
- 4. 180123 BOLT $\frac{3}{8}$ -16 x $1\frac{1}{8}$ HEX. (3)
- 5. 702622 BOLT $\frac{3}{8}$ -16 x $\frac{3}{8}$ SPEC. SM. HEX.
- 6. 706466 SUPPORT - HYD. STRG. PUMP FRT. - 6 CYL.
- 7. 180121 BOLT $\frac{3}{8}$ -16 x $\frac{3}{8}$ HEX. (2)
- 8. 706250 SPACER - HYD. STRG. PUMP - FRT.
- 9. 706247 SUPPORT - HYD. STRG. PUMP - LOWER
- 10. 120377 NUT $\frac{3}{8}$ -16 HEX.
- 11. 180122 BOLT $\frac{3}{8}$ -16 x 1 HEX. (3)
- 12. 702262 WASHER $\frac{1}{2}$ -10 x $\frac{3}{4}$ O.D. x $\frac{1}{8}$ (2)
- 13. 705271 BRACE & SHIELD ASM. - P/S
- 14. 180126 BOLT $\frac{3}{8}$ -16 x $1\frac{1}{2}$ HEX.
- 15. 178551 L.W. $\frac{3}{8}$ INT. EXT. (2)

- 16. 180350 BOLT $\frac{5}{16}$ -16 x $1\frac{1}{8}$ HEX.
- 17. 702965 WASHER $\frac{1}{2}$ ID x $\frac{1}{3}$ O.D. x $\frac{1}{8}$
- 18. 120214 L.W. $\frac{3}{8}$ MED. SPRING
- 19. 704854 SPACER - ALT. MTS. UPPER
- 20. 702944 BRACKET - ALT. MTS.

MI-134 FLUID - 1.25 QTS.



▲ 15 - 20 LBS. FT. TORQUE
 ▲ 14 - 22 LBS. FT. TORQUE

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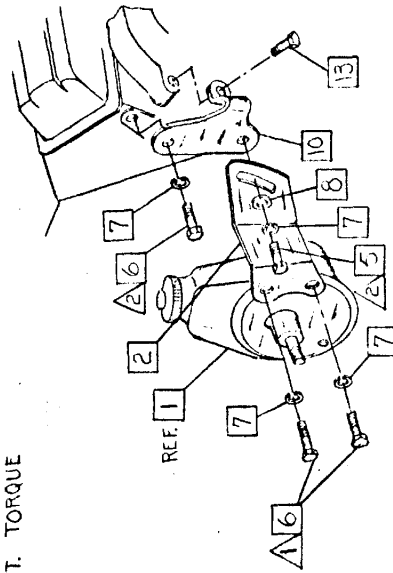
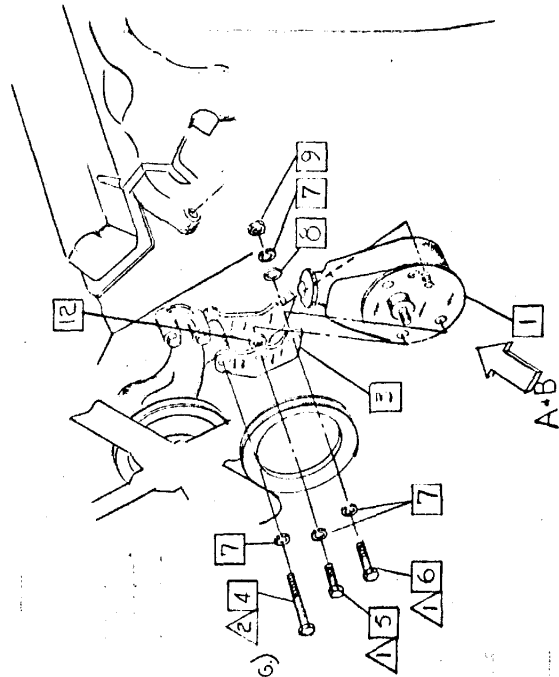
EFFECTIVE MODEL 375 B-2

MODEL:	B-12	DATE	6-8-73
B-11	B-12W	GRAPHIC ILLUSTRATION	
B-11E		STEERING - POWER - PUMP INTG. 8 CYL.	
DWN.	CHK.	APPVD.	CHANGES
			10-5-73 MI-134 Added.

