

September 21, 1965
Revised 12-6-65
Revised 3-4-66

ENGINEERING MEMO #123

TO: Memo Distribution
FROM: S. Wilson
SUBJECT: A-12E LIMO. TRIM

The following revision is to be incorporated as soon as possible at the request of management.

A. FRONT SEAT CUSHION

1. Reduce the quantity of cotton (MH-125)
2. Change 1-1/2" Pad to 3/4" Thick
3. Remove Muslin Sheeting (MH-109)

B. REAR SEAT BACK

1. Increase Cotton Batt qty. from (1) to (2)
2. Change 1-1/2" Pad to 3/4" Thick
3. Remove Muslin Sheeting (MH-109) & MH-129 Pad
4. Cancel Foam Rubber Pads 642273 & 642274
5. Standardize on Cloth facings and Vinyl boxings eliminating the need for two different types of Rear Backs.
6. Springs to be redesigned to conform to new armrest

C. REAR SEAT CUSHION

1. Reduce the quantity of cotton (MH-125)
2. Change 1-1/2" Pad to 3/4" Thick
3. Remove Muslin Sheeting (MH-109)
4. Standardize on cloth facings and Vinyl boxings eliminating the need for two different types of Rear Backs

D. REAR QUARTER TRIM

1. Cancel Foam Rubber Pads 642255 & 6
2. Cancel Hardboard 642101 & 2
3. Cancel Stnls. Stl. Retainer 642089
4. Reduce Usage of 145173 #4 Screws
5. Release new design similar to A-12, A-12E "Sedan"

E. REAR QUARTER LINER

1. Cancel Foam Rubber Pads 642373 & 4
2. Cancel Stl. Liner 642221 & 2
3. Release new design similar to A-12, A-12E "Sedan"

F. SHELF TRIM

1. Remove MH-130 Treated Felt
2. Add MH-131 Fabric & Wadding

ENGINEERING MEMO #123 (Cont'd)

G. SUN VISOR

1. Remove ME-188 Trim
2. Add ME-240 Trim (Lighter Weight)

H. HEADLINING-Black Vinyl

1. Remove ME-188 Trim
2. Add ME-240 Trim (Lighter Weight)

J. LIMO PARTITION

1. Remove MH-130 Felt
2. Remove 104880 Tack
3. Replace 104881 Tack with Staples
4. Add 626725 Button & 626726 Prong (12)
5. Add MH-132 1/4" Sponge Rubber
6. Eliminate ME-188 Binding From Carpet

K. DOOR TRIM PANELS

1. Eliminate Inserts
2. Replace 642257, 58, 59&60 Purch. Pad with MH-132 1/4" Sp. Rubber
3. Add Carpet to Code 18 Frt. Door Trim Panel
4. Standardize Rear Door Trim Panels for Codes 17 and 18. Both to have ME-214 cloth and ME-200 Gray Carpet
5. Add 626725 Button & 626726 Prong (22 Per Job)

L. REAR FLOOR MAT

1. Replace Black Carpet & Binding ME-203 & ME-207 with Gray Carpet & Binding ME-200 & ME-208 for Partition Jobs.

M. WIDE AUXILIARY SEATS

1. Replace Black Carpet & Binding ME-203 & ME-207 with Gray Carpet & Binding ME-200 & ME-203 for Partition Jobs.

N. REAR OUTER ARMRESTS

1. Replace all cloth for Partition jobs with a cloth & Vinyl combination same as without a partition.
2. New design to be similar to A-12

P. REAR CENTER ARMRESTS

1. Replace all cloth for Partition jobs with a cloth & Vinyl combination same as without a Partition

Consolidated list of parts affected will follow.

