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TO: Memo Distribution  
 FROM: R. E. Orwig  
 SUBJECT: CHASSIS FRAME REVISIONS FOR 1968 PRODUCTION

The Chassis Frames are being redesigned to be strengthened in some areas. These changes are basic and will effect frames for all models. The effective point for these changes will be January 1, 1968.

Following is a list of the chassis parts affected:

NAME	B or M	OLD PART NO.	NEW PART NO.	I	A	REMARKS
Frame Assembly-Complete(Basic)	M	-----	703158	NO	NO	NEW PART
Frame Assembly-Complete (6-Cyl. Eng)	M	701350	701984	NO	NO	SERVICE
Reinf. Assem.-Frame Side Rail-Frt. LH	M	701009	701983	NO	NO	REWORK - AS REQ'D.
Reinf.-Frame Side Rail-Frt. LH (Reworked)	M	702015	704203	NO	YES	NEW PART
Reinf.-Frame Side Rail-Frt. LH (Purch.)	B	702015	-----	NO	NO	USE
Reinf.-Frame Side Rail-Frt. RH (Reworked)	M	702016	704204	NO	YES	NEW PART
Reinf. Frame Side Rail-Frt. RH (Purch.)	B	702016	-----	NO	NO	USE
"X"-Crossmember-Frame - LH	B	92379	704185	NO	NO	REWORK - AS REQ'D.
"X"-Crossmember-Frame - RH	B	92378	704186	NO	NO	REWORK - AS REQ'D.
Bracket-Body Frame-Inner	M	702019	-----	NO	NO	SERVICE OR SCRAP
Bracket-Aux. Seat Anchor	M	702093		NO	YES	INCREASE USAGE
Bracket-Rear Eng. Supt. Frame-LH	M	702057	704169	NO	NO	SERVICE OR SCRAP
Bracket-Rear Eng. Supt. Frame-RH	M	702058	704170	NO	NO	SERVICE OR SCRAP
Bracket Assem.-Battery Supt. Frame	M	-----	701985	--	--	NEW PART
Bracket-Battery Support - Frame	M	-----	704189	--	--	NEW PART
Support Assem.-Engine Mtg. Rear	M	701099	701842	NO	NO	SERVICE
Support-Engine Mtg. Rear	M	702060	704164	NO	NO	SERVICE
Bracket Assem.-Parking Brk. Lever	M	701124	701578	NO	NO	SERVICE
Bracket-Parking Brake Lever	M	702151	704176	NO	NO	SERVICE
Frame Assem.-Complete-129" W.B.	M	701352	701997	NO	NO	SERVICE
Frame Sub. Assem.-129" W.B.	M	701351	701996	NO	NO	REWORK - AS REQ'D.
"X" Crossmember-Frame LH	M	98495	704209	NO	NO	REWORK - AS REQ'D.
Filler - "X" Crossmember to Front Reinforcement	M		704367	NO	NO	TEMPORARY NEW PART

