

Group 1 Frame Assembly

GENERAL: This group contains information on the basic frame or understructure.

SPECIFICS: As applicable

- ...Energy Absorbers (bumper)
- ...Frame Brackets (not welded on)
- ...Frame Crossmembers (not welded on)
- ...Frame of Coach
- ...Front Bumper
- ...Lifting Eyes
- ...Lifting Pads
- ...Rear Bumper
- ...Tow Eyes
- ...Tow Hooks
- ...Tubing through Frame (cables, wires, hoses)



FMC Corporation
Motor Coach Division
333 Brokaw Road Box 664 Santa Clara California 95052

REPAIR PARTS LIST

GROUP 1 Frame Assembly

MODEL 2900R

FIG NO.	ITEM NO.	PART NUMBER	ITEM DESCRIPTION	QTY PER UNIT
<u>FRONT BUMPER (CHROME OR SILVER FINISH)</u> (Coach 00001 through 00440)				
1-1	1	5100131	BUMPER, Front (chrome or silver finish)	1
	2	M-18036	BOLT, Bumper to adapter (1/2-13 x 2)	4
	3	M-17055	LOCKNUT, Bumper bolt (1/2-13)	4
	4	M-17006	LOCKWASHER, Bumper bolt (split, 1/2 ID)	4
	5	M-18100	BOLT, Adapter to energy absorber (5/16-18 x 1)	16
1-1	6	M-17092	NUT, Energy absorber bolt (5/16-18)	16
	7	M-17042	LOCKWASHER, Energy absorber bolt (split, 5/16 ID)	16
	8	5101228	ADAPTER, Bumper to energy absorber	4
	9	5100126	ABSORBER, Front bumper energy	4
	10	5101488-07	SEAL, Energy absorber to frame (sup 5100192-07)	4
NOTE: The following parts are required to substitute the current bumper design in place of existing bumper on coach 00001 to 00440.				
1-1	11	5101822-01	BUMPER, Front	1
	12	M-18125	BOLT, Bumper to bracket carriage (1/2-13 x 1-1/2)	8
	13	M-17049	LOCKNUT, Bumper to bracket bolt (1/2-13)	8
	14	5100570-02	WASHER, Bumper bolt (flat, 0.516 ID x 1.50 OD)	8
	15	5101884	BRACKET, Bumper to energy absorber inboard	2
	16	5101885	BRACKET, Bumper to energy absorber outboard	2
1-1	17	M-18100	BOLT, Bracket to energy absorber (5/16-18 x 1)	16
	18	M-17042	LOCKWASHER, Energy absorber bolt (split, 5/16 ID)	16
	19	M-17092	NUT, Absorber bolt (5/16-18)	16
	20	5100126	ABSORBER, Front bumper energy	4
	21	5101488-07	SEAL, Energy absorber to frame (sup 5100192-07)	4
NOTE: See Group 2, front grille configuration when replacing front chrome or silver bumper with a stainless steel bumper.				
<u>FRONT BUMPER (STAINLESS STEEL OR CHROME FINISH)</u> (Coach 00441 and up)				
1-1	22	5101822-01	BUMPER, Front	1
	23	M-18125	BOLT, Carrier bumper to spring (1/2-13 x 1-1/2)	8
	24	M-17055	LOCKNUT, Bolt (1/2-13)	8
	25	5100570-02	WASHER, Bumper bolt (flat, 0.516 ID x 1.50 OD)	8
	26	5101716	SPRING, Bumper to brackets	4
	27	M-18001	BOLT, Spring to brackets (1/2-13 x 1-3/4)	8
1-1	28	M-17055	LOCKNUT, Bracket bolt (1/2-13)	8
	28	M-17006	WASHER, Bracket bolt locknut (1/2 ID)	32
	29	5101717-02	BRACKET, Spring to frame (inboard)	4
	30	5101717-01	BRACKET, Spring to frame (outboard)	4
	31	M-18037	BOLT, Bracket to frame (1/2-13 x 1-1/4)	16
	32	5100570-02	WASHER, Frame bolt (flat, 0.516 ID x 1.50 OD)	16
	33	M-17055	LOCKNUT, Bracket to frame bolt 1/2-13	16
<u>REAR BUMPER (CHROME OR SILVER FINISH)</u> (Coach 00001 through 00440)				
1-1	34	5101227	BUMPER, Rear	1
	35	M-18099	BOLT, Bumper to adapter (3/4-10 x 5-3/4)	2
	36	M-17075	LOCKNUT, Bumper bolt (3/4-10)	2
	37	5101488-W01	ADAPTER, Bumper to energy absorber	2
	38	M-18100	BOLT, Adapter to energy absorber	16
	39	M-17042	LOCKWASHER, Adapter to energy absorber bolt (split, 5/16 ID)	16
1-1	40	M-17092	NUT, Adapter to energy absorber (5/16-18)	16
	41	5100126	ENERGY ABSORBER, Adapter to frame	4
	42	5101488-07	SEAL, Energy absorber to frame (sup 5100192-07)	4



