QUICK REFERENCE INDEX. To use, move either the hand or selection tool directly over the section you desire to reference. Simply click once with the mouse button and the manual will automatically jump to that section.

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DAVE GRAHAM
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Made in the USA
INTRODUCTION

This 1967 instruction manual illustrates the operations required for the final assembly of the vehicle. It has been designed to expedite the latest assembly information to the user. It is imperative that additions and revisions be inserted in their proper places immediately and that superseded sheets be removed.

The manual is arranged in sections, production and option, corresponding as closely as practicable to the uniform parts classification (U.P.C.) groups to which the component parts and assemblies are assigned at the point of release. A section contents sheet is provided at the beginning of each section where warranted. Certain sections have been sub-divided into areas of assembly which are determined by the physical location of the parts in the vehicle. These sub-sections are identified by a letter prefacing the sheet number (Sheet B2 for example). Refer to the general index for the production sections and sub-sections, and to the option index for all regular production options (R.P.O.) currently available.

The option index will indicate if an option is illustrated or non-illustrated. An option will be illustrated if it varies in assembly from regular production or non-illustrated if it assembles the same as regular production or a related option.
QUICK REFERENCE INDEX. To use, move either the hand or selection tool directly over the section you desire to reference. Simply click once with the mouse button and the manual will automatically jump to that section.

UPC 0  GENERAL INFORMATION

A1  Introduction
A2  General Index
A3  General Information
A4  General Information
A5  General Instructions
A6  General Instructions
A7  Stapling Instructions

B1  Labels & Stickers
B2  Vehicle Identification Plate
B3  Vehicle Protect-O-Plate

C1  Misc. Shipping List
C1.5  Misc. Shipping List
C2  Shipping Protection

D1  Lubrication
D2  Lubrication
D3  Lubrication
D4  Lubrication
D5  Cements & Sealers
D6  Cements & Sealers
D6.5  Cements & Sealers
D7  Fill Items

E1  Paint & Trim (Open)
F1  Publications (Open)
G1  Export Info (Open)

UPC 1  BODY

A. Dash Panel Area
B. Instrument Panel Area
C. Body Complete
D. Mounting

UPC 2  FRAME

UPC 3  FRONT SUSPENSION

UPC 4  REAR SUSPENSION

A. Drive Line
B. Suspension

UPC 5  BRAKES

A. Cylinder Mounting & Lever
B. Pipes
C. Parking

UPC 6  ENGINES

A. Belt Trains
B. Cooling Electrical & Mounting
C. Carburetion & Exhaust
D. Controls

UPC 7  TRANSMISSION

A. Column Mounting Controls
B. Clutch

UPC 8  FUEL & EXHAUST

A. Exhaust System
B. Fuel System

UPC 9  STEERING

UPC 10  WHEELS & TIRES

UPC 11-13  SHEET METAL-RADIATOR GRILLE

A. Inner Panels
B. Outer Panels

UPC 12  ELECTRICAL

A. Engine
B. Instrument Panel
C. Body
D. Diagrams

UPC 14  BUMPERS & MISCELLANEOUS

A. Front Bumpers
B. Rear Bumpers

OPTION INDEX
MODELS
SHEETS DESIGNATED 12000 REPRESENT ALL MODELS RELEASED FOR PRODUCTION

SYMBOLS
1  INDICATES CROSS REFERENCING OF PART NUMBERS OR NOTES.
△  INDICATES TORQUE.
⊙  INDICATES A REVISION
○  INDICATES OPTIONAL PARTS THAT INSTALL THE SAME AS REGULAR PRODUCTION.

1A  INDICATES APPLIED MATERIALS-ITEMIZED IN UPC 0. NUMERAL REPRESENTS A CERTAIN MATERIAL; LETTER REPRESENTS USAGE.

<p>| | | |</p>
<table>
<thead>
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<tr>
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F  INDICATES RELATED SHEETS THAT CONTAIN INFORMATION REQUIRED TO COMPLETE A CERTAIN INSTALLATION. THIS IS NOTED ABOVE THE SHEET NUMBER.

<table>
<thead>
<tr>
<th>CHEVROLET MOTOR DIVISION, GMC</th>
<th>UPC</th>
<th>DATE</th>
<th>SYM</th>
<th>REVISION RECORD</th>
<th>AUTH.</th>
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<td></td>
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<tr>
<td>SHEET X</td>
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<td></td>
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</tr>
</tbody>
</table>
QUANTITY

QUANTITY WHEN SHOWN, REPRESENTS FULL AMOUNT PER VEHICLE FOR USAGE INDICATED.
QUANTITY OF STAPLES REPRESENTS NUMBER REQUIRED PER PART.

MISCELLANEOUS SHIPPI NG LIST

PERTAINS TO LOOSE ITEMS SHIPPED WITH VEHICLE FROM ASSEMBLY PLANTS-ITEMIZED IN UPC 0.

ATTACHING PARTS

THE INSTALLATION OF ALL ATTACHING PARTS IS SHOWN IN DESIGN POSITION & SHOULD BE ADHERED TO WHEREVER POSSIBLE. BOLT, NUT ASSEMBLIES & STAPLES MAY BE INSTALLED FROM EITHER DIRECTION UNLESS OTHERWISE SPECIFIED. THE TORQUE SYMBOL IS SHOWN ADJACENT TO THE DRIVEN PART AND THE MATING THREADED FASTENER MUST NOT MOVE DURING THE APPLICATION OF THE SPECIFIED TORQUE.

IT IS RECOMMENDED THAT TORQUE PREVAILING LOCK NUTS BE DRIVEN WITH AIR STALL TOOLS AT SPEEDS SLOWER THAN 350 R.P.M. THIS WILL PREVENT POSSIBLE GALLING OR DAMAGE TO THE LOCKING FEATURES.

FLUID CARRYING PIPES

PIPES CARRYING FLUIDS SUCH AS GASOLINE, OIL, BRAKE FLUID, ETC., MUST BE FREE OF ALL INCLUSIONS PRIOR TO INSTALLATION.

CLEARANCE DIMENSIONS

DIMENSIONS SHOWN ARE NOMINAL UNLESS OTHERWISE SPECIFIED.

LUBRICANT GREASE

LUBRICATION OPERATIONS ON ALL AFFECTED PARTS (e.g. SWIVELS, RODS, BUSHINGS, BOLTS, OR SHAFTS) MUST BE ACCOMPLISHED PRIOR TO SUB-ASSEMBLY, EXCEPT FOR ITEMS INCORPORATING LUBRICATION FITTINGS.

BELT TENSION

ALL BELT TENSION SPECIFICATIONS ARE SHOWN IN UPC 6 ENGINE.

SPRINGS & SHOCKS

ALL OPTIONAL SPRING & SHOCK ABSORBERS ARE LISTED IN UPC 3, FRONT SUSPENSION & UPC 4, REAR SUSPENSION.
NOTE! All cotter pins must be secured by spreading each leg away from the centerline of the pin not less than 45°.

NOTE: When castellated nuts & cotter pins are used together, torque nut as specified & then tighten to next notch for insertion of cotter pin except when otherwise specified. Cotter pin may be installed in either position shown but must be tight to prevent rotation or looseness.

**NOTE** Assemble all type "MB stamped nuts" with open end up.

**CAUTION** If nut is assembled with open end down, it will strip mating stud before proper installation torque is obtained.

**NOTE** All non-hardened steel clips are to be clinched closed after wires, tubes or bowden cables are installed.

**NOTE** All special retainers must be installed as shown to provide end load in direction of arrow.

**NOTE** Lock washer must be positioned as shown to insure a proper ground.
Install headless tubular clip on emblem stud so that clip contacts emblem as shown at point A, then push into hole in panel.

Install tubular clip in hole in panel so that retention barbs are engaged on back of panel, then push stud into clip until back of emblem contacts panel.

On hose clamp installations where the pipe, nipple, tee, connector etc. has a bead, the hose clamp must be positioned directly beyond the bead. The hose must be assembled far enough to assure at least 1/8 hose protrusion beyond the clamp.

Caution: Clamp must not be located on top or radius of sealing bead.

On hose clamp installations, where beaded hose nipples are short, the following procedure should be followed.

On hose clamp installations, where pipes up to and including 1/4 O.D. having no bead and are short as an integral part of a unit, the following procedure should be followed.
ASSEMBLY INSTRUCTIONS

3891775 "F" CAR 12000 SERIES

WIRE DRAW • 2C • 2T

WIRE DRAW • C • 2T • 3/8

SURE

CROWN SIZE

T • THICKNESS OF WORK

STAPLES MUST NOT BE COUNTERSUNK IN THE RUBBER MORE THAN TWICE THE DIAMETER OF THE STAPLE WIRE TO AVOID TEARING RUBBER.

IN ORDER TO ENSURE QUALITY STITCHING IT IS ESSENTIAL THAT THE WIRE DRAW (AMOUNT OF WIRE FED FOR EACH STITCH) BE THE CORRECT LENGTH FOR THE WORK TO BE STITCHED. THE LENGTH OF THE WIRE DRAW IS DEPENDENT UPON THE CROWN SIZE OF THE STAPLE TO BE USED AND THE THICKNESS OF THE WORK TO BE STITCHED.

AS A GENERAL RULE, STITCHES HAVING A CROWN WIDTH SIZE WITHIN THE RANGE OF .15 THROUGH .60 SHOULD HAVE SUFFICIENT WIRE DRAW SO THAT THE CLINCHED LEGS OF THE STAPLE JUST ABOUT MEET. (SEE FIG. 1). FOR STITCHES IN THIS RANGE OF CROWN SIZES THE CORRECT LENGTH OF WIRE DRAW WOULD BE: TWICE THE CROWN SIZE PLUS TWICE THE THICKNESS OF WORK TO BE STITCHED OR, WHEN REDUCED TO A FORMULA: WIRE DRAW • 2C • 2T.

FOR EXAMPLE: IF CROWN SIZE OF STITCH IS .15 AND THE THICKNESS OF WORK TO BE STITCHED IS .06, 2 TIMES .15 (OR .30") PLUS 2 TIMES .06 (OR .12") EQUALES 1-1/4" WIRE DRAW.

STITCHES HAVING CROWN SIZES GREATER THAN .60 SHOULD HAVE SUFFICIENT WIRE DRAW SO THAT EACH CLINCHED LEG OF THE STAPLE IS 3/16" IN LENGTH. (SEE FIG. 2). FOR STITCHES IN THE RANGE OF CROWN SIZES THE CORRECT WIRE DRAW WOULD BE: CROWN SIZE PLUS TWICE THE THICKNESS OF WORK TO BE STITCHED PLUS 3/8", OR WHEN REDUCED TO A FORMULA: WIRE DRAW • C • T • 3/8.

FOR EXAMPLE: IF CROWN SIZE OF STITCH IS 1-1/16" AND THE THICKNESS OF WORK TO BE STITCHED IS 1/2", THE CORRECT WIRE DRAW WOULD BE 1-1/16", PLUS 2 TIMES 1/2", OR 1", PLUS 3/8", EQUALES 2-1/2" WIRE DRAW.

THE ABOVE FORMULAS DO NOT TAKE INTO CONSIDERATION THE TYPE OF MATERIAL TO BE STITCHED. SOME MATERIALS MAY REQUIRE STAPLE LEG LENGTHS DIFFERENT THAN THOSE SHOWN IN FIGS. 1 & 2. HOWEVER, AS A GENERAL RULE THE FORMULA GIVEN IN FIG. 1 CAN BE USED FOR STITCHES HAVING CROWN SIZES WITHIN THE RANGE OF .15 THROUGH .60, WHILE THE FORMULA GIVEN IN FIG. 2 CAN BE USED FOR STITCHES HAVING CROWN SIZES GREATER THAN .60.
ADHESIVE .00375 GAL.

STICKER - TIRE PRESSURE CHART

NOTE: Surface must be clean.
Locate as shown using gummed gummed back to adhere.

PRICE LABEL LOCATION
Position label on rear quarter glass with label maintaining vertical position.
PLATE

After plate is stamped, attach to adhesive backed portion of last page in owners protection plan booklet.

ENLARGED SECTION A-A THRU TYPICAL STAMPED CHARACTER

REFERENCE GRID FOR DATA LOCATION

STAMP PROTECT-O-PLATE WITH NO. 35 SIZE TYPE WITH DATA AT LOCATION NOTED BELOW. STAMPED SIDE OF PLATE MUST READ NORMALLY (NOT REVERSED OR MIRROR IMAGE). DATA OF MORE THAN ONE TYPE CHARACTER LENGTH WILL START AT INDICATED LOCATION & CONTINUE TOWARD RIGHT FOR APPROPRIATE NUMBER OF CHARACTERS. PLATE WILL BE 33 COLUMNS LONG & 9 ROWS DEEP WHEN OPTIONAL NO. 28 SIZE TYPE IS USED.

<table>
<thead>
<tr>
<th>LOCATION</th>
<th>DATA TO BE STAMPED</th>
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</thead>
<tbody>
<tr>
<td>*A-1</td>
<td>TRIM CODE</td>
</tr>
<tr>
<td>*A-5</td>
<td>PAINT CODE (LEAVE BLANK IF F &amp; SO, COPO OR PRIME PAINT IS SPECIFIED)</td>
</tr>
<tr>
<td>A-15</td>
<td>VEHICLE SERIAL NUMBER</td>
</tr>
<tr>
<td>***A-29</td>
<td>CARBURETOR SOURCE</td>
</tr>
<tr>
<td>B-1</td>
<td>ENGINE SOURCE, DATE, &amp; TYPE CODE</td>
</tr>
<tr>
<td>B-8</td>
<td>TYPE DESIGNATIONS ON CERTAIN OPTIONAL ENGINES ONLY WILL BE FOLLOWED BY AN &quot;R&quot; OR &quot;E&quot; TO DESIGNATE CARBURETOR REQUIREMENTS.</td>
</tr>
<tr>
<td>B-15</td>
<td>REAR AXLE TYPE, DATE &amp; SOURCE CODE</td>
</tr>
<tr>
<td>*B-29</td>
<td>MONTH PRODUCED</td>
</tr>
<tr>
<td>**C-1</td>
<td>TRANSMISSION SOURCE &amp; DATE CODE EXCEPT OPTION M40 TO BE STAMPED WITH CODE NUMBER ON UNIT EXCEPT THAT THE LARGE &quot;C&quot; PREFIX AND LARGE &quot;A&quot; SUFFIX ARE TO BE DROPPED.</td>
</tr>
<tr>
<td>**C-15</td>
<td>POWER BRAKE AND/OR STEERING CODE</td>
</tr>
<tr>
<td>**C-16</td>
<td>RADIO CLOCK</td>
</tr>
<tr>
<td>**C-17</td>
<td>RADIO CODE</td>
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<tr>
<td>**C-18</td>
<td>DISC BRAKE</td>
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<tr>
<td>**C-19</td>
<td>AIR CONDITIONING CODE</td>
</tr>
<tr>
<td>**C-20</td>
<td>POWER WINDOW CODE</td>
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<tr>
<td>**C-21</td>
<td>POWER SEAT CODE</td>
</tr>
<tr>
<td>**C-29</td>
<td>CHEVROLET &quot;BOW TIE&quot; SYMBOL</td>
</tr>
</tbody>
</table>

# CODE | *** CODE
AUG. 1966 | V BAY CITY B
SEPT. | L CARTER C
OCT. | R HOLLY H
NOV. | K ROCHELLE R
DEC. | Z
JAN. 1967 | S
FEB. | P
MAR. | W
APR. | N
MAY | Y
JUNE | T
JULY | X

**NOTE** Whenever a Warner Gear Transmission is installed, use the code "W" only with no date code.

*CODES ARE OBTAINED FROM OPTION SALES CODES SHOWN IN THE DATA SYSTEMS STANDARDS MANUAL NO. 5
## Assembly Instructions

### 3891775 "F" Car 12000 Series

<table>
<thead>
<tr>
<th>PART NO</th>
<th>NAME</th>
<th>UPC</th>
<th>MODELS</th>
<th>SHPC REF</th>
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<td>CAP UNIT</td>
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<td>3893121</td>
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<td>RPO P01</td>
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<td>3908760</td>
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<td>RPO P02</td>
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<td>RPO N96</td>
<td>ALL</td>
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<td>CAP UNIT</td>
<td>RPO J52</td>
<td>ALL</td>
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<td>BOOKLET-SUN, AIR &amp; WHEELS</td>
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<td>3871173</td>
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<td>3876412</td>
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<td>RPO U63-73</td>
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<td>3875700</td>
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### Notes
- PLACE IN LUGGAGE COMPT
- PLACE IN INSTR PANEL COMPT
- DOMESTIC ONLY SHOWN. SEE PARTS LIST OR BILL OF MATERIAL FOR CANADA EXPORT VEHICLES
### ASSEMBLY INSTRUCTIONS

#### 3891775 "F" CAR 12000 SERIES

<table>
<thead>
<tr>
<th>PART NO.</th>
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<td>AIR CLEANER &amp; SIL ASM.</td>
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<td>BOLT-GEN BRKT AT REAR</td>
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<td>103321</td>
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<td>WASHER-GENERATOR BRACKET SPACER</td>
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**PLACE IN LUGGAGE COMPT.**

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**CHEVROLET MOTOR DIVISION, GMCo.**

#### MISCELLANEOUS SHIPPING LIST

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<thead>
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<th>BAR</th>
<th>DIVISION RECORD</th>
<th>ARR. 50</th>
<th>CI</th>
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<tr>
<td>1</td>
<td>1</td>
<td>397677 CLEANER UNIT ARM/SP.</td>
<td>92375</td>
<td>4</td>
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</table>
Remove existing headrest.

1. Install front seat protector cover & cut 1-1/2 inch slit in cover at each escutcheon.
2. Reinstall headrests.
<table>
<thead>
<tr>
<th>PART</th>
<th>USAGE</th>
<th>UPC</th>
</tr>
</thead>
<tbody>
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**CHEVROLET MOTOR DIVISION, GMC**

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### ASSEMBLY INSTRUCTIONS

#### 3891775 “F” CAR 12000 SERIES

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<td>9985047</td>
<td>SOLVENT TO BE PLACED IN WINDSHIELD WASHER JAR</td>
<td>1</td>
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<tr>
<td>9985016</td>
<td>REFRIGERANT AIR CONDITIONING SYSTEM</td>
<td>C60</td>
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<tr>
<td>9985037</td>
<td>GASOLINE THRU GAS TANK FILLER NECK ASM</td>
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<td>ANTI FREEZE (ETHYLENE GLYCOL)</td>
<td>11-13</td>
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<td>COOLING SYSTEM - For engine cooling system capacities, refer to chart 3909888</td>
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<tr>
<td>9985166</td>
<td>WAX LIQUID COAT ALL EXTERIOR HORZ PAINTED SURFACES</td>
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<td>9985137</td>
<td>FLUX GAS TANK FILLER NECK</td>
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**CHEVROLET MOTOR DIVISION, GMC**

<table>
<thead>
<tr>
<th>ITEM DESCRIPTION</th>
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<tr>
<td>REFRIGERANTS, COOLING SYSTEM, GASOLINE &amp; SOLVENTS</td>
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<tr>
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<td>D7</td>
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**ASSEMBLY INSTRUCTIONS**

**3891775 "F" CAR 12000 SERIES**
ASSEMBLY INSTRUCTIONS
3891775 "F" CAR 12000 SERIES

SHEET TITLE
A1 CONTENTS
A2 W/S WIPER MOTOR ASM & LINKAGE
A3 W/S WIPER BLADES & VENT GRILLE
A4 W/S WASHER JAR & WIPE PATTERN
A5 W/S WASHER NOZZLE & HOSE ROUTING
A6 HEATER & DEFROSTER ASM
A7 DASH-MAT
A8 HEATER HOSES
B1 HEATER CONTROL ASSEMBLY
B2 HEATER CONTROL CABLES
B3 INSTR PANEL TRIM PLATE & REAR VIEW MIRROR
B4 ASH TRAY & RADIO CONTROL HOLE COVER
B5 INSTR PANEL COMPARTMENT
B6 INSTR PNL COMPT DOOR & W/S WIPER MOTOR SWITCH
C1 OUTSIDE REAR VIEW MIRROR
C2 FLOOR PANEL REINF
C3 BODY SILL MOLDINGS
C4 BODY DAMPENER ASSEMBLIES
C5 FRONT CARPETS
D1 BODY MOUNTING

CHEV MOT DIV GMC

BODY - CONTENTS

UPC

DATE
SYM
REVISION RECORD
AUTHL
DR

12000
A1

97-1947
1
C4 SHEET ADDED
7771 AM HE

1-1947
2
SHEET C5 ADDED
8777 OP HB

1-1947
3
SHEET A6.5 ADDED
6458 D JR

1-1947
4
SHEET A7 TITLE REVIS
6458 C1

1

A1

SHEET X

C1

33
4917000  TRANSMISSION ASM
3832845  SCREW ASM
3792579  GASKET
5045508  MOTOR & PUMP-ASM
3824124  SCREW ASM

CAUTION: Do not install motor which has been dropped or has hung from the drive link prior to installation.

NOTE: Marks on crank arm must coincide with marks on cover within 5° for park position.

CRANK ARM

20-30 LBS. IN.
Screw - As req'd - To protect to minus 20 °F. per instructions furnished by facilities & planning dept.

NOTE: Windshield glass must be wet when checking the blade asm to the specified D.L.O. dimension.

NOTE: Windshield wiper rod asm must be installed so that tip of blade asm is positioned as dimensioned above D.L.O. surface of glass in park position.
ASSEMBLY INSTRUCTIONS

3891775 "F" CAR 12000 SERIES

HOSE - L.H.
SCREW
NOZZLE ASM
RETAINER

HOSE - R.H.

NOTE Bend end of nozzle to adjust stream to 4 inch target area.

WATER STREAM

16.50 INS. (APPROX)

TARGET AREA

ENG. WIRING HARNESS (UPC 12)

W/S WASHER JAR

10-15 LBS. IN.

W/S WIPER MOTOR & PUMP ASM

RETAINER (UPC 12)

VENT GRILLE

WIPER WITO

PUMP

WINDSHIELD WASHER NOZZLE & HOSE ROUTING

DATE SYM

6/24 1

ITEM 7 ADDED

2
-L.H ADDED

3
-WAS APPROX 8

4
-VIEW A REVIRED

5
-WAS 384006G HOSE RETAINER, DWG REMOVED

AUTH. DR. CX

72370 AN

5010 A

6010 A

5115 A

5015 A

5010 A

5010 A

5010 A
NUT - Tighten nut to the specified installation torque. The residual torque on nut must register a minimum torque of 10 lbs. in. after 24 hours.

SCREW ASM.

SEALING-COMPOUND

.03 gal per job

7 - 12 LBS. IN.

30-40 LBS. IN.

LOCATING HOLE
ASSEMBLY INSTRUCTIONS
3891775 "F" CAR 12000 SERIES

1 3863392 SCREW ASM
2 3891785 OUTLET ASM-DEFROSTER
3 3895932 DUCT ASM
4 9427326 SCREW
5 3895933 OUTLET ASM.

6 9419892 SPL. WASHER
7 9419303 SCREW

15-20 LBS. IN.
13-18 LBS. IN.

HEATER DEFROSTER DUCT, OUTLETS

CATALOG

CHEVROLET MOTOR DIVISION, GMC

1

A7

1-1947 IS REDRAWN & REDESIGNED 54553.2/C1

12000

L-80547 L-80550

DATE REL 3-1 C1 L- L- L-
Hose slack must be positioned rearward of the fender prior to securing hose clip to fender.

**HEATER HOSES**

<table>
<thead>
<tr>
<th>SHEET</th>
<th>DATE REL</th>
<th>REF.</th>
<th>PREL</th>
<th>SWG</th>
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<td>A8</td>
<td>L-80530L</td>
<td>L-7-8-7-8-7</td>
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**UPC**

| CHEV | MOTOR DIVISION, GMC | UPC | DATE | SYM | REV. | REV. | REV. |  
|------|---------------------|-----|------|------|------|------|------|------|
| 12000 | A8 | 6/17/66 | 3739436, 3751698 | 3736495 | 770259 | 9420906 |  |
| | | | | | | | |

**ASSEMBLY INSTRUCTIONS**

3891775 “F” CAR 12000 SERIES

1. 3739436 HOSE L-6 V-8
2. 3751698 CLAMP
3. 272852 CLAMP
4. 3764148 HOSE L-6 V-8
5. 3902327 CLAMP L-6 ENG
6. 3736495 NIPPLE V-8 ENG
7. 3770259 CLIP
8. 9420906 CLAMP L-6 ENG

**NOTE**

1. Hose slack must be positioned rearward of the fender prior to securing hose clip to fender.
HEATER CONTROL ASSEMBLY

NOTE: Attach upper L.H. screw first to locate 4 in instrument panel.

UPC 12

30-40 LBS IN.
20-30 LBS IN.

HEATERS MOTOR DIVISION, GMC

1 131262 BULB REMOVED
2 ATTACHMENT NOTE ADDED 8/1670 RHD
3 ITEM 6 ADDED(1) PLACE

1 12000 B1

CHEVROLET MOTOR DIVISION, GMC

1 SHEET

32
ASSEMBLY INSTRUCTIONS

3891775 "F" CAR 12000 SERIES

1. SCREW
2. BUSHING
3. MIRROR ASM
4. RETAINER
5. TRIM PLATE
6. SCREW
7. COVER (INNER)
8. SCREW ASM
9. COVER (OUTER)

Assembly clearance of .06/.12 between top forward edge & instrument Cluster Asm (ref UPC 12)

TAPE approx. 18 inches
2 pcs 9 inches long

ATTACH OUTBOARD SCREWS BEFORE CENTER SCREW.

Short end to top of car with Ball Stud Arm positioned as shown.

3893822 3891665 3899895 3899897 SCREW ASM COVER (OUTER) COVER (INNER) SCREW SCREW BUSHING MIRROR ASM RETAINER TRIM PLATE

®

INSTR. PANEL TRIM PLATE STEERING SUPPORTS, COVERS & REAR VIEW MIRROR
ASSEMBLY INSTRUCTIONS

3891775 “F” CAR 12000 SERIES

1. 9418551 SCREW
2. 4566397 BUMPER
3. 9420723 SCREW
4. 3891663 DOOR ASM
5. 3899887 CASE ASM
6. 1993395 SWITCH ASM
7. 135629 L. WASHER
8. 3904858 BEZEL
9. 3904859 NUT
10. 3906147 KNOB ASM.

- Set Screw (Part of asm.) with switch in “OFF” position, screw must be at bottom in vertical position.

- Cylinder asm. (Fisher)

- Instrument panel must be flush .04

- 40-50 LBS IN.
- 15-22 LBS IN.
- 12-18 LBS IN.
- 10-15 LBS IN.

- Instrument PNL compartment door & windshield wiper motor switch
ASSEMBLY INSTRUCTIONS

3891775 "F" CAR 12000 SERIES

1 3874240 MIRROR
2 3874252 BRACKET
3 3821961 SCREW
4 3874250 GASKET
5 3874250 SCREW ASM

NOTE: Position reinforcement of mirror behind front tab of bracket.

OUTSIDE REAR VIEW MIRROR

OUTSIDE REAR VIEW MIRROR

* CHEVROLET MOTOR DIVISION, GMC *

UPC 1

DATE SYM REVISION RECORD AUTH. DR. CR.

12000

DWG REF 11-16 EN REF: Pro.C1 L-60051 L-

DATE REF 3-1 DP L- L- L-

SHEET 1
FLOOR PANEL REINFORCEMENT

UPC 1

DATE 6/66

SYA WAS 3853842 REINF.

REVISION RECORD WAS 3872455 CREAM

AUTH. DR. CX 78000 16

4 SHEET
ASSEMBLY INSTRUCTIONS

3891775 “F” CAR 12000 SERIES

1. 942245 SCREW
2. 3849634 SCREW
3. 3898142 MOLDING
4. 3899871 RETAINER

• 120 ± 1/64 hole (1) place each side
• .141 ± .004 hole (1) place each side
• .120 ± 1/64 hole (1) place each side

Use S as a template.

10-15 LBS. IN.

BODY SILL MOLDINGS

UPC DATE SYNL REVISION RECORD AUTH. DR CX
1 0-360 1 REDRAWN & REDESIGNED 7/63 1-A-40
C3 SHEET 1/4
ASSEMBLY INSTRUCTIONS

3891775 “F” CAR 12000 SERIES

3909919-20 DAMPENER ASM FRT. L. & R.H.
9419901 SCREW ASM
3909927-8 DAMPENER ASM RR. L. & R.H.
3909938 SPL. WASHER
3795490 REINFORCEMENT
9418931 NUT
12B FLUID-AUTO TRANS. 1.25 GALS.
64 COMPOUND .006 LBS.
85 CEMENT .15 PCS.

.50 DIA. HOLE AT DIMPLE IN SKIRT EXT.

BODY DAMPENER ASSEMBLIES
12000 (CONVERTIBLE)

<table>
<thead>
<tr>
<th>ITEM</th>
<th>PART NUMBER</th>
<th>DESCRIPTION</th>
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<tbody>
<tr>
<td>1</td>
<td>3909919-20</td>
<td>DAMPENER ASM FRT. L. &amp; R.H.</td>
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<td>2</td>
<td>9419901</td>
<td>SCREW ASM</td>
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<tr>
<td>3</td>
<td>3909927-8</td>
<td>DAMPENER ASM RR. L. &amp; R.H.</td>
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<td>4</td>
<td>3909938</td>
<td>SPL. WASHER</td>
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<tr>
<td>5</td>
<td>3795490</td>
<td>REINFORCEMENT</td>
</tr>
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<td>6</td>
<td>9418931</td>
<td>NUT</td>
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<tr>
<td>7</td>
<td>12B</td>
<td>FLUID-AUTO TRANS. 1.25 GALS.</td>
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<td>8</td>
<td>64</td>
<td>COMPOUND .006 LBS.</td>
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<tr>
<td>9</td>
<td>85</td>
<td>CEMENT .15 PCS.</td>
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</tbody>
</table>

20-30 LBS. FT.
100-125 LBS. IN.
ASSEMBLY INSTRUCTIONS

3891775 "F" CAR 12000 SERIES

PART FURNISHED BY FISHER BODY & INSTALLED BY CHEVROLET.

