

ASSEMBLY OPERATIONS

4x4 CHEVROLET TRUCKS

TWO-UNIT PACK



**CHEVROLET MOTOR DIVISION and
GENERAL MOTORS OVERSEAS OPERATIONS**

Divisions of

**GENERAL MOTORS CORPORATION
DETROIT : MICHIGAN**

ASSEMBLY OPERATIONS

For

CHEVROLET 4 x 4 TRUCKS

"TWO UNIT PACK"



Prepared by

GENERAL MOTORS OVERSEAS OPERATIONS

(Engineering and Manufacturing Department)

Division of

GENERAL MOTORS CORPORATION

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VIEWS OF COMPLETED VEHICLES



LESS WINCH



WITH WINCH

VIEWS OF COMPLETED VEHICLES



BOMB SERVICE - LEFT SIDE



BOMB SERVICE - RIGHT SIDE

CHEVROLET TRUCK —(4 x 4)— ASSEMBLY OPERATIONS

INTRODUCTION

This book covers in logical sequence all operations necessary to unbox and re-assemble the following Chevrolet 4 X 4 Trucks - Two Unit Pack.

Winch Models
Less Winch Models
Bomb Service Models

The "Two Unit Pack" (TUP) for 4 X 4 Winch and Less Winch Models consists of two complete chassis and cabs, partially disassembled and packed in three separate cases as follows:

- (1) Chassis Case
- (1) Cab Case
- (1) Axle Case

The "Two Unit Pack" (TUP) Bomb Service Model consists of two complete chassis, flat face cowl's and bodies, partially disassembled and packed in four separate cases as follows:

- (1) Chassis Case
- (2) Cowl and Body Cases
- (1) Axle Case

The sequence of assembly operations pertaining to any of the above mentioned models can easily be followed by referring to the "Operation Number" columns in the Guide to Operations.

CAUTION

DUE TO POSSIBLE CHANGES IN ENGINEERING DESIGN OF VEHICLES, OR BOXING, IT IS IMPORTANT THAT THE SAME GROUP OF CASES WHICH WERE BOXED FOR ANY GIVEN "TWO UNIT PACK" BE USED AT RE-ASSEMBLY. THEREFORE BEFORE PROCEEDING WITH UNBOXING, SEE THAT CASES SELECTED HAVE THE SAME "U.S.A. NUMBERS". THESE NUMBERS ARE STENCILLED ON EACH CASE SIDE PANEL, AND APPEAR ON THE PACKING LIST.

FURTHERMORE, ABSOLUTE CARE MUST BE TAKEN TO MATCH AXLES, CHASSIS, CABS (OR COWLS), AND HOODS ACCORDING TO "U.S.A. NUMBER". THIS NUMBER ALSO APPEARS ON TAGS ATTACHED TO THE VARIOUS PARTS AND IS STENCILLED ON HOOD.

PACKING LISTS

In each case will be found a PACKING LIST, itemizing each part contained therein. These packing lists should be carefully checked and studied before any attempt is made to assemble the vehicle.

IMPORTANT

Water has been drained from radiator and engine block.

Gasoline has been drained from fuel tank, pump and filter.

Oil has been drained from crankcase, oil filter and air cleaners.

Battery is shipped either dry and uncharged or dry and charged. (See instruction tag attached to each battery).

CHECK TRANSMISSION, FRONT AND REAR AXLES, TRANSFER CASE AND WINCH TO SEE THAT LUBRICANT IS AT PROPER LEVEL.

DO NOT START VEHICLE UNTIL ALL ASSEMBLY OPERATIONS HAVE BEEN COMPLETED.

ALL SHAKEPROOF LOCKWASHERS SHIPPED WITH THIS JOB ARE NEW LOCKWASHERS. IT IS IMPORTANT THAT THESE NEW LOCKWASHERS BE USED AT RE-ASSEMBLY TO INSURE EFFECTIVE RADIO SUPPRESSION.

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HOISTS AND SUPPORTS

If suitable supports are provided together with sufficient man-power to handle heavier parts (stripped chassis, axles or cabs), hoists may not be necessary. However, use of one or more hoists will appreciably reduce assembly labor hours.

The heaviest "dead weight" lift necessary is the lifting of top chassis from bottom chassis in Chassis Case. The "high-

est" and perhaps the most awkward lift necessary is the mounting of cab.

If hoists are used, support structure should be strong enough and of sufficient height to take care of heaviest lift. The hoist mounting should be mobile enough to permit placement and support of various sections of chassis throughout assembly operations.

CHEVROLET TRUCK —(4 x 4)— ASSEMBLY OPERATIONS

GUIDE TO OPERATIONS

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