

ENGINEERING MEMO #309

TO: Memo Distribution

FROM: B. Lewis

SUBJECT: PRODUCT IMPROVEMENTS TO BE INCORPORATED ON NEW YORK AREA TAXICABS STARTING WITH NOVEMBER, 1971 PRODUCTION

1. At the request of Management the following changes will be made:
 - A. Increase gauge of Coil Spring Frame Seat from .090 to .119".
 - B. Increase gauge of Lower Control Arm Spring Seat from .119 to .140".
 - C. Add wire welded gusset to inside of channel on long lower control arm and wire weld the spring seat to the long support arm.
 - D. New Front Suspension Front Crossmember and mounting hangers to raise center of front crossmember 1.7". Also increase tubing gauge from .104" to .165".
 - E. Remove Oval Holes from Frame Side Rail and reinforce due to Front Crossmember change.
 - F. Increase gauge of Front Suspension Rear Crossmember from .104 to .165".
 - G. New 1/2" higher Front Coil Spring to raise #2 Crossmember Frame Side Rail and Reinforcement to
 - H. Revise Mounting Ears on Transmission Extension Housing to increase strength.
 - I. Incorporate stop plate in 6-cylinder Front Engine Mounting.
 - J. Increase gauge of Rear Cross Sill Panel from 20 to 18 gauge.
 - K. Revise Floor Pan Side Brackets 630151 and 630152 with reinforcing angles for improved Front Fender Skirt attachment to underbody.

Changes on above listed items will be made without obsolescence of current stock of materials on hand or committed for with our vendors and will be used for cars not being built for the New York Area. Special precautions must be observed in the shop to properly identify for correct use both old and new materials.

2. The following items of Product Improvement are either already in effect or will become effective well in advance of Nov., 1971 production.
 - A. Continuous welds top and bottom of Frame Side Rail to Reinforcement forward of Front Body Outrigger.
 - B. Full thread Bolt #626892 for improved securing of Radiator Support Assembly to Frame.
 - C. Gluing of Rubber Radiator Insulators to mounting brackets.
 - D. New Front Shock Absorbers with support welds on studs.
 - E. 100% Magnaflux inspection of Rear Engine Mounting Brackets.
 - F. G.I. #60 A-1 Body Bolt Tightening Sequence, has been issued for production and is to be strictly adhered to along with proper use of Body Mounting Shims to alleviate mounting stress at cowl brackets. Procedure to be periodically inspected.

Effective Point: All Parts Per This Memo 1st Used N.Y. Area Cars Only at Ch. #21015 and All Cars After Ch. #22388

September 27, 1971
 Revised & Retyped 9-30-71
 "A" Rev. 10-26-71
 "B" Rev. 10-29-71

ENGINEERING MEMO #309 (Cont'd.)

- G. Fuel Tank Baffle Reinforcement added along with additional spot welds of baffle to tank.
- H. Fuel Tank Mounting Bracket has been increased in width and forward corners relieved.
- I. Improved Hood Latch and Related Parts (Eng.Memo #305).
- J. Revised Bracket and Welding on Vent Window Frames for improved strength.

3. Following is a list of Parts affected by changes listed in Paragraph (1) above.

ITEM	NAME	B Or M	OLD PART NUMBER	NEW PART NUMBER	INT NEW FOR OLD	A	REMARKS
ⓑ 1.	Crossmember Assembly	M	701011	703999	YES	NO	Use W/O Obsoles.
2.	Crossmember-Frt.Susp. Fr.Frt.	M	702017	706161	NO	NO	Use W/O Obsoles.
3.	Bracket-Crossmember	M	-----	706162	NO	YES	New Part
4.	Spacer-Frt.Bumper Supt. FRAME	M	702233	-----	-	YES	Use W/O Obsoles. of 702017
5.	Filler-Frame Rail to C/Member	M	702358	-----	-	YES	Use W/O Obsoles. of 702017
6.	Guard Install.-Frt. C/Member	R e f	SK-2957	CHG"A"	-	-	Ref Drawing
Ⓐ 7.	Reinf.-Lwr.Cont.Arm.- Frt.	M	-----	706191LH 706192RH	-	YES	New Part
8.	Arm Sub Asm.-Lwr.Cont. 6-Cyl.	M	703481LH 703482RH	CHG"C"	YES	NO	Rework
9.	Arm Sub Asm.-Lwr.Cont. 8-Cyl.	M	703511LH 703512RH	CHG"A"	YES	NO	Rework
10.	Cont.Arm Asm.-Low.Conn 8-Cyl.	M	703507LH 703508RH	CHG"C"	YES	NO	Use W/O Obsoles.
11.	Arm & Bush.Asm.-Low Cont. 8-Cyl.	M	703509LH 703510RH	CHG"A"	YES	NO	Use W/O Obsoles.

ENGINEERING MEMO #309 (Cont'd.)