1 9416208 SCREW

<table>
<thead>
<tr>
<th>WARNING</th>
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<tbody>
<tr>
<td>TUCK UNDER DASH MAT</td>
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</table>

PARKING BRAKE CABLE

NOTE: Do not loosen kick panel, tuck mat under kick pad.

EXISTING SCREWS

15-20 LBS IN.

PROTECTIVE COVER (SEE UPC 0)

ALL FLOOR SHIFTS (EXCEPT CONSOLE)

PEDAL (UPC 6)

DIMMER SWITCH

FRONT CARPET DETAILS:
ASSEMBLY INSTRUCTIONS

3891775 “F” CAR 12000 SERIES

BOLT 38914816
SPL. WASHER 38914814
CUSHION 3893159
P. WASHER 1305797
L. WASHER 103339
NUT 9418828
NUT-PUSH 9425568

CUSHION ASM 3893156
CUSHION ASM 3893161
CUSHION 38914802
P. WASHER 3901355
BOLT 3912533
CUSHION ASM 3901361

Residual torque after roll test to be 60 lbs. ft. minimum.

Residual torque after roll test to be 60 lbs. ft. minimum.

Radiator Support
See UPC 11-13

No. 1 MTG

No. 2 MTG

NOTE: 7 retains 1 2 3 5 & 8 to radiator support prior to assembly to frame.

NOTE: TYPICAL SECTION CUSHION ASM. TO CUSHION

CHEVROLET MOTOR DIVISION, GMCO

U.P.C. 12000

12000 BODY MOUNTINGS

12000 BODY MOUNTINGS

12000 BODY MOUNTINGS

12000 BODY MOUNTINGS

12000 BODY MOUNTINGS

12000 BODY MOUNTINGS
NOTE: At body drop use .610 ±.002 dia. pins at locations shown on L. & R.H. side.
ASSEMBLY INSTRUCTIONS
3891775 "F" CAR 12000 SERIES

A1 CONTENTS
A2 UPPER & LOWER CONTROL ARMS
A3 STEERING KNUCKLE, STUD ASSEMBLIES & FRONT WHEEL HUB ASM
A4 SHOCK ABSORBER & SPRING
A5 STABILIZER SHAFT
A6 FRONT SUSPENSION GEOMETRY
A7 FRONT SPRING CHART
A8 FRONT TRIM HEIGHTS
A8.1 FRONT TRIM HEIGHTS
A9 FRONT TRIM HEIGHTS
A10 FRONT TRIM HEIGHTS
A10.1 FRONT TRIM HEIGHTS
A10.2 FRONT TRIM HEIGHTS
A11 FRONT TRIM HEIGHTS-H.D.
A11.5 FRONT TRIM HEIGHTS-H.D.
A12 FRONT TRIM HEIGHTS

FRONT TRIM CONTENTS
A10 FRONT TRIM
A10.1 FRONT TRIM
A10.2 FRONT TRIM
A11 FRONT TRIM
A11.5 FRONT TRIM
A12 FRONT TRIM

CHEVROLET MOTOR DIVISION, GMC
12000

UPC 3
DATE 3/1
DESRN 1
REDRAWN 1
REDESIGNED 1

SAE 7/25
A1
ASSEMBLY INSTRUCTIONS

3891775 "F" CAR 12000 SERIES

1. 3914871-2 ARM ASM-UPPER L. & R.H.
2. 3751282 SHIM AS REQ'D
3. 3751284
4. 3751348
5. 381909 BOLT
6. 9422299 NUT
7. 3842220 BUMPER
8. 9421430 BOLT
9. 3859194 BUMPER
10. 3842220 BUMPER

NOTE: Shim to fill gap as reqd. by caster & camber adjustment
See sheet A6

45-55 LBS. FT.
70-90 LBS. FT.
100-140 LBS. IN.

UPC DETAIL

1. CHEVROLET MOTOR DIVISION, G.M.C.
2. 12000
3. UPPER & LOWER CONTROL ARMS

DATE SYM REVISION RECORD AUTH. DR. CF
5/2/64 5 WAS 62657853 BUMPER 73146661 DP
6/17/64 61 3751282 WAS 3751282 73046613 CR
7/22/64 3 BOLT INSTALL. REVISED 80034661 CR
8/5/64 4 "TORQUE 2" WAS 70-25785 LBS. FT. 80084661 DP
9/26/64 5 WAS 3895701-2 ARM 41181661 CR
10/6/64 6 3125891-2 WAS 3895701-5 66269661 CR

4/6
ASSEMBLY INSTRUCTIONS
3891775 "F" CAR 12000 SERIES

LUB FITTING
RIVET
STUD & SEAL ASM.
OPTIONAL
3892569-70 STRG KNU & FRT WHL HUB ASM L. & R.H.
NUT
NUT
358501
9418843
NOTE
Eyelet must be tight in nut slot & shaft bent as shown. To prevent rotation or loosening which will interfere with camber-caster gauges.
LUBRICANT-LITHIUM SOAP

NUT-A torque of 90 lbs. ft. max. is permissible on nut when slot is in correct position for insertion of cotter pin.

C. PIN

LUBRICANT-LITHIUM SOAP

COTTER PINS INSTALLATION

UPPER CONTROL ARM ASM.
LOWER CONTROL ARM ASM.
WHEEL-UPC 10

40-60 LBS. IN.
55-75 LBS. FT.
70-95 LBS. FT.
40-60 LBS. FT.
1. 1365067 NUT
2. 5544049 RETAINER
3. 381957 GROMMET
7. 3192419 SHOCK ABSORBER (EXC. L78 & F41)
8. 3192477 L78 & F41
5. 3846202 SCREW ASM

NOTE: Hold stud at this point when necessary to stop rotation & obtain torque.

NOTE: End of coil must be 3/8 ± 1/8 from stop.

---

60 - 120 LBS. IN.
15 - 25 LBS. FT.
ASSEMBLY INSTRUCTIONS

3891775 "F" CAR 12000 SERIES

1 3790332 BOLT
2 5544049 RETAINER
3 3790333 SPACER
4 3654642 NUT

5 9420603 SCREW
6 383493 BRACKET
7 3908372 SHAFT

381957 GROMMET
3760439 BUSHING

FRAME SIDE-MEMBER

LOWER CONTROL ARM

NOTE: MANDATORY THAT BOLT BE ASSEMBLED FROM DIRECTION SHOWN

15-20 LBS. FT.
10-15 LBS. FT.

STABILIZER SHAFT

12000

UPC 3
DATE 5-21-66
SYM "BOLT" DWG REVISED 79317 B6 DP
REV 6-21-66 WAS 383432 BUSHING 79289 B7
3 WAS 3862325 SHAFT DP
4 WAS 3909935 BUSHING 83071 B6 HP
5 82247 TORQUE (#) WAS 50-120 LBS FT 85650 GY
6 TORQUE NOTE REMOVED C1

SHEET X

49
### Assembly Instructions

#### 3891775 “F” Car 12000 Series

**Checking Heights**

<table>
<thead>
<tr>
<th>Models</th>
<th>Checking Heights</th>
<th>Caster</th>
<th>Camber</th>
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<tbody>
<tr>
<td>All</td>
<td>As Shipped</td>
<td>$+0^\circ 14' \pm 1^\circ$</td>
<td>$+0^\circ 17' \pm 0^\circ 30'$</td>
</tr>
<tr>
<td></td>
<td>Curb</td>
<td>$+0^\circ 30' \pm -1^\circ$</td>
<td>$+0^\circ 15' \pm 0^\circ 30'$</td>
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</tbody>
</table>

**Caster and Camber**

- Caster Angle: $90^\circ$
- Positive Direction: Forward (FWD)

**Total Toe-In**

<table>
<thead>
<tr>
<th>Models</th>
<th>Total Toe-In</th>
<th>Height</th>
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<tbody>
<tr>
<td>All</td>
<td>$1/8 - 1/4$</td>
<td>Curb &amp; As Shipped</td>
</tr>
</tbody>
</table>

**Front Suspension Geometry**

- Wheel Toe-In: $X - Y$
- Camber Angle: $90^\circ$
- Positive Direction: Forward

---

**Revision History**

- Castor: Camber Data Added
- Toe-In Data Added

---

**Reference:**

- CHEVROLET MOTOR DIVISION, GMC
- DWGREL 1.6
- REF: Prel. A 6 L-
- L-
- L-
- L-
- L-
# Assembly Instructions

## Code Colors - Black Print on Red

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<th>Part Number</th>
<th>Code Letter</th>
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<td>YT</td>
<td>3909944</td>
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<td>YJ</td>
<td>3912552</td>
<td>YU</td>
<td>3895231</td>
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## Production

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<tr>
<td>12500</td>
<td>12600</td>
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### With RPO C60
- YL, YN, YL, YN, YU, YY, YU, YY

### With RPO F41
- YW, YY, YY, YY, YY, YY

### With RPO G31
- YL, YN, YL, YN, YU, YY, YU, YY

### With C60 & F41
- YX, YQ, YX, YQ

### With C60 & G31
- YN, YY, YN, YY, YT, YY, YT

### RPO L22
- YL, YN, YL, YN

### RPO L30
- YU, YS, YU, YS

### With RPO C60
- YY, YQ, YY, YQ

### With RPO F41
- YW, YY

### With RPO G31
- YU, YS, YU, YS

### With C60 & F41
- YX, YX

### With C60 & G31
- YY, YQ, YY, YQ

### RPO L48
- YU, YS, YU, YS

### With RPO C60
- YY, YQ, YY, YQ

### With RPO F41
- YW, YY

### With RPO G31
- YU, YS, YU, YS

### With C60 & F41
- YX, YX

### With C60 & G31
- YY, YQ, YY, YQ

### RPO L35 & L78
- YG, YK, YG, YK

### With RPO F41
- YJ, YJ

### With RPO G31
- YJ, YK, YJ, YK

### RPO Z28 With RPO M21
- YW, YW
VEHICLE HEIGHTS
FIGURES INCLUDE POWERGLIDE TRANSMISSION
POWER STEERING, POWER BRAKES & STD.
ACCESSORIES ON V-8 MODELS. 6 CYL MODELS
INCLUDE POWERGLIDE TRANSMISSION & STD.
ACCESSORIES.

NOTE Pull vehicle up 3 or more times; allow to
settle, then measure "Z" & "J" dimensions.

LOAD CONDITIONS
AS SHIPPED-OIL, WATER, 2 GALS OF FUEL &
RECOMMENDED TIRE PRESSURE.
CURB WEIGHT-OIL, WATER, FULL TANK OF
FUEL & RECOMMENDED TIRE PRESSURE.

RECOMMENDED TIRE PRESSURE
CONV. & COUPE-24 LBS FRONT & 24 LBS ± 2 REAR

- FRONT TRIM HEIGHTS

*STANDARD EQUIPMENT ON V-8 MODELS

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52
## Assembly Instructions

### 3891775 "F" Car 12000 Series

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### Front Trim Heights

- **Date**: 6-12-67
- **Chart Revised**: 12-09-66
- **Rev.**: A8
- **Auth.**: D. C.

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- **Upc**: 3
- **Date**: 1-7-67
- **Revision Record**: A8-1
- **Auth.**: D. C.
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### CHEVROLET MOTOR DIVISION, GMC

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- **SYN:**
- **REVISION RECORD:**
- **AUTH:**
- **DR:**

**FRONT TRIM HEIGHTS**

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**Ref. A8 A10**
## ASSEMBLY INSTRUCTIONS

**3891775 "F" CAR 12000 SERIES**

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### General Notes
- Chevrolet Motor Division, GMC
- 3891775 "F" CAR 12000 SERIES
- Assembly Instructions
- 230 Base
- 250 L-22
- 327 Base
- H.D. Front Trim Heights
- UPC
- Date: 3/72
- Division Record: 12000
- Auth: DR. #3

---

**59**
### 396 L35

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ASSEMBLY INSTRUCTIONS

3891775 “F” CAR 12000 SERIES

1. AXLE ASM
2. NUT
3. L. WASHER
4. “U” BOLT
5. PROP SHAFT ASM
6. NUT
7. LUBRICANT-HYPOID 3.7 LBS
8. FLUID-SYN TRANS

Fill to level of filler plug hole.

This area of shaft must be entirely free of paint.

Note: This area of shaft must be entirely free of paint.

12-16 LBS FT
55-75 LBS FT
15-20 LBS FT
# Assembly Instructions

## 3891775 “F” Car 12000 Series

### Parts List
- **NUT ASM**: 3892755
- **BRACKET L. & R.H.**: 3892751-2
- **SCREW ASM**: 3831892
- **NUT**: 103028
- **WASHER**: 103329
- **P. WASHER**: 415919
- **BOLT**: 3892754

### Mandatory Sequence
1. Locate tab in slot to body
2. Drive screw to side rail for first attachment

### SPRING to FRONT EYE & BRACKET

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### Notes
- Install spring eye bolt with spring at approx. 4°

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**CHEVROLET MOTOR DIVISION, GMC**

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ASSEMBLY INSTRUCTIONS

3891775 "F" CAR 12000 SERIES

1 3791381 CUSHION-UPPER
2 3792585 CUSHION-LOWER
3 3901315-6 PLATE L. & R.H.
4 3901399 NUT

NOTE: Tighten with vehicle weight on springs.

(3) [NOTE] Shackles & pins to be assembled in direction shown.

5 3908370 BUSHING
6 3830840 SHACKLE
7 272876 NUT
8 3830844 PIN Must be assembled as shown.

60-45 LBS FT
40-60 LBS FT.

12000

SPRING TO AXLE & EYEBEAR SHACKLE

UPC 4 7/66

DATE 1966

UPC 4 7/66

DATE 1966

NOTE REVISED
ASSEMBLY INSTRUCTIONS
3891775 "F" CAR 12000 SERIES

1. 1365067 NUT
2. 5544049 RETAINER
3. 381957 GROMMET
4. 3892761 BRACKET ASM
5. 3784303 SCREW ASM
6. 271500 BOLT
7. 103328 L. WASHER
8. 3192420 SHOCK ABS.
9. 9419402 SCREW
10. 3892756 BUMPER ASM
11. 3923564 BUMPER
12. 3784303 SCREW ASM
13. 3905569 WASHER-SEALING
14. 63 CEMENT-PLASTIC SEAM 4.5 INCHES
15. 3908372 CAP-L.H. ONLY (EXCEPT CONV.)

NOTE: Install as shown with bolt head toward the front of vehicle.

- CHEVROLET MOTOR DIVISION, GMC -

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VEHICLE HEIGHTS

FIGURES INCLUDE POWERGLIDE TRANSMISSION, POWER STEERING, POWER BRAKES & STD. ACCESSORIES ON V-8 MODELS. 6 CYL MODELS INCLUDE POWERGLIDE TRANSMISSION & STD. ACCESSORIES.

NOTE: Pull vehicle up 3 or more times, allow to settle, then measure "D" & "K" dimensions.

LOAD CONDITIONS

AS SHIPPED—OIL, WATER, 2 GALS. OF FUEL & RECOMMENDED TIRE PRESSURE.

CURB WEIGHT—OIL, WATER, FULL TANK OF FUEL & RECOMMENDED TIRE PRESSURE.

RECOMMENDED TIRE PRESSURE

CONV. & COUPE—24 LBS FRONT & 24 LBS ± 2 RR.
### ASSEMBLY INSTRUCTIONS

#### 3891775 "F" CAR 12000 SERIES

**WHEN VEHICLE HAS THE FOLLOWING EQUIPMENT:** ADD OR SUBTRACT FROM CHARTS AS SHOWN BELOW.

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| DWG E-66          |     |      |     |      |      |
| DATE REL. 10/10   |     |      |     |      |      |
### 3891775 "F" Car 12000 Series

#### 230 Base

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#### 250 L-22

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#### 3891775 “F” CAR 12000 SERIES

**Model 12437**
- **Option**: BASE
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- **DIMEN. D**: 5.19
- **DIMEN. K**: 8.76
- **AS SHIPPED**: 5.16
- **Curb**: 8.71
- **AS SHIPPED**: 5.16
- **Curb**: 8.29

**Model 12637**
- **Option**: BASE AND A/C
- **STO. TIRES**: D70X14
- **DIMEN. D**: 5.16
- **DIMEN. K**: 8.72
- **AS SHIPPED**: 5.13
- **Curb**: 8.67
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**Model 12457**
- **Option**: BASE
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- **DIMEN. D**: 5.40
- **DIMEN. K**: 8.89
- **AS SHIPPED**: 5.37
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**Model 12557**
- **Option**: BASE AND A/C
- **STO. TIRES**: D70X14
- **DIMEN. D**: 5.34
- **DIMEN. K**: 8.86
- **AS SHIPPED**: 5.37
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**Model 12437 F41 BASE**
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**Model 12537 F41 BASE AND A/C D70X14**
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- **AS SHIPPED**: 5.06
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**Model 12437 G31 BASE AND A/C D70X14**
- **Option**: D70X14
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- **AS SHIPPED**: 6.23
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**Model 12537 G31 BASE AND A/C D70X14**
- **Option**: D70X14
- **STO. TIRES**: D70X14
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- **AS SHIPPED**: 6.20
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**Model 12457 G31 BASE AND A/C D70X14**
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**Model 12557 G31 BASE AND A/C D70X14**
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**SYN**

**REVISION**

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**DR**

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**CHEVROLET MOTOR DIVISION, GMC**

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### TRIM HEIGHTS

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<td>FOUR SPEED</td>
<td>7.35X15</td>
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*CHEVROLET MOTOR DIVISION, GMC.*

**UPG**

| 4 | 181X66 | 096 L-35 TRIM HEIGHTS REV0 | 01 | 2 | 302"Z28" TRIM HEIGHTS REV0 | 0647 B4 |

**DATE**

| 1/1967 | 1 | 302"Z28" TRIM HEIGHTS REV0 | 0647 B4 |

**REV0SION RECORD**

| B4 | 1/1967 | 3 | 302"Z28" TRIM HEIGHTS REV0 | 0647 B4 |

**AUTH.**

| B4 | 1/1967 | 5 | 302"Z28" TRIM HEIGHTS REV0 | 0647 B4 |

---

**DRAWING**

| B8 | SHEET | 74 | 181X66 | 096 L-35 TRIM HEIGHTS REV0 | 01 | 2 | 302"Z28" TRIM HEIGHTS REV0 | 0647 B4 |
ASSEMBLY INSTRUCTIONS

3891775 "F" CAR 12000 SERIES

SHEET TITLE

A1 CONTENTS

1 A2 BRAKE-CYLINDER, BRACKET & PRESSURE INDICATOR SWITCH

2 A3 BRAKE-PEDAL, PUSH ROD & CLEVIS

B1 FRONT BRAKE LINES

B2 REAR BRAKE LINES

C1 PARKING BRAKE PEDAL FRONT CABLE & EQUALIZER

C2 PARKING BRAKE CONNECTOR & REAR CABLES

NOTE: Brake system to be inspected for leaks at 1800 PSI to 2000 PSI for 10 seconds.
ASSEMBLY INSTRUCTIONS

3891775 “F” CAR 12000 SERIES

1. 3918739 BRACKET ASM
2. 3723230 BUMPER
3. 9418931 NUT
4. 103321 L. WASHER
5. 3909903 PIPE ASM RR
6. 3904271 PIPE ASM FRT
7. 3904270 SWITCH ASM
8. 3909933 BRKT SWITCH
9. 9419370 SCREW
10. 5452475 CYLINDER ASM
11. 3993302 OPT
12. 3782566 GASKET
13. 5456779 BOOT
14. 9426553 NUT

NOTE: Fill master cylinder reservoirs to .25 in ± .125 in. from top.

INSTRUMENT PANEL RETIEF

BRAKE PEDAL

DASH PANEL

20 - 28 LBS FT
90 - 140 LBS IN.
120 - 180 LBS IN.

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<th>CHEVROLET MOTOR DIVISION, GMC</th>
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A2 SHEET 1
ASSEMBLY INSTRUCTIONS

3891775 “F” CAR 12000 SERIES

1. 3850084 SPRING
2. 3841645 EXTENSION
3. 3798255 BUSHING
4. 1379621 PIN
5. 3890601 PEDAL ASM
6. 3888880 COVER
7. 387574 CLEVIS
8. 9419815 NUT
9. 3790222 ROD
10. 3817880 RETAINER
11. 1B GREASE .0066 LBS.
12. 1G .006 LBS
13. 1C .013 LBS
14. 1E

CAUTION: Retainer, 11 must scribe a legible line on end of clevis pin during assembly. Avoid any expanding tool which nullifies this intent.

II-16 LBS FT

NOTE: Brake pedal must support a 50 lb. load at “A” after traveling a maximum of 3.00” after brakes are applied three times in quick succession and free play is .06 to .25 inches.

CAUTION: If 3.00 is exceeded brakes should be re-checked for proper bleed.
ASSEMBLY INSTRUCTIONS

3891775 "F" CAR 12000 SERIES

1 390972 PIPE ASM-FRT R.H.
2 3881339 CLIP ASM
3 390993 PIPE ASM-FRT L.H.
4 3910718 HOSE ASM-Must not be twisted when installed.
5 231343 WASHER
6 476737 SPRING CLIP
7 9422606 SCREW
8 3893141-2 BRACKET L. & R.H.
9 9408358. CLIP
10 9419303 SCREW.
11 140566 CLIP
12 9420825 SCREW

NOTE: Pipe routed thru small end of clip.

SWITCH ASM

FOONT BRAKE, LINES

1 389337 PIPE 80-115 LBS IN.
2 70-70 LBS IN.
3 10-15 LBS IN.
4 20-25 LBS FT 72-96 LBS IN.

NOTE: PIPE NOTE ADDED

AUTH.
**ASSEMBLY INSTRUCTIONS**

**3891775 “F” CAR 12000 SERIES**

1. **LEVER ASM-PEDAL-L.D.**
2. **SCREW ASM**
3. **SLEEVE (Conv. only)**
4. **NUT**
5. **EQUALIZER**

**NOTE:** Tighten nut [9] at dash to specified torque before tightening bolt [2] at instrument panel to specified torque.

**ASSEMBLY PROCEDURE**

With the parking brake mechanism in the released position, cable tension measured on the front cable 3.00 inches in front of the equalizer is 30 ± lbs.

With the correct cable tension, pedal should start to move with a 15 ± 5 lb. load applied to the pedal. With the brake pedal depressed two (2) inches from the released position, the pedal load will be 35 ± 5 lbs. To obtain cable tension, tighten nut [4A], then hold nut [4A] and tighten nut [5] to specified torque.

**NOTE:** When brake unapplied install dimensions ± .25.

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**CHEVROLET MOTOR DIVISION, GMC**

<table>
<thead>
<tr>
<th>ITEM</th>
<th>REV</th>
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<th>DATE</th>
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32 - 40 LBS. IN.
75 - 95 LBS. IN.
80 - 120 LBS. IN.

**NOTE:** When brake unapplied install dimensions ± .25.
ASSEMBLY INSTRUCTIONS
3891775 “F” CAR 12000 SERIES

Sheet Title
A1 CONTENTS
A2 CONTENTS V-8 ENGINE
A3 GENERATOR, MOUNTING FAN, BELT & PULLEYS
A5 BELT ROUTING
B1 RADIATOR HOSES
B2 OIL FILLER, GAGE & FILTER
B3 STARTING MOTOR MOUNTING
B4 SPARK PLUG WIRING & COIL
B6 VOLTAGE REGULATOR & IGNITION SWITCH

Sheet Title
B7 ENGINE FRONT MOUNTING
B9 ENGINE REAR MOUNTING
C1 AIR CLEANER, CARB, CHOKE, STICKER & ENGINE VENTILATION
C3 GASOLINE & SPARK CONTROL PIPES
D1 ACCELERATOR CONTROLS-LEVER, ROD PEDAL & TRIM PLATE
D3 ACCELERATOR CONTROL ROD, SPRING, SWIVEL & BRACKET

L-6 ENGINE ASM (As shipped)
Initial tension on all 3/8 belts to be 125 ± 5 lbs. and on all 15/32 belts to be 140 ± 5 lbs. **CAUTION** Any re-tensioning of previously installed belts required due to part replacement or repair, should be 75 ± 5 lbs. for all 3/8 belts and 95 ± 5 lbs. for all 15/32 belts.

These specifications are such that the residual or stabilized tension at the time the vehicle is shipped from the plant will result in the latter figures. Belts are to be checked for correct tension with a Burroughs Gage BT-33-95. **NOTE** A.I.R. pump belt strand tension, see RPO K19.

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These specifications are such that the residual or stabilized tension at the time the vehicle is shipped from the plant will result in the latter figures. Belts are to be checked for correct tension with a Burroughs Gage BT-33-95. **NOTE** A.I.R. pump belt strand tension, see RPO K19.
1ST TRACK
2ND TRACK
3RD TRACK

NOTE: For belt tensioning specs, see L-6 belt routing sheet.

NOTE: Air pump belt strand tension—See RPO K19

ALL V-8 ENGINES

RPO C60

RPO N40

RPO C60 WITH RPO N40

CHEVROLET MOTOR DIVISION, GMC

Belt Routing

12000 V-8 ENGINE

UPC

DATE

REV

REVISION RECORD

AUTHOR OR CR

SHELF

6

A6

PAGE 48
1ST TRACK
2ND TRACK
3RD TRACK

NOTE For belt tensioning specs, see L-6 belt routing sheet.

NOTE Air pump belt strand tension—See RPO K19
NOTE: The attaching parts for this bracket must be tightened after the starting motor attaching bolts have been torqued.

- SCREW ASM
- BRACKET ASM
- BOLT
- BRACE
- NUT
- SCREW ASM

STARTING MOTOR MOUNTING

- L-6 ENGINE
- V-8 ENGINE

-t- 5-20 LBS FT
- 30-40 LBS FT
- 60-70 LBS IN
1 2985802 WIRE ASM (CYL NO 1)
2 2985802 WIRE ASM (CYL NO 2)
3 2985805 WIRE ASM (CYL NO 3)
4 2985808 WIRE ASM (CYL NO 4)
5 2985812 WIRE ASM (CYL NO 5)
6 2985814 WIRE ASM (CYL NO 6)
7 2985951 WIRE ASM-HIGH TENSION

[Diagram]

8 Wire from dist to neg terminal. Loosen nut & position terminal between nut & clip.
9 1115208 COIL ASM
10 121852 BOLT
11 3702799 RETAINER

<<CHEVROLET MOTOR DIVISION, GMC>>

SPARK PLUG WIRING & COIL

12000 L-6 ENGINE

UPC 6 B4

DATE SYM REVISION RECORD AUTH. DR CE

Dwg No: 1-15 J2 Ref: B7 L- L-
Date Rev: 3-1 C1 L- L-

SHSHEE L-
ASSEMBLY INSTRUCTIONS
3891775 "F" CAR 12000 SERIES

1. 2985929 WIRE ASM (Cyl no. 1)
2. 2985927 WIRE ASM (Cyl no. 2)
3. 2985929 WIRE ASM (Cyl no. 3)
4. 2985927 WIRE ASM (Cyl no. 4)
5. 2985934 WIRE ASM (Cyl no. 5)
6. 2985934 WIRE ASM (Cyl no. 6)
7. 2985934 WIRE ASM (Cyl no. 7)
8. 2985933 WIRE ASM (Cyl no. 8)
9. 2987119 WIRE ASM-HIGH TENSION

NOTE: Loosen nut on neg. post of coil & position dist wire term between nut & clip.

Part of Engine

Part of Engine

Part of Engine

Part of Engine

Used for Rearward Position

Used for Forward Position

Typical L.H. Side

Typical R.H. Side

- HIGH TENSION

Loosen nut on neg. post of coil & position dist wire term between nut & clip.

1. 3848408 SCREW
2. 2965746 RETAINER
3. 1115457 COIL ASM
4. 3845622 SHIELD ASM
5. 3845621 SHIELD ASM
6. 274430 SCREW ASM
7. 3845717 SHIELD
8. 447143 SCREW
9. 3702799 RETAINER
10. 2977555 RETAINER

SPARK PLUG WIRING, COIL, & SHIELDS

12000 V-8 ENGINE

UPC 6

SKU B5

DATE REL 3-1 DP

L-781063-L-80008
1119515  REGULATOR ASM
See UPC 12 for wiring
3876130  SPL. NUT
9419306  SCREW
2987004  WIRE ASM-GRD

3876129  SCREW-Shoulder of screw must be seated against threaded brass sleeve in nut.
3897349  NUT-IGN. SW.
1116885  SWITCH ASM-IGN.
3904860  BEZEL-IGN. SW

15-20 LBS IN
5-10 LBS IN
25-30 LBS IN

LH HEADLAMP GROUND WIRE HOLE & ATTACHING PARTS

1. WIRE ASM-GRD
2. SPL. NUT
3. SCREW
4. REGULATOR ASM
5. LH HEADLAMP GROUND WIRE HOLE & ATTACHING PARTS
6. OUTBOARD FORWARD
7. CYLINDER ASSEMBLY KEY (FISHER)

VOLTAGE REGULATOR & IGNITION SWITCH

UPC  DATE  SYM  PHYSICIAN RECORD  AUTH. BR. CF
12000  6  1  WIRE ASM-GRD  76288 B
2  SPL. NUT  76468 B
3  SCREW  76468 GP
4  REGULATOR ASM  76288 B
5  LH HEADLAMP GROUND WIRE HOLE & ATTACHING PARTS  76288 B
6  OUTBOARD FORWARD  76468 GP
7  CYLINDER ASSEMBLY KEY (FISHER)  76468 GP
ASSEMBLY INSTRUCTIONS

3891775 “F” CAR 12000 SERIES

9418699 WING NUT
6423516 AIR CLEANER
3708408 GASKET
3901839 HOSE
7025003 CARBURETOR
9419815 NUT
3828267 GASKET
423553 SCREW
3821564 THERMOSTAT & COVER ASM
3830922 ROD

- Position air cleaner into slot before tightening
- Insert & rotate rod 180° to upright position.

