



1967 BUICK ASSEMBLY INSTRUCTION MANUAL
SPECIAL - SKYLARK 43000 - 44000 SERIES

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1967 BUICK ASSEMBLY INSTRUCTION MANUAL

SPECIAL - SKYLARK 43000 - 44000 SERIES
ENGINES - THROTTLE CONTROLS & CRUISE CONTROL (SECTION 6)

GENERAL INFORMATION

All Buick carburetors carry a two letter, broad-castable, code, stamped on a colored metal tag for identification. Standard carburetors (non K-19) have a triangular tag, while the Quadrajet (4MC) has a round tag with a small round hole in it. K-19 Carburetors have a rectangular tag, while K-19 Quadrajet (4MC) has a round tag with a small square hole in it. In addition, for Buick, the K-19 Quadrajet has a rectangular tag attached to one of the bowl screws.

All K-19 carburetors are received with either a black colored dust cap or a black "K" stenciled on a plain cap, for ease of identification. See Chart Page 6-1.5 for identification codes.

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1967 BUICK ASSEMBLY INSTRUCTION MANUAL

SPECIAL - SKYLARK 43000 - 44000 SERIES
 ENGINES - THROTTLE CONTROLS & CRUISE CONTROL

SECTION (6)

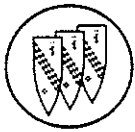
1967 AIR CLEANER CHART

SERIES	433, 35, 43	434, 36, 44, 48	434, 36, 44, 48	446
Engine	225 in ³ V6	300 in ³ V8 & 340 in ³ V8	340 in ³ V8	400 in ³ V8
Carburetor	2 Bbl.	2 Bbl.	4 Bbl.	Quadrajets 4 Bbl.
Usage	Std.	Std.	Opt. L77	Std.
Standard Air Cleaner Part No.	6419040	6424149	6424150	6423354
K19 Air Cleaner Part No.	6423155	6423745	6423922	6423361
Element Type	Polyurethane A132C	Polyurethane A96C	Polyurethane A96C	Polyurethane A96C
Snorkel Location	45°R	33°L-Std 52°L-K19	33°L-Std 52°L-K19	Dual Forward
Stud	*1382106 on 1187709	1365001 Stud & Bail	1373267 on 1187709	*1382106 on 1187709
Wing Nut	9418699	9418699	9418699	Captive with Air Cleaner
Gasket	2-1351403	1351403	1181130	3886085
Spacer	1377065	None	None	None

*6-9-66

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1967 BUICK ASSEMBLY INSTRUCTION MANUAL
SPECIAL - SKYLARK 43000 - 44000 SERIES

ENGINE (SECTION 6)

AIR PUMP PRESSURE SETTING PLUG IDENTIFICATION

K-19 OPTION ENGINES (ALL SERIES)

<u>ENGINE & EXHAUST SYSTEM</u>	<u>PART NO.</u>	<u>IDENTIFICATION COLOR</u>
V-6 (With Single Exhaust)	5697398	Silver (Zinc or Cad)
300, 340, 401, 425 (With Single Exhaust)	5697397	Green
All Series with Dual Exhaust	5697396	Black

*Idle Stator Switch Adjustment

All A.I.R. equipped jobs, the idle stator switch must be adjusted as spelled out on the Throttle Control Information Page 6-6.1. It is requested that the switch be installed and adjusted on the lever, on the sub-assembly fixture, to obtain an accurate and consistent setting.

