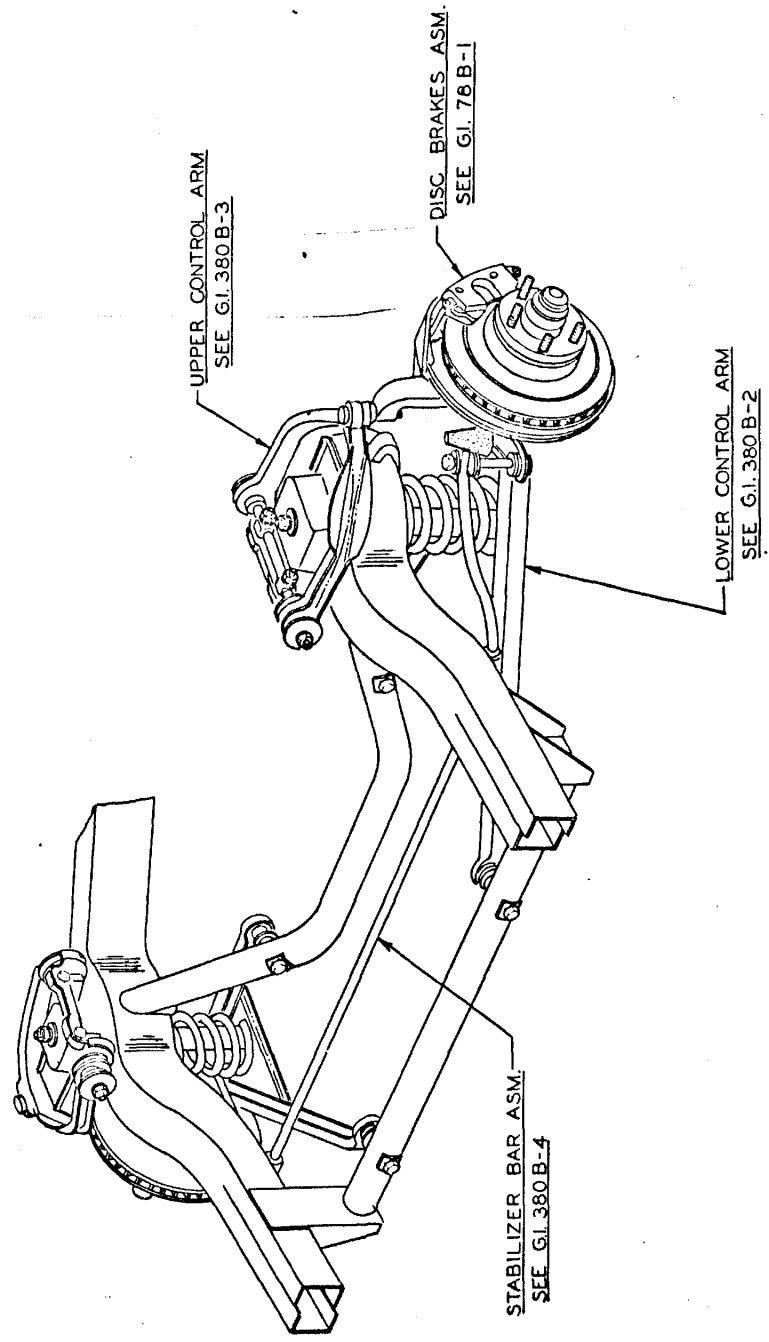


CHECKER MOTORS CORP. KALAMAZOO, MICH.

MODEL: B-II B-IIIE	B-12 B-12E	DATE 6-7-73	GRAPHIC ILLUSTRATION SUSPENSION - FRONT	DWN. CHECKER	SHEET NO. 380 B-1
				CHIK.	

DATE	CHANGES

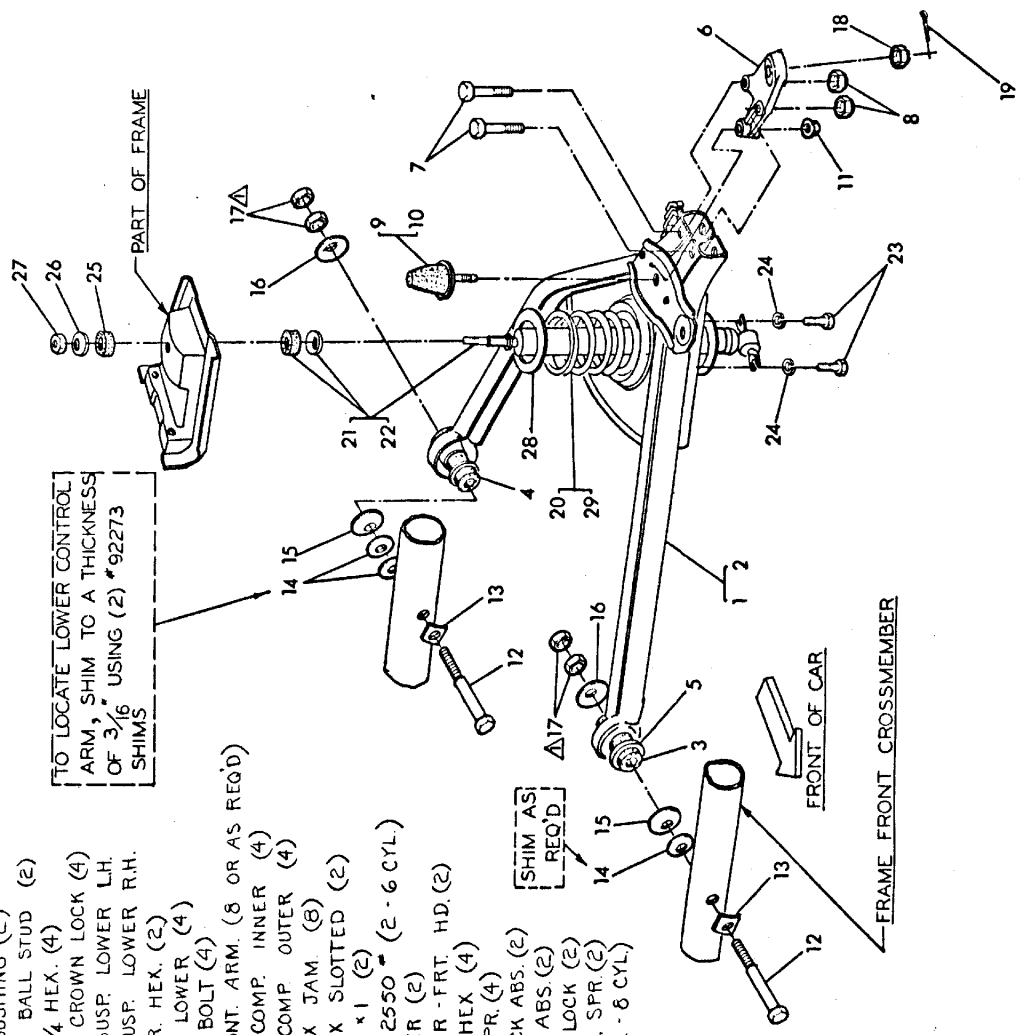


CHECKER MOTORS CORP. KALAMAZOO, MICH.