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	NAME	B OR M	OLD PART NO.	NEW PART NO	I	A	REMARKS
	"X" Crossmember-Frame RH	M	98496	704210	NO	NO	REWORK - AS REQ'D.
	Frame Assem.-Complete (154 $\frac{1}{2}$ " W.B.)	M	701354	701988	NO	NO	USE
	Frame Assem.-Complete (189" W.B.)	M	701355	701989	NO	NO	USE
	Frame Sub.Assem.-327 V-8 Eng.	M	701356	701987	NO	NO	USE
A	Bracket-Parking Brake Cable Frame	M	94780	-----	YES	YES	CHANGE "B"
BA	Frame Assem.-Complete (V-8 Eng.)	M	701350	701999	NO	NO	SERVICE
B	Reinf. Frame to Front Body Bracket	M	702821 702822	704243	NO	NO	SERVICE OR SCRAP
C	Reinf.-Dash Supt. Frame Brkt.	M	-----	704289	NO	YES	NEW PART
C	Spacer-Side Rail to Reinf.	M	-----	704292	NO	YES	NEW PART
C	Rail Assem.-Frame Side LH	M	701017	-----	YES	YES	CHANGE "G"
C	Rail Assem.-Frame Side RH	M	701018	-----	YES	YES	CHANGE "G"
C	Reinf.-Frame Engine Mtg. Brkt.-Frt.	M	-----	704287	NO	YES	NEW PART
KC	Brkt. Assem.-Frame Engine Mtg. Frt. LH	M	-----	703161	NO	YES	NEW PART
KC	Brkt. Assem.-Frame Engine Mtg. Frt. RH	M	-----	703162	NO	YES	NEW PART
C	Crossmember Assem.-Frt. Susp Fr-Rr.	M	701345	-----	YES	YES	CHANGES "A&B"
C	Brkt.-Frame Engine Mtg.-Front LH	M	702467	-----	YES	YES	CHANGE "C"
C	Brkt.-Frame Engine Mtg.-Front RH	M	702468	-----	YES	YES	CHANGE "C"
E	Extension - Exhaust Pipe	M	702412	704348	NO	YES	SERVICE
E	Extension - Exhaust Pipe	M	702380	704349	NO	YES	SERVICE
G	Extension - Exhaust Pipe (Diesel)	M	704265	Chg. A&B	NO	YES	REWORK
G	Connector-Exh. Pipe Flex Tube (Diesel)	M	704224	Chg. A	NO	YES	REWORK
I	Frame Assem.-Complete-6 Cyl. 129 WB	M	701352	703219	NO	YES	SERVICE
I	Frame Assem.-Complete -V-8 Eng. 129 WB	M	701352	703220	NO	YES	SERVICE

## ADDITION TO ENG. MEMO #196

NAME	B OR M	OLD PART NO.	NEW PART NO.	I	A	REMARKS
Underbody Assem.Comp: Welded	M	641452	645423	NO	NO	REWORK AS REQ.
Pan Assem.-Front Floor	M	641453	645424	NO	NO	REWORK AS REQ.
Pan-Front Floor	M	640522	644304	NO	NO	REWORK AS REQ.
Member Assem.-Floor Pan Frt.Cross	M	633279	645425	NO	NO	REWORK AS REQ.
Member & Nut Assem.-Flr.Pan Frt.Cross	M	633276	645426	NO	NO	REWORK AS REQ.
Member-Floor Pan Front Cross	M	634382	644303	NO	NO	REWORK AS REQ.
Underbody Assem.-Floor Shift	M	641530	645427	NO	NO	REWORK AS REQ.
Pan Assem.-Frt.Flr.(Floor Shift)	M	641533	645428	NO	NO	REWORK AS REQ.
Pan-Frt.Floor(Floor Shift)	M	640599	644349	NO	NO	REWORK AS REQ.
Member Assem.-Frt.Cross LH (Flr.Shift)	M	633909	645431	NO	NO	REWORK AS REQ.
Member Assem.-Frt.Cross RH(Flr.Shift)	M	633910	645430	NO	NO	REWORK AS REQ.
Underbody Assem.-Aux.St.(Col.Shift)	M	641454	645432	NO	NO	REWORK AS REQ.
Pan Assem.-Frt.Flr.Aux.Seat	M	641455	645433	NO	NO	REWORK AS REQ.
Underbody Assem.-Flr.Shift W/Aux.St.	M	641531	645434	NO	NO	REWORK AS REQ.
Pan A.-Frt.Flr.(Flr.Shift W/Aux.Sts.)	M	641534	645435	NO	NO	REWORK AS REQ.
Underbody Assem.-Rear St.Fwd.	M	641456	645436	NO	NO	REWORK AS REQ.
Underbody Assem.-Col.Shift W/O Aux.St.	M	643181	645438	NO	NO	REWORK AS REQ.
Underbody A.-Flr.Shift W/O Aux.Sts.	M	643179	645439	NO	NO	REWORK AS REQ.
Underbody A.-Col.Shift W/Aux. Seats	M	643182	645440	NO	NO	REWORK AS REQ.
Underbody A.-Flr.Shift W/Aux.Seats	M	643180	645441	NO	NO	REWORK AS REQ.
Pan-Frt.Flr.(Eaton Air Cond.)	M	634399	644353	NO	NO	REWORK AS REQ.
Pan-Frt.Flr.(Air Cond.)	M	642726	644352	NO	NO	REWORK AS REQ.
Pan A.-Frt.Flr.(Bucket St.)	M	643848	645472	NO	NO	REWORK AS REQ.
Pan A.-Frt.Flr.(Twin Bucket Sts.)	M	645016	645473	NO	NO	REWORK AS REQ.
Underbody A.-Rear St.Fwd.	M	641532	645437	NO	NO	REWORK AS REQ.