NOTE: Insert & rotate rod 180° to upright position.
ASSEMBLY INSTRUCTIONS

3891775 "F" CAR 12000 SERIES

WING NUT
AIR CLEANER ASM
STUD
GASKET-CARB
CARBURETOR ASM
NUT ASM
SPL WASHER-Front studs only
GASKET
THERMOSTAT ASM

NOTE 1 Push choke assembly towards rear before tightening screw.

NOTE! Long end of choke rod must assemble to the thermostat coil.

NOTE: Inboard vertical surface at the lower horizontal surface of the cover must be tight against the manifold.

NOTE: This tang must be engaged in casting hole.

---

1 9418699 WING NUT
2 6424490 AIR CLEANER ASM
3 3901834 STUD
4 3708408 GASKET-CARB
5 7027101 CARBURETOR ASM
6 120388 NUT ASM
7 3719427 SPL WASHER-Front studs only
8 3704952 GASKET
9 3908666 THERMOSTAT ASM
10 3840806 COVER-CHOKE
11 3840807 ROD-CHOKE
12 Position air cleaner into slot before tightening.
13 6255773 CLIP
14 159853 SCREW
15 3911044 STICKER ENG IDENT

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<td>THERMOSTAT ASM</td>
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<td>ROD-CHOKE</td>
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<td>12</td>
<td>Position air cleaner into slot before tightening.</td>
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<td>CLIP</td>
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**CHEVROLET MOTOR DIVISION, G M C**

**UPC**

**DATE**

**REVISION RECORD**

**AUTH. DR. C**

**12000 V-8 ENGINE**

**C 2**

---

**NOTE**

Push choke assembly towards rear before tightening screw.

Long end of choke rod must assemble to the thermostat coil.

Inboard vertical surface at the lower horizontal surface of the cover must be tight against the manifold.

This tang must be engaged in casting hole.
NOTE: Slide hose far enough on spark control pipe to remove slack.
ASSEMBLY INSTRUCTIONS
3891775 "F" CAR 12000 SERIES

1 444040 ELBOW
2 6421884 VALVE ASM
3 3828381 HOSE
4 3853194 ADAPTER ASM
5 9420839 BOLT

6 120392 L. WASHER
7 5646135 GASKET
8 3855582 GASKET
9 445673 PLUG

SECTION A-A

100-125 LBS IN
39 - 49 LBS IN

ENGINE VENTILATING SYSTEM

ENGINE VENTILATING SYSTEM

1 444040 ELBOW
2 6421884 VALVE ASM
3 3828381 HOSE
4 3853194 ADAPTER ASM
5 9420839 BOLT

6 120392 L. WASHER
7 5646135 GASKET
8 3855582 GASKET
9 445673 PLUG

SECTION A-A

100-125 LBS IN
39 - 49 LBS IN

ENGINE VENTILATING SYSTEM

12000 V-8 ENGINE

CHEVROLET MOTOR DIVISION, GMC
NOTE: Bend tabs back against flange of pedal at assembly.
NOTE! Accelerator rod must turn freely in bushing after assembly, and must be orientated as shown with swivel at carburetor end.

NOTE! Must be assembled in direction shown.
ACCELERATOR CONTROL RODS, SPRING, SWIVEL & BRACKET

NOTE: Accelerator rod must turn freely in bushing after assembly.

25-35 LBS. IN.
70-100 LBS. IN.
Adjustment Requirements

With accelerator pedal depressed, Bell Crank or Carburetor Lever (A) must be at wide open throttle position & Dash Lever (B) spaced from pedal support to dimension shown.
ASSEMBLY INSTRUCTIONS

3891775 "F" CAR 12000 SERIES

1. 3920233 SUPPORT
2. 3891754 ROD
3. 3901547 PIN
4. 3909982 SPRING
5. 3909978 PEDAL
6. 9419380 SCREW ASM.
7. 274574 RING
8. 3917565 GASKET

CABLE ASM

CANCELED

19-27 LBS IN

ACCELERATOR CONTROLS-LEVER, ROD & PEDAL

12000 L-6 ENGINE

D5

DRAWING 12-1 REF: ECR8236L 8164/73 L-81078
DATE REV. 12-5 SHEET 1 OF 1

UPC DATE 2ND REVISION CODE AUTH. DR CK
1. 4-67 1 WAS 3963551 SUPPORT 33805 AM
2. 3409400 SCREW
3. 3920233 BUSHING REMOVED 33043 GT C1
4. 2-1-67 4 WAS 3920751 SCREW 33043 GT C1
5. 3909975 WAS 3909980 SCREW 65062 GRV-1 C1
6. 1-1-67 6 SHEET "D5" CANCELLED 65062 GRV-1 C1
ASSEMBLY INSTRUCTIONS
3891775 "F" CAR 12000 SERIES

CONTENT

A1 CONTENTS
A2 CONTROL LEVER
A3 CONTROL LINKAGE
A4 CONTROL LEVER POSITION
A5 LINKAGE ADJUSTMENT

SHEET 1
C1 CLUTCH RELEASE BEARING
C2 CLUTCH PEDAL & LINKAGE
C3 CLUTCH SHAFT & PUSH ROD
C4 LINKAGE ADJUSTMENT

STEERING COLUMN ASM.
-SEE UPC 9.

TRANS. REAR MOUNTING
-SEE UPC 6

CHEVROLET MOTOR DIVISION, GMC

TRANSMISSION-CONTENTS

DWG DATED 12000

101

A1

169
ANTI-RATTLE SPRING - (Part of steering column asm.)

NOTE: Must be installed against tip of lever & parallel to C of column asm.
ASSEMBLY INSTRUCTIONS

3891775 “F” CAR 12000 SERIES

1. 103329 L. WASHER
2. 100161 BOLT
3. 4 FLUID-SYN. TRANS-.249 GALS
4. 4 FLUID-SYN. TRANS-.0045 GALS.
5. 3860040 TRANS-L-6 ENGINE
6. 3915057 -V-8 ENGINE
7. 3895247 ROD-2nd & 3rd
8. 3895245 ROD-1st & REV.
9. 3833108 GREASE .01 LBS.
10. 3833108 GROMMET
11. 382102 BUSHING
12. 3898210 P. WASHER
13. 3749084 RETAINER
14. 3895241 LEVER 1ST & REV
15. 9418931 NUT
16. 103321 L. WASHER
17. 382103 CLAMP
18. 382104 SWIVEL
19. 9419234 P. WASHER
20. 3895243 LEVER-2ND & 3RD

NOTE: Fill to level of filler hole.

45-60 LBS.FT.
15-20 LBS.FT.
15-24 LBS.FT.

MISSION-COMM. CONTROL LINKAGE

UPC | DATE | SYM | REVISION RECORD | AUTH. | DR. | CR.
--- | --- | --- | --- | --- | --- | ---
7 | 12/24/66 | 6 | 3905496 Was 3905496 | 88357 RE | 82234 | 82234
7 | 12/24/66 | 7 | 3915057 Was 3915001 | 88357 RE | 82234 | 82234
8 | 12/24/66 | 8 | TORQUE (2) Was 14-20 LBS.FT | 88357 RE | 82234 | 82234

FM REF: Prel. A3 1-80725 L
ASSEMBLY INSTRUCTIONS
3891775 “F” CAR 12000 SERIES

TRANSMISSION-CONTROL LEVER POSITION

Rev.
21° 25' REF.

2ND
18° REF.

1ST
21° 44' REF.

3RD
17° 0' REF.

NEUTRAL
15° REF.

HORIZONTAL

STEERING COLUMN

CHEVROLET MOTOR DIVISION, GMC

TRANSMISSION-CONTROL LEVER POSITION

UPC

DATE SYM

DIVISION RECORD

AUTH. DR. CR

11/29/44 1 WAS 20° 15' REF
2 WAS 16° 35' REF
3 WAS 16° 40' REF

A4

12000

A4

DWG PREL 2-29 REF: Prel. A4 L-80725 L-

DATE REL 3-1

SHEET 1

1/2
2. Attach Rods (A) & (B) to Shift Levers (E) & (F) with retainers.
3. Use Gage Pin (D) to lock Shift Levers (E) & (F) in "NEUTRAL" position utilizing gage slots. See View B.
4. Install Grommet in Trans. Levers. Slide Swivel into Rods (A) & (B) then loosely assemble Swivel, Clamps, Bushings, Plain Washers, Lockwashers and Nuts (C) to Trans. Levers. See View A.
5. Tighten Nut (C) using recommended torque. See View A.
6. The centerlines of the Shift Lever Tangs must be within .01 of each other and must be ± 1°-0' of horizontal centerline after Rods (A) & (B) are secured.
ASSEMBLY INSTRUCTIONS

3891775 "F" CAR 12000 SERIES

1  3828428 RETAINER  
2  3798256 BUSHING  
3  3749084 RETAINER  
5  3888680 COVER PAD  
6  3890609 PEDAL ASM  
7  3899020 PEDAL PUSH  
8  3419699 SCREW  
9  9419699 SCREW  
10 3723230 BUMPER  
12 3748358 WASHER  
13 3908071 SEAL ASM

CAUTION Retainer 1 must scribe a legible line on end of clevis pin during assembly. Avoid any expanding tool which nullifies this intent.
CLUTCH ADJUSTMENT

Apply a 10 lb. load in direction of Arrow (E) to hold Clutch Pedal against Clutch Pedal Bumper.

Apply a 10 lb. load to Clutch Fork in direction of Arrow (D) to eliminate clearance between throwout bearing and clutch fingers.

Insert a .198 Spacer (F) between clutch fork and Adjusting Rod (A).

Rotate Adjusting Rod against Spacer until it has a 5 in. lb. torque.

Hold Adjusting Rod and tighten Nut (C) against Swivel (B) or Rod (B).

Remove Spacer. Install return spring and extension to clutch fork.

Pedal will have approximately 1.00-1.125 free travel.
Sheet 1

Contents

A1 Exhaust System - Front Exhaust Pipe & Manifold Attachment
A2 Exhaust System - Rear Exhaust Pipe & Hangers
A3 Exhaust System - Muffler Assembly
A4 Exhaust System - V-8 Eng Front Exhaust Pipe Assembly & Manifold Attachment
A5 Exhaust System - Exhaust & Muffler Assembly, Checking Dim.

Sheet 2

B1 Gas Tank & Straps
B2 Gas Meter & Rear Hose
B3 Fuel Line & Clips
B4 Lower Filler Neck & Cover

Chevrolet Motor Division, GMC
Do not drive into position at over 250 R.P.M. (free) to prevent excessive heat build-up and consequent galling of nut or stud. Tighten nuts uniformly to specified torque. (8 lbs. ft. minimum inspection torque after roll test.

**NOTE**

Dimension indicated is reference reflecting nominal design clearance. Variation of more than .25 from this dimension indicates a quality deficiency.

---

**Title:** Exhaust System - Exhaust Pipe

**Model:** 3891775 “F” Car 12000 Series

**Part Numbers:**
- 3629086 NUT
- 3892765 Exhaust Pipe ASM
- 3748781 Extension
- 3696990 Packing

---

**Diagram:**

- Transmission Support
- Exhaust System - Exhaust Pipe
- Manifold Attachment

---

**Table:**

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**Notes:**

- Do not drive into position at over 250 R.P.M. (free) to prevent excessive heat build-up and consequent galling of nut or stud.
- Tighten nuts uniformly to specified torque. (8 lbs. ft. minimum inspection torque after roll test.)
- Dimension indicated is reference reflecting nominal design clearance. Variation of more than .25 from this dimension indicates a quality deficiency.
ASSEMBLY INSTRUCTIONS

3891775 “F” CAR 12000 SERIES

<table>
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<td>SCREW ASM</td>
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All dimensions indicated are reference reflecting nominal design clearance. Variation of more than .25 from the dimension indicates quality deficiency in a component part.

NOTE: Apply to full I.D. of muffler inlets prior to assembly with rear exhaust pipe.

NOTE: Front of hanger asm. bracket to line up with rear exhaust pipe.

1. D. of muffler inlets prior to assembly with rear exhaust pipe.

NOTE: Apply to full I.D. of rear exhaust pipe to assembly of front exhaust pipe.
ASSEMBLY INSTRUCTIONS

3891775 "F" CAR 12000 SERIES

3892787 MUFF & TAIL PIPE ASM L-6
3892772 V-8
3863512 CLAMP
1363900 SCREW
9411890 SCREW

3892790 HANGER ASM

All dimensions indicated are reference reflecting nominal design clearance. Variation of more than .25 from this dimension indicates a quality deficiency in a component part.

NOTE: Rear spring edge, full round.

84-103 LB. IN.
35-50 LB. IN.

REAR QTR. PANEL

EXHAUST SYSTEM-MUFFLER
ASM & HANGER

EXHAUST SYSTEM-MUFFLER ASM & HANGER

DATE SYM
11-8-66 7
11-3-66 8

REVISION RECORD
11-66 MUFFLER ADDED
11-77 B WAS 34/3400 3680W
(19-27 LBS. IN)

AUTH. CK
3385500 R

1200U

Dwg. Prc. 7-3
date rel. 3-1
ref: Prel. A3 l-79355 l-

A4

Sheet1
Dimensions indicated are reference reflecting nominal design clearance variation of more than .25 from this dimension indicates a quality deficiency.

Note: Do not drive into position at over 250 R.P.M. (Free) to prevent excessive heat buildup and consequent galling of nut or stud. Tighten nuts uniformly to specified torque. (8 lbs. ft. minimum inspection torque after roll test).

13-17 lbs. ft.
ALL DIMENSIONS INDICATED ARE REFERENCE REFLECTING NOMINAL DESIGN CLEARANCE. VARIATION OF MORE THAN .25 FROM THIS DIMENSION INDICATES A QUALITY DEFICIENCY IN A COMPONENT PART.

MUFFLER BEAD

21.76

19.89

13.17 REF

1.57 L & R.

E OF MUFFLER

EXHAUST SYSTEM - EXHAUST & MUFFLER
ASM. CHECKING DIMENSIONS
ASSEMBLY INSTRUCTIONS
3891775 "F" CAR 12000 SERIES

1 3863930 INSULATOR
2 55 CEMENT- (0.54 oz)
3 55A CEMENT- (0.08 oz)
4 9417761 SCREW-DRIVE
5 3895203 CAP ASM.
6 3895204 HANDLE

Handle & cap asm must fit securely after assembly.

NOTE: When cap is in the closed position the axis of the handle must be within 3° of vertical. Variation from this dimension indicates a quality deficiency.

7 3908341 STRAP
8 3909904 TANK ASM.
9 3893119 ANTI-SQUEAK
10 396712 BOLT
11 1361640 NUT
12 92 GASOLINE
13 9420065 SCREW
14 396713 SPACER

NOTE: After fuel tank is mounted, tank may be pressurized up to 0.75 PSI maximum to check for final line leakage or force fuel through the system. Pressures greater than this amount are detrimental to fuel tank durability due to mounting strap stretch and/or tank distortion.

80 - 110 LB. IN.

GAS TANK & GAS TANK STRAPS

UPC 8 B1

DATE SYM. REVISION RECORD AUTH. DR. CK
12/2816 9 WAS: 3892105 TANK ASI 72255 NC DD
11/28210 0.8 WA: 0812 oz 52426 NC
11 0.08 WAS: 0621 oz 525 NC
185

1 SHEET X

1/25
NOTE: No flux or residue should be allowed to remain in tank or filler neck after soldering operation.
CAUTION: Assemble tie rod sleeve adjusting clamp between dimples at ends of sleeve.

NOTE: Ends of adjustable tie rods must be held in correct angular relationship to each other after adjustment within +2°.

Inboard clamps—L. & R.H. side:
Open end of clamp must be positioned within 15° either side of tie rod sleeve slot (Position relative to ground unimportant.)

Bolts must be positioned as shown (Position relative to slot unimportant).

*NOTE: A torque of 50 lbs. ft. maximum is permissible on nut after insertion of cotter pin.
CAUTION! With the .20"-.30" spacing dimension (measured at lower pin) held when column is tightened to LP, (items 2 & 5) permissible rag joint distortion is that which results from the steering column to steering gear included shaft angle maintained at 3° (ref.).

NOTE The minimum upper pin to flange engagement is pin flush to rear flange surface.

-60-75 LBS FT
-15-20 LBS FT
-120-180 LBS IN
-12-18-LBS FT 15-25 LBS FT
1) 415919  P. WASHER
2) 9745767  CHART-STEERING WHEEL
   ASM 12300-400
   9745769  12500-600

2) JHWIB Notch is steering wheel hub must be in line with mark on shaft.

3) NOTE  Steering wheel must be assembled to shaft with center spoke as shown, & wheels positioned straight ahead.

30-40 LBS FT
1. Position rolled portion of dash seal (part of column asm.) at column lower reaction tab—two inches from bottom of jacket. CAUTION: Rolled portion of seal must be directed down column toward front of car and must remain in this position during and after column installation. See View B.

2. Install upper (A) and lower (B) steering column to dash covers on column and tighten two screws (C) so that cover assembly is snug on column but still will move with respect to column.

3. Glue seal (D) (part of the column assembly) to upper (A) and lower cover (B).

4. Position column in car.

5. Attach steering shaft flange to rag joint and tighten nuts (G) to specified torque.

6. Position wedge on forward support with retainer (L).

7. After mast jacket bracket to mast jacket bolts are tightened to specified torque, install two rearward mast jacket bracket retaining nuts (H) and tighten nuts to specified torque while holding rag joint to flange clearance dimension (X) shown on Sheet A-3.

8. Position wedge (E) to distance required to fill gap—do not force wedge beyond this point.

9. Holding wedge in position, install forward mast jacket bracket nut (K) and tighten the nut to specified torque.

10. Push upper (A) and lower (B) cover assembly to dash and line up all cover to dash attaching holes. CAUTION: Do not permit rolled section of seal (D) to reverse itself.

11. Holding both upper & lower cover assemblies against dash & column, install & tighten two screws (J) to the specified torque.

12. Tighten two screws (C) to specified torque.

13. Loosen two screws (J) & shake column in area immediately above cover, so as to make certain column position is not affected by column to dash cover attachment.

14. Install screw (M) & tighten it along with two screws (J) to specified torque.
ASSEMBLY INSTRUCTIONS
3891775 "F" CAR 12000 SERIES

Sheet Title:

A1 CONTENTS
A2 SPARE TIRE & JACK STOWAGE

1 3884014 TIRE UNIT CHART 7.35-14
2 3869444 WHEEL ASM
   3869454 OPT
3 3872273 OPT
4 9421500 WHEEL BALANCEWEIGHT
   CHART (Approx 1 wt. per wheel as req'd)

3 4 All wheel & tire assemblies are to be checked for static unbalance. Add weights to inside of wheel at rim edge only to obtain a balance condition not to exceed 5 oz. inches of unbalance. If total weight required to balance the wheel & tire assembly exceeds 5 oz., either the tire or wheel is excessively out of balance and the assembly should be rejected.

5 Serial number on tire to face inside of wheel when tire is mounted on wheel asm.

6 3 LUBRICANT-RUBBER 1.6 OZ.

7 3 14 HUB ASM
7 3 24 HUB CAP (SEE MISC. SHIP. LIST UPC 0)
7 3 5 NUT (SEE UPC 3 & 4)

4 3 NOTE: All tires of same size & ply rating furnished with any vehicle shall be of same make

# CHEVROLET MOTOR DIVISION, G.M.C.

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135
Position wheel so that tire valve stem is down.

Housing to be positioned at bottom of column against stop.

Lug wrench to be slipped under tire after wing nut has been started on bolt. Complete & tighten wing nut.

NOTE: Lug wrench to be slipped under tire after wing nut has been started on bolt. Complete & tighten wing nut.

62-91 LBS. IN.
SUGGESTED SHEET METAL ASSEMBLY PROCEDURE

A. Grille cube sub-assembly
   1. Rivet center grille (A) to upper grille (B) and lower grille (C).
   2. Rivet valance panel (D) to lower grille (C).
   3. Nest above grille assembly in fixture and attach grille header panel (E) with screws.
   4. Attach parking lamp (F) to grille.
   5. Attach hood lock catch support grille (G) to header panel (E) and valance panel (D).
   6. Attach catch asm. (H) to hood lock catch support (G) an grille header panel (E).

B. Radiator support - (J) sub-assemble assemble radiator, shroud, and electrical components.

C. Fender sub-assemble assemble fender (K), skirt (L), bumper bracket (M) and fender extension (N).

D. Headlamp housing (P) sub-assemble headlamp (R) to the headlamp housing (P).

E. Hood (S) sub-assemble hood lock (T), ornamentation and insulators.

F. Final Sheet Metal Assembly
   1. Loose assemble radiator support to frame
      (Note: optional at this time to have grille sub-assemble to the support.)
   2. Loose assemble fenders to radiator support and cowl.
   3. Introduce grille cube and pin catch assembly to support and drive bolts.
   4. Drop in squaring fixture to establish body and sheet metal relationship.
   5. Drive valance panel to fender and fender extension bolts.
   6. Drive header to fender bolts.
   7. Adjust sheet metal to doors, shim, and drive fender to cowl, front of dash, hinge pillar, and rocker bolts.
   8. Remove squaring fixture.
   9. Drive remaining front end attachment.
   10. Install radiator support to frame mounts and tighten bolts.
   11. Install headlamp housing assembly and drive bolts to the fender then drive the bolts through radiator support.
   12. Drop in hood, fit to fenders and header then drive hinge bolts.
   13. Adjust hood lock striker and hood bumpers to obtain flush condition.
   14. Adjust cowl vent grille to provide uniform gap at rear of the hood and drive bolts.
   15. Aim headlamp and attach bezels.

---

![Diagram](image_url)
3891775 "F" CAR 12000 SERIES

1. 3886607-8 FENDER ASM L. & R.H.
2. 3916019 BUMPER
3. 3839741 SCREW ASM
4. 3711834 SHIM (As req'd)
5. 3891633-4 REINFORCEMENT ASM. L. & R.H.
   A. Spotweld (6) places to reinforcement
   B. Spotweld (20) places to 1
   C. Spotweld (4) places to reinforcement

REINFORCEMENT PART OF 1

30-35 LBS. FT.

FENDER & CENTER REINFORCEMENT

UPC

DATE  SYM  DIVISION RECORD  AUTH. OR CK
54-66  1  ITEM 7 ADDED  SHEET 1  CP
96-66  1  ITEM 7 WAS ITEM 3  SHEET 2  CP
98-66  1  WAS 3891690 BUMPER  82067  DF

11-13

B1

12000

145
Sufficient pressure must be exerted at the center of retainer to assure full engagement of the largest diameter of retainer prong thru the hood inner panel.
ASSEMBLY INSTRUCTIONS

PLATE ASM 3891682
"J" NUT 3784845
CATCH ASM 5891606
SUPPORT ASM 3891650
SCREW 9780422
BUMPER 3792828

"J" NUT 3839682
SCREW 1359887
NUT 9418302

BUMPERS-Hood bumper must be adjusted until hood & fender line up to dimension shown. Adjust hood lock bolt until hood & header peak surface line up to dimension shown. See sheet metal checking.

GREASE (.002 LBS.)
NOTE! All gap tolerances between hood & adjacent panels to be held constant as far as possible.

NOTE: Adjust to align rear bumper parallel to taillamp housing.

VIEW A

TYPICAL SECTION

TYPICAL ON SURFACE FLUSH CONDITION DESIRED

HEADER TO FENDER FLUSH ± .06

HEADER TO BE FLUSH TO + .06 TO HEADER

SURFACE

FENDER TO W/SHIELD MOLDING .06 ± .06

GRILLE & FENDER .06 TO .18 GAP

GRILLE TO W/SHIELD MOLDING +.06 - .06

FENDER FLUSH TO .06 ABOVE DOOR

FENDER .06 TO .120 OUTBOARD OF DOOR AT THE FENDER CENTER PEAK LINE.

FENDER PEAK LINE

FENDER TO DOOR .182 .04

FENDER TO ROCKER .091 .06

NOTE: Adjust to align rear bumper parallel to taillamp housing.
ASSEMBLY INSTRUCTIONS
3891775 "F" CAR 12000 SERIES

Sheet A1
- CONTENTS

Sheet A2
- BATTERY TRAY

Sheet A3
- HEADLAMP & PARKING LAMP

Sheet A4
- BATTERY & CABLES

Sheet A5
- HEAVY DUTY BATTERY & CABLES

Sheets A5.5
- HEADLAMP & CABLES

Sheet A6
- BLOCK WIRING & HORN WIRING

Sheet A7
- GEN, REG, & RELAY WIRING

Sheet A8
- ENGINE WIRING L-6 ENGINE

Sheet A9
- ENGINE WIRING V-8 ENGINE

Sheet A10
- HEADLAMP AIMING

Sheet B1
- FUSE PANEL

Sheet B2
- INSTRUMENT CLUSTER

Sheet B3
- INSTRUMENT CLUSTER LIGHTING

Sheet B4
- INSTRUMENT PANEL HARNESS

Sheet B5
- INSTRUMENT PANEL HARNESS

Sheet B6
- LIGHT SW. & CIGARETTE LIGHTER

Sheet B7
- DIMMER & STOP LAMP SW.

Sheet B8
- COURTESY LAMP, INST. PANEL COMP

Sheet B9
- LIGHT SW.

Sheet B9
- PARKING BRAKE ALARM

Sheets C1
- REAR LICENSE LAMP

Sheets C2
- DIRECTIONAL SIG. LAMP & HORN CAP

Sheets C2.5
- BACK-UP LAMP FRONT WIRING

Sheets C3
- SPEEDOMETER SHAFT

Sheets D1
- ENGINE-COMP. WIRE DIAGRAM

Sheets D2
- FUSE PANEL

Sheets D3
- INST. PANEL-CLUSTER

Sheets D4
- BODY & REAR END

Electrical Contents

Model 12000

Dwg - WO Ref: A1 L - L - L
Date REL 3/1 DP

UPC 12

Title 12000

Sheet A1
ASSEMBLY INSTRUCTIONS

3891775 "F" CAR 12000 SERIES

1. 9780422 SCREW ASM
2. 3893882 TRAY ASM
3. 3758783 BOLT
4. 3887588 CLAMP
5. 9420941 SCREW ASM

RADIATOR SUPPORT

FENDER SKIRT

BATTERY

NOTE: Lip of clamp must fit in slot of battery.

120-180 LBS IN.
60-80 LBS IN.

- CHEVROLET MOTOR DIVISION, GMC -

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RECOMMENDED INSTALLATION PROCEDURE

2. Assemble the above headlamp housing assembly to the fender, header panel, valance panel upper, lower, center grille and radiator support in the following sequence.
   a. First, drive the two outboard screws [9] used to attach the headlamp housing [18] to the fender.
   b. Second, drive the three inboard screws [3] through the radiator support.
   d. Assemble the headlamp bezel [13] to the fender, drive the outboard screw [12] to the fender, then the two inboard screws [12] and [14].
To prevent diode damage, all connections including generator, regulator and relay must be tightened before positive battery terminal is connected.
ASSEMBLY INSTRUCTIONS

3891775 "F" CAR 12000 SERIES

- L. WASHER 138485
- NUT 120368
- L. WASHER 138489

**CAUTION!** When assembling battery cable terminals to battery, do not open beyond position shown or permanent set and loose connections will result.

With terminals fully open push onto battery post as far as possible at least flush with or below top of post.

Do not drive terminal onto post with hammer or any other tool.

10-16 LBS. FT.
15-22 LBS. FT.
Clips part of engine. Bend to position shown.
ASSEMBLY INSTRUCTIONS

3891775 “F” CAR 12000 SERIES

1. 6291938 HARNESS ASM-ENGINE
2. 3815935 SW. ASM-OIL PRESSURE
   Keep free of chassis paint
3. NUT-Positive (+) post-locsen to allow term to be positioned between nut & clip.
4. CLIP-Part of engine asm bend at asm
5. 120622 NUT
6. 121752 L. WASHER
7. 120614 NUT
8. 138479 L. WASHER
9. 3799990 CLIP
10. Install clips on outside of heater case.
11. 1993409 SW ASM WATER TEMP
12. 3864327 RETAINER
13. 9427325 SCREW ASM.

CAUTION: Wire end of conn. must always remain at 90° or not pass line "A" max.

NOTE: Press boot over switch asm.

1. CYLINDER ASM. BRACKET
2. CLIP PART OF 7
3. EXISTING SCREW
4. BRAKE SW. ASM.
5. NUT (UPC.1)
6. TO BLOWER MOTOR
7. W/S WIPER MOTOR
8. POS. BATTERY CABLE
9. SEE SHEET A8
10. PPL. TO SW. TERM.
11. YELLOW (TO 'R' TERM.)