ADDITION TO ENGINEERING MEMO #123REAR SEAT BACKS & OUTER ARMRESTS

ITEMS TO BE AFFECTED IN GROUP B-52.28, B-52.29 & B-52.32

| PART NAME | MAKE OR BUY | OLD PART NO. | NEW PART NO. | I | A | REMARKS |
|--------------------------------------|-------------|--------------|--------------|-----|-----|------------------|
| SPRING ASSEM-Rr.St.Bk.LH Limo | M | 641067 | 641287 | NO | YES | Rework |
| SPRING ASSEM-Rr.St.Bk.RH Limo | M | 641068 | 641288 | NO | YES | Rework |
| PANEL-Rr.A/Rest Low. LH | M | 642077 | | NO | YES | Service or Scrap |
| PANEL-Rr.A/Rest Low. RH | M | 642078 | | NO | YES | Service or Scrap |
| PANEL-Rr.A/Rest Upper LH | M | 642095 | | NO | YES | Service or Scrap |
| PANEL-Rr.A/Rest Upper RH | M | 642096 | | NO | YES | Service or Scrap |
| LATEX FOAM RUBBER-3/8" | B | MH-129 | | | YES | Decrease Usage |
| LATEX FOAM RUBBER-1/2" | B | MH-129 | | | YES | Decrease Usage |
| RETAINER-Rr.A/Rest Side | M | 642097 | - - - | NO | YES | Service or Scrap |
| SCREW-#8 x 1/2 PHCR Type "A" Tapp. | B | 626611 | | | YES | Decrease Usage |
| RETAINER-Rr.A/Rest Bottom | M | 642094 | - - - | | YES | Service or Scrap |
| SCREW-#8 x 1/2 PHCR Type "A" Tapp. | B | 626611 | | | YES | Decrease Usage |
| WASHER-Prestitite Sealer | B | 626453 | | YES | YES | Decrease Usage |
| VENTI FOAM RUBBER-1-1/2" Thick | B | MH-124 | | YES | YES | Decrease Usage |
| VENTI FOAM RUBBER-3/4" Thick | B | | MH-133 | | | New Item |
| SHEETING-Unbleached Muslin | B | MH-109 | - - - | | YES | Service or Scrap |
| PAD-Rr.St.Bk.Outer-Upper | B | 642273 | MH-133 | NO | YES | Service or Scrap |
| PAD-Rr.St.Bk.Outer-Upper | B | 642274 | MH-133 | NO | YES | Service or Scrap |
| COTTON BATT.-6 Oz. | B | 634628 | | YES | YES | Increase Usage |
| SCREW-#14 x 1/2 PHCR Type "A" Tapp. | B | 9411537 | | YES | YES | Increase Usage |
| BK.ASSEM-Rr.St.LH-M.Gry | M | 641653 | 641761 | NO | YES | Service or Scrap |
| BK.ASSEM-Rr.St.RH-M.Gry | M | 641654 | 641762 | NO | YES | Service or Scrap |
| BK.ASSEM-Rr.St.LH M.Gray.Cl. | M | 641645 | 641761 | NO | YES | Service or Scrap |
| BK.ASSEM-Rr.St.PH-M.Gry.Cl. | M | 641646 | 641762 | NO | YES | Service or Scrap |
| COVER ASSEM-Rr.St.Bk.-LH-M. Gry | M | 641655 | 641763 | NO | YES | Service or Scrap |
| COVER ASSEM-Rr.St.Bk.PH-M.Gry | M | 641656 | 641764 | NO | YES | Service or Scrap |
| COVER ASSEM-Rr.St.Bk.-LH M. Gry. Cl. | M | 641647 | 641763 | NO | YES | Service or Scrap |
| COVER ASSEM-Rr.St.Bk.-RH M. Gry.Cl. | M | 641648 | 641764 | NO | YES | Service or Scrap |