It is equally important that proper setting of the idle stator switch be made on all Non A.I.R. jobs with an automatic transmission

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PART NUMBER-1379480

PAGE NUMBER- 6-1.4



1967 BUICK ASSEMBLY INSTRUCTION MANUAL

SPECIAL - SKYLARK 43000 - 44000 SERIES

ENGINES - THROTTLE CONTROLS & CRUISE CONTROL (SECTION 6)

CARBURETOR IDENTIFICATION-CIRCULAR TAGS & K19 ADDITIONAL RECTANGULAR TAG OF LIKE COLOR

ENGINE	TRANSMISSION	PART NO.	MFG. & CODE	I.D. TAG	MFG. CODE
6-225	Manual	7027042	R.P.D. 2GC	Silver	YB
6-225	Auto	7027040	R.P.D. 2GC	Red	YA
6-225-K19	Auto	7027041	R.P.D. 2GC	Red	YC
8-300-K19	Auto	7027045	R.P.D. 2GC	Lt. Green	ZD
8-300 & 340	Manual	7027046	R.P.D. 2GC	Dk. Blue	ZA
8-300 & 340	Auto	7037034	R.P.D. 2GC	*Black	ZE
8-340-K19	Auto	7027049	R.P.D. 2GC	Yellow	KB
8-400	Auto	*7027244 7027146	R.P.D. 4MV	*White Purple	*LF LB
8-400-K19	Auto	*7027245 7027147	R.P.D. 4MV	*White Sq. Hole Purple	*LG LC
8-400	Manual	*7027246 7027148	R.P.D. 4MV	*Dk. Blue. Rd. Orange Hole	*LH LD
8-400-K19	Manual	7027149	R.P.D. 4MV	Orange	LE

*Denotes After Job Changes. Reference ECR 71544.

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1967 BUICK ASSEMBLY INSTRUCTION MANUAL
SPECIAL - SKYLARK 43000 - 44000 SERIES

1967 BELTS - CODES & USAGE

<u>SERIES</u>	<u>ENGINE</u>	<u>PART NO.</u>	<u>CODE</u>	<u>LENGTH</u>	<u>USAGE</u>
"A" & 4500	225 & 300	1374978	RD	43.92	Del. (All)
	340	1374979	RE	45.08	Del. (All)
	225 & 300	1378417	SS	50.96	Power Steering
	340	1378702	RR	52.20	Power Steering
	225 & 300	*1379392	RC	58.62	A.C. Comp.
	340	*1381470	RF	59.84	A.C. Comp.
	225, 300 & 340	1375841	RH	49.32	Police Gen.
	225, 300 & 340	1374972	RK	36.24	Air Pump (Std.)
225, 300 & 340	1380955	RA	33.76	Air Pump (A.C.)	
"A" G.S. & 46,48,49	400,430	1378321	SD	48.90	Del. (All)
	400	1378417	SS	50.96	Power Steering
	430	1377872	SP	40.98	Power Steering
	400,430	1378322	SC	63.86	A.C. Comp.
	400	1378419	SX	35.80	Air Pump (Std.)
	400	1380955	RA	33.76	Air Pump (A.C.)
	430	1377873	SK	41.82	Air Pump (Std.)
	430	1377874	SR	44.48	Air Pump (A.C.)
	400,430	1379723	SG	54.44	Police Gen.

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1967 BUICK ASSEMBLY INSTRUCTION MANUAL
SPECIAL - SKYLARK 43000 - 44000 SERIES

1967 PULLEYS & USAGE

<u>SERIES</u>	<u>ENGINE</u>	<u>PART NO.</u>	<u>NO. GROOVES</u>	<u>USAGE</u>
"A" & 4500	225,300,340	1359065	1	Fan Driven, Std. With/without P.S.
		1365027	1	Fan Driving, Std. without P.S.
		1365028	2	Fan Driving, Std. with P.S.
		1380956	2	Fan Driven, A.C. (All)
		1362611	3	Fan Driving, A.C. (All)
		1377638	1	Power Steering
		1374886	1	Air Pump Driving (Std.)
		1380954	1	Air Pump Driving (A.C.)
	225,300,340, 400	1374702	1	Air Pump Driven (All)
"A" G.S.	400	1378361	1	Air Pump Driving (Std.)
		1378360	1	Air Pump Driving (A.C.)
46,48,49	400,430	1375141	1	Fan Driven with & without Std. P.S.
	400,430	None	1	Fan Driving without Std. P.S.
	400,430	1375142	2	Fan Driving with Std. P.S.
	400,430	1375146	2	Fan Driven A.C.
	400,430	1375143	3	Fan Driving A.C.
	400,430	1377638	1	Power Steering
	430	1377645	2	Fan Driven "Air" (Std.)
	430	1377646	3	Fan Driven "Air" (A/C)
	430	1377640	1	Air Pump Driven Std.
	430	1377641	1	Air Pump Driven A.C.