ENGINE WIRING

12000 L-6

UPC A8

DATE 31/01/80

REV: A

165
NOTE: Press boot over switch asm.

4-20 LBS FT.
100-125 LBS IN.
20-30 LBS FT.
25-35 LBS IN.

BALANCE OF ENGINE HARNESS SAME AS LG ENG. EXCEPT AS SHOWN SEE SHEET A8

TO BRAKE ALARM SWITCH ASM SEE SHEET A8

CLIP-PART OF HARNESS

STARTER MOTOR

BOLT-CLUTCH HOUSING

W/S WIPER MOTOR

EXISTING CLIP

SEE SHEET A8

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UPC 12 193351-640186
HEAD LAMPS ARE TO BE AIMED AS FOLLOWS:

(This specification represents the SAE visual aim specifications per SAE code J-599a)

Headlamp Visual Aim Specifications

Beam locations are shown on an aiming board 25 feet from the lamps.

Horizontal - Represents a horizontal centerline at the level of the lamp center.

Vertical - Represents a vertical centerline straight ahead of the lamp center.

Low Beam - Low beam filament to be aimed as shown

1. Left hand edge of high intensity zone must be 2"
   right of vertical with limits of on vertical line
to 6" right of vertical line.

2. Upper edge of high intensity zone must be at
   horizontal with limits of ± 2" above and below
   the horizontal line.

LOW BEAM Aim Diagram

IT IS SUGGESTED MECHANICAL AIM BE CONSIDERED AS FOLLOWS:

HORIZONTAL

"When using a mechanical type aimer incorporating a split image or equivalent, the aiming plane
horizontal setting is 0°± .40°. R.H. and L.H. aimers calibrated to read 0° when mounted on individual
checking planes angled .30° to right for L.D. vehicles; .30° left for R.D. vehicles."

VERTICAL

"The aiming plane vertical setting is 0°± .30° using the same mechanical aimer incorporating a spirit
level or equivalent and calibrated to read 0° when aiming plane is perpendicular to level."

"Vehicle to be a curb minus gas weight and on a level area of transit accuracy for all four wheels."
ASSEMBLY INSTRUCTIONS

3891775 "F" CAR 12000 SERIES

BULB-HEATER CONTROL
- A. 383638 FLASHER ASM.
- B. 3909545 OPT.

CLIP
- 3866440
- 9419232
- 9419583
- 3903405

SCREW
- 9419663

INSULATOR 12300-400
- 2962664

TAPE (4 in.)
- 3724851

Insulator to inst.
- pnl compt. light
terminal wire.

NUT
- 445109

15-20 LBS. IN.

INSTRUMENT PANEL WIRING HARNESS

UPC

DATE

SYM

DESCRIPTION

REV

REVISION RECORD

AUTH

DR

CK

12

10 ITEMS S & 3 ADDED

11 VIEW "B" REVISED

Chevrolet Motor Division, GMC

12000

B 4

164
ASSEMBLY INSTRUCTIONS
3891775 "F" CAR 12000 SERIES

*INDICATES A COMBINATION TO BE USED OPTIONAL WITH A COMBINATION INDICATED BY #.

CONNECTOR-Part of instrument panel wiring harness.

CONNECTIONS:

1. #7002184 RETAINER
2. 3904863 BEZEL
3. #7033520 HOUSING ASM
4. #7031884 KNOB ASM
5. 3886987 ROD ASM
6. 3904861 NUT ASM
7. 1995147 SWITCH ASM-LIGHT
8. 1995149 RPO U17
9. 3904862 BEZEL

* 20-30 LBS IN.
  # 8-10 LBS IN.

CHEVROLET MOTOR DIVISION, GMC

LIGHT SWITCH & CIGARETTE LIGHTER

UPC 12
B 6

DATE REL 12000
DRAWN REL 12000

REF: Prel. B£ 1-72/S7 L-75/87 L-

SHEET 1
After adjustment of brake pedal, adjust switch asm so that electrical contact is made when brake pedal is depressed to dimension shown.
ASSEMBLY INSTRUCTIONS

3891775 “F” CAR 12000 SERIES

1 9417863 BULB
2 3870209 SWITCH ASM. (OPT.)
3 4876863 SUPPORT
4 193125 BULB
5 9417587 WASHER

NOTE: Route wire thru slit in top of inst. pnl compt asm.

NOTE: Terminal must be assembled to switch before bulb can be properly installed.

ORANGE (Part of inst panel harn asm)

15-25 LBS IN.
### ASSEMBLY INSTRUCTIONS

**3891775 “F” CAR 12000 SERIES**

<table>
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<tr>
<th>Part Number</th>
<th>Description</th>
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<td>134551</td>
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<tr>
<td>121753</td>
<td>L. WASHER</td>
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<tr>
<td>3863390</td>
<td>SWITCH ASM.</td>
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<tr>
<td>3916782</td>
<td>STRAP</td>
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**INSTRUMENT PANEL**

**PARKING BRAKE PEDAL ASM.**

**FUSE PANEL ASM.**

**PARKING BRAKE CABLE**

**35-50 LBS. IN.**

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**CHEVROLET MOTOR DIVISION, GMC**

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<th>REV.</th>
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<th>Dwg.</th>
<th>Auth.</th>
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<td>397</td>
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**12000**

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<td>REL</td>
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**SHEET 1 X**

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**PARKING BRAKE ALARM**

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<tr>
<td>61093</td>
<td>L</td>
<td>L</td>
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Transmission must be in neutral position for installation of back-up lamp switch.

CAUTION Position switch actuator & hazard flasher plunger in off position before cam asm-installation.
INSTALLATION OF BACK-UP LIGHT SWITCH

1. After Transmission Control Linkage adjustment, place Transmission Selector Lever into “Reverse”.

2. Locate “Reverse” position of switch by manually pushing switch drive tang to left and inserting .093 dia. pin to depth of .250 in.

3. Install switch to column and rotate switch clockwise until switch drive tang contacts left surface of Shift Tube opening.

4. Install attaching screws and torque to specifications.

5. Remove .093 dia. pin.
ASSEMBLY INSTRUCTIONS
3891775 "F" CAR 12000 SERIES

LH. DOOR JAMBSW
INST PNL COMPT LP
RADIO
HEAT CONTROL SW
HEAT CONTROL LIGHT
CE LIGHTER

14OR 20GY 20GY
ONLY WIRES PERTINENT TO PRODUCTION OR NEUTRAL SAFETY SW. HAVE BEEN SHOWN.

12R 12P 12P
INSTRUMENT CLUSTER
- ILLUM
- BRAKE ALARM
- R.H. SIG LAMP
- GEN WARN. LAMP
- ILLUM
- ILLUM
- FUEL GAGE
- OIL PRESS. WARN.
- L.H. SIG LAMP
- ENG TEMP WARN. LP
- ILLUM

HIGH BEAM LAMP
LIGHT SW

W/S WIPER SW

BODY HARNESS
SHEET TITLE

A1 CONTENTS
A2 FRONT BUMPER
B1 REAR BUMPER
B2 REAR BUMPER GUARD

UPC 0 (Continued)
SHIPPING PROTECTION (Seat Covers, Wax)
LUBRICATION, COOLING SYSTEM, GASOLINE & REFRIGERANTS
PLASTIC CEMENT & SEALERS

The following parts are located in UPC 10
AUTO JACK
JACK STOWAGE

MISCELLANEOUS LABELS & STICKERS
IDENTIFICATION NO. PLATE
CUSTOMER VEHICLE PROTECT O'PLATE
MISCELLANEOUS SHIPPING LIST

---

*CHEVROLET MOTOR DIVISION, GMC*

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**ASSEMBLY INSTRUCTIONS**

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**SUGGESTED FRONT BUMPER ASSEMBLY SEQUENCE**

1. Assemble item 5 to fender skirt & fender extension. (See UPC 11-13).
2. Loosely assemble item 2 to frame asm.
3. Assemble item 13 to item 5 and torque.
4. Loosely assemble item 2 to item 13, then torque item 2 to frame.
5. Torque item 2 to item 13.

---

**DIAGRAM**

- **VALANCE PANEL**
- **FRAME ASM**
- **SCREW ASM (UPC 11)**
- **SPL. WASHER**
- **BOLT**
- **NUT ASM.**
- **BAR-FRONT BPR. FACE**
- **SCREW ASM.**
- **BOLT**
- **NUT**
- **WASHER**

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<td>TORQUE BLS 20-30 IN. FT</td>
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ASSEMBLY INSTRUCTIONS

3891775 "F" CAR 12000 SERIES

DY-UPC 1 (A01-E99)

* A48   BELTS-Seat-Less
* A39   BELTS-Seat-Frt & Rr
* A17   GLASS-(Export)
* A01   GLASS-Body Tinted
* A02   GLASS-Windshield-Tinted
* A85   HARNESS-Shoulder-Deluxe
* A81   HARNESS-Shoulder-Std
* A82   HEADREST-Spc Contour Type
* A47   SEAT-Frt Bench Contour Type
* A57   SEAT-Folding Rr
A31   WINDOW-Electric

B93   GUARD-Door Edge
* B37   MATS-Floor

C60   AIR CONDITIONING-All Weather
C50   DEFROSTER-Rr Window
C48   HEATER-Less

* C05   TOP-Folding
C06   TOP-Folding-Power Lift
C08   TRIM-Roof Exterior Soft

D55   CONSOLE-Frt Compartment
* D80   EXTENSION-Valance
* D28   MIRROR-O. S. R. V. Export
D33   MIRROR-Outside Rr View-Remote
D91   PAINT STRIPE-Header (See L48)

FRAME-UPC 2 (F01-F39)

FRONT SUSPENSION-UPC 3 (F40-F99)

* F41   SUSPENSION-Frt & Rr Spc Perf (See UPC 3 & 4)

REAR SUSPENSION-UPC 4 (G50-H99)

* G31   SPRING-Rr-Spc (See UPC 4)
G80   AXLE-Rr-Positraction
* G94   AXLE-Rr-3.31 Ratio
* G96   AXLE-Rr-3.55 Ratio
* G97   AXLE-Rr-2.73 Ratio
* G92   AXLE-Rr-3.08 Ratio (Export)
* H01   AXLE-Rr-3.07 Ratio
* H05   AXLE-Rr-3.73 Ratio

BRAKE-UPC 5 (K01-L99)

J52   BRAKE-Disc-Frt
* J65   BRAKE-Metallic Facing
J50   BRAKE-Vacuum Power
* J58   BRAKE-Heavy Duty

ENGINE-UPC 6 (K01-L99)

* K76   GENERATOR-A/C-61 Amp
K30   CONTROL-Speed & Cruise
K02   DRIVE-Fan
* K79   GENERATOR-A/C 12-42 Amp
K19   REACTOR-Air Injection
K24   VENTILATION-Closed Engine Positive

L22   ENGINE-L-6 250 Cu In
L30   ENGINE-V-8 327 Cu In
L48   ENGINE-V-8 350 Cu In (SS)
* L32   ENGINE-V-8 283 Cu In (Export)
* L92   ENGINE-V-8 Low Compression-Export
L35   ENGINE-V-8 396 Cu In
L78   ENGINE-V-8 396 Cu In; Spc Hi-Perf.
* L90   ENGINE-L-6 Low Compression-Export

SEE MISC. SHIPPING LIST:
* DENOTES OPT. INDEXED ONLY (SEE INTROD SHT)
ASSEMBLY INSTRUCTIONS
3891775 "F" CAR 12000 SERIES

TRANSMISSION-UPC 7 (M01-M99)

- M11 FLOORSHIFT-TRANS CONT. (SEE M13)
- M13 TRANSMISSION-3 Spd H. D.
- M20 TRANSMISSION- 4 Spd
- M21 TRANSMISSION-4Spd-C. R. (SEE M20)
- M35 TRANSMISSION - Powerglide
- M40 TRANSMISSION - 3 Spd Automatic

ELECTRICAL & INSTRUMENT-UPC 12 (T60-U99)

- T60 BATTERY H. D.
- T64 BATTERY (Less)
- T70 HEADLAMP (Export)
- U73 ANTENNA-Rr Manual
- U35 CLOCK - Electric
- U17 CONSOLE - Frt Compt Inst Cluster
- U15 DEVICE - Speed Warning
- U03 HORN - Low "D" Note
- U28 LAMP - Ash Tray
- U27 LAMP - Glove Compt
- U25 LAMP-Luggage
- U26 LAMP-Underhood
- U29 LIGHTS-Inst Pnl Courtesy
- U63 RADIO-Push Button
- U69 RADIO-Push Button-AM/FM (See U63)
- U80 SPEAKER-Auxiliary
- U18 SPEEDOMETER (Export)
- U57 TAPE PLAYER

FUEL & EXHAUST-UPC 8 (N01-N29)

- N10 EXHAUST-Dual
- *N61 EXHAUST-Dual-Deep Tone (See N10)

STEERING UPC 9 (N30-N49)

- N40 STEERING-Hydraulic
- * N44 STEERING-Special
- N33 WHEEL-Steering - Tilt
- N34 WHEEL-Steering - Wood Grained
- * N30 WHEEL-Steering Deluxe

RADIATOR & GRILLE-UPC 13 (V01-V29)

- V01 RADIATOR-H. D.

WHEEL & TIRE-UPC 10 (N50-T49)

- * N96 COVER-Wheel Trim-Sim Mag [1]
- N65 SPARE TIRE-Space Saver Wheel
- * P01 COVER-Wheel Trim [1]
- * P02 COVER - Wheel Trim-Sim Wire [1]
- * P02 TIRES-7. 35-14-4PR-NYLON-White Stripe
- * P58-P71 TIRES
  - 38 TIRES (Less)
- * P73 TIRES-14-4PR-NYLON-Red Stripe
- * P12 WHEEL-14 X 6JK

BUMPERS & MISCELLANEOUS-UPC 14 (V30-V99)

- * V48 ENGINE COOLANT-Maximum Protection
- V31 GUARD-Frt Bumper
- V32 GUARD-Rr Bumper
- * V60 PUMP-Tire (Export)

SPECIAL ITEMS (Z01-Z99)

- * Z14 AIR CONDITIONING-Body Conversion
- * Z12 GEAR-Speedo Driven
- * Z87 INTERIOR-Deluxe
- Z21 PAINT STRIPE
- Z22 PACKAGE-Rally Sport
- Z23 PACKAGE-Interior Decor
- Z28 SPECIAL ENGINE EQUIP

1 SEE MISC SHIPPING LIST
**DENOTES OPT INDEXED ONLY (SEE INTROD SHT)

CHEVROLET MOTOR DIVISION, GMC

ALPHABETICAL OPTION LIST

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1 SEE MISC SHIPPING LIST
*DENOTES OPT INDEXED ONLY (SEE INTROD SHT)
The following components are not illustrated in this R.P.O. (Except as shown below) See Parts List or Bill of Materials for part numbers.

**NOTE**

**UPC 12 ELECTRICAL**

12L CIRCUIT BREAKER & WIRE ASM. - Assembles same as RPO C06

**NOTE**

Plug into fuse panel receptacle marked "Acc. Fused".

**EXISTING FISHERBODY HARNESS**

**FUSE PANEL ASM.**
Place control bracket between flange & instrument panel compartment.

NOTE: Cut lock extension to 1.54 length.

NOTE: Use cylinder & bracket as template.
**ASSEMBLY INSTRUCTIONS**

3891775 “F” CAR 12000 SERIES

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<td>A2</td>
<td>INSTRUMENT PANEL HOLE COVER &amp; HARNESS TAPE</td>
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<td>2</td>
<td>3909136 COVER</td>
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<td>2</td>
<td>3724851 TAPE</td>
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<td>A. 1 inch-Def duct hole</td>
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<td>B. 4 inches-Tape heater blower connector &amp; wire lead.</td>
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<td>C. 1 inch-Heater hose clip hole</td>
<td>3925403 MAT ASM</td>
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<td>D. 1 inch-Heater blower &amp; air inlet asm screw hole</td>
<td>3868790 FASTENER</td>
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| 3 | 9419803 SCREW | 6/4 | DIA. 3 PLACES |
|   | USE COVER AS TEMPLATE |

|   | 141 | DIA. 6 PLACES |
|   | AT EXISTING DIMPLES |

|   | 8 | NOTE |
|   | BALANCE OF INSTALLATION SAME AS REG. PROD. |

|   | 56 | DIA. AT DIMPLE |

- **Existing Hole**: View A Added
- **Existing Hole**: 15-25 LBS IN

**CHEVROLET MOTOR DIVISION, GMC**

**UPC**

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<td>HH</td>
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<td>9/26</td>
<td>5</td>
<td>WAS 3823881 MAT</td>
<td>FB</td>
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<td>3/76</td>
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ASSEMBLY INSTRUCTIONS

3891775 “F” CAR 12000 SERIES

1 3724851 TAPE
   A. (6 Inches) Tape resistor conn. & lead
   B. (6 Inches) Tape heater control lamp socket & lead

2 3894533 CLIP

3 387999 SCREW

4 3891864 COVER

5 9424858 SCREW
   6 438159 PLUG
   7 444588 OPT
   8 444687 -WITH RPO L70

3914923 CLAMP

7 1191141 CAP

9 3903478 COVER

10 3839835 TAPE-Adh. approx. 18 ins.
     2 pcs. 9 ins. long

TAPING

HEATER EQUIPMENT-INST.

L-6 ENGINE

V-8 ENGINE

- CHEVROLET MOTOR DIVISION, GMC -

L-6 HEATER EQUIPMENT-INST.

15-20 LBS IN.
30-40 LBS IN.
12-18 LBS IN.

SECTION 4

NOTE ATTACH SCREW AT THIS LOCATION FIRST.
The following parts are furnished by Fisher Body as part of body assembly to adapt bodies for rear window defogging:

- BLOWER ASM (3003268)
- SPACER (1189857)
- GRILLE ASM (3899746)
- COVER (3899736)

Plug into receptacle marked "Accessory Fused".

Body wiring & connectors to be installed by Fisher Body.

**Notes:**
- Remove existing cups and screws.
- Set screw (part of knob asm).
- 15-20 lbs. in.
- 10-15 lbs. in.
## ASSEMBLY INSTRUCTIONS

**3891775 “F” CAR 12000 SERIES**

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<td>SIDE SHROUD CONTROL KICK PNL &amp; COVER</td>
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<td>PLENUM VALVE</td>
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<td>CENTER OUTLET &amp; INST. PNL COMP</td>
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<td>RECEIVER &amp; DEHYDRATOR</td>
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<td>COMP, FAN, BELT &amp; PULLEYS</td>
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<td>CARE AIR BLEED VALVE</td>
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<td>D2</td>
<td>FITTING &amp; MUFFLER ASM</td>
</tr>
<tr>
<td>D3</td>
<td>HOSE ROUTING</td>
</tr>
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<td>D4</td>
<td>HEATER HOSES</td>
</tr>
<tr>
<td>D5</td>
<td>HOSES A/C &amp; HEATER</td>
</tr>
<tr>
<td>E1</td>
<td>FRONT WIRING</td>
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<tr>
<td>E2</td>
<td>COMP. WIRING BATTERY &amp; CABLES</td>
</tr>
<tr>
<td>E3</td>
<td>CONTROL ASM</td>
</tr>
<tr>
<td>E4</td>
<td>CONTROL CABLES &amp; VAC HOSE ASM</td>
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<tr>
<td>E5</td>
<td>VAC CONTROL HOSES</td>
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<td>E6</td>
<td>INST. PANEL WIRING</td>
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<tr>
<td>E7</td>
<td>INST. PANEL WIRING</td>
</tr>
<tr>
<td>E8</td>
<td>WIRING DIAGRAM</td>
</tr>
<tr>
<td>E9</td>
<td>TEST PROCEDURE</td>
</tr>
<tr>
<td>E10</td>
<td>GEN. SPECS &amp; PROCEDURES</td>
</tr>
</tbody>
</table>

### AIR CONDITIONING CONTENTS

<table>
<thead>
<tr>
<th>SHEET</th>
<th>TITLE</th>
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<tr>
<td>C60</td>
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<td>C60</td>
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### DIAGRAM
### ASSEMBLY INSTRUCTIONS

3891775 “F” CAR 12000 SERIES

**NOTE** The following components are not illustrated in this R.P.O. See Parts List or Bill of Material for Part Numbers.

<table>
<thead>
<tr>
<th>UPC 3</th>
<th>FRONT SUSPENSION</th>
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<tbody>
<tr>
<td>3C</td>
<td>FRONT SPRINGS (1)</td>
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<table>
<thead>
<tr>
<th>UPC 4</th>
<th>AXLE ASM-(REAR)-(3) or same as RPO L48</th>
</tr>
</thead>
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<table>
<thead>
<tr>
<th>UPC 6</th>
<th>ENGINE</th>
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<tr>
<td>6</td>
<td>ENGINE- (1) or same as RPO M35</td>
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<tr>
<td>6K2</td>
<td>WATER PUMP &amp; DRIVE-(1)</td>
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<tr>
<td>6M1</td>
<td>CARBURETOR-(3) or same as RPO L39</td>
</tr>
<tr>
<td>6Y2</td>
<td>STARTING MOTOR (1)</td>
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<table>
<thead>
<tr>
<th>UPC 7</th>
<th>TRANSMISSIONS</th>
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<tr>
<td>7A</td>
<td>TRANSMISSION-(1) or applicable R.P.O.</td>
</tr>
<tr>
<td>7B-6</td>
<td>OIL COOLER LINES-Same as RPO M35</td>
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</tbody>
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<table>
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<tr>
<th>UPC 10</th>
<th>WHEELS &amp; TIRES</th>
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<tr>
<td>10B</td>
<td>TIRES (1)</td>
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<tr>
<th>UPC 13</th>
<th>RADIATORS</th>
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<tr>
<td>13A</td>
<td>RADIATORS-(1) or same as RPO V01</td>
</tr>
<tr>
<td>13A</td>
<td>HOSE-RADIATOR-OVERFLOW- Same as RPO V01</td>
</tr>
<tr>
<td>13E</td>
<td>FAN SHROUD (1)</td>
</tr>
</tbody>
</table>

(1) Assembles same as production. See Parts List or Bill of Material for part number.
ASSEMBLY INSTRUCTIONS
3891775 "F" CAR 12000 SERIES

1 9419303 SCREW
2 3891703 PLATE
3 .1998927 CONTROL ASM-VACUUM
4 3891700 VALVE ASM
5 3891701 HOUSING-VALVE
6 3891707 CLIP

VACUUM HOSE (SHEET E5)

PLENUM PANEL

- IS TURNED IN "HCVTDLT MOTOR OTJStON, GMC*

DATE

UPC C60

A4

SHEET 1
ASSEMBLY INSTRUCTIONS

3891775 “F” CAR 12000 SERIES

3891708 SEAL
9881098 CEMENT
50A (.016 oz.) Seal to plate
50B (.002 oz.) Seal to housing
50C (.0025 oz.) Seal to housing
3891704 SEAL
138479 L. WASHER
120614 NUT

NOTE Before torquing, bottom vac. control arm in housing, hold valve closed with 2 lbs. min. load.

SECTION W-W

TANGS ON 5
TANGS ON 6

20-30 LBS. IN.
15-20 LBS. IN.

12000

AIR CONDITIONING-PLENUM VALVE

C60
A5

20-30 LBS. IN.
15-20 LBS. IN.
## Assembly Instructions

**3891775 “F” CAR 12000 SERIES**

<table>
<thead>
<tr>
<th>Part</th>
<th>Assembly Instructions</th>
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<tbody>
<tr>
<td>NUT 446069</td>
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<tr>
<td>GASKET 3889483</td>
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<tr>
<td>SEAL 3889484</td>
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<tr>
<td>CEMENT-ADH .005 OZ 446069</td>
<td>Insert flange under flange on retainer</td>
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<td>.04 OZ</td>
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<tr>
<td>.02 OZ</td>
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<td>DUCT ASM-SEL 3889486</td>
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<td>SCREW 3863383</td>
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<tr>
<td>DUCT 3902274</td>
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<tr>
<td>DUCT ASM-DIST 3891724</td>
<td>Insert flange into retainer on air defroster dist.</td>
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<tr>
<td>GASKET 3891723</td>
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<tr>
<td>P. WASHER 3769610</td>
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<td>DIST ASM-DEF 3917338</td>
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<td>OUTLET ASM 3902277</td>
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<td>OUTLET ASM 3902331</td>
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<td>MAT ASM 3925405</td>
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<tr>
<td>DASH PANEL</td>
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**Notes:**

- **30-40 LBS. IN.**

---

**Conditioning-Selector & Distributors**

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<th>UPC  C60</th>
<th>Date</th>
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**Questions:**

- What are the assembly instructions for the 3891775 “F” CAR 12000 SERIES?
- How many pounds of torque is recommended for the screws?
- What are the part numbers and their corresponding functions in the assembly?
ASSEMBLY INSTRUCTIONS

3891775 "F" CAR 12000 SERIES

1. 3891760 OUTLET ASM
2. 3925719 Spacer
3. 3891762 Valve
4. 3891761 Bezel

5. 3891764 Seal
6. 9424858 Screw
7. 9985028 Staple 10 Req'd
8. 9423633 Opt.
9. 3891766 Compartment ASM
10. 3893821 Instr. Pnl. Trim Plate

Install L.H. screw prior to R.H.

30-40 LBS. IN.

CENTER OUTLET DUCT

VIEW

RETAILER (SEE UPC)

SCREW (SEE UPC)

3893821 INSTR. PNL. TRIM PLATE

DBC 12000
ASSEMBLY INSTRUCTIONS
3891775 “F” CAR 12000 SERIES

- 3906907 PIPE ASM
- 3906326 VALVE ASM
- 3906338 PIPE ASM

- 9430626 CREW
- 3906326 VALVE A8M
- 3906336 PIPS ASM

NOTE: From this point rearward pipe installs same as UPC 8.

- 90-140 LBS. IN.
- 50-70 LBS. IN.

VIEW A

C60

A9
ASSEMBLY INSTRUCTIONS

3891775 "F" CAR 12000 SERIES

1. 3899747-8 BRACKET L. & R.H.
2. 3899747 CONDENSER ASM
3. 3899747-8 BRACKET L. & R.H.
4. 3899747 CONDENSER ASM

FOR MOUNTING OF RADIATOR SEE RPO VOI

4. 50-180 LBS. IN.
   25-35 LBS. IN.

NOTE FOR MOUNTING

RADIATOR SUPPORT

RADIATOR SUPPORT

CONDENSER

C 60
B 1

UPC
DATE
SYM
DIVISION RECORD
AUTH.

12000

DATE
SYM
DIVISION RECORD
AUTH.

12000

DATE
SYM
DIVISION RECORD
AUTH.

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ASSEMBLY INSTRUCTIONS
3891775 "F" CAR 12000 SERIES

1 3899771 TUBE ASM
2 8526398 O-RING
3 3155342 RECEIVER & DEHYDRATOR
4 3899772 TUBE ASM

5 9419380 SCREW
6 3895918 BRACKET -LOWER
7 3902248 BRACKET - UPPER

NOTE: TOP OF RECEIVER & DEHYDRATOR IS TO ABUT THE LOCATING ARM AS SHOWN.

R.H. SHIRT ONLY AT ASSEMBLY.

TO EVA T OF RECEIVERS 1ST TO ABUT THE LOCATING ARM AS SHOWN.

TO CONDENSER

TO EVAPORATOR

132 - 156 LBS. IN.
10 - 15 LBS. IN
CAUTION: Do not remove shipping straddle plate & plugs from rear of compressor until immediately before assembly of hoses to compressor, to prevent entry of air into system.

25-35 Lbs. Ft.
ASSEMBLY INSTRUCTIONS

3891775 “F” CAR 12000 SERIES

1. TEE
2. TEE ARM
3. CARB-AIRATOR
4. TEE ARM

3873848
3891523
7025095
3891524

C60 VACUUM HOSE

V-8 ENGINE

* PLUS TORQUE REQUIRED TO ALIGN FITTINGS

100 * LBS. IN.
100 - 125 LBS. IN.

L-6 ENGINE

C60 VACUUM HOSE

FORWARD

15°
MANDATORY ASSEMBLY SEQUENCE FOR DETERMINING PROPER SHIM REQUIREMENTS

1. Assemble front mounting bracket to compressor & torque bolts.
2. Assemble rear mounting brackets to compressor & start bolts.
3. Position front & rear brackets relative to supports on engine.
4. Add shims between rear bracket & compressor as required.
5. Torque (Rear bracket to compressor) bolts.

NOTE: Minimum clearance between radiator hose & fan belt to be 1.80.
ASSEMBLY INSTRUCTIONS

3891775 "F" CAR 12000 SERIES

1. 3885185 TUBE ASM
2. 606404 SPL. WASHER
3. 3895910 STUD ASM
4. 3859062 CLAMP
5. 3885183 EVAPORATOR ASM
6. 3863393 SCREW ASM
7. 3135649 CLAMP
8. 3148473 HOSE
9. 8526398 GASKET
10. 3878598 TUBE ASM
11. 3873950 SCREW
12. 446009 NUT
13. 8526645 GASKET
14. 3140852 GASKET
15. 590602 VALVE ASM
16. 9419727 SCREW
17. 3873914 BRACKET
18. 51 SEALING COMPOUND (.04 OZ)
19. 91 REFRIGERANT (3.75 LBS)
20. 3902250 SEAL
21. 50N ADHESIVE (.06 OZ)

NOTE: 5/8 Inch minimum clearance between equalizer line & all adjacent brackets, hoses & clamps.

