

ENGINEERING MEMORANDUM #6

TO: J. Stout, R. Fuller, S. Wilson, S. Hori, E. Horrigan, K. Luke,  
F. Leamy(3), R. McCulfor, A. Radke(3), W. Asselin, R. Smith,  
A. Goedhart, E. Nelson, C. Cornwell, S. Megyesi, B. Herrington(8)  
R. Bach, D. Markin, F. Baldwin, J. Copeland, J. Coleman, T. Bedard,  
K. Bothe, L. Hilsky(4), J. Temple(4). Channingham

FROM: Peter Visser

SUBJECT: New master cylinder, power and non-power

Sales Order No. 834, of which 50 cars will be started on the line June 27, will be equipped with the new vacuum suspended master-vac as per 97320, although this unit with its related mounting parts, as well as the non-power version, master cylinder 97321 will go into effect sometime in September, at which time the hydro-vac, treadle-vac, and existing non-power master cylinder will be cancelled out. This in conjunction with the revised firewall which Body Department has already released.

\* Since the quantities & scheduling of the Aerobus Military conversion is as yet unknown, except for Prod. orders 855 & 972, it would be advisable to install Master-Vac Power Brakes on these & all future Military Conversion orders to avoid different types of Power Brakes on Government vehicles.

\*See attached supplement for part numbers of cancelled & new parts regarding this revision of brakes.

\*\*Addition - The Master-Vac will be used on Military Conversion vehicles as soon as available, as per agreement with Mr. Nelson. Until that time, Hydrovac & Treadle-Vac will be used as required.

\*\*\* 1st Chassis no. using Master-vac on A-12, A-12W-5421  
1st Chassis no. using Non Power Brakes - 6268

\*\*\* Added 6-13-63

\*\* Added 7-6-62

\*Added notes 7-5-62

BRAKES - ALL JOBS

FROM: P. Visser

Rqd.	Part No.	Part Name	Total Jobs Covered	Price Each	Total Amt.
1	634210	Panel-Dash	5235	.9162	4,796.31
1	634271	Plate	7841	.0630	493.98
2	127638	Nut	8385	.0085	71.27
1	10971	Gasket	10001	.0017	17.00
1	10973	Gasket	9529	.0017	16.20
1	93965	Support Assy.	2725	.3355	914.24
1	94424	Support	3895	.2665	1,038.02

BRAKES - NON POWER

1	81741	Bolt	6437	.0840	540.71
1	94467	Fitting	3724	.1550	577.22
1	93518	Mast. Cyl.	4777	2.6400	12,611.28
1	94416	Plate	4786	offal	

BRAKES - TREADLE VAC

1	93987	Lever Assy.	706	.1795	126.80
1	94436	Plate	1362	.0238	32.42
1	94437	Sleeve	2331	.0410	95.57
1	94438	Bracket	1506	.0455	68.52
1	94439	Bracket	1474	.0319	47.02
2	94440	Lever	905	.0139	12.58
1	94441	Link	717	.0346	24.81
1	94442	Pin	2875	.0500	143.75
1	94448	Hub	895	.1126	100.78
1	94523	Hose	1499	.1925	288.56
1	94524	Hose	1341	.0653	87.57
1	94879	Pin	717	.0045	3.23
1	95198	Treadle Vac	504	10.0600	5,070.24
1	93994	Tank	2118	.6910	1,463.54
1	95007	Hose	3331	.6800	2,265.08
1	95263	Tee	641	.3400	217.94
1	94522	Hose	1375	.1362	187.28
1	96252	Clip	934	.0115	10.74
1	94377	Nipple (OHV.)	4592	.1665	764.57
1	640077	Hose	200	.2280	45.60
1	626551	Connec.	200	.0260	5.20

BRAKES - HYDROVAC

1	27044	Bolt	3670	.0950	348.65
1	94332	Bracket	3150	offal	
2	94379	Plt.	3027	offal	
1	94658	Hose (L-Hd.)	3048	.2992	911.96
1	94986	Plt.	3104	offal	
1	95205	Hyd/Vac	3027	13.4300	40,652.61
1	95262	Ch. Valve	3215	.2130	684.80
1	94655	Fitting	3010	.1080	325.08
1	94657	Hose	3267	.0180	58.81
1	93597	Adapter	3220	.0630	202.86
1	94667	Clip	4555	.0073	33.25
1	95515	M/Cyl. (Aero W/O AC)	173	2.680	463.64