ITEM	NAME	B or M	OLD PART NUMBER	NEW PART NUMBER	INT NEW FOR OLD	A	REMARKS
12.	Cont. Arm Asm.-Low Comp. 6-Cyl.	M	703363LH 703364RH	CHG"E"	YES	NO	Use W/O Obsoles.
13.	Arm & Bush. Asm.-Low Cont. 6-Cyl.	M	703479LH 703480RH	CHG"B"	YES	NO	Use W/O Obsoles.
14.	Rail-Frame Side	B	702013LH 702014RH	CHG"Y"	YES	NO	Use W/O Obsoles.
15.	Reinf.-Fr.Side Rail Frt	B	702015LH 702016RH	CHG"U"	YES	NO	Use W/O Obsoles.
16.	Crossmember-Frt.Susp. Fr.Rear	M	702018	CHG"R" & "S"	YES	NO	Use W/O Obsoles.
(A) 17.	Spring-Front	B	704460	704632	YES	NO	Use W/O Obsoles.
18.	Trans.-Auto.6-Cyl.	B	703842	CHG"A"	YES	NO	Use W/O Obsoles.
19.	Trans.-Auto.8-Cyl.	B	703843	CHG"A"	YES	NO	Use W/O Obsoles.
20.	Plate-Frt. Eng.Mtg.Stop	M	-----	706184	-	YES	New Part
21.	Stabilizer-Rubber Frt. Strg.	B	704926	-----	-	YES	Cancel W/O Obsoles. of 704660
22.	Panel-Rr.Cross Sill	M	634810	CHG"F"	YES	NO	Use W/O Obsoles.
23.	Reinf.-Frt.Fl.Pan Side Brkt.	M	-----	646345	-	YES	New Part
(A) 24.	Brkt.& Reinf.Asm.-Flr. Pan Side Frt.	M	-----	647885LH 647886RH	-	YES	New Part
25.	Arm Asm.-Lwr.Cont.	B	92298RH 92299LH	CHG"S" & "T"	YES	NO	Use W/O Obsoles.
26.	Seat-Front Spring	B	92243	CHG"E"	YES	NO	Use W/O Obsoles.
(A) 27.	Member A.-Frt.Fl.Pan Cross	M	645425	Chg"A"	YES	NO	Use W/O Obsoles.
(A) 28.	Rail-Frame Side-Diesel	M	704509LH 704510RH	Chg"A"	YES	NO	Use W/O Obsoles.
(A) 29.	Frame A.-Complete 129	M	703654	Chg"B"	YES	NO	Use W/O Obsoles.

October 26, 1971
 "A" Rev. 10-29-71
 "B" Rev. 2-16-72

ENGINEERING MEMO #309 (Cont'd.)

ITEM	NAME	B OR M	OLD PART NUMBER	NEW PART NUMBER	INT. NEW FOR OLD	A	REMARKS
30.	Reinf.A.-Fr.Side Rail RH Frt.	M	703708	Chg"G"	YES	NO	Use W/O Obsoles.
31.	Reinf.A.-Fr.Side Rail LH Frt.	M	701983	Chg"P"	YES	NO	Use W/O Obsoles.
32.	Frame Asm.-Complete	M	701984	Chg"D"	YES	NO	Use W/O Obsoles.
33.	Frame Sub Asm.-Diesel	M	703401	Chgs. "L,M,N,P"	YES	NO	Use W/O Obsoles.
34.	Reinf.-Fr.Side Rail Diesel	M	704513LH 704514RH	Chg"B"	YES	NO	Use W/O Obsoles.
35.	Frame Sub Asm.-Aero.	M	701987	Chgs. "A-J-P"	YES	NO	Use W/O Obsoles.
36.	Rail A.-Fr.Side Diesel	M	703399 703400	Chg"F"	YES	NO	Use W/O Obsoles.
37.	Rail A.-Frame Side	M	701017 701018	Chg"P"	YES	NO	Use W/O Obsoles.
38.	Frame A.-Comp.Basic	M	703158	Chgs. "AH-AN"	YES	NO	Use W/O Obsoles.
39.	Reinf.-Fr.Side Rail Frt. (Mod.)	M	704781 704782	Chg"A"	YES	NO	Use W/O Obsoles.
40.	Frame Asm.-Comp. 189WB	M	701989	Chg"M"	YES	NO	Use W/O Obsoles.
41.	Support-Front Bumper	M	704796	Chgs. "A-E"	YES	NO	Use W/O Obsoles.
(A) 42.	Tube-Frt.Susp.C/Member Rr.	B	702333	-----	-	YES	Reinstate
B 43.	Reinf.-Lwr.Cont.Arm Frt.	M	706186	706191 706192	NO	YES	Scrap
B 44.	Plate-Eng.Mtg.Rr.Stop	M	706093	-----	-	-	Serv.or Scrap

September 27, 1971

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3.	Bracket-Crossmember	M	-----	706162	NO	New Part
4.	Spacer-Frt.Bumper Supt.-Frame	M	702233	-----	-	Use W/O Obsoles. of 702017
5.	Filler-Frame Rail to C/Member	M	702358	-----	-	Use W/O Obsoles. of 702017
6.	Guard Install.-Frt.C/Member	Ref	SK-2957	Chg" A"	-	Ref.Drawing

REVISED & RETYPED
9-30-71