

Technical Service Bulletin

DATE September 15, 1967

NUMBER 67DT-21 MODEL D100 WITH SIX CYLINDER ENGINE

GROUP FRAME SUBJECT FRAME & ENGINE SUPPORT REINFORCEMENT

SUMMARY REINFORCEMENTS ADDED TO FRAME & ENGINE SUPPORT BRACKETS

Frame bracket and plate package (P/N 2808688) may be installed on six cylinder equipped model D100 trucks (having serial number which fall between 1161-492000 and 1161-682239) if cracks develop in the frame at the engine support area.

Procedure - Refer to Figure 1

1. Raise front end of truck, supporting weight on front bumper. Remove engine mounting bolts and raise engine about 1/2" off mounting brackets.
2. Repair any existing cracks by arc welding before the enclosed parts are installed.
3. Drill a 3/8" hole in lower flange of rail at point "A", as indicated in bottom view.
4. Attach reinforcement plate to lower flange of rail. Plate must be parallel to lower frame flange as shown in bottom view. Drill remaining four (4) 3/8" dia. holes in lower flange of rail using reinforcement plate as template.
5. Attach both engine support brackets to lower flange of frame. Be sure vertical leg of support brackets are against engine mounting bracket. Drill two (2) 3/8" dia. holes in both sides of engine mounting brackets using support brackets as template (See top view).
6. Use same procedure on the right side.
7. Paint to improve appearance and prevent rust.

CAUTION: DO NOT WELD BRACKETS IN PLACE

(Over)

P-2810

Frame bracket and plate package (P/N 2808688) is stock class Code "P".

Policy: A Warranty Repair Order may be submitted in the normal manner for reimbursement. Flat rate times will be allowed as follows:

- A. No welding required 4 hours
- B. Welding required 5 hours



R. H. KLINE
Manager - Service
DODGE DIVISION

LEFT SIDE SHOWN—SYMETRICALLY

OPPOSITE FOR RIGHT SIDE

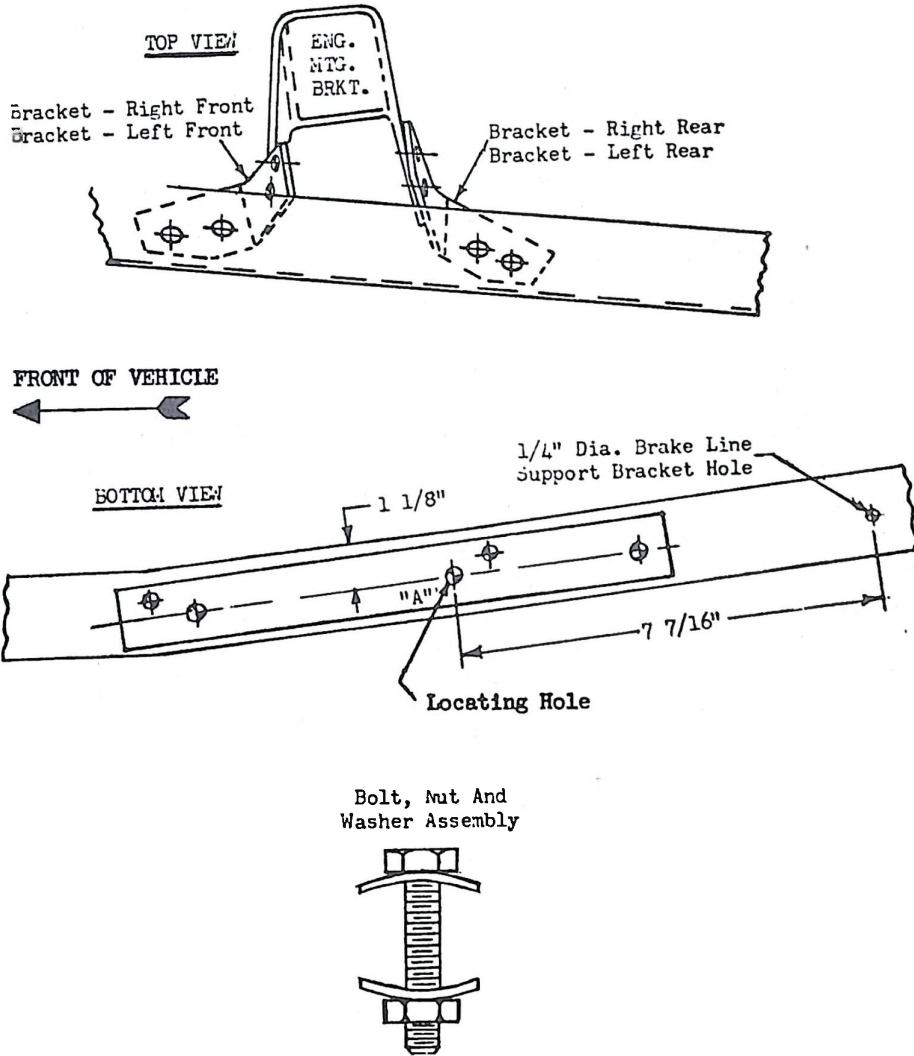


FIGURE 1. FRAME BRACKET & PLATE PACKAGE INSTALLATION