See Page 6-12.1 or 6-13.1 for detail illustration.

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PAGE NUMBER- 6-1.7



1967 BUICK ASSEMBLY INSTRUCTION MANUAL
SPECIAL - SKYLARK 43000 - 44000 SERIES
ENGINES (SECTION 6)

1967 ENGINE ROCKER ARM COVER LABELS

43-44-45-46-48-49 SERIES

NOTE: None Required for 225 Cu.In. Engine

<u>ENGINE</u>	<u>LABEL</u>	<u>PART NO.</u>
300 - 2 bbl	300 - 2	1380560
340 - 2 bbl	340 - 2	1380559
340 - 4 bbl	340 - 4	1380558
430 - 4 bbl	430 - 4	1380557
400 - 4 bbl	400 - 4	1380556

The above labels will be installed on all engines, (except 225) located on the top of each rocker arm cover in the slight depression provided.

NOTE: The surface of the cover to be wiped fairly free of dirt and oil prior to installation of the label.

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PART NUMBER-1379480

PAGE NUMBER- 6-1.8

BUICK MOTOR DIVISION
 GENERAL MOTORS CORPORATION
 FLINT, MICH., U. S. A.

1382313

DATE	SYM.	REVISION RECORD	AUTH.	DR.	CK.
7-28-66	A	400 4 MV. 500 TO 550. 550 TO 600, 430 4 MV. 500 TO 550 & 550 TO 600			HS/WA

ENGINE ADJUSTMENTS				
ENGINE TYPE	MANUFACTURING PREFIX LETTERS	IDLE SPEED (RPM)		IGNITION TIMING
		NON A/C	A/C OR A. I. R.	
225 2 BBL	NH	550	600	5° BTDC
300 2 BBL	NL	550	600	2-1/2° BTDC
340 2 BBL	NA	550	600	2-1/2° BTDC
340 4 BBL	NB	550	600	2-1/2° BTDC
(A) 400 4 MV	NR	550	600	2-1/2° BTDC
430 4 MV	ND	550	600	2-1/2° BTDC

ADJUSTMENTS:

1. ENGINE MUST BE WARM, THE CARBURETOR THROTTLE STOP MUST BE OFF OF THE FAST IDLE CAM AND THE HOT IDLE COMPENSATOR VALVE CLOSED BEFORE MAKING ADJUSTMENTS.
2. WITH IGNITION ON, PRESS AGAINST THE THROTTLE LEVER (IN VICINITY OF IDLE SWITCH) IN A DIRECTION AS TO OPEN THE THROTTLE SLIGHTLY. THEN RELEASE THE LEVER. THE IDLE SWITCH SHOULD "BREAK" AND "MAKE" DURING THIS MANEUVER IF ADJUSTED CORRECTLY. THIS WILL BE APPARENT BY AN AUDIBLE CLICK AT THE SWITCH. ALSO THE STATOR SOLENOID WILL BE ACTUATED AND GIVE A SIMILAR AUDIBLE SOUND. IF THE SWITCH IS NOT ADJUSTED PROPERLY, READJUST AS STATED ON THROTTLE CONTROL INFO. ASM.
3. MAKE IDLE SPEED ADJUSTMENT TO PROVIDE SPECIFIED SPEED IN NEUTRAL ON MANUAL TRANSMISSION CARS AND IN DRIVE RANGE ON AUTOMATIC TRANSMISSION CARS, AFTER TRANSMISSION IDLE SWITCH ADJUSTMENT IS COMPLETE. AIR CONDITIONED CARS ARE TO BE ADJUSTED WITH AIR CONDITIONING TURNED OFF.
4. IGNITION TIMING: (1) ENGINE NOT RUNNING, HOLD CAMSHAFT REARWARD WITH DISTRIBUTOR SHAFT HELD UPWARD AND COUNTER-CLOCKWISE. (2) ENGINE RUNNING, DISCONNECT AND PLUG DISTRIBUTOR VACUUM HOSE.