LIQUID BLEED

EQUALIZER LINE

35-40 LBS FT
30-40 LBS IN
20-30 LBS IN
15-20 LBS FT
35-50 LBS IN
60-84 LBS IN
2-5 LBS IN

UPC
C60
D1

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ITEMS 20 ADDED
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ITEMS 26 ADDED

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C1
3891775 "F" CAR 12000 SERIES

1. 3895914 FITTING & MUFFLER ASM
2. 3706737 SPL. WASHER
3. 103321 L. WASHER
4. 120677 BOLT
5. 3906066 BRACKET-LOWER
6. 3906065 BRACKET-UPPER
7. 9421033 SCREW
8. 10 OIL-REFRIGERANT (.6063 qts.)

COMPRRESSOR ASM

O" RING (PART OF COMP ASM)

17-24 LBS FT
20-30 LBS IN.
CAUTION Hose clamp screw torques of 35-42 lbs. in. are for initial installation only, & will drop off. Residual torques must not be less than 10 lbs. in. at any time. If torque falls below 10 lbs. in. after initial installation, clamp screw should be retightened to 20-25 lbs. in.

At no time is hose or on clamp to project beyond bead on pipe.
ASSEMBLY INSTRUCTIONS

3891775 “F” CAR 12000 SERIES

HOSE-WATER PUMP V-8 ENG
3752052
3754190

HOSE-INLET MANIFOLD
3902328
181610
187119
103320

L. WASHER

NUT

3752052
3754190

3767476

PLUG-SPL.

3752052
3754190

NOTE: Hose slack must be positioned rearward of prod. clip prior to securing clip to fender.

HOLE IN DASH

CLAMP (UP)

CLAMP (DOWN)

SELECTOR-HEATER CORE PIPES

15-25 LBS. FT.
15-20 LBS. FT.

NOTE: Hook end of clip to compressor bracket flange.

NOTE: This hose must route over water pump hose at all times.

12000 L.D.

MOTOR

COND. HEATER HOSES

E 12000 L.D.

H-19-M

T-27-66

AUTM.

D4

NOTE!

SCREW

3873950

3895993

942277

863320

186634

3885184

GROMMET
CAUTION: Do not install connector to compressor until after system has been leak tested.

30-40 LBS IN.
10-15 LBS IN.
21-30 LBS IN.

NOTE: Remove perforated portion of dash mat.
ASSEMBLY INSTRUCTIONS
3891775 "F" CAR 12000 SERIES

1. 385075 TANK ASM (OPT.)
   385076

2. 3866153 SCREW

3. 3872086 HOSE-VAC (L-6 ENG)
   3902292 (V-8 ENGINE)

4. 3724851 TAPE
   A. (4 in.) Tape to gen & fwd lamp wiring harness.
   B. (4 in.) Coll & tape prod. htr to blo mtr wire to engine wiring harness.

5. 2987251 CABLE ASM-BAT NEG (L-6 ENG.
   EXC RPO L22)
   6286125
   2987212 (V-8 ENGINE)

6. 444684 BOLT (L-6 ENG)
   186634 (V-8 ENGINE)

7. 6291260 EXT. ASM.

8. 9422033 STRAP

9. 120524 CLIP

**NOTE**


**NOTE**
Balance of asm is same as reg. prod.

**PRODUCT WASHER**
(Bat. Neg Cable attaching)

**REFRIGERANT HOSE**

**ACCELERATOR PULL SPRING BRKT & ATTCH PARTS-SEC.6**

**CONNECTOR (VAC SOURCE-SIR CS)**

**PROD. BAT. (POS) CABLE**

**PRODUCT BATTERY**

**CONNECTOR (VAC SOURCE SAT CS)**

**VIEW A**
L-6 ENGINE

**20-30 LBS FT.**
**10-15 LBS IN.**

**VIEW B**
V-8 ENGINE
ASSEMBLY INSTRUCTIONS

3891775 “F” CAR 12000 SERIES

1. 3891775 SWITCH ASM
2. 3891797 CONTROL ASM
3. 9420494 SCREW (HTR CABLE)
4. PROD. SCREW (HTR CABLE)
5. PROD. SCREW (HTR CABLE)
6. PROD. SCREW (HTR CABLE)
7. PROD. SCREW (HTR CABLE)
8. PROD. SCREW (HTR CABLE)
9. PROD. SCREW (HTR CABLE)
10. 3891759 CLAMP

VAC SWITCH (Part of air-temp arm)
DEFR CABLE
OUTLETS CABLE
VAC CONTROL HOSE ASM
TO VAC TANK
A-B
CONN (Part of A/C harness)

TAB (Part of air-temp control arm)
PIN (Part of temp control arm)

30-40 LBS IN.
20-30 LBS IN.

- CHEVROLET MOTOR DIVISION, GMC
- AIR CONDITIONING-CONTROL ASM
- C60
- E3
- SHEET 1

UPC
DATE SYN
REVISION RECORD
AUTH. DR CK

3891776 SWITCH REMOVED
94670 RA
8 SCREW DRAWING REMOVED
9 CONNECTOR DRAWING REMOVED
C1
NOTE! Remove slit portion of dash mat.

NOTE: Thread thru 8 & pull thru dash into eng. compt.

NOTE: Remove slit portion of dash mat.
Tape (4 in.) TAPE A/C harness to inst panel harness.
ASSEMBLY INSTRUCTIONS
3891775 “F” CAR 12000 SERIES

PROD. INST PANEL WIRING HARNESS
GROMMET (Part of A/C harness asm) in dash panel (See Shit. E1)
HARNESS ASM A/C (Shit E1)

CONNECTOR TO CONTROL SW (Shit E3)

NOTE
Rework prod. Inst Pnl Harness:
1. Cut heater resistor leads 1.50 inches before breakout & discard the conn.
2. Remove terminal (brown wire) from prod. heater switch conn & insert into [I]
3. Cut the (2) heater control conn orange leads flush at breakout.
4. Pull heater control connector (& four wires) free from harness & discard.
### ASSEMBLY INSTRUCTIONS

**3891775 “F” CAR 12000 SERIES**

**Outside Air Entry**

- **Blower Motor**: 12 PPL 12B
- **Blower Intake Air**
  - **Evaporator ASM.**
  - **Plenum Valve**: Normally open - spring held
  - **Actuator**: Vacuum operated
  - **Inside Valve**: Normally closed - spring held
  - **Inside Car Air (Recirc.)**

**EVAPORATOR ASM.**

- **Resistor Assy.**
- **Diode (Arc suppressor)**
- **Compressor Clutch Coil**
- **Fuse (In-line)**
- **Comp Blower Switch Contacts**
  - #2 & #3
  - #2

**CONTROL ASM**

- **Compressor Switch Contacts**
  - Open
  - Closed
  - Open
- **Blower Intake Air**

**Legend:**
- Production wiring
- Wire is part of equip.
- Air conditioning wrg.

### TEMP CONTROL LEVER

- **Switch Lever Position**
  - Off
  - Low
  - Med
  - High

- **Contacts made**
  - B to None
  - B to L
  - B to L & M
  - B to L & H

- **Fan Speed**
  - Low
  - Med
  - High

- **Resistance in series with Motor**
  - R1
  - (R2/(R1+R2))

**Blower Switch Contacts**

- Open
- Closed

**Compressor Switch Contacts**

- Open
- Closed

**Table of Switch Lever Position and Blower Switch Contacts**

<table>
<thead>
<tr>
<th>Switch Lever Position</th>
<th>Blower Switch Contacts</th>
</tr>
</thead>
<tbody>
<tr>
<td>Off</td>
<td>Open</td>
</tr>
<tr>
<td>Low</td>
<td>#2 &amp; #3</td>
</tr>
<tr>
<td>Med</td>
<td>#2</td>
</tr>
<tr>
<td>High</td>
<td>#3</td>
</tr>
</tbody>
</table>

**Horn Relay “Bat” Terminal**

**To Battery Positive (+) Terminal**

**To Vacuum Tank**

**Extension Wire ASM**

**To Dash Panel**

**To Inst Panel Harness**

**Ign. Sw. Access Term.**

**Compressor Switch Contacts**

- None
- #2

**Temp Switch Contacts**

- Closed
- Open

**Blower Intake Air**

- Open
- Outside Car Air Intake Used
- Outside Car Air Intake Recirculated
- Outside Car Air Intake Used
ASSEMBLY INSTRUCTIONS

3891775 "F" CAR 12000 SERIES

EVACUATING AND CHARGING EQUIPMENT
(EXAMPLE ONLY—See Sheet 10)

TEST PROCEDURE OUTLINE:

IN ORDER TO ASSURE PROPER OPERATION OF THE UNIT, THE FOLLOWING STEPS SHOULD BE TAKEN:

A. AFTER THE SYSTEM HAS BEEN INSTALLED, A LEAK TEST SHOULD BE MADE.
   ASSEMBLE AIR COND. HARNESS CONNECTOR TO COMPRESSOR CLUTCH TERMINALS AFTER LEAK TESTING.

B. A FUNCTIONAL TEST OF COMPLETED ASSEMBLY MUST NOW BE MADE. SEE SHEET E10.

C. THE HEATING SYSTEM CAN BE CHECKED BY MOVING THE "TEMP" CONTROL KNOB TO EXTREME RIGHT (HOT) POSITION. WITH THE "OUTLETS" KNOB IN EXTREME RIGHT (LOWER OUTLETS) POSITION, WARM AIR WILL COME OUT OF THE HEATER OUTLETS. WITH THE "OUTLETS" KNOB IN EXTREME LEFT (UPPER OUTLETS) POSITION, WARM AIR WILL COME OUT OF THE AIR CONDITIONING OUTLETS.

<table>
<thead>
<tr>
<th>AIR CONDITIONING-TEST PROCEDURE</th>
<th>UFC</th>
<th>DATE</th>
<th>SHEET</th>
<th>SPD</th>
<th>AUTO OR CF</th>
</tr>
</thead>
<tbody>
<tr>
<td>12000</td>
<td>C60</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>DWG 4-11</td>
<td>E9</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>DATE 4-12</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>
Evacuating and Charging the System

1. Remove cap from Muffler and S.T.V. Valves.
2. Attach Process Coupler Yoke Assembly to process valves uncapped in Step 1.
3. Attach quick-connect fitting from vacuum system to Process Coupler and open valves slowly to evacuate Air Conditioning System.
4. Evacuate Air Conditioning System for a minimum of three minutes and until such time that the vacuum system gage indicates an absolute pressure of 1500 microns maximum of mercury.
5. Disconnect quick-connect fitting from vacuum system to Process Coupler and attach quick-connect fitting from Freon Charging Board to Process Coupler.
6. Charge Air Conditioning System with specified amount of Freon.
8. Leak Test System.

System Leak Test Limits

1. Except as noted in (2) below, all lines, connectors, and system components shall be free of leakage with a detector sensitivity calibration of 1 lb. in 40 years.
2. The compressor seal, sight glass, and S.T.V. valve shall show no leakage with a detector sensitivity calibration of 1 lb. in 5 years.

Functional Test

A standard test of the function of the system is to be conducted in the following manner:

1. Doors or windows open.
2. "Outlets" knob at full left position. "Temp" knob at "COLD" (Full outside air) position "DEFR" knob at "OFF" posn.
3. Temperature indicators at condenser inlet and center outlet.
4. Start engine and run at 2000 R.P.M.
5. After one minute the minimum drop in temperature of the air from the center outlet should be as follows:

<table>
<thead>
<tr>
<th>CONDENSER INLET TEMP</th>
<th>CENTER OUTLET TEMP. DROP (MIN.)</th>
</tr>
</thead>
<tbody>
<tr>
<td>70°F</td>
<td>20°F</td>
</tr>
<tr>
<td>80°F</td>
<td>25°F</td>
</tr>
<tr>
<td>90°-110°F</td>
<td>30°F</td>
</tr>
</tbody>
</table>

AIR CONDITIONING-GENERAL SPECS & PROCEDURES

C60

E10
### ASSEMBLY INSTRUCTIONS

#### 3891775 “F” CAR 12000 SERIES

<table>
<thead>
<tr>
<th>SHEET</th>
<th>TITLE</th>
<th>SHEET</th>
<th>TITLE</th>
</tr>
</thead>
<tbody>
<tr>
<td>A1</td>
<td>CONTENTS</td>
<td>A5</td>
<td>AUTOMATIC TRANSMISSION CONTROL</td>
</tr>
<tr>
<td>A2</td>
<td>FRAME &amp; SEAT COMPARTMENT</td>
<td>A6</td>
<td>HARNESS ASM &amp; COURTESY LAMP</td>
</tr>
<tr>
<td>A3</td>
<td>COMPARTMENT DOOR &amp; ASH TRAY ASM</td>
<td>A7</td>
<td>HARNESS ROUTING -WITH RPO M35</td>
</tr>
<tr>
<td>A4</td>
<td>3 &amp; 4 SPEED TRANSMISSION CONTROL</td>
<td>A8</td>
<td>HARNESS ROUTING -WITH RPO C60</td>
</tr>
</tbody>
</table>

---

**NOTE:** The following components are not illustrated in this RPO parts list or bill of materials for part numbers.

**UPC 7 TRANSMISSION**
- **7A** EXTERNAL CONTROLS (Components below tunnel)
  - See applicable RPO Transmission
- **7B** 3 TRANSMISSIONS - See applicable RPO

**UPC 9 STEERING**
- **9A** Steering gear & pitman arm

---

#### Graphics

- [Diagram of car interior](image)

---

**CHEVROLET MOTOR DIVISION, GM Co.**

<table>
<thead>
<tr>
<th>TITLE</th>
<th>UPC</th>
<th>DATE</th>
<th>SYM</th>
<th>REVISION RECORD</th>
<th>AUTHL</th>
<th>DR. CK</th>
</tr>
</thead>
<tbody>
<tr>
<td>FRONT COMPARTMENT FLOOR</td>
<td>D55</td>
<td>T-46</td>
<td>3</td>
<td>REDRAWN &amp; REDESIGNED</td>
<td>RH/DP</td>
<td></td>
</tr>
<tr>
<td>CONSOLE-CONTENTS</td>
<td>A1</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>
ASSEMBLY INSTRUCTIONS

3891775 “F” CAR 12000 SERIES

1. 9418962 SCREW
2. 3893864 TRANS CONTROL PLATE-R.H.
3. 3893872 RETAINER
4. 9412180 SCREW
5. 3893876 RETAINER
6. 3893875 DIAL PLATE
7. 3893874 DIAL (EXC RPO M40) (RPO M40)
8. 3893863 TRANS. CONT. PLATE-L.H.
9. 3893871 SEAL

\( \mathbf{15-22 \ \text{LBS. IN.}} \)
ASSEMBLY INSTRUCTIONS

3891775 "F" CAR 12000 SERIES

1. 274004 BULB
2. 6293329 SEAT SEPARATOR WIRING HARNESS ASM.

**Chevrolet Motor Division, GMC**

<table>
<thead>
<tr>
<th>FRONT COMPARTMENT FLOOR CONSOLE-HARNESS ROUTING</th>
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</thead>
<tbody>
<tr>
<td>12000 WITH RPO M35 &amp; M40</td>
</tr>
</tbody>
</table>

**UPC**

<table>
<thead>
<tr>
<th>D55</th>
<th>Date</th>
<th>Sym</th>
<th>Rev. No.</th>
<th>Author</th>
<th>Doc.</th>
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<tbody>
<tr>
<td>Dec. 1</td>
<td>M40 ADDED</td>
<td>3/11/67</td>
<td>2</td>
<td>WAS 6290654 HARNESS 2</td>
<td>83872</td>
</tr>
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</table>

**A7**
**Title:** FRONT COMPARTMENT FLOOR CONSOLE-HARNESS ROUTING

**Model:** 12000 WITH RPO C60

**Revision:** D55

**Document:** CHEVROLET MOTOR DIVISION, GMC 3891775 “F” CAR 12000 SERIES

1. **3909586 CLIP**

---

<table>
<thead>
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<th>UPG</th>
<th>DATE</th>
<th>SYM</th>
<th>REVISION RECORD</th>
<th>AUTH. DR. CK</th>
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</thead>
<tbody>
<tr>
<td>D55</td>
<td>3/10/67</td>
<td>Redrawn &amp; redesigned</td>
<td>389724/01 C1</td>
<td></td>
</tr>
</tbody>
</table>

**Legend:**
- EXISTING P. WASHER & SCREW
- TUNNEL

---

[Diagram of the front compartment floor and console-harness routing]
NOTE For rear body extension & paint stripe. See RPO Z28
NOTE: The following components are not illustrated in this R.P.O. See Parts List or Bill of Materials for part numbers.

Assemble same as production—See Parts List or Bill of Materials for part numbers.

UPC 4A REAR AXLE ASM
LUBRICATION

INNER DECK LID RIGHT SIDE

REGULAR PRODUCTION JACK INSTRUCTION
1 3839896  SPEEDO CBL. ASM.
     6454648  OPT.
2  59  CEMENT 2 oz.
      Applied to clip and hole
      from inside of car
3  6476735  ADAPTER
     6476736  OPT.
4  867209  KEY

---

**CHEVROLET MOTOR DIVISION, G.M.C.**

<table>
<thead>
<tr>
<th>UPC</th>
<th>DATE</th>
<th>SM</th>
<th>REVISION RECORD</th>
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<th>DR</th>
<th>CK</th>
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<td></td>
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<td></td>
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<tr>
<td>A2</td>
<td></td>
<td></td>
<td></td>
<td></td>
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<td></td>
</tr>
</tbody>
</table>

**4 SPEED TRANS SPEEDOMETER CABLE ROUTING**

**Dwg 4-4-47**
**Ref: ECR 856/A L-81634 L-**
**Date Rel. 4-14 C1 L- L- L-**
<table>
<thead>
<tr>
<th>PART</th>
<th>USAGE</th>
<th>UPC</th>
</tr>
</thead>
<tbody>
<tr>
<td>3851970</td>
<td>CEMENT-PLASTIC SEAM BUMPER GUARD BRACKET TO BODY</td>
<td>14 &amp; V32</td>
</tr>
<tr>
<td></td>
<td>USED TO CEMENT STR COLUMN TO DASH COVER WRAP AROUND SCREW &amp; PUT IN WELD NUT</td>
<td>9</td>
</tr>
<tr>
<td>9980607</td>
<td>CEMENT-RUBBER SOLVENT USED TO SEAL SPEEDO FLEX SHAFT CLIP HOLE</td>
<td>M20-21</td>
</tr>
<tr>
<td></td>
<td>USED TO CEMENT STEREO TAPE PLAYER PAD</td>
<td>U57</td>
</tr>
<tr>
<td>3764800</td>
<td>ADHESIVE PRICE LABEL STICKER TO RR DOOR WDO</td>
<td>0</td>
</tr>
<tr>
<td>3878153</td>
<td>CEMENT-BLK NON HARD BETWEEN BACK-UP LIGHT SWITCH BRACKET &amp; TRANS COVER</td>
<td>M13-20-21</td>
</tr>
<tr>
<td>9981300</td>
<td>DEADENER UNDERSIDE OF REAR HALF OF SKIRT</td>
<td>11-13</td>
</tr>
<tr>
<td>3765759</td>
<td>CEMENT-PLASTIC SEAM SEAL SHOCK ABSORBER OPENING IN U/BODY</td>
<td>4</td>
</tr>
<tr>
<td>9985000</td>
<td>SEALING COMPOUND TO SEAL BODY DAMPENER &amp; BRACKET PLUG THREADS</td>
<td>1</td>
</tr>
<tr>
<td>3857030</td>
<td>CEMENT-PLASTIC SEAM BODY BRACKET &amp; DAMPENER REAR MTG. HOLES</td>
<td>1</td>
</tr>
<tr>
<td>1163105</td>
<td>SEALING COMPOUND RADIATOR - THRU FILLER NECK</td>
<td>11-13</td>
</tr>
<tr>
<td>9985040</td>
<td>SEALING COMPOUND OPT</td>
<td></td>
</tr>
</tbody>
</table>
ASSEMBLY INSTRUCTIONS
3891775 "F" CAR 12000 SERIES

1. 5460748 CYLINDER ASM
2. 9418931 NUT
3. 103321 L. WASHER
4. 9420165 NUT
5. 3917957 STRIKER
6. 106324 BOLT
7. 3788262 SPRING WASHER
8. 3909970 PIPE ASM-FRT R.H.
9. 3909966 PIPE ASM-RR
10. 3909968 RPO C60 (ONLY)
11. 3909995 PIPE ASM-FRT L.H.

--- Diagram ---

NOTE: Fill master cylinder reservoirs to .25 in \( \pm \) .125 in from top measured at rear edge.

--- Instructions ---

1. Brake pedal must support a 50 lb. load at "A" after traveling a maximum of 1.75" after brakes are applied three times in quick succession.

CAUTION! If 1.75 is exceeded brakes should be rechecked for proper bleed. Check must be made with no vacuum reserve assist.
ASSEMBLY INSTRUCTIONS

CAR 12000 SERIES

3891775

3909909

3921929

3921927

PIPE & SUPPORT ASM.

RPOL78

RPOL35

3829058

3905370

SUPPORT ASM.

Screw is used to install item [T] & existing reinforcement must remain against rocker cover flange.

Attach to existing vacuum cylinder asm.

ACCELERATOR CONTROL RODS

ANTI-SMOG HOSE

NOTE

C60 VACUUM HOSE

M35 VACUUM HOSE

RPO C60 or M35

VIEW A

RPO C60 WITH M35

VIEW B

RPO Z28

RPO L35 & L78

100 - 125 LBS. IN.

NOTE

Attach to vacuum cylinder asm.

12000 V-8 ENGINE

J50

A3

12/73

1/4/74

REV 03/07

B572

AUTH: G1

DATE: 3-1

DRAWN: L

DESIGN: L

SHEET: A
ASSEMBLY INSTRUCTIONS

6291392 HARNESS EXT ASM
(Los Angeles plant only)

Remove tape from eng wiring harness before connecting to switch.

Existing clip
HARNESS ASM ENG SEE UPC 12

SWITCH & BRKT

NOTE:

FUSE PANEL ASM
Use backup wrench on hose fitting to prevent bracket distortion when pipe nut is torqued.
ASSEMBLY INSTRUCTIONS

5461705 CYLINDER ASM
5463422 (WITH J50)
3848408 SCREW ASM
3912539 BRACKET
3905525 VALVE ASM
3908317 PIPE ASM-Main cyl to valve

G NUT & L. WASHER
SEE UPC 5

NOTE: Balance of installation same as prod.

NOTE: Brake pedal must support a 50 lb. load at "A" after traveling a maximum of 3.75" after brakes are applied three times in quick succession and free play is .08 to .25 inches.

CAUTION: If 3.75 is exceeded, brakes should be re-checked for proper bleed.

---

3848408 SCREW ASM
3912539 BRACKET
3905525 VALVE ASM
3908317 PIPE ASM-Main cyl to valve

---

NOTE: Brake pedal must support a 50 lb. load at "A" after traveling a maximum of 3.75" after brakes are applied three times in quick succession and free play is .08 to .25 inches.

CAUTION: If 3.75 is exceeded, brakes should be re-checked for proper bleed.

---

NOTE: Brake pedal must support a 50 lb. load at "A" after traveling a maximum of 3.75" after brakes are applied three times in quick succession and free play is .08 to .25 inches.

CAUTION: If 3.75 is exceeded, brakes should be re-checked for proper bleed.

---

NOTE: Brake pedal must support a 50 lb. load at "A" after traveling a maximum of 3.75" after brakes are applied three times in quick succession and free play is .08 to .25 inches.

CAUTION: If 3.75 is exceeded, brakes should be re-checked for proper bleed.
ASSEMBLY INSTRUCTIONS
3891775 "F" CAR 12000 SERIES

SHEET

A1 CONTENTS
A2 NON-ILLUSTRATED PARTS
A3 EXHAUST GAS COMBUSTION
A4 PUMP, BRACES & BRACKETS L-6 ENG
A5 PUMP & BRACKETS V-8 ENG EXC RPO L35 & L78
A6 CARB & VACUUM LINES L-6 ENG
A7 CONNECTOR & VACUUM FITTINGS L-6 ENG
A8 VALVE, AIR CLEANER & HOSES L-6 ENG
A9 VALVE, AIR CLEANER & HOSES (327) 2 BBL

A10 VALVE, AIR CLEANER & HOSES (RPO L30 & L48)
A11 BELTS & PULLEYS L-6 ENG
A12 BELTS & PULLEYS V-8 ENG
A13 VALVE, AIR CLEANER & HOSES (RPO Z28)
A14 VALVE, AIR CLEANER & HOSES (RPO L35)
A15 VALVE, AIR CLEANER & HOSES (RPO L78)
A16 PUMP & BRACE RPO L35 & L78
A17 VALVE, AIR CLEANER & HOSES (RPO L30 & L48)

CHEVROLET MOTOR DIVISION, GM

AIR INJECTION REACTOR EQUIPMENT CONTENTS

K19
A1
1 SHEET
NOTE: The following components are not illustrated in this R.P.O. See Parts List or Bill of Material for part numbers.

1. UPC 0  GENERAL INFORMATION
   0  BOOKLET - See miscellaneous shipping list

2. UPC 6  ENGINE
   6A  ENGINE ASM (AS SHIPPED)
   6M1  CARB-CHOKE - Assembles same as prod RPO L30, L48, L35, L78 & Z28
   6K1  FAN & DRIVE
   6Y2  STARTING MOTOR
   6Y3  DISTRIBUTOR

3. UPC 7  TRANSMISSION
   7B3  TRANS ASM - Assembles same as RPO M35

(1) Assembles same as production. See Parts List or Bill of Materials for part number.
ASSEMBLY INSTRUCTIONS

3891775 "F" CAR 12000 SERIES

1. 5696104 PUMP ASM-PROD & RPO Z28
   5696468 RPO L30 & L48

2. 3896989 BRACE EXC RPO Z28
   3828872 RPO Z28

3. 9419054 BOLT

4. 3765135 P. WASHER

5. 3877606 BOLT-PIVOT Exc RPO C60
   3879686 RPO C60

6. Production attaching parts

7. See RPO C60 for parts

8. STUD-Part of eng. asm (Exc RPO C60)
   187070  BOLT-RPO C60

9. 3896978 BRACE-RPO C60

![Diagram]

NOTE: Push until plug stops on 3 "EARS". Installation pressure should not exceed 40 lbs.

NOTE: Bolt must be installed in direction shown.

NOTE: Bracket stamped 3.7 & 350-Cast RPO Z28
Part of engine.

NOTE: Remove spacer on vehicles with RPO C60.

NOTE: Route air pump outlet hose under A/C rear brace on vehicles with RPO L30.
ASSEMBLY INSTRUCTIONS
3891775 "F" CAR 12000 SERIES

1. 3901797 CONNECTOR
2. 444613 PLUG
3. 3749168 NIPPLE
4. 3751206 CONNECTOR

RPO K19 BASE

AIR BLEED VALVE RPO C60

FORWARD

RPO C60

AIR BLEED VALVE RPO C60

FORWARD

WITI RPO J50

* PLUS TORQUE REQUIRED TO ALIGN FITTINGS

100 LBS. IN.
100-125 LBS. IN.

WITI RPO C60 & J50

CHEVROLET MOTOR DIVISION, GMC

12000 L-6 ENGINE

REF: Prod. A11 6C567 L-
DATE REL 3-1
SHEET 5"
Assemble air cleaner RPO L30

Part number & installation
same as (327) 2 BBL.

NOTE: Assemble valve same as (327) 2 BBL

NOTE: Turn product trans. oil filler cap & level gage 180°.

12 - 18 LBS IN.
Air cleaner:
- Assemble, same as RPO L70 except as shown.

NOTE! Press tube into manifold with small tube parallel to centerline of crankshaft.

Press.

12 - 18 LBS. IN.
20 - 30 LBS. IN.

NOTE: Assemble hose with part number as shown.
Belt strand tension 75 ± 5 lbs. - "This specification is such that the residual or stabilized tension at the time the vehicle is shipped from the plant will be approximately 60 lbs."
ASSEMBLY INSTRUCTIONS
3891775 "F" CAR 12000 SERIES

1 1st TRACK
2 2nd TRACK
3 3rd TRACK
4 3845648 BELT
5 3744043 PULLEY-CR/SF EXC
   RPO L35 & L78
6 3863108 RPO L35 & L78
7 3900434 PULLEY ASM-W/P EXC
   RPO L35 & L78
8 3906565 (REAR) RPO L35 & L78
9 3906657 PULLEY ASM-W/PUMP
10 3887101 PULLEY ASM
11 3845642 BELT
12 181591 BOLT
13 103320 L. WASHER
14 3881885 PULLEY PROD & L30
15 3880800 RPO Z28, L35 & L78

BELT-STRAND TENSION 75 ± 5 lbs

This specification is such that the residual or stabilized tension at the time the vehicle is shipped from the plant will be approximately 60 lbs.

BELT-FAN & GEN
3849739

PULLEY RPO L35
3844100

PULLEY W/P FRT
3921932

BELT
3921934

BELT ASM-W/PUMP

BELT ASM-W/P

Belt strand tension 75 ± 5 lbs—This specification is such that the residual or stabilized tension at the time the vehicle is shipped from the plant will be approximately 60 lbs.

BELT ASM-W/PUMP
ASSEMBLY INSTRUCTIONS

3891775 "F" CAR 12000 SERIES

1. 7800308  PUMP ASM RPO L35
   5696104  RPO L78

2. 3921935  BRACE

3. 9419054  BOLT

4. 3765135  P WASHER

5. 9422277  SPL NUT

6. 103321  L. WASHER

7. 120377  NUT

8. 3877646  STUD

9. 3877606  BOLT

10. 5697396  PLUG-PRES. (BLACK)

NOTE: Push until plug stops on 3 "EARS". Installation pressure should not exceed 40 lbs.

NOTE: Bolt must be installed in direction shown.