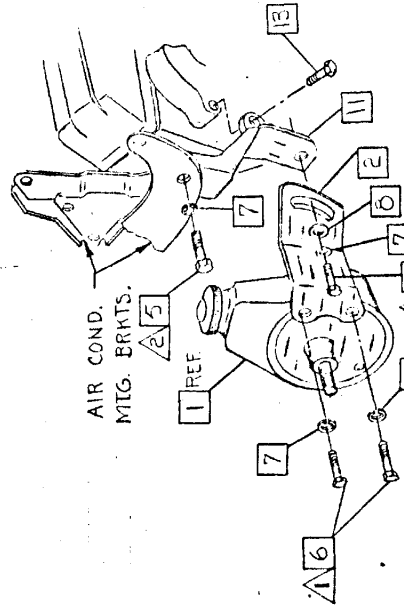
1. 703567 PUMP ASM. - POWER STEERING V-6
2. 704518 BRACKET - HYD. STRG., PUMP.
3. 703411 BRACKET ASM. - HYD. STRG. PUMP.
4. 180135 BOLT $\frac{3}{8}$ -16 x 3 HEX.
5. 180122 BOLT $\frac{3}{8}$ -16 x 1 HEX. (3)
6. 180120 BOLT $\frac{3}{8}$ -16 x $\frac{1}{4}$ HEX. (4)
7. 120352 L.W. $\frac{3}{8}$ MED. SPRING (8)
8. 446363 WASHER $\frac{3}{8}$ ID. x $\frac{3}{8}$ OD. x $\frac{1}{8}$ (2)
9. 120377 NUT $\frac{3}{8}$ -16 HEX.
10. 703965 SUPPORT ASM. - HYD. STRG. PUMP
11. 705138 SUPPORT ASM. - HYD. STRG. PUMP
12. 702171 WASHER - HYD. STRG. PUMP
13. BOLT $\frac{3}{8}$ -16 x 2 $\frac{1}{4}$ HEX. (FURN. WITH ENG.)

MI-134 FLUID 1.25 QTS.

- ▲ 15 - 24 LBS. FT. TORQUE
- ▲ 20 - 30 LBS FT. TORQUE



VIEW IN DIRECTION OF ARROW 'A' WITHOUT AIR COND.



VIEW IN DIRECTION OF ARROW 'B' WITH AIR COND.

CHECKER MOTORS CORP. KALAMAZOO, MICH.

EFFECTIVE MODEL YEAR 1974

MODEL: B-11 B-11E	E-1E B-12E B-12W	DATE 6-8-73	GRAPHIC ILLUSTRATION STEERING - HOSE ROUTING 6 CYL.	DWN. CHK.	SHEET NO. 375 B-3
1. 701191 HOSE ASM. - PRESS. LINE POWER STEERING			APPRVD. C. PEREDES GI 375 A-16 PER VENO 387	DATE	CHANGES
2. 703875 HOSE ASM. - RETURN LINE POWER STEERING				10-24-73	8 CH. LIMITATION REMOVED
3. 702221 CLAMP - 1/2" CLOSED (2)					
4. 120376 NUT 3/16" - 18 HEX.					

