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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INTRODUCTION

THIS 1968 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 IT IS IMPERATIVE THAT ADDITIONS AND REVISIONS BE INSERTED IN THEIR PROPER PLACES IMMEDIATELY AND THAT SUPERSEDED SHEETS BE REMOVED.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 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.
MODELS

SHEETS DESIGNATED 12000 REPRESENT ALL MODELS RELEASED FOR PRODUCTION

SYMBOLS

1 INDICATES CROSS REFERENCING OF PART NUMBERS OR NOTES.

△ INDICATES TORQUE.

1 INDICATES A REVISION

1 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.

INDICATES RELATED SHEETS THAT CONTAIN INFORMATION REQUIRED TO COMPLETE A CERTAIN INSTALLATION. THIS IS NOTED ABOVE THE SHEET NUMBER.
ASSEMBLY INSTRUCTIONS

QUANTITY

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

MISCELLANEOUS

SHIPPING 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 SPRINGS ARE LISTED IN UPC 0, SHOWN IN UPC 3, FRONT SUSPENSION & UPC 4, REAR SUSPENSION.

ALL SHOCK ABSORBERS ARE LISTED & SHOWN IN UPC 3, FRONT SUSPENSION & UPC 4, REAR SUSPENSION.

---

**CHEVROLET MOTOR DIVISION, GMC**

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*NOTE: All parts and specifications are subject to change without notice.*
GENERAL INSTRUCTIONS

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

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

NOTE Rivet attachment between plastic & metal must be upset on metal side.

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

NOTE Lock washer must be positioned as shown to insure a proper ground.
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.

**HOSE CLAMP SHOULDERS TO .06 MAX GAP**

On hose clamp installations, where nipples 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.

**HOSE SHOULDERS TO .03 MAX GAP**

On all exhaust pipe clamp installations locate centerline of clamp to end of slot in exhaust pipe as follows.

**GENERAL INSTRUCTIONS**

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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.

HEADER TOOL & NUT PERPENDICULAR TO PANEL FOR UPSET

UNDERSIDE OF NUT HEAD MUST BE FLUSH TO PANEL FOR COMPLETE 360° CONTACT WITH PANEL UPSET SHANK

HEADER TOOL PULL UP STUD TO EXTEND THRU NUT PRIOR TO UPSET TO AVOID DEFORMED OR STRIPPED THREADS.

RIVNUT TYPE PART INSTALLATION
ASSEMBLY INSTRUCTIONS

1968 CAMARO 12000 SERIES

STAPLING

WIRE DRAW = 2C + 2T

FIGURE 1

C - CROWN SIZE
T - THICKNESS OF WORK

WIRE DRAW = C + 2T - 3/8

FIGURE 2

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

STAPLING INSTRUCTIONS

12000

DATE SYM REVISION RECORD AUTH DR CR

UPC

0

A7

REF: 47

DATE REL 5 28 68

SHEET 5
ASSEMBLY INSTRUCTIONS

1. UPC 1
   A. .147/.151 DIA. 1 hole L-6 at existing dimple.

2. UPC 6
   A. .185 DIA. hole at existing dimple
   B. .50 ± .02 DIA. hole at existing dimple

3. RPO C48
   A. .141/.144 DIA. -3 holes use cover 2823111 as template
   B. .141/.144 DIA. -6 holes at existing dimples
   C. .38 DIA. -1 hole at existing dimple
   D. .38 DIA. -1 hole

CHEVROLET MOTOR DIVISION, GMAC

COWL & DASH PANEL HOLE PIERCING

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DGW 3-18-67 | REF: PROJ. | L-81609 | L |
DATE REL. 5-24 | L- | L- | L- |
X SHEET
ASSEMBLY INSTRUCTIONS

3918855

1968 CAMARO 12000 SERIES

1 RPO C06
   A. .125/.129 DIA. -2 holes at existing dimples

2 RPO K30
   A. .185/.189 DIA. -3 holes
   B. 1.00 DIA. -1 hole

3 RPO M20
   A. 1.00 DIA. -hole at existing dimple
   B. .326/.340 DIA. -2 holes at existing dimples
   C. .920/.940 DIA. -hole at existing dimple

4 RPO U63
   A. .185/.189 DIA. -2 holes V-8 at existing dimples
   B. .185/.189 DIA. -1 hole L-6 at existing dimple

5 RPO U17
   A. .50 + .000/.010 Dia. hole at existing dimple.

6 RPO Z22
   A. 1.00 DIA. hole at existing dimple
# Spring Release Chart

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* 4.10, 4.56, 4.88 Axle Ratios Only

---

## Assembly Instructions

**3918855 1968 Camaro 12000 Series**

**Spring Release Chart**

**Chevrolet Motor Division, GMC**

**UPC**

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**Date of Issue:**

- 01/07/68
- 01/17/68
- 01/27/68

**Revision Record:**

- A9
- A9
- A9

**Author:**

- CB
- CB
- CB

**Date of Revision:**

- 01/07/68
- 01/17/68
- 01/27/68

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**Date of Approval:**

- 01/07/68
- 01/17/68
- 01/27/68

**Drawing Number:**

- 510-67
- 510-67
- 510-67

**Ref. Proc.:**

- L-
- L-
- L-

**SHEET:**

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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 - 24LBS FRONT & 24 LBS 2 REAR
# Assembly Instructions

1968 Camaro 12000 Series

## Trim Heights RPO Variables

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**Ref**: Prel.

**Date Rel.**: 5:24 C0

**Sheets**: 1

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**TRIM HEIGHTS RPO VARIABLES**

**UPC**: 0

**DATE SYN**: 7/7/67

**REVISION RECORD**: REDRAWN & REDESIGNED

**AUTH**: 9/1/67

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**TRIM HEIGHTS RPO VARIABLES**

**UPC**: 0

**DATE SYN**: 7/7/67

**REVISION RECORD**: REDRAWN & REDESIGNED

**AUTH**: 9/1/67
# ASSEMBLY INSTRUCTIONS

## 1968 CAMARO 12000 SERIES

### 3918855

**CHEVROLET MOTOR DIVISION, GM**

**TRIM HEIGHTS L-6 ENGINE**

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## 16
# Assembly Instructions

## 1968 Camaro 12000 Series

### ASSEMBLY INSTRUCTIONS

**Model:** 12447  
**Option:** E  
**Std. Tires:** 6.70x14

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*4.10, 4.56, 4.88: AXLE RATIOS ONLY*

**TRIM HEIGHTS 302-350 V-8 ENGINE**

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** CHEVROLET MOTOR DIVISION, GMC **
## ASSEMBLY INSTRUCTIONS

### 1968 CAMARO 12000 SERIES

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</table>
ASSEMBLY INSTRUCTIONS

1968 CAMARO 12000 SERIES

3918855

1. ADHESIVE .00375 GAL.

2. 3934877 STICKER-TIRE PRESSURE CHART
   [NOTE] Surface must be clean. Locate as shown using gummed back to adhere.

3. 3927740 CHART-Exhaust emission engine tune up.
   [NOTE] Tune-up sticker must be readable from front of vehicle.

4. Position so that label may be read from right side of vehicle.

5. View B

6. View A

7. PRICE LABEL LOCATION
   Position label on rear quarter door window with label maintaining vertical position.

LABEL-S & STICKERS

12000

WAS 3909821 CHART
ITEM 5 ADDED
VIEW B ADDED
VIEW B REVISION 4, ADDED
LABEL DWG LOCATION REV.
LABEL NOTE REVISED

20
3918855 1968 CAMARO 12000 SERIES

VIN Sequential Serial Number
Assembly Plant Designation
Model Year
Division Identification Number

ENGINE & TRANSMISSION VEHICLE IDENTIFICATION NUMBER SPECS.
(For location see engine & transmission UPC or RPO)

INSTRUMENT PANEL

.046 DIA. HOLES 6 X 3 GROUPS
V.L.N. (See above for specs.)

DATE MILEAGE

OWNERS PROTECTION PLAN BOOKLET PERFORATING
(See UPC 0, Sheet C1 for Part No.)
PLATE
After plate is stamped, attach to adhesive backed portion of last page in owners protection plan booklet.

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.

LOCATION | DATA TO BE STAMPED
---|---
*A-1 | TRIM CODE
*A-5 | PAINT CODE (LEAVE BLANK IF F & SO, COPO OR PRIME PAINT IS SPECIFIED)
A-15 | VEHICLE SERIAL NUMBER
***A-29 | CARBURETOR SOURCE
B-1 | ENGINE SOURCE, DATE & TYPE CODE
B-15 | REAR AXLE TYPE, DATE & SOURCE CODE
#B-29 | MONTH PRODUCED
***C-1 | CHEVROLET MANUFACTURED; USE SOURCE AND DATE, HYDRA-MATIC; USE CODING STAMPED ON UNIT PLATE EXCEPT THAT THE LARGE "C" PREFIX AND THE LARGE SINGLE ALPHA SUFFIX ARE TO BE DROPPED, WARNER GEAR; USE CODE "W" ONLY, WITH NO DATE CODE.
*C-15 | POWER BRAKE AND/OR STEERING CODE
*C-17 | RADIO CODE
*C-18 | DISC BRAKE
*C-19 | AIR CONDITIONING CODE
*C-20 | POWER WINDOW CODE
*C-29 | CHEVROLET "BOW TIE" SYMBOL

*Obtain plate entries from Model Option Codes shown in the Data Systems Standards Manual No. 5. For other plate details see DSSM No. 6.
## ASSEMBLY INSTRUCTIONS

### 1968 CAMARO 12000 SERIES

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<td>BOOKLET FOLDING TOP</td>
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**MISCELLANEOUS SHIPPING LIST**

- Place in instrument panel compartment.
- Place in luggage compartment.
- Furnished by Fisher Body within each body.
NOT El Remove existing headrest.
Install front seat protector cover &
cut 1-1/2 inch slit in cover at each
escutcheon. Reinstall head rests.

NOTE Used in vehicles with carpeting only.
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<th>PART</th>
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<tr>
<td>9985164 LUBRICANT-GREASE</td>
<td>CLUTCH PEDAL PUSH RODS-BOTH ENDS, PEDAL SHAFT, &amp; PULL BACK SPRING</td>
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<tr>
<td>1A</td>
<td>TRANS CONTROL LEVER-BALL &amp; FULCRUM</td>
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<tr>
<td>1B</td>
<td>BRAKE PEDAL BUSHING, SHAFT OR PINS</td>
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<td>1C</td>
<td>BRAKE PEDAL HUB</td>
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<td>1D</td>
<td>REAR CABLE AT EQUALIZER</td>
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<tr>
<td>1E</td>
<td>BRUSH LIGHTLY ON O.D. OF PINS &amp; CONNECTING LEVER ASSEMBLIES TO PUSH ROD &amp; CYL ASM</td>
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<td>1F</td>
<td>ASH TRAY RETAINER-BOTH SIDES</td>
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<td>1G</td>
<td>CLUTCH FORK PULL BACK SPRING &amp; EXTENSION-ALL CONTACT POINTS</td>
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<td>1H</td>
<td>HOOD LOCK BOLT</td>
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<td>HOOD BUMPERS (AT FENDER OPENING, APPLIED TO THE SURFACE WHICH CONTACTS THE HOOD FLANGE)</td>
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<td>TRANS CONTROL RODS-BOTH ENDS</td>
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<td>TRANS PARKING LOCK &amp; RANGE SELECTOR LEVER, CROSS SHAFT &amp; PIN</td>
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<td>TRANS THROTTLE VALVE CONTROL RODS</td>
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<td>TRANS CONTROL IDLER LEVER BEARING SURFACES</td>
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<td>SHIFTER TANG OF CONTROL LEVER</td>
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<td>1O</td>
<td>AIR OUTLET TO PLENUM DUCT</td>
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**ASSEMBLY INSTRUCTIONS**

**PART 1968 CAMARO 12000 SERIES**

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<td>CLUTCH LINKAGE STUD SEAT &amp; SEAL</td>
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<td>CLUTCH RELEASE BEARING COLLAR-COAT O.D. GROOVE LIGHTLY &amp; FILL I.D. GROOVE</td>
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<td>9985005</td>
<td>LUBRICANT- SOAP-DILUTE 3 TO ASSEMBLE TIRE &amp; VALVE STEM TO RIM &amp; FOR MISC. APPLICATIONS TO FACILATE ASM.</td>
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<td>FLUID-SYN TRANS 4 TO ASSEMBLE TIRE &amp; VALVE STEM TO RIM &amp; FOR MISC. APPLICATIONS TO FACILATE ASM.</td>
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<td>TRANS 3-4 SPEED THRU HOLE IN CASE</td>
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<td>TRANS EXT BUSHING BEFORE INSTALLING PROP SHAFT YOKE</td>
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<td>LUBRICANT- HYPOID</td>
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<td>SOAK WASHER FOR BATTERY POSITIVE TERMINAL</td>
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<td>REAR AXLE THRU FILLER PLUG HOLE IN HOUSING</td>
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<td>TRANS - THRU FILLER PLUG IN HOUSING</td>
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<td>LUBRICANT- HYPOID POSTTRACTION</td>
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<td>REAR AXLE THRU FILLER HOLE IN HOUSING</td>
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**REVISION RECORD**

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- USAGE 3 REMOVED
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<td>PROP. SHAFT YOKE TRANS END ON INSIDE AND OUTSIDE</td>
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<td>9985006</td>
<td>COAT &quot;O&quot; RING SEAL AT A/C COMPRESSOR FITTING ASM</td>
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<td>THRU FILLER HOLE IN VALVE ROCKER COVER L-6</td>
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<td>TRANS-THRU FILLER NECK ON RIGHT SIDE</td>
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<td>STEERING RELAY &amp; TIE ROD ASM 7-FITTINGS</td>
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<td>FUEL PUMP PUSH ROD LUBE-APPROX (1) INCH ON CAMSHAFT END V-8 ENGINE</td>
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**ASSEMBLY INSTRUCTIONS**

**3918855**

**1968 CAMARO 12000 SERIES**

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<td>OIL-RUST PROOFING - DILUTE WITH 9 PARTS WATER</td>
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<td>13 ▶ SPRAY ENG COMPT &amp; ALL PARTS AFTER FINAL ASM, EXCEPT UNDER SURFACE OF HOOD</td>
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<td>9985164</td>
<td>LUBRICANT - GREASE</td>
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<td>14 ▶ HEAD LAMP AIMING PADS</td>
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<td>14A ▶ USED TO LUB TRANS CONTROL RODS &amp; SWIVELS</td>
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<td>14B ▶ BETWEEN SUPPORT &amp; TRANS. CONTROL SHIFTER LEVER RETAINER AT CENTER PIVOT</td>
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<td>14C ▶ ATTACHING SURFACES OF INSTRUMENT CLUSTER 7 PLACES</td>
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<td>14D ▶ CARBURETOR BALL STUD BEFORE INSTALLING THE &quot;SNAP ON&quot; ACCELERATOR CABLE</td>
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<td>9985196</td>
<td>RUST PREVENTIVE</td>
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<td>15 ▶ SPRAY OR BRUSH ON EACH BATTERY TERMINAL AFTER CABLE HAS BEEN ATTACHED</td>
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**CHEVROLET MOTOR DIVISION, GM**

**LUBRICATION**

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**DWG 6-19-67**

**REF. D4**

**DATE REL. 6-16 C1**

**29**
### ASSEMBLY INSTRUCTIONS

**PART** | **USAGE** | **UPC**
--- | --- | ---
9981098 ADHESIVE-NEOPRENE SOLVENT | 50 ➔ STEERING COLUMN COVER TO DASH PANEL | 9
 | 50A ➔ SEAL TO PLENUM PLATE | C60
 | 50B ➔ FRONT SEAL TO PLENUM VALVE PLATE | 50C ➔ REAR SEAL TO PLENUM VALVE PLATE | L35
 | 50D ➔ HEATER ASM SEAL TO DASH PANEL | C60
 | 50E ➔ GASKET TO SELECTOR | C60
 | 50F ➔ SEAL TO CORE PIPE HOLES | 50G ➔ GASKET TO DUCT ASM. | 50H ➔ COWL TOP VENT GRILLE SEAL | 50J ➔ CLUTCH HOLE PEDAL COVER TO SEAL | M35
 | 50K ➔ SEAL TO EVAPORATOR & BLOWER | 50L ➔ HEADLAMP RETRACTABLE COVER BUMPER TO COVER | Z22

**PART** | **USAGE** | **UPC**
--- | --- | ---
9985059 SEALER-BLACK PUMPABLE | 51 ➔ BETWEEN BLOWER & EVAPORATOR ASM & DASH PANEL | C60
 | 51A ➔ BETWEEN BLOWER INLET ASM & DASH PANEL | 1
 | 51B ➔ SEAL JOINT OF RADIO ANTENNA LEAD IN CABLE BOOT | U63

---

**CEMENTS & SEALERS**

**D5**

**DOWG 6-14-67**

**DATE** | **D5**
--- | ---
12000 | --

**REV**

**DATE**

**D5**

**REV**
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<td>9985020 SEALER-GREASE BASE</td>
<td>USED TO SEAL EXHAUST PIPE CLAMP JOINTS</td>
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<tr>
<td>9985105 ADHESIVE-RUBBER &amp; WATER BASE</td>
<td>USED TO ADHERE CAUTION STICKER TO REAR COMPARTMENT LID ON SEDANS OR TO REAR QTR. PANEL ON WAGONS</td>
<td>G80</td>
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<tr>
<td>3840733 CEMENT-PLASTIC SEAM</td>
<td>WINDSHIELD WASHER SPRAY NOZZLE ATTACHMENT</td>
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<td>54A USED TO SEAL DIMMER SWITCH ASM SCREW</td>
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<tr>
<td>3857962 ADHESIVE</td>
<td>USED TO ATTACH GAS TANK ANTI-SQUEAK</td>
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<td>55A USED TO ATTACH GAS TANK INSULATOR</td>
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<td>3399878 CEMENT-PLASTIC SEAM</td>
<td>USED TO CEMENT CAR HEATER LWR HOLE COVER</td>
<td>C48</td>
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<tr>
<td>9981041 SEALER-COMPOUND</td>
<td>USED TO SEAL CAR HEATER UPPER HOLE COVER</td>
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<td>9980664 SEALER</td>
<td>TO SEAL CLUTCH HOLD SEAL</td>
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<td>TO SEAL PARK, BRAKE HOLES IN DASH</td>
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<td>TO SEAL SPEEDO CABLE GROMMET IN DASH</td>
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<td>TO SEAL FUSE PANEL ASM TO DASH</td>
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<td>TO BE PLACED IN WINDSHIELD WASHER JAR</td>
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<td>9985037 GASOLINE</td>
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<td>9985012 ANTI FREEZE (ETHYLENE GLYCOL)</td>
<td>COOLING SYSTEM—For engine cooling system capacities, refer to chart 3909888</td>
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<tr>
<td>9985168 WAX-LIQUID</td>
<td>COAT ALL EXTERIOR HORIZ PAINTED SURFACES</td>
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<td>1163105 INSULATOR COMPOUND-SEALING</td>
<td>PLACE (1) CAPSULE OR (2) PELLETS IN RADIATOR FILLER NECK</td>
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<td>9985040 OPT.</td>
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</table>
20-30 LBS. IN.
45-60 LBS. IN.
30-45 LBS. IN.

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

1968 CAMARO 12000 SERIES

1 3798372 CAP
2 3840083 JAR
3 9420415 SCREW
4 90°

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

15 - 20 LBS. IN.

WINDSHIELD WASHER JAR

CHEVROLET MOTOR DIVISION, GMC

UPC: 12000

DRAWN 5-22-67 AN REF: Proj. A4 L-78901 L-78901
DATE RCL 5-24 C1 L- L- L-

FULL SHEET
1968 CAMARO 12000 SERIES

HOSE - L.H.
SCREW
NOZZLE ASM
RETAINER

HOSE - JAR to pump
CEMENT - Approx. 4 in.
HOSE - R.H.

WATER STREAM &
TARGET AREA

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

VENT GRILLE

ENG. WIRING HARNESS (UPC 12)

W/S WIPER MOTOR & PUMP ASM

10-15 LBS. IN.
W/S WASHER JAR

HOSE ROUTING

* CHEVROLET MOTOR DIVISION, GMC *

WINDSHIELD WASHER NOZZLE & HOSE ROUTING

12000

UPC 1

DATE SYM DEPARTMENT RECORD AUTH. DR CK

2/348 WASH. ITEM & RETAINER 92756 ACA

3 ITEM 4 RELOCATED

4 VIEW B ADDED

1 SHEET
COMPARTMENT ASM. 1968 CAMARO 12000 SERIES

1 1 3891671 COMPARTMENT ASM. 5 3898178 HINGE ASM.
2 2 3891672 STRIKER 6 9423518 NUT - U
3 3 3765243 BUMPER 7 9985028 STAPLE - 10 REQ'D
4 4 9421851 SCREW 8 9420721 SCREW

△ 10-15 LBS. IN.
△ 25-35 LBS. IN.

INSTRUMENT PANEL COMPARTMENT 1 1 3891671 COMPARTMENT ADDED - 11-1-67
12000 2 3391672 STRIKER ADDED - 11-1-67

CHEVROLET MOTOR DIVISION, GMC

41
SET SCREW (Part of asm.) with switch in "OFF" position, screw must be at bottom in vertical position.

MUST BE FLUSH ± .04

.06 ± .04 CONSTANT AROUND PERIMETER
ASSEMBLY INSTRUCTIONS
1968 CAMARO 12000 SERIES

1 9425111, SCREW
2 3893846 RETAINER
3 3927455 BUMPER
4 3893845 COVER-RADIO

5 3919123 ASH TRAY ASM
6 9419327 SCREW
7 3891674 RETAINER ASM
8 IG GREASE .001 LBS.

• CHEVROLET MOTOR DIVISION, GMC

ASH TRAY & RADIO CONTROL HOLE COVER
12000

UPC

DATE 7-23-67
REF. B4
L-19600 L-

43
ASSEMBLY INSTRUCTIONS

1968 CAMARO 12000 SERIES

1. 565542 SCREW
2. 565801 BUSHING
3. 916177 MIRROR ASM
4. 3893822 RETAINER
5. 3891655 TRIM PLATE
6. 9419327 SCREW
7. 3899895 COVER (INNER)
8. 9427208 SCREW ASM
9. 3899897 COVER (OUTER)
10. Assembly clearance of .06/.12 between top forward edge & instrument cluster asm (ref UPC 12)

NOTE: Attach outboard screws before center screw.

NOTE: Short end to top of car with ball stud arm positioned as shown.

TAPE approx. 18 inches 2 pcs 9 inches long

UPC 3839835

TAPE approx. 18 inches 2 pcs 9 inches long

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

NOTE: Short end to top of car with ball stud arm positioned as shown.

NOTE: Attach outboard screws before center screw.

TAPE approx. 18 inches 2 pcs 9 inches long

Assembly clearance of .06/.12 between top forward edge & instrument cluster asm (ref UPC 12)
1. **.141 ± 000/.004 hole (1)** place each side in quarter panel & (4) places each side in rocker panel.

2. **.120 ± 1/64 hole (1)** place each side use 4 as a template.

3. **.120 ± 1/64 hole (1)** place each side. Use 3 as a template.

4. **10-15 LBS. MIN.**
OUTSIDE REAR VIEW MIRROR

10-15 LBS. IN.
0-18 LBS. IN.

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

1968 CAMARO 12000 SERIES

1. 9416208 SCREW
   PART FURNISHED BY FISHER BODY & INSTALLED BY CHEVROLET.

2. 7644760 PLATE

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

TUCK UNDER DASH MAT

PARKING BRAKE CABLE

DIMMER SWITCH

ALL FLOOR SHIFTS (EXCEPT CONSOLE)

PROTECTIVE COVER (SEE UPC O)

15-20 LBS IN.
3909919-20 DAMPENER ASM FRT. L. & R.H.
9419301 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.
65 CEMENT 15 PCS.

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

BODY DAMPENER ASSEMBLIES
12000 (CONVERTIBLE)
FLOOR PANEL REINFORCEMENT

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ASSEMBLY INSTRUCTIONS

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

NOTE Typical section cushion asm. to cushion.

BODY MOUNTINGS

1 3918855 1968 CAMARO 12000 SERIES

1 3914816 BOLT
2 3914814 SPL. WASHER
3 3893159 CUSHION
4 1305797 P. WASHER
5 103329 L. WASHER
6 9418828 NUT
7 9425568 NUT-PUSH
8 3893156 CUSHION ASM
9 3928380 CUSHION ASM
10 3914802 CUSHION
11 3901365 P. WASHER
12 3912533 BOLT
13 3901361 CUSHION ASM
14 Residual torque after roll test to be 60 lbs. ft. minimum.
15 3914049 WASHER-SPL. SPRING

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

CAGE NUT

FRAME

RADIATOR SUPPORT SEE UPC 11-13

NO. 3 MTG

192 MTG

30-40 LBS. FT.

75-95 LBS. FT.

BODY MOUNTINGS

MOD 12000

D1

SECTION Dwg REvised

DATE 5-24-67 AM Ref. D1 L-80267 L-

NOTE 7 retention 1 2 3 & 8 to radiator support prior to assembly to frame.

CAGE NUT

CUSHION ASM

CUSHION

SPRING WASHER

(WHEN USED)
1968 CAMARO 12000 SERIES

INSTRUMENT PANEL

CENTER VENT PANEL

PLUMM PANEL

INSTRUMENT PANEL

VIEW A

VIEW B

VIEW C

NOTE: Bottom out nut on outside of duct when flat of rod is bottomed on inside of duct.

10-15 LBS. IN.
L.H. SIDE

HIGH LEVEL VENTILATION SYSTEM

12000

UPC

DATE
SYN
REVISION RECORD
AUTH.
REV

M1

1

5-68
13
2

13174571-2 DUCT

9/1222 REV

13

13174571-2 DUCT

9/1222 REV

13

13174571-2 DUCT

9/1222 REV

13

13

13

13174571-2 DUCT

9/1222 REV

13

13174571-2 DUCT

9/1222 REV

13

13174571-2 DUCT

9/1222 REV

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13174571-2 DUCT

9/1222 REV

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13174571-2 DUCT

9/1222 REV

13

13174571-2 DUCT

9/1222 REV

13

13174571-2 DUCT

9/1222 REV

13

13174571-2 DUCT

9/1222 REV

13
ASSEMBLY INSTRUCTIONS

1968 CAMARO 12000 SERIES

3918855

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<td>HEATER &amp; DEFROSTER ASM. 3016907</td>
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<td>SPL. WASHER 3868702</td>
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<td>8</td>
<td>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.</td>
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<tr>
<td>10</td>
<td>SEALER, 3.0 OZ. 67G</td>
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NOTE: At time of application, sealer bead must be .38 dia. minimum - measured perpendicular to flange.

ENG. WIRING HARN. UPC 12
LOCATING HOLE
7-12 LBS. IN.
25-35 LBS. IN.

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.

SEALER, 3.0 OZ.
ASSEMBLY INSTRUCTIONS

3918855

OUTLET ASM. DEF.
3925711

DUCT ASM.
3917382

SCREW
9427326

SCREW
3863392

WASHER
9419892

SCREW
3919089

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

HEATER DEFROSTER DUCT OUTLETS

12000

M3

53
NOTE: Attach upper L.H. screw first to locate 4 in instrument panel.
ASSEMBLY INSTRUCTIONS
1968 CAMARO 12000 SERIES

CABLE ASSEMBLY SEQUENCE

1. Attach 1 to control asm. (see sht. M5).
2. Place control temperature lever in "off" position.
3. Attach opposite loop of 1 to selector duct temperature lever pin.
4. Push sheath toward heater lever until valve seats & lash is out of cable & control (approx. 5 lbs.).
5. Tighten 7 to secure cable.