## ENG. MEMO #196 (Cont'd.)

NAME	B OR M	OLD PART NO.	NEW PART NO.	I	A	REMARKS
Balloon & Underbody A.Rework Chev.6	M	637441	645453	NO	NO	REWORK AS REQ.
Balloon & Underbody A.Flr.Shift	M	641457	645454	NO	NO	REWORK AS REQ.
Balloon & Underbody A.-Auto.Trans.	M	641462	645455	NO	NO	REWORK AS REQ.
Balloon & Und.A.-Aux.Sts.Flr.Shift	M	641461	645456	NO	NO	REWORK AS REQ.
Balloon & Und.A.-Aux.Sts.Auto.Trans.	M	641538	645457	NO	NO	REWORK AS REQ.
Balloon & Und.A.RR St. Fwd.(Flr.Shift)	M	641464	645442	NO	NO	REWORK AS REQ.
Balloon & Und.A.RR St.Fwd. Auto.Trans.	M	641539	645443	NO	NO	REWORK AS REQ.
Balloon & Und.A.W/O Aux. Sts.	M	641459	645458	NO	NO	REWORK AS REQ.
Balloon & Und.A. Aux. Seats	M	641463	645459	NO	NO	REWORK AS REQ.
Balloon & Und. A.Flr.Shift	M	643068	645460	NO	NO	REWORK AS REQ.
Balloon & Und. A.Flr.Shift-Aux.Sts.	M	643069	645461	NO	NO	REWORK AS REQ.
Underbody Assem.Complete(Welded)	M	639903	645466	NO	NO	REWORK AS REQ.
Underbody Assem.-Compl.-Flr.Shift	M	639986	645449	NO	NO	REWORK AS REQ.
Balloon & Underbody Assem.	M	639904	645467	NO	NO	REWORK AS REQ.
Balloon & Underbody Assem.-Flr.Shift	M	639987	645450	NO	NO	REWORK AS REQ.
Underbody Assem.-Complete	M	639923	645468	NO	NO	REWORK AS REQ.
Underbody Assem.-Partial	M	639924	645469	NO	NO	REWORK AS REQ.
Pan Assem.-Frt.Flr.Partial Chev.V-8	M	639925	645470	NO	NO	REWORK AS REQ.
Pan-Front Floor Chev. V-8	M	640799	644740	NO	NO	REWORK AS REQ.
Underbody Assem.-Compl.Chev. V-8	M	639930	645471	NO	NO	REWORK AS REQ.
Balloon & Und.Assem.-6-Door	M	639992	645451	NO	NO	REWORK AS REQ.
Balloon & Und.Assem.-8-Door	M	639994	645452	NO	NO	REWORK AS REQ.
Underbody Assem.-Complete (Welded)	M	641096	645462	NO	NO	REWORK AS REQ.
Pan Assem.-Frt.Flr.Frt.	M	641094	645429	NO	NO	REWORK AS REQ.
Pan-Front Floor Front	M	642331	644350	NO	NO	REWORK AS REQ.