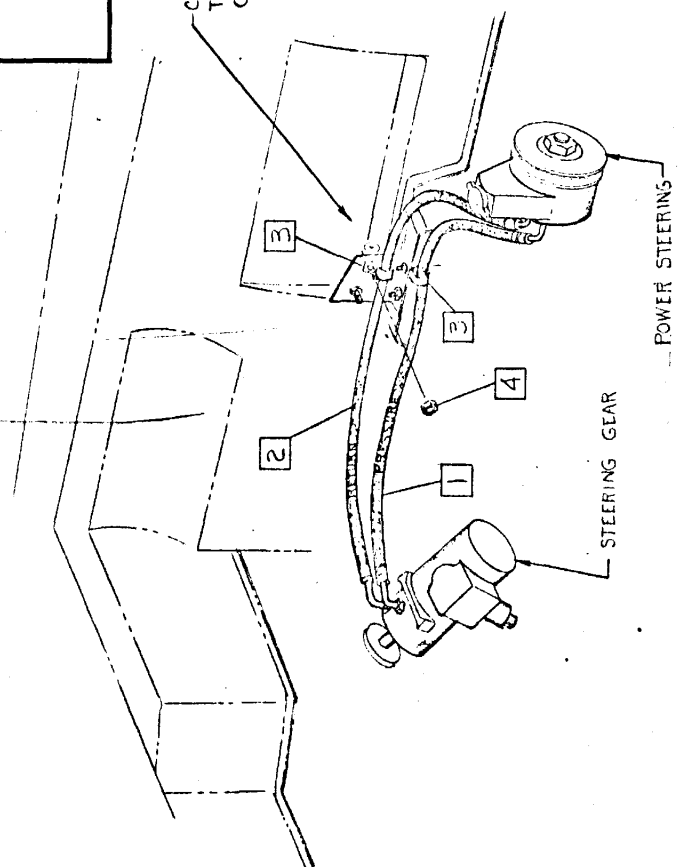
ASSEMBLY RECOMMENDATIONS

HOSE FITTINGS SHOULD BE TIGHTENED TO THE FOLLOWING TORQUE VALUES AFTER THE NUTS & INSERT FLARES HAVE BEEN FIRMLY SEATED.

- ① STEERING GEAR : 20-30 LBS. FT. TORQUE
- ② PUMP : 30-40 LBS. FT. TORQUE

HYDRAULIC STEERING BLEEDING INSTRUCTIONS

1. ATTACH HOSES TO PUMP & GEAR. **CAUTION - DO NOT REMOVE PLASTIC PLUGS FROM GEAR UNTIL IMMEDIATELY PRIOR TO INSTALLATION OF HOSES**
2. FILL PUMP TO WITHIN APPROX. 2.0 INCHES OF TOP OF FILLER NECK PRIOR TO ENGINE START OR PUMP ROTATION.
3. ROTATE PUMP & MAINTAIN 2.0 INCH LEVEL UNTIL NO FOAM OR BUBBLES APPEAR. **CAUTION - DO NOT TURN STEERING WHEEL UNTIL COMPLETION OF STEP 3** SINCE THIS WILL LOAD THE SYSTEM AND BUILD UP OIL PRESS. WHICH WILL DISSOLVE AIR IN THE OIL. IT WILL THEN TAKE 2 OR 3 HOURS TO DEFOAM BEFORE BLEEDING CAN BE COMPLETED.
4. CHECK HOSES & FITTINGS FOR LEAKS BY PRESSURIZING SYSTEM.
5. ADD FLUID TO LEVEL MARKED ON DIPSTICK AS REQ'D.



CLIP 4 ROUTE HOSES TO MAINTAIN A MIN. OF (1") BETWEEN HOSES & A.I.R. TUBES.

CHECKER MOTORS CORP. KALAMAZOO, MICH.

EFFECTIVE ACCEL. YEAR 1974

SHEET NO. 375 B-4

DWN. CHECKER
CHK.

GRAPHIC ILLUSTRATION

STEERING - HOSE ROUTING - POWER 8 CYL.