HEATER CONTROL CABLES

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### Assembly Instructions

**1968 Camaro 12000 Series**

**Part Number:** 3939739

**Frame Assembly**

**NOTE:** At body drop use .610 - .002 dia. pins at locations shown on L. & R.H. side.

---

**Table:**

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**UPC:** 728471053356

**Chevrolet Motor Division, GMC**
ASSEMBLY INSTRUCTIONS

SHEET TITLE

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

NOTE: For springs & vehicle heights see UPC Q.
3

NOTE With hub and drum attached and springs in position, tighten lower control arm attaching nuts to specified torque with vehicle weight on the lower control arm assemblies.

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

NOTE Frame pocket may be expanded, to accept the front lower control arm, when interference exists on qualified parts.

45-55 LBS. FT.
70-90 LBS. FT.
100-140 LBS. IN.
**ASSEMBLY INSTRUCTIONS**

**1968 CAMARO 12000 SERIES**

1. **LUB FITTING**
2. **RIVET**
3. **STUD & SEAL ASM.**
4. **STRG KNU & FRT WHL HUB ASM L. & R.H.**
5. **NUT**
6. **C. PIN**

**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.**

**NUT-A torque of 125 lbs. ft. max. is permissible on nut when slot is in correct position for insertion of cotter pin.**

**WHEEL—UPC 10**

**LOWER CONTROL ARM ASM.**

**UPPER CONTROL ARM ASM.**

**COTTER PINS INSTALLATION**
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.

CHEVROLET MOTOR DIVISION, GMC

SHOCK ABSORBER & SPRING

UPC DATE STN. REVISION RECORD AUTH. DR Ck
3 7/13 GT 3/92826 WAS 392449 SHOCK 83540 6 31
A4 7/9265 L
12000 L-79685 L-

SHOCK ABSORBER & SPRING - See UPC 0
### ASSEMBLY INSTRUCTIONS

**1968 CAMARO 12000 SERIES**

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<td>3</td>
<td>3790333</td>
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<td>4</td>
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<td>381957</td>
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<td>3908373</td>
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**Diagram:**

- **Frame Side-Member**
- **Lower Control Arm**

**NOTE:** Mandatory that bolt be assembled from direction shown.

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## Assembly Instructions

### 1968 Camaro 12000 Series

#### Models

<table>
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<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° 14' ± 1&quot;</td>
<td>+0° 17' ± 0° 30'</td>
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<tr>
<td></td>
<td>CURB</td>
<td>+0° 30' ± 1&quot;</td>
<td>+0° 15' ± 0° 30'</td>
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#### Front Suspension Geometry

- **Caster Angle**: Positive Direction
- **Camber Angle**: Positive Direction
- **Wheel Toe-In**: X-Y

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<th>MODELS</th>
<th>TOTAL TOE-IN</th>
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<td>1/8 - 1/4</td>
<td>CURB &amp; AS SHIPPED</td>
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**Chevrolet Motor Division, GMC**

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**Drawing Information**

- **DWG**: 5-22-27
- **DATE**: 5-24-67
- **REF**: A6

---

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ASSEMBLY INSTRUCTIONS

3918855

1968 CAMARO 12000 SERIES

SHEET TITLE

A1 CONTENTS
A2 AXLE, PROP SHAFT & WHEEL NUT
B1 SPRING FRONT EYE & BRACKET
B2 SPRING-TO AXLE & SPRING-REAR SHACKLE
B3 SHOCK ABSORBER & BUMPER

NOTE For springs & vehicle heights see UPC 0.
AXLE, PROP SHAFT & WHEEL NUT

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

12-16 LBS FT
55-75 LBS FT
18-20 LBS FT

PROP SHAFT ASM.
NUT
L. WASHER
"U" BOLT
LUBRICANT-HYPOID 4.420 LBS.
FLUID-SYN TRANS.

ASSEMBLY INSTRUCTIONS
1968 CAMARO 12000 SERIES
ASSEMBLY INSTRUCTIONS

3918855

1968 CAMARO 12000 SERIES

1. 3892755 NUT ASM
2. 3892751-2 BRACKET L. & R.H.
3. 3831892 SCREW ASM
4. 9417614 NUT
5. 103329 L. WASHER
6. 415919 P. WASHER
7. 3892754 BOLT

MANDATORY SEQUENCE
A. Locate tab in slot to body
B. Drive screw to side rail for first attachment

RR. SPRING CHART
(See UPC 0)

SIDE RAIL

FLOOR PAN REINFORCEMENT

SLOT

A. TAB

NOTE: Install spring eye bolt with spring at approx. 4°.

COLOR CODE STRIPE

SPRING TO FRONT EYE & BRACKET

<table>
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<th>SPRING TO FRONT EYE &amp; BRACKET</th>
<th>UPC</th>
<th>DATE</th>
<th>REV</th>
<th>REVISION RECORD</th>
<th>AUTH</th>
<th>CTRL</th>
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</table>

CHEVROLET MOTOR DIVISION, GM
ASSEMBLY INSTRUCTIONS

1968 CAMARO 12000 SERIES

3918855

1. 3791381 CUSHION - UPPER
2. 3792585 CUSHION - LOWER
3. 3922570 PLATE L. & R. H.
4. 3901399 NUT
5. 3908370 BUSHING
6. 3830840 SHACKLE
7. 272876 NUT
8. 3830844 PIN - Must be assembled as shown.

NOTE: Tighten with vehicle weight on springs.

NOTE: Shackles & pins to be assembled in direction shown.

R.H. INSTALLATION

35-45 LBS. FT.
40-60 LBS. FT.

L.H. INSTALLATION

FORWARD OUTBOARD

CHEVROLET MOTOR DIVISION, GMC

SPRING TO AXLE & SPRING-REAR SHACKLE

12000

B2

UPC 4

DATE 82/7

REVISION RECORD 5922866 BUSHING 1202741C1

AUTH OR 1E

DWG PREL 3/5 LS REF: Prel 81 L84323 L-
DATE REF. 5/24 C1 L- L-84799 L-

X SHEET

67
**ASSEMBLY INSTRUCTIONS**

**3918855**  
**1968 CAMARO 12000 SERIES**

1. 3908372  CAP-L.H. ONLY (EXC. CONV.)
2. 1365067  NUT,
3. 5544049  RETAINER
4. 381957  GROMMET
5. 3905569  WASHER-SEALING
6. 3892761  BRACKET ASM.
7. 3784303  SCREW ASM.
8. 3192831  SHOCK ABSORBER
9. 179868  BOLT

10. 103328  L. WASHER
11. 271500  NUT-Tighten with spring compressed to curb height
12. 3923564  BUMPER
13. 3918503  SCREW
14. 392735  BUMPER
15. 393273-4  BRACKET L. & R.H.
16. 3909140  SCREW
17. 63  CEMENT - 4.5 IN.

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

**R.H. SHOCK ABS INSTALLATION**

**FLOOR PAN**

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

---

**UPC**

**DATE SYM**  
1977-01-01  
**REVISION RECORD**  
**AUTH. DR CK**

**SHOCK ABSORBER & BUMPER**

**12000**

**REF: Pred. B2 L-54739 L-**

**L H SHOCK ABS INSTALLATION**
NOTE  Brake system to be inspected for leaks at 1800 PSI to 2000 PSI for 10 seconds.
**ASSEMBLY INSTRUCTIONS**

1968 CAMARO 12000 SERIES

<table>
<thead>
<tr>
<th>PART</th>
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<tr>
<td>SPRING</td>
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<tr>
<td>EXTENSION</td>
<td>3841645</td>
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<tr>
<td>BUSHING</td>
<td>3798256</td>
</tr>
<tr>
<td>PIN</td>
<td>1379621</td>
</tr>
<tr>
<td>PEDAL ASM.</td>
<td>3923541</td>
</tr>
<tr>
<td>COVER</td>
<td>3921648</td>
</tr>
<tr>
<td>RETAINER</td>
<td>3817880</td>
</tr>
<tr>
<td>GREASE</td>
<td>3817880</td>
</tr>
<tr>
<td>.0066 LBS.</td>
<td>1B</td>
</tr>
<tr>
<td>.006 LBS.</td>
<td>1C</td>
</tr>
<tr>
<td>.013 LBS.</td>
<td>1E</td>
</tr>
<tr>
<td>BUSHING</td>
<td>387574</td>
</tr>
<tr>
<td>CLEVIS</td>
<td>9419815</td>
</tr>
<tr>
<td>NUT</td>
<td>3790222</td>
</tr>
</tbody>
</table>

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

**NOTE** Torque nut against clevis after free play adjustment.

**CAUTION** If 3.00 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 3.00" 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.

---

**NOTE** Adjust clevis to obtain .06-.25 inches free pedal play.
ASSEMBLY INSTRUCTIONS

1968 CAMARO 12000 SERIES

PIPE ASM-FRT R.H. 3909972
CLIP ASM 3881239
PIPE ASM-FRT L.H. 3909983
HOSE ASM-Must not be twisted when installed. OPT. 3923566
WASHER 231343
SPRING CLIP 476737

NOTE Retorque to 40-90 lbs. in. after bleeding hydraulic brake system.

NOTE Pipe routed thru small end of clip.

NOTE 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 With wheels straight ahead in full rebound position, insert hose into frame bracket without kinking or twisting & install retainer spring as shown. Paint stripe on hose is a visual aid for preventing or detecting any kinks or twists.

---

80-115 LBS IN.
50-70 LBS IN
10-15 LBS IN
2.0-25 LBS FT 72-96 LBS IN.
25-35 LBS IN.

CHEVROLET MOTOR DIVISION, GMC

FRONT BRAKE LINES

UPC 5

DATE 4826B
SYN 9 SEIDEM SCREW REF ADDED
REVISION RECORD 82VE 4-K
AUTH. DR. CE M12000

DWG 5-24-67 AUT REL. 329-C
L. 79322 L. 82350

SHET C

72
**ASSEMBLY INSTRUCTIONS**

**1968 CAMARO 12000 SERIES**

Pipe routed thru small end of clip.
Position wire protector as shown.
With wheels in full rebound position, insert hose into body bracket without kinking or twisting & install retainer spring as shown. Paint stripe on hose is a visual aid for preventing or detecting any kinks or twists.

Retorque to 40-90 lbs. in. after bleeding hydraulic brake system.

**NOTE:** This area to maintain a tight fit to axle.

**NOTE:** Install clip with smaller end to pipe protector.

**NOTE:** Form clip to securely retain pipe.

---

**1. PIPE ASM**
**2. CLIP ASM**
**3. CLIP ASM**
**4. PIPE ASM L. & R.H.**
**5. SPRING**
**6. TEE CONNECTOR**
**7. SCREW ASM**
**8. BRACKET**
**9. HOSE ASM**
**10. BRACKET**
**11. CLIP**
**12. SCREW**
**13. CLIP**
**14. SCREW**

**NOTE:** Position of shield must be over flange of side rail.

**NOTE:** Main cylinder, axle asm.

**NOTE:** Form clip to retain pipe.

---

**REAR BRAKE LINES**

- **UPC:** 5
- **DATE:** 5-24-67
- **REV:** 1
- **SHEET:** 1

---

**CHEVROLET MOTOR DIVISION, GM**

---

**AUTH:** KI

---

**73**
ASSEMBLY INSTRUCTIONS

1968 CAMARO 12000 SERIES

1. NOTE] When brake unapplied install dimensions ± .25.

ASSEMBLY PROCEDURE

With the parking brake mechanism in the released position, cable tension measured on the front cable 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 4B to specified torque.

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

NOTE When brake unapplied install dimensions ± .25.
ASSEMBLY INSTRUCTIONS
1968 CAMARO 12000 SERIES

1 3918948 BRACKET ASM.
2 9422277 NUT
3 7802609 PUMP
4 9419234 WASHER
5 103321 L WASHER
6 180122 BOLT

7 3918946 BOLT
8 9418823 BOLT
9 3852856 BOLT

- 20-30 LBS FT
- 20-27 LBS FT
- 15-24 LBS FT
- 15-20 LBS FT

CHEVROLET MOTOR DIVISION, GM

PUMP MOUNTING

12000 L-6 ENGINE

A5

DATE REF. 5-14 C1

80
ASSEMBLY INSTRUCTIONS
1968 CAMARO 12000 SERIES

1. 7802609 PUMP ASM
2. 103321 L. WASHER
3. 9419234 P. WASHER
4. 941822 BOLT
5. 941822 BOLT
6. 3877608 SPACER
7. 9422297 NUT.
NOTE: Assemble pulley with stamped part number facing rearward.

NOTE: See BELT ROUTING sheets for belt strand tension.
NOTE: 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.

NOTE: Initial A.I.R. pump belt tension to be 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. Belts are to be checked for correct tension with a Burroughs Gage BT-33-95.
For belt tension specifications, see transmission belt routing sheet A8.
NOTE: For belt tensioning specifications see L-6 manual transmission belt routing sheet A8.

BELT ROUTING - MANUAL TRANSMISSION

12000 V-8 ENGINE

UPC 6
DATE 85
REF: Prel. A10
DRAWN: EL. 24/C1
AUTH: L- L- L-

CHEVROLET MOTOR DIVISION, GMCA
NOTE: For belt tensioning specifications see L-6 manual transmission belt routing sheet A8.
Install hoses with part no. & code letters of hose at radiator end.

Position clamp so it will not interfere with fan.

Minimum clearance between radiator hose & fan belt to be 1.98
**CAUTION** Slow take-up for compression of gasket is necessary to prevent damage to gasket. Over torquing will rupture filter.

**NOTE** Tube should be inserted until tube bead is against engine block.

**COLOR CODE IDENTIFICATION**

**14-22 LBS. FT.**
**20-25 LBS. FT.**
**30-40 LBS. FT.**

---

**ASSEMBLY INSTRUCTIONS**

**3918855**

**1968 CAMARO 12000 SERIES**

**3886082**  GAGE ASM.-OIL LEVER L-6 ENG.
Color code (White)

**3923239**  V-8 ENG-Color code (Grey)

**3886081**  TUBE-OIL LEVEL GAGE L-6 ENG.

**3876870**  V-8 ENG.

**3916328**  VALVE ASM.-OIL FILLER

**179820**  BOLT

**6437955**  FILTER ASM.-OIL

**3853870**  CONNECTOR

**OIL-ENG. 1.250 GALS.**

**FILTER ASM.-OIL FILLER BOLT**

**CONNECTOR**

**COLOR CODE IDENTIFICATION**

**OIL CAP & TUBE PART OF ENGINE ASM.**
ASSEMBLY INSTRUCTIONS

3918855

1968 CAMARO 12000 SERIES

1 9419370 SCREW ASM.
2 3941028 BRACE
3 NOTE: The attaching parts for this bracket must be tightened after the starting motor attaching bolts have been torqued.
4 3830134 BOLT
5 1108555 STARTING MOTOR ASM. L-6 ENG.
6 1108387 V-8 ENG.

NOTE: The attaching parts for this bracket must be tightened after the starting motor attaching bolts have been torqued.

FORWARD

BOLT
BRACE
NUT

15-20 LBS FT
30-40 LBS FT
60-70 LBS IN
1968 CAMARO 12000 SERIES

Wire from dist to neg terminal. Loosen nut & position terminal between nut & clip.

1115208 COIL ASM

121852 BOLT

3702799 RETAINER

NOTE MANDATORY that STAKE MARKS be aligned between distributor and cylinder & case. For proper stake mount location see engine asm. instructions.

100 - 140 LBS IN
25 - 35 LBS IN

SPARK PLUG WIRING & COIL

12000 L-6 ENGINE

UPC DATE SYM REVISION RECORD AUTH. DR CR

6 12/67 1 STAKE NOTE ADDED 301004 01 01

B4 12/67 2 STAKE NOTE REVISED C1 76 01

SHRT 1

90
**Assembly Instructions**

**1968 Camaro 12000 Series**

**Table of Contents**

1. Wire Asm (Cyl no. 1)
2. Wire Asm (Cyl no. 2)
3. Wire Asm (Cyl no. 3)
4. Wire Asm (Cyl no. 4)
5. Wire Asm (Cyl no. 5)
6. Wire Asm (Cyl no. 6)
7. Wire Asm (Cyl no. 7)
8. Wire Asm (Cyl no. 8)
9. Wire Asm - High Tension

**Notes:**
- Loosen nut on neg. post of coil & position dist wire term between nut & clip.
- Mandatory that stake marks be aligned between distributor and inlet manifold. For proper stake mount location see engine asm. instructions.

**PART OF ENGINE**

**Typical L.H. Side**

**Typical R.H. Side**

**Spark Plug Wiring, Coil, & Shields**

**12000 V-8 Engine**

**UPC**

| 6 |

**Date**

| 10-10-67 | 5 | REDRAWN & REDESIGNED | 7-736 | A/C | 1 |

**Sym**

| B5 |

**Ref.**

| B5 |

**Rel.**

| 5-20 | C1 |

**UPC**

| 6 |

**Shelf**

| X |
**ASSEMBLY INSTRUCTIONS**

1968 CAMARO 12000 SERIES

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<th>Description</th>
<th>Note</th>
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<tr>
<td>1119515</td>
<td>REGULATOR ASM</td>
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<tr>
<td>3876130</td>
<td>SPL. NUT</td>
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<tr>
<td>9419305</td>
<td>SCREW</td>
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<tr>
<td>2987004</td>
<td>WIRE ASM-GRD</td>
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**Notes:**
- SCREW - Shoulder of screw must be seated against threaded brass sleeve in nut.
- NUT - IGN. SW.
- SWITCH ASM - IGN.
- BEZEL - IGN. SW

---

**Diagram:**

- LH HEADLAMP GROUND WIRE
- HOLE & ATTACHING PARTS
- OUTBOARD
- FORWARD
- CYLINDER ASSEMBLY
- KEY (FISHER)
- 15-20 LBS IN
- 5-10 LBS IN
- 25-30 LBS IN

---

**Table:**

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<tr>
<th>ITEM</th>
<th>VOLTAGE REGULATOR &amp; IGNITION SWITCH</th>
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<tr>
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<td>B6</td>
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<td>B6</td>
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</table>
ASSEMBLY INSTRUCTIONS

3918855

1968 CAMARO 12000 SERIES

1. SCREW ASM.
2. BRACKET-ENG L. & R. H.
3. SPACER
4. NUT
5. P. WASHER
6. BOLT
7. BRACKET-STOP
8. BRACKET-FRAME L. & R. H.

MOUNTING ASM.
SCREW ASM.
SCREW ASM.
NUT
L. WASHER
BOLT

EXISTING REINF.

VIEW A

ENGINE FRONT MOUNTING

12000 L-6 ENGINE

UPC 5-666447 MOUNTING 5-664390 SCREW
3-0640 FT
3 VIEW "A" REVISED
3-1-68 WAS 3918503 SCREW ASM

CHASER MOTOR DIVISION, GMC

DATE "L" REVISED TO "L" REVISED

REVISED RECORD A0168 CO

Dwg 5-23-67 J.B. ref. B7 l - 78860 L.
Date rel. 5-30-67 L - L - L.
ASSEMBLY INSTRUCTIONS

3918855

1968 CAMARO 12000 SERIES

- HOSE
- CARBURETOR
- NUT
- GASKET
- SCREW
- THERMOSTAT & COVER ASM.
- ROD
- CONNECTOR
- CLAMP
- CLIP
- VALVE
- GROMMET

SECTION A-A

CARB. CHOKE & ENGINE VENTILATION

12000 L-6 ENGINE

UPC 6

DATE 7.6.67

SYM 1

RECORD WAS 697/458 VALVE 849655 C1

AUTH. 3.1

MM 81529 PRT C1

REV. 891379 NUT 39062 HMP C1

REV. WAS 277777 THERMOSTAT 90976 WM C1
Slide hoses far enough on spark control pipe to remove slack.
**ASSEMBLY INSTRUCTIONS**

**3918855**

**1968 CAMARO 12000 SERIES**

<table>
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<th>Part Number</th>
<th>Description</th>
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<tr>
<td>7028101</td>
<td>CARBURETOR ASM.</td>
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<tr>
<td>120368</td>
<td>NUT ASM.</td>
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<td>3719427</td>
<td>SPL. WASHER-Front studs only</td>
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<td>3704952</td>
<td>GASKET</td>
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<tr>
<td>3908966</td>
<td>THERMOSTAT ASM.</td>
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**NOTE**

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.

---

**14-18 LBS IN.**

**20-30 LBS FT**

---

**CHEVROLET MOTOR DIVISION, GMC**

**UPC**

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<th>ALT E CY</th>
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**CARBURETOR & CHOKE**

**12000 V-8 ENGINE**

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<td>C2</td>
<td>L-79264</td>
<td>L-</td>
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Install hoses with trade mark as shown.

NOTE: Install muffler asm over adapter tube and snap on retaining ring. (Position of ring ends is irrelevant.)

15 - 20 LBS IN,
12 - 18 LBS IN,
75 - 95 LBS IN.
INSTRUCTIONS

1. Position air cleaner into slot before tightening.

NOTE: Formed end must be assembled to Rocker Cover.

AF CLEANER, CRANKCASE VENTILATION
MUFFLER, DIVERTER VALVE,
STICKER & HOSES

12000 V-8 ENGINE

15-20 LBS. IN.
12-18 LBS. IN.
10-12.5 LBS. IN.
7.5-9.5 LBS. IN.

6

C 7

10-35/67, 85423577 CLAMP (12-125 LBS. IN.)
REMOVED
11-76, 9 WAS 9418966 L JIFLER
10 WAS 7024767 VALVE ASM.
11 VIEW "C" REMOVED
12 WAS 1432575 MUFFLER
13-58, 3 MUFFLER DUG REvised (1) Pcs
ASSEMBLY INSTRUCTIONS

1968 CAMARO 12000 SERIES

Care must be taken during installation of Retainer 7 onto Cable 1 and the proper tooling must be utilized to press the Retainer 7 into hole on Accelerator Pedal Rod to assure the cable is not "KINKED" or "DAMAGED" in any way.
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.
ADJUSTMENT REQUIREMENTS

1. Gage space between dash lever (A) & pedal support (B) to dimension shown.
2. Hold carburetor lever (C) at wide open position.
3. Adjust swivel (D) on accelerator control rod (E) so that it enters freely into carburetor lever (C).

NOTE: To check throttle adjustment of completed vehicle, depress accelerator pedal to wide open throttle position. The carburetor lever should be against the wide open stop and the dash lever (A) should have a clearance of .09-.12 to pedal support (B).
Lever must be installed on top of anti rattle spring with spring installed parallel to center line of column.

**NOTE**

ANTI-RATTLE SPRING (PART OF COLUMN)
TRANS. CONTR. LINKAGE ADJUSTMENT

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.
BEARING ASM V-8 ENG.
L-6 ENGINE
BOOT
GREASE GRAPHITE .0055 LBS.
**ASSEMBLY INSTRUCTIONS**

1 3828428 RETAINER
2 3798256 BUSHING
3 3749084 RETAINER
4 3921648 COVER PAD
5 3920261 PEDAL ASM.
6 3920262 ROD PEDAL PUSH

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

**1968 CAMARO 12000 SERIES**

![Diagram of clutch pedal & linkage]
ASSEMBLY INSTRUCTIONS

1 3899013 SHAFT ASM
2 3743349 SEAT
3 382661 STUD
4 3750696 SPRING RETAINER
5 3743360 SEAL
6 138489 L. WASHER
7 9418931 NUT
8 9420603 SCREW
9 3932760 BRACKET
10 3899022 EXTENSION

11 3899021 SPRING
12 3749084 RETAINER
13 3866568 STUD ASM
14 124829 NUT
15 3840845 SWIVEL
16 3895211 ROD
17 3849703 ROD
18 3840843 ROD
19 2 ➔ GREASE (.24 oz.)
20 1 ➔ GREASE

L 6-ENGINE

VIEW A

V8-ENGINE

VIEW B

REF. ENG. MOUNTING BRACKET

16-26 FT LBS
120-180 LBS IN
25-52 LBS FT
96-144 LBS IN.

CLUTCH SHAFT & PUSH ROD

12000
C3

DRAWING REVISION

718 6/23 720 6/24 15 720 6/24 C3
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 1.20 ± .3 free travel.
ASSEMBLY INSTRUCTIONS

3918855

1968 CAMARO 12000 SERIES

<table>
<thead>
<tr>
<th>SHEET</th>
<th>TITLE</th>
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<td>A1</td>
<td>CONTENTS</td>
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<tr>
<td>A2</td>
<td>EXHAUST SYSTEM - EXHAUST PIPE &amp; MANIFOLD ATTACHMENT (L-6 ENGINE)</td>
</tr>
<tr>
<td>A3</td>
<td>EXHAUST SYSTEM - EXHAUST PIPE ASM. &amp; MANIFOLD ATTACHMENT (V-8 ENGINE)</td>
</tr>
<tr>
<td>A4</td>
<td>EXHAUST SYSTEM - REAR EXHAUST PIPE &amp; HANGERS</td>
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<tr>
<td>A5</td>
<td>EXHAUST SYSTEM - MUFFLER ASM &amp; HANGER</td>
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<tr>
<td>A6</td>
<td>EXHAUST SYSTEM - EXHAUST &amp; MUFFLER ASM. CHECKING DIM.</td>
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<tr>
<td>B1</td>
<td>GAS TANK &amp; STRAPS</td>
</tr>
<tr>
<td>B2</td>
<td>LOWER FILLER NECK &amp; COVER</td>
</tr>
<tr>
<td>B3</td>
<td>FUEL LINE &amp; CLIPS</td>
</tr>
<tr>
<td>B4</td>
<td>GAS METER &amp; REAR HOSE</td>
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</tbody>
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**FUEL & EXHAUST-CONTENTS**

<table>
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<th>DATE</th>
<th>SYM</th>
<th>DIVISION RECORD</th>
<th>AUTRL</th>
<th>DS</th>
<th>CK</th>
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<td>8</td>
<td>6/167</td>
<td>1</td>
<td>CARRY OVER* NOTE RMVBD</td>
<td>RT</td>
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**12000**

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<td>5-67</td>
<td>SB</td>
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</tr>
<tr>
<td>DATE</td>
<td>5-24</td>
<td>C1</td>
<td></td>
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</tbody>
</table>
NOTE: 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.
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.
ASSEMBLY INSTRUCTIONS

1968 CAMARO 12000 SERIES

1 393034  HANGER ASM.
2 32  SEALER GREASE
   Approx. .125 oz. per job
3 3848157  CLAMP
4 339887  NUT
5 3848156  "U" BOLT
6 "U" Bolt to be over end of slots on muffler & rear exhaust pipe joints.

HANGER ASM.

SCREW ASML.

SUPPORT

Approx. .125 oz. per job

CLAMP

NUT

"U" BOLT

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

"U" Bolt to be over end of slots on muffler & rear exhaust pipe joints.

See UPC 0 Sheet A6 for proper clamp location.

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

100-125 LBS. IN.
120-140 LBS. IN.
ASSEMBLY INSTRUCTIONS

3932750 HANGER ASM.

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

NOTE Rear spring edge full jounce.

84 - 108 LBS. IN.
35 - 50 LBS. IN.

REAR QTR. PANEL

EXHAUST SYSTEM-MUFFLER ASM & HANGER

DATE SYM. DIVISION RECORD AUTO. OR CR
2-6-67 / 39l2599 WAS 3892722 MUFF GMC 86062 KEW
2 3923398 WAS 3892727 MUFF 67210 PW T
12-6-67 3 3932750 WAS 3932751 WAS 67203 AN

1968 CAMARO 12000 SERIES

CHEVROLET MOTOR DIVISION, GMC
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.

ASSEMBLY INSTRUCTIONS

CHEVROLET MOTOR DIVISION, GMC

EXHAUST SYSTEM - EXHAUST & MUFFLER
ASM. CHECKING DIMENSIONS

12000 SERIES

UPC

DATE

REV. REC.

AUTH.

DR.

CK

A6

12000

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5-24-67

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ASSEMBLY INSTRUCTIONS

1. 3863930 INSULATOR
2. 55 CEMENT (0.54 oz)
   55A (0.06 oz)
3. 9417761 SCREW-DRIVE
4. 3895203 CAP ASM.
5. 3895204 HANDLE
6. 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.

NUT - ASSEMBLY PROCEDURE
1. Install 14 and run 11 (upper) onto 10 and torque.
2. Install 7.
3. Run 11 (lower) onto 10 and torque.