MODEL:	B-12	B-12W	DATE	6-7-73
	B-11E	B-12E		
	DWN. DENNER		SHEET NO. 380 B-2	
	CHK.		SUPERSEDES G.I. 360 A-12 PER MEMO #337	
GRAPHIC ILLUSTRATION			CHANGES	
SUSPENSION - FRT. LOWER CONTROL ARM			DATE	
			9-24-73 SHIM INSTALLATION NOTE ADDED	

1.	705243	ARM SUB. ASM. - LOWER CONT. LH.
2.	705244	ARM SUB. ASM. - LOWER CONT. RH.
3.	705282	BUSHING - LOWER CONT. ARM. PIVOT - FRT. (2)
4.	705283	BUSHING - LOWER CONT. ARM. PIVOT - REAR (2)
5.	92513	SPACER - SUSP. BUSHING (2)
6.	704425	BRACKET - LOWER BALL STUD (2)
7.	181707	BOLT 1/2-20 x 2 1/4 HEX. (4)
8.	622682	NUT 1/2-20 HEX. CROWN LOCK (4)
9.	92291	BUMPER - FRT. SUSP. LOWER LH.
10.	92290	BUMPER - FRT. SUSP. LOWER RH.
11.	274643	NUT 3/8-24 SERR. HEX. (2)
12.	92261	BOLT - FRT. SUSP. LOWER (4)
13.	93355	WASHER - SUSP. BOLT (4)
14.	92273	SHIM - LOWER CONT. ARM. (8 OR AS REQ'D)
15.	92264	WASHER - BUSH. COMP. INNER (4)
16.	92263	WASHER - BUSH. COMP. OUTER (4)
17.	124944	NUT 3/8-18 HEX JAM. (8)
18.	125267	NUT 3/8-18 HEX SLOTTED (2)
19.	137185	COTTER PIN 1/8 x 1 (2)
20.	706311	SPRING - FRT. 2550" (2-6 CYL)
21.	705268	SHOCK ABSORBER (2)
22.	705269	SHOCK ABSORBER - FRT. HD. (2)
23.	181608	BOLT 3/16-24 x 1 HEX (4)
24.	120214	LW. 3/16 MED. SPR. (4)
25.	706989	INSULATOR - SHOCK ABS. (2)
26.	94408	WASHER - SHOCK ABS. (2)
27.	442828	NUT 3/8-24 HEX LOCK (2)
28.	92293	INSULATOR - FRT. SPR. (2)
29.	704632	SPRING - FRT. (2-8 CYL)

TO LOCATE LOWER CONTROL ARM, SHIM TO A THICKNESS OF 3/16" USING (2) #92273 SHIMS



RECOMMENDED INSTALLATION PROCEDURE TO ESTABLISH PROPER USE OF SHIMS AT PIVOT BOLTS

1. ASSEMBLE (2) SHIMS NEXT TO C' MEMBER ON THE REAR PIVOT BOLT AS INDICATED.
2. PLACE ARM ASM. ON BOLT + PUSH FORWARD AGAINST SHIMS TO DETERMINE THE SHIM SPACE REQ. AT THE FRONT PIVOT BOLT.
3. IF SHIM SPACE AT FRONT IS LESS THEN (1) SHIM THICKNESS (09), REMOVE ARM + ASSEMBLE CUPPED WASHERS, ALSO FRONT BOLT + WASHERS. TIGHTEN BOTH ASSEMBLIES TO 60-75 FT. LBS. TORQUE WHILE HOLDING PIVOT BOLT FROM TURNING.
4. IF SHIM SPACE AT FRONT IS MORE THEN (1) SHIM THICKNESS, REMOVE ONE OR BOTH REAR SHIMS AS MAY BE REQ'D - OR - ADD PROPER AMOUNT OF SHIMS AT FRONT. ASSEMBLE CUPPED WASHERS, ALSO FRONT BOLT + WASHERS. TIGHTEN ASSEMBLIES AS SPECIFIED ABOVE.

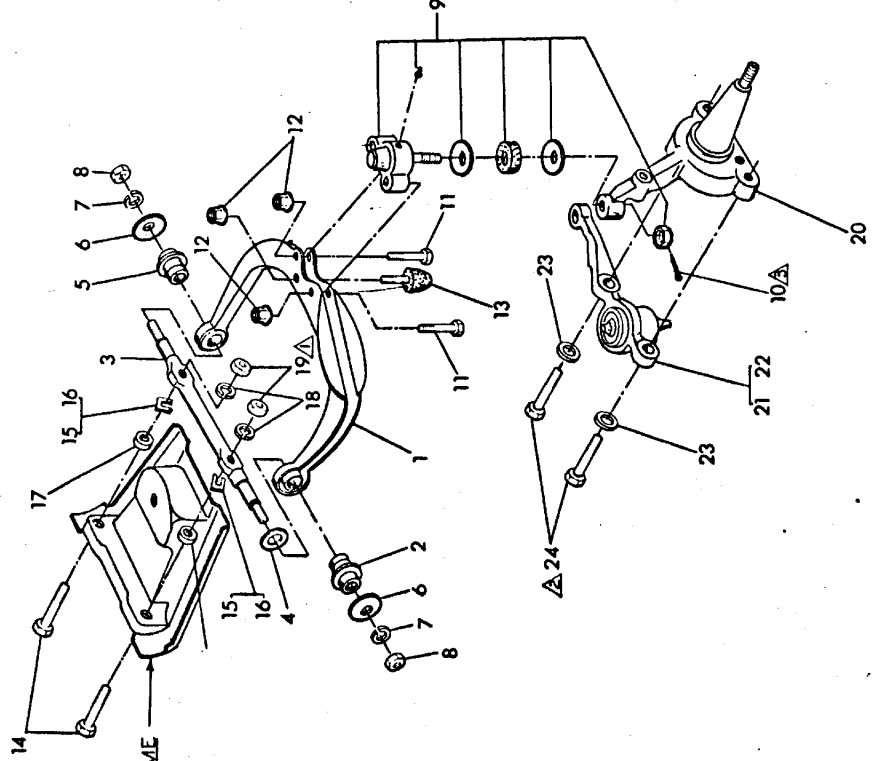
60-75 FT. LBS. TORQUE

CHECKER MOTORS CORP. KALAMAZOO, MICH.

MODEL:		DATE		SHEET NO. 380 B-3	
B-11	B-12	B-12W	6-7-74	DWN. DESSER	CHANGES
B-11E	B-12E			CHK.	8-15-73 706-492 WAS 704031
GRAPHIC ILLUSTRATION				SUPERSEDES G.I. 380 A-13 PER MEMO * 337	
SUSPENSION - FRONT UPPER CONTROL ARM.					