20 - 30 LBS FT

---

AIR INJECTION REACTOR EQUIPMENT
PUMP & BRACE RPO L35 & L78

12000 1-0 ENGINE
3891775 "F" CAR 12000 SERIES

Title: Closed Engine Positive Ventilation - Contents

Sheet 1

1. 6423517  Air Cleaner
2. 6419458  Valve Assembly Prod RPO L22
3. 3873853  Gasket 388106  Opt
4. 3856955  Connector Spl
5. 3856954  Grommet
6. 3845774  Cover Assembly - Valve Rocker
7. 3856959  Cap Assembly
8. 3856957  Hose Spl
9. 3849856  Arrestor Assembly - Flame

NOTE: Pre-cemented surface to be assembled to rocker cover flange.

NOTE: Gasket flanges to be free of oil at time of installation on all models.

25-50 lbs in.

L-6 Engine

Date: May 44

Revision Record:
- 4-44: Reprint
- 6-44: Sheet (3) added
- 12-44: Title changed to "Closed Engine Positive Ventilation - Contents"
Push hose till stop insures perfect seal on tubes or connector.

Prod. parts:

1. 6424802 AIR CLNR PROD
2. 6422191 RPO L30
3. 6424456 RPO L48
4. 3881834 CAP ASM
5. 3882864 RPO L48
6. 3889311 TUBE ASM
7. 382294 VALVE ASM
8. 3829058 CLAMP
9. 6424970 FILTER ASM
10. 3856659 HOSE
11. 3882871 TUBE ASM
12. 3881848 TUBE ASM
13. 9420777 BOLT
14. 5385701 HOSE RPO L30 & L48
15. 9419234 P. WASHER
16. 9418931 NUT

RPO L30 & L48

1. 9423581 CLAMP
2. 9419234 HOSE PROD RPO L30 & L48
3. 9418931 ARRESTOR
4. 3856954 GROMMET

Closed engine positive ventilation

124-260 V-8 ENGINE EXC. RPO L35 & L78

WP 5/8-16

CNC 3/16

Date 3/16

Revision: 14

Model: 124-260 V-8

Engine: EXC. RPO L35 & L78

Date: 3/16

Revision: 14

Model: 124-260 V-8

Engine: EXC. RPO L35 & L78

Date: 3/16

Revision: 14

Model: 124-260 V-8
Position air cleaner into slot before tightening. 

1. AIR CLEANER
2. GROMMET
3. CONNECTOR
4. HOSE
5. FLAME ARRESTOR

EXISTING CARB
EXISTING HOSE

PROD WING NUT

CLOSED ENGINE POSITIVE VENTILATION

CHEVROLET MOTOR DIVISION, GMC

K24

A3
With air cond. cut air cond. supply hose approx. 8 inches from reservoir can and splice Cruise Control supply hose at this point. Cut Cruise Control vacuum supply hose to a length of 27 inches.

---

With carburetor at idle position, (choke completely off). Attach ball chain to servo & clip allow (1) ball slack in chain (between pulley & clip). Trim excess chain to within 3 balls of clip.
NOTE: Activating wiring harness parallels turn signal wiring.

NOTE: Do not subject wires to sharp bends during installation.

POWER BRAKES (SEE SHT A3)

REG. WIRE HARNESS
VACUUM HOSE

MANUAL BRAKE (SEE SHT A3)

POWER BRAKES (SEE SHT A3)

PART OF REGULATOR WIRING HARNESS
### ASSEMBLY INSTRUCTIONS

**3891775 “F” CAR 12000 SERIES**

<table>
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#### Power Brakes

- Harness
- Vacuum hose: RPO J50-J52 hose
- Auto trans hose

#### Manual Brakes

- View A

#### NOTE

Cruise Control system must be checked for engagement and disengagement with vehicle run at a speed of 35 MPH.

---

**Table**

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**UPC:** K30  A6  SHEET 1

**DATE:** 1956-09  **REV.:** A  **AUTH:** L  **DR.:** L  **CX:** L

**REVISION RECORD:**
- Item 10 added
- Item 11 is note removed
- Item 12 is note added
**NOTE** The following components are not illustrated in this R.P.O.
See Parts List or Bill of Material for part numbers.

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Assemble same as production. See Parts List or Bill of Materials for part numbers.
NOTE: The following components are not illustrated in this R.P.O. See Parts List or Bill of Material for part numbers.

**UPC 3**
- FRONT SUSPENSION
- FRONT SPRINGS—SEE UPC 3

**UPC 4**
- REAR SUSPENSION
- REAR CHASSIS SPRINGS—SEE UPC 4
- REAR SPRING INSTALLATION PARTS
- RADIUS ROD—ASSEMBLES SAME AS RPO L48

**UPC 6**
- ENGINE
- ENGINE ASM (AS SHIPPED)—1
- ACCELERATOR—1
- STARTING MOTOR—1
- DISTRIBUTOR—1
- COIL & SPARK PLUG WIRES—1

**UPC 7**
- TRANSMISSION
- TRANSMISSION, EXTENSION & CLUTCH BEARING—1
- BRG ASM-CLU REL—1

- Assembles same as production. See Parts List or Bill of Material for part number.
ASSEMBLY INSTRUCTIONS
3891775 “F” CAR 12000 SERIES

- 3916339 HOSE
- 3829058 CLAMP
- 3916337 CLIP-VALVE
- 6419553 VALVE ASM
- 3916338 HOSE
- 9419234 P. WASHER

ATTACHING PARTS SAME AS PROD

20 - 30 LBS IN.
Position air cleaner into slot before tightening.
The following components are not illustrated in the R.P.O. See Parts List or Bill of Material.

**UPC 3 FRONT SUSPENSION**
- 3A LOWER CONTROL ARMS
- 3C FRONT SPRINGS-SEE UPC 3
- 3F FRONT SHOCK ABSORBERS

**UPC 4 REAR SUSPENSION**
- 4 REAR AXLE
- 4A4 PROPELLER SHAFT
- 4B REAR SPRINGS-SEE UPC 4
- 4D REAR SPRING INSTALLATION PARTS
  (REAR AXLE RADIUS RODS)-Assembles same as RPO L48 or L73

**UPC 5 BRAKES**
- 5D PARKING BRAKE MECHANISM
- 5F BRAKE LINES

**UPC 6 ENGINE**
- 6C2 CRANKSHAFT BALANCER-Assembles same as RPO L35
- 6G2 OIL FILLER-Assembles same as RPO L35
- 6G4 OIL LEVEL INDICATOR-Assembles same as RPO L35
- 6H ENGINE VENTILATING SYSTEM-Assembles same as RPO L78
- 6K1 FAN & DRIVE-Assembles same as RPO L35
- 6K2 WATER PUMP & DRIVE
- 6L INTAKE & EXHAUST MANIFOLDS-Assembles same as RPO L35
- 6Y1 GENERATOR & REGULATOR-Assembles same as RPO L35
- 6Y2 STARTING MOTOR & CONTROLS-Assembles same as RPO L35
- 6Y3 DISTRIBUTOR
- 6Y4 SPARK PLUGS, IGNITION COIL & WIRES, IGNITION SWITCH & GROUND-Assembles same as RPO L35

**UPC 8 FUEL & EXHAUST**
- 8A FUEL TANK & TANK GAUGE UNIT & CAP-Assembles same as RPO L48 & PROD.
- 8C MUFFLER TAIL PIPE-Assembles same as RPO N10

**UPC 10 WHEELS & TIRES**
- 10B TIRES

**UPC SHEET METAL**
- 11D HOOD
- 11G SHEET METAL ORNAMENTATION-Assembles same as RPO L48

**UPC 12 ELECTRICAL**
- 12A BATTERY & LEADS-Assembles same as RPO T60
- 12G HORN BUTTON

**UPC 13 RADIATOR & GRILLE**
- 13A RADIATOR
- 13E RADIATOR SHROUD

**UPC 14 BUMPERS & MISC.**
- 14B GREASE & OIL
- 14F TIRE PRESSURE STICKER

( Assembles same as Production. See Parts List of Bill of Materials for part numbers.)
ASSEMBLY INSTRUCTIONS
3891775 "F" CAR 12000 SERIES

NOTE: The following components are not illustrated in the R.P.O. See Parts List or bill of material for part numbers.

UPC 3 FRONT SUSPENSION
3A LOWER CONTROL ARMS
3C FRONT SPRINGS—SEE UPC 3
3F FRONT SHOCK ABSORBERS

UPC 4 REAR SUSPENSION
4A REAR AXLE
4A4 PROPELLER SHAFT
4B REAR SPRINGS—SEE UPC 4
4D REAR SPRING INSTALLATION PARTS
(Rear axle radius rods)—Assembles same as RPO L78

UPC 5 BRAKES
5D PARKING BRAKE MECHANISM
5F BRAKE LINES

UPC 6 ENGINE
6K WATER PUMP & DRIVE
6Q POWER PLANT TO FRAME MOUNTING

UPC 8 FUEL & EXHAUST
8A FUEL TANK & TANK GAUGE UNIT & CAP—Assembles same as RPO L48 & PROD.
8C MUFFLER TAIL PIPE—Assembles same as RPO N10

UPC 10 WHEELS & TIRES
10B TIRES

UPC 11 SHEET METAL
11D HOOD
11G SHEET METAL ORNAMENTATION—Assembles same as RPO L48

UPC 12 ELECTRICAL
12A BATTERY & LEADS—Assemble same as RPO T60
12G HORN BUTTON

UPC 13 RADIATOR & GRILLE
13A RADIA TOR
13E RADIA TOR SHROUD

UPC 14 BUMPERS & MISC.
14B GREASE & OIL
14F TIRE PRESSURE STICKER

Assembles same as production. See parts list or Bill of Materials for part number.
COLOR CODE IDENTIFICATION

* Plus additional torque to align the fittings as shown, so as to maximize clearance to TV or clutch linkage.
MANDATORY ASSEMBLY SEQUENCE

1. Install cable to solenoid with specified torque.
2. Install starting motor to engine with positive cable routed between forward brace and engine.
3. Install oil level gage tube with positive cable between tube and engine as shown.
4. Install cable into clip and bend as shown.

NOTE: Clip is bent to this position at asm. cable inserted & clip closed.

Route battery cable behind oil level gage tube.

30-35 LBS FT
120-150 LBS IN.
NOTE: Assemble spark plug wires to plugs so that wire is directed upwards to maximize clearance to manifolds. Position slack towards distributor cap.

1. 2989400 WIRE ASM (CYL NO. 1)
2. 2989400 WIRE ASM (CYL NO. 2)
3. 2989401 WIRE ASM (CYL NO. 3)
4. 2989402 WIRE ASM (CYL NO. 4)
5. 2989403 WIRE ASM (CYL NO. 5)
6. 2989404 WIRE ASM (CYL NO. 6)
7. 29895933 WIRE ASM (CYL NO. 7)
8. 2989405 WIRE ASM (CYL NO. 8)
9. 2989408 WIRE ASM (HIGH TENTION)
10. PRODUCTION PART
11. 2977995 RETAINER-CTR
12. 2977555 RETAINER
13. 2977417 RETAINER
ASSEMBLY INSTRUCTIONS
3891775 "F" CAR 12000 SERIES

CARBURETOR 7027211
BOLT-FRT 9422857
HOSE 3785770
PIPE-SPARK 3870334
PIPE ASM-GAS 3906683
PLUG 445673
FUEL PUMP 6440668
SCREW ASM 3874976
AUTO-CHOKE ASM 3916161

12 - GASKET-CARB 3884574
11 - BAFFLE 3884576
10 - NUT 120563
9 - CLIP R.H. 7005165
8 - GASKET 1345198
7 - VALVE ASM 3887033

NOTE: Install spark pipe over vent, hose only.

14 - 18 LBS FT
160 - 190 LBS IN
100 - 125 LBS IN
25 - 30 LBS FT

V-8 ENGINE 396-CARBURETOR
FUEL PUMP & LINES

12000 V-8 ENGINE

UPC L35
DATE A7
SYM A7
REVISION RECORD
AUTH L
DC X

1 SHEET
Position air cleaner into slot before tightening.
NOTE: Rotate shaft against the exhaust pipe before torquing nut.
PRODUCTION PART

1. 3906092 HEATER & DEFROSTER ASM
2. 33C3C04 SEAL
3. 3906094 SEAL
4. 3739432 HOSE
5. 3736590 HOSE
6. 3906096 RETAINER
7. 3906096 SCREW
8. 3906093 BLOWER & INLET ASM
9. 37379G ADHESIVE .02 OZ.

FORWARD

15-20 LBS IN.

CHEVROLET MOTOR DIVISION, GMC

V-8 ENGINE 396-HEATER & DEFROSTER

12000 V-8 ENGINE

L35

A13

UPC

DATE

SYM

REVISION RECORD

AUTHL

DR

CK
ASSEMBLY INSTRUCTIONS

3891775 “F” CAR 12000 SERIES

1 3912570 SUPPORT ASM.

EXISTING PARTS

EXISTING BOLT

FRAME

\[\text{25-35 LBS. FT.}\]
NOTE The following components are not illustrated in this R. P. O. See Parts List or Bill of Material for part numbers.

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<td>OIL FILLER TUBE &amp; CAP-Assemble same as RPO L30</td>
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<td>6H</td>
<td>ENGINE VENT SYSTEM-Assemble same as RPO L30</td>
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<td>6M1</td>
<td>CARBURETOR-CHOKE-Assemble same as RPO L30</td>
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<td>AIR CLEANER-Assemble same as RPO L30</td>
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<td>RADIATOR ASM-Assemble same as RPO L30</td>
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1 Assemblies same as production. See Parts List or Bill of Materials for part number.
ASSEMBLY INSTRUCTIONS

3891775 "F" CAR 12000 SERIES

- 3739422 SPL. WASHER
- 138494 L. WASHER
- 3815833 BOLT

- DAMPER - PART OF ENGINE AS SHIPPED
- PROD PULLEY
- PROD BOLT

60-90 LBS FT

- V-8 ENGINE 350 TORSIONAL DAMPER
- 12000 V-8 ENGINE

CHEVROLET MOTOR DIVISION, GMC

UPC: L48, A3

DATE SYN: 5/2/66

REVISION RECORD: REDRAWN & REDESIGNED 7/4/66

AUTH: DR CK
1. STENCIL—See paint instructions

2. PAINT STRIPE-HEADER

3. V-8 ENGINE

4. A header peak

5. Extension ASM

6. CHEVROLET MOTOR DIVISION, GMC

7. V-8 ENG

8. DWG PRL 1 UA


10. DATE REL 3-1

11. L48

12. B2

13. UPC

14. SYM

15. REV

16. AUTH. DR. CK

17. L-81724

18. L-
Mandatory Assembly Instruction

2. Loosely assemble Rod Assembly [5] to Bracket [A].
3. After Special Nut [10] has been installed in Underbody Rail, Reinforcement. Attach Bracket [1] to Underbody with Specified Torque at three places. Be sure Bracket is against Underbody with specified Torque to Nuts on Stud.
4. Apply specified Torque to complete Assembly of Rod Assembly to Bracket [A].

**Note**: Maintain a 50 minimum clearance between resonator and radius rod bracket.

**Note**: Weight of car must be on springs when performing steps 3 and 4.

**V-8 Engine 350**

**Rear Axle Radius Rod**

**12000 V-8 Engine**

---

** UPC **

** Date **

** Revision **

** Authorization **

---

**Sheet Canceled**
**NOTE** The following components are not illustrated in the R.P.O. See Parts List or bill of material for part numbers.

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<td>3C</td>
<td>FRONT SPRINGS—SEE UPC 3</td>
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<td>FRONT SHOCK ABSORBERS—()</td>
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<td>6G2</td>
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<td>FAN BLADE &amp; CLUTCH ASM.—Assembles same as RPO K02</td>
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<td>EXHAUST MANIFOLD &amp; HEAT CONTROLS—Assembles same as RPO L35</td>
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<td>ACCELERATOR CONTROLS—Assembles same as RPO L35</td>
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<td>STARTING MOTOR &amp; CONTROLS—Assembles same as RPO L35</td>
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<td>6Y3</td>
<td>DISTRIBUTOR—()</td>
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<tr>
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<td>SPARK PLUG WIRES—Assembles same as RPO L35</td>
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\(\) Assembles same as production. See Parts List or Bill of Materials for part number.
NOTE: The following components are not illustrated in the R. P. O. See Parts List or Bill of Material for part numbers.

UPC 7 TRANSMISSION
7B1B CLUTCH & CONTROLS-Assembles same as RPO L35

UPC 8 FUEL & EXHAUST
8A FUEL TANK & TANK GAUGE UNIT
     (Cap Asm.)-Assembles same as RPO Z22
8B FUEL LINES-Assembles same as RPO L35
8C MUFFLER TAIL PIPE-Assembles same as RPO N10

UPC 10 WHEELS & TIRES
10B TIRES-1

UPC 11 SHEET METAL
11D HOOD-1
11G SHEET METAL ORNAMENTATION-Assembles same as RPO L48

UPC 12 ELECTRICAL
12G HORN BUTTON-1

UPC 13 RADIATOR & GRILLE
13A RADIATOR-1
13E RADIATOR SHROUD-1

UPC 14 BUMPERS & MISC.
14B GREASE & OIL-1
14F TIRE PRESSURE STICKER-1

- Assembles same as production. See Parts List or Bill of Materials for part number.

---

V-8 ENGINE 396 SPECIAL HIGH PERF. - NON-ILLUSTRATED PARTS

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ASSEMBLY INSTRUCTIONS

3891775 "F" CAR 12000 SERIES

1. Part installs same as L35
2. 6423907 AIR CLEANER ASM.
3. 6423438 VALVE ASM.
4. 3846117 CLIP
5. 3871298 HOSE
6. 3856954 GROMMET
7. 3868842 CONNECTOR
8. 3846122 HOSE
9. 3873852 STUD
10. 3849856 ARRESTOR ASM.
11. 219281 WING NUT

NOTE: Position air cleaner slot as shown before tightening.

V8 396 SPECIAL HIGH PREF.
CLOSED POSITIVE VENT.

L78
A5
3891775 "F" CAR 12000 SERIES

Part number & installation same as L35

1. 3886152 PIPE ASM.
2. 3894336 PIPE ASM.
3. 6440470 FUEL PUMP ASM.
4. 3886153 TEE

120-165 LBS. IN.
100-125 LBS. IN.

V8 396 SPECIAL HIGH PREF.
FUEL PUMP & LINES

12000 V-8 ENGINE

L78
A7
MANDATORY ASSEMBLY SEQUENCE

3. Attach bracket [11] to underbody with specified torque at three places. Be sure bracket is against underbody with specified torque to nuts on stud.

NOTE: Weight of car must be on springs when performing steps 3 and 4.
BACK-UP SWITCH ASSEMBLY PROCEDURE


3. Using .090" dia. gage, pin switch lever to bracket.

4. With pin engaged, tighten transmission bolts to required torque.

5. Backup light switch wire routing same as RPO M20.

NOTE: Boot, retainer and attaching part numbers installed same as RPO M20.
3 SPEED LEVER & LINKAGE ADJUSTMENT

1. Set Lever (L), (K) in neutral position.
2. Mover Lever Asm (A) & Levers (C), (D) to neutral position & insert Locating Gage (B) into control Lever Bracket assembly.
3. Install Rod (H) with Retainer (M) on Lever (L).
4. With two Jam Nuts (G), (E) & Swivel (F) loose on Rod (H) insert & attach Swivel with Retainer (N) to Lever (D).
5. Repeat steps 3 & 4 for Rod (J) and Lever (C & K).
6. Remove Locating Gage & check shift to insure proper operation.
ASSEMBLY INSTRUCTIONS

3891775 "F" CAR 12000 SERIES

1. 3895283 LEVER REVERSE
2. 3895284 ROD REVERSE
3. 3749084 RETAINER
4. 3841497 NUT
5. 3895244 SWIVEL
6. 3895253 ROD 1ST & 2ND
7. 3895255 ROD 3RD & 4TH
8. 103321 L. WASHER
9. 9419234 P. WASHER
10. 9421287 BOLT
11. 3895251 LEVER 3RD & 4TH
12. 3895249 LEVER 1ST & 2ND
13. 3895201 LUB. GREASE .01 LBS.
14. 3895204 LUB. HYPOID (.435 GAL.)
15. 3923534 NUT
16. 3920216 KNOB-UPPER
17. 3920216 KNOB-UPPER

NOTE: Typical rod end.

NOTES:
- Typical rod end.
- Prod. bolt L. washer & P. washer.

A2-17 4-SPEED TRANS CONTROL RODS

- CHEVROLET MOTOR DIVISION, GMC
- UPC 839297
- DATE 5-1
- SPEC A2
- SHEET 1

20-30 LBS. FT.
15-24 LBS. FT.

- 4-SPEED TRANSMISSION CONTROL RODS
- 1200w EXC RPO L48-L35
- DWG P001-7 S8 REF: Prod. A2 L-30268 L-
- DATE REP. 2-1 DD L- L-
- SHEET 1/2

- LUB. GREASE 20-30 LBS. FT.
- LUB. HYPOID 15-24 LBS. FT.

- NOTE: Typical swivel end.

- 4-SPEED TRANSMISSION CONTROL RODS
- 1200w EXC RPO L48-L35
- DWG P001-7 S8 REF: Prod. A2 L-30268 L-
- DATE REP. 2-1 DD L- L-
- SHEET 1/2
ASSEMBLY INSTRUCTIONS

3891775 “F” CAR 12000 SERIES

- Rod 1st & 2nd
- Rod Reverse
- Retainer
- Nut
- Swivel
- Rod 3rd & 4th
- Lub. Grease .01 lbs.
- Lub. Hypoid (.435 gal.)
- Nut Upper
- Nut Lower
- 20-30 lbs. ft

NOTE: Rods must be installed in lower holes of levers as shown.

NOTE: Typical rod end.

NOTE: Typical swivel end.

ASSEMBLY INSTRUCTIONS

- Rod 1st & 2nd
- Rod Reverse
- Retainer
- Nut
- Swivel
- Rod 3rd & 4th
- Lub. Grease .01 lbs.
- Lub. Hypoid (.435 gal.)
- Nut Upper
- Nut Lower
- 20-30 lbs. ft

NOTE: Rods must be installed in lower holes of levers as shown.

NOTE: Typical rod end.

NOTE: Typical swivel end.

ASSEMBLY INSTRUCTIONS

- Rod 1st & 2nd
- Rod Reverse
- Retainer
- Nut
- Swivel
- Rod 3rd & 4th
- Lub. Grease .01 lbs.
- Lub. Hypoid (.435 gal.)
- Nut Upper
- Nut Lower
- 20-30 lbs. ft

NOTE: Rods must be installed in lower holes of levers as shown.

NOTE: Typical rod end.

NOTE: Typical swivel end.
**NOTE** Used with RPO L48-L35, Existing trans washer on PROD L-6 RPO L22 PROD V-8 & RPO L30

**NOTE** Tighten Nut to bottom of thread while holding Shaft in horizontal position prior to assembling Bolt 1 to Lever Asm 3

\[ \text{NOTE: } 0.29 \pm 0.06 \text{ clearance to trans.} \]

\[ \text{NOTE: } \text{Flat on rod must be installed towards bracket with} \]
\[ \text{0.02 min. clearance} \]

**NOTE** 20-30 LBS FT

**NOTE** 14-22 LBS FT

**NOTE** 35-55 LBS FT
4 SPEED LEVER & LINKAGE ADJUSTMENT

1. Set Lever (M) (N) & (O) in neutral position.
2. Move Shift Lever (A) to neutral position & insert Locating Gage (C) into control Lever Bracket Assembly (B).
3. Install Reverse Rod (J) with Retainer (T) on Lever (O).
4. With two Jam Nuts (F) & (H) & Swivel (G) loose on Rod (J) insert & attach Swivel (G) with Retainer (E) to Lever (D).
5. Repeat steps 3 & 4 for Rod (K) & (L).
6. Remove Locating Gage & check shift to insure proper operation.
ASSEMBLY INSTRUCTIONS

3891775 “F” CAR 12000 SERIES

1. SPEEDO CBL ASM (LWR) PROD ENG.
2. (UPR) PROD. ENG. COUPE ONLY
3. (UPR) PROD. ENG. CONV. ONLY
4. PRODUCTION CABLE WITH RPO L48-L55-L78
5. PLUG USED WITH RPO L48-L55
6. CLIP
7. CEMENT .33 oz
   Applied to clip and hole from inside of car
8. SPEEDOMETER GEAR—Refer to chart 3901120

NOTE: Prod speedo cable hole.

Position color ident. mark in clip.

5 - 10 LBS IN
20 - 30 LBS IN

RPO L48-L55-L78

59 • 1.00 DM. HOLE AT DIMPLE
PROD GROMMET

328 ± .02 DIA HOLE
3 PLACES AT DIMPLE

VIEW A

PRODUCT ENGINE

PROD. CABLE ROUTING

UPPER
LOWER

NOTE
BACK-UP SWITCH ASSEMBLY PROCEDURE

1. Subassemble selector lever activating rod to back-up switch with retainer spring & loose assemble switch to mounting bracket with attaching screws.

   **NOTE**: With RPO L48-L35 loose-assemble switch & shield to mounting bracket with attaching screws.

2. Attach subassembly to transmission with cover bolts & attach activating rod to reverse selector lever with retainer spring. Place selector levers in neutral.

3. Using .090" dia. gage, pin switch lever to bracket.

4. With pin engaged, tighten attaching screws to required torque.

---

**INSTRUMENT HARNESS**

.320/.940 DIA. HOLE AT EXISTING Dimple

**BOLT PART OF TRANS**

20-30 LBS IN
15-20 LBS FT
25-30 LBS FT

---

**CHEVROLET MOTOR DIVISION, GMC**

| 1 | 1993413 SWITCH |
| 2 | 2404001 CLIP |
| 3 | 6290554 WIRE ASM |
| 4 | 3397317 BRACKET |
| 5 | 3364296 USED WITH RPO L48 |
| 6 | 148145 SPRING |
| 7 | 3362365 ROD |
| 8 | 3361440 USED WITH RPO L48 |
| 9 | 423595 SCREW |
| 10 | 3706355 SHIELD USED WITH RPO L48 |

**TRANS COVER ATTACHING PARTS**

| 9 | CEMENT .048 OZ. |

---

**4 SPEED TRANS-BACK UP LAMP**

SWITCH & ROUTING

| M20 | A7 | SHEET X |

---

**DRAWN:**

| 280 A7 L-77753 L-50266 |

**DATE REV:**

| 3-47 | 3-47 | 3-47 |

**DATE REL:**

| 3-47 | 3-47 | 3-47 |

---

**APPENDIX:**

| 2 | 8 BACK-UP SWITCH ASM PROCEDURE ADDED 63675 (A) |
| 3 | 63675 | 63675 |
| 4 | 63675 | 63675 |
| 5 | 63675 | 63675 |
| 6 | 63675 | 63675 |
| 7 | 63675 | 63675 |
| 8 | 63675 | 63675 |
| 9 | 63675 | 63675 |
| 10 | 63675 | 63675 |

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**AUTHOR:**

| C1 |

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**DATE:**

| 3-47 | 3-47 | 3-47 |

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**SRV:**

| L | L | L |

---

**REV:**

| L | L | L |

---

**SRC:**

| L | L | L |
ASSEMBLY INSTRUCTIONS

3891775 "F" CAR 12000 SERIES

SHEET  TITLE
A1  CONTENTS
A2  NON-IllUSTRATED PARTS
A3  DIAL INDICATOR & CONTROL COLUMN
A4  TRANS TO ENGINE
A5  -INSTALLATION PROCEDURE
A6  CONTROL LINKAGE
A7  -ADJUSTMENT
A8  -RPO DSS
A9  -ADJUSTMENT
A10  INSTR. PNL. HARNESS & CLUTCH HOLE COVER
A11  NEUTRAL SAFETY SWITCH
A12  -RPO DSS
A13  BRAKE PEDAL

SHEET  TITLE
A14  T. V. RODS & MODULATOR PIPE-(L-6 ENG)
A14.1  -(L-6 ENGINE)
A14.5  -(V-8 ENGINE)
A15  -(V-8 ENGINE)
A16  TRANS TO CARB. LINKAGE-(L-6 ENG)
A17  -(V-8 ENGINE)
A18  OIL COOLER PIPES
A19  T. V. CONTROL SPLASH SHIELD

T. V. CONTROL SPLASH SHIELD

TRANS. REAR MOUNTING
- SEE UPC 6

CHEVROLET MOTOR DIVISION, GMC

AUTO. TRANSMISSION-CONTENTS

1200G

UPC  DATE  SYM  REVISION RECORD  AUTH.
M35  4-25-66  A1  M35  REDRAWN & REDESIGNED  -
A1  323  L-6  A1  M35  3  DWG REVISED  MDP
A14  L-6  A14  M35  4  SHT A14.1 ADDED  VDP
NOTE: The following components are not illustrated in this R.P.O. See Parts List or Bill of Materials for part numbers.

