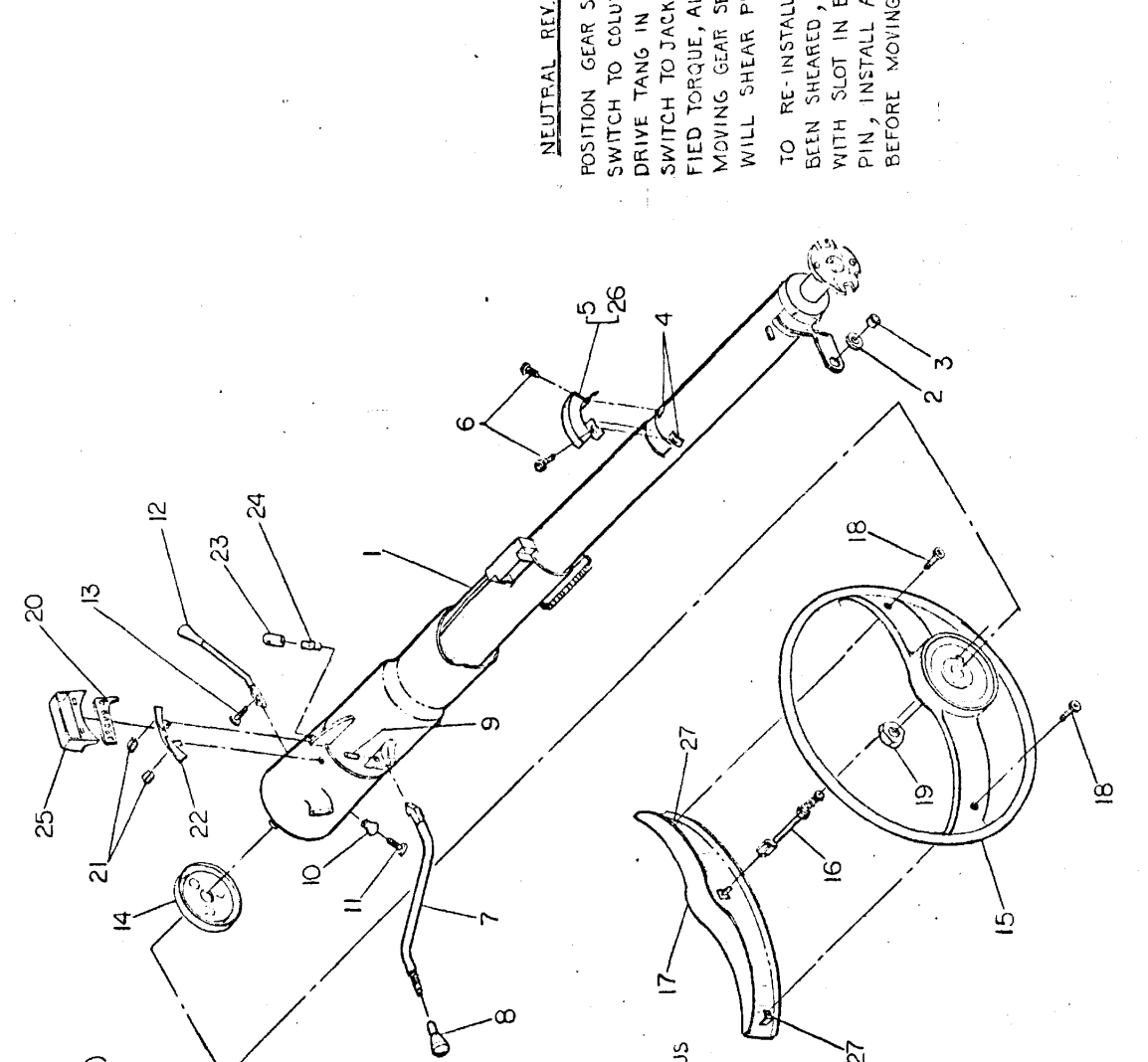


CHECKER MOTORS CORP. KALAMAZOO, MICH.