NOTE:

IDLE SPEED AND TRANSMISSION SLOW IDLE SPEED SWITCH ARE TO BE SET ONLY ON A. I. R. EQUIPPED CARS AT THE CAR ASSEMBLY PLANTS.

1382313

DO NOT SCALE		REPORT ERRORS
TOLERANCES UNLESS OTHERWISE SPECIFIED		
= ALLOWED ON TWO PLACE DECIMALS		
± .010 ALLOWED ON THREE PLACE DECIMALS		
COMMERCIAL TOLERANCES APPLY TO STANDARD PARTS - ROLLED SECTIONS - SHEET METAL GAGES - DRILLED AND PUNCHED HOLES.		
BURR ALL DRILLED HOLES. COUNTERSINK ALL TAPPED HOLES .030 X 90°.		
DWG. DATE	SCALE	DR. PP.
6-29-66		CK. <i>A. J. ...</i>
FIRST USED	1967	APPR.
REFERENCE	E. C. R. 70799	APPR.
MATERIAL SPEC.		

NAME	
CHART - ENGINE ADJUSTMENTS	
PART NO.	INDEX
1382313	6-2.0

BUICK MOTOR DIVISION
 GENERAL MOTORS CORPORATION
 FLINT, MICH., U. S. A.

1967 ENGINE IDENTIFICATION CHART - 2BBL 225 CUBIC INCH
 ALL ENGINES ASSEMBLED IN FACTORY #36

ENGINE PREFIX	FLINT MFG CODE	PART NUMBER	COMP RATIO		TRANSMISSION		AIR INJECTION
			EXP	STD	MAN	AUTO	
NH	OA	1395598	X		X		
NH	OB	1395658	X		X		X-FLINT
NH	OC	1395659	X		X		X-CALIF
NH	OD	1395599	X			X	
NH	OE	1395600	X			X	X-CALIF
NH	OF	1395634	X			X	X-FLINT
NK	OG	1395601	X		X		
NK	OH	1395602	X			X	

DATE	SYM.	REVISION RECORD	AUTHORITY	DR.	CK.
3-29-66A		FLINT MFG. CODE			
		REVISED	70492	JH	WJR

DO NOT SCALE TOLERANCES UNLESS OTHERWISE SPECIFIED
 REPORT ERRORS
 ± ALLOWED ON TWO PLACE DECIMALS
 ±.010 ALLOWED ON THREE PLACE DECIMALS
 COMMERCIAL TOLERANCES APPLY TO STANDARD
 ROLLED SECTIONS-SHEET METAL GAGES-
 DRILLED AND PUNCHED HOLES.
 BURR ALL MOUNTED HOLES, COUNTERSINK ALL
 TAPPED HOLES 45° X 90°

DATE 11-11-65	SCALE	DR.
FIRST USED		CK.
	1967	APPR.
REFERENCE		APPR.
		APPR.

MATERIAL SPEC.	
NAME CHART-ENGINE IDENTIFICATION	
PART NO. 1379559 Sheet 1 of 6	INDEX 6-2.1

* * AIR INJECTION NOTES:
 X - Flint - This means the engine is assembled with all air injection parts. These assemblies can only be used at Flint.
 X - Calif - This means the engine is equipped with plugs so air injection parts may be installed at the car assembly plant. These assemblies cannot be used at Flint.

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Sheet #1 of 6

BUICK MOTOR DIVISION
 GENERAL MOTORS CORPORATION
 FLINT, MICH., U. S. A.