REAR SEAT BACKS & OUTER ARMRESTS

ITEMS TO BE AFFECTED IN GROUP B-52.28 & B-52.29

| PART NAME | MAKE OR BUY | OLD PART NO. | NEW PART NO. | I | A | REMARKS |
|-------------------------------------|-------------|--------------|--------------|-----|-----|------------------|
| | | | | | | Service or Scrap |
| FABRIC-Med. Gray | B | ME-214 | | | | Decrease Usage |
| COATED FABRIC-Charcoal #PR-30 | B | ME-221 | | | | Increase Usage |
| PAN.ASSEM-Rr.A/Rest Low.LH-Gry | M | 641907 | | NO | YES | Service or Scrap |
| PAN.ASSEM-Rr.A/Rest Low.RH-Gry | M | 641908 | | NO | YES | |
| PAN.ASSEM-Rr.A/Rest Low.LH-M.Gray | M | 641649 | 641793 | NO | YES | |
| PAN. ASSEM-Rr.A/Rest Low.RH-M. Gray | M | 641650 | 641794 | NO | YES | |
| PAN. ASSEM-Rr.A/Rest Up.LH-M. Gray | M | 641657 | | NO | YES | |
| PAN. ASSEM-Rr.A/Rest Up.RH-M. Gray | M | 641658 | | NO | YES | |
| COV.ASSEM-Rr.A/Rest Up. LH-M. Gry. | M | 641659 | | NO | YES | |
| COV.ASSEM-Rr.A/Rest Up. RH-M. Gry. | M | 641660 | | NO | YES | |
| CAP-Rr.A/Rest Pan. LH Limo. | M | - - - | 642217 | NO | YES | MAKE FR. 642673 |
| CAP-Rr.A/Rest Pan.-RH-Limo | M | - - - | 642218 | NO | YES | MAKE FR. 642674 |
| PAN.-Rr.A/Rest LH-Limo | M | - - - | 642233 | NO | YES | MAKE FR. 642651 |
| PAN.-Rr.A/Rest RH-Limo | M | - - - | 642234 | NO | YES | MAKE FR. 642562 |
| PAN.ASSEM-Rr.A/Rest LH-Limo | M | - - - | 641665 | NO | YES | |
| PAN ASSEM-Rr.A/Rest RH-Limo | M | - - - | 641666 | NO | YES | |
| PLATE-Rear Armrest-100 | M | - - - | 642432 | | | New Item |
| PANEL-Rr.A/Rest Frt. LH | M | | 642707 | NO | YES | Increase Usage |
| PANEL-Rr.A/Rest Frt. RH | M | | 642708 | NO | YES | Increase Usage |
| PLATE-Arm Rest Cover | M | - - - | 642398 | NO | YES | New Item |
| LIMO. PARTITION | | | | | | |
| B/M Grp. #B-171.2 | | | | | | |
| PART NAME | MAKE OR BUY | OLD PART NO. | NEW PART NO. | I | A | REMARKS |
| PART. ASSEM-Sliding Gl. (Comp.) | M | 641744 | 641840 | NO | YES | Service or Scrap |
| STAPLE-50 Ga. #5-1/2 Wide Crown | B | 626598 | | YES | YES | Increase Usage |
| TACK-#8 Trimmers | B | 104880 | | YES | YES | Decrease Usage |
| TACK-#10 Trimmers | B | 104881 | | YES | YES | Decrease Usage |
| LATEX SPONGE RUBBER-1/4" | B | MH-130 Felt | MH-132 | | | |