GASOLINE

NOTE: After fuel tank is mounted, tank may be pressurized up to .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.
NOTE! No flux or residue should be allowed to remain in tank or filler neck after soldering operation.
ASSEMBLY INSTRUCTIONS

1968 CAMARO 12000 SERIES

3886522 CLIP
3841230 SCREW
3881339 CLIP ASM
3932778 PIPE L-6 ENG
3932776 V-8 ENG
3826008 HOSE L-6 ENG
3764856 V-8 ENG
9420825 SCREW
3786275 CLAMP
3786276 V8 ENG
3886521 CLIP ASM
3912538 CLIP
9419402 SCREW
140568 CLIP

NOTE: Position large end of clip forward.

FUEL LINE & CLIPS

18-23 LBS.IN.
72-96 LBS.IN.
**Assembly Instructions**

**1968 Camaro 12000 Series**

<table>
<thead>
<tr>
<th>Part</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>C. PIN</td>
</tr>
<tr>
<td>2</td>
<td>NUT</td>
</tr>
<tr>
<td>3</td>
<td>BOLT</td>
</tr>
<tr>
<td>4</td>
<td>P. WASHER</td>
</tr>
<tr>
<td>5</td>
<td>GREASE-CHASSIS .045 LBS</td>
</tr>
</tbody>
</table>

**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°.

**NOTE** 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.)

**NOTE** Outboard clamps-L. & R.H. side; Bolts must be positioned as shown (Position relative to slot unimportant).

**NOTE** A torque of 50 lbs. ft. maximum is permissible on nut when slot is in correct position for insertion of cotter pin.

---

**Assembly Diagram**

- 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.)
- Outboard clamps-L. & R.H. side; Bolts must be positioned as shown (Position relative to slot unimportant).
- A torque of 50 lbs. ft. maximum is permissible on nut when slot is in correct position for insertion of cotter pin.
ASSEMBLY INSTRUCTIONS

1968 CAMARO 12000 SERIES

Seat shoulder of brace rods to lower instrument panel reinforcement prior to driving upper attaching screws.

CAUTION! With the .20"-.30" spacing dimension (measured at lower pin) held when column is tightened to L.P. (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: Align flange so that holes match correct size bolt.

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

STEERING GEAR-COLUMN

12000

UPC | DATE | SYM | REVISION RECORD | AUTH. DR CR
--- | --- | --- | --- | ---
9 | 7-6-67 | 5-6-67 | DIMENSION RELOCATED | 5-92340 C1
10 | 10-6-67 | ITEM 21 ADDED | R9 C1
3 | 3-5-68 | SYMBOL 21 WAS SYMBOL 17 | 5-33807 401
5 | 5-5-68 | WEDGE PLATE DIM ADDED | 5-38429 401
7 | 7-20-68 | WAS TORQUE (6) 15-20 LBS FT. | 5-220142 C1
A3 | 10-30-68 | TORQUE (6) 15-20 LBS FT. RWD. | 4-3725
12-25-68 | TORQUE (6) WAS 10-160 LBS FT. | 4-3725
ASSEMBLY INSTRUCTIONS

1968 CAMARO 12000 SERIES

1 3899848 COVER-UPPER
2 9422641 SCREW ASM
3 3914799 COVER-LOWER
4 9419380 SCREW
5 50 CEMENT .30 OZ
6 58A CEMENT PLASTIC SEAM 3 PIECES
7 3916615 TRIM COVER
8 67F SEALER .20 OZ.

STEEERING COLUMN TO DASH SEAL

- CHEVROLET MOTOR DIVISION, GMC -

STEEERING COLUMN TO DASH SEAL

UPC 9
DATE 2-24-67
DRAW 5-24-67
WS A4
REF: A4
L-78001
L
L
A4
SHEET 1

AUTH: 31334
DR: KL

80-40 LBS/IN

FASTENERS SEE UPC 1

VIEW A
ASSEMBLY INSTRUCTIONS

CHART-STEERING WHEEL

P. WASHER

1968 CAMARO 12000 SERIES

NOTE: Notch in steering wheel hub must be in line with mark on shaft.

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

STEERING WHEEL-ASSEMBLY SEQUENCE

9 A5

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 wedge on forward support with retainer (L).

5. Position column in car.

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

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.

   **NOTE:** For remaining steps, upper (A) and lower (B) cover must move to established position of column which has been determined by rag joint and I.P. attachment.

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.

**NOTE:** Expanded rolled portion of seal directed towards front of car.
## CONTENTS

1. **TIRE UNIT CHART 7.35-14**
2. **WHEEL ASM.**
3. **WHEEL BALANCE WEIGHT CHART** (Approx. 1 wt. per wheel as req'd).
4. **LUBRICANT-RUBBER 1.6 OZ.**

### Instructions

- All wheel & tire assemblies are to be checked for static unbalance. Add weights to inside of wheel at rim edge to obtain a maximum unbalance condition of 5 oz. inches. If total weight required to balance the wheel & tire asm. exceeds 5 oz., either the tire or wheel is excessively out of balance & asm. should be rejected. For unbalance conditions in excess of 3 oz. inches, splitting of weights may be done if desired.

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

- Install valve assembly tubeless tire (part of tire unit as received) in wheel assembly.

### Diagram

- **HUB ASM**
- **3918855 5**
- **WHEEL ASY. OPT.**

**NOTE**

- All tires of same size & ply rating furnished with any vehicle shall be of same make.

- **NOTE** Tire pressure sticker. See UPC 0, Sheet B1 for part number & location.
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

62-91 LBS. IN.
ASSEMBLY INSTRUCTIONS

1968 CAMARO 12000 SERIES

SHEET
A1 CONTENTS
A2 FRONT END SHEET METAL COMPONENTS
A3 FENDER & CENTER REINFORCEMENT
A4 HOOD, HINGE & COWL GRILLE SEAL
A5 HEADER TO FENDER & GRILLE UPPER
A6 GRILLE UPPER, LOWER, CENTER & EMBLEM
A7 NAME PLATE & EMBLEM

B1 SEALS & PROTECTIVE COATING
B2 FENDER TO FENDER SKIRT
B3 RADIATOR SUPPORT TO FENDER & FENDER SKIRT
B4 SKIRT TO FENDER, EXTENSION & VALANCE PANEL
B5 HOOD CATCH, SUPPORT & LOCK PLATE
B6 RADIATOR & FAN SHROUD
B7 SHEET METAL CHECKING
B8 SHEET METAL CHECKING

---

CHEVROLET MOTOR DIVISION, GM

DATE
11-13

REV. REC

DRAWINGS ADDED

1

CHART
ASSEMBLY INSTRUCTIONS

1968 CAMARO 12000 SERIES

1. 3919127-8 FENDER ASM L. & R.H.
2. 3919126 BUMPER
3. 3839741 SCREW ASM
4. 3711834 SHIM (As req'd)
5. 3919131-2 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

1. 20-30 LBS. FT.

UPC 11-13

FENDER & CENTER REINFORCEMENT

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<td>1-75006</td>
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ASSEMBLY INSTRUCTIONS

3918855
1968 CAMARO 12000 SERIES

1 3916639 PANEL ASM.-HEADER
2 9780422 SCREW
3 9417954 NUT

4 3916654 PLATE-NAME
5 9419753 NUT
6 271172 NUT

ETHER TO FENDER &
GRILLE UPPER

15-22 LBS. FT.
10-15 LBS. IN.
ASSEMBLY INSTRUCTIONS

1963 CAMARO 12000 SERIES

1. SCREW & WA ASM
2. SUPPORT ASM RAD
3. NUT
4. SCREW

5. SHIM (As req'd)
6. "U" NUT
7. BRACE L. & R.H.

FENDER CTR. REINF

NO. 1 BODY MOUNT

FRAME

RADIATOR SUPPORT TO FENDER
& FENDER SKIRT

15-22 LBS. FT.
30-35 LBS. FT.

11-13
BUMPER-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.

SCREW

GREASE-.002 LBS.

HOOD CATCH, SUPPORT & LOCK PLATE

12000

11-13

B 5

144
ASSEMBLY INSTRUCTIONS
1968 CAMARO 12000 SERIES

PLAN VIEW

SIDE VIEW

FRAME ATTACHING SURFACE ON RADIATOR SUPPORT

Sheet Metal Checking

CHEVROLET MOTOR DIVISION, GMC

UPC
DATE
SHAPE

REF: 88
1-7800
1-7900
1-8079

11-13
B 7

12000
1-7800G
1-7809B
L-79100L-80243L-80199

5-23-67
146
NOTE: All gap tolerances between hood & adjacent panels to be held constant as far as possible.

1. NOTE: Adjust to align rear bumper parallel to tail lamp housing.
Lip of clamp must fit in slot of battery.

15-22 LBS. FT.
60-80 LBS IN.
To prevent diode damage, all connections including generator, regulator and relay must be tightened before positive battery terminal is connected.
ASSEMBLY INSTRUCTIONS

1968 CAMARO 12000 SERIES

2985649 CABLE - NEGATIVE
6290592 CABLE - POSITIVE
1980030 BATTERY ASM

3857706 CLIP
SAME AS L6 ENGINE
15 RUST PREVENTIVE .125 OZ.

Each terminal

FENDER REINFORCEMENT

SEE SHEET AS

SCREW & L. WASHER

CHARGING CIRCUIT LEAD

SEE SHEET AS

NUT

JUNCTION BLOCK

WASHER

RADIATOR SUPPORT

NOTE: Clips part of engine.
End to position shown.

BATTERY & CABLES

12000 - V-8 ENGINE

DRAWN: 3/1-67 REV: A55
DATER: 6-1 CT
L-61027 L- L-

UPC

DATE

REMARKS

28-0017 1 WAS 6280352 CABLE 87700 AM
2 WAS 6280365 CABLE 87701 AM
3 J-67 3 L91 (5/1) WASHER RMVD.
4 ITEM 6 ADDED 87700 AM
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.
RECOMMENDED INSTALLATION PROCEDURE

1. Assemble the headlamp 10 to the headlamp housing 15.

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 8 used to attach the headlamp housing 16 to the fender.
   b. Second, drive the three inboard screws 5 through the radiator support.
   c. Aim the headlamp 10.
   d. Assemble the headlamp bezel 12 to the fender, drive the outboard screw 13 to the fender, then the two inboard screws 14.
ASSEMBLY INSTRUCTIONS

1968 CAMARO 12000 SERIES

1 9419755 NUT
2 9427942 BULB
3 916638 LAMP
4 3925429 BEZEL

SIDE MARKING LAMPS

MODE 12000

UPC 12 A7

DATE SEL. 5-2-67 REF. PROJ. "A" L. 84745 L.
DATE REL. 5-2-67 C1 L. L. L.
ASSEMBLY INSTRUCTIONS

1968 CAMARO 12000 SERIES

1. SCREW 9420415
2. L. WASHER 174916
3. CLIP - PART OF 6
4. RELAY & BUZZER ASM. 1115862
5. SCREW 9420431
6. WASHER 3904222
7. NUT 121735
8. NUT 121743
9. HARNESS ASM. L-6 ENG. 6495053
   V-8 ENG. 6295054

NOTE: Assemble generator & fwd lamp connector to engine harness connector before assembling to junc block.

Voltage reg. see UPC 6.

FENDER REINF.

TO SIDE MARKER LAMP

TO PARKING LV.

TO BRAKE FLUID WARNING SWITCH.

TO WATER TEMP SWITCH V-8.

ENGINE WIRING

TO Fuse PANEL

FENDER REINF.

NOTE: Small end of boot to be installed downward.

ENGINE MP/NQ X BOLT PART OF ENG HARN ASM

NOTE: Assemble generator & fwd lamp connector to engine harness connector before assembling to junc block.

LOCATING TAB

20-30 LBS IN.

30-40 LBS IN.

25-35 LBS, IN.

50-75 LBS, IN.

A C. generator see UPC 6.

VIEW A

LOCATING TAB

20-30 LBS IN.

30-40 LBS IN.

25-35 LBS, IN.

50-75 LBS, IN.

A C. generator see UPC 6.
ASSEMBLY INSTRUCTIONS

3918855

1968 CAMARO 12000 SERIES

1. 6295051 HARNESS ASM.-ENGINE
2. 6295051 CLIP-PART of engine asm. bend at asm.
3. 6295051 NUT-Positive (+) post-loosen to allow
term to be positioned between nut &
clip.
4. 3815936 SW. ASM.-OIL PRESSURE
   Keep free of chassis paint.
5. 5653197 OPT.
6. 120622 NUT
7. 121752 L. WASHER
8. 120614 NUT
9. 138479 L. WASHER
10. 3799990 CLIP
11. 3864327 RETAINER
12. 9427325 SCREW ASM.
13. 1993427 SW ASM. WATER TEMP.
    OPT.

Install clips on outside of heater case

Install clips on outside of heater case

Press boot over switch asm.

CONNECTOR (SEE SHEET A9)

W/S WIPER MOTOR

TO BLOWER MOTOR

NOTE

Press boot over switch asm.

PPL. TO SW. TERM.

POS. BATTERY CABLE

SEE SHEET 11

YELLOW (TO "R" TERM.)
Assembly Instructions

1968 Camaro 12000 Series

- Harness ASM.
- Switch ASM. Water Temp.
- Switch ASM. Oil Press.
- Nut - Positive (+) post loosen to allow term to be positioned between nut clip.
- Clip

**Balance of ENG harness same as L6 ENG except as shown (see SHT A10)**

- Connector (see SHT A9)
- Bolt - Clutch housing
- Existing clip
- Wipers motor

**Connectors**

<table>
<thead>
<tr>
<th>Connector</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Engine Wiring Connector (see SHT A9)</td>
</tr>
<tr>
<td>2</td>
<td>Connection between harness and engine</td>
</tr>
<tr>
<td>3</td>
<td>Ground to engine block</td>
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<tr>
<td>4</td>
<td>Connection between harness and battery</td>
</tr>
<tr>
<td>5</td>
<td>Connection between harness and dash</td>
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</table>

**Specifications**

- 14-20 LBS FT
- 100-125 LBS IN
- 20-30 LBS FT
- 2.5-35 LBS IN

**Engine Wiring**

- 12000 V-8

<table>
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<th>Sym</th>
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HEADLAMPS ARE TO BE AIMED AS FOLLOWS:

1. Headlamp aim to be set with mechanical aimer that conforms to SAE J602 with the exception that aimer calibration shall be set to read 0" U/D and 0" R/L when aiming planes are in true vertical and horizontal alignment.

2. Vehicle to be curb minus 1/2 tank of gasoline or equivalent.

PRODUCTION SETTING - ALL HEADLAMPS

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<th>Vertical Aim</th>
<th>Horizontal Aim</th>
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<tr>
<td>1.0&quot; Up*</td>
<td>0&quot; R/L</td>
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*Vertical aim specification to be modified as required to compensate to one-half fuel tank load and other build conditions.

CHECKING LIMITS - ALL HEADLAMPS

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<thead>
<tr>
<th>Vertical Aim</th>
<th>Horizontal Aim</th>
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<tr>
<td>1.0&quot; Up ± 4.0&quot;</td>
<td>0&quot; R/L ± 5 1/2&quot;</td>
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DATE: 02/29

UPC: 12

REF: Pr.M/0- L- 1- 12

HEADLAMP AIMING

12000

DWG 
5-23-67

DATE 
5-3361
ASSEMBLY INSTRUCTIONS

1968 CAMARO 12000 SERIES

1 3919053 SCREW

2 A. 3928799 FLASHER ASM.,-Traffic Haz.
B. 3904868 OPT.
3934200 OPT.

4 3 67C SEALER .20 OZ.

Mask junction block terminals before spraying sealer.

VIEW A

HOLE IN DASH PANEL

FUSE PANEL ASM. (PART OF INST PANEL WIRING HARN)

12-17 LBS. IN.

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<tr>
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<th>FUSE PANEL ASM.</th>
<th>UPC</th>
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<td>3928799 3904868 WAS</td>
<td>87433 LLL</td>
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<td>PANEL Dwg. REVIS</td>
<td>9004 RT C1</td>
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<td>4</td>
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<td>ITEM 3 &amp; VIEW A ADDED</td>
<td>9333 GADF</td>
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DATE REL. 6/1 C1 L- L- L-

160
ASSEMBLY INSTRUCTIONS
3918855
1968 CAMARO 1,2000 SERIES

9423258 SCREW
6480929 CLUSTER ASM.
9422836 NUT
3880723 NUT
14C LUBRICANT – .10 OZ.

Existing Screw
Pedal Bracket ASM.

10-20 LBS IN.
22-30 LBS IN.

INSTRUMENT CLUSTER

INSTRUMENT PANEL

REINFORCEMENT

CROSS REF:
S-31-67
B2
L-19300 L-

UPC
DATE SYM
REVISION RECORD
AUTH
DR CK
12 B2

12000

161
ASSEMBLY INSTRUCTIONS

1968 CAMARO 12000 SERIES

3918855

6290070 CIRCUIT-PRINTED
2973932 SOCKET ASM (BLK)
3884953 OPT
9421330 BULB

A. Instrument cluster light
B. L.H. direction indicator
C. R.H. direction indicator
D. "Temp" T.T.

3886902 P. WASHER
274004 BULB
3882798 SOCKET ASM (GRAY)
454626 BULB

A. "BRAKE" T.T.
B. "GENERATOR" T.T.

3883748 SOCKET ASM (BLK)

A. "OIL PRESS." T.T.

131014 P. WASHER
134530 NUT
447143 SCREW

CONNECTOR (PART OF INST. PANEL WIRING HARNESS)

1. B3

INSTRUMENT CLUSTER LIGHTING

12000

UPC 12
DATE SYM B3
REVISION RECORD
AUTH. DR. CK

4-8 LBS. IN.

CHEVROLET MOTOR DIVISION, GMC
*INDICATES A COMBINATION TO BE USED OPTIONAL WITH A COMBINATION INDICATED BY #.

CONNECTOR - Part of instrument panel wiring harness.

20-30 LBS. IN.
8-10 LBS. IN.
After adjustment of brake pedal, adjust switch asm. so that electrical contact is made when brake pedal is depressed to dimension shown.

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

SWITCH MTG BRKT (Part of Brake Pedal Bracket Asm)

NOTE Route wires between dash panel & mat.
ASSEMBLY INSTRUCTIONS
1968 CAMARO 12000 SERIES

1. 4876930 SUPPORT
2. 193125 BULB
3. 9417587 WASHER

4. 9419329 SCREW
5. 9421851 SCREW ASM.

COURTESY LAMP WIRING

12000 (CONV)

Dwg 5-26-67 ER ref. 88 L-79187 L-79304
Date rel. 6-1 G1 L- L- L-

12
B 8
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.
NOTE: Route speedo cable to plenum panel & instrument panel harness to avoid kinking.

CAUTION: Shaft asm. to cluster & cluster asm. to instrument panel to be made prior to shaft grommet installation & clip positioning to avoid kinking.

- DASH TO MOTOR MOUNT RAIL BRACE L.H. SIDE
- INSTRUMENT CLUSTER
- FLOOR PAN LONGITUDINAL REINF. L.H. SIDE
- INSTRUMENT PANEL HARNESS
- CLUTCH PEDAL
- DASH BRACE

NOTE: Position color ident. mark inside clip.

NOTE: Position color ident. mark inside clip.

SPEEDOMETER SHAFT

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<td>OPT. (CONVERTIBLE)</td>
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<td>3792008</td>
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<td>3924777</td>
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<tr>
<td>3708146</td>
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<td>3775589</td>
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<td>3708148</td>
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<td>9409107</td>
<td>SCREW ASM.</td>
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<tr>
<td>3881339</td>
<td>CLIP ASM.</td>
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<tr>
<td>3708146</td>
<td>SEALER, .10 OZ.</td>
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<td>20-80 LBS. IN.</td>
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<td>10-15 LBS. IN.</td>
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ASSEMBLY INSTRUCTIONS

1968 CAMARO 12000 SERIES

1 911242 LAMP ASM
2 1367472 GROMMET
3 9414724 SCREW

REAR BUMPER BAR

EXISTING HARNESS

15-25 LBS. IN.
ASSEMBLY INSTRUCTIONS
3918855
1968 CAMARO 12000 SERIES

SHEET     TITLE
A1         CONTENTS
A2         FRONT BUMPER
B1         REAR BUMPER

THE FOLLOWING PARTS ARE LOCATED IN UPC 0

MISCELLANEOUS LABELS & STICKERS
IDENTIFICATION NO. PLATE
CUSTOMER VEHICLE PROTECT O'PLATE
MISCELLANEOUS SHIPPING LIST
SHIPPING PROTECTION (Seat Covers, Wax)
LUBRICATION, COOLING SYSTEM, GASOLINE
& REFRIGERANTS
PLASTIC CEMENT & SEALERS

UPC 10
AUTO JACK
JACK STOWAGE

BUMPERS & MISCELLANEOUS CONTENTS

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<td>5-24-67</td>
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14
A1
177
1. Assemble item 6 to fender skirt & fender extension.
(See UPC 11-13).
2. Loosely assemble item 2 to frame asm.
3. Assemble item 4 to item 5 and torque.
4. Loosely assemble item 2 to item 4, then torque item 2 to frame.
5. Torque item 2 to item 14
180122 BOLT
103321 L. WASHER
3916607 GUARD ASM.
3916600 BRACKET
120377 NUT

10-20 LBS. FT.

REAR BUMPER GUARD

14
B 2

CHEVROLET MOTOR DIVISION, GMC

MODEL 12000

DWG 5-23-67 REZ: 02 DATE: 84/74 SHEET

180
ASSAMLY INSTRUCTIONS

1968 CAMARO 12000 SERIES

ASSEMBLY INSTRUCTIONS

*DY-UPC 1 (A01-E99)

*A39 BELT-Seat-Frt. & Rr.-Deluxe
*A48 BELT-Seat-(Less)-(Export)
*A17 GLASS-(Export)
*A01 GLASS-Body Tinted
*A02 GLASS-Windshield-Tinted
*A85 HARNESS-Shoulder-Deluxe
*A51 HARNESS-Shoulder-Standard
*A54 HARNESS-Shoulder-Rr. Seat-Deluxe
*A55 HARNESS-Shoulder-Rr. Seat-Standard
*A52 HEADREST-Spc. Contour Type
*AL4 SEAT-Frt.-Bench Contour Type
*A47 SEAT-Rr.-Folding
*A31 WINDOW-Electric

*B38 FLOOR CARPETTS-(Less)-(Export)
B37 FLOOR MATS-Equipment
B93 GUARD-Door Edge

C60 AIR CONDITIONING
C50 DEFROSTER-Rear Window
C48 HEATER-(Less)
*C05 TOP-Folding
*C06 TOP-Folding-Power Lift
*C08 TRIM-Roof Exterior Soft

D80 AUXILIARY PANEL & VALENCE
D55 CONSOLE-Frt. Compartment
'D33 MIRROR-Remote

D90 STRIPES-Frt. End & Body Side
D91 STRIPE-Frt. End Paint
D96 STRIPE-Body Side

FRAME-UPC 2 (F01-F39)

FRONT SUSPENSION-UPC 3 (F40-F99)

*F40 SUSPENSION-Frt. & Rr. - H.D.
*F41 SUSPENSION-Frt. & Rr. - Spc.Perf.

REAR SUSPENSION-UPC 4 (G31-H99)

G80 AXLE-Rear Positraction
*GT1 AXLE-Rear-2.56 Ratio
*G97 AXLE-Rear-2.73 Ratio
G92 AXLE-Rear-3.08 Ratio (Export)
*G94 AXLE-Rear-3.31 Ratio
*G96 AXLE-Rear-3.55 Ratio
*G31 SPRING-Rr. -Spcc. (See UPC 0 & RPO V32)

*H01 AXLE-Rear-3.07 Ratio
*H05 AXLE-Rear-3.73 Ratio

BRAKE-UPC 5 (J50-J99)

J52 BRAKE-Disc-Frt.
J50 BRAKE-Vacuum Power

(7) JL8 DISC BRAKES-Front & Rear

ENGINE-UPC 6 (K01-L99)

KD1 AIR INJECTION REACTOR-(Less)
KD5 CLOSED ENG. POS. VENT. -H.D.
K30 CONTROL-Speed & Cruise
K02 DRIVE-Fan
K76 GENERATOR-AC 61 AMP
K05 HEATER-Engine Block-(Export)

*L22 ENGINE-L-6 "250" Cu. In.
*L90 ENGINE-L-6-Low Comp. -(Export)
L30 ENGINE-V-8 "327" Cu. In.
L48 ENGINE-V-8 "350" Cu. In.
L35 ENGINE-V-8 "396" Cu. In.
*L69 ENGINE-V-8 "396" Cu. In.-Aluminum Head
L34 ENGINE-V-8 "396" Cu. In.-Hi.-Perf.
L78 ENGINE-V-8 "396" Cu. In.-Spcc. Hi-Perf.
*L92 ENGINE-V-8-Low Com. -(Export)

TRANSMISSION-UPC 7 (M01-M99)

M11 FLOOR SHIFT-Trans. Cont.
M13 TRANSMISSION-3-Speed-H. D.
M20 TRANSMISSION-4-Speed
M21 TRANSMISSION-4-Speed-C. R. (See M20)
M22 TRANSMISSION-4-Speed-H. D.
M35 TRANSMISSION-P/Glide
M40 TRANSMISSION-3-Speed Automatic

MB1 TRANSMISSION-P/Glide-2 Speed Manual

FUEL & EXHAUST-UPC 8 (N01-N29)

N10 EXHAUST-Dual
*NF2 EXHAUST-Dual-Muffler-Deep Tone

STEERING-UPC 9 (N30-N49)

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

SEE MISC. SHIPPING LIST-UPC 0

* DENOTES OPT. INDEXED ONLY
(SEE INTROD. SHT.)

ALPHABETICAL OPTION LIST

| OPTION INDEX | UPC | DATE | SYM | REV | DEVIATION | DRC | AUTHL | DEV
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1

* CHEVROLET MOTOR DIVISION, GMC.

12000

DATE

FILE

REF:

D1

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DATE

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REF:

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187
ASSEMBLY INSTRUCTIONS

1968 CAMARO 12000 SERIES

WHEEL & TIRE-UPC 10 (N50-T49)

N96 COVER-Wheel Trim-Simulated Mag. 1
N95 COVER-Wheel Trim-Simulated Wire 1
N65 SPARE TIRE-Space Saver Wheel
P01 COVER-Wheel Trim (See UPC 10)
PA2 COVER-Wheel Trim-Simulated Mag. 1
P-38-P71 TIRES
*PW7-PY5 TIRES (CONV. SEE RPO L35) 1
P28 WHEEL-TIRE Special 15 in. 1

SHEET METAL-UPC 11 (T50-T59)

ELECTRICAL & INSTRUMENT-UPC 12 (T60-U99)

T60 BATTERY-H.D.
*U62 BATTERY-(Export)
*T64 BATTERY-(Less)-(Export)
*T70 HEADLAMP-(Export)
U73 ANTENNA-Rr. Manual
U35 CLOCK-Electric
U17 CONSOLE-Frt. Comp. Inst. Cluster
U03 HORN-Low "D" Note
U15 INDICATOR-Speed Warning
U28 LAMP-Ash Tray
*U27 LAMP-Glove Compartment (SEE RPO Z87) 2
U25 LAMP-Luggage Compartment
U46 LAMP-Monitor
U26 LAMP-Underhood
*U29 LIGHTS-Inst. Pnl., Courtesy
U63 RADIO-Push Button
U69 RADIO-Push Button-AM/FM (See U63)
U79 RADIO-Stereo
U80 SPEAKER-Auxiliary
*U18 SPEEDOMETER-(Export)
U57 TAPE PLAYER

RADIATOR & GRILLE-UPC 13 (V01-V29)

V01 RADIATOR-H.D.