92845 ARM * SOCKET ASM. - UPPER CONTROL L.H.
 92844 ARM * SOCKET ASM. - UPPER CONTROL R.H.
 92434 ARM. ASM. - UPPER CONTROL (2)
 1. 702728 ARM - UPPER CONTROL (2)
 2. 705280 BUSHING - UPPER CONT. ARM. PIVOT - FRT. (2)
 3. 706353 SHAFT - UPPER CONT. ARM. (2)
 4. 92265 WASHER - BUSH. COMP. - UPPER INNER (2)
 5. 705281 BUSHING - UPPER CONT. ARM. PIVOT - REAR (2)
 6. 92263 WASHER - BUSH COMP. - OUTER (4)
 7. 121574 L.W. $\frac{3}{8}$ MED. SPRING (4)
 8. 124944 NUT $\frac{3}{8}$ - 18 HEX JAM. (4)
 9. 703362 SOCKET ASM. - UPPER (2)
 10. 137185 COTTER PIN $\frac{1}{8}$ x 1 (2)
 11. 181648 BOLT $\frac{3}{8}$ - 24 * 2 HEX. (4)
 12. 274643 NUT $\frac{3}{8}$ - 24 SERR. HEX. (6)
 13. 92289 BUMPER - FRT. SUSP. - UPPER (2)
 14. 181710 BOLT $\frac{1}{2}$ - 20 * 2 $\frac{3}{4}$ HEX (4)
 15. 706403 SHIM - UPPER CONT. ARM. - FRT. SUSP. (8)
 16. 706404 SHIM - UPPER CONT. ARM. - FRT. SUSP. (4)
 17. 706237 SPACER - UPPER CONT. (4)
 18. 131101 L.W. $\frac{1}{2}$ HEAVY SPRING (4)
 19. 120371 NUT $\frac{1}{2}$ - 20 HEX. (4)
 20. 706492 KNUCKLE - STEERING (2)
 21. 703757 ARM * JOINT ASM. - STEERING LH.
 22. 703758 ARM * JOINT ASM. - STEERING RH.
 23. 131016 WASHER $\frac{5}{32}$ I.D. * 1 $\frac{1}{16}$ O.D. (4)
 24. 626817 BOLT $\frac{3}{8}$ - 18 * 2 $\frac{1}{4}$ HEX. (4)

WHEEL ALIGNMENT NOTE - USE MINIMUM NUMBER OF SHIMS TO PROVIDE PROPER CASTER + CAMBER.

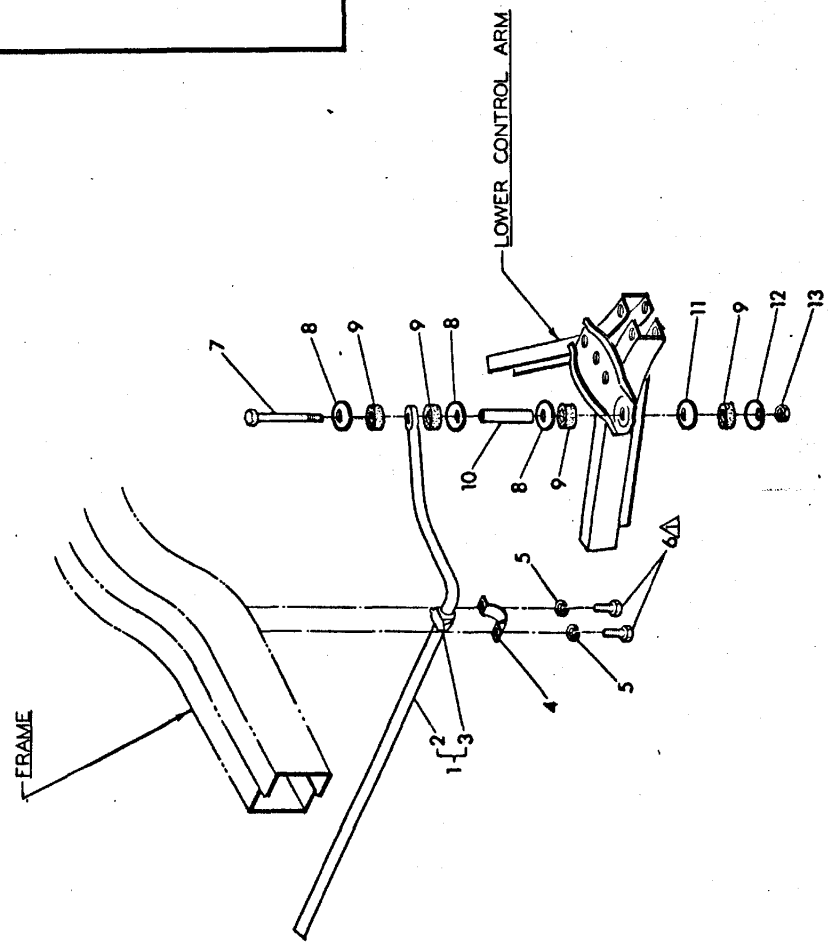


- ① 65 - 75 FT. LBS. TORQUE
- ② 90 - 103 FT. LBS. TORQUE
- ③ 75 - 95 FT. LBS. TORQUE PLUS $\frac{1}{6}$ TURN MAX. TO ALIGN NUT SLOT AND COTTER PIN HOLE

CHECKER MOTORS CORP. KALAMAZOO, MICH.

MODEL:		DATE	GRAPHIC ILLUSTRATION	DWN. DECKER	SHEET NO. 380 B-4
B-11	B-12	6-7-73	SUSPENSION - FRONT STABILIZER BAR	CHK.	SUPERSEDES G.I. 380 A-14 PER MEMO # 337
B-11E	B-12E				

	DATE	CHANGES



1. 701013 BAR ASM. - STABILIZER
2. 702021 BAR - STABILIZER
3. 94446 BUSHING - STABILIZER BAR (2)
4. 92475 BRACKET - STABILIZER BAR (2)
5. 120382 LW. 3/8 MED. SPRING (4)
6. 181637 BOLT 3/8-24 x 1 HEX. (4)
7. 92474 BOLT - STABILIZER BAR (2)
8. 704180 WASHER - STAB. BAR INSUL. - UPPER (6)
9. 92145 BUSHING - STAB. BAR MTG. (8)
10. 92473 SPACER - STAB. BAR LINK (2)
11. 704181 WASHER - STAB. BAR INSUL. - CENTERING (2)
12. 704182 WASHER - STAB. BAR INSUL. - LOWER (2)
13. 442828 NUT 3/8-24 HEX. LOCK (2)

△ 30 - 35 FT LBS. TORQUE

CHECKER MOTORS CORP. KALAMAZOO, MICH.