EFFECTIVE MODEL YEAR 1974

MODEL:	B-12	B-12WB	DATE	6-8-73
B-11	B-12E			
B-11E	B-12W			
DWN. CHECKED		SHEET NO. 370 B-1		
CHK.		APPVD. SUPERSEDES G.I. 370A-7 PER MEMO 387		
GRAPHIC ILLUSTRATION		STEERING COLUMN ASM. HYDRA-MATIC		

DATE	CHANGES
2-5-74	703822 WAS 705079, 703823 WAS 705119, 626894 ADDED



1. COLUMN ASM. - STRG. AUTO TRANS.
2. GROMMET - STRG. COL. GEARSHIFT
3. BUSHING - STRG. COL. GEARSHIFT
4. RETAINER - NEUT. START SW. MTG (2)
5. SWITCH ASM. - NEUT. START
6. SCREW #6-18x.270 HEX. (2)
7. LEVER - GEAR SEL.
8. KNOB - GEAR SEL.
9. PIN 3/32x1/16 GEAR SEL.
10. KNOB - HAZARD WARN.
11. SCREW #6-32x7/16 OHCR
12. LEVER ASM. - DIR. SIGNAL CONT.
13. SCREW #6-32x7/16 PHCR
14. COVER ASM. - STRG. COL. SHAFT
15. WHEEL ASM. - STEERING
16. CONTACT ASM. - STRG. WHEEL-HORN
17. PAD ASM. - STRG. WHEEL
18. SCREW #8x7/16 PHCR. (2)
19. FURN. ON COLUMN - 3/16-18 HEX
20. DIAL - AUTO TRANS. GR. SEL.
21. SPRING - GEAR SEL. DIAL RET. (2)
22. BRACKET - GEAR SEL. BEZEL
23. CAP - GR. SEL. DIAL LAMP
24. BULB - GEAR SEL. DIAL
25. BEZEL - AUTO TRANS GEAR SEL.
26. SWITCH ASM. - NEUT. START - AEROEUS
27. NUT - TINN. (2)

NEUTRAL REV. SWITCH INSTALL PROCEDURE

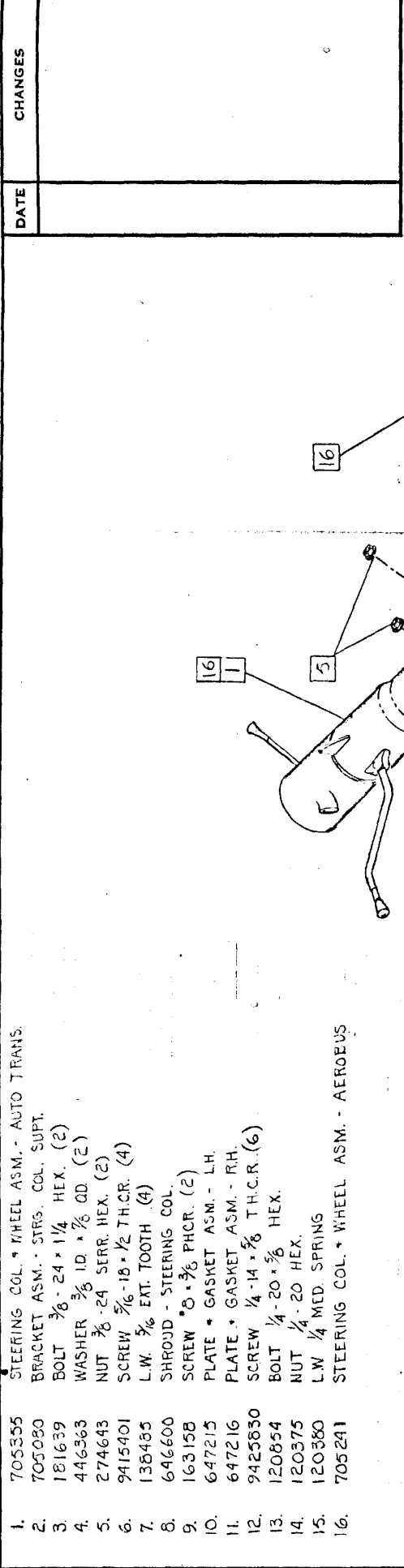
POSITION GEAR SELECTOR IN NEUTRAL, ASM. SWITCH TO COLUMN JACKET BY INSERTING DRIVE TANG IN SHIFTER TUBE SLOT & FASTER SWITCH TO JACKET WITH SCREWS TO SPECIFIED TORQUE, ALIGNING SWITCH TO COLUMN. MOVING GEAR SELECTOR OUT OF NEUTRAL WILL SHEAR PIN.