BUMPERS & MISCELLANEOUS-UPC 14 (V30-V99)

*V48 ENGINE COOLANT-Maximum Protection
V31 GUARD-Frt. Bumper
V32 GUARD-Rr. Bumper (See V31)
*V60 PUMP-Tire-Foot Operated-(Export)
*VE2 BUMPER FACE BARS (Less Chrome)
*V78 PLATE-Compliance-(Less)-(Export)

SPECIAL ITEMS (Z01-Z99)

*Z14 AIR CONDITIONING-Body Conversion
*Z09 CHASSIS & BODY ITEMS-Misc.- (Less)-(Export)
Z87 INTERIOR-Deluxe
Z21 MOULDING-Exterior
Z23 PACKAGE-Interior Decor
Z22 PACKAGE-Rally Sport
*Z12 SPEEDOMETER-Driven Gear
*Z28 SPECIAL ENGINE EQUIPMENT
*ZD6 SUNSHADE-(Less)-Export
*Z77 WHEEL-Hub Cap & Trim Ring-Special 1
*ZK3 DELUXE SEAT BELT & SHOULDER HARN.

TRIM & PAINT COMB. (700-999)

SEE MISC. SHIPPING LIST UPC 0
DENOTES OPT. INDEXED ONLY
(SEE INTROD. SHT.)
NOTE 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.

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

NOTE Plug into fuse panel receptacle marked "Acc. Fused".
NOTE: If model has body side molding, it should be loosened to allow edge guard to slide underneath.
ASSEMBLY INSTRUCTIONS

1. TAPE-(5 inches) Loop excess wire & tape to fwd lamp harness
2. STRAP
3. WIRE ASM
4. NUT ASM
5. SWITCH ASM OPT.

6. CLIP
7. HOUSING
8. SCREW
9. SCREW
10. CIRCUIT BREAKER ASM.

For hole piercing information see UPC 0, Sheet A8.5

---

*CHEVROLET MOTOR DIVISION, GMC*

1968 CAMARO 12000 SERIES

---

POWER CONTROL EQUIPMENT.

C06

A1
INSTRUMENT PANEL HOLE COVER & HARNESS TAPING

A. 1 inch-Def duct hole
B. 4 inches-Tape heater blower connector & wire lead.
C. 1 inch-Heater hose clip hole
D. 1 inch-Heater blower & air inlet asm screw hole

NOTE: Balance of installation same as reg. proc.

For hole piercing information see UPC 0, Sheet A8.

**HEATER. BLOWER. LEAD EXISTING HOLE**

**ENG WIRING HARNESS**

**C48**

**LESS HEATER EQUIPMENT-CONTENTS**

**A1**

**12000**

**C1**

**WAS 3025403 MAT ASM 532051256**
3918855

1968 CAMARO 12000 SERIES

ASSEMBLY INSTRUCTIONS

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

3894533 CLIP
3873999 SCREW
3891664 COVER

9424858 SCREW
438159 PLUG
444588 OPT
444667 WITH RPO L70

9414923 CLAMP
1191141 CAP
3903478 COVER

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

ATTACH SCREW AT THIS LOCATION FIRST.

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

L-6 ENGINE

V-8 ENGINE

LESS HEATER EQUIPMENT-INST.
PANEL HOLE COVER & HARNESS TAPING

C48
A2
The following parts are furnished by Fisher Body as part of body assembly to adapt bodies for rear window defogging:

- 3014811: BLOWER ASM.
- 3014886: CONV.
- 3929036: DUCT-CONV.
- 1189857: SPACER-EXC. CONV.
- 3899746: GRILLE ASM.
- 3923111: GRILLE-CONV.
- 3923130: RETAINER-CONV.
- 3899736: COVER-EXC. CONV.
- 3929037: BRACKET-CONV.
- 3929038: GASKET-CONV.
- 3147081: FLANGE & SCREEN ASM.-CONV.
- 3927157: CAPACITOR ASM.

**NOTE:** Body wiring & connectors to be installed by Fisher Body.

**NOTE:** Plug into receptacle marked "Acc.",

**REAR WINDOW DEFOGGING - CONTENTS**

**UPC:** C50

**DATE:** 10-10-77

**REV:** 3-7-68

**AUTH:** L-78895

**DRAW:** C1

**MDC:** 12000

**SYM:** 3927157 CAPACITOR ADDED, 3147081 FLANGE & SCREEN ASM.-CONV, 3929038 GASKET ADDED, 3929037 BRACKET-CONV, 1189857 SPACER-EXC. CONV, 3899736 COVER-EXC. CONV, 3923130 RETAINER-CONV, 3899746 GRILLE ASM, 3923111 GRILLE-CONV, 3929036 DUCT-CONV, 3014886 CONV, 3014811 BLOWER ASM.
CAUTION: Maintain clearance of the tire to the defroster motor during spare tire installation.

NOTE: Position wheel so that valve stem is down.

NOTE: Housing to be positioned at bottom of column against stop.

62-91 LBS IN.

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<th>DATE</th>
<th>SYM.</th>
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**Diagram:**

- CHEVROLET MOTOR DIVISION, GMC
- AIR CONDITIONING-CONTENTS

**UPC:**

- 12000
- A1

<table>
<thead>
<tr>
<th>Dwg</th>
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<th>Date</th>
<th>Division</th>
<th>Auth.</th>
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<td>5-24</td>
<td>C2</td>
<td>L-L</td>
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**Notes:**
- SHEET 'B3' ADDED
**NOTICE:** 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</th>
<th><strong>FRONT SUSPENSION</strong></th>
<th><strong>ENGINE</strong></th>
<th><strong>TRANSMISSIONS</strong></th>
<th><strong>WHEELS &amp; TIRES</strong></th>
<th><strong>RADIATORS</strong></th>
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<tr>
<td>3</td>
<td>3C FRON TSPRINGS</td>
<td>6 ENGINE- (1) or same as RPO M35</td>
<td>7A TRANSMISSION- (1) or applicable R.P.O.</td>
<td>10B TIRES 1</td>
<td>13A RADIATOR ASM.- Assemblies same as RPO V01</td>
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<td>4 AXLE ASM-(REAR)-(1) or same as RPO L48</td>
<td>6X2 WATER PUMP &amp; DRIVE- (1)</td>
<td>7B-6 OIL COOLER LINES-Same as RPO M35</td>
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<td>13B FAN SHEILD 1</td>
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<td>6 CARBURETOR-(1) or same as RPO L30</td>
<td>6Y4 SPARK PLUG WIRE- (1)</td>
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(1) Assemblies same as production. See Parts List or Bill of Material for part number.
ASSEMBLY INSTRUCTIONS

1968 CAMARO 12000 SERIES

Provided by Fisher Body:
- Door Asm (A)
- Screw (4) (B)
- Kick Panel (C)

3918855

1. Door Asm
2. Screw (4)
3. Kick Panel
4. "J" Nut
5. Screw
6. Control Asm
7. Cover
8. Screw
9. Screw
10. Bracket
11. Nut

12. L. Washer
13. Spring
14. Pin Stake Securely To
15. Arm
16. Retainer
17. .204/.208 dia (2) holes in side shroud panel. Use existing holes in kick panel as template to locate.

INSTRUMENT PANEL

SIDE SHROUD PANEL

12000

INFO:
- CHEVROLET MOTOR DIVISION, GMC
- UPC
- DATE
- REVISION RECORD
- AUTH. DR. CK

AIR CONDITIONING - SIDE SHROUD CONTROL, KICK PANEL & COVER

C60
A3

12000

Dwg 5-23-67 KB REL A3 L-77742 L-
ASSEMBLY INSTRUCTIONS

1968 CAMARO 12000 SERIES

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

18-18 LBS. IN.

PLAGNUM PANEL

VACUUM HOSE (SHEET E5)

CHEVROLET MOTOR DIVISION, GMC

AIR CONDITIONING-PLAGNUM VALVE

C60

REF. A5

A4

12000

Dwg 5-23-67

REF. A4 L-79688 L-

DATE REV. C-2

194
Before torquing, bottom vac. control arm in housing, hold valve closed with 2 lbs. min. load.
ASSEMBLY INSTRUCTIONS
1968 CAMARO 12000 SERIES

1. 3891760 OUTLET ASM
2. 9776399 SPACER
3. 3891762 VALVE
4. 3891761 BEZEL
5. 9424858 SCREW
6. 9985028 STAPLE 10 REQ'D
7. 9423663 OPT.
8. 3891766 COMPARTMENT ASM.
9. 3893821 INSTR. PNL. TRIM PLATE

OUTLET'ASM
SPACER
VALVE
BEZEL

1. Install L.H. screw prior to R.H.
2. 30-40 LBS. IN.
3. RETAINER (SEE UPC I)
4. CENTER OUTLET DUCT
5. SCREW (SEE UPC I)

VIEW A

AIR CONDITIONING-CENTER OUTLET ASM. & INSTRUMENT PANEL COMPARTMENT

C60
A7

DATE 11-18-67

REPLACE 12000

L-77741 L-
Remove backing for installation
1. 3917694 BRACE - FRONT
2. 120368 NUT
3. 187119 L. WASHER
4. 3792420 P. WASHER
5. 3860404 BOLT
6. 9418918 BOLT
7. 9422275 NUT
8. 103321 L. WASHER
9. 179840 BOLT
10. 3854059 BRACE - REAR
11. 122104 BOLT
12. 3765135 P. WASHER
13. 3896983 BRACKET
14. 3903382 PIPE ASM.

PUMP BRACKET

CHEVROLET MOTOR DIVISION, G.M.

AIR CONDITIONER-COMPRESSOR MOUNTING

12000 V-8 ENGINE (MAN. TRANS.)

UPC   DATE   SYM   REVISION RECORD

C60  1/1671  1    NOCH CCED
C3   1/1667  2    MAN TRANS. ADDCCO

SHEET X

204
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.

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

1968 CAMARO 12000 SERIES

1. 3872720 BRACE - REAR
2. 103321 L. WASHER
3. 9418994 BOLT
4. 3710593 SPL. WASHER
5. 103328 L. WASHER
6. 9419074 BOLT
7. 3906882 BRACE - FRONT
8. 3792420 P. WASHER
9. 187119 L. WASHER
10. 186634 BOLT
11. 3765135 P. WASHER
12. 9418967 BOLT
13. 9419054 BOLT
14. 3872726 SUPPORT - REAR BRACE
15. 9418931 NUT

VIEWS:
A (AUTO, TRANSMISSION)
B (MANUAL TRANSMISSION-A.L.R.)
ASSEMBLY INSTRUCTIONS

1968 CAMARO 12000 SERIES

1 3891523 FITTING ASM.
2 3891524 TEE ASM.

FORWARD

V-8 ENGINE

C60 VACUUM HOSE

TRANSMISSION VACUUM HOSE

VIEW A (AUTO. TRANSMISSION)

* PLUS TORQUE REQUIRED TO ALIGN FITTING

100 * LBS IN

L-6 ENGINE

C60 VACUUM HOSE

C60 VACUUM HOSE

VERTICLE 15°

FORWARD
ASSEMBLY INSTRUCTIONS

1. PROD. BELT-A.I.R. PUMP-1ST TRACK
   1100817 GEN. ASM.
   1100796 RPO M35 & M40

2. ASSEMBLES SAME AS RPO KD2
3. BELT-GEN.-3rd TRACK
   3850803 RPO M35 & M40 - 1ST TRACK

4. SCREW
   3784349

5. BELT-COMPRESSOR - 2nd TRACK
   3847709

6. PULLEY CRANKSHAFT
   3876872

7. PULLEY - WATER PUMP
   3890419

8. COMPRESSOR ASM.
   6550133

9. BELT STRAND TENSION - See UPC 6

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.

A.I.R. PUMP PULLEY

MANUAL TRANSMISSION-
A.I.R. ONLY

25-35 LBS FT

*CHEVROLET MOTOR DIVISION, GMC*

AIR CONDITIONING-COMPRRESSOR, FAN, BELTS & PULLEYS

12000 L-6 ENGINE

DWG PREL: 3-70 GMV REF: SPEC.C2 L-89509 L-
DATE 5-24-71 L- L- L-

CHVREF.C2 L-25909 L-

UPC 62167 1 1100817 WAS 1100760 GEN 6,1919
2 3850803 WAS 3850811 PUL 811119
3 3847709 RPO M35 & M40 ASM.
4 RPO L22 REMOVED
5 PROD SCREW REB MIV0
6 A130 M"
ASSEMBLY INSTRUCTIONS

1 3917238 PULLEY-A.L.R. PUMP
2 1100796 GENERATOR ASM.
3 3861952 BELT-FAN & GEN. "396" ENG.
3861946 "327", "350" ENG.
4 FAN, CLUTCH ASM, ATTACHING PARTS & INSTALLATION SAME AS RPO KD2
5 3911013 PULLEY-CRANKSHAFT "307", "327" ENG.
3877414 "396" ENG.
6 3847705 BELT-COMPRESSOR "307", "327" ENG.
3906681 "396" ENG.
7 3908920 PULLEY ASM-WATER PUMP & FAN RPO M35
8 3845642 BELT-A.L.R. PUMP

1968 CAMARO 12000 SERIES

9 6550133 COMPRESSOR
10 BELT STRAND TENSION - See UPC 6

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.
ASSEMBLY INSTRUCTIONS
1968 CAMARO 12000 SERIES

1. 3885185 TUBE ASM
2. 606404 SPL. WASHER
3. 3895910 STUD ASM
4. 3859062 CLAMP
5. 3919578 EVAPORATOR ASM
6. 3863393 SCREW ASM
7. 3135649 CLAMP
8. 3148473 HOSE
9. 8526398 GASKET
10. 3878598 TUBE ASM
11. 3873950 SCREW
12. 9419912 NUT
13. 8526945 GASKET
14. 3140852 GASKET
15. 5910602 VALVE ASM
16. 9419727 SCREW
17. 3942672 BRACKET
18. 51 SEALING COMPOUND (.04 GAL.)
19. 91 REFRIGERANT (3.75 LBS.)
20. 3902250 SEAL
21. 50N ADHESIVE (.06 OZ)
22. 102386 P. WASHER
23. 67H SEALER, 5.0 OZ.

NOTE: At time of application, sealer bead must be .38 dia., minimum-measured perpendicular to flange.

EQUALIZER LINE

NOTE: .25 inch minimum clearance between equalizer line & all adjacent brackets, hoses & clamps.

LIQUID BLEED

- CHEVROLET MOTOR DIVISION, G/M/C -

UPC | DATE | SYM | REVISION RECORD | AUTH. | DR | CK
---|---|---|---|---|---|
C60 | 1/648 | 0 | TORQUE (8) ADDED | 96694 (4)
D1 | 7 | WAS TORQUE (5) 20-30 LBS. IN. | 96694 (4)
 | 8 | WAS TORQUE (6) 20-30 LBS. IN. | 96694 (4)
 | 9 | WAS .04 OZ. SEALER | 96694 (4)
 | 10 | SEALER BEAD NOTE ADDED | 96694 (4)
Evaporator assembly same as sheet 01 except as shown.
ASSEMBLY INSTRUCTIONS

1968 CAMARO 12000 SERIES

1. 187119 WASHER
2. 181591 BOLT
3. 3925797 FITTING & MUFFLER ASM.
   3923194 V-8 ENG.
4. 10 OIL REFRIGERANT .0063 qts.
5. 3706737 WASHER
6. 103321 L. WASHER
7. 120677 BOLT

COMPRESSOR ASM
"O" RING 10 (PART OF COMP ASM)

V-8 ENGINE

L-6 ENGINE

17 - 26 LBS. FT.
CAUTION: Hose clamp screw torques of 38-42 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.
The text provided seems to be an assembly instruction diagram for a 1968 Camaro 12000 Series. The diagram includes parts and instructions for the assembly of the water pump hose and related components. Here are some notes from the diagram:

- **Hose-Water Pump**: 396 ENG.
- **Hose-Inlet Manifold**: 396 ENG.
- **Bolt**: 181610, 187119, 103320, 120368, 180129, 942297
- **Nut**: 384984, 385396, 187648
- **Washer**: 3923195, 3902328
- **Nipple**: 3873950
- **Clip**: 3895993, 3851320
- **Pro Cup**: 3895993
- **Spacer**: 3792381
- **Plug-Spl**: 3767476
- **Grommet**: 3885184
- **Screw**: 3873950
- **Clamp**: (UP) (Down)
- **Selector-Heater Core Pipes**: Hole in Dash
- **View A**
- **Compressor Bracket**
- **Thermo Housing**
- **Water Pump**

Instructions within the diagram include:

1. **NOTE**: Hose slack must be positioned rearward of prod. clip prior to securing clip to fender.
2. **NOTE**: Hook end of clip to compressor bracket flange.
3. **NOTE**: This hose must route over water pump hose at all times.
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.
15-20 LBS IN.
**ASSEMBLY INSTRUCTIONS**

**1968 CAMARO 12000 SERIES**

**3918855**

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<td>HOSE-VAC (L-6 ENGL.)</td>
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<td>3902292</td>
<td>HOSE-VAC (V-8 ENGL.)</td>
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<td>CABLE ASM. (NEG.)-L-6 ENG.</td>
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<td>BOLT V-8 ENG. &amp; L-6 ENG. WITH RPO T60</td>
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<td>9422033</td>
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<td>120524</td>
<td>SEALER, 10 OZ.</td>
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**NOTES:**

A. (4 in.) Tape 7 to gen & fwd. lamp wiring harness.

B. (4 in.) Coil & tape prod. htr. to bio mtr. wire to engine wiring harness.

C. (4 in.) Tape 7 to gen & fwd. lamp wiring harness.

D. (4 in.) Coil & tape prod. htr. to bio mtr. wire to engine wiring harness.

E. (4 in.) Tape 7 to gen & fwd. lamp wiring harness.

F. (4 in.) Coil & tape prod. htr. to bio mtr. wire to engine wiring harness.

G. (4 in.) Tape 7 to gen & fwd. lamp wiring harness.

H. (4 in.) Coil & tape prod. htr. to bio mtr. wire to engine wiring harness.

I. (4 in.) Tape 7 to gen & fwd. lamp wiring harness.

J. (4 in.) Coil & tape prod. htr. to bio mtr. wire to engine wiring harness.

K. (4 in.) Tape 7 to gen & fwd. lamp wiring harness.

L. (4 in.) Coil & tape prod. htr. to bio mtr. wire to engine wiring harness.

M. (4 in.) Tape 7 to gen & fwd. lamp wiring harness.

N. (4 in.) Coil & tape prod. htr. to bio mtr. wire to engine wiring harness.

O. (4 in.) Tape 7 to gen & fwd. lamp wiring harness.

P. (4 in.) Coil & tape prod. htr. to bio mtr. wire to engine wiring harness.

Q. (4 in.) Tape 7 to gen & fwd. lamp wiring harness.

R. (4 in.) Coil & tape prod. htr. to bio mtr. wire to engine wiring harness.

S. (4 in.) Tape 7 to gen & fwd. lamp wiring harness.

T. (4 in.) Coil & tape prod. htr. to bio mtr. wire to engine wiring harness.

U. (4 in.) Tape 7 to gen & fwd. lamp wiring harness.

V. (4 in.) Coil & tape prod. htr. to bio mtr. wire to engine wiring harness.

W. (4 in.) Tape 7 to gen & fwd. lamp wiring harness.

X. (4 in.) Coil & tape prod. htr. to bio mtr. wire to engine wiring harness.

Y. (4 in.) Tape 7 to gen & fwd. lamp wiring harness.

Z. (4 in.) Coil & tape prod. htr. to bio mtr. wire to engine wiring harness.

**PRODUCTS:**

- **C 1800**
  - AIR CONDITIONING-BATTERY CABLES & VACUUM TANK
  - UPC: C60 E2

**DATE & SYM:**

- **3/28/68**
  - 6/68
  - L-77753 L-646

**AUTH:**

- **6/68**

**DRAWN:**

- **6/68**

**DATE REL. 6/6**

- **6/9/68**

**REF:**

- **6/12/68**

**ASSISTANT DESIGNER:**

- **6/26/68**

**AUTH:**

- **6/26/68**

**DR CK:**

- **6/26/68**
CABLE ASSEMBLY SEQUENCE

1. Attach 1 & 4 to control asm. (see sh. E3)
2. Place control temperature lever in "off" position.
3. Attach opposite loop of 1 & 4 to selector duct temperature lever pins.
4. Push sheath toward heater lever until valve seats & dash is out of cables & control. (approx. 5 lbs.)
5. Tighten 5 to secure cable.
TAPE (4 in.)
Tape A/C harness to inst panel harness

Hose ASM-VAC

Harness ASM-A/C

Inst Panel Harness (Prod.)

Plenum Panel

To W/S Wiper

To Light Switch

Clip (on plenum)

Control Cables

SPEEDO CABLE

A/C OIL HOSE - LH

Radio Conn (RPO U63 & U69)

To Ign Sw

To Flasher

To Cigarette Lighter

Air Conditioning - Inst Panel Wiring
NOTES
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 [1].
3. Cut the (2) heater control conn orange leads flush at breakout.
4. Pull heater control connector (& four wires) free from harness & discard.
**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 OUTLTS) 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.
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. Air conditioning system must be evacuated to a minimum of 25 mm Hg. absolute system pressure (1). After a 15-second hold time (2), the system pressure must not exceed 28 mm Hg. absolute pressure.

- System Pressure - the level of evacuation of the vehicle's A/C system once the vacuum source has been removed.
- Hold Time - elapsed time which occurs between vacuum disconnect and charge connect.

For those plants which have a longer than 15-second hold time, the system pressure may be allowed to rise to the values shown below in Table #1.

<table>
<thead>
<tr>
<th>Elapsed Time Between Evacuation and Charge</th>
<th>TABLE #1 Acceptable Evacuation Level (mm Hg) per Evacuation and Charge Spec.</th>
</tr>
</thead>
<tbody>
<tr>
<td>15-30 seconds</td>
<td>28 mm Hg</td>
</tr>
<tr>
<td>31-60 seconds</td>
<td>30 mm Hg</td>
</tr>
<tr>
<td>61-90 seconds</td>
<td>35 mm Hg</td>
</tr>
<tr>
<td>91 seconds and over</td>
<td>40 mm Hg</td>
</tr>
</tbody>
</table>

5. Disconnect quick-connect fitting from vacuum system to Process Coupler and attach quick-connect fitting from Refrigerant Charging Board to Process Coupler.
6. Charge Air Conditioning System with specified amount of Refrigerant.
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" position.
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>80°F</td>
</tr>
<tr>
<td>90°F - 110°F</td>
<td></td>
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<tr>
<td>20°F</td>
<td>25°F</td>
</tr>
<tr>
<td>30°F</td>
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---

**CHEVROLET MOTOR DIVISION, GM CO.**

**AIR CONDITIONING-GENERAL SPECS & PROCEDURES**

<table>
<thead>
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<th>UPC</th>
<th>DATE</th>
<th>SYM</th>
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<th>AUTH. DR. OK</th>
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<td>C60</td>
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<td>STEP 4 REVISION</td>
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<td></td>
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**REFERENCE SHEET**

---
The following parts are released by Chevrolet & installed by Fisher Body:

- 3927448 RETAINER
- 3927449 RPO Z87
2 The following parts are not illustrated in this RPO. See Parts List or Bill of Materials for part numbers.

UPC 1 BODY
1A2B INSTRUMENT PANEL PARTS
1A2E ASM. ASH TRAY
1A2C VENT. HEATING & A/C (Assembles same as C60)

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

UPC 9 STEERING
9A Steering gear & pitman arm

UPC 12 ELECTRICAL
12E REAR LAMPS (Components below tunnel) - See applicable RPO Transmission
Paint entire rear portion of the upper and lower seat separator compartment interior cavity with black paint W 30 A848 for a distance of 6.50" forward of rear compartment wall.
Cutoff to be forward & injector pin bosses down.

Word "FRONT" must be forward.
ASSEMBLY INSTRUCTIONS

1. 3921835  PLATE-UPPER
2. 9421934  SCREW
3. 3921827  SEAL
4. 9419755  NUT
5. 3921804  PLATE-LOWER
6. 3919160  DIAL POWERGLIDE
7. 3919161  3 SPD. AUTO.
8. 3919162  RETAINER
9. 3921803  PLATE

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

1968 CAMARO 12000 SERIES

FRONT COMPARTMENT FLOOR CONSOLE AUTOMATIC TRANSMISSION CONTROL

12000
ASSEMBLY INSTRUCTIONS

1968 CAMARO 12000 SERIES

1 3945747 PENETRATION NOSE STRIPE CHART
2 3918544 COLOR COMBINATION CHART

MULTI-COLOR NOSE STRIPES

SECTION A A

± .04 MISALIGNMENT TOLERANCE OF THIS LINE.

3.50 (REF.)

PAINT BREAK TO LINE UP WITH TOP OF FENDER EXTENSION

BUMPER BRACKET

UPC:

D88
A1

236
ASSEMBLY INSTRUCTIONS
39188S5
1968 CAMARO 12000 SERIES

3940144 FENDER & BODY STRIPE-CHART

Diagram of a 1968 Camaro 12000 Series with overlaid annotations:
- **View A**: Center of paint stripe on side crease line.
- **View B**: Paint stripe header & body side.
- **View C**: Door opening & side crease line.

Technical specifications and part numbers are listed in the lower section of the page.
1 STENCIL—See paint instructions
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
ASSEMBLY INSTRUCTIONS

3918855

1968 CAMARO 12000 SERIES

1. 3839896
   SPEEDO CBL. ASM.
2. 6477131
   OPT.
3. 59
   CEMENT 2 oz.
   Applied to clip and hole from inside of car
4. 6476735
   ADAPTER
5. 6476736
   OPT.
6. 3932220
   RPO M40 WITH L34
7. 867209
   KEY

--- Diagram ---

--- UPC ---

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<th>LOCATION</th>
<th>REV</th>
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<td>21/5/67</td>
<td>2322220</td>
<td>RPO M40 WITH L34</td>
<td>4/27/67</td>
<td>6477131 WAS 6154648</td>
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</table>

--- Diagram Details ---

SEE UPC M20 SHT. A6
ASSEMBLY INSTRUCTIONS
1968 CAMARO 12000 SERIES

SHEET   TITLE
A1  CONTENTS
A2  BRAKE PIPES & PARKING BRAKE BRACKET

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

UPC 3  FRONT SUSPENSION
      3B  ASM-STRG KNU & FRT WHEEL HUB

UPC 4  AXLE ASM

UPC 5  BRAKES
      5F  BRAKE LINES & VAC. CYL. ASM - ASSEMBLE SAME AS R.P.O. J50 & J52

UPC 6  ENGINE
      6L  FITTINGS - ASSEMBLE SAME AS R.P.O. J50.

UPC 10  WHEELS & TIRES

NOTE The following items are listed in UPC 0
      Miscellaneous Shipping List.
      WHEEL TIRE INSTRUCTION SHEET
      RING UNIT
      CAP UNIT

DISC BRAKES - FRONT & REAR
CONTENTS

<table>
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<tr>
<th>UPC</th>
<th>A1</th>
<th>A2</th>
</tr>
</thead>
<tbody>
<tr>
<td>JL8</td>
<td></td>
<td></td>
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</tbody>
</table>
ASSEMBLY INSTRUCTIONS

1968 CAMARO 12000 SERIES

1. 3950119 PIPE ASM L.H.
2. 3950120 PIPE ASM R.H.
3. 3953248 "U" BOLT
4. 3945519 BRACKET
5. 3953251 RETAINER
6. 3953249-50 BRACKET L.&R.H.
7. 476737 SPRING-YOKE
8. 3947037-8 PIPE ASM L.&R.H.
9. 3953247 HOSE ASM

NOTE: Form clip to securely retain pipe.

CAUTION: Use backup wrench on hose fitting to prevent bracket distortion when pipe nut is torqued.

1/2-20 thd. L.H.
7/16-24 thd. R.H.

80 - 115 LBS IN.
**Assembly Instructions**

1968 Camaro 12000 Series

---

**Parts List**

- **Cylinder Assembly**
  - RPO L34, L35, L48, L78, Z28 & L30 with M20

- **Nuts**
  - 9418921
  - 103321
  - 9420165
  - 3917957

- **Washers**
  - L

---

**Notes**

1. **NOTE**
   - Bracket must be on a vertical plane relative to cylinder assembly.