EFFECTIVE MODEL YEAR 1974

MODEL: B-12WB

DATE

GRAPHIC ILLUSTRATION
SUSPENSION - FRONT

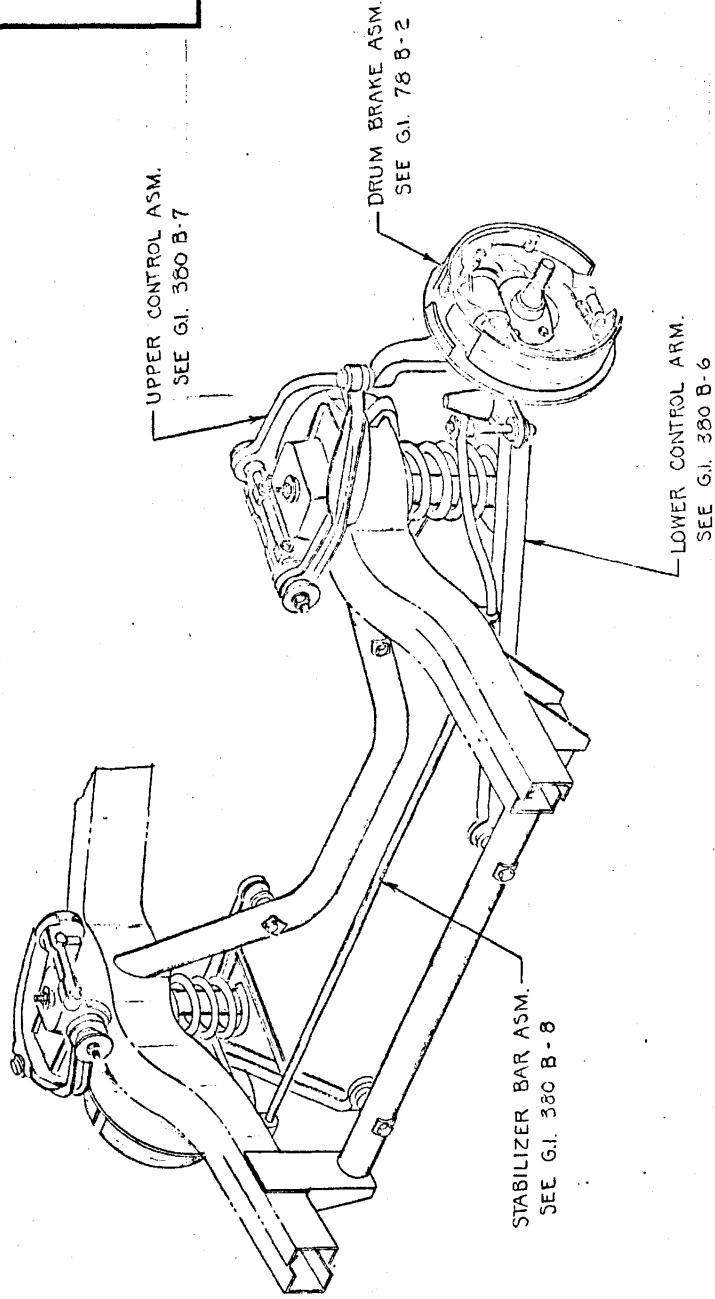
DWN. DESKED:
CHK.

SHEET NO. 350 B-5

APPVD. SUPERSEDES G.I. 380 A-16 PER MEND 597

DATE

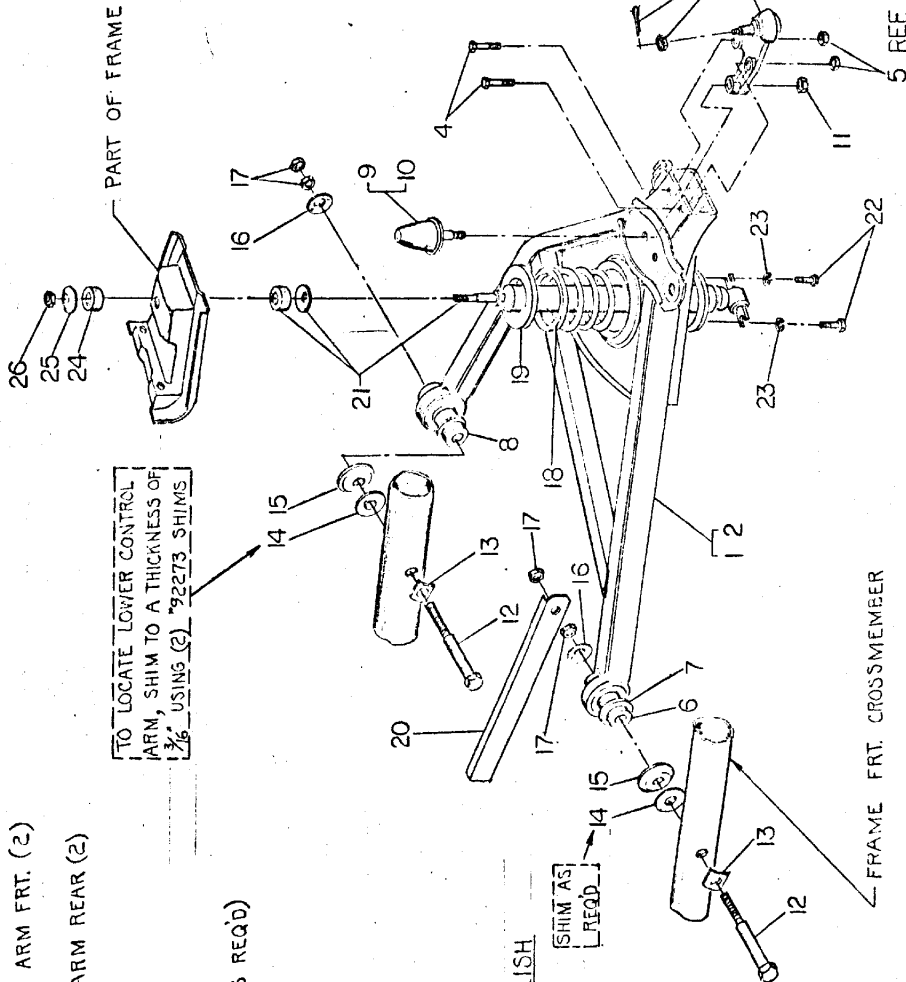
CHANGES



CHECKER MOTORS CORP. KALAMAZOO, MICH.

MODEL:	B-12W8	DATE	6-7-73
DWN. DRAWING	CHK.	APPVD.	SUPERSEDES G.I. 330A-16 PER MEMO 337
GRAPHIC ILLUSTRATION		SHEET NO.	330B-6
SUSPENSION - FRT. - LOWER CONTROL ARM		DATE	7-19-73
		CHANGES	705400 W/W 705270
			10-2-73 SHIM INSTALLATION NOTE ADDED

1.	705265	ARM ASM. - LOWER CONT. WELDED LH.
2.	705266	ARM ASM. - LOWER CONT. WELDED RH.
3.	705169	SOCKET ASM. - LOWER (2)
4.	181707	BOLT 1/2-20 x 2 1/4 HEX. (4)
5.	626852	NUT 1/2-20 HEX CROWN LOCK (4)
6.	705282	BUSHING ASM. - SUSP. LOWER CONT ARM FRT. (2)
7.	92513	SPACER - SUSPENSION BUSHING (2)
8.	705283	BUSHING ASM. - SUSP. LOWER CONT. ARM REAR (2)
9.	92291	BUMPER - FRT. SUSP. LOWER LH.
10.	92290	BUMPER - FRT. SUSP. LOWER RH.
11.	274643	NUT 3/8-24 SERR. HEX. (2)
12.	92261	BOLT - FRT. SUSP. LOWER (4)
13.	93355	WASHER - SUSP. BOLT (4)
14.	92273	SHIM - LOWER CONT. ARM. (8 OR AS REQ'D)
15.	92264	WASHER - BUSH. COMP. - INNER (4)
16.	92263	WASHER - BUSH. COMP. - OUTER (4)
17.	124944	NUT 5/8-18 HEX JAM. (8)
18.	96130	SPRING - FRT. (2)
19.	92293	INSULATOR - SPRING FRT. (2)
20.	704557	REINFORCEMENT - LOWER CONT. ARM.
21.	705400	SHOCK ABSORBER ASM. - FRT. (2)
22.	181608	BOLT 5/8-24 x 1 HEX. (4)
23.	120214	L.W. 5/8 MED. SPRING (4)