DATE

6-8-73

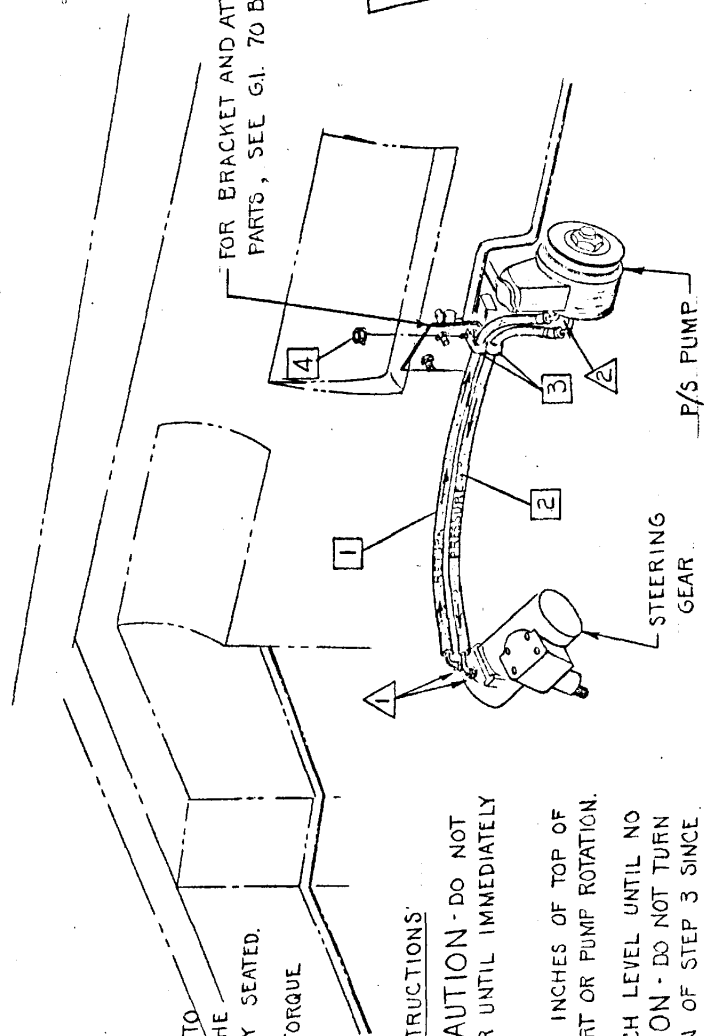
MODEL:

B-12
B-12E
B-12W

B-11
B-11E

1. 703875 HOSE - POWER STEERING
2. 705209 HOSE - POWER STEERING
3. 702221 CLAMP 3/16 CLOSED. (2)
4. 271172 NUT + LW. ASM. - 1/4-20 HEX.

CHANGES



ASSEMBLY RECOMMENDATIONS:

HOSE FITTINGS SHOULD BE TIGHTENED TO THE FOLLOWING TORQUE VALUES AFTER THE NUTS + INSERT FLARES HAVE BEEN FIRMLY SEATED.

- 1. STEERING GEAR: 20-30 FT. LBS. TORQUE
- 2. PUMP: 30-40 FT. LBS. TORQUE

HYDRAULIC STEERING BLEEDING INSTRUCTIONS:

1. ATTACH HOSES TO PUMP + GEAR. CAUTION - DO NOT REMOVE PLASTIC PLUGS FROM GEAR UNTIL IMMEDIATELY PRIOR TO INSTALLATION OF HOSES.
2. FILL PUMP TO WITHIN APPROX. 2.0 INCHES OF TOP OF FILLER NECK PRIOR TO ENGINE START OR PUMP ROTATION.
3. ROTATE PUMP + MAINTAIN 2.0 INCH LEVEL UNTIL NO FOAM OR BUBBLES APPEAR. CAUTION - DO NOT TURN STEERING WHEEL UNTIL COMPLETION OF STEP 3 SINCE THIS WILL LOAD THE SYSTEM AND BUILD UP OIL PRESS. WHICH WILL DISSOLVE AIR IN THE OIL. IT WILL THEN TAKE 2 OR 3 HOURS TO DEFOAM BEFORE BLEEDING CAN BE COMPLETED.
4. CHECK HOSES + FITTINGS FOR LEAKS BY PRESSURIZING SYSTEM.
5. ADD FLUID TO LEVEL MARKED ON DIPSTICK AS REQ'D.