2. **NOTE**
   - Fill master cylinder reservoirs to 0.25 in ± 0.125 in from top measured at rear edge.

3. **NOTE**
   - Locate seal to dash with identification mark installed toward top.

4. **NOTE**
   - Install jam nut to end of thread finger tight, torque clevis jam nut.

5. **NOTE**
   - 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.

6. **CAUTION**
   - If 1.75 is exceeded brakes should be rechecked for proper bleed. Check must be made with no vacuum reserve assist.

---

**Diagram**

- **View C**
  - CYLINDER ASM.
  - VIEW C
  - PROD. SWITCH & BRACKET
  - FRAME
  - TOE PAN

- **View B**
  - POWER CYL. NUT
  - PRODUCTION NUT & L. WASHER
  - NOTE: Attachment to frame & underbody

- **View A**
  - NOTE: 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.

---

**Specifications**

- 2.0 - 3.0 lbs.
- 55 - 75 lbs.
- 90 - 140 lbs.
- 20 - 26 lbs.
- 16 - 26 lbs.

---

**References**

- Ref. AZ
- L-79589
- L-79532

---

**Chevrolet Motor Division, GMC**

- UPC
- Date

---

**Records**

- 12000
- 245

---

**Drawings**

- 6-3Y-67

---

**Revision**

- View C added
- Production Nut added
- Torque added
- PWV Cyl. & Torque added
- PWV Cyl. & Torque added

---

**Authorized Edition**

- B

---

**Manual Number**

- J50 A2
Attach to vacuum cylinder asm:

- SPARK PLUG WIRE SUPPORT
- ANTI-SMOG HOSE
- C60 VACUUM HOSE
- M35 VACUUM HOSE

Clearance—Throttle rod to hose:
- 3/8 in. at closed throttle position
- 1/2 in. at mid throttle position
- 3/4 in. at WOT position

RPO C60 or M35

RPO C60 WITH M35

RPO L34, L35 & L78

Chevrolet Motor Division, G-O

Title: VACUUM POWER BRAKE HOSE, SUPPORT & TEES

Model: 12000 V-8 ENGINE

UPC: J50

Date: 12/10/68

Chevrolet Motor Division, G-O

100-125 LBS. IN.
140-190 LBS. IN.
## ASSEMBLY INSTRUCTIONS

**3918855**

**1968 CAMARO 12000 SERIES**

### CONTENTS

<table>
<thead>
<tr>
<th>A1 CONTENTS</th>
<th>SHEET</th>
<th>A2 MAIN CYL. &amp; BALANCE VALVE</th>
</tr>
</thead>
<tbody>
<tr>
<td>1 3924377-8 STRG. KNUCKLE &amp; FRT. WHEEL HUB ASM. L. &amp; R.H.</td>
<td>4 3910710 HOSE ASM.</td>
<td></td>
</tr>
<tr>
<td>2 3932797 WHEEL ASM. 3914894 ZZ8</td>
<td>5 476737 SPRING</td>
<td></td>
</tr>
<tr>
<td>3 3928375-6 ARM ASM.-LOWER CONTROL L. &amp; R.H.</td>
<td>6 3923535-6 PIPE ASM.</td>
<td></td>
</tr>
</tbody>
</table>

### DISC BRAKES FRONT-CONTENTS

![Diagram of disc brakes front-contents](image)

**CAUTION** Use backup wrench on hose fitting to prevent bracket distortion when pipe nut is torqued.

**CAUTION**

- 80-120 LBS. IN

**CHECK LIST**

- DISC BRAKES FRONT-CONTENTS
- 12000
- [6-12-67 ANREF A1 KELG-13 C1]
- [J52] A1
- [247]
ASSEMBLY INSTRUCTIONS

1968 CAMARO 12000 SERIES

1. CYLINDER ASM. 3918855
2. SCREW ASM. 54649061
3. VALVE ASM. 3905525
4. PIPE ASM. -Main cyl to valve 3908317
5. PIPE ASM. -Switch to valve 3905573

NOTE Cylinder installs same as RPO J-50

NOTE Balance of installation same as RPO J-50

NOTE 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 in. exceeded brakes should be rechecked for proper bleed. Check must be made with no vacuum reserve assist.

MAIN CYLINDER & BALANCE VALVE

J 52

A2

REV. RECORD

AUTH. OR C

MAIN CYLINDER & BALANCE VALVE

12000

11-16 LBS FT TORQUE REMOVE
ASSEMBLY INSTRUCTIONS

1968 CAMARO 12000 SERIES

SHEET 3918855

Sheet Title

A1 CONTENTS
A2 NON-ILLUSTRATED PARTS

A3 DISTRIBUTOR CONVERSION INSTRUCTIONS L-6 ENG.
A4 DISTRIBUTOR CONVERSION INSTRUCTIONS V-8 ENG.

Study V-8 (except "396")
Plug "396"

Stud V-8 (except "396")
Plug "396"

Bolt V-8 "396"

Cap

\[\begin{array}{c}
\text{View A} \\
\text{View B}
\end{array}\]

Less Air Injection-Contents

Chevrolet Motor Division, G.M.C.

UPC

Date

Revision Record

Auth. Dr. CK

K1

KD1

A1

1 SHEET

-25-35 LBS. FT.
-150-175 LBS./IN.

-25-35 LBS. FT.
-150-175 LBS./IN.
NOTE: The following parts are not illustrated in this R.P.O. See Parts List or Bill of Materials for part numbers.

**UPC 6 ENGINE**

- **6C-2** - CRANKSHAFT BALANCER - V-8 ("396") assembles same as RPO'S L34-L35 & L78
- **6K-1** - FAN & DRIVE - L-6 assembles same as RPO M35 - V-8 ("396") assembles same as RPO'S L34-L35 & L78
- **6K-2** - WATER PUMP & DRIVE - L-6 & V-8 - 
- **6M-1** - CARBURETOR (HEAT STOVE) - Assembles same as RPO M35
- **6M-3** - AIR CLEANER & SILENCER - Assembles same as RPO M35
- **6Y-1** - GENERATOR & REGULATOR - L-6 Assembles same as RPO M35

**UPC 9 STEERING**

- **9E** - HYDRAULIC STEERING PUMP (BRACKET) - L-6 Assembles same as RPO N40 (with RPO M35)

Assembly same as production. See Parts List or Bill of Materials for part number.
DIRECTIONS FOR CONVERTING A.L.R. EQUIPPED ENGINE DISTRIBUTOR TO SAME DISTRIBUTOR AS NON A.L.R. ENGINES

1. Remove distributor cap.
2. Rotate engine crankshaft until timing mark on torsional damper aligns with "O" on timing pointer and distributor rotor arm points approximately 15° toward the left from front of engine. (Engine in #1 cylinder firing position).
3. Remove distributor clamp.
4. Remove distributor. Do not disturb engine crankshaft position while distributor is out of engine.
5. Position rotor arm of distributor to point to the front of the engine and carefully slide distributor into engine. (After installation, rotor arm will point approximately 15° toward the left from front of engine).
6. Rotate distributor body until the cap attaching clips form an angle of approximately 15° counter-clockwise from rear face of engine as shown in View A.
7. Secure distributor clamp snugly.
8. With vacuum line disconnected and engine running, set timing as follows:

   L-6 Eng. 4° + 1° B.T.D.C. @ 500 RPM

9. Tighten distributor clamp to specified torque.

14-18 LBS FT
DIRECTIONS FOR CONVERTING A.L.R. EQUIPPED ENGINE DISTRIBUTOR TO SAME DISTRIBUTOR AS NON A.L.R. ENGINES

1. Remove distributor cap.

2. Rotate engine crankshaft until timing mark on torsional damper aligns with "O" on timing pointer and distributor rotor arm points approximately 45° toward the right from front of engine. (Engine #1 cylinder firing position).

3. Remove distributor clamp.

4. Remove distributor. Do not disturb engine crankshaft position while distributor is out of engine.

5. Position rotor arm of distributor to point to the front of the engine and carefully slide distributor into engine. (After installation, rotor arm will point approximately 45° toward the right from front of engine).

6. Rotate distributor body until the cap attaching clips form an angle of approximately 15° clockwise from rear face of engine as shown in view A.

7. Secure distributor clamp snugly.

8. With vacuum line disconnected and engine running, set timing as follows:
   - REG. PROD: 2° B.T.D.C. @ 550 R.P.M.
   - L30 4° B.T.D.C. @ 550 R.P.M.
   - L48 4° B.T.D.C. @ 550 R.P.M.

9. Tighten distributor clamp to specified torque.
ASSEMBLY INSTRUCTIONS

1968 CAMARO 12000 SERIES

SHEET  A1  L-6 ENGINE

SHEET  A2  V-8 ENGINE (307) & (327)

SHEET  A3  V-8 ENGINE (396)

Assembly & Part Numbers same as Prod.

1.  3927734 HOSE
2.  3924544 ARRESTER
3.  3927733 CONNECTOR
4.  3927735 PLUG
5.  3927768 CONNECTOR ASM.
6.  114500 NUT
7.  103375 C. PIN

NOTE! Remove existing breather tube from air cleaner, insert plug as shown.

15/16 DIA. HOLE IN BOTTOM OF AIR CLEANER

1. WING NUT
2. 2.74
3. 0.62
4. 20.36
5. GROMMET
6. 4
7. 3
8. 2
9. VIEW A

10-15 LBS FT

CHEVROLET MOTOR DIVISION, GMC

HEAVY DUTY CLOSED POS. CRANKCASE VENT-CONTENTS & L-6 ENGINE

UPC  DATE  SYM  REVISION RECORD  AUTH. DB XE

KD5

A1

12000

DAG 10-12-67  RS  R4F ECR 96785L 86542 L
DATE REL 10-12 C1  ECR 96493 L
Assembly & Part Numbers same as Prod.

1. 392768 CONNECTOR ASM.
2. 3927735 PLUG
3. 3933125 HOSE
4. 3923260 CONNECTOR

NOTE: Remove existing breather tube from air cleaner, insert plug as shown.

1. AIR CLEANER
2. GROMMET
3. 15/16 DIA. HOLE IN BOTTOM OF A/C
4. 3.05
5. WING NUT
6. 3924544 ARRESTER
7. 114500 NUT
8. 103375 C. PIN
9. 3927732 GASKET

10-15 LBS FT

RPO HOLE LOCATING DIMENSIONS

HEAVY DUTY CLOSED POSITIVE CRANKCASE VENTILATION

12400 V-8 ENGINE (EXCEPT 396 ENG)

KD5
A2
ASSEMBLY INSTRUCTIONS

Assembly & Part Numbers same as Prod.

1 103375 C. PIN
2 3927735 PLUG
3 114500 NUT
4 3921978 HOSE
5 3924544 ARRESTER
6 3927731 CONNECTOR
7 3923260 CONNECTOR
8 3827530 HOSE
9 3927731 CONNECTOR ASM.
10 3927732 GASKET

NOTE: Remove existing breather tube from air cleaner, insert plug as shown.

15/16 DIA. HOLE IN BOTTOM OF AIR CLEANER

10-15 LBS FT

CHEVROLET MOTOR DIVISION, G.M.C.

HEAVY DUTY CLOSED POSITIVE CRANKCASE VENTILATION

12000-396 ENGINE

KG5 A3 255
ASSEMBLY INSTRUCTIONS

1968 CAMARO 12000 SERIES

A1 CONTENTS

A2

1. 730541 HEATER ASM.
   730540 396 ENG.
2. 380782 CLIP
3. 730542 CORD
4. 3772788 CLIP
5. 3830786 RETAINER

RADIATOR SUPPORT

GENERATOR (FORWARD LAMP HARNESS)

V-8 (EXC. 396 ENG.)
NOTE: Route heater cord thru front eng., mount then thru pos. battery clip on front cross member.

FENDER REINF.

RADIATOR SUPPORT

POS. BATTERY CABLE

CLIP (SEE UPC 12)

CANCELED
1. Remove water jacket support plug carefully.  
   **NOTE** Do not score machined surface of hole.

2. Thoroughly clean plug hole removing any burrs, compound, paint or rough spots.

3. Apply a coating of grease or vaseline to the "O" ring and machined surface of hole (this prevents damage to the "O" ring and makes installation easier).

4. The #10 - 32 screw is backed off by turning counter clockwise to the limit of the thread. This allows the center axis of the screw carrying the yoke to take up angular positions relating to the center line axis of the heater.

5. To install into engine block, merely insert the hairpin end of the heating coil into the opening and one end of the yoke into the inside face of the block. In this displaced position it allows the other end of the yoke to be pushed beyond the inside face of the engine block. (Refer to fig. 1) To insert support into block merely center the axis of the heater and the axis of the core hole and push support in as far as it will go.

6. Complete assembly by tightening screw in clockwise direction. **CAUTION** (Excessive tightening is not necessary). (Refer to fig. 2).

7. Route cord to front of radiator support (See sheet A1 & A2). **CAUTION** Insure that cord does not touch engine, hot pipes, manifold or any moving parts.

---

**Engine Block Heater Installation Instructions**

**ENGINE BLOCK HEATER INSTALLATION INSTRUCTIONS**

**UPC**

K05

**DATE**

6/18855

**SY#**

A3

**REVISION RECORD**

12000

**AUTH**

257
**ASSEMBLY INSTRUCTIONS**

**1968 CAMARO 12000 SERIES**

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<tr>
<td>12</td>
<td>6TN</td>
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</table>

For hole piercing information see UPC 0, Sheet A8.5

**NOTE** With carburetor at idle position (choke completely off), attach ball chain to servo & clip. Chain should be tight as possible without holding throttle open. Trim excess chain to within 3 balls of clip.

**HOSES & WIRING**

**12000 V-8 ENGINE WITH AUTO TRANS**
After build up of details & brake pedal adjustment (Sect. 5) adjust switch (Item 10) so that plunger clears pedal arm at .25 in. of movement, measured at switch.

After brake adjustment, adjust valve (Item 4) so that plunger clears striker at .30 in. of movement measured at valve.

System must be checked for engagement & disengagement with vehicle run at a speed of 35 MPH.

Grease .13 LBS.

Manual Brakes

Power Brakes

Chevrolet Motor Division, GMC

Title: Speed Cruise Control Switches & Vacuum Fittings

Part Number: 12000 V-8 Eng with Auto Trans

UPC: K30

Revision: A6
1 3776292 HOSE
2 PROD PART

SPEED CRUISE CONTROL WINDSHIELD WASHER BOTTLE-WITH R.P.O. Z28

12000 V-8 ENGINE WITH AUTO TRANS.
The following belts assemble the same as production (or pertinent RPO's):

- 3923415 BELT-FAN & GEN. L-6 ENG. (EXC. A.L.R.)
- 3915962 RPO C60 (EXC. A.L.R.)
- 3916394 V-8 ENG. (EXC. "396" ENG.)
- 3932332 RPO C60 (EXC. "396" ENG.)
- 3917208 "396" ENG.
- 3928904 RPO C60
- 3845648 BELT-HYDRAULIC STEERING PUMI L-6 ENG. WITH RPO N40.

**A-C GENERATOR EQUIPMENT (61 AMP) & PULLEY INSTALLATION - CONTENTS**

**K76**

**A1**

**1968 CAMARO 12000 SERIES**

**GENERATOR ASM.**

**RPOC60**

**P. WASHER**

**NUT**

**PULLEY-GEN.**

---

**L-G ENG 1**

**L-G ENG 2**

**L-G ENG 3**

**L-G ENG 4**

**GENERATOR FAN-Part of Gen. Asm.**

---

**90-50 LBS FT.**
ASSEMBLY INSTRUCTIONS

3918855
1968 CAMARO 12000 SERIES

A1 CONTENTS
A2 NON-ILLUSTRATED PARTS
A3 A.L.R. EQIP. PUMP, VALVE & HOSES

3914629 ENGINE ASM. (AS SHIPPED)

V-8 ENGINE 327 - CONTENTS

UPC L30
DATE 6/13/67
SYN 1
REVISION RECORD
1. "CARRYOVER" NOTE REMOVED
   2. MODEL WAS V-8 ENGINE
   3. DRAWING ADDED
   4. ITEM 1 ADDED
AUTH. JB CK

CHEVROLET MOTOR DIVISION, GMC

11400
DWG 5/10/67 EC REF. A1 L- L-
DATE REL 5/24 C1 L- L-
SHEET X

268
NOTE: The following components are not illustrated in this R.P.O. See Parts List or Bill of Materials for part numbers.

UPC 3 FRONT SUSPENSION
3C FRONT SPRINGS-0

UPC 4 REAR SUSPENSION
4 REAR AXLE-0
4B REAR CHASSIS SPRINGS-0

UPC 5 BRAKES
5F BRAKE LINES-(Used with RPO M20)-Assemble same as L48

UPC 6 ENGINE
6 ENGINE ASM. (AS SHIPPED)-0
6T3 DISTRIBUTOR-0
6T4 COIL & SPARK PLUG WIRES-0

UPC 7 TRANSMISSION
7B1 TRANSMISSION, EXTENSION ASM.-0

UPC 12 ELECTRICAL
12A BATTERY STORAGE-0

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

3918855

1 3917646 BRACKET ASM.
2 Part number & installation same as Prod. V-8 ENGINE
3 3921901 HOSE
4
5 7024768 VALVE ASM.
6 3927164 HOSE
7
8 3917688 HOSE
9 9419004 BOLT

10 103319 L. WASHER
11 7801154 ELBOW
12 3918954 GASKET
13 9423577 CLAMP
14 3917648 HOSE

VIEW A

58 - 50 LBS.IN.
20 - 30 LBS.IN.

- CHEVROLET MOTOR DIVISION, GMC -

V-8 ENGINE 327 - A.I.R. EQUIP.
PUMP, VALVE & HOSES

V-8 ENGINE

REV. B RC 83-02 88-03 08-01 270
DATE DEC. 5-24 C1 L-83608 L-
ASSEMBLY INSTRUCTIONS

1968 CAMARO 12000 SERIES

1. 6484221 AIR CLEANER
2. 3903398 STICKER
3. 3737482 STUD
4. 3919612 GASKET
5. 9422657 BOLT
6. 7028213 CARB. ASM.
7. 3785770 HOSE
8. 3831055 HOSE
9. 3911060 PIPE ASM.-GAS
10. 3883220 PIPE-SPARK
11. 3884574 GASKET
12. 3884576 BAFFLE
13. 3930791 BRACKET
14. 3923539 ROD-ACCEL. CONT.
15. 3921189 AUTO CHOKE ASM.
16. Position air cleaner into slot before tightening

NOTE: Formed end must be assembled to Rocker Cover.

15 - 20 LBS IN.
14 - 18 LBS FT
115 - 135 LBS IN.
INSTRUCTIONS

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

UPC 1
BODY
1A2C VENTILATING, HEATING & A/C EQUIP.-*

UPC 2
FRAME
2B FRAME-*

UPC 3
FRONT SUSPENSION
3A FRONT SUSPENSION-
3B FRONT HUBS & BEARINGS-
3C FRONT SPRINGS-
3F FRONT SHOCK ABSORBERS-

UPC 4
REAR SUSPENSION
4 REAR AXLE-
4A1 LUBRICANT-
4A4 PROPELLER SHAFTS & UNIVERSAL JOINTS-
4B REAR SPRINGS-
4D REAR SPRING INSTALLATION PARTS-
4E REAR SHOCK ABSORBERS-

UPC 5
BRAKES
5D PARKING BRAKE MECHANISM
 (Bracket-Rr. Cbl.)-
5F BRAKE LINES-Assemble same as RPO L43

UPC 6
ENGINE
6 ENGINE (As shipped)-
6C2 CRANKSHAFT BALANCER-
6G4 OIL LEVEL INDICATOR-
6K1 FAN & DRIVE-
6K2 WATER PUMP & DRIVE-
6L INTAKE & EXHAUST MANIFOLDS & HEAT CONTROL-
6N2 THROTTLE CONTROL FOR ACCELERATOR PEDAL OPERATION-
6Q POWER PLANT TO FRAME MOUNTINGS-
6T AIR COMPRESSOR-
6Y1 GENERATOR & REGULATOR-
6Y2 STARTING MOTOR & CONTROLS-
6Y4 SPARK PLUGS, IGN. COIL & WIRES, IGN. SW. & GROUND STRAP-

* Assembles same as production.
* Assembles same as RPO L35
See Parts List or Bill of Materials
for part numbers.
The following components are not illustrated in the R.P.O.
See Parts List or Bill of Materials for part numbers.

**UPC 7 TRANSMISSION**
7B1B CLUTCH & CONTROLS-

**UPC 8 FUEL & EXHAUST**
8A FUEL TANK, MOUNTINGS & TANK GAUGE UNIT-Assemble same as RPO Z22
8B FUEL LINES-
8C EXHAUST PIPE, MUFFLER & MUFFLER TAIL PIPE-Assemble same as NF2

**UPC 10 WHEELS & TIRES**
10B WHEELS & TIRES-
10E SPARE WHEEL MOUNTINGS-

**UPC 11 FRONT END SHEET METAL**
11D HOOD-Assemble same as RPO L48
11G CHASSIS SHEET METAL ORNAMENTATION-* & RPO L48

**UPC 12 ELECTRICAL**
12A BATTERY & LEADS-
12G HORN, SWITCH, WIRING & MOUNTINGS-
12H FUSES, BULBS & MULTI-PURPOSE WIRING-
12J INSTRUMENT CARRIER PANEL &/OR INSTRUMENTS-

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

**UPC 14 BUMPERS & MISC.**
14B MISC. LUBRICANTS, SEALERS & GASOLINE-
14E TOOL COMPARTMENT & KIT-

* Assembles same as production.
* Assembles same as RPO L35
See Parts List or Bill of Materials for part numbers.
1968 CAMARO 12000 SERIES

ASSEMBLY INSTRUCTIONS

219281  NUT
6423907  AIR CLEANER
3902410  STICKER ENG. IDENT.
3908964  STICKER ENG. H.P.
3919812  GASKET
3921975  STUD
3868834  HOSE
3933189  GROMMET

PROD. PART

Hose

ARRESTOR

GROMMET

NOTE: Formed end must be assembled to Rocker Cover.

15-20 LBS. IN.
3918855

ASSEMBLY INSTRUCTIONS

1968 CAMARO 12000 SERIES

A1 CONTENTS
A2 NON - ILLUSTRATED PARTS
A3 GENERATOR MOUNTING, FAN, BELT & PULLEYS
A4 OIL PRESSURE FITTINGS, OIL GAGE & OIL FILLER CAP
A5 STARTER MOTOR MOUNTING
A6 SPARK PLUG WIRES
A7 A.L.R. EQUIPMENT

A8 FUEL LINE & CLIPS
A9 CLUTCH SHAFT & PUSH ROD
A10 ACCELERATOR CONTROLS
A11 HEATER & DEFROSTER
A12 HOOD ORNAMENT & DRAIN TUBE
A13 SHOCK ABSORBERS & REAR SPRINGS
A14 TRANS. SUPPORT ASM.
A15 RETAINER AUTO JACK

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V-8 ENGINE 396 - CONTENTS

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UPC

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CHEVROLET MOTOR DIVISION, GMC

V-8 ENGINE 396 - CONTENTS

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DRAWING ADDO
The following components are not illustrated in the R.P.O. See Parts List or Bill of Materials for part numbers.

### UPC 3 FRONT SUSPENSION
- **3A** FRONT SUSPENSION
- **3B** FRONT HUBS & BEARINGS
- **3C** FRONT SPRINGS
- **3F** FRONT SHOCK ABSORBERS

### UPC 4 REAR SUSPENSION
- **4** REAR AXLE
- **4A1** LUBRICANT
- **4A4** PROPELLER SHAFTS & UNIVERSAL JOINTS

### UPC 5 BRAKES
- **5D** PARKING BRAKE MECHANISM
  - (Bracket-Rr. Cbl.)
- **5F** BRAKE LINES
  - Assemble same as RPO L48

### UPC 6 ENGINE
- **6** ENGINE (As shipped)
- **6H** ENGINE VENTILATING SYSTEM
  - Assemble same as RPO L34
- **6K2** WATER PUMP & DRIVE
- **6L** INTAKE & EXHAUST MANIFOLDS & HEAT CONTROL
- **6M1** CARBURETOR
  - Assemble same as RPO L34
- **6M3** AIR CLEANER & SILENCER
  - Assemble same as RPO L34
- **6M4** FUEL PUMP & VACUUM PUMP
  - Assemble same as RPO L34
- **6Q** POWER PLANT TO FRAME MOUNTINGS
- **6Y3** DISTRIBUTOR
  - Assemble same as RPO L34

### UPC 8 FUEL & EXHAUST
- **8A** FUEL TANK, MOUNTINGS & TANK GAUGE UNIT
  - Assemble same as RPO Z22
- **8C** EXHAUST PIPE, MUFFLER & MUFFLER TAIL PIPE
  - Assemble same as NF2

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

### UPC 11 FRONT END SHEET METAL
- **11D** HOOD
  - Assemble same as RPO L48
- **11G** CHASSIS SHEET METAL ORNAMENTATION
  - Assemble same as RPO L48

### UPC 12 ELECTRICAL
- **12A** BATTERY & LEADS
- **12G** HORN, SWITCH, WIRING & MOUNTINGS
  - (Cap-Horn But.)
- **12H** FUSES, BULBS & MULTI-PURPOSE WIRING

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

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

**3918855**

**1968 CAMARO 12000 SERIES**

1. **444052** - ELBOW
2. **3784832** - CLIP
3. **606404** - SPL. WASHER
4. **3817006** - SCREW ASM.
5. **6295265** - HARNESS ASM

**Color Code Identification**

- **Yellow** @

**444026** - BUSHING

**TUBE ASM-OIL GAGE**

**SEAL-TUBE**

**GAGE ASM-OIL LEVEL**

**Color Code (Yellow)**

**4398290**

**274244**

**3925599**

**V-8 ENGINE 396 - OIL PRESSURE FITTINGS OIL GAGE & OIL FILLER CAP**

**12000 V-8 ENGINE**

**PART OF ENGINE HARNESS**

**PART OF OIL PAN ASM**

**SCREW ASM**

**PROD SWITCH**

**FORWARD LAMP HARNESS ROUTING**

**COLOR CODE IDENTIFICATION**

- **100** - 125 LBS IN
- **100** - LESS IN MIN.
- **50 - 65 LBS IN**
- **18 - 22 LBS FT**

*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.
NOTE: Assemble spark plug wires to plugs so that wire is directed upwards to maximize clearance to manifolds. Position slack towards distributor cap.
ASSOCIATION INSTRUCTIONS

1968 CAMARO 12000 SERIES

1. PROD. PART
2. 3917249 HOSE
3. 7801659 PLUG-Press. setting (Black) Installation pressure should not exceed 40 lbs.
4. 3917230 BRACE
5. 9418967 BOLT
6. 3917234 PULLEY
7. 7801512 PUMP ASM.

NOTE! Assemble pulley with stamped part number facing forward.

WARNING:

1. 100 - 140 LBS. IN.
2. 38 - 50 LBS. IN.
3. 20 - 30 LBS. IN.
4. 75 - 90 LBS. IN.

V-8 ENGINE (396)
A.L.R. EQUIPMENT

MODEL 12000

UPC L35
DATE L524
REVISION L13
AUTH. L

NOTE:

Assemble pulley with stamped part number facing forward.
NOTE! From this point rearward pipe installs same as UPC 8.

- ENGINE BRACKET ATTACHING PARTS
- BEND AFTER ASSEMBLY

View A
**ASSEMBLY INSTRUCTIONS**

3918855

1968 CAMARO 12000 SERIES

1. SHAFT ASM.
2. SPRING
3. ROD
4. SWIVEL
5. EXTENSION
6. STUD

**NOTE** Torque Item 6 to this dimension.

**NOTE** Rotate shaft against the exhaust pipe before torquing nut.
PRODUCTION PART

1. 3917381 HEATER & DEFROSTER ASM
2. 3906094 SEAL
3. 3906095 SEAL
4. 3752052 HOSE

PARTS LIST

1. 3736590 HOSE
2. 3906096 RETAINER
3. 3873951 SCREW
4. 3906093 BLOWER & INLET ASM
5. ADHESIVE .02 OZ.