ADDITION TO ENGINEERING MEMO #123

Parts to be affected by A-12E Limo. Trim Revision

DOOR TRIM PANELS

B/M GRP. NO. B-7017 & B-7018

| PART NAME | MAKE OR BUY | OLD PART NO. | NEW PART NO. | I | A | REMARKS |
|-------------------------------------|-------------------|--------------------|--------------------|-----|-----|------------------------|
| PAD-Frt.Dr.Trim Pan.Low.-Limo. LH | B | 642257 | MH-132 | NO | YES | SERVICE OR SCRAP |
| PAD-Frt.Dr.Trim Pan.Low-Limo RH | B | 642258 | MH-132 | NO | YES | |
| PANEL-Frt.Dr.Tr.Insert-Limo | M | 642000 | - - - | NO | YES | |
| RETAINER-Dr.Tr.Pan.Insert-Limo | M | 642098 | - - - | NO | YES | |
| STRIP-Dr.Tr.Pan.Insert Ret. | B | 642183 | - - - | NO | YES | |
| PAD-Dr.Trim Insert | B | 642252 | - - - | NO | YES | |
| PAD-Rr.Dr.Trim LH-129 W.B. | B | 642259 | MH-132 | NO | YES | |
| PANEL-Rr.Dr.Trim Insert | M | 642210 | - - - | NO | YES | |
| PAD-Rr.Dr.Trim Insert-129 W.B. | B | 642253 | - - - | NO | YES | |
| PANEL ASSEM-Frt.Dr.Tr.LH-M.Gry. Cl. | M | 641679 | 641545 | NO | YES | |
| PAN.ASSEM-Frt.Dr.Tr.RH-M.Gry. Cl. | M | 641680 | 641546 | NO | YES | |
| PAN.ASSEM-Frt.Dr.Tr.LH-Blk. V. | M | 641823 | 641541 | NO | YES | |
| PAN.ASSEM-Frt.Dr.Tr. RH-Blk.V | M | 641824 | 641542 | NO | YES | |
| INSERT ASSEM-Frt.Dr.Tr.-Gray | M | 641677 | - - - | NO | YES | |
| PAN.ASSEM-Rr.Dr.Trim LH-Gray | M | 641675 | 641551 | NO | YES | |
| PAN.ASSEM-Rr.Dr.Trim RH-Gray | M | 641676 | 641552 | NO | YES | |
| PAN.ASSEM-Rr.Dr.Trim-LH-Gray Cl. | M | 641669 | 641551 | NO | YES | |
| PAN.ASSEM-Rr.Dr.Trim RH-Gray Cl. | M | 641670 | 641552 | NO | YES | |
| INSERT ASSEM-Rr.Dr.-Gray Cl. | M | 641673 | - - - | NO | YES | |
| INSERT ASSEM-Rr.Dr.-Gray Cl. | M | 641671 | - - - | NO | YES | |
| CARPET-Black | B | ME-203 | - - - | YES | YES | Revise Usage |
| BINDING-Blk. Carpet | B | ME-207 | - - - | YES | YES | Revise Usage |
| CARPET-Med. Gray | B | ME-200 | - - - | YES | YES | Revise Usage |
| BINDING-Gray Carpet | B | ME-208 | - - - | YES | YES | Revise Usage |
| BUTTON ASSEM-#30 Tack Type | B | - - - | 626725 | YES | YES | New Item |
| PRONG-1-1/2" | B | - - - | 626726 | YES | YES | New Item |
| LATEX SPONGE RUBBER-1/4" | B | - - - | MH-132 | YES | YES | Increase Usage |
| FACING ASSEM-Frt.Dr.Tr.Lower-Gr. LH | M | - - - | 641547 | | | |
| FACING ASSEM-Frt.Dr.Tr.Lower-Gr. RH | M | - - - | 641548 | | | |
| FACING ASSEM-Frt.Dr.Tr.Lower-Blk.LH | M | - - - | 641543 | | | |
| FACING ASSEM-Frt.Dr.Tr.Lower-Blk.RH | M | - - - | 641544 | | | |
| FACING ASSEM-Rear Dr.Tr.Lower-Gr.LH | M | - - - | 641553 | | | |
| FACING ASSEM-Rear Dr.Tr.Lower-Gr.RH | M | - - - | 641554 | | | |
| PANEL ASSEM-Rr.Dr.Tr.Upper-Gr. LH | M | 641667 | 641945 | NO | YES | Revise |
| PANEL ASSEM-Rr.Dr.Tr.Upper-Gr. RH | M | 641668 | 641946 | NO | YES | Usage |

ADDITION TO ENGINEERING MEMO #123

MISC. TRIM ITEMS
GRP. NO. B-56.7, B-56.13 & B-54.3

| PART NAME | MAKE OR BUY | OLD PART NO. | NEW PART NO. | I | A | REMARKS |
|-------------------------------------|--------------|--------------|-------------------|---------------|----------------|---------------------------|
| PANEL ASSEM-Shelf Trim | M | 641792 | 641870 | NO | YES | Ser. or Scr. |
| PANEL-Rear Quarter Trim LH | M | 642101 | 642675 | NO | YES | Service or Scrap |
| PANEL-Rear Quarter Trim RH | M | 642102 | 642676 | NO | YES | |
| PAD-Rear Quarter Trim-Limo.LH | B | 642255 | - - - | NO | YES | |
| PAD-Rear Quarter Trim-Limo.RH | B | 642256 | - - - | NO | YES | |
| RETAINER-Rear Quarter Trim | B | 642089 | - - - | NO | YES | |
| SCREW-#4 x 1/4 PH.SL. TAPP. | B | 145173 | - - - | NO | YES | Decrease Usage |
| PANEL-Rr.Qtr.Liner Tr. LH | M | 642221 | - - - | | YES | Service or Scrap |
| PANEL-Rr.Qtr.Liner Tr. RH | M | 642222 | | | YES | |
| PAD-Rr.Qtr.Liner Tr. LH | B | 642373 | | | YES | |
| PAD-Rr.Qtr.Liner Tr. RH | B | 642374 | | | YES | |
| PAN. ASSEM-Rr.Qtr.Tr.LH Gray | M | 641867 | | NO | YES | |
| PAN. ASSEM-Rr.Qtr.Tr. RH Gray | M | 641868 | 643867 | NO | YES | |
| PAN. ASSEM-Rr.Qtr.Tr. LH-M.Gry. | M | 641789 | 643868 | NO | YES | |
| PAN. ASSEM-Rr.Qtr.Tr. RH-M.Gry. | M | 641790 | | NO | YES | |
| SUN VISOR ASSEM-Blk. V. | M | 641878 | 641672 | NO | YES | |
| EXT. Rr.Qtr.Tr.Panel LH | M | | 640047 | NO | YES | Increase Usage |
| EXT. Rr.Qtr.Tr.Panel RH | M | | 640048 | NO | YES | Increase Usage |
| PAN.ASSEM-Rr.Qtr.Trim LH | M | | 641291 | NO | YES | Increase Usage |
| PAN.ASSEM-Rr.Qtr.Trim RH | M | | 641292 | NO | YES | Increase Usage |
| FELT-1/8" Thick | B | MH-130 | - - - | YES | YES | Decrease Usage |
| PADDING-Non Woven Fabric | B | | MH-131 | YES | YES | Increase Usage |
| TRIM-Rear Pillar LH/RH | M | | 644025&6 | | | New |
| REAR FLOOR MAT B/M GRP. #B-16.11 | | | | | | |
| PART NAME | MAKE OR BUY | OLD PART NO. | NEW PART NO. | I | A | REMARKS |
| MAT ASSEM-Rr.Fl.-Blk W/Part | M | 641849 | 641705 | | | Service or Scrap |
| CARPET-ASSEM-Rr.St.Riser-Blk | M | 641848 | 641846 | | | Service or Scrap |