RECOMMENDED INSTALLATION PROCEDURE TO ESTABLISH PROPER USE OF SHIMS AT PIVOT BOLTS:

- ASSEMBLE (2) SHIMS NEXT TO CROSSMEMBER ON THE REAR PIVOT BOLT AS INDICATED.
- PLACE ARM ASM. ON BOLT AND PUSH FORWARD AGAINST SHIMS TO DETERMINE THE SHIM SPACE REQUIREMENT AT THE FRONT PIVOT BOLT.
- IF SHIM SPACE AT FRONT IS LESS THAN (1) SHIM THICKNESS (09), REMOVE ARM AND ASSEMBLE CUPPED WASHERS, ALSO FRONT BOLT AND WASHERS. TIGHTEN BOTH ASSEMBLIES TO 60-75 FT. LBS. TORQUE WHILE HOLDING PIVOT BOLT FROM TURNING.
- IF SHIM SPACE AT FRONT IS MORE THAN (1) SHIM THICKNESS, REMOVE ONE OR BOTH REAR SHIM AS MAY BE REQUIRED - OR ADD PROPER AMOUNT OF SHIMS AT FRONT. ASSEMBLE CUPPED WASHERS, ALSO FRONT BOLT AND WASHERS. TIGHTEN ASSEMBLIES AS SPECIFIED ABOVE.

CHECKER MOTORS CORP. KALAMAZOO, MICH.

SHEET NO. 550 B-7

DWN. CHK.

GRAPHIC ILLUSTRATION

SUSPENSION - FRT - UPPER CONTROL ARM

DATE 6-7-73

MODEL: 8-12W8

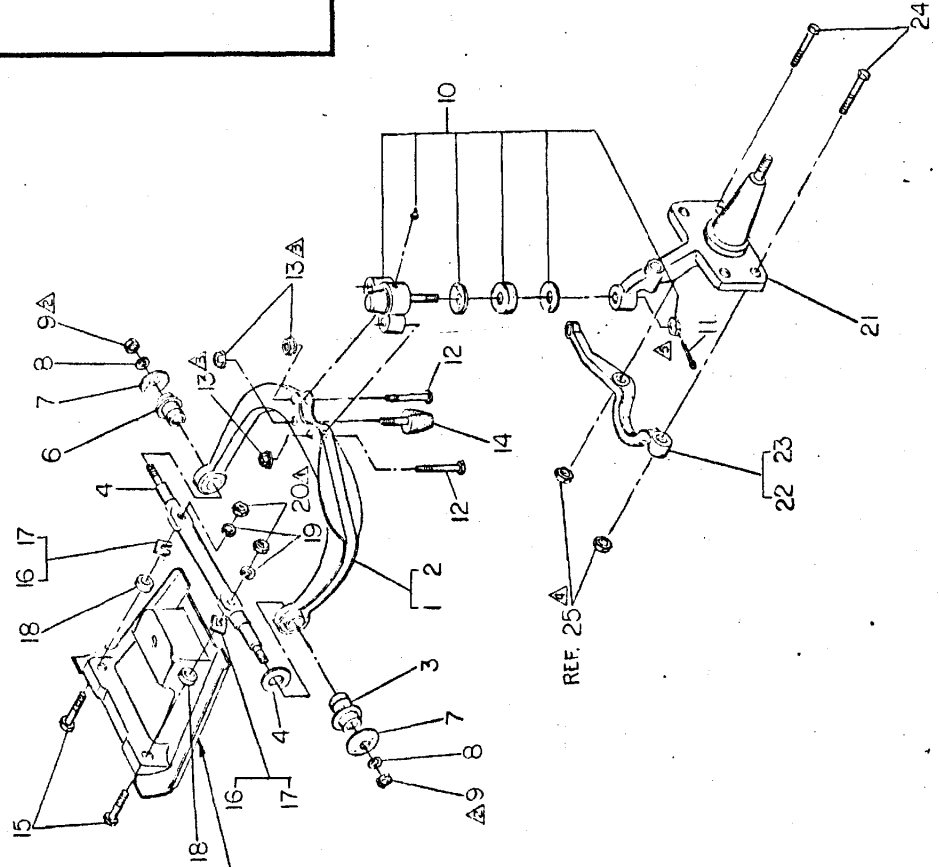
APPVD. PERIODIC GI 550 A-17 FOR NEWS 557

DATE	CHANGES

WHEEL ALIGNMENT NOTE: USE MIN NUMBER OF SHIMS TO PROVIDE PROPER CASTER & CAMBER.

1. 701633 ARM & SOCKET ASM. - UPPER CONT. LH.
2. 701634 ARM & SOCKET ASM. - UPPER CONT. RH.
3. 701631 ARM & SHAFT ASM. - UPPER CONTROL LH.
4. 701632 ARM & SHAFT ASM. - UPPER CONTROL RH.
5. 701629 ARM ASM. - UPPER CONTROL LH.
6. 701630 ARM ASM. - UPPER CONTROL RH.
7. 705280 BUSHING ASM. - SUSP. UPPER CONT. ARM PIVOT - FRT (2)
8. 706353 SHAFT - UPPER CONT. ARM. (2)
9. 92265 WASHER - BUSH. COMP. - UPPER INNER (2)
10. 705281 BUSHING ASM. - SUSP. UPPER CONT. ARM PIVOT - REAR (2)
11. 92263 WASHER - BUSH. COMP. - OUTER (4)
12. 121574 L.W. $\frac{3}{8}$ MED. SPRING (4)
13. 124944 NUT $\frac{3}{8}$ - 18 HEX. JAM. (4)
14. 703362 SOCKET ASM. - UPPER (2)
15. 137185 COTTER PIN $\frac{1}{8}$ - 1 (2)
16. 181645 BOLT $\frac{3}{8}$ - 24 x 2 HEX. (4)
17. 274643 NUT $\frac{3}{8}$ - 24 SERR. HEX. LOCK (6)
18. 92289 BUMPER - FRT. SUSP. - UPPER (2)
19. 181710 BOLT $\frac{1}{2}$ - 20 x $2\frac{1}{4}$ HEX. (4)
20. 706403 SHIM - UPPER CONT. ARM. (8 OR AS REQ'D)
21. 706404 SHIM - UPPER CONT. ARM. (4 OR AS REQ'D)
22. 706237 SPACER - UPPER CONT. FRT. SUSP. (4)
23. 131101 L.W. $\frac{1}{2}$ HEAVY SPRING (4)
24. 120371 NUT $\frac{1}{2}$ - 20 HEX. (4)
25. 702593 STEERING KNUCKLE - (2)
26. 702735 ARM. - STEERING LH.
27. 702736 ARM. - STEERING RH.
28. 181707 BOLT $\frac{1}{2}$ - 20 x $2\frac{1}{4}$ HEX. (4)
29. 626552 NUT $\frac{1}{2}$ - 20 HEX. CROWN LOCK (4)

PART OF FRAME



- ① 65 - 75 LBS. FT. TORQUE
- ② 60 - 75 LBS. FT. TORQUE
- ③ 20 - 30 LBS. FT. TORQUE
- ④ 65 - 85 LBS. FT. TORQUE
- ⑤ 75 - 95 LBS. FT. TORQUE PLUS $\frac{1}{6}$ TURN MAX. TO ALIGN NUT SLOT AND COTTER PIN HOLE.