**UPC 1**
**BODY**
1A-1 Body as purchased

**UPC 2**
**FRAME**
2B FRAME
(Trans. support cross member asm)-Assembles same as Prod.V-8 Eng.

**UPC 3**
**FRONT SUSPENSION**
3C FRT. SPRING-1

**UPC 4**
**REAR SUSPENSION**
4 RR AXLE ASM-(RPO L48)-0
4B RR SPRING-1

**UPC 5**
**ENGINE**
6 ENGINE ASM-1
6H ENGINE VENTILATING SYSTEM-1
6M-1 CARBURETOR ASM-1
6M-3 AIR CLEANER & SILENCER-1
6M-4 FUEL & VACUUM PUMP
(Carb gas pipe)-1
6Y-3 DISTRIBUTOR ASM-1
6Y-4 IGNITION-(Spark plug wire asm. Cly. No. 5)-1

**UPC 9**
**STEERING**
9A STEERING GEAR & PITMAN ARM-12000 Used with RPO D55
(Strg. column asm.)-1

**UPC 12**
**ELECTRICAL**
12J INST CARRIER PANEL &/OR INSTRUMENTS
(Speedo cable)-1

Assembles same as production. See Parts List or Bill of Material for part numbers.
INSTRUCTIONS FOR FILLING

Add specified amount of fluid thru transmission filler tube either with transmission stationary or immediately after starting engine. Fluid may be added immediately after starting engine for first time on final assembly line.

The oil level (measured with engine idling & trans. in neutral range) must be within 1/4 inch of the point on the gage asm. shown on the chart at the left.

**CAUTION** To avoid damage to transmission, the vehicle must not be driven with fluid more than (1) inch above or below "FULL MARK".

---

**ASSEMBLY INSTRUCTIONS**

3891775 "F" CAR 12000 SERIES

1. 3905449 GAGE ASM
2. 12 FLUID-AUTO TRANS 763 GALS L-6 ENG, 813 GALS V-8 ENG
3. 3790700 TUBE ASM
4. 179843 BOLT
5. 179841 BOLT
6. 3905499 TRANS. ASM. -L-6 ENG.
7. 3915022 -RPO L35
8. 3911820 -V-8 "327" ENG.
9. 3911807 -RPO L30
10. 3905787 -RPO L48
11. 1164253 SEAL
12. 3905499 BOLT
13. 3905499 BOLT
14. 12C MODULATOR PIPE -L-6 ENG.
15. 12C FLUID-AUTO TRANS .0045 GALS.

**OIL LEVEL ON GAGE VS. TRANS. SUMP TEMPERATURE**

- ABOVE 50 - 40 LBS. FT.
- BELOW FULL MARK

**REFERENCES**

- CHEVROLET MOTOR DIVISION, GMC
- UPC A4
- M35
- Date: 8-1-66
- Sym: 81465
- Auth: DR CK
- Div: 81465
- Rev: 80429
- Dk: 80429
- SHEET: A4
- PX: 2.00
- SY: 50493
- 12C SYM WAS SYM 4A
SUGGESTED INSTALLATION PROCEDURE.

1. Remove converter safety clamp. **CAUTION** Make sure that converter has not slipped forward.
2. Align white balance marker on flywheel with blue balance marker on converter to nearest bolt hole to assure proper balance of engine to transmission.
3. Enter transmission case into dowels on engine. Assemble oil filler & modulator pipe, o.. V-8 engine, on right side of case with bolt as shown.
4. Seat converter snout in crankshaft pilot hole.
5. On L-6 Engines, assemble modulator pipe clip on left side of case with bolt as shown.
6. On V-8 engines, assemble bell crankshaft bracket of left side of case with two bolts as shown.
7. Drive (6) trans. case to engine bolts.
8. Drive (3) flywheel to converter bolts.
9. Assemble converter under pan & splash shield to trans. case with (4) screws. **CAUTION** Hand start all converter bolts prior to torquing.

**CHEVROLET MOTOR DIVISION, GMC**

AUTO TRANS-INSTALLATION PROCEDURE

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<td>OF</td>
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**NOTE:** Hand start all converter bolts prior to torquing.
TRANSMISSION CONTROL LINKAGE ADJUSTMENT

1. Shift Lever must not bind in Column Asm. when making this adjustment.
2. Attach Rod (A) to Shift Lever with Retainer.
3. Set Transmission Lever (B) in "DRIVE" position. **NOTE:** Obtain "DRIVE" position by moving Transmission Lever (B) counter clockwise to low detent, then clockwise one detent position to "DRIVE".
4. Set Shift Lever in "DRIVE" position.
5. Install Grommet in Idler Lever (C). Slide Swivel onto Rod (A) then loosely assemble Swivel, Clamp, Bushing, Plain Washer, Lockwasher and Nut (D) to Idler Lever (C). See View A.
6. Tighten Nut (D) using recommended torque. See View A.

**NOTE:** When above procedure is adhered to, the following conditions must be met by manual operation of the steering column shift lever:
From reverse to drive position travel, the transmission detent feel must be noted & related to indicated position in dial.

When in drive & reverse position, pull lever upward (toward steering wheel) & then release. It must drop back into position with no restriction.

**CAUTION:** Any inaccuracies in the above adjustment may result in premature failure of the transmission due to operation without controls in full detent. Such operations results in reduced oil pressure & in turn partial engagement of the affected clutches. Partial engagement of the clutches with sufficient pressure to cause apparent normal operation of the vehicle will result in failure of the clutches or other internal parts after only a few miles of operation.
ASSEMBLY INSTRUCTIONS

3891775 "F" CAR 12000 SERIES

1. LEVER & BRKT ASM
   3895200

2. SCREW
   9422825

3. RETAINER
   3895282

4. SEAL
   3895281

5. RETAINER
   3749084

6. P. WASHER
   3748358

7. GROMMET
   3833107

8. IN
   GREASE .0066 LBS.

9. NUT
   124829

10. SWIVEL
    3843142

11. ROD
    3895268

12. LEVER
    3842080

A) 15-20 LBS. IN.
B) 35-40 LBS. IN.

AUTO TRANS-CONTROL LINKAGE

M35
A8

12000 USE WITH RPO D55

UPC: CHEVROLET MOTOR DIVISION, GM

DATE SYNTH. REVISION RECORD AUTH. BR CHK
M35 3-61 "IM" LUB SYMBOLS RMVD 8207 2
6 3-63 "IM" LUB, QUANTITY ADDED 8120 3
3 3-65 TORQUE ADDED 8120 3

DWG PREL 1-7 RFM. REF: Proc. A4 L-80351 L-
DATE REL J-1 DP L L L

330
ASSEMBLY INSTRUCTIONS

3891775 “F” CAR 12000 SERIES

TRANSMISSION CONTROL LINKAGE ADJUSTMENT

1. Loosely assemble Nuts (A) & (B) on Lower Rod (C).

2. Set Transmission Lever (D) in "DRIVE" position. [NOTE] Obtain "DRIVE" position by moving Trans. Lever Counter clockwise to "LOW" detent, then clockwise one detent position to "DRIVE".

3. Set Control Pawl Rod (E) in the "NEUTRAL or DRIVE" notch of Detent (F). See View A.

4. Apply load in direction of Arrow (Y) on Actuating Lever (G) until pawl Rod comes in contact with Detent at Contact Point (Z). See View A & B.

5. Place a .094 Spacer (H) between Nut (A) & Swivel (J), run Nut (A) until it touches Nut (A). Tighten Nut (B) against Swivel & lock Swivel between Nuts (A) & (B). See View B.

The foregoing procedure will provide a .05 over travel gap in the notches of Detent (F).
**INSTALLATION PROCEDURE**

1. Position column shift lever against drive gate by rotating lower lever (part of shift tube) clockwise as viewed from driver's seat.

2. Assemble switch asm. to column by inserting "DRIVE" tang in shifter tube slot. **SEE VIEW A.**

3. Tighten nuts on studs using recommended torque.

**INSTALLATION IF PIN HAS BEEN SHEARED**

1. Align .093/.097 hole in switch asm. with "DRIVE" tang. Insert pin to depth of .25 to hold tang in place.

2. Assemble switch asm. to column by inserting "DRIVE" tang in shifter tube slot. **SEE VIEW A.**

3. Tighten nuts on studs using recommended torque.

4. Remove pin.

**12-18 LBS.IN**

---

**CHEVROLET MOTOR DIVISION, GMC**

**AUTO TRANS-NEUTRAL SAFETY & BACK-UP LAMP SWITCH**

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ASSEMBLY INSTRUCTIONS

3891775 “F” CAR 12000 SERIES

1 3900503 SWITCH ASM
2 446161 P. WASHER
3 138479 L. WASHER

INSTALLATION PROCEDURE

1. Position Lever & Brkt. Asm; in "DRIVE" Clamp Pawl Rod (A) against Point of Contact (B) of detent. See View A.
2. Align slot of Contact Support (D) with .093/.097 dia. "DRIVE" hole in Switch Asm. Insert Pin (C) to a minimum depth of .25 to hold Contact Support in place. See View A.
3. Assemble Switch Asm. to Lever & Brkt Asm. with Tang of Lever (E) engaged in slot of Contact Support (D).
4. Tighten mounting screws using recommended torque.
5. Remove Clamp and Pin (C).

20-30 LBS. IN. 1
ASSEMBLY INSTRUCTIONS
3891775 "F" CAR 12000 SERIES

1. 3798256 BUSHING
2. 3828427 SHAFT
3. 1B GREASE .0066 LBS.
4. 3888682 COVER
5. 6. 3890605 PEDAL ASM-BRAKE

RETAINER-Must scribe a legible line on end of shaft during assembly. CAUTION Avoid any expanding tool which nullifies this intent.

BUSHING SHAFT GREASE \0066 LBS. COVER PEDAL, ASM-BRAKE

BRAKE PEDAL BRKT. ASM.-SEE U.P.C.S.

BRAKE CYLINDER PUSH ROD-SEE U.P.C.S.

- CHEVROLET MOTOR DIVISION, GMC -

AUTO TRANS-BRAKE PEDAL

M35 A13

DA-1C

1 325 66
2 325 66
3 325 66
4 325 66

1 WAS LUBRICANT QTY ADDED 22 2 6111
2 DWG REVISED 76 511 DF
3 DWG REVISED 77 c-1 PM AE
4 3888683 PLATE REMOVED 61461 RM AE

CHEVROLET MOTOR DIVISION, GMC

AUTO TRANS-BRAKE PEDAL

12000

UPC DATE SYM DIVISION RECORD ALINH DR CY

325 66 1 WAS LUBRICANT QTY ADDED 22 2 6111
325 66 2 DWG REVISED 76 511 DF
325 66 3 DWG REVISED 77 c-1 PM AE
325 66 4 3888683 PLATE REMOVED 61461 RM AE

SHEET 1/3
NOTE! Bottom hose against connector body.

NOTE! Bottom shoulder against connector extension.

* Plus torque required to align connector.

---

**assy.** 3891775 "F" CAR 12000 SERIES

1. 3905423 PIPE ASM.
2. 3905427 CLIP
3. 3785770 HOSE
4. 3891523 CONNECTOR ASM.
5. 103321 P. WASHER

---

**Auto. Trans. - Modulator Pipe**

- **Model:** 12000 V-8 ENG
- **Engine:**
  - **Date:** 3-1
  - **Engine:** 12000 V-8 ENG
- **UPC:**
  - **Code:** M35
  - **Date:** 5-20-48
  - **Details:** 3 REDRAWN & REDESIGNED 7769 RM DP
  - **Items:** 4 ITEMS ADDED

---

**Notes:**

- OL OF VEHICLE
- TRANS. ATTACHING BOLT
- OIL FILLER TUBE
- View A
- View B
- TYR HOSE INSTALLATION

---

**Attachment:**

- **Bottom hose** against connector body.
- **Bottom shoulder** against connector extension.
1. With accelerator pedal depressed, Bell Crank (D) must be in wide open throttle position.

2. Dash Lever (A) must be .03-.06 clearance from Pedal Support (B) as shown and Transmission Lever (C) must be against internal stop.

3. On L-6 engine, adjust swivel on Throttle Valve Rod (E) at Bell Crank (D).

On RPO L85, depress Bracket (G) downward on Throttle Valve Rod (F), install adjusting spring & tighten Set Screw (H) to recommended torque. SEE VIEW A.
1. With accelerator pedal depressed, Carburetor Lever (D) must be in wide open throttle position.

2. Dash Lever (A) must be .03-.06 clearance from Pedal Support (B) as shown and Transmission Lever (C) must be against internal stop.

3. Adjust swivel on throttle Valve Rod (E).

**Linkage Adjustment Procedure**

- **Prod. Accelerator Rod**: See UPC6 for adjustment.
- **Dash Lever (A)**
- **Pedal Support (B)**
- **Accelerator Pedal** (in wide open throttle position)
- **Trans. Lever (C)**
- **Swivel**
- **RBuretor Lever (D)** (in wide open throttle position)
- **Throttle Valve Rod (E)**

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</table>
ASSEMBLY INSTRUCTIONS

3891775 "F" CAR 12000 SERIES

1. BODY ASM-RADIATOR L-6 ENG.
2. CLIP
3. PIPE ASM-OUTLET
4. PIPE ASM-INLET
5. CONNECTOR

.50 ± .12
TO FAN SHROUD
(V-8 ENG ONLY)

.38 MINIMUM
TO ENGINE MOUNT

18 MINIMUM TO ENGINE
OIL PAN (L-6 ENG.
ONLY)

LOCATE MIDWAY BETWEEN
BENDS AS SHOWN

LOCATE APPROX 2 INCHES
FROM BEND AS SHOWN.

115-135 LBS.IN.
100-125 LBS.IN.

AUTO. TRANS. - OIL COOLER PIPES

M35
A18

DATE SYM

5-3-64 1 VIEW A ADDED
5-4-66 2 3010172 BODY ADDED
7-1-64 3 VIEW B ADDED
9-26-66 4 DIM ADDED 2 PLACES
10-26-66 5 DNG REVISED
12-21-66 6 "RPO L85 WAS "RPO L85"
2-23-67 7 DIM .18 MIN. MOVED

UPC

REF.

MOTOR DIVISION, GMC

AUTO. TRANS. - OIL COOLER PIPES

M35
A18

DWGPREL. HAPREF. REF.

12000

DATE REL 3-1 DP L L L
1) Extension to be assembled to shield so that natural curvature of rubber is toward shield as shown.

2) Extension to be flush to .12 away from point as shown.

NOTE: Staples to be installed in direction shown & must not cut through rubber extension.

NOTE: Splash shield extension must bend outboard when assembled.

NOTE: Extension to be assembled to shield so that natural curvature of rubber is toward shield as shown.

NOTE: Extension to be flush to .12 away from point as shown.

NOTE: Staples to be installed in direction shown & must not cut through rubber extension.

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NOTE: Extension to be flush to .12 away from point as shown.

NOTE: Staples to be installed in direction shown & must not cut through rubber extension.

NOTE: Splash shield extension must bend outboard when assembled.
NOTE The following components are not illustrated in this R.P.O. See Parts List or Bill of Material for part numbers.

UPC 1 BODY 1A-1 BODY AS PURCHASED

UPC 2 FRAME 2B FRAME (Side & cross member asm)-

UPC 5 BRAKES 5C BRAKE PEDAL & CONNECTIONS-Assemble same as RPO M35

UPC 7 TRANSMISSION 7A TRANS. EXTERNAL CONTROLS-Assemble same as RPO M35
7B1B CLUTCH CONTROLS (Clutch pedal push rod hole cover)-assembles same as RPO M35

UPC 9 STEERING 9A STRG. GEAR & PITMAN ARM (Strg. Column Asm.)-

UPC 12 ELECTRICAL 12H WIRING (Inst. Panel Wiring Harness Asm)-
12J SPEEDO CABLE (Speedo Gear, Fitting & Retainer)-

Assemble same as production. See Parts List or Bill of Materials for part numbers.

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3891775 "F" CAR 12000 SERIES

- 1 3920569 AXLE ASM
- 2 3882979 STRAP
- 3 3887348 BOLT
- 4 7801406 SHF. & UJT. ASM.-PROP.
- 5 8F GREASE-.02 lb.

12-17 LBS. FT.

3-SPD AUTO TRANS-REAR AXLE & PROP SHAFT

M40
A3
INSTRUCTION FOR FILLING

Add specified amount of fluid thru trans. filler tube prior to starting engine. With transmission in neutral range & throttle set at fast idle cam, start engine & allow to run for one minute.

The oil level (measured with engine idling & trans. in neutral range) must be within 1/4 inch of the point on the gage asm. shown on the chart at left.

CAUTION: To avoid damage to transmission, the vehicle must not be driven with fluid more than (1) inch above or below "FULL MARK".
SUGGESTED INSTALLATION PROCEDURE

1. Remove converter safety clamp. **CAUTION** Make sure that converter has not slipped forward.
2. Enter transmission case into dowels on engine & assemble modulator pipe clip & oil filler tube on right side of case with bolt as shown.
3. Assemble wiring clip on left side of case with bolt as shown.
4. Seat converter snout in crankshaft pilot hole.
5. Drive (6) transmission case to engine bolts.
6. Drive (3) flywheel to converter bolts.
7. Assemble converter underpan.

**CAUTION** Hand start all converter bolts prior to torquing.

\[ 75-110 \text{ LBS. IN.} \]
\[ 30-55 \text{ LBS. FT.} \]
Part numbers & installation - Same as RPO M35

2 3912617 ROD
3 3914805 ROD
4 9418931 NUT
5 3914807 LEVER

TRANSMISSION CONTROL LINKAGE ADJUSTMENT

Same as RPO M35 except for obtaining "DRIVE" position. **NOTE** Obtain "DRIVE" position by moving transmission lever counter clockwise to low detent, then clockwise two detent positions to "DRIVE".

1 RETAINER
2 PWASHER
3 GROMMET
4 SLEEVE

![Diagram of transmission control linkage](image)

CAUTION: Do not use impact type wrench to torque this nut.

*CHEVROLET MOTOR DIVISION, GM*
TRANSMISSION GEARSHIFT & CONTROL ADJUSTMENT

Same as RPO M35 except for obtaining "DRIVE" position.

**NOTE** Obtain "DRIVE" position by moving transmission lever counter clockwise to low detent, then clockwise two detent positions to "DRIVE".

**CAUTION** Do not use impact type wrench to torque this nut.

**NOTE** Impact type wrench.
TRANSMISSION CONTROL SWITCH ADJUSTMENT

With carburetor lever in wide open throttle position & automatic choke in "OFF" position, fully depress plunger of switch. Slide switch toward paddle of throttle lever maintaining a .20 ± .01 gap between switch plunger & lever paddle. Then tighten switch attaching screws to recommended torque.

Allow carburetor lever to return to the closed position.
ASSEMBLY INSTRUCTIONS

3891775 "F" CAR 12000 SERIES

1. Position Lever & Brkt. Asm. in "DRIVE". Clamp Pawl Rod (A) against Point of Contact (B) of detent. See View A.
2. Align slot of Contact Support (D) with .093/.097 dia. "DRIVE" hole in Switch Asm. Insert Pin (C) to a minimum depth of .25 to hold Contact Support in place. See View A.
3. Assemble Switch Asm. to Lever & Brkt Asm. with Tang of Lever (E) engaged in slot of Contact Support (D).
4. Tighten mounting screws using recommended torque.
5. Remove Clamp and Pin (C).

RECOMMENDED INSTALLATION PROCEDURE

RECOMMENDED INSPECTION PROCEDURE

1. Position shift lever in "Neutral."
2. Move lever forward to remove all play in linkage. CAUTION Do not move out of detent in transmission.
3. Turn ignition switch to "Start." Engine must start but vehicle must not move. Shut off engine.
4. Repeat procedure by moving lever rearward.
5. Position shift lever in "Reverse".
6. Move lever rearward to remove all play in linkage. CAUTION Do not move out of detent in transmission.
7. Turn ignition switch to "Start". Engine must not start.
8. Position shift lever in "Drive".
9. Move lever forward to remove all play in linkage. CAUTION Do not move out of detent in transmission.
10. Turn ignition switch to "Start". Engine must not start.
3892777-8 FRONT EXHAUST & RESONATOR PIPE ASM L. & R.H.

Dimensions indicated are reference, reflecting nominal design clearance variation of more than .25 from this dimension indicates a quality deficiency.
1. 3892782  EXHAUST PIPE-REAR
2. 3784303  SCREW ASM
3. 3908360  HANGER ASM
4. 3792287  SPL. NUT
5. 103520   L. WASHER
6. 102634   NUT
7. 52       SEALER-GREASE
            Approx. .25 oz.
8. 3908363  "U" BOLT
9. 387096   "U" BOLT
10. 3867046 CLAMP


11. "U" bolt to be over end of slots on muffler & rear exhaust joints.
12. 3908362 CLAMP
13. All dimensions indicated are reference reflecting nominal design clearance variation of more than .25 from this dimension indicates quality deficiency in a component part.
14. 120386 WASHER

NOTE: Front of hanger asm bracket to line up with rear exhaust pipe.

NOTE: Apply to full I.D. of rear exhaust pipe to assembly of resonator.

NOTE: Apply to full I.D. of muffler inlets prior to assembly with rear exhaust pipe.

NOTE: 

- "U" bolt to be over end of slots on muffler & rear exhaust joints.
- All dimensions indicated are reference reflecting nominal design clearance variation of more than .25 from this dimension indicates quality deficiency in a component part.
- Front of hanger asm bracket to line up with rear exhaust pipe.
- Apply to full I.D. of rear exhaust pipe to assembly of resonator.
- Apply to full I.D. of muffler inlets prior to assembly with rear exhaust pipe.

- CHEVROLET MOTOR DIVISION, GMC

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- DUAL EXHAUST-REAR EXHAUST PIPE & HANGERS

- 12400-600

- REF: Pr. A 4 L-79335 L-

- DATE REL 3-1 DP

- TESTED 1X

- 350
ASSEMBLY INSTRUCTIONS

3891775 "F" CAR 12000 SERIES

SCREW 9411890
HANGER ASM 3892789
SCREW 1363900
PIPE L.H. 3892783
CLAMP 3848157
NUT 102634
L. WASHER 103320
MUFF. ASM & TAIL PIPE 3892788

SEALER—Grease approx. .25 oz. Apply to full I.D. of muffler asm. to pipe.

All dim indicated are ref. reflecting nominal design clearance. Variation of more than .25 from this dim. indicates quality deficiency in a component part.

Ex. 3863512. CLAMP

RIVNUT—L.H. (COUPE) 3818073
SCREW—L.H. (COUPE) 9409107

NOTE: Rear spring edge, full jounce.

DUAL EXHAUST—MUFFLER ASM
TAILPIPE & HANGERS

UPC N 10
A 4

DATE SYM. REVISION RECORD
4/25/66 W43 38419400 16600 635000
8 169-100 L.B. IN. 550885 A-79358
8 ITEMS 13-57 ADDED

*CHEVROLET MOTOR DIVISION, GMC*
ALL DIMENSIONS INDICATED ARE REFERENCE REFLECTING NOMINAL DESIGN CLEARANCE. VARIATION OF MORE THAN 0.25 FROM THIS DIMENSION INDICATES A QUALITY DEFICIENCY IN A COMPONENT PART.

NOTE: All dimensions are measured from surface of muffler bead.

NOTE: Tail pipe measured from R.H. side of muffler.
NOTE 1 Cut .2 in off the top of cover before installing same on turn signal switch lever.
ASSEMBLY INSTRUCTIONS

3891775 "F" CAR 12000 SERIES

1 3901310 HUB ASM-STEERING WHEEL
2 3908599 EYELET
3 9746195 WHEEL ASM-STEERING
4 9419712 SCREW
5 3901330 CONTACT ASM
6 159612 SCREW
7 3901313 CAP ASM-HORN BUTTON

- 20-30 LBS IN
- 5-10 LBS IN

WOOD GRAINED PLASTIC
STEERING WHEEL

N34 A1

CHEVROLET MOTOR DIVISION, GMC

UPC DATE SYM REVISION RECORD AUTH. DR Cx

12000

DWG PREL 1-26 WS REF: Prod. AI L-8/599 L-
DATE REL 3-1 DP L- L-

SHEET -

343
Position generator maximum outboard in bracket slot & tighten bolt. Adjust belt to required tension by adjusting hydraulic steering pump.

**L6 ENGINE**

\[\text{\textbf{NOTE}}\]

\[21-30 \text{ LBS FT}\]
ASSEMBLY INSTRUCTIONS

3891775 "F" CAR 12000 SERIES

1. CLAMP
   9430534
   9434894

2. HOSE (to gear outlet) L-6 ENG
   3763238
   3853300

3. PIPE ASM L-6 ENG
   3901352
   3874690

4. HOSE ASM (to gear inlet) L-6 ENG.
   3856964
   3901351

NOTE: Install hose parallel with top surface of crossmember.

NOTE: Position pressure & return hoses 3" on steering gear centerline.

DATE REL 3-1

DATE FEL 3-1-80 TRL 7-9671

SHEET B

370
MANDATORY ASSEMBLY PROCEDURE

1. Cradle hydraulic steering pump in a fixture with a back-up plate supporting perimeter of reservoir.
2. Support shaft from opposite side when it is necessary to straighten key to allow mounting of the pulley.
3. Line up key with keyway in the pulley & mount pulley on shaft applying a steady hand pressure on pulley. **CAUTION** Any impact on pulley or pump shaft can cause damage to pump thrust plate.
4. Use a stall wrench while applying a brake force in pulley groove, torque set.

HYDRAULIC STEERING BLEEDING INSTRUCTIONS

1. Attach hoses to pump & gear. **CAUTION** Do not remove plastic plugs from gear until immediately prior to installation of hoses.
2. Fill pump to within approx. 2.0 inches of top of filler neck prior to engine start or pump rotation.
3. Rotate pump & maintain 2.0 inch level until no more foam or bubbles appear. **CAUTION** Do not turn steering wheel until completion of Step 3 since this will load the system and build up oil pressure which will dissolve air in the oil. It will then take 2 to 3 hours to defoam before bleeding can be completed.
4. Check hoses & fittings for leaks by pressurizing system.
5. Add fluid to level marked on dipstick as required.
ASSEMBLY INSTRUCTIONS

3891775 “F” CAR 12000 SERIES

1. 103321 L. WASHER
2. 9422277 NUT
3. 3901804 BRACE-ADJ
4. 3825452 P. WASHER
5. 9418968 BOLT
6. 125525 NUT
7. 7800307 PUMP ASM
8. RPO K19 part
9. 3901803 BRACE-FIXED
10. 180126 BOLT—See sect 6 for torque.

== PROD. GEN. ADJ. PARTS ==

11. 3901807 BRACE-AIR PUMP
12. 180079 BOLT
13. 187119 L. WASHER
14. 120376 NUT
15. 3991559 BRACKET ASM
16. 9417950 BOLT
17. Installation covered elsewhere in this group.

== HYDRAULIC STEERING ==

L-6 ENGINE WITH RPO K19

Remove gen. brace. (Part of eng asm not replaced).

PROD WASHER

BOLT-SPACER-BOLT

25-35 LBS. FT.
20-30 LBS. FT.
14-22 LBS. FT.

N40
A8

DATE: 3-1
ASSEMBLY INSTRUCTIONS

3891775 "F" CAR 12000 SERIES

1 3901805 HOSE
2 3901806 HOSE
3 3330002 BELT (2ND TRACK)

4 HOSE CLAMPS—See RPO K19
5 Part no. end of hose to A.I.R. pump

CHECK VALVE

A.I.R. PUMP

PULLEY—RPO K19

TENSION—RPO K19

P/S PUMP PULLEY

HYDRAULIC STEERING
A.I.R. PUMP BELT & HOSES

12000 WITH RPO K19

N40
A9

373
Position pressure & return hoses 0° on steering gear centerline.

Installation covered elsewhere in this group.
ASSEMBLY INSTRUCTIONS
3891775 "F" CAR 12000 SERIES

SHEET TITLE
A2 CONTENTS
1 9789272 TIRE UNIT
2 9427279 VALVE ASM.
3 3901320 WHEEL ASM.
4 LUBRICANT 1.6 OZ.

INSTALLATION & CHECKING PROCEDURE
1. After assembling valve asm. and tire to wheel asm. inflate tire to 40-50 psi to seat tire beads.
2. Inspect for complete seating-both tire beads.
3. Inspect for leaks-rim, valve asm. & tire by submersion in water.
4. Deflate tire asm. before stowing in trunk of car by removing valve core.
5. Reinstall valve core and tighten to
6. Install valve cap to valve asm. as shown.

NOTE Tire & valve stem installation must be made before lubricant is dry.

INSTALLATION OF TIRE TO WHEEL ASM. (BOTH SIDES OF RIM)

1.5-2.5 LBS. IN.
2 LBS. IN. MIN

---

SPACE SAVER SPARE TIRE & WHEEL EQUIPMENT-CONTENTS

1 12000
2 3891775 "F" CAR 12000 SERIES

CHEVROLET MOTOR DIVISION, GMCA
Position wheel so that tire valve stem is down

NOTE: Position firmly against pan wall.

NOTE: Inflator must rest on top of base.

NOTE: Position tire against wheelhouse and seat back.

NOTE: Position jack asm. 1" rearward of seat back.
INSTRUCTION SHEET

1. SCREW DRIVER
   - Install screw driver under jack base
2. EXTENSION
   - 9417730
3. COVER ASM (See misc shipping list-UPC 0)

The following parts are shown in UPC 0-misc shipping list.
1. SCREWDRIVER
   2. Install screw driver under jack base.

3. EXTENSION
4. COVER ASM (See misc. shipping list-UPC 0)

INFORMATION TRANSFERRED
SEE SECTION

SIMULATED WIRE WHEEL
TRIM COVER

MODEL 12000

DATE 3/7/66

PO2 A1

L- L- L-
ASSEMBLY INSTRUCTIONS

3891775 "F" CAR 12000 SERIES

1. 9422033 STRAP
2. 6287814 WIRE ASM WITH RPO Z22
3. 9000508 HORN ASM
4. 3853846 SCREW ASM

- 36 dia. hole in existing dimple of skirt extension panel.
- 14-22 FT. LBS
ASSEMBLY INSTRUCTIONS

3891775 “F” CAR 12000 SERIES

1 6291353 WIRE ASM
2 3724851 TAPE
   A. (4 in. (2) places. Wire asm to inst panel harness.
   B. (4 in.) Loop & tape excess wire asm.