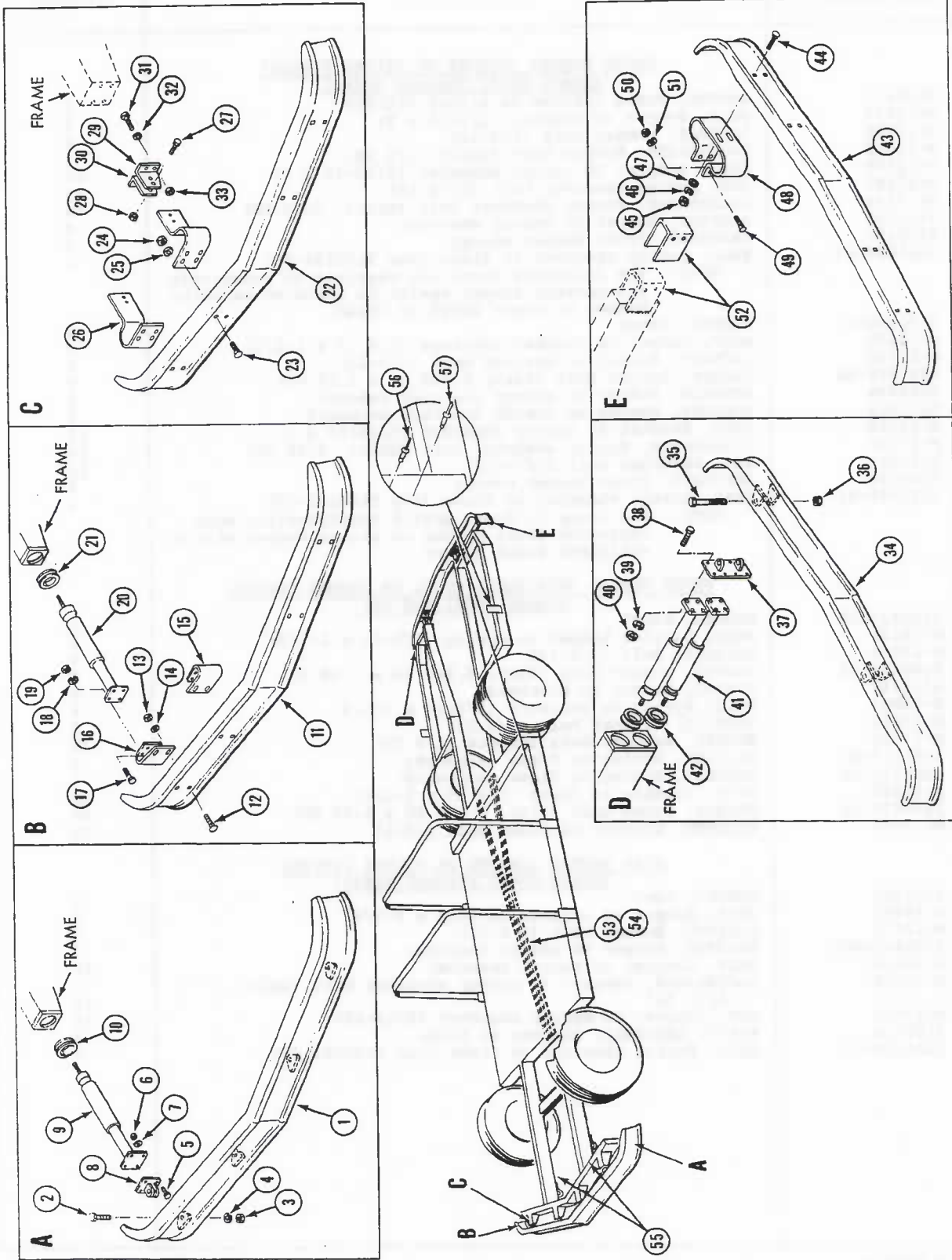
FMC Corporation
Motor Coach Division
333 Brokaw Road Box 664 Santa Clara California 95052