24 REF. SEE G.I. 785-2

CHECKER MOTORS CORP. KALAMAZOO, MICH.

MODEL:

B-12W6

DATE

6-7-73

GRAPHIC ILLUSTRATION

SUSPENSION - FRONT - STABILIZER BAR

DWN. BY:

CHK.

SHEET NO. 550 B-8

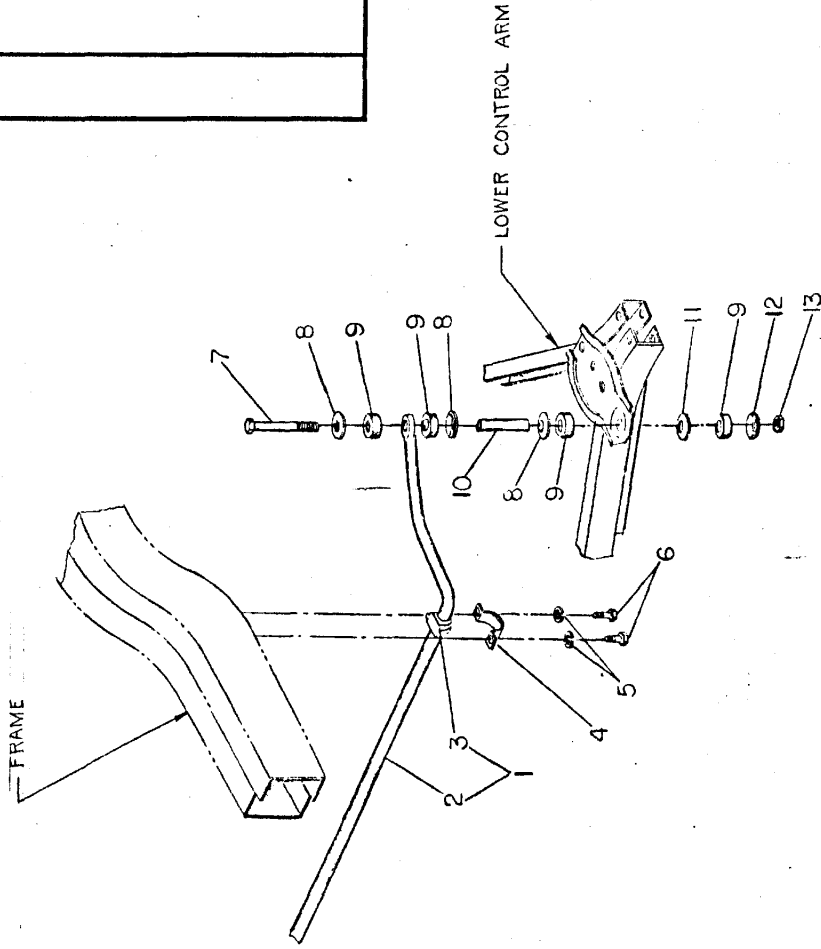
APPVD. REVISIONS G.I. 550A-15 PER MEMO 537

CHANGES

DATE

CHANGES	DATE

- 1. 701013 BAR ASM. - STABILIZER
- 2. 702021 BAR - STABILIZER
- 3. 94446 BUSHING - STABILIZER BAR (2)
- 4. 92475 BRACKET - STABILIZER BAR (2)
- 5. 120382 L.W. 3/8 MED. SPRING (4)
- 6. 181637 BOLT - 3/8-24 x 1 HEX. (4)
- 7. 92474 BOLT - STABILIZER BAR LINK (2)
- 8. 704180 WASHER - STAB. BAR INSUL. - UPPER (6)
- 9. 92145 BUSHING - STAB. BAR MTG (8)
- 10. 92473 SPACER - STAB. BAR LINK (2)
- 11. 704181 WASHER - STAB. BAR INSUL. - CENTERING (2)
- 12. 704182 WASHER - STAB. BAR INSUL. - LOWER (2)
- 13. 442628 NUT 3/8-24 HEX LOCK (2)



CHECKER MOTORS CORP. KALAMAZOO, MICH.

EFFECTIVE MODEL YEAR 1974

GRAPHIC ILLUSTRATION

DWN. DESKTOP

CHK.

SHEET NO. 380 B-9

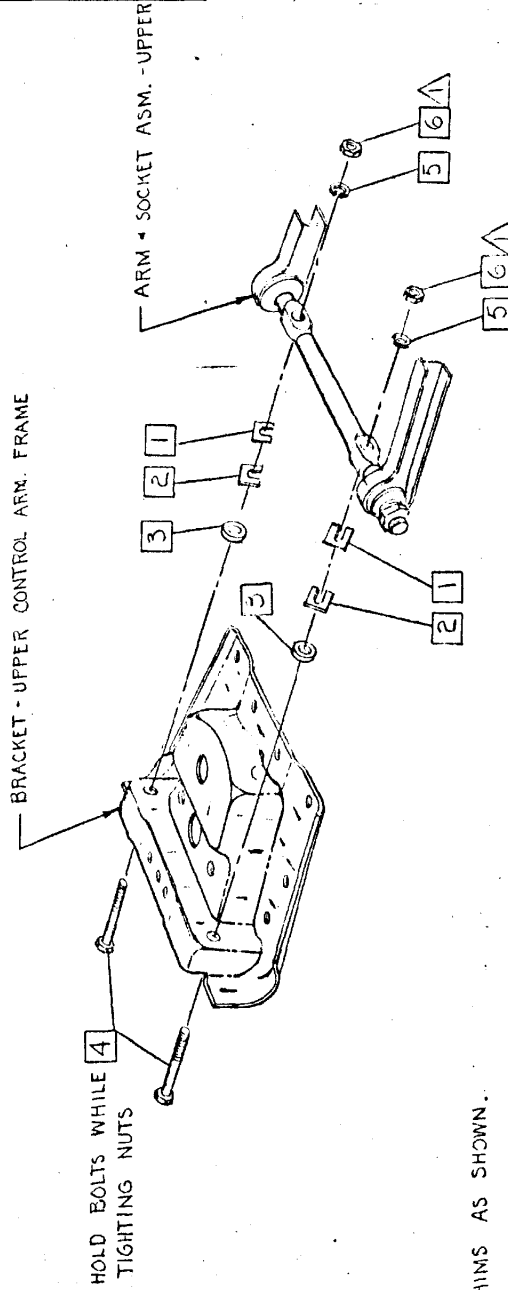
DATE

MODEL: B-12 B-12W6 B-12E B-12W

FRT. SUSPENSION - UPPER CONTROL ARM SHIM INSTALL.