FORWARD

15-20 LBS IN.

V-8 ENGINE 396-HEATER & DEFROSTER
12000
ASSEMBLY INSTRUCTIONS

1968 CAMARO 12000 SERIES

1 3927469-70  ORNAMENT L. & R.H.
2 3898146  SEAL
3 3927468  SCREEN
4 3927471-2  PLATE L. & R.H.
5 9419756  NUT
6 3903974  TUBE - DRAIN

25-35 LBS. IN.

HOOD ASM. & INSULATOR
SAME AS RPO L48

INNER PANEL REINF.
R.H. SHOCK ABS. INSTALLATION

NOTE: Upper atch. of shock absorber same as reg. prod.

55-65 LBS. FT.
ASSEMBLY INSTRUCTIONS
1968 CAMARO 12000 SERIES

SUPPORT ASM.

EXISTING PARTS

EXISTING BOLT

FRAME

25-35 LBS. FT.

L35

A14

CHEVROLET MOTOR DIVISION, GMC®
3918855

1  3929976  RETAINER
2  3929975  BOLT
3  3929977  INSTRUCTION SHEET

3929976 RETAINER
3929975 BOLT
3929977 INSTRUCTION SHEET

PROD. NUT

62-91 LBS. IN.

V8- ENGINE 396 - RETAINER AUTO JACK

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SHEET
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
3B FRONT HUBS & BEARINGS-1
3C FRONT SPRINGS-1

UPC 4 REAR SUSPENSION
4 REAR AXLE-1
4A-1 LUBRICANT-1
4B REAR SPRINGS-1
4D REAR SPRINGS INSTALLATION PARTS-Assembles same as RPO L35
4E REAR SHOCK ABSORBERS-Assembles same as RPO L35

UPC 5 BRAKES
5D PARKING BRAKE MECHANISM
   (Bracket-Rr. Cbl.)-1 L.H. Side.
5F BRAKE LINES
   (Bracket-Rr. Hose Conn.)-1

UPC 6 ENGINE
6 ENGINE (AS SHIPPED)-1
6H ENGINE VENT. SYSTEM
   (Hose)-Assembles same as RPO L30
6M1 CARBURETOR-Assembles same as RPO L30
6M3 AIR CLEANER & SILENCER-Assembles same as RPO L30
6M4 FUEL PUMP & VACUUM PUMP
   (Pipe)-Assembles same as RPO L30
6N2 THROTTLE CONTROL-Assembles same as RPO L30
6T AIR COMPRESSOR-Assembles same as RPO L30
6Y2 STARTING MOTOR-1
6Y3 DISTRIBUTOR-Assembles same as RPO L30

UPC 7 TRANSMISSION

UPC 8 FUEL & EXHAUST
8A FUEL TANKS, MOUNTINGS & TANK GAUGE UNIT-Assembles same as RPO Z22
8C EXHAUST PIPE, MUFFLER & MUFFLER TAIL PIPE-Assembles same as NF2

UPC 10 WHEEL & TIRES
10B WHEELS & TIRES-1
10E SPARE WHEEL MOUNTINGS-Assembles same as RPO L35

UPC 11 FRONT END SHEET METAL
11D HOOD
   (Hinge)-1

UPC 12 ELECTRICAL
12A BATTERY & LEADS
   (Cable-Pos.)-1
12G HORN, SWITCH, WIRING & MOUNTINGS
   (Harn. Button)-1

UPC 14 BUMPERS & MISC.
14E TOOL COMPARTMENT & KIT
   (Sticker)-1

Assembles same as production. See Parts List or Bill of Materials for part number.
1. SPL. WASHER
2. L. WASHER
3. BOLT

60-90 LBS FT

DAMPENER - PART OF ENGINE AS SHIPPED

PROD PULLEY

PROD BOLT

V-8 ENGINE 350-TORSIONAL DAMPER

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NOTE Delete deck lid stripe when RPO D80 auxiliary panel and valance equipment is specified with SS option.
NOTE: From this point rearward pipe installs same as UPC 5.

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

3918855

1968 CAMARO 12000 SERIES

SHEET

A1 CONTENTS
A2 NON-ILLUSTRATED PARTS
A3 NON-ILLUSTRATED PARTS
A4 CARB. AUTO. CHOKE & SPARK PIPE
A5 FUEL PUMP & LINES
A6 CLOSED POSIT. VENT.

3918961 ENGINE ASM. (AS SHIPPED)

V-8 ENGINE 396 SPECIAL HIGH Perf.
CONTENTS

12000 V-8 ENGINE

L78

A1
NOTE: The following components are not illustrated in the R.P.O.
See Parts List or Bill of Materials for part numbers.

UPC 1 BODY
1A2C VENTILATING, HEATING & A/C EQUIP.-*

UPC 2 FRAME
2B FRAME-*

UPC 3 FRONT SUSPENSION
3A FRONT SUSPENSION-1
3B FRONT HUBS & BEARINGS-1
3C FRONT SPRINGS-1
3F FRONT SHOCK ABSORBERS-1

UPC 4 REAR SUSPENSION
4 REAR AXLE-1
4A1 LUBRICANT-1
4A4 PROPPELLER SHAFTS & UNIVERSAL JOINTS-1
4B REAR SPRINGS-*
4D REAR SPRING INSTALLATION PARTS-*
4E REAR SHOCK ABSORBERS-*

UPC 5 BRAKES
5D PARKING BRAKE MECHANISM
   (Bracket-Rr. Cbl.)-1 L. H. Side
5F BRAKE LINES-Assemble same as RPO L48

UPC 6 ENGINE
6 ENGINE (As shipped)-1
6C2 CRANKSHAFT BALANCER-*
6G4 OIL LEVEL INDICATOR-*
6K1 FAN & DRIVE-Assemble same as RPO K02
6K2 WATER PUMP & DRIVE-7
6L INTAKE & EXHAUST MANIFOLDS & HEAT CONTROL-1
6N2 THROTTLE CONTROL FOR ACCELERATOR PEDAL OPERATION-*
6Q POWER PLANT TO FRAME MOUNTINGS-1
6T AIR COMPRESSOR-*
6Y1 GENERATOR & REGULATOR-*
6Y2 STARTING MOTOR & CONTROLS-*
6Y3 DISTRIBUTOR-1
6Y4 SPARK PLUGS, IGN. COIL & WIRES, IGN. SW. & GROUND STRAP-*

* Assembles same as production.
* Assembles same as RPO L35.
See Parts List or Bill of Materials for part numbers.
NOTE: The following components are not illustrated in the R.P.O.
See Parts List or Bill of Materials for part numbers.

UPC 7 TRANSMISSION
7B1B CLUTCH & CONTROLS-*

UPC 8 FUEL & EXHAUST
8A FUEL TANK, MOUNTINGS & TANK GAUGE UNIT-Assemble same as RPO Z22
8B FUEL LINES-*
8C EXHAUST PIPE, MUFFLER & MUFFLER TAIL PIPE-Assemble same as NF2

UPC 10 WHEELS & TIRES
10B WHEELS & TIRES-
10E SPARE WHEEL MOUNTINGS-*

UPC 11 FRONT END SHEET METAL
11D HOOD-Assemble same as RPO L48
11G CHASSIS SHEET METAL ORNAMENTATION-* & RPO L48

UPC 12 ELECTRICAL
12G HORN, SWITCH, WIRING & MOUNTINGS-
12H FUSES, BULBS & MULTI-PURPOSE WIRING-*
12J INSTRUMENT CARRIER PANEL &/OR INSTRUMENTS-*

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

UPC 14 BUMPERS & MISC.
14B MISC. LUBRICANTS, SEALERS & GASOLINE-
14E TOOL COMPARTMENT & KIT-

Assembles same as production.
* Assembles same as RPO L35
See Parts List or Bill of Materials for part numbers.
Part number & installation same as L35

Pipe Assembly (3886152)
Pipe Assembly (3935425)
Fuel Pump Assembly (6440568)
Tee (3886153)

20-25 LBS FT
100-125 LBS IN.

2000 SPECIAL HIGH PERFORMANCE FUEL PUMP & LINES

L78
A5
INSTRUCTIONS

3918855
1968 CAMARO 12000 SERIES

A1 CONTENTS
A2 NON-ILLUSTRATED PARTS
A3 AUTO. TRANS. - CONTROL LINKAGE ADJUSTMENT
A4 AUTO. TRANS. - NEUTRAL SAFETY & BACK-UP LAMP SWITCH

1 3940920 CAP L-6 ENG.
2 3946701 TRANS. ASM.

VAC. MODULATOR PIPE OUTLET - (PART OF CARB. ASM)
The following components are not illustrated in this R.P.O. See Parts List or Bill of Material for part numbers.

**UPC 0**  
**GENERAL INFORMATION**  
0 CHARTS, INSTRUCTION DRAWINGS & GENERAL INFORMATION

**UPC 4**  
**REAR SUSPENSION**  
4 REAR AXLE AND REAR SUSPENSION

**UPC 5**  
**BRAKES**  
5C SERVICE BRAKE PEDAL & CONNECTIONS TO MASTER CYLINDER-Assembles same as RPO M35

**UPC 6**  
**ENGINE**  
6 ENGINE
   6C2 CRANKSHAFT BALANCER
   6K1 FAN & DRIVE
   6K2 WATER PUMP & DRIVE
   6M1 CARBURETOR
   6M3 AIR CLEANER & SILENCER-Assembles same as RPO M35
   6T AIR COMPRESSOR
   6Y1 GENERATOR & REGULATOR
   6Y3 DISTRIBUTOR

**UPC 7**  
**TRANSMISSION**  
7 TRANSMISSION, CLUTCH AND CONTROLS-Assembles same as RPO M35
   7A TRANSMISSION EXTERNAL CONTROLS-Assembles same as RPO M35
   7B1B CLUTCH & CONTROLS-Assembles same as RPO M35
   7B3A UNDERPAN, OIL FILLER GAGE & TUBE-Assembles same as RPO M35
   7B3B AUTO. TRANS. FLUID-Assembles same as RPO M35
   7B6 OIL COOLER PIPES-Assembles same as RPO M35

**UPC 9**  
**STEERING**  
9A STEERING GEAR & COLUMN

**UPC 12**  
**ELECTRICAL**  
12H FUSES, BULBS AND MULTI-PURPOSE WIRING-Assembles same as RPO M35
   12J INSTRUMENT CARRIER PANEL AND/OR INSTRUMENTS

**UPC 13**  
**RADIATOR & GRILLE**  
13A RADIATOR ASSEMBLY

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

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<th>UPC</th>
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ASSEMBLY INSTRUCTIONS

SHIFT LEVER-(Part of Column Asm.)

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 "HI" position. **NOTE**: Obtain "HI" position by moving Transmission Lever (B) counter clockwise to 1st detent, then clockwise one detent position to "HI".

4. Set Shift Lever up against "HI" position stop.

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 hi position travel, the transmission detent feel must be noted & related to indicated position in dial.
- When in "HI": 1st & 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 result 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.

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**ASSEMBLY INSTRUCTIONS**

**1968 CAMARO 12000 SERIES**

**HARNESS ASM.**
**SWITCH ASM.**
**SCREW**

**INSTALLATION PROCEDURE**

1. Position column shift lever against drive gate by rotating lower lever (part of shift tube) counter 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. Install attaching screw and torque to specifications.

**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. Install attaching screws and torque to specifications.

4. Remove pin.

**RECOMMENDED INSPECTION PROCEDURE**

A. Position gear shift lever in "P" detent.
B. Turn ignition switch to "start"; starter should operate but the vehicle must NOT move.
C. Position gear shift lever to "R" detent.
D. Move selector toward "N" to remove play, but DO NOT MOVE out of detent.
E. Turn ignition switch to "start"; starter must be INOPERATIVE.
F. Move selector toward "P" to remove play, but DO NOT MOVE out of detent.
G. Turn ignition switch to "start"; starter must be INOPERATIVE.
H. Position gear shift lever in "N" detent.
I. Turn ignition switch to "start"; starter should operate but the vehicle must NOT move.
J. Position gear shift lever to HI detent.
K. Move selector toward "N" to remove play, but DO NOT MOVE out of detent.
L. Turn ignition switch to "start"; starter must be INOPERATIVE.
M. Move selector toward 1st to remove play, but DO NOT MOVE out of detent.
N. Turn ignition switch to "start"; starter must be INOPERATIVE.
O. Position gear shift lever to 1st.
P. Turn ignition switch to "start"; starter must be INOPERATIVE.
Q. Position gear shift lever to 1st detent.
R. Turn ignition switch to "start"; starter must be INOPERATIVE.
1968 CAMARO 12000 SERIES

ASSEMBLY INSTRUCTIONS

CONTENTS

A1 CONTENTS
A2 HOUSING & PLATE
A3 CONTROL LINKAGE
A4 CONTROL LINKAGE ADJUSTMENT
A5 L.P. HARNESS & INDICATOR LAMP WIRING
A6 NEUTRAL SAFETY & BACK UP LAMP SWITCH

NOTE: The following components are not illustrated in this RPO. See Parts List or Bill of Material for part numbers.

UPC 7 TRANSMISSION

7A EXTERNAL CONTROLS (Components below tunnel) - See applicable RPO Transmission

UPC 9 STEERING

9A STRG. GEAR & PITMAN ASM.

UPC 12 ELECTRICAL

12E REAR LAMPS - Assembles same as RPO M20
12J INSTRUMENT CARRIER PANEL AND/OR INSTRUMENTS - Assembles same as RPO M20

UPC 14 BUMPERS & MISC.

14B MISC. LUBRICANTS, SEALERS & GASOLINE - Assembles same as RPO M20

REFERENCE TABLE:

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ASSEMBLY INSTRUCTIONS

1968 CAMARO 12000 SERIES

1 3893848 RETAINER ASM.
2 9422242 U - NUT
3 9419303 SCREW
4 3893852 HOUSING
5 3893850 LEN
6 3893851 PLATE
7 9414752 SCREW
8 3893847 HOUSING
9 3893849 SEAL
10 9422825 SCREW
11 3912607 CONTROL LEVER BRACKET ASM.
12 3912612 SEAL

© & 9422825 SCREW
@ (Mi) .3912607 CONTROL LEVER BRACKET ASM.

10-15 LBS. IN
15-20 LBS. IN.
CAUTION: Do not use impact type wrench to torque this nut.

20 - 30 LBS. FT.
35 - 40 LBS. IN.
ASSEMBLY INSTRUCTIONS
3918855
1968 CAMARO 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 transmission lever counter clockwise to low detent, then clockwise two detent positions 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. Run Nut (A) until it touches Swivel (H). Tighten Nut (B) against Swivel & lock Swivel between Nuts (A) & (B). See View B.
ASSEMBLY INSTRUCTIONS

1 3724851 TAPE-Approx. 1-1/2 in.
   used to tape indicator lamp
   wire to housing

2 274004 BULB

3 6295245 WIRE ASM.

4 3937605 CLIP

5 3724852 TAPE-Approx. 4 in. 2 places
   used to tape inst. pnl. harness
   to u/body

6 6295244 HARNESS ASM.

7 3799990 CLIP

NEUTRAL SAFETY
BACK UP LAMP SWITCH

FLOOR SHIFT-L. P. HARNESS & INDICATOR
LAMP WIRING

12400 RPO M40

M 11
A 5
RECOMMENDED 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.

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.
BACK-UP SWITCH ASSEMBLY PROCEDURE

1. Subassemble selector lever activating rod 2 to back-up switch asm. 3 with retainer spring 4.

2. Attach subassembly to transmission with cover bolts & attach activating rod 2 to reverse selector lever with retainer spring 4. Place selector levers in reverse.

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

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

NOTE: Backup light switch wire routing same as RPO M20.
Attaching part numbers & lub same as RPO M20

Part numbers and cable routing same as RPO M20 & RPO L48/L35

Attaching parts PART OF TRANS.

Typical rod end.

Typical swivel end.

- CHEVROLET MOTOR DIVISION, GM C

3 SPEED H.D. TRANS.

12000  V-8 ENG. WITH RPO L48/L35

LUB GREASE .01 LBS.
FLUID SYN TRANS (.435 GAL)

1968 CAMARO 12000 SERIE
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

1968 CAMARO 12000 SERIES

SHEET

A1 CONTENTS
A2 TRANS CONTROL RODS L-6 & PROD V-8 ENG.
A3 TRANS CONTROL RODS RPO L34-35-46-78
A4 TRANS LEVER AND BRACKET ASM.

NOTE: The following components are not illustrated in this RPO. See Parts List or Bill of Material for part numbers.

UPC 3C FRONT SPRINGS
4B REAR SPRINGS
4D REAR SPRING INSTALLATION PARTS-Assemble same as RPO L35
4E REAR SHOCK ABSORBERS-Assembles same as RPO L35
5D PARKING BRAKE MECHANISM
5F BRAKE LINES-Assembles same as RPO L48
9A STEERING GEAR & COLUMN

4 SPEED TRANSMISSION-CONTENTS
**ASSEMBLY INSTRUCTIONS**

---

**NOTE** Used with RPO L34, L35, L48 & Z28. Existing trans washer on PROD L-8, RPO L22, PROD V-8 & RPO L30

**NOTE** Flat on rod must be installed towards bracket with .02 min. clearance

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

---

**1** 3895263 BOLT

**2** 3895261 SUPPORT ASM.

**3** 3934286 LEVER CONTROL RPO L34, L35, L48 & Z28

**4** 103321 L. WASHER

**5** 9418822 BOLT

**6** 9425691 NUT & LOCKWASHER ASM.

**7** 102635 NUT

**8** 3901377 SHAFT STABILIZER RPO L48

**9** 3913720 RPO L34, L35 & L48

**10** 3910700 GROMMET

**11** 179817 BOLT

**12** 103320 L. WASHER

**13** 3901372 NUT ANCHOR

**14** 9422297 NUT

**15** 3920249 BRACKET RPO L34, L35, L48 & Z28

**16** 3920250 RPO L34, L35, L48 & Z28

**17** 3901371 NUT-SPL. ANCHOR

**18** 14B LUB GREASE .001

---

**1** 3895263 BOLT

**2** 3895261 SUPPORT ASM.

**3** 3934286 LEVER CONTROL RPO L34, L35, L48 & Z28

**4** 103321 L. WASHER

**5** 9418822 BOLT

**6** 9425691 NUT & LOCKWASHER ASM.

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**15** 3920249 BRACKET RPO L34, L35, L48 & Z28

**16** 3920250 RPO L34, L35, L48 & Z28

**17** 3901371 NUT-SPL. ANCHOR

**18** 14B LUB GREASE .001

---

**4 SPEED TRANS-LEVER AND BRACKET ASM**

**UPC**

**DATE**

**REV.**

**DMC 12000**

**M20**

**M21 & M22**

---

**NOTE** .79 + .06 clearance from trans to back of bracket.

**NOTE** .29 + .06 clearance from trans to back of bracket.
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.

7. After removing Locating Gage (C) readjust Rod (J) by shortening the Rod three turns by use of Jam Nuts. Tighten to prescribed torque.

RPO M20, M21 WITH D55
BACK-UP SWITCH ASSEMBLY PROCEDURE

1. Subassemble selector lever activating rod \( A \) to back-up switch \( 1 \) with retainer spring \( 5 \) & loose assemble switch \( 1 \) to mounting bracket \( 4 \) with attaching screws \( 7 \).

   **NOTE** With RPO L48 loose assemble switch \( 1 \) & shield \( 8 \) to mounting bracket with attaching screws \( 7 \).

2. Attach subassembly to transmission with cover bolts & attach activating rod \( 6 \) to reverse selector lever with retainer spring \( 5 \). Place selector levers in neutral.

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

4. With pin engaged, tighten attaching screws \( 7 \) to required torque.

---

**Back-up Switch Assembly Procedure**

1. Attach switch \( 1 \) to back-up switch \( 1 \) with retainer spring \( 5 \) & loose assemble switch \( 1 \) to mounting bracket \( 4 \) with attaching screws \( 7 \).

   **NOTE** With RPO L48 loose assemble switch \( 1 \) & shield \( 8 \) to mounting bracket with attaching screws \( 7 \).

2. Attach subassembly to transmission with cover bolts & attach activating rod \( 6 \) to reverse selector lever with retainer spring \( 5 \). Place selector levers in neutral.

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

4. With pin engaged, tighten attaching screws \( 7 \) to required torque.
ASSEMBLY INSTRUCTIONS
1963 CAMARO 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 | CONTROL LINKAGE ADJUSTMENT
A8 | CONTROL LEVER & BRACKET (RPO D55)
A9 | CONTROL CABLE (RPO D55)
A10 | NEUTRAL SAFETY & BACK-UP LAMP SWITCH
A11 | NEUTRAL SAFETY & BACK-UP LAMP SWITCH (RPO D55)
A12 | THROTTLE CONTROL & MODULATOR PIPE (L-6 ENGINE)
A13 | THROTTLE CONTROL (V-8 ENGINE)
A14 | MODULATOR PIPE (V-8 ENGINE)
A15 | TRANS. TO CARB. LINKAGE ADJUSTMENT (L-6 ENGINE)
A16 | TRANS. TO CARB. LINKAGE ADJUSTMENT (V-8 ENGINE)
A17 | OIL COOLER PIPES
A18 | BRAKE PEDAL
A19 | THROTTLE VALVE CONTROL, SPLASH SHIELD & COVER
A20 | AIR CLEANER, HEAT STOVE & TUBE (L-6 ENGINE)
A21 | AIR CLEANER, HEAT STOVE & TUBE (V-8 ENGINE)
A22 | IDLE STOP SOLENOID (L-6 ENGINE)
A23 | IDLE STOP SOLENOID (V-8 ENGINE)

V.I.N. LOCATION-SEE UPC 0, SHEET B2 FOR SPECS.
NOTE: The following components are not illustrated in this R.P.O. See Parts List or Bill of Materials for part numbers.

UPC 4
- REAR SUSPENSION
- REAR AXLE
- REAR SPRINGS

UPC 6
- ENGINE
- ENGINE (As shipped)
- CRANKSHAFT BALANCER
- FAN & DRIVE
- CARBURETOR
- AIR COMPRESSOR (Sticker)
- GENERATOR & REGULATOR
- DISTRIBUTOR

Assembles same as production. See Parts List or Bill of Materials for part numbers.
ASSEMBLY INSTRUCTIONS

1968 CAMARO 12000 SERIES

1. 3895208 RETAINER
2. 9420587 SCREW
3. 3895209 DIAL
4. 7803775 COLUMN ASM

5. 3928323 LEVER
6. 274004 BULB
7. 3903400 CAP-QUADRANT LAMP
8. 3925885 CAP

STRG WHEEL - SEE UPC 9
DIR. SIG. SWITCH - SEE U.P.C. 12

PROD. PIN - SEE UPC 7
PROD KNOB - SEE UPC 7

10-20 LBS. IN.

# CHEVROLET MOTOR DIVISION, GMC

AUTO TRANS-DIAL INDICATOR & CONTROL COLUMN

M35

A3

DATE SYM

PHS4169A1
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".
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, on 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**

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<td>SCREW ASM.</td>
<td></td>
</tr>
<tr>
<td>3924779</td>
<td>UNDERPAN (EXC. RPO L48)</td>
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</tr>
<tr>
<td>3831527</td>
<td>(RPO L48)</td>
<td></td>
</tr>
<tr>
<td>3799830</td>
<td>BOLT</td>
<td></td>
</tr>
</tbody>
</table>
ASSEMBLY INSTRUCTIONS

3918855

1968 CAMARO 12000 SERIES

1. 3920215 ROD
2. 3792168 BUSHING
3. 3685801 LOCK-Bend straight at assembly
4. 3749084 RETAINER
5. 3895294 ROG
6. 3852837 GROMMET
7. 9419402 SCREW ASM.
8. 103321 L., WASHER
9. 382105 P. WASHER
10. 3895290 LEVER-IDLER

ROD BUSHING LOCK-Bend straight at assembly
RETAINER GREASE 0066 LBS.
ROD NUT WASHER LEVER-IDLER

VIEW A

BOTH ENDS

16-26 LBS.FT.
120-180 LBS.IN

* CHEVROLET MOTOR DIVISION. GMC *

AUTO. TRANS. -CONTROL LINKAGE

M35

A 6

UPC

DATE

SYN

REVISION RECORD

AUTH.

R: D. C.

M. 0 12000

DWG 5-24-67 AM REF A6

REF 6-4-68 C1

L-64160 L-

M35 399243 ROD

SHEET 1

329
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

3918855

1968 CAMARO 12000 SERIES

1. 3920267 CONTROL LEVER & BRACKET ASM.
2. 9417950 BOLT
3. 103320 L. WASHER
4. 3792287 NUT

110-150 LBS IN.

1/4" DIA HOLE IN UNDERBODY AT EXISTING DIMPLE

5/16" DIA (3) HOLE IN UNDERBODY AT EXISTING DIMPLES
1. 564708 RETAINER
2. 1382792 PIN
3. 3932732 CABLE ASM.
4. 476737 SPRING
5. 3922581 BRACKET
6. 3922549 SCREW ASM.
7. 9419234 P. WASHER
8. 9418931 NUT

**ASSEMBLY INSTRUCTIONS**

**NOTE** With range selector outer lever in drive position, adjust [2] to this dimension prior to installation of [3].
ASSEMBLY INSTRUCTIONS

1968 CAMARO 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. Install attaching screws and torque to specifications.

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. Install attaching screws and torque to specifications.

4. Remove pin.

A - 12-18 LBS, IN

RECOMMENDED INSPECTION PROCEDURE

A. Position gear shift lever in "P" detent.
B. Turn ignition switch to "start"; starter should operate but the vehicle must NOT move.
C. Position gear shift lever to "R" detent.
D. Move selector toward "N" to remove play, but DO NOT MOVE out of detent.
E. Turn ignition switch to "start"; starter must be INOPERATIVE.
F. Move selector toward "P" to remove play, but DO NOT MOVE out of detent.
G. Turn ignition switch to "start"; starter must be INOPERATIVE.
H. Position gear shift lever in "N" detent.
I. Turn ignition switch to "start"; starter should operate but the vehicle must NOT move.
J. Position gear shift lever to "D" detent.
K. Move selector toward "N" to remove play, but DO NOT MOVE out of detent.
L. Turn ignition switch to "start"; starter must be INOPERATIVE.
M. Move selector toward "L" to remove play, but DO NOT MOVE out of detent.
N. Turn ignition switch to "start"; starter must be INOPERATIVE.
O. Position gear shift lever to "L" or "L2" detent.
P. Turn ignition switch to "start"; starter must be INOPERATIVE.
Q. Position gear shift lever to "L" detent.
R. Turn ignition switch to "start"; starter must be INOPERATIVE.
1968 CAMARO 12000 SERIES

ASSEMBLY INSTRUCTIONS

INSTALLATION PROCEDURE

1. Position Control Lever & Bracket Assm. in "DRIVE".
2. Assemble Switch Assm. to Control Lever by inserting drive tang into hole in Neutral Safety Switch Lever. See View A.
3. Tighten screws using recommended torque.

INSTALLATION OF SWITCH IF PIN HAS BEEN SHEARED

1. Same as above.
3. Assemble Switch Assm. to Control Lever by inserting drive tang into hole in Neutral Safety Switch Lever. See View A.
4. Tighten screws using recommended torque.
5. Remove pin.