3 6459143 CLUSTER ASM
4 6459138 RPO UI1
4 6454841 CABLE ASM

NOTE: Plug into fuse panel receptacle marked BAT. FUSED.

SPEED WARNING DEVICE

U15
A1

CHEVROLET MOTOR DIVISION, GMC

UPC
DATE SYM
12000

REDRAWN & REDESIGNED

DIVISION RECORD
PLA18

AUTH. DR CHK

SHEET

38
ASSEMBLY INSTRUCTIONS

3891775 “F” CAR 12000 SERIES

SHEET TITLE
A1 CONTENTS
A2 CONSOLE CLUSTER ASM & CLOCK
A3 WIRING
A4 FRT WIRING & OIL PRESSURE HOSE

The following part assembles same as
RPO DS5

1 3919081 SEPARATOR COMPARTMENT
2 1995149 LIGHT SWITCH
3 1513321 SWITCH ASM-THERMO GAGE

PARTS LIST

1 5462909 TACH ASM-Exc L35, L48, L78 & Z28
2 6468910 RPO L35 & L48 Exc L78 & Z28
3 6468911 RPO L78 & Z28
4 6480776 CLUSTER ASM

PRINTED CIRCUIT (UPC 12)

connector (part of inst pnl harn)

- CHEVROLET MOTOR DIVISION, GMC -

FRT. COMPT. CONSOLE INSTRUMENT CLUSTER-CONTENTS

<table>
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<td>4-6-67</td>
<td>15</td>
<td>720674 NUT</td>
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- SHEET X -
1  6457859  CLUSTER ASM-CONSOLE
2  9420014  SCREW
3  3794017  KNOB
4  3794018  NUT
5  3901613  CLOCK ASM
6  9419699  SCREW

15 - 22 LBS IN.
1 - 2 LBS IN.
7 - 12 LBS IN.

CHEVROLET MOTOR DIVISION, GMC

FRONT COMPT. CONSOLE INSTRUMENT CLUSTER-CONSOLE CLUSTER & CLOCK

U17
A2

DATE SYM REVISION RECORD  AUTH. DR CK

9302011  L  ITEM & TORQUE ADDED  L- 2021  Tm L

DWG REV L-85 "Sheet 1" REVISION 3-1 L-88471 L-

3891775 "F" CAR 12000 SERIES
ASSEMBLY INSTRUCTIONS

3891775 "F" CAR 12000 SERIES

1 6293326 HARNESS ASM-INST PNL RPO M35
   6293328
2 6293330 HARNESS ASM-ST SEP (RPO M35)
   (PROD 3 SPD & RPO M13-M20-M21)
   6293332

GROMMET IN DASH PANEL (SEE SHEET 4A)

NOTE: Route oil hose under mat.

Hose ASM (SEE SHEET 4A)

SCREW (SEE SHEET A2)

EXISTING NUT

EXISTING GROUND WIRE

Hose ASM (SEE SHEET A4)

VIEW A

CLUSTER ASM BLACK (Part of 2)

VIEW B

ST. SEP. COMPARTMENT

SEAT SEPARATOR COMPARTMENT

A 30-35 LBS IN.

NOTE: Coil excess hose 4 inside console.

3 9417863 BULB
4 TAPE

# CHEVROLET MOTOR DIVISION, GMC

FRONT COMP. CONSOLE INSTRUMENT CLUSTER-CONSOLE CLUSTER WIRING

UFC 12400-600

DATE SYM DIVISION RECORDED AUTH. DR CHECK

3-18-67 7 REDRAWN (REDESIGNED 83872-83912 DA-C1)

A3 SHEET A

355
For proper operation, lamp should turn off when lid is 12 in. ± 3 in. from the closed position when vehicle is on level ground.
A - (6 IN.) Lamp wire to engine wiring harness.

B - (6 IN.) Lamp wire to gen. & forward lamp harness.

For lamp wire routing with hood insulator, see Sheet A2.

For proper operation, lamp should turn off when lid is 28 in. = 6 in. from closed position when vehicle is on level ground.

NOTE: For lamp wire routing with hood insulator, see Sheet A2.
1. Remove insulation within perforated circle.
2. TAPE (3 IN.) Tape lamp wire to lamp wire
3. Slit retainers as shown.

**NOTE:** For wire routing forward of this point, see Sheet A1.
1. SWITCH ASM & BULB, PART NUMBERS & INSTALLATION SAME AS PRODUCTION.
2. 2986256 WIRE ASM
3. 3724851 TAPE - APPROX. 4 in. per job
TAPE-8 inches Lamp asm wire to instrument panel harness (2 places).

3900518 LAMP ASM

PRODUCTION CLIP

9418016 SCREW

Plug lamp asm lead into fuse panel at location marked panel lamps.

10-14 LBS. IN.
ASSEMBLY INSTRUCTIONS

3891775 "F" CAR 12000 SERIES

9417496 SCREW
3901633 BRACKET
3827441 NUT
3724851 TAPE (4 IN.) (3 PLACES) Wire asm to dash & toe panel.
6290686 WIRE ASM

NOTE: For clock asm & attaching parts when installed to item 2 see UPC 0 - Miscellaneous Shipping List.

NOTE: Slit carpet (at bracket) to allow connectors thru.

NOTE: Remove stamped outline from jute prior to installation of wire asm.

NOTE: Locate per pattern on underside of separator.

NOTE: Plug into fuse panel receptacle marked "LAMPS".

NOTE: Plug into fuse panel receptacle marked "BAT. FUSED".

NOTE: 5-10 LBS. IN.
NOTE: 15-20 LBS. IN.

50 X 1.25 SLOT
22 DIA (2) HOLES

FLOOR MOUNTED CLOCK

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<th>UPC</th>
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<th>SYM</th>
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<td>8-8-67</td>
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<td>&quot;CLOCK&quot; NOTE REVISED</td>
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<tr>
<th>FLOOR MOUNTED CLOCK</th>
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<tbody>
<tr>
<td>DWG 4-15</td>
<td>REF: Prof. A1</td>
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</table>

| 392 |
Fader control asm, knob & harness part numbers & installation same as RPO U80.

Rear speaker asm, grille, wiring & attaching parts are released by Chevrolet & installed by Fisher Body.

Stereo tape cartridge ref. UPC 0-Misc. shipping list.
**ASSEMBLY INSTRUCTIONS**

**3891775 “F” CAR 12000 SERIES**

1. 9426552 SCREW
2. 7301751 BRACKET
3. 9420431 SCREW
4. 7301181 KNOB
5. 9770546 NUT
6. 7301740 PLATE ASM.
7. 7301001 TAPE PLAYER

**NOTES**

- Cut off heater duct outlet as shown to provide clearance for tape player asm.

**HINTS**

- 16-22 LBS. IN.
- 30-40 LBS. IN.
- 13-18 LBS. IN.
- 20-30 LBS. IN.

**UPC D55**

**CHEVROLET MOTOR DIVISION, GMC**

**STEREO TAPE-PLAYER ASM & BRACKET**

**U57**

**DATE**

**DIVISION RECORD**

**AUTH.**

**Dwg PREL. 4-6 Ref: Prod.**

**L-79185 L-79185 L-79185**

**DATE REL. 4-20 HB**

**L-79185 L-79185 L-79185**

**CLASS**

**X SHEET**

**384**
ASSEMBLY INSTRUCTIONS

3891775 "F" CAR 12000 SERIES

1. 3921422 PAD ASM.
2. 7304181 TAPE PLAYER
3. 3921421 BUMPER
4. 3921420 BRACKET
5. 9417611 NUT
6. 3421375 SCREW
7. 3681751 GROMMET
8. 3841230 SCREW-ASM
9. 3686821 GROMMET
10. Part number & installation see Sheet A2.
11. 59A CEMENT 3 OZ.

NOTE: Route tape player harness parallel to seat separator harness.

Part number & installation see Sheet A2.

STEREO TAPE-PLAYER ASM. & BRACKET

12000 WITH RPO C60

UFC: U57
SYM: A2.5
NOTE: For harness installation (with & without radio) see sheet A3.

- Tape Player Harness
- Instrument Panel Reinforcement
- Seat Separator
- Existing Harness

30-40 LBS. IN.
19-27 LBS. IN.

**CHEVROLET MOTOR DIVISION, GMC**

<table>
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<tr>
<th>STEREO TAPE- WIRING &amp; CONVECTOR ASM.</th>
<th>UPC</th>
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<td>12000 WITH RPO C60</td>
<td>U57</td>
<td>7-34-67</td>
<td>392423</td>
<td>BRACKET REMOVED</td>
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<td></td>
<td></td>
<td>2</td>
<td>3415303</td>
<td>SCREW (30-40 LBS. IN)</td>
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<td>CONVECTOR DWE REVISED</td>
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REF: CR 836624 | 84304 | 1-1 | L- | L- | L- |
### ASSEMBLY INSTRUCTIONS

**3891775 “F” CAR 12000 SERIES**

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<thead>
<tr>
<th>No.</th>
<th>Description</th>
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<tbody>
<tr>
<td>1</td>
<td>WIRE ASM-FRONT SPEAKER</td>
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<tr>
<td>2</td>
<td>TAPE</td>
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<td>3</td>
<td>BLACK &amp; PURPLE WIRE (To R.H. Speaker)</td>
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<td>4</td>
<td>BLACK &amp; TAN WIRE (To L.H. Speaker)</td>
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<td>5</td>
<td>REAR SPEAKER EXT ASM (Installed by Fisher Body)</td>
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<tr>
<td>6</td>
<td>SPEAKER CONNECTOR (From Tape Player)</td>
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<td>7</td>
<td>RADIO CONNECTOR (Black wire)</td>
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<tr>
<td>8</td>
<td>POWER LEAD FROM BODY HARNESS (Yellow Wire)</td>
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<tr>
<td>9</td>
<td>TAPE PLAYER CONNECTOR (Red Wire)</td>
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<tr>
<td>10</td>
<td>GROUND WIRE WITH CLIP</td>
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<tr>
<td>11</td>
<td>FADER CONTROL (Green Wire)</td>
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### Diagram

- **VIEW A**: Wire connections and layout of the stereo and speaker components.
- **VIEW B**: Wiring near the panel brace with existing clips noted.
- **VIEW C**: Close-up of the wire assembly with stripe marker positioning.
- **VIEW D**: Connection details near the speaker terminals.

### Notes

**NOTE**: Position (1) stripe marker on wire asm. in R.H. clip & (2) stripe marker in L.H. clip.

---

**STereo TAPE-SPReaker WIRINg**

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<td>STEREO TAPE-SPEAKER WIRING</td>
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<td>U57</td>
<td><strong>UPC</strong></td>
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<td><strong>DATE</strong></td>
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<td><strong>AUTH.</strong></td>
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<tr>
<td>BCP</td>
<td><strong>DR.</strong></td>
</tr>
<tr>
<td>1</td>
<td><strong>SHEET</strong></td>
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---

**UPC**

- **UPC U69**: Reference for wire assembly.

---

**EXISTING CLIPS (SEE NOTE)**

- **UPC U69**: Reference for existing clip positions.
1. Turn BALANCE Knob to extreme clockwise direction.
   a. Turn FRONT-REAR Knob to FRONT. With knobs in these positions, the right front speaker should operate.
   b. Turn FRONT-REAR Knob to REAR. In these positions, the left rear speaker should operate.

2. With BALANCE rotated to extreme counter-clockwise position and front rear knob in FRONT position, left hand front speaker should operate.
   When FRONT-REAR knob is rotated to REAR, the right hand rear speaker should operate.
**Assembly Instructions**

*3891775 “F” Car 12000 Series*

**Contents**

- Contents
- Receiver & Speaker
- Receiver Bracket, Wiring & Antenna Cable
- Capacitors
- Capacitors-U69
- Ground Straps
- Ground Straps
- Front Antenna
- Front Wheel Hub Asm.

**Notes**

- Remove all grease from grease retainer & lathe hole before installing static collector.
- Bend cotter pin back for clearance.

**Diagram**

[Diagram of car showing assembly parts and instructions]

**Revision History**

- U63
- U69 AM/FM-Contents
- A1
- 12000
- U63
- U69
- A1
- Title Added (2) Places
- 109552 Fuse Removed
PROCEDURE FOR PEAKING THE ANTENNA TRIMMER

1. Set antenna mast at a height of 31 ± 1.0 inches (except U69).
2. Set volume control knob at maximum volume.
3. Tune radio to a signal at or near 1400 KC on the AM scale.
4. Adjust antenna trimmer screw (±2° screw rotation) until maximum volume is received.
5. Turn receiver off.
1. Harness ASM-Starter Motor Wiring

2. Nut-Positive (+) Post loosen nut & allow terminals to be positioned between nut & clip.

3. 9412180 Screw

4. 121752 L. Washer-Ext Tooth

5. 1947452 Capacitor ASM

6. 1964086 Capacitor ASM

---

**L-6 Engine**

- 1. Coil
- 2. Regulator
- 3. Existing Ground Wire
- 4. Existing Screw

---

**V-8 Engine**

- 1. Coil
- 2. Regulator
- 3. Existing Ground Wire
- 4. Existing Screw

---

**Chevrolet Motor Division, GMC**

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<th>UPC</th>
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<th>Division</th>
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<td>U69</td>
<td>7/10/44</td>
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<td>79404 WH DP</td>
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**Radio-Capacitors**

- 12000
- Dwg. Ref: Prel. A4 L-81137 L-
- Date/Rev: 3-1 DP L- L- L-
1. TAPE
   A. (8 in.) Tape excess blower motor feed wire to harness
   B. (4 in.) Tape capacitor wire to dash.
   C. (4 in. each application) Double back & tape blower motor feed to ground wire.
   D. (4 in.) Tape capacitor wire to evaporator.

2. CAPACITOR

3. TAPE (8 in.) Tape excess blower motor feed wire to harness
4. CAPACITOR
5. TAPE (4 in. each application) Double back & tape blower motor feed to ground wire.
6. TAPE (4 in.) Tape capacitor wire to evaporator.

NOTE: Untape blower feed & ground wire harness to this point as shown. (Approx. 9 in.)

NOTE: Modify capacitor as shown.

---

**CHEVROLET MOTOR DIVISION, GMC**

<table>
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<th>PART DESCRIPTION</th>
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<td>RADIO-CAPACITORS-U69</td>
<td>U63</td>
<td>12000</td>
<td>U69</td>
<td>REF: Prel. A5 L-81157</td>
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Screw & ground strap (REF. SHT A7)

**ALL EXCEPT C60**

View A

(ASSEMBLED)
1. 6290315  STRAP ASM
2. .195/.189 dia. hole thru existing dimple
3. SCREW, SPARK PLUG WIRE SUPPORT & REINFORCEMENT—Part of engine asm.
4. 9420415  SCREW
5. Install ground strap under spark plug wire support.

\[\text{R.H. ROCKER COVER}\]

\[\text{L.H. ROCKER COVER}\]

- 25 LBS. IN. MAX.
- 11-30 LBS. IN.
- 10-15 LBS. IN.

---

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<td>RADIO-GROUND STRAPS</td>
<td>U63</td>
<td>U69</td>
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<tr>
<td>(V-8 ENGINE TO BODY)</td>
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<td>A6</td>
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REV: 3  WAS .182/.185 DIA. HOLE  80667 NM
REV: 4  WAS 9419380 SCREW (31-
30 LBS. IN.)
3891775 “F” CAR 12000 SERIES

ASSEMBLY INSTRUCTIONS

1  3849461  CAP—For shipping purposes only. Shipping Cap must be installed before exposure to water test or weather. Remove before installing rod & mast asm.

2  3863499  CAP

3  3897333  BEZEL

4  3820672  GASKET

5  3863239  GROUND RING—Installed on pins of antenna body with flat directly below notch in fender & key on bezel.

6  3880695  ANTENNA BODY ASM.

7  3897334  CABLE ASM LEAD-IN

8  3832639  CLIP

ROD & MAST ASM. (See Misc. Shipping List UPC O)

NOTE Antenna should lean inboard approx. 4° (Ref.) when viewed from front of car & stand vertically when viewed from side of car.

CAUTION Push connector all the way into antenna body until boot bottoms against antenna body. Do not twist cable asm. lead-in during assembly.

NOTE Assemble clips at both ends of glove box.

Antenna should lean approx. 4° (Ref.) when viewed from front of car & stand vertically when viewed from side of car.

CAUTION Push connector all the way into antenna body until boot bottoms against antenna body. Do not twist cable asm. lead-in during assembly.
Part the same as & installed the same as RPO U63

3138635 GASKET
3903424 BEZEL
3903406 GROUND RING

The following parts are released by Chevrolet & installed by Fisher Body:
3897311 CABLE ASM LEAD-IN

NOTE: Antenna should lean-inboard approx. 4° (Ref.) when viewed from rear & stand vertically when viewed from side of car.

1.12 DIAM. HOLE VERTICALLY THRU R.H. REAR QUARTER PANEL

FORWARD

1. ANTENNA BODY ASM.
2. GASKET
3. BEZEL KEY
4. NOTCH IN REAR QUARTER PANEL
5. PIN
6. GROUND TAB (UP)
7. CABLE ASM. LEAD-IN

CAUTION: Push connector all the way into antenna body until boot bottoms against antenna body. Do not twist cable asm lead-in during assembly.

35-40 LBS. IN.
ASSEMBLY INSTRUCTIONS
3891775 "F" CAR 12000 SERIES

The following parts are released by Chevrolet and installed by Fisher Body:

1. 7300614 SPEAKER ASM
2. 7296971 GRILLE
3. 2988134 EXTENSION WIRE ASM
4. 3909551 HOUSING ASM (CONV.)
5. 7292636 STUD (CONV.)
6. 7292635 SCREW (CONV.)
7. 2989256 GROUND WIRE (CONV.)

AUXILIARY SPEAKER
EXTENSION WIRE ASM.
1. 7300461 FADER CONTROL KNOB ASM
2. Part the same as & installed the same as RPO U63
3. 7290858 HARNESS ASM

[CAUTION] Avoid crimping wires when installing thru opening in trim plate.

CAUTION Align locating pin with cutout in trim plate.

Alignment:
- Align locating pin with cutout in trim plate.

Extension Wire ASM.
- Installed to this point by Fisher Body

[WARNING] Align locating pin with cutout in trim plate.

Clip to Receiver ASM.
- Clip to receiver ASM.

Auxiliary Speaker Equipment:
- Speaker Wiring & Controls

12000 (EXC. CONV.)
The following parts are assembled the same as prod.

- 3010175 BODY ASM RAD L-6 ENG
- 3010176 L-6 ENG with RPO M35
- 3010178 BODY ASM RAD V-8 ENG
- 3010179 V-8 ENG with RPO M35
- 3893814 SHROUD V-8
- 3893816 SHROUD L-6 (Same as V-8 prod)
- 3893832 BRACKET ASM. L-6 (Same as V-8 prod)

HOSE RAD INLET RPO L30 & L48

RADIATOR SUPPORT

PROD. NUT L.H. SIDE ONLY

PROD. SCREW

(V-8 ENG)
ASSEMBLY INSTRUCTIONS

3891775 “F” CAR 12000 SERIES

1 180122 BOLT
2 103321 L. WASHER
3 3893803-4 CLAMP L. & R.H.
4 3893800 CUSHION ASM
5 3893801-2 GUARD ASM L. & R.H.
6 10 58 CEMENT-SEAM (2 PCS)
7 9419842 NUT
8 3891775 "F" CAR 12000 SERIES
9 3893802-3 CUSHION ASM
10 120377 NUT

VALANCE PANEL
FRONT BUMPER
CENTERLINE OF VALANCE PANEL
3 1/32 DIA. HOLE

15-24 LBS FT
20-30 LBS IN.

VIEW A

FRONT BUMPER GUARD.
The following parts are assembled the same as produced.

- 3921841: Grille-Center
- 3921842: Grille-Lower
- 3888143: Valance Panel
- 3903463: Catch ASM-Hood Lock
- 3905585: Cap ASM-Horn
- 383636: Flasher ASM

With position, lettering on Z must be perpendicular to ground.
ASSEMBLY INSTRUCTIONS
3891775 “F” CAR 12000 SERIES

1 9419912 NUT
2 3899800 GASKET-INNER
3 3899801 GASKET-OUTER
4 911479-80 LAMP ASM L. & R.H.

GROMMET

1) 35-50 lbs in

CHEVROLET MOTOR DIVISION, GMC

RALLY SPORT-
BACK UP LAMP

Z 22

B 3

UPC

DATE
SYN

DIVISION RECORD

AUTH. DR

M B
12000

DATE REL 3-1
**SUGGESTED RALLY SPORT HEADLAMP ASSEMBLY PROCEDURE**

**A. Headlamp Housing Sub-Assembly**
1. Housing assembly (A)
2. Motor assembly (B)
3. Hinge (C)
4. Plate assembly (D)
5. Headlamp assembly (E)
6. Limit Switch assembly-Outboard (F)

**B. Headlamp Housing Assembly**
1. Drive Outboard attachments to fender
2. Loose assemble inboard attachments and shim (G) (if required) to radiator support to maintain a parallel line of plate (D) to center grille at outboard edge.
3. Drive inboard attachments

**C. Inboard Limit Switch Assembly (H)**
1. Attach to radiator support

**D. Aim Headlamps (E)**

**E. Bezel Assembly (J)**
1. Drive outboard attachments
2. Drive inboard attachments

**F. Headlamp Door Cover Assembly**
1. Sub-Assemble molding (K) to cover (L)
2. Loose assemble cover to plate. Adjust cover so there is .04 to .170 gap between cover and bezel.
3. Drive attachments

**CAUTION** This gap must be maintained to provide assurance that the limit switch (F) in closed position has turned off motor (B).

---

**DIAGRAM**

- **(A) HINGE**
- **(B) PLATE**
- **(C) COVER**
- **(D) MOLDING**
- **(E) HEADLAMP**
- **(F) MOTOR**
- **(G) SHIM**
- **(H) LIMIT SWITCH INBOARD**
- **(I) LIMIT SWITCH OUTBOARD**
- **(K) MOLDING**
- **(L) COVER**
- **CENTER GRILLE**
- **RADIATOR SUPPORT**
- **HOUSING (A)**
- **FENDER**
- **BEZEL (J)**

---

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Prod attaching part.

1. 3906179 SWITCH ASM
2. 138479 L. WASHER
3. 456887 SCREW
4. 423582 SCREW
5. 134530 NUT

8. 131014 L. WASHER
9. 3916733-4 BRACKET L & RH
10. 3906175-6 BRACKET ASM L & RH

Attach before voltage regulator.

NOTE: Position bracket edge against both dimples before tightening.

Prod horns relocated.

20-30 LBS IN.
10-15 LBS IN.
ASSEMBLY INSTRUCTIONS
3891775 "F" CAR 12000 SERIES

BRACKET ASM 3909542
SCREW 3855554
HARNESS ASM-12300-500 6292096
HARNESS ASM-12400-600 EXC RPO U17 6292097
HARNESS ASM-12400-600 & RPO U17 6292098
BREAKER ASM-CRC 4749164
NUT 120614
SCREW 9419303
SCREW 9430415
RELAY ASM 1115858
CLIP 3833478

75-95 LBS IN
20-30 LBS IN

7
6
5
4
3
2
1

TO LIMIT SW
TO LIMIT SW

TO PARKING LAMP
TO RECL SOLE LP MOTOR
TO HEADLAMP
ROUTE LIMIT SWITCH WIRES OVER HOUSING ASM

ALLY SPORT-RETRACTABLE HEADLAMP WIRING & MTR RELAY

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<tr>
<th>UPN</th>
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<th>DIVISION RECORD</th>
<th>AUTL</th>
<th>DR</th>
<th>CK</th>
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DATE
REF: Prod W6 L-77753 L-
DATE REV 3-1/05 L-

427
1. 6291830 WIRE ASM-EXT
2. 2977253 CONNECTOR
3. 3724851 TAPE-Approx. 12 in.-Tape to inst. panel harness (3) places.

- Note: Remove brown wire from ignition switch.
- Tape close to connector to prevent rattling.
- Remove light blue wire from light switch.

- To IGNITION SWITCH
- Dash Panel
- Fuse Panel ASM
- Loop & Tape
- Headlamp-Wiring to IGN. & LT. SW.

---

**CHEVROLET MOTOR DIVISION, GMC**

**RALLY SPORT-RETRACTABLE HEADLAMP-WIRING TO IGN. & LT. SW.**

**UPC**

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<td>1/15/66</td>
<td>WAS LT BLUE WIRE</td>
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**DATE: 6-26**

**REF: ECR 7911/L**

**SHEET: 428**
3899036 TRIM PLATE
3888679 TRIM PLATE

5. Bend tabs down securely 100° to 110°.
ASSEMBLY INSTRUCTIONS

3891775 "F" CAR 12000 SERIES

A1 CONTENTS
A2 NON-ILLUSTRATED PARTS
A3 GENERATOR & ACCELERATOR LINKAGE
A4 CARB, CHOKE & FUEL LINES
A5 AIR CLEANER & CLOSED POSIT. VENT.

NOTE The following items are listed in UPC "O" miscellaneous shipping list.
SPL. EXHAUST
PLENUM AIR
SPECIAL EXHAUST WITH PLENUM AIR
TRANSISTORIZED IGNITION

+ 3916355 ENGINE ASM (AS SHIPPED)
NOTE: The following components are not illustrated in this R. P. O. See Parts List or Bill of Material for part numbers.

UPC 3 FRONT SUSPENSION
3A FRONT SUSPENSION-ASM STRG KNU UPR CONTROL ARM BALL STUD & SEAL
3C FRONT SPRING-Assemblies same as prod & RPO F41
3F FRONT SHOCK ABSORBER ASM-

UPC 4 REAR SUSPENSION
4A REAR AXLE STD & POSITRACTION-Assemblies same as RPO G80.
4B REAR SPRING-Assemblies same as prod & RPO F41
4D ROD ASM RR AXLE RADIUS-Assemblies same as RPO L78
4E REAR SHOCK ABSORBER ASM-

UPC 5 BRAKES
5 BRAKES-Assemblies same as RPO J50 & J65

UPC 6 ENGINE
6C2 TORSIONAL DAMPER-Assemble same as RPO L48
6K1 FAN & DRIVE-Assemble same as RPO K02
6K2 HOSE RAD.-
6L VAC. FITTING-Assemble same as RPO J50
6M FUEL PUMP- 
6Y2 GENERATOR & REGULATOR-
6Y4 COIL ASM-IGN. SPK PLUG WIRING-

UPC 7 TRANSMISSION
7A TRANSMISSION EXTERNAL CONTROLS-Assembles same as RPO L48

UPC 8 FUEL & EXHAUST
8A METER ASM-
8B PIPE GAS FEED-
8C EXHAUST PIPE MUFFLER & TAIL PIPE ASSEMBLES-same as RPO N10 & N61 except without resonators

UPC 9 STEERING
9A GEAR ASM-

UPC 10 WHEEL & TIRES
10B COVER-WHEEL TRIM & TIRES-

UPC 12 ELECTRICAL
12A BATTERY-STORAGE-
12J INSTRUMENT CARRIER PANEL AND/OR INSTRUMENTS-Assembles same as RPO L48

UPC 13 RADIATOR & GRILLE
13A BODY ASM., RAD-

Assembles same as production. See Parts List or Bill of Materials for part number.
ASSEMBLY INSTRUCTIONS

3891775 “F” CAR 12000 SERIES

1  3916143  CARBURETOR ASM
2  3886152  PIPE ASM.
3  3881847  GASKET
4  3916376  PIPE ASM.
5  3886153  TEE
6  3813024  HOSE
7  7005165  CLIP
8  3785770  HOSE
9  3911066  PIPE-SPARK
10  3917614  AUTO-CHOKE ASM.

PROD SCREW

PROD NUTS

120 - 165 LBS IN
100 - 125 LBS IN

SPECIAL COUPE EQUIP. (302 CU. IN.)
CARBURETOR, CHOKE & FUEL LINES

Z28

A4

UPC  DATE  SYM  REVISION RECORD  AUTH  DR  CR
Z28  11/34/67  I  WAS 3916277 CARB ASM  84727-A4

12437-637

DWG 10-12  LS  REF:ECR825386 L-84224 L-
DATE REL 11-9  OF  L-  L-  L-

434
ASSEMBLY INSTRUCTIONS

3891775 "F" CAR 12000 SERIES

1. 219281 NUT
2. 6423907 AIR CLEANER
3. 3916390 STICKER-IDENT
4. 3886085 GASKET
5. 3873852 STUD
6. 3882864 CAP ASM
7. 3893316 TUBE ASM
8. 6422294 VALVE ASM
9. 3829058 CLAMP
10. 3916339 HOSE
11. PROD PARTS
12. 3900474 TUBE ASM
13. 2977555 RETAINER

L.WASHER
GASKET

• Chrome Motor Division, GM-C

SPECIAL COUPE EQUIP. (302 CU. IN.)
AIR CLEANER & CLOSED POSIT. VENT

UPC: Z28
A5

NOTE: Air cleaner stud to be installed with tapered end up.

15 - 20 LBS IN
100 - 125 LBS IN
39 - 49 LBS IN
20 - 30 LBS IN

1/35
STICKER - Remove paper backing

CANCELED

EXISTING HOLES

PEAK LINE

EXISTING HOLE

E 62 REF

OF STICKER

SPECIAL COUPE EQUIP. (302 CU. IN.)
FRONT FENDER STICKER

Z28

A6
NOTE: Painted area on extension to be between points "A" & "B"