TO RE-INSTALL SWITCH AFTER PIN HAS BEEN SHEARED, ALIGN HOLE IN SUPPORT WITH SLOT IN BACK AND INSERT .092 DIA. PIN, INSTALL AS ABOVE. REMOVE PIN BEFORE MOVING GEAR SELECTOR.

CHECKER MOTORS CORP. KALAMAZOO, MICH.

EFFECTIVE MODEL YEAR 1974

MODEL: B-11 B-11E B-12 B-12E B-12W B-12WB	DATE 6-8-73	GRAPHIC ILLUSTRATION STEERING COLUMN INSTALLATION HYDRA-MATIC	SHEET NO. 570 B-2
DWN. CHK.	APPVD. SUPERSEDES G.I. 570 A19 PER MEMO 587	DATE	CHANGES



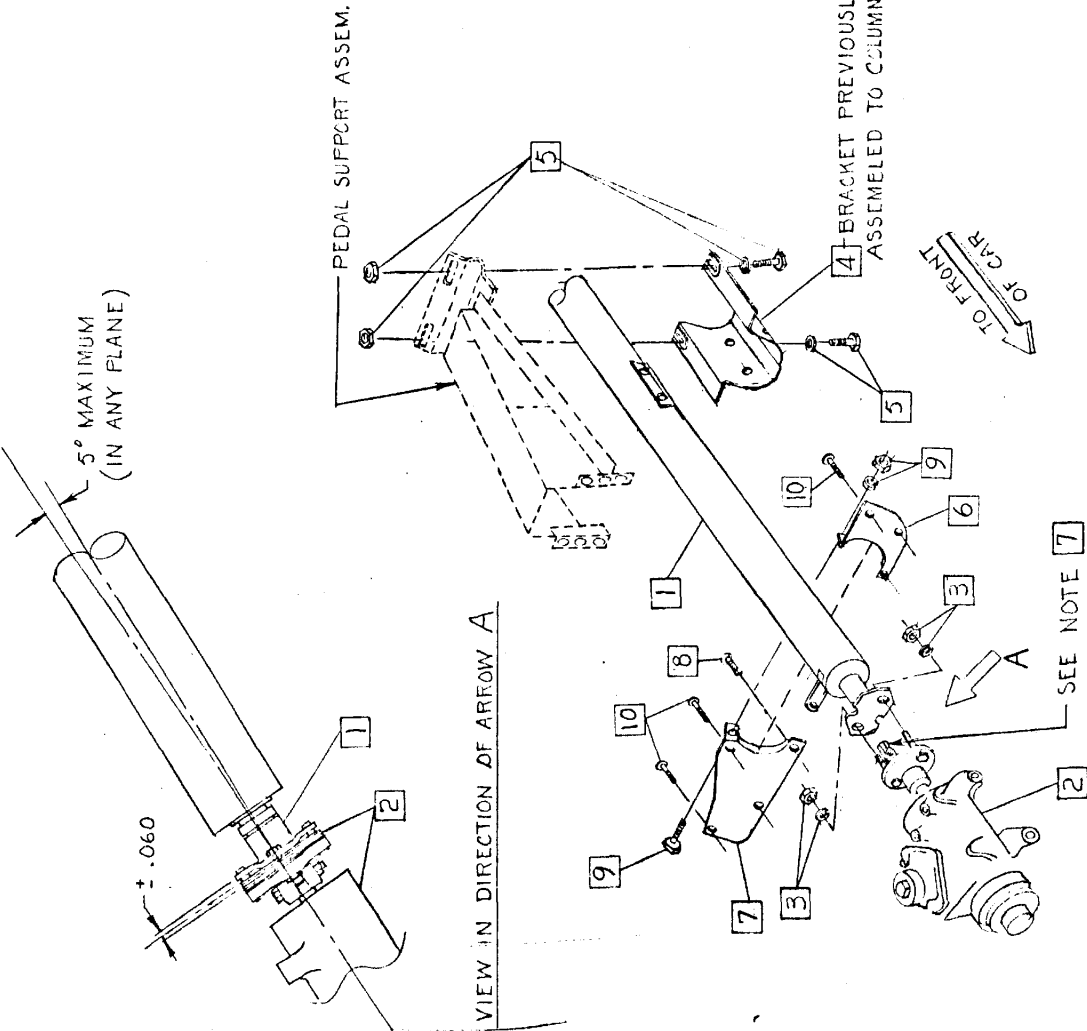
1. 705355 STEERING COL. * WHEEL ASM. - AUTO TRANS.
2. 705080 BRACKET ASM. - STRG. COL. SUPT.
3. 181639 BOLT 3/8 - 24 * 1 1/4 HEX. (2)
4. 446363 WASHER 3/8 ID * 3/8 OD (2)
5. 274643 NUT 3/8 - 24 SERR. HEX. (2)
6. 9415401 SCREW 3/16 - 18 * 1/2 TH.C.R. (4)
7. 138485 L.W. 3/8 EXT. TOOTH (4)
8. 646600 SHROUD - STEERING COL.
9. 163158 SCREW 8 * 3/8 PHCR. (2)
10. 647215 PLATE * GASKET ASM. - L.H.
11. 647216 PLATE * GASKET ASM. - R.H.
12. 9425830 SCREW 1/4 - 14 * 3/8 T.H.C.R. (6)
13. 120654 BOLT 1/4 - 20 * 3/8 HEX.
14. 120375 NUT 1/4 - 20 HEX.
15. 120380 L.W. 1/4 MED. SPRING
16. 705241 STEERING COL. * WHEEL ASM. - AEROEUS