Total Cars Built to 7-19-62

All Jobs	3371
Non Power	1400
Treadle-Vac	347
Hydrovac	1624

FROM: P. VISSER  
S. WILSON

7-5-62  
7-19-62  
8-30-62

ALL TOOLS

- 1 634210 Panel-Dash
- 1 634170 Panel Assmly-Dash
- 1 634171 Panel & Nut Assy.
- 1 634210 Flat
- 1 634221 Plate
- 2 127029 Nut
- 1 16471 Gasket (2 Extra Red/A.S.)
- 1 16473 Gasket
- 1 16475 SUPPL. ASSY.
- 1 16474 SUPPL.

\*\*1 97345 Pedal Suppt. Assy. Std. Trans.  
\*\*1 97347 Pedal Suppt. Assy. -Auto Trans.

NON POWER

- 1 97441 Bolt (Also Tr/Vac)
- 1 97407 Fitting (Also Invt/Vac)
- 1 97416 Rest. Cyl. (Also Invt/Vac)
- 1 97415 Plate (Also Invt/Vac)

MASTER-VAC

- 1 95985 Bmt. Assmly.
- 1 95986 Lever Assy.
- 1 95987 Lever Assy.
- 1 97430 Plate
- 1 97437 Sleeve
- 1 97435 Bolt.
- 1 97439 Bmt.
- 2 97440 Lever
- 1 97441 Link
- 1 97442 Pin
- 1 97446 Hose
- 1 97423 Hose
- 1 97424 Hose
- 1 97479 Pin
- 1 95198 Tr/Vac
- 1 92294 Tank
- 1 95007 Hose
- 1 95262 Tee
- 1 97422 Hose
- 1 97452 Clip
- 1 97377 Nipple (OINV)
- 1 640077 Hose
- 1 626551 Connec.

MASTER-VAC

- 1 97344 Bolt
- 1 97405 Bolt Assy.
- 1 97392 Bolt
- 1 97393 Bolt
- 1 97400 Bolt
- 1 97409 Invt/Vac
- 1 97402 Ch. Valve
- 1 97405 Fitting
- 1 97407 Hose
- 1 97417 Oil
- 1 97417 Adapter
- 1 97407 Clip
- 1 97407 Term.
- 1 97515 Rest. Cyl.

ALL TOOLS

- 1 64030 Panel-Dash
- 1 639128 Panel Assy-Dash
- 1 639026 Panel & Nut Assy.
- 1 640370 Plate
- 1 97406 Suppt. Assy.
- 1 98399 Support
- 1 98420 Brace
- 1 97392 Shank

NON POWER

- 1 97400 Plate
- 1 97421 Mast. Cyl.
- \*\*1 97412 Pedal Suppt. Assy.
- \*\*1 97415 Pedal Suppt. Assy.

MASTER-VAC

- 1 97320 Mast/Vac
- 1 97409 Hose
- 1 98415 Hose
- 1 98396 Bolt.
- 1 98397 Pin.
- 1 98396 Sleeve
- \*\* 1 95337 Pedal
- \*\* 1 95338 Pedal
- \*\* 1 97318 Pedal
- \*\* 1 97319 Pedal
- \*\* 1 97413 Pedal Suppt. Assy.
- \*\* 1 97414 Pedal Suppt. Assy.
- \*\* 1 97416 Pedal Suppt. Assy.
- \*\* 1 97417 Pedal Suppt. Assy.