RECOMMENDED INSPECTION PROCEDURE

A. Position gear shift lever in "P" detent.
B. Turn ignition switch to "start"; starter should operate but the vehicle must NOT move.
C. Position gear shift lever to "N" detent.
D. Move selector toward "N" to remove play, but DO NOT MOVE out of detent.
E. Turn ignition switch to "start"; starter must be INOPERATIVE.
F. Move selector toward "P" to remove play, but DO NOT MOVE out of detent.
G. Turn ignition switch to "start"; starter must be INOPERATIVE.
H. Position gear shift lever in "N" detent.
I. Turn ignition switch to "start"; starter should operate but the vehicle must NOT move.
J. Position gear shift lever to "D" detent.
K. Move selector toward "N" to remove play, but DO NOT MOVE out of detent.
L. Turn ignition switch to "start"; starter must be INOPERATIVE.
M. Move selector toward "L" to remove play, but DO NOT MOVE out of detent.
N. Turn ignition switch to "start"; starter must be INOPERATIVE.
O. Position gear shift lever to "L" or "L3" detent.
P. Turn ignition switch to "start"; starter must be INOPERATIVE.
Q. Position gear shift lever to "L" detent.
R. Turn ignition switch to "start"; starter must be INOPERATIVE.

20-30 lbs. in.
NOTE! Bottom hose against modulator body.

NOTE! Bottom shoulder against modulator extension.
MODULATOR ASM.  

**NOTE:** Bottom shoulder against connector extension.

**NOTE:** Bottom hose against connector body.

100-125 LBS. IN. *  
* Plus torque required to align connector.
LINKAGE ADJUSTMENT PROCEDURE

1. With accelerator pedal depressed, Bell Crank (A) must be in wide open throttle position.
2. Transmission Lever (B) must be against internal stop.
3. Adjust swivel on Throttle Valve Rod (C) at Bell Crank (A).
ASSEMBLY INSTRUCTIONS

1968 CAMARO 12000 SERIES

PROD ACCELERATOR ROD
- SEE UPC 6 FOR ADJUSTMENT

LINKAGE ADJUSTMENT PROCEDURE

1. With accelerator pedal depressed, Carburetor Lever (D) must be in wide open throttle position.

2. Dash Lever (A) must be .09-.12 clearance from Pedal Support (B) as shown and Transmission Lever (C) must be against internal stop.

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

---

CHEVROLET MOTOR DIVISION, GMC

AUTO. TRANS.-TRANS. TO CARB. LINKAGE ADJUSTMENT

12000 V-8 ENGINE

UPC M35 A17

DATE 5/74

REVISED RECORD/REDESIGNED

AUTH. DB CK

340
ASSEMBLY INSTRUCTIONS

1968 CAMARO 12000 SERIES

1. 3010174 BODY ASM-RADIATOR L-6
   3010172 RPO L22
   3010176 V-6 ENG.
   3016782 RPO L30 & L48
2. 3710497 CLIP
3. 3901307 PIPE ASM.-OUTLET
4. 3901309 PIPE ASM.-INLET

VIEW A
(L-6 ENG ONLY)

1. LOCATE MIDWAY BETWEEN BENDS AS SHOWN
2. LOCATE APPROX 2 INCHES FROM BEND AS SHOWN.
3. .38 MINIMUM TO ENGINE MOUNT

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

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

115-135 LBS. IN.

CHEVROLET MOTOR DIVISION, GMC

AUTO. TRANS.-OIL COOLER PIPES

M35

A18
1 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 RPO J52
PEDAL ASM-BRAKE

BRAKE PEDAL BRKT.
ASM.—SEE U.P.C.S.

BRAKE CYLINDER PUSH ROD—SEE U.P.C.S.
NOTE: Staples to be installed in direction shown & must not cut through rubber extension.

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

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

NOTE: Splash shield extension must bend outboard when assembled.
Solenoid & Carburetor Adjustment

1. Install Solenoid Bracket (Item 4) to inlet manifold.
2. Set the carburetor in the closed throttle position with the choke completely off.
3. With Solenoid Energized (power on) slide into Bracket so the Solenoid plunger just slightly contacts the carburetor lever. Tighten the bracket strap to secure the Solenoid in place.
4. Back Adjusting Screw (A) out 1/2 turn (counter-clockwise) this results in a clearance between the Adjusting Screw and its stop on the lever of approximately .018.

NOTE: The above adjustment should produce an engine idle speed of approximately 400 RPM when the Solenoid is DE-ENERGIZED (power removed).

Bend clip after wire has been inserted.

15-30 LBS FT
15-25 LBS IN
40-55 LBS IN
38-50 LBS IN.
NOTE! For rear trans. mounting—See UPC 6.

NOTE! For seat separator parts & installation. See RPO D55.
The following components are not illustrated in this R.P.O. See Parts List or Bill of Materials for part numbers.

<table>
<thead>
<tr>
<th>UPC 3</th>
<th>FRONT SUSPENSION</th>
</tr>
</thead>
<tbody>
<tr>
<td>3F</td>
<td>FRONT SHOCK ABSORBERS-3</td>
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<thead>
<tr>
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<th>REAR SUSPENSION</th>
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<tbody>
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<td>REAR AXLE-3</td>
</tr>
<tr>
<td>4A4</td>
<td>PROPELLER SHAFT &amp; UNIVERSAL JOINT-3</td>
</tr>
<tr>
<td>4E</td>
<td>REAR SHOCK ABSORBERS-Assembles same as RPO L35</td>
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<tr>
<th>UPC 5</th>
<th>BRAKES</th>
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<tr>
<td>5C</td>
<td>SERVICE BRAKE PEDAL-Assembles same as RPO M35</td>
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</table>

<table>
<thead>
<tr>
<th>UPC 6</th>
<th>ENGINE</th>
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<tr>
<td>6</td>
<td>ENGINE (As Shipped)-3</td>
</tr>
<tr>
<td>6L</td>
<td>INTAKE &amp; EXHAUST MANIFOLDS &amp; HEAT CONTROL-Assembles same as RPO M35</td>
</tr>
<tr>
<td>6M1</td>
<td>CARBURETOR-Assembles same as RPO L34</td>
</tr>
<tr>
<td>6Q</td>
<td>POWER PLANT TO FRAME MOUNTING-3</td>
</tr>
<tr>
<td>6T</td>
<td>AIR COMPRESSOR (Sticker)-3</td>
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<td>6Y3</td>
<td>DISTRIBUTOR-3</td>
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<tr>
<th>UPC 7</th>
<th>TRANSMISSION</th>
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<tbody>
<tr>
<td>7A</td>
<td>TRANSMISSION EXTERNAL CONTROLS (Dial)-Assembles same as RPO M35</td>
</tr>
<tr>
<td>7B1B</td>
<td>CLUTCH &amp; CONTROLS-Assembles same as RPO M35</td>
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<table>
<thead>
<tr>
<th>UPC 9</th>
<th>STEERING</th>
</tr>
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<tbody>
<tr>
<td>9A</td>
<td>STEERING GEAR &amp; COLUMN-Assembles same as RPO M35</td>
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<tr>
<th>UPC 12</th>
<th>ELECTRICAL</th>
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<tr>
<td>12H</td>
<td>FUSES, BULBS &amp; MULTI-PURPOSE WIRING-Assembles same as RPO M35</td>
</tr>
<tr>
<td>12J</td>
<td>INSTRUMENT CARRIER PANEL &amp;/OR INSTRUMENTS-3</td>
</tr>
</tbody>
</table>

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

FRAME

EXISTING PARTS

EXISTING BOLT

\[ 25-35 \text{ LBS. FT.} \]

M 40

A3

3 SPD. AUTO. TRANS.

SUPPORT ASM.

12000 RPO L35

DATE/REV: 6/6

REF: A12

L-83666, L-50087

AUTH: DR CE
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 LBS. IN.
50-65 LBS. FT.
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".

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

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

NOTE: With range selector outer lever in drive position, adjust \( \text{[7]} \) to this dimension prior to installation of cable.

1. LEVER
2. NUT
3. RETAINER
4. BRACKET
5. SCREW ASM.
6. P. WASHER
7. PIN

VIEW A

SEE RPO M35

20-30 LBS. FT.
120-180 LBS. IN.
ASSEMBLY INSTRUCTIONS

1968 CAMARO 12000 SERIES

SCREW ASM.
BRACKET
SWITCH ASM.
LEVER (Ident color-Dark Green)

NOTE: Attach with front of bracket parallel to raised surface of carburetor.

ROCHESTER CAR
OPT. CARB

CABLE ATTACHING NUT

CABLE, THROTTLE LEVER

PLUNGER PART OF SWITCH ASM.

PADDLE- PART OF THROTTLE LEVER

.23 & .01 GAP

TRANS, 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 the required gap between switch plunger & lever paddle. Then tighten switch attaching screws to recommended torque.

Allow carburetor lever to return to the closed position.
3013685 BODY ASM.-RADIATOR
3710497 CLIP
3912614 PIPE ASM-INLET
3912615 PIPE ASM-OUTLET

1.06 ± .12 TO FAN SHROUD

MODULATOR ASM.-PART OF TRANS ASM.

WASHER & CONNECTOR-(Part of trans. asm)

115-135 LBS. IN.
ASSEMBLY INSTRUCTIONS

1968 CAMARO 12000 SERIES

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<td>DUAL EXHAUST-MUFFLER ASM, TAIL PIPE &amp; HANGER</td>
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<td>DUAL EXHAUST-MANIFOLD ATTACHMENT</td>
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<td>DUAL EXHAUST-EXHAUST, MUFFLER &amp; TAIL PIPE CHECKING DIMENSIONS</td>
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<tr>
<td>A3</td>
<td>DUAL EXHAUST-REAR EXHAUST PIPE &amp; HANGERS</td>
<td></td>
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</tbody>
</table>

DUAL EXHAUST CONTENTS

MODEL 12400

DRAWN 5-22-68  REF L L
REVISED 6-3  A4 L L L

* CHEVROLET MOTOR DIVISION, GMC *

UPC

DATE SYM REVISION RECORD AUTH. L clk

NF2

A1

SHEET

358
Dimensions indicated are reference, reflecting nominal design clearance variation of more than .25 from this dimension indicates a quality deficiency.
ASSEMBLY INSTRUCTIONS

3918855 1968 CAMARO 12000 SERIES

1. 3930085-6 EXHAUST PIPE-RR L. & R. H.
2. 3867096 "U" BOLT
3. 3922549 SCREW ASM-R. H.
4. 3848156 "U" BOLT
5. 3848157 CLAMP
6. 1359887 NUT
7. 3930087 HANGER ASM
8. 3928339 CLAMP
9. 3908362 CLAMP
10. 3908363 "U" BOLT
11. ALL dimensions indicated are reference reflecting nominal design clearance. Variation of more than .25 from this dimension indicates quality deficiency in a component part.
12. See UPC 0 Sheet A6 for proper clamp location.
13. 52 SEALER-GREASE Approx. .50 OZ.

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

DUAL EXHAUST-REAR EXHAUST PIPE & HANGERS

BILL OF MATERIALS

<table>
<thead>
<tr>
<th>ITEM</th>
<th>DESCRIPTION</th>
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<tr>
<td>3930085-6</td>
<td>EXHAUST PIPE-RR L. &amp; R. H.</td>
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<tr>
<td>3867096</td>
<td>&quot;U&quot; BOLT</td>
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<tr>
<td>3922549</td>
<td>SCREW ASM-R. H.</td>
</tr>
<tr>
<td>3848156</td>
<td>&quot;U&quot; BOLT</td>
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<tr>
<td>3848157</td>
<td>CLAMP</td>
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<tr>
<td>1359887</td>
<td>NUT</td>
</tr>
<tr>
<td>3930087</td>
<td>HANGER ASM</td>
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<tr>
<td>3928339</td>
<td>CLAMP</td>
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<tr>
<td>3908362</td>
<td>CLAMP</td>
</tr>
<tr>
<td>3908363</td>
<td>&quot;U&quot; BOLT</td>
</tr>
</tbody>
</table>

NOTES:

- Apply to full I.D. of muffler inlets prior to asm with rear exhaust pipe.
- 52 SEALER-GREASE Approx. .50 OZ.
ASSEMBLY INSTRUCTIONS

1968 CAMARO 12000 SERIES

HANGER ASM. L.H.  
SCREW  
PIPE L.H.  
CLAMP  
MUFF. ASM. & TAIL PIPE  
SEALER GREASE.  
Approx .50 oz.

1362006 CLAMP  
3818073 RIV NUT-L.H. (COUPE)  
9409107 SCREW-L.H. (COUPE)  
See UPC 0 Sheet A6 for proper clamp location.

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

Variation of more than .25 from this dim. indicates quality deficiency in a component part.

10.88 11.06

NOTE: Rear spring edge, full jounce.

NOTE: Clinch prior to assembly of 1 or 13 in position 12.

CIA (2) HOLES-COupe

CIA (2) HOLES-CONV IN CIPPLES

VIEW A  
VIEW B

PROD. HANGER & ATTACHING BARTS  
L. RH-CONV  
R. RH-COUPE

NOTE: Rear spring edge, full jounce.

NOTE: Clinch in position 1 or 13.

CIA (2) HOLES-COupe

CIA (2) HOLES-CONV IN CIPPLES

VIEW A  
VIEW B

86 - 108 LBS IN.

55 - 70 LBS IN.

CHEVROLET MOTOR DIVISION, GMC

* DUAL EXHAUST-MUFFLER ASM. TAILPIPE & HANGERS

UPC  
NE2

DATE SHEET

REV.

AUTH. DR. CR

361
ASSEMBLY INSTRUCTIONS

1. 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: All dimensions are measured from surface of muffler bead.

NOTE: Tail pipe measured from R.H. side of muffler.

MUFFLER BEAD

13.17 REF

21.76 L.H.

2.39 L.H

19.89 L. & R.H.

37.17 L.H.

1.57 L. & R.H.

.06 L.H.

11.70 L.H.

3918855

1968 CAMARO 12000 SERIES
ASSEMBLY INSTRUCTIONS

SHEET TITLE

A1 CONTENTS
A2 DUAL EXHAUST-MANIFOLD ATTACHMENT
A3 DUAL EXHAUST-REAR EXHAUST PIPE & HANGERS

SHEET TITLE

A4 DUAL EXHAUST-MUFFLER ASM, TAIL PIPE & HANGER
A5 DUAL EXHAUST-EXHAUST, MUFFLER & TAIL PIPE CHECKING DIMENSIONS

CANCELED
ASSEMBLY INSTRUCTIONS
1968 CAMARO 12000 SERIES

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

PRODUCTION TRANS (3 SPEED)

CONTROL ROODS

CORKON SHAFT ASSY

ATTACHING PARTS SAME AS PROD V-8 ENG.

OIL FILTER

REINFORCEMENT (CANV ONLY)

4 SPEED TRANS. CONTROL ROD

TRANSMISSION SUPPORT

DUAL EXHAUST-MANIFOLD ATTACHMENT

N 10

A 2

CHEVROLET MOTOR DIVISION, GMC

DUAL EXHAUST-MANIFOLD ATTACHMENT

N 10

A 2

CHEVROLET MOTOR DIVISION, GMC

DUAL EXHAUST-MANIFOLD ATTACHMENT

N 10

A 2

CHEVROLET MOTOR DIVISION, GMC

DUAL EXHAUST-MANIFOLD ATTACHMENT

N 10

A 2

CHEVROLET MOTOR DIVISION, GMC

DUAL EXHAUST-MANIFOLD ATTACHMENT

N 10

A 2

CHEVROLET MOTOR DIVISION, GMC

DUAL EXHAUST-MANIFOLD ATTACHMENT

N 10

A 2

CHEVROLET MOTOR DIVISION, GMC

DUAL EXHAUST-MANIFOLD ATTACHMENT

N 10

A 2

CHEVROLET MOTOR DIVISION, GMC

DUAL EXHAUST-MANIFOLD ATTACHMENT

N 10

A 2

CHEVROLET MOTOR DIVISION, GMC

DUAL EXHAUST-MANIFOLD ATTACHMENT

N 10

A 2

CHEVROLET MOTOR DIVISION, GMC

DUAL EXHAUST-MANIFOLD ATTACHMENT

N 10

A 2

CHEVROLET MOTOR DIVISION, GMC

DUAL EXHAUST-MANIFOLD ATTACHMENT

N 10

A 2

CHEVROLET MOTOR DIVISION, GMC

DUAL EXHAUST-MANIFOLD ATTACHMENT

N 10

A 2
All dimensions indicated are reference reflecting nominal design clearance; variation of more than .25 from this dimension indicates quality deficiency in a component part.

1. 3930085-6 EXHAUST PIPE-REAR L. & R.H.
2. 3934861-2 HANGER ASM. L. & R.H.
3. Support R.H.
4. 3930032 SUPPORT R.H.
5. 3922549 SCREW ASM. R.H.
6. 3928339 "U" BOLT CLAMP
7. 3867096 "U" BOLT
8. 1359887 NUT
9. 13930032 SUPPORT R.H.
10. 3908362 CLAMP
11. 3908363 "U" BOLT
12. "U" Bolt to be over end of slots on muffler & rear exhaust joints.
13. 52 SEALER-GREASE
    Approx. .50 oz.
14. See UPC 0 Sheet A6 for proper clamp location.

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

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

NOTE Apply to full L.D. of rear exhaust pipe prior to assembly of resonator.
ASSEMBLY INSTRUCTIONS

1968 CAMARO 12000 SERIES

3. SCREW 3918855
   4. HANGER ASM. L.H.
   5. SCREW 3932749
   6. PIPE L.H.
   7. CLAMP 3848157
   8. NUT 1359887
   9. MUFF. ASM. & TAIL PIPE 3932743

SEALER-Grease approx. .25 oz. Apply to full I.D. of muffler asm. to pipe.

NOTE Rear spring edge, full jounce.

NOTE Clinch in position prior to assembly of or 13.

See UPC 0 Sheet A6 for proper clamp location.

UPC 010440 N10 A4

DUAL EXHAUST-MUFFLER ASM TAILPIPE & HANGERS

3. 1 9419400 SCREW
   2. 3932749 HANGER ASM. L.H.
   3. 9424814 SCREW
   4. 3932745 PIPE L.H.
   5. 3848157 CLAMP
   6. 1359887 NUT
   7. 3932743 MUFF. ASM. & TAIL PIPE
   8. 52 SEALEC-Grease approx. .25 oz. -

Apply to full L.D. of muffler asm. to pipe.

All dim. indicated are ref. reflecting nomina. design clearance. Variation of more than .25 from this dim. indicates quality deficiency in a component part.

See UPC 0 Sheet A6 for proper clamp location.
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 All dimensions are measured from surface of muffler bead.

MUFFLER BEAD

13.17 REF

21.76 L.H.

1.57 L & R.H.

37.17 L.H.

2.39 L.H

19.89 L & R.H.

.06 L.H.

11.70 L.H.

NOTE Tail pipe measured from R.H. side of muffler.

C1

DUAL EXHAUST - EXHAUST, MUFFLER & TAIL PIPE CHECKING DIMENSIONS

12400

1968 CAMARO 12000 SERIES

NOTE: All dimensions are measured from the surface of the muffler bead.
ASSEMBLY INSTRUCTIONS

3918855

1968 CAMARO 12000 SERIES

1 3925148 EMBLEM
   3925881 RPO L35, L34, L48 & L78
2 9748911 SHROUD CHART
3 9745802 SCREW
4 9747688 STEERING WHEEL CHART
5 9411468 NUT

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

PRODUCTION ATTACHING PARTS

DELUXE STEERING WHEEL

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368
NOTE | Cut .2 in. off the top of cover before installing same on turn signal switch lever.

30-40 LBS. IN.
10-14 LBS. IN.
HYDRAULIC STEERING-PUMP MOUNTING WITH RPO M35

12000 L-6 ENGINE

UPC | N40
---|---
A3 |

DATE | SYM | REV
---|---|---
5-12-67 | 1 | SYMBOL 12D WAS SYMBOL 9A
1-28-67 | 2 | SYMBOL 2 WAS SYMBOL 10
2-4-67 | 3 | SYMBOL 2 WAS SYMBOL 10
2-28-67 | 4 |

CHECKSHEET

12D

20-30 LBS. FT.
100-140 LBS. IN.
15-24 LBS. FT.
15-20 LBS. FT.

PUMP ASM.
NUT
L. WASHER
WASHER
BOLT
WASHER
L. WASHER
NUT
BRACE

STUD
BOLT
BRACKET
SUPPORT
BOLT
BOLT
NUT
FLUID-AUTO. TRANS., 285 GAL.

1968 CAMARO 12000 SERIES

ASSEMBLY INSTRUCTIONS

3918855

1 780514 PUMP ASM.
2 9418931 NUT
3 103312 L. WASHER
4 9419234 WASHER
5 3826839 BOLT
6 3852446 WASHER
7 103210 L. WASHER
8 9417954 NUT
9 3834446 BRACE
10 3904180 STUD
11 9419051 BOLT
12 3877430 BRACKET
13 3891998 SUPPORT
14 3852856 BOLT
15 9419064 BOLT
16 942277 NUT
17 12D FLUID-AUTO. TRANS., 285 GAL.
ASSEMBLY INSTRUCTIONS

1968 CAMARO 12000 SERIES

1. 7800515  PUMP ASM.
2. 3905366  BRACE
3. 3786494  SCREW
4. 120377   NUT
5. 9418931  RPO L34-L35-L78
6. 103331   L. WASHER
7. 120394   WASHER
8. 3941114  BRACKET
9. 180320   BOLT
10. 9418967 RPO L34-L35-L78
11. 454906  BOLT
12. 3918855  FLUID-AUTO. TRAN. .288 GAL.

1. 9418823  BOLT
2. 3892698  BRACKET ASM.
3. 3896900  BRACE

NOTE: Slide forward to contact rear of pump before tightening eng mount screws.

**CHEVROLET MOTOR DIVISION, GMC**

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| REF: A4 | L-78997 L- |

* SHEET
1. Install hose parallel with top surface of crossmember.

2. Position pressure & return hoses 0° on steering gear centerline.

ASSEMBLY INSTRUCTIONS

CLAMP

HOSE (To gear outlet) L-6 ENG.

CLAMP SLEEVE

PIPE ASM L-6 ENG.

HOSE ASM (To gear inlet) L-6 ENG.

HOSE ASM (To gear inlet) V-8 ENG.

Pipe ASM V-8 ENG.

NOTE: Install hose parallel with top surface of crossmember.

NOTE: Position pressure & return hoses 0° on steering gear centerline.
Installation covered elsewhere in this group.

NOTE: Position pressure & return hoses 0° on steering gear centerline.
ASSEMBLY INSTRUCTIONS
1968 CAMARO 10000 SERIES

1. 3845642 BELT-A.L.R. PUMP
2. 3880866 PULLEY-STEERING PUMP
3. 3791943 RPO M35
4. 3850994 BELT-STEERING PUMP
5. 3845648 RPO M35
6. 1100813 GEN ASM. RPO M35
7. 3790337 PULLEY-CRANKSHAFT RPO M35
8. 3900434 PULLEY-WATER PUMP RPO M35

BELT STRAND TENSION SEE UPC 6

BELT-A.L.R. PUMP
PULLEY-STEERING PUMP
RPO M35
BELT-STEERING PUMP
RPO M35
GEN ASM. RPO M35
PULLEY-CRANKSHAFT RPO M35
PULLEY-WATER PUMP RPO M35

BELT STRAND TENSION SEE UPC 6

50-65 LBS FT

UPC

DATE SYM

REVISION NO.

AUTH

A40

1. REDRAWN

7-1-67

C+D

2. ITEM B C FORCING ADDED

7-1-67

C+D

3. 1100813 WAS 1770

7-1-67

C+D

4. TORQUE WAS 50.7 NL

7-1-67

C+D

5. 1800246 WAS 1800866

7-1-67

C+D

A7

1968 CAMARO 10000 SERIES

HYDRAULIC STEERING
BELTS - PULLEYS

12.0 - L-6 ENGINE

DATE

REF. PRL

PLT

CAT

M0

3-76
ASSEMBLY INSTRUCTIONS

1. 3880886 PULLEY STEERING PUMP
   3791943 RPO M35
2. 3845642 BELT AIR PUMP
3. 3850994 BELT STEERING
   3845648 RPO M35
4. 1100817 GENERATOR ASM. RPO M35
5. 3850803 BELT, FAN & GEN RPO M35
6. 3784349 SCREW ASM.
7. 3876872 PULLEY CRANKSHAFT RPO M35
8. BELT STRAND TENSION - See UPC 6
   3824475 NUT

- HYDRAULIC STEERING BELTS & PULLEYS
- 12000 L-6 ENGINE WITH RPO C60

21-30 LBS. FT
50-65 LBS. FT.

- MANUAL TRANS
- PULLEY, BELT & SCREW (SEE RPO C60)

- AUTO TRANS
- FAN & CLUTCH
- AIR PUMP
- COMPRESSOR ASM.
ASSEMBLY INSTRUCTION

1968 CAMARO 12000 SERIES

1 3848263 BELT STEERING PUMP
   3863114 RPO'S L34, L35 & L78
   3874424 RPO L48
   3927158 RPO Z28

2 3860457 PULLEY - STEERING PUMP
   3873847 RPO'S L35, L78 & Z28
   3770509 RPO L48

3 3751232 PULLEY - CRANKSHAFT
   3874416 RPO L34
   3899978 RPO'S L35 & L78
   3916385 RPO Z28

4 3824475 NUT

50 - 65 LBS FT

50 - 65 LBS FT

INSTRUCTION

1 3927158 NUT
2 3916385 RPO Z28
3 3824475 BELT STEERING PUMP
4 3899978 RPO'S L35 & L78
5 3874416 PULLEY - CRANKSHAFT

HOLE 1216 LBS FT

HYDRAULIC STEERING
BELTS & PULLEYS

N40

12400 V-8 ENGINE

A9

DATE

1967

DRAWN

REV. 1

DATE

1967

DRAWN

REV. 1
**ASSEMBLY INSTRUCTIONS**

**1968 CAMARO 12000 SERIES**

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**HYDRAULIC STEERING BELTS & PULLEYS**

- 12400 V-8 ENGINE WITH RPO C60
- SWG 7/36"-7/36"-7/36"-7/36"-7/36"-7/36"-7/36"-7/36"-7/36"
- N40 A10

**DRAWING**

**VIEW A AUTO TRANS**

**50 - 65 LBS.FT.**

**DATE**

- N40 A10

**REVISION HISTORY**

- 1/14 8 RPO L35 REMOVED
- 3/14 59 3925537 RPO’S L34&L35
- 7/14 ADDED
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 nut.

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

1968 CAMARO 12000 SERIES

1. 1980036 BATTERY
2. 6299196 CABLE ASM. (POSITIVE) L-6 ENG.
   PROD. CABLE V-8 ENG.
3. 2985649 CABLE ASM. (NEGATIVE) L-6 ENG.
   PROD. CABLE V-8 ENG.

FENDER REINF

PROD JUNCTION BLOCK

TO RADIATOR SUPPORT GROUND

RADIATOR SUPPORT

PROD WASHER

PROD CLIP

HEAVY DUTY BATTERY

12000

T60

A1
INSTRUCTIONS

3918855

1968 CAMARO 12000 SERIES

1 6295117 WIRE ASM.
2 9000268 HORN ASM.
3 6290552 WIRE ASM.
4 3853846 SCREW
5 3688003 WASHER

HOOD LATCH SUPPORT

RADIATOR SUPPORT

14-22 LBS. FT

LOW NOTE HORN

12337 - 437

DWG PRL: 5-4
DATE PRL: 6-24
REF: PRL A1

LOW NOTE HORN

U03

A1

1. 4295117 WIRE ASM
2. ITEM 5 ADDED

382
ASSEMBLY INSTRUCTION

1968 CAMARO 12000 SERIES

1. WIRE ASM
   - TAPE
     A. (4 in.) (2) places. Wire asm to inst panel harness.
     B. (4 in.) Loop & tape excess wire asm.

2. 6295111

3. 6480931  CLUSTER ASM
   6480941  RPO U17

4. 6454841  CABLE ASM

NOTE: Plug into fuse panel receptacle mark BAT. FUSED.

