

April 5, 1966

ENGINEERING MEMO #144

TO: Memo Distribution
FROM: S. Hori
SUBJECT: GRILLE REVISION (ALL MODELS)

At the request of both the Tooling and Production departments (with Management approval), a grille revision is being made. The change is primarily to improve manufacturing technique by eliminating some metal finishing and greatly improving the polishing & stacking conditions. A cost reduction is also anticipated along with a better quality grille surface. The mounting brackets will be eliminated from the Grille assembly and studs will be welded to the grille panel after chrome plating.

The new Grille Assembly (Panel & Studs) is interchangeable with the old Grille Assembly (Panel & Brackets). However, the new grille must also have the new center mounting bracket. For the older type model A-11 grilles (cars with Continental Engines), a special center mounting bracket will be supplied for service requirements.

Following is a list of the new and old parts affected:

- | | | | |
|--------|---|---|-----|
| 643892 | Grille Assem.-Complete | } | NEW |
| 643891 | Panel Assem.-Grille (Welded) | | |
| 644033 | Panel-Grille | | |
| 626764 | Stud-1/4-20 x 1/2 (AW) KSM Non- Flanged | | |
| 626765 | Stud-1/4-20 x 1-1/2(AW) KSM Non-Flanged | | |
| 644034 | Bracket-Grille Lower | | |
| 120380 | Lockwasher-1/4 Med. Spring (Increase Usage) | | |
| 120375 | Nut-1/4-20 Hex. (Increase Usage) | | |
| | | | |
| 641504 | Grille Assem.-Complete | } | OLD |
| 641505 | Panel Assem-Grille (Welded) | | |
| 640000 | Panel-Grille | | |
| 631324 | Bracket Assem.-Grille | | |
| 630085 | Bracket-Grille | | |
| 625192 | Bolt-1/4-20 x 3/4 Ohio Weld #HW-2112 | | |
| 640563 | Bracket-Grille Lower | | |

NOTE: From the above list parts: #643891, #644034, #120380, & # 120375 are used to replace #641505

The special mounting bracket for the older model A-11 Grilles (on cars with Continental Engines) is:

#644035 - Bracket-Grille Lower (Special For Service)

This revision incorporated on the following Chassis No.

- A-11, A-12 Models-Chassis 42848
- A-12W6 & 8 Models Chassis 2165

TO: Memo Distribution
FROM: B. Lewis
SUBJECT: GRILLE REVISION (ALL MODELS)

At the request of the Tooling and Production Departments, the grille mounting is being revised. This change will eliminate any welding of attaching parts to the grille panel.

For a short period (until changes "A", "B", & "C" on 644033 can be incorporated) production will revert to the original mounting method using the following parts.

- 641504 Grille Assem-Complete
 - 641505 Panel Assem-Grille (Welded)
 - 644033** Panel Grille (Before Changes "A", "B" & "C")
 - 631324 Bracket Assem-Grille
 - 630085 Bracket-Grille
 - 625192 Bolt-1/4-20 x 3/4 Ohio Weld #HW-2112
 - 640563 Bracket-Grille Lower
 - 120380 Lockwasher-1/4 Med. Spring
 - 626322 Washer-5/16 I.D. x 7/8 O.D. x .065
 - 120375 Nut-1/4-20 Hex.
- } Grille Outer to Fender

The following parts will be used when tooling is revised and the supply of old Grille Panels is exhausted.

- 643892 Grille Assem-Complete (Changes "A" & "B")
 - * 644033 Panel-Grille (Changes "A", "B" & "C")
 - * 189129 Screw-1/4-20 x 5/8 Truss Hd.
 - * 120375 Nut-1/4-20 Hex.
 - * 120380 Lockwasher-1/4 Med. Spring
 - * 644034 Bracket-Grille Lower
 - * 626771 Screw-1/4-20 x 1-1/2 O.H.C.R. Mach. Stainless Steel
 - 120380 Lockwasher-1/4 Med. Spring
 - 626322 Washer-5/16 I.D. x 7/8 O.D. x .065
 - 120375 Nut-1/4-20 Hex.
- } Grille Outer to Fender

SERVICE INFORMATION

No Service problem is anticipated as replacement of Grille Panel Assemblies 641505 or 643891 can be made by using in combination the new Grille Panel and the attaching parts noted above by *.

For Service of older A-11 models (Cars with Continental engines) previously released 644035 Bracket (Special for Service) should be substituted for 644034 Bracket.

This Revision Incorporated on the Following Chassis No. A-11, A-12
Models-Chassis #44570 A-12W6M, A-12W8M Chassis #2254