▲ 15 - 25 LBS. FT. TORQUE

CHECKER MOTORS CORP. KALAMAZOO, MICH.

EFFECTIVE MODEL YEAR 1974

MODEL: A-11 A-11E	A-12	DATE	6-8-73	DWN. CHK.	SHEET NO. 370 B-3
	A-12E A-12W	GRAPHIC ILLUSTRATION			
STEERING COLUMN INSTALLATION			APPVD. SUPERIDES 31 370 A-75		



THE RECOMMENDED AND APPROVED ENERGY ABSORBING STEERING COLUMN INSTALLATION PROCEDURE FOR ALL CHECKER MOTORS VEHICLES IS AS FOLLOWS:

1. CONNECT COLUMN (1) TO STEERING GEAR (FLEXIBLE COUPLING)(2) BY TIGHTENING TWO FLANGE NUTS AND LOCKWASHERS (3) TO 15-20 FOOT POUNDS TORQUE.
2. POSITION COLUMN (1) & SUPPORT BRACKET ASSEM. (4) UP TO INSTRUMENT PANEL AND INSTALL WITH TWO SPECIFIED BOLTS, WASHERS & LOCKNUTS (5), TO PEDAL SUPPORT ASSEM. TORQUE TO 15-25 FOOT POUNDS.
3. ASSEMBLE LEFT HAND (6) AND RIGHT HAND (7) STEERING COLUMN HOLE COVER PLATE & GASKET ASSEMBLY TO COLUMN WITH SPECIFIED SCREW (8) AND CLAMPING BOLT, LOCKWASHER & NUT (9). SLIDE THIS ASSEMBLY SNUG AGAINST FLOORPAN (TOEBOARD) AND TIGHTEN CLAMP BOLT NUT TO 3-4 FT. POUNDS.
4. AFTER STEPS 1, 2 & 3 ARE COMPLETED, DRILL FIVE HOLES IN FLOORPAN (USING COVER PLATE ASSEMBLY AS TEMPLATE) FOR THE SPECIFIED MOUNTING SCREWS (10). ASSEMBLE COVER PLATE ASSEMBLY SECURELY TO FLOOR PAN.
5. CHECK FLEXIBLE COUPLING TO SEE THAT IT IS NOT DISTORTED AXIALLY MORE THAN $\pm .060$, OR THAT SAFETY RIVETS ARE NOT CONTACTING UPPER FLANGE. ENDS OF PINS SHOULD ENGAGE THE FLANGE BY AT LEAST THE FULL THICKNESS OF THE FLANGE.
6. MAXIMUM RECOMMENDED LATERAL MISALIGNMENT BETWEEN THE COLUMN (1) AND STEERING GEAR (2) IS .130 AND THE MAXIMUM ANGLE AT THE FLEXIBLE COUPLING BETWEEN COLUMN & MATING STEERING GEAR SHAFT IS 5°.
7. THESE SPACERS (2) ARE FOR ALIGNMENT PURPOSES ONLY AND MUST BE REMOVED AFTER FINAL ASSEMBLY WITH MATING FLANGE. PINS MUST NOT CONTACT UPPER FLANGE IN EITHER RADIAL OR AXIAL DIRECTION AFTER ASSEM.

VIEW IN DIRECTION OF ARROW A

SEE NOTE 7