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REPAIR PARTS LIST

GROUP 1 Frame Assembly
 MODEL 2900R



SD-1044

Figure 1-1. Frame

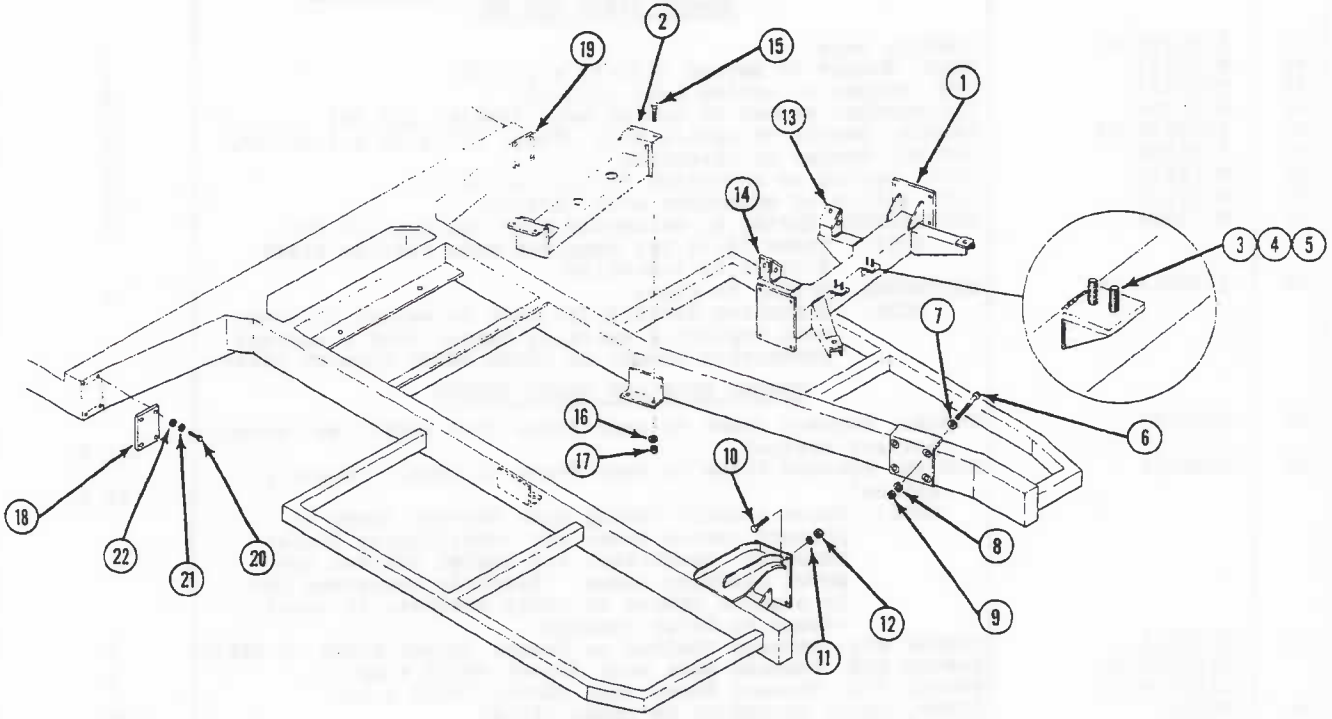
REPAIR PARTS LIST

GROUP 1
MODEL 2900R

FIG NO.	ITEM NO.	PART NUMBER	ITEM DESCRIPTION	QTY PER UNIT
			<u>REAR BUMPER (STAINLESS STEEL OR CHROME FINISH)</u> <u>(Coach 00441 and up)</u>	
1-1	43	5101756-01	BUMPER, Rear	1
	44	M-18153	BOLT, Bumper to spring (1/2-13 x 1-1/2)	8
	45	M-17157	NUT, Bumper to spring bolt (1/2-13)	8
	46	M-17006	LOCKWASHER, Bumper to spring bolt (Split, 1/2 ID)	8
	47	5100570-02	WASHER, Bumper to spring bolt (flat, 0.516 ID x 1.50 OD)	8
1-1	48	5101750	SPRING, Bumper to extension	2
	49	M-18154	BOLT, Spring to extension (1/2-13 x 1-1/2)	8
	50	M-17157	NUT, Spring to extension bolt (1/2-13)	8
	51	M-17006	LOCKWASHER, Spring to extension bolt (split, 1/2 ID)	8
			NOTE: Items 48-51. Not required when trailer hitch 5101778 is installed.	
	52	5100013-103	EXTENSION, Spring to frame	2
			NOTE: Extension 5100013-103 must be welded to frame when replacing existing bumper with a current production bumper on coach 00001 through 00440.	
			<u>TOWING EYES AND FRAME TUBING</u>	
1-1	53	5100617	TUBING, Forward frame to rear frame (3/4 inch) (all except battery cables)	112 ft
	54	5100618	TUBING, Forward frame to rear frame (1 inch) (battery cables)	14 ft
			NOTE: Above plastic tubing runs through frame to protect vacuum hose; air conditioning lines; throttle, handbrake, and heater cables; and power steering hoses. Electric harnesses ran in plastic tubing on early coaches, in steel trough on later coaches.	
1-1	55	5101143	TOWING EYE, Forward (welded to frame) (Coach 00001 to 00558)	2
		5106320-01	TOWING EYE, Forward Left Hand (Coach 00559 & up)	1
		5106320-02	TOWING EYE, Forward Right Hand (Coach 00559 & up)	1
	56	M25031	RIVET, Upper Structure to Frame (#6-6)	100
	57	M25032	RIVET, Upper Structure to Frame (#6-8)	100

REPAIR PARTS LIST

GROUP 1 FRAME ASSEMBLY
MODEL 2900R



SD-464

Figure 1-2. Engine-Transmission Support