APPVD. SUPERSEDES G.I. 350A-10

1. 706403 SHIM - (AS REQ'D)
2. 706404 SHIM. AS REQ'D
3. 706237 SPACER - UPPER CONTROL (2) PER SIDE
4. 181710 BOLT 1/2-20 x 2 3/4 HEX. (2) PER SIDE
5. 131101 LW. 1/2 HEAVY SPR. (2) PER SIDE
6. 120371 NUT 1/2-20 HEX. (2) PER SIDE



1. PLACE SPACER AND SHIMS AS SHOWN.
2. TORQUE NUT TO 65 - 75 FT. LB. WHILE HOLDING BOLT

▲ 65 - 75 LB. FT. TORQUE

DATE	CHANGES

CHECKER MOTORS CORP. KALAMAZOO, MICH.

EFFECTIVE MODEL YEAR

SHEET NO. 350 B16

DWN. CHECK.

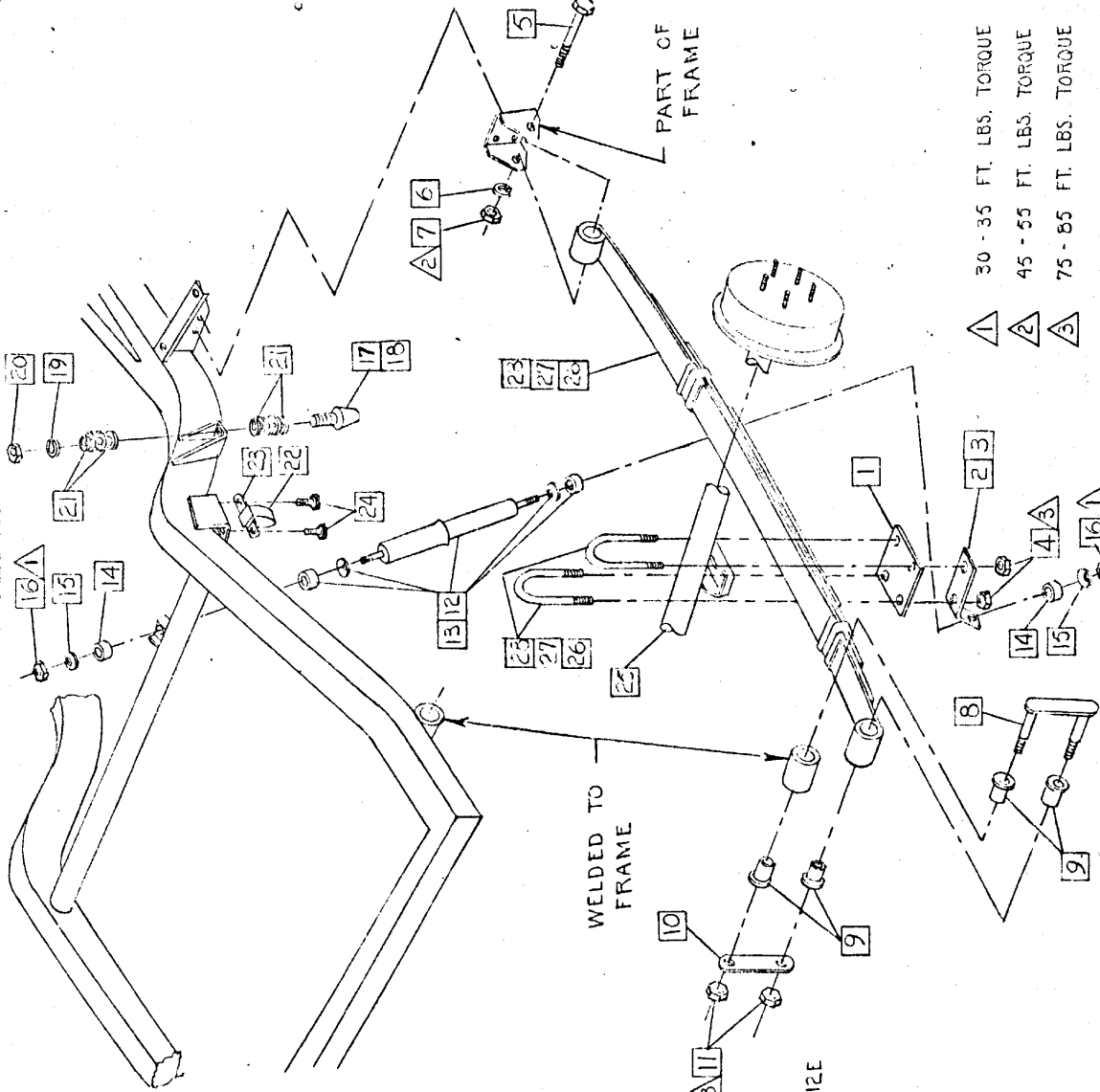
APPVD. SUPERIDES G.I. 380A-5

GRAPHIC ILLUSTRATION

SUSPENSION - REAR

MODEL: B-11 B-11E B-12 B-12E B-12W DATE 6-7-73

1. 98300 PLATE - REAR SPRING (2)
2. 98301 BRACKET - LOWER L.H.
3. 98302 BRACKET - LOWER R.H.
4. 65198 NUT - SPRING CLIP (8)
5. 271756 BOLT $\frac{3}{8}$ -18 x 4 $\frac{1}{2}$ HEX. (2)
6. 121574 L.W. $\frac{5}{8}$ MED. SPRING (2)
7. 121358 NUT $\frac{5}{8}$ -18 HEX. (2)
8. 95634 PLATE + PIN ASSEM. (2)
9. 96153 BUSHING (8)
10. 80766 PLATE (2)
11. 626852 NUT $\frac{1}{2}$ -20 HEX. (4)
12. 703942 SHOCK ABSORBER ASSEM. - STD. (2)
13. 703944 SHOCK ABSORBER ASSEM. - H.D. (2)
14. 706089 INSULATOR (4)
15. 94406 WASHER (4)
16. 442626 NUT $\frac{3}{8}$ -24 HEX. (4)
17. 701015 BUMPER ASSEM. (2)
18. 92289 BUMPER ASSEM. (2) B-11E, B-12E ONLY
19. 120382 L.W. $\frac{3}{8}$ MED. SPR. (2)
20. 120369 NUT $\frac{3}{8}$ -24 HEX. (2)
21. 446477 WASHER $\frac{7}{16}$ I.D. x $1\frac{3}{8}$ O.D. (30)
22. 702356 BUMPER - REAR AXLE (2)
23. 702354 CLIP - (2)
24. 626912 SCREW $\frac{1}{16}$ -18 x $\frac{3}{4}$ HEX. (4)
25. 703765 AXLE ASSEM. 3.31:1
- 703766 AXLE ASSEM. 3.31:1 TRAC. LOCK



26. { 705173 SPRING ASSEM. (2) B-11, B-11E, B-12, B-12E
98308 CLIP - INNER (4)
27. { 705064 SPRING ASSEM. (2) B-12W
98308 CLIP - INNER (4)
28. { 703000 SPRING ASSEM. H.D. (2)
95308 CLIP - INNER (4)

▲ 30 - 35 FT. LBS. TORQUE
▲ 45 - 55 FT. LBS. TORQUE
▲ 75 - 85 FT. LBS. TORQUE

CHECKER MOTORS CORP. KALAMAZOO, MICH.