35-50 LBS. IN.
A1 CONTENTS

A2 CONSOLE CLUSTER WIRING

1. 6468713 TACH & CLOCK ASM.
2. 6468714 RPO L34, L35
3. 6468715 RPO L78 & Z28
4. 6480947 CLUSTER ASM.
5. 134530 NUT
6. 131014 P. WASHER

A3 FRT. WIRING & OIL PRESSURE HOSE

5. 6295093 PRINTED CIRCUIT
6. 447143 SCREW
7. 3794018 NUT
8. 3974017 KNOB
9. 9421330 BULB (LOW FUEL WARNING)
10. 2973932 SOCKET ASM.
11. 3884953 OPT.
12. 454626 BULB (INSTRUMENT CLUSTER)
13. 3882798 SOCKET

The following parts assemble same as RPO D55

3921825 SEAT SEPARATOR

- L. H. direction indicator
- R. H. direction indicator
- Brake warning indicator

CONNECTOR (PART OF INST PNL HARN)

25-35 LBS IN.
4-2 LBS IN.
1-2 LBS IN.

CHEVROLET MOTOR DIVISION, GMC

12000 V-8 ENGINE

FRT. COMPT. CONSOLE INSTRUMENT CLUSTER CONTENTS

UPC     DATE SYM   DIVISION ACCID   ALT. OR CR
U17     6-767     2     REMAINT & REDESIGNED 2222 C1
6-767    3     RPO LGB REMOVED 2222 C1
6-767    4     ITEMS 9,10,11 ADDED 2222 C1
12-6-79  5     VIEW A REVISED 2222 C1
11-14-67 6     ITEM 11 A REMOVED 2222 C1
11-14-67 7     ITEMS 16, 13 ADDED 2222 C1
11-14-67 8     VIEW A REVISED 2222 C1

A1

L-84617 L-
ASSEMBLY INSTRUCTIONS

1968 CAMARO 12000 SERIES

1. 6295063 HARNESS ASM.-INST. PNL.
   RPO M35

2. 6480874 CLUSTER ASM.

3. 6295115 HARNESS ASM.-CONSOLE RPO M35
   RPO M13, M21

4. 3925753 SCREW

5. 9417587 WASHER

6. 120614 NUT

7. 454626 BULB

NOTE: Route oil hose under mat.

EXCESS HOSE INSIDE CONSOLE.

10-20 LBS. IN.
25-35 LBS. IN.

VIEW A

HARNESS ASM.
(SEE SHT A3)
NOTE! For proper operation, lamp should turn off when lid is 12 in. ± 3 in. from the closed position when vehicle is on level ground.
ASSEMBLY INSTRUCTIONS

3918855

1968 CAMARO 12000 SERIES

SHEET CONTENTS
A1
A2 UNDERHOOD LAMP EQUIPMENT - RPO Z87

1 3916764 LAMP ASM.
2 9415191 SCREW ASM.
3 3724851 TAPE
   A-(6 in.) LAMP WIRE TO ENG.
   WIRING HARNESS
   B-(6 in.) LOOP & TAPE EXCESS
   LAMP WIRE TO FORWARD LAMP
   HARNESS
4 9422033 STRAP
5 3772788 CLIP

NOTE Bend lamp bracket if required for lamp to operate within the following range: 23.0 opening between hood
bumper & bumper striker area to normal open position.

120/124 DIA.
HOLDS

10 - 15 LBS. IN.

HORN RELAY

VIEW A

EXISTING HOLE

396 ENGINE
WITH RPO C60

VIEW B

L-6, 196, & V-8

FENDER REINFORCEMENT

396 ENGINE
3, VIEW B HOLED

U26

A1
1. Remove insulation within perforated outline.

LOCATION:
L-6 ENGINE,
396 ENG. WITHOUT RPO C60.

EXISTING PERFORATIONS IN INSULATOR

NOTE: Cut out this portion of insulator.

LAMP ASM Sheet A1

VIEW A
396 ENGINE WITH RPO C60
CONSOLE MOUNTED CLOCK (RPO D55)

**NOTE:** For clock asm. & attaching parts when installed to item 2 see UPC 0.

- **GRAY WIRE**
  - lamp feed
  - **NOTE:** Plug into fuse panel receptacle marked "LAMPS"

- **ORANGE WIRE**
  - power feed
  - **NOTE:** Plug into fuse panel receptacle marked "BAT. FUSED"

- **TAPE (4 in.) (3 PLACES) Wire asm. to dash & toe panel**
- **WIRE ASM. RPO D55**
- **NOTE:** Slit carpet (at bracket) to allow connectors thru.

- **NOTE!** Remove stamped outline from jute prior to installation of wire asm.

5-10 LBS. IN.
The following parts are released by Chevrolet & installed by Fisher Body:

1. 6295140 CONDUCTOR ASM. REAR
   6295141 CONDUCTOR ASM. REAR (CONVERTIBLE ONLY)
   3928738 SLEEVE
ASSEMBLY INSTRUCTIONS

3918855

TAPE
6 PCS 3 INCHES LONG USED TO TAPE FIBER OPTIC WIRES TO PARK LP. WRG. HARNESS

916897 LAMP ASM. L.H.
916898 R.H.
916203 L.H. RPO Z22
916204 R.H.

NUT

9419751

916897 Tape 3724851 Tape
L - 6 PCS 3 INCHES LONG USED TO TAPE FIBER OPTIC WIRES TO PARK LP. WRG. HARNESS

916898 Lamp ASM. L.H.
916899 R.H.
916203 L.H. RPO Z22
916204 R.H.

NUT

9419751

3905135 Seal
6295133-4 CONDUCTOR ASM. R. & L.H.

EXISTING 6 FT OF WIRE TO USEExisting Wire Harness

VIEW A L.H.

VIEW B R.H.

VIEW C

VIEW D

EXISTING LAMP HARNESS

EYELLET

EXISTING GROMMET

1 RPO Z22

2 RPO Z22 ONLY

10 - 15 LBS. IN.

1968 CAMARO 12000 SERIES

UPC: U46

DATE: 11-16-71

REV: 1 of 1

DRAWN: 11-12-71

CHECKED: S. W. BURGESS

CONDUCTOR ASM. R. & L.H.

CONDUCTOR ASM. R. & L.H.
TAPE
3 PCS 3 IN. LONG USED TO TAPE
TAIL STOP & LIC. LP. FIBER
OPTIC COND. & HSG. TO
TAIL LP. WIRING HARNESS

BULB
LAMP HOUSING

CONDUCTOR & HOUSING ASM
(FISHER BODY)

REAR END PANEL
CREASE LINE
7.75"
3918855 1968 CAMARO 12000 SERIES

Sheet Title
A1 CONTENTS
A2 PLAYER ASM, BRACKET
A3 PLAYER ASM, BRACKET RPO D55
A4 WIRING & CONVECTOR ASM.
A5 SPEAKER WIRING
A6 FRONT SPEAKERS & SYSTEM CHECK-OUT

1 Fader control asm. installs same as RPO U80
2 Rear speaker asm, grille, wiring & attaching parts are released by Chevrolet & installed by Fisher Body.
3 Stereo tape cartridge ref. UPC 0-Misc. shipping list.

STEREO TAPE-CONTENTS

- CHEVROLET MOTOR DIVISION, GMCo. -

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<td>A6</td>
<td>FRONT SPEAKERS &amp; SYSTEM CHECK-OUT</td>
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UPC: U57

DATE 12000

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ASSEMBLY INSTRUCTIONS

1968 CAMARO 12000 SERIES

1. 7306116 KNOB ASM.
2. 396987 NUT
3. 7301740 PLATE ASM.
4. 7307811 PLAYER ASM.
5. 7307831 RPO U79
6. 7301739 COVER ASM.
7. 9426773 SCREW
8. 9426552 SCREW
9. 7301751 BRACKET
10. 7302757 PLATE
11. 120622 NUT
12. 121752 L. WASHER
13. 9420146 SCREW
14. 4785334 CLIP
15. 3903474 PLATE

NOTE: Use bracket for template. Locate over ash tray screws and drill (2) .161/.165 DIA. holes in reinforcement.
- Tape player harness route is detailed in sheet A5.

Route tape player harness with existing harness.

For wire routing from this point forward, see sheet A5.

- Tape player harness uses existing screws.

- Use tape to connect stereo tape player to existing harness.

- Maintenance notes:
  - 12-27 lbs. in.
  - 30-40 lbs. in.
ASSEMBLY INSTRUCTIONS

3918855

1. 6290068 WIRE ASM-FRONT SPEAKER
2. 3747298 TAPE
   A. Used to tape excess fader control wires (without radio)
   B. (3 in) Used to tape radio connector to tape player connector (without radio)
3. BLACK & PURPLE WIRE (To R.H. Speaker)
4. BLACK & TAN WIRE (To L.H. Speaker)
5. REAR SPEAKER EXT ASM (Installed by Fisher Body)
6. SPEAKER CONNECTOR (From Tape Player)
7. RADIO CONNECTOR (Black wire)
8. POWER LEAD FROM BODY HARNESS (Yellow Wire)
9. TAPE PLAYER CONNECTOR (Red Wire)
10. FADER CONTROL (Green Wire)

NOTE: Position (1) stripe marker on wire asm. 1 in R.H. clip & (2) stripe marker in L.H. clip.

HOLE IN INSTRUMENT PANEL BRACE

EXISTING CLIPS (SEE NOTE)

STEREO TAPE-SPEAKER WIRING

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- CHEVROLET MOTOR DIVISION, GM

STereo Tape-SPEAKER WIRING

12000

DRAW 6-7-67 JP REF: A3 L-79185 L-
DATEREL 6-9 CI L L L L-

DARK BLUE

BROWN

EXISTING RR. SPEAKER WIRES
EXISTING REAR SPEAKER WIRES
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.
1 7276494 STATIC COLLECTOR ASM.

2 U69 Instruction sheet ref UPC 0-Misc.
Shipping List

NOTE Remove all grease from
grease retainer & lathe hole
before installing static collector

NOTE Bend cotter pin
back for clearance.
ASSEMBLY INSTRUCTIONS
1968 CAMARO 12000 SERIES

1 7298001 SPEAKER ASM.
2 3886998 TRIM PLATE
3 3916721 RETAINER
4 3927358 KNOB - TONE CONTROL
5 7278015 WASHER
6 3886997 TAG RPO U69
7 3897313 KNOB
8 7279805 NUT

EXISTING BRACKET
INDEX TAB
INDEX NOTCH
TRIM PLATE (REF. UPC 1)

10-15 LBS. IN.
25-35 LBS. IN.
45-60 LBS. IN.

- CHEVROLET MOTOR DIVISION, GM -
RADIO-RECEIVER & SPEAKER

U63 U69
A2

DATE 7-10-67
REVISION 11-30-61
AUTL 37653 4W/C1

SHEET 1
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.

25-35 LBS. IN.
ASSEMBLY INSTRUCTIONS

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. 1964082 CAPACITOR ASM

1968 CAMARO 12000 SERIES

L-6 ENGINE

V-8 ENGINE

\[\text{COIL}\]

\[\text{REGULATOR}\]

\[\text{EXISTING GROUND WIRE}\]

\[\text{EXISTING SCREW}\]

25-35 LBS. IN.
16-22 LBS. IN.
15-20 LBS. IN.

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ASSEMBLY INSTRUCTIONS

1968 CAMARO 12000 SERIES

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

NOTE: Untape blower feed & ground wire harness to this point as shown. (Approx. 9 in.)

NOTE: Modify capacitor as shown.
1. 6290315 STRAP ASM.

2. For hole piercing info, see UPC 0 Sheet A/3.

3. SCREW, SPARK PLUG WIRE SUPPORT & REINFORCEMENT - Part of engine asm.

4. 9420415 SCREW

5. Install ground strap under spark plug wire support.

A.R.H. ROCKER COVER

L.H. ROCKER COVER

---

**CHEVROLET MOTOR DIVISION, GMC**

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<td>RADIO-GROUND STRAPS (V-8 ENGINE TO BODY)</td>
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<td>9/29/67</td>
<td>1</td>
<td>ITEM 2 REVISED</td>
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**UPC: U63**

**DRAWING: 6-67**

**INDEX**: A6

**SHEET**: L-81/37 L-

---

25 LBS. IN MAX.

10-15 LBS. IN
For hole piercing info...
See UPC 0 Sheet A8.5
ASSEMBLY INSTRUCTIONS

3918855

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

9 51B ➔ .06 oz.

NOTE Antenna should lean inboard approx. 4° (Ref.) when viewed from front of car & stand vertically when viewed from side of car.

NOTE Assemble clips at both ends of glove box.

CAUTION Push connector all the way into antenna body until boot bottoms against antenna body. Do not twist cable asm. lead-in during assembly.

RADIO-FRONT ANTENNA

U63

U69

1/18/68 1 ITEM 9 ADDED 313 CB

313 CB 2 TORQUE (1) WAS 45-60 LBS IN 3/4/68 3 6 CB

CHEVERLET MOTOR DIVISION, GANC

U63

B1

SHEET X

1-10
ASSEMBLY INSTRUCTIONS
1968 CAMARO 12000 SERIES

1. Part the same as & installed the same as RPO U63
2. 3138635 GASKET
3. 3903424 BEZEL
4. 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.

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.

UPC
MANUAL ANTENNA EQUIP-REAR
U73
A1

- CHEVROLET MOTOR DIVISION, GMC -
Rear speaker asm., grille, wiring & attaching parts are released by Chevrolet & installed by Fisher Body.

Frt. speaker asm., grille, wiring & attaching parts install the same as RPO U57.
NOTE: Use bracket for template. Locate over ash tray screws, and drill (2) .161/.165 dia. holes in reinforcement.

INSTRUMENT PANEL CENTER & VACUUM CUP FROM SPEAKER BATTERY CONNECTOR

SPEAKER CONNECTOR WITH CUP

RECEIVER

ADAPTER CONNECTOR

RADIO CONNECTOR (BLACK + YELLOW STRIP)

GROUND WIRE CLIP

EXISTING SPEAKER EXTENSION CONNECTOR

INSTRUMENT PANEL CENTER BRACE

30-40 LBS IN

16-22 LBS IN

ADAPTER PLUG
**ASSEMBLY INSTRUCTIONS**

**1968 CAMARO 12000 SERIES**

- **1** 7305221 ADAPTER ASM.
- **2** 9420065 SCREW
- **3** 6295250 WIRE ASM.
- **4** 6295249 WIRE ASM.
- **5** 3943635 WEDGE
- **6** 3744771 TAPE (8 in.) Used to tape directional signal connector & excess wire to underside of adapter bracket.

**INSTRUMENT PANEL CENTER BRACE**

- **POWER FEED WIRE**
- **RADIO**
- **FM STEREO PLUG CONNECTOR**

**TO REAR SPEAKERS (FISHER BODY) TAPE**

**RADIO RECEIVER CONNECTOR**

**PEDAL BRACKET**

**NOTE** Position wedge rearward against screw.

**NOTE** Bend bracket to clear adapter.

**SEE SHEET A4**

**INSTRUCTIONS**

- Bend bracket to clear adapter.
- Position wedge rearward against screw.

**OPTIONS**

- WITH RPO C06 & C50

**TYPE**

- RADIO STEREO MULTIPLEX-ADAPTER

**UPC**

- U79

**DATE**

- 12000 RPO D55

**REF:

- 04817 L- 85489 L-

**DATE REL:

- 6-21

**AUTH:

- 9/24/76
ASSEMBLY INSTRUCTIONS
1968 CAMARO 12000 SERIES

1. 7298048  LENS ASM.
2. 9770546  NUT
3. 3897312  DECALCOMANIA
4. 9418502  SCREW
5. 7305321  CONTROL ASM.
6. 3283772  KNOB

Lens Assembly:
- Torque 1/2 lbs in.
- Torque 20-30 lbs in.
- Torque 5/10 lbs.

Control Assembly:
- Torque 1 lbs in.
- Torque 2 lbs in.
- Torque 3 lbs in.

For hole drilling, see RPO U57.

CONSOLE COMPARTMENT DOOR

1.00 DIA HOLE
71/8 DIA (4) Holes
PARALLEL TO CENTERLINE OF DOOR

VIEW C

SEE SHEET A3

RADIO STEREO MULTIPLEX-CONTROLS
U79
12000 RPO D55

UPC
DATE
SYN
MODIFICATION RECORD
AUTH
DR
CR

1/19/67 1  TORQUE 1 WAS 20-30 LBS IN
2  TORQUE 2 WAS 1-2 LBS IN
3  TORQUE 3 ADDED

10-19-67 4  ITEM 6 ADDED
18-28-76 5  CB GND WIRE 50
4  2.05 CMI ADDED

AUTH. NO 1
85/64 AG C1
9094 AG C1
2W
C1

415
The following parts are released by Chevrolet & installed by Fisher Body:

- 7300614  SPEAKER ASM
- 7296871  GRILLE
- 2988134  EXTENSION WIRE ASM
- 3909551  HOUSING ASM (CONV.)
- 7292636  STUD (CONV.)
- 7292635  SCREW (CONV.)
- 2989256  GROUND WIRE (CONV.)
1. FADER CONTROL KNOB ASM
   Part the same as & installed the same as RPO U63
2. HARNESS ASM

CAUTION Avoid crimping wires when installing thru opening in trim plate.

CAUTION Align locating pin with cutout in trim plate.

VIEW A

VIEW B

(U63 HARNESS ASM. ROUTING)

VIEW C

(U63 HARNESS ASM. ROUTING)
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
- **3893816** SHROUD L-6 (Same as V-8 prod)
- **3893832** BRACKET ASM. L-6 (Same as V-8 prod.)
ASSEMBLY INSTRUCTIONS
1968 CAMARO 12000 SERIES

SHEET  TITLE
A1 CONTENTS
A2 NON-ILLUSTRATED PARTS
A3 FENDER NAME PLATE, EMBLEM & MOLDING
A4 GRILLE & EMBLEM
A5 HEADLAMP BEZEL & PARKING LAMP

1 9417761 SCREW
2 3901349 CAP ASM. - GAS
3 3901350 ORNAMENT
4 3901374 WASHER
5 3901373 NUT

NOTE: With 2 in closed position, lettering on 3 must be perpendicular to ground.

HEADLAMP ASSEMBLY PROCEDURE

FENDER MOLDING (SEE RPO Z22)
NOTE: The following components are not illustrated in this R.P.O. See Parts List or Bill of Materials for part numbers.

UPC 11-13 SHEET METAL
11D HOOD
   (Hood lock catch)-3
11E MISCELLANEOUS FRONT END SHEET METAL PARTS-3
11G CHASSIS SHEET METAL ORNAMENTATION
   (Wheel moulding) - assemble same as RPO Z21

UPC 12 ELECTRICAL
12C FRONT LAMPS
   (Direction signal flasher)-3
12G HORN, SWITCH, WIRING & MOUNTING
   (Horn button cap)-3

1 Assembles same as production. See Parts List or Bill of Materials for part number.
3918855

1968 CAMARO 12000 SERIES

1. 916619-20 LAMP ASM. L. & R.H.
2. 3773683 SCREW
3. 3936500 BUMPER
4. 3898149-50 BEZEL L. & R.H.
5. 3859847 NUT
6. 9420554 SCREW

RALLY SPORT - HEADLAMP BEZEL & PARKING LAMP

10-15 LBS.IN.

GRILLE UPPER

VIEW A

ASSEMBLED

ASSEMBLY INSTRUCTIONS
### Assembly Instructions

#### 1968 Camaro 12000 Series

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<th>Item</th>
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<td>NUT</td>
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<td>2</td>
<td>GASKET-INNER</td>
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<td>3</td>
<td>GASKET-OUTER</td>
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<td>4</td>
<td>LAMP ASM L. &amp; R.H.</td>
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<td>5</td>
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**Diagram:**

- **GROMMET**
- **TAIL LAMP**

---

**Notes:**

- **35-50 LBS IN**

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**Revision History:**

- 1. ITEM(s) ADDED
- 2. WIRE DWG. REVISED

---

**Drawn by:**

- **Graphic Division, GM**

---

**Date:**

- **11/67**

---

**Checked:**

- **Z22**

---

**Approved:**

- **C1**

---

**Revision Code:**

- **C1**
ASSEMBLY INSTRUCTIONS

MARO 12000 SERIES

1 3925460  SUPPORT
2 3925461-2 BRACKET ASM. L. & R.H.
3 3846202  SCREW ASM.
5 3865846  NUT
6 3749084  RETAINER
7 3925465  SPACER
8 5638326  ACTUATOR ASM.
9 3925466  PIN
10 3856691  SCREW
11 3925493-4 SKIRT ASM. L. & R.H.

120 - 180 LBS. IN.
75 - 35 LBS. IN.

RALLY SPORT - RETRACTABLE HEADLAMP - ACTUATOR MOUNTING

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**ASSEMBLY INSTRUCTIONS**

**1968 CAMARO 12000 SERIES**

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<td>SPRING</td>
<td>3925458</td>
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<td>WASHER</td>
<td>1359887</td>
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<td>3925473-4</td>
<td>RETAINER</td>
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<td>SUPPORT</td>
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<td>WASHER</td>
<td>3929949-50</td>
<td>LEVER ASM. L. &amp; R.H.</td>
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**HOUSING ASM**

- See SHT A7

**RALLY SPORT - RETRACTABLE HEADLAMP - ACTUATOR MOUNTING**

- FWD.
- FRONT FENDER
- SKIRT ASM
- SHIELD

**Notes:**
- 60-80 LBS. IN.
- 120-180 LBS. IN.
NOTE: Washer hose from this point rearward routes same as prod.
1. Prod. attaching part.
2. 6295099 HARNESS ASM. L-6 ENG.
   6295100 V-8 ENG.
   6295101 V-8 ENG. WITHOUT RPO U17
3. 3833476 CLIP

**NOTE!** Position bracket edge against both dimples before tightening.

- **HARNESS ASM. L-6 ENG.**
- **V-8 ENG.**
- **V-8 ENG. WITHOUT RPO U17**
RALLY SPORT-RETRACTABLE HEADLAMP WIRING TO IGN. & LT. SW.

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* CHEVROLET MOTOR DIVISION, G.M.C.

1. 6291830 WIRE ASM-EXT
2. 2977253 CONNECTOR
3. 3724851 TAPE-Approx. 12 in.-Tape
   1 to inst. panel harness (3) places.
4. For hole drilling see UPC 0 Sheet A8

NOTE: Remove brown wire from ignition switch.

NOTE: Tape close to connector to prevent rattling.

NOTE: Remove light blue wire from light switch.

TD IGNITION SWITCH

DASH PANEL

FUSE PANEL ASM

FWD WIRING HARNESS

TD LIGHT SWITCH

WIRE ASM-EXT CONNECTOR TAPE-Approx. 12 in.-Tape

(7) For hole drilling see UPC 0 Sheet A8
SUGGESTED RALLY SPORT HEADLAMP ASSEMBLY PROCEDURE

A. Headlamp Housing Sub-Assembly
1. Housing assembly (A)
2. Actuator assembly (B)
3. Hinge (C)
4. Plate assembly (D)
5. Headlamp assembly (E)

B. Headlamp Housing Assembly
1. Drive Outboard attachments to fender
2. Loose assemble inboard attachments and shim (F) (if required) to radiator support to maintain a parallel line of plate (D) to center grille at outboard edge.
   Drive inboard attachments

C. Headlamps (E)

D. Bezel Assembly (G)
1. Drive outboard attachments
2. Drive inboard attachments

E. Headlamp Door Cover Assembly
1. Sub-Assemble molding (H) to cover (J)
2. Loose assemble cover to plate. Adjust cover so there is .04 to .170 gap between cover and bezel.
3. Drive attachments
The following components are not illustrated in the RPO. See parts list or bill of material for part numbers.

UPC 1 BODY
1A2B INSTRUMENT PANEL PARTS-

UPC 9 STEERING
9B STEERING WHEEL-

UPC 12 ELECTRICAL
12G HORN, SWITCH, WIRING & MOUNTING-

1. Bend tabs down securely 100 to 110
NOTE! The following items are listed in UPC "0" miscellaneous shipping list.

5 PLENUM AIR
6 TRANSISTORIZED IGNITION

3923217 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-0
  3B  FRONT HUBS & BEARINGS-0
  3C  FRONT SPRING-Assembles same as prod & RPO F41
  3F  FRONT SHOCK ABSORBER ASM-0

UPC 4  REAR SUSPENSION
  4  REAR AXLE-0
  4B  REAR SPRING-Assembles same as prod & RPO F41
  4D  REAR SPRING INSTALLATION PARTS-Assembles same as RPO L35
  4E  REAR SHOCK ABSORBER ASM-0

UPC 5  BRAKES
  5  BRAKES-Assembles same as RPO J50 & J52.

UPC 6  ENGINE
  6C2  TORSIONAL DAMPER-Assembles same as RPO L48
  6K1  FAN & DRIVE-Assemble same as RPO K02
  6K2  HOSE RAD.-0
  6M1  CARBURETOR-Assemble same as RPO L78
  6M4  FUEL PUMP-0
  6Y3  DISTRIBUTOR-0
  6Y4  COIL ASM-IGN. SPK PLUG WIRING-0

UPC 8  FUEL & EXHAUST
  8C  EXHAUST PIPE MUFFLER & TAIL PIPE-Assembles same as NF2 & N61 except without resonators

UPC 9  STEERING
  9D  STEERING LINKAGE-0

UPC 10  WHEEL & TIRES
  10B  COVER-WHEEL TRIM & TIRES-0

UPC 11  SHEET METAL
  11G  FRONT END SHEET METAL FENDER EMBLEM-0

UPC 12  ELECTRICAL
  12A  BATTERY-STORAGE-0

UPC 13  RADIATOR & GRILLE
  13A  BODY ASM. RAD-0

UPC 14  BUMPERS & MISC.
  14A2  REAR BUMPERS-Assembles same as RPO V32
  14B  GREASE & OIL-0

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

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440
Part number & installation same as Prod. V-8 ENGINE

- 3917646 BRACKET ASM.
- 3917689 HOSE
- 7801512 PUMP ASM.
- 3917688 HOSE
- 3917692 HOSE
- 9419004 BOLT
- 103319 L. WASHER

NOTE: Assemble pulley— with stamped part number facing rearward.

- 7801154 ELBOW
- 3918954 GASKET
- 9423577 CLAMP
- 3917648 HOSE
- 7801659 PLUG—Press setting (Black) push in til it stops on (3) ears. Force not to exceed 40 lbs. pres.
### Assembly Instructions

**1968 Camaro 12000 Series**

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<th>Number</th>
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<td>Valve Assembly</td>
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- **Special Coupe Equipment (302 Cu. In.)**
- Air Cleaner & Closed Pos. Vent.

---

**UPC:**

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<td>WAS 3932336 Hose</td>
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**Chevrolet Motor Division, GMC**

- Special Coupe Equipment (302 Cu. In.)
- Air Cleaner & Closed Pos. Vent.

**Model:**

- **12437**

**Drawing Rel:**

- RS: A3
- L-853/15
- L-

**Date Rel:**

- C1
- L-
Painted area on extension to be between points "A" & "B"
NOTE: Terminal must be assembled to switch before bulb can be properly installed.

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

- Terminal must be assembled to switch before bulb can be properly installed.
- Route wire thru slit in top of inst. pnl. compt. asm.
NOTE: The following components are not illustrated in this R.P.O.
See Parts List or Bill of Material for part numbers.

UPC 1

1A2B INSTRUMENT PANEL PARTS - 0
1A2E MISCELLANEOUS PARTS - 0

UPC 5

5C SERVICE BRAKE PEDAL - Assembles same as RPO Z33

UPC 9

9B STEERING WHEEL - Assembles same as RPO Z30

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

### CHEVROLET MOTOR DIVISION, GMC

<table>
<thead>
<tr>
<th>HOOD INSULATOR</th>
<th>UPC</th>
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<th>DRAW</th>
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**ASSEMBLY INSTRUCTIONS**

1. 3898152 INSULATOR
2. 3909199 RETAINER
ASSEMBLY INSTRUCTIONS

3918855

1968 CAMARO 12000 SERIES

1 9419784 NUT
2 3925437 SPACER
3 3925435-6 BEZEL L. & R.H.
4 3925430 ASSIST HANDLE CHART

INSTRUMENT PANEL

ASSIST GRIP HANDLE

Z87

A4

449