## ENG. MEMO #196 (Cont'd.)

NAME	B OR M	OLD PART NO.	NEW PART NO.	I	A	REMARKS
Underbody Assem.-Flr.Shift 129WB	M	643035	645463	NO	NO	REWORK AS REQ.
Pan A Frt.Flr.-Flr.Shift(129 WB)	M	643036	645464	NO	NO	REWORK AS REQ.
Pan Frt.Flr-Flr.Shift 129 W.B.	M	642344	644351	NO	NO	REWORK AS REQ.
Balloon & Und.A.-129 W.B. CAB	M	643037	645465	NO	NO	REWORK AS REQ.
Balloon & Und.A.-Flr Shift 129 W.B.	M	643039	645444	NO	NO	REWORK AS REQ.
Underbody A.-Col.Shift 129 W.B.	M	643226	645445	NO	NO	REWORK AS REQ.
Underbody A.-Flr.Shift 129 W.B.	M	643225	645446	NO	NO	REWORK AS REQ.
Balloon & Und.A.-129 WB-Col.Shift	M	641175	645447	NO	NO	REWORK AS REQ.
Balloon & Und.A.-129 WB-Flr.Shift	M	641950	645448	NO	NO	REWORK AS REQ.
Bracket Assem.-Battery Supt.Frame	M	701105		YES	YES	CHANGE"A"
Bracket-Battery Supt.-Frame	M	702139		YES	YES	CHANGE"C"
Member-Radiator Support Upper	M	640590	-----	YES	YES	CHANGE"L"
Panel Assem.-Radiator Support	M	641519	-----	YES	YES	CHANGE"K"
Panel Assem.-Rad. Support - A/C	M	645298	-----	YES	YES	CHANGE"A"
Panel-Front Fender Inner RH	M	640550	-----	YES	YES	CHANGE"E"
Wiring Harness Eng.Comp. (V-8)	B	-----	703185	NO	YES	NEW
Wiring Harness-Main Chassis	B	701640	-----	NO	YES	REDUCE USAGE
Tray A. Batt.Supt.(Left Side Mtd.)	M	-----	703184	NO	YES	NEW
Batt.Supt.A.Complete(Left Side Mtd.)	M	-----	703183	NO	YES	NEW
Tray A.Batt.Supt.(Rt. Side Mtd.)	M	701886	CHG"A"	NO	YES	REDUCE USAGE
Supt. A.Batt.Comp.(Rt. Side Mtd.)	M	701892	CHG"A"	NO	YES	REDUCE USAGE
Supt.A.Batt.(Left Side Mtd.)	M	-----	95057	NO	NO	REINSTATE
Supt.Batt. (Left Side Mtd.)	M	-----	94481	NO	NO	REINSTATE
Plate-Batt.Supt.Side (Left Side Mtd.)	M	-----	94483	NO	NO	REINSTATE
Panel-Front Fender Inner LH	M	640705	Chng"L"	YES	YES	DRILL AT ASSEM.
Plug Button-For 13/32 Dia.Hole	B	-----	626806	NO	YES	New Part

## ENGINEERING MEMO #196 (Cont'd)

	NAME	B or M	PART NO.	PART NO.	I	A	REMARKS
E	Supt.A. Batt.(Rt. Side Mtd.)	M	701103	CHG"A"	NO	YES	REDUCE USAGE
E	Plate-Batt.Supt.Side (Rt.Side Mtd.)	M	702140	CHG"A"	NO	YES	REDUCE USAGE
E	Supt. Batt. (Rt. Side Mtd.)	M	702141	CHG"A"	NO	YES	REDUCE USAGE
F	Cable Assem.-Left Side Mtd.Battery	B	701261	-----	NO	YES	REDUCE USAGE
F	Cable Assem.-Left Side Mtd.Battery	B	-----	703203	NO	YES	NEW PART
K	Extension-Exhaust Pipe No. 1	M	702274	704362	NO	YES	SERVICE
<del>MK</del>	<del>Washer-5/3 I.D. x 5/8 O.D. Plain</del>	<del>B</del>	<del>120392</del>	<del>-----</del>	<del>NO</del>	<del>YES</del>	<del>INCREASE USAGE</del>
K	Screw - 1/4-20 x 5/8 Tr.Hd.C.R.Mach	B	189129	-----	NO	YES	INCREASE USAGE
K	Nut & Ext.Tooth L/W Assem. - 1/4-20	B	271172	-----	NO	YES	INCREASE USAGE
K	Clip - "J" Type - 1/4	B	92869	-----	NO	YES	INCREASE USAGE
	Clamp-13/16 Closed Type-11/32 Bolt Hole	B	702221	-----	NO	YES	INCREASE USAGE
<del>MK</del>	<del>Screw #14 x 5/8 Rd.Hd.C.R.Type "A"</del>	<del>B</del>	<del>161711</del>	<del>-----</del>	<del>NO</del>	<del>YES</del>	<del>INCREASE USAGE</del>
	<del>Tapp.</del>						
K	Bracket-Body Frame-Kick Up	M	94171	-----	YES	YES	INCREASE USAGE
K	Bracket-Aux.Seat Anchor	M	702093	-----	NO	YES	REDUCE USAGE
K	Tube Assem.-Fuel Tank to Union	M	92724	CHANGE H thru L	NO	YES	REWORK
K	Tube Assem.-Fuel Tank to Union	M	97502	CHANGE B thru E	NO	YES	REWORK
K	Tube Assem.-Fuel Tank to Union	M	701207	CHANGE B thru E	NO	YES	REWORK
K	Tube Assem.-Union to Rr.Brake Hose	M	701899	CHANGE B thru D	NO	YES	REWORK
K	Tube Assem.-Union to Rr.Brake Hose	M	701900	CHANGE B thru D	NO	YES	REWORK
K	Loom =Horn Wire	B	855	-----	YES	YES	INCREASE USAGE
K	Loom-3/8 I.D. x 1/2 O.D. x 12"	B	702830	-----	YES	YES	DECREASE USAGE
K	Loom-3/8 I.D. x 1/2 O.D. x 15"	B	94319	-----	YES	YES	INCREASE USAGE
	Spacer-Rr.Spring Shackle Bushing	M	702807	-----	NO	YES	TEMPORARILY INCREASE USAGE