EFFECTIVE MODEL YEAR 1974

SHEET NO. 380 B-11

DWN. *[Signature]*
CHK.

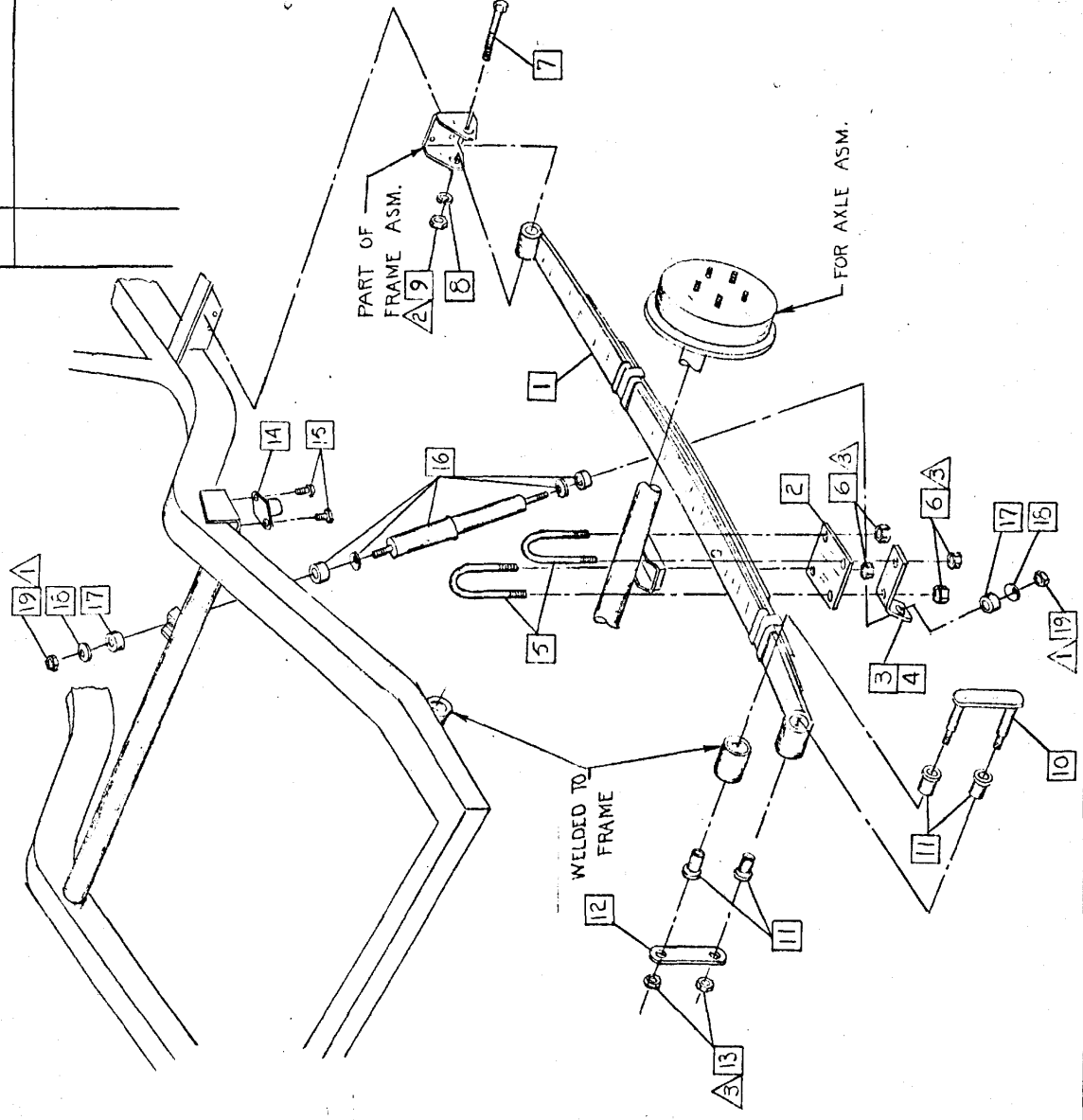
APPVD. SUPERSEDES G1.380 A-9

GRAPHIC ILLUSTRATION
SUSPENSION - REAR AEROBUS

DATE
6-7-73

MODEL:
B-12W8

- 1. 95645 SPRING ASM. - REAR (2)
- 2. 702603 PLATE - REAR SPRING (2)
- 3. 98301 BRACKET - REAR SHOCK ABS. LOWER LH.
- 4. 98302 BRACKET - REAR SHOCK ABS. LOWER RH.
- 5. 702602 CLIP - REAR SPRING (4)
- 6. 65198 NUT - SPRING CLIP (8)
- 7. 271758 BOLT $\frac{5}{16}$ - 18 x $4\frac{1}{2}$ (2)
- 8. 121574 L.W. $\frac{5}{8}$ MED. SPRING (2)
- 9. 121358 NUT $\frac{3}{8}$ - 18 HEX. (2)
- 10. 95634 PLATE - PIN ASM. - SHACKLE (2)
- 11. 96153 BUSHING - SPR. SHACKLE (8)
- 12. 80768 PLATE - SHACKLE (2)
- 13. 626852 NUT $\frac{1}{2}$ - 20 HEX (4)
- 14. 95651 BUMPER ASM. - REAR AXLE (2)
- 15. 626912 SCREW $\frac{5}{16}$ - 18 x $\frac{3}{4}$ HEX. (4)
- 16. 703946 SHOCK ABS. ASM. - REAR. (2)
- 17. 706089 INSULATOR (4)
- 18. 94408 WASHER - SHOCK ABS. (4)
- 19. 442828 NUT $\frac{3}{8}$ - 24 NC HEX (4)
- 20.



- △ 1 30 - 35 FT. LBS. TORQUE
- △ 2 45 - 55 FT. LBS. TORQUE
- △ 3 75 - 85 FT. LBS. TORQUE

CHECKER MOTORS CORP. KALAMAZOO, MICH.

EFFECTIVE MODEL YEAR 1974

SHEET NO. 380 B-12

DWN. DEKER
CHK.

APPVD. SUPERSEDES GI. 550 A-8

GRAPHIC ILLUSTRATION

SUSPENSION - HELPER SPRING

DATE

6-7-73

MODEL: B-11 B-11E
B-12 B-12E
B-12W

- 1. 703221 SPRING ASSEM. - LEVELATOR (2)
- 2. 704374 BUMPER (4)
- 3. 704375 PLATE - LEVELATOR CROSS (4)
- 4. 704376 "U" BOLT (2)
- 5. 98326 CLIP - REAR SPRING (4)
- 6. 120382 L.W. $\frac{3}{8}$ MED. SPRING (12)
- 7. 120377 NUT $\frac{3}{8}$ -16 HEX. (12)

FURN. IN KIT
NO. 97399