ADDITION TO ENGINEERING MEMO #123

REAR SEAT CUSHION
B/M GRP. #B-53.28, B-53.29 & B-72.16

| PART NAME | MAKE OR BUY | OLD PART NO. | NEW PART NO. | I | A | REMARKS |
|----------------------------------|-------------|--------------|--------------|-----|-----|------------------|
| SPRING ASSEM-Rr.St.Cush.-Limo | M | 641122 | Chg. H | NO | YES | Rework |
| COTTON-30" Wide 24 Oz. | B | MH-125 | | YES | YES | Decrease Usage |
| CUSH.ASSEM-Rr.St.-M.Gray | M | 641641 | 641760 | NO | YES | Service or Scrap |
| CUSH.ASSEM-Rr.St.-M.Gry.Cl. | M | 641643 | 641760 | NO | YES | |
| COVER ASSEM-Rr.St.Cush.-M.Gray | M | 641642 | 641769 | NO | YES | |
| COVER ASSEM-Rr.St.Cush.-M.Gry.Cl | M | 641644 | 641769 | NO | YES | |

HEADLINING
B/M GRP. #B-59.12

| PART NAME | MAKE OR BUY | OLD PART NO. | NEW PART NO. | I | A | REMARKS |
|----------------------------------|-------------|--------------|--------------|-----|-----|--------------|
| Hd/Lng.ASSEM-129WB Blk.V.&Gry.Cl | M | 641162 | 641807 | YES | YES | Use |
| COATED FABRIC-Black Premiere | B | ME-188 | | NO | YES | Reduce Usage |
| COATED FABRIC-Blk.Hd/Lng. | B | - - - | ME-240 | NO | YES | New Item |

FOLDING REAR ARMRESTS
B/M GRP. #B-61.5 & #B-170.5

| PART NAME | MAKE OR BUY | OLD PART NO. | NEW PART NO. | I | A | REMARKS |
|----------------------------------|-------------|--------------|--------------|-----|-----|------------------|
| A/REST ASSEM-Rr.St.Ctr.-Gry Cl. | M | 641638 | - - - | NO | YES | Service or Scrap |
| A/REST ASSEM-Rr.St.Ctr.-M.Gry. | M | | 641635 | NO | YES | Increase Usage |
| A/REST ASSEM-Sht.Rr.Ctr.-M.Gr.Cl | M | 641626 | - - - | NO | YES | Service or Scrap |
| A/REST ASSEM-Sht.Rr.Ctr.-M.Gr. | M | | 641628 | NO | YES | Increase Usage |
| COV.ASSEM-Rr.Ctr.A/Rest-Gr.Cl. | M | 641639 | - - - | NO | YES | Service or Scrap |
| COV.ASSEM-Rr.Ctr.A/Rest-M.Gr. | M | | 641636 | NO | YES | Increase Usage |
| COV.ASSEM-Sht.Rr.Ctr.A/R.M.Gr.Cl | M | 641625 | - - - | NO | YES | Service or Scrap |
| COV.ASSEM-Sht.Rr.Ctr.A/R.M.Gr.Cl | M | | 641627 | NO | YES | Increase Usage |
| FABRIC-Med. Gray Cloth | B | ME-214 | - - - | YES | YES | Decrease Usage |
| COATED FABRIC-Charcoal | B | ME-221 | - - - | YES | YES | Increase Usage |