\*\* Added 8-30-62  
\* Added 7-19-62

TO: F. J. Leamy, E. Nelson, B. Herrington

September 24, 1962

K. LUKE

FROM: P. Visser

## SUPPLEMENT TO MEMO #6

## DISPOSITION OF SURPLUS STOCK

PART NO.	NAME	APPROX. QTY.	DISPOSITION
634271	Plate	2500	Scrap
10973	Gasket	4185	Service-Return to Vendor-or Scrap
81741	Bolt	2093	Service-Return to Vendor-or Scrap
94467	Fitting	1258	Service-Return to Vendor-or Scrap
94436	Plate	870	Service-Return to Vendor-or Scrap
94437	Sleeve	1881	Service-Return to Vendor-or Scrap
94438	Brkt.	1000	Service-Return to Vendor-or Scrap
94439	Brkt.	950	Service-Return to Vendor-or Scrap
94440	Lever	448	Service-Return to Vendor-or Scrap
94442	Pin	2425	Service-Return to Vendor-or Scrap
94448	Hub	440	Use as 94426
94523	Hose (25-3/4")	1049	Rework to 94656 (10-1/4") makes two
94524	Hose (8-1/4")	891	Service or Scrap
93994	Tank	1657	Service-Return to Vendor-or Scrap
95007	Hose (12-1/4")	2881	Use in place of 97409 (10-1/4")
95263	Tee	241	Service-Return to Vendor-or Scrap
94522	Hose (18")	925	Rework to 94656 (10-1/4")
96252	Clip	483	Scrap
94377	Nipple	4141	Service-Return to Vendor-or Scrap
27044	Bolt Wagner FC-3474	670	Service-Return to Vendor-or Scrap
94658	Hose (35")	118	Rework to 94656 (10-1/4") makes three
95262	Ch. Valve	1030	Service-Return to Vendor-or Scrap
94655	Fitting Wagner FC-3511	317	Service-Return to Vendor-or Scrap
94657	Hose (1-1/2")	142	Service or Scrap
93597	Adaptor Wagner FC-2832	1041	Service-Return to Vendor-or Scrap
94667	Clip	1555	Service-Return to Vendor-or Scrap

PART NAME	QTY	TO REPLACE		REPLACED BY		2" STOCK ON HAND	MAKE OR BUY	ADDITIONAL REQTS.	SURPLUS
		2 1/2" VERSION PART NO.	2" VERSION PART NO.	2" VERSION PART NO.	2" VERSION PART NO.				
FR AXLE ASSEM. 3-31 STD.		97310	93970 X		135*		BUY		
" " " 3-73 "		97314	93971		231		"		
" " " 3-54 "		97312	93972		5		"		
" " " 4-09 "		97316	93973		11		"		
" " " 4-55 "		NONE	93974		14		"		
" " " 3-31 PWR.LK.		97311	93975		34		"		
" " " 3-73 "		97315	93976		68		"		
" " " 3-54 "		97313	93977		4		"		
" " " 4-09 "		97317	93978		22		"		
" " " 4-55 "		NONE	93979		17		"		
SPRING ASSEM. REAR STD. 2	}	97039	←	92542 X	302*		BUY		
" " " STD. PASS. 2				95349	1064		"		
" " " HD.-6L 2				92972	0		"		
" " " HD.-7L 2				93067	4		"		
PLATE & PIN ASSEM. SHACKLE	2	95634	80767 X	1767			BUY		
BUSHING SPRING SHACKLE	8	96153	80760 X	5600			"		
BRACKET REAR SPR. SHACKLE	2	(96155) 96136	92021 X	432			"		
CLIP - REAR SPRING STD.	2	98308	94198 X	6400 APP			"		
" " " HD.	2	NONE	92278	0			"		
PLATE - REAR SPRING	2	98300	94300 X	3220			"		
BRACKET - SHOCK ABSORBER STD.		98301 L	94301 LX	3624			MAKE		
" " " " "		98302 R	94302 RX	3754			"		
" " " " H.D			94873 L	523			"		
" " " " "			94874 R	476			"		
BOLT - REAR SPR. FRT	2	271758	271755 X	3516			BUY		
BRKT. ASSY. - SPR. BODY - FRM.		95637 L	93863 LX	12			MAKE		
" " " " " "		95638 R	93864 RX	12			"		
BRKT. BODY FRAME L.H.		96133 L	94207 LX	869			"		
" " " " R.H.		96134 R	94208 RX	891			"		
RIVET -	4	NONE	443661 X	12100			BUY		
BOLT -	4	181687	NONE				"		
NUT -	4	96101	NONE				"		
BRKT. REAR SPR. FRT	2	96103	94205 X	940			MAKE		
REINFORCEMENT - L.H.		96183 L	---	---			"		
" " R.H.		96184 R	---	---			"		
HELPER SPRING KIT		97399	95694	117			BUY		

NOTE - WHEN USING 2" SPRING SPECIFY FRAME ASSEM. # 95085 X  
2 1/2 SPRING SPECIFY FRAME ASSEM # 97300