NAME	B OR M	OLD PART NO.	NEW PART NO.	I	A	REMARKS
L Frame Assem.-Complete(Basic)Rail Car	M	-----	703222	NO	YES	New Part
L Frame Sub Assem.-129"WB Rail Car	M	701620	703225	NO	YES	Service
L Frame Assem.-Complete(6 Cyl.)Rail Car	M	701526	703223	NO	YES	Service
L Frame Assem.-Complete(8 Cyl.)Rail Car	M	701526	703224	NO	YES	Service
L Frame Assem.-Complete(Basic)129" WB Rail Car	M	-----	703226	NO	YES	New Part
L Frame Assem.-Complete(8 Cyl.)129"WB Rail Car	M	701619	703228	NO	YES	New Part
L Frame Assem.-Complete(6 Cyl.)129"WB Rail Car	M	701619	703227	NO	YES	New Part
L Underbody Assy.-Col.Shift-Rail Car	M	643550	643669	NO	YES	Rework As Req'd.
L Balloon & Underbody Assy.-Rail Car	M	643546	643667	NO	YES	Rework As Req'd.
L Balloon Assy.-Rail Car	M	643549	643668	NO	YES	Rework As Req'd.
Balloon & Underbody Assy.-Pass.-Rail Car	M	-----	645646	NO	YES	New Part
L Balloon Assy.-Pass.-Rail Car	M	-----	645647	NO	YES	New Part
L Balloon & Underbody Assy.-Cab-Rail Car	M	-----	645641	NO	YES	New Part
L Balloon Assy.-Cab-Rail Car	M	-----	645642	NO	YES	New Part
L Underbody Assy.-Cab-Rail Car	M	-----	645645	NO	YES	New Part
L Frame Assem.-Cab-Side-Rail Car	M	643821 643822	645643 645644	NO	YES	Rework As Req'd.
L Frame Assem.-Pass.-Side-Rail Car	M	643833 643834	645649 645650	NO	YES	Rework As Req'd.
L Balloon & Underbody Assy.-A-11E - Rail Car	M	-----	645651	NO	YES	New Part
L Balloon Assy.-A-11E - Rail Car	M	-----	645652	NO	YES	New Part
L Underbody Assy.-A-11E - Rail Car	M	-----	645648	NO	YES	New Part
L Frame Assy. - A-11E-Side-Rail Car	M	-----	645653 645654	NO	YES	New Part
Balloon & Underbody Assy.-A-12E - Rail Car	M	-----	645655	NO	YES	New Part
L Balloon Assy.-A-12E - Rail Car	M	-----	645656	NO	YES	New Part
L Frame Assy.-A-12E-Side-Rail Car	M	-----	645657 645658	NO	YES	New Part