1967 ENGINE IDENTIFICATION CHART-2BBL 300 CUBIC INCH
 ALL ENGINES ASSEMBLED IN FACTORY #36

ENGINE PREFIX	FLINT MFG CODE	PART NUMBER	COMP RATIO		TRANSMISSION		AIR INJECTION
			EXP	STD	MAN	AUTO	
NL	OJ	1395603		X	X		
NL	OK	1395656		X	X		X-FLINT
NL	OL	1395657		X	X		X-CALIF
NL	OM	1395604		X		X	
NL	ON	1395605		X		X	X-CALIF
NL	OO	1395635		X		X	X-FLINT
NM	OP	1395606	X		X		
NM	OR	1395607	X			X	

* * AIR INJECTION NOTES:

X - Flint - This means the engine is assembled with all air injection parts. These assemblies can only be used at Flint.

X - Calif - This means the engine is equipped with plugs so air injection parts may be installed at the car assembly plant. These assemblies cannot be used at Flint.

1379559
Sheet #2 of 6

DATE	SYM.	REVISION RECORD	AUTHORITY	DR.	CK.
3-29-66	A	FLINT MFG. CODE REVISED	70492	JH	<i>[Signature]</i>

DO NOT SCALE TOLERANCES UNLESS OTHERWISE SPECIFIED
 REPORT ERRORS
 ± ALLOWED ON TWO PLACE DECIMALS
 ±.010 ALLOWED ON THREE PLACE DECIMALS
 COMMERCIAL TOLERANCES APPLY TO STANDARD PARTS - ROLLED SECTIONS - SHEET METAL GAGES - DRILLED AND PUNCHED HOLES.
 BURR ALL DRILLED HOLES, COUNTERSINK ALL TAPPED HOLES .030 X 90°

DWG. DATE 11-11-65	SCALE	DR.
FIRST USED		CK
1967		APPR.
REFERENCE		APPR.
		APPR.

MATERIAL SPEC.

NAME
 CHART-ENGINE IDENTIFICATION

PART NO. 1379559	INDEX
Sheet 2 of 6	6-22

1967 ENGINE IDENTIFICATION CHART - 2 & 4 BBL 340 CUBIC INCH
ALL ENGINES ASSEMBLED IN FACTORY #36

ENGINE PREFIX	FLINT MFG. CODE	PART NUMBER	COMP RATIO EXP STD HI	CARB 2BBL 4BBL	TRANS MAN AUTO	* * AIR INJ	LESABRE	SPORT WAGON	SPECIAL
NA	OS	1395593	X	X	X		X		
NA	OT	1395597	X	X	X	X-FLINT	X		
NA	OU	1395626	X	X	X	X-CALIF	X		
NA	OV	1395609	X	X	X			X	
NA	OW	1395627	X	X	X	X-FLINT		X	
NA	OX	1395642	X	X	X	X-CALIF		X	
NA	OY	1395610	X	X	X		X	X	
NA	PA	1395594	X	X	X	X-FLINT	X	X	
NA	PB	1395611	X	X	X	X-CALIF	X	X	
NB	PC	1395636		X	X			X	X
NB	PD	1395643	X	X	X	X-FLINT		X	X
NB	PE	1395655	X	X	X	X-CALIF		X	X
NB	PF	1395612	X	X	X		X	X	X
NB	PG	1395637	X	X	X	X-FLINT	X	X	X
NB	PH	1395613	X	X	X	X-CALIF	X	X	X
NX	PJ	1395608	X	X	X			X	
(A)NX	PX	1395625	X	X	X		X		

NOTE: All manual transmission model 45 vehicles with A. I. R. will be built at Flint only so that engine 1395626 is not required.

* * AIR INJECTION NOTES:

X-Flint-This means the engine is assembled with all air injection parts. These assemblies can only be used in Flint.

X-Calif-This means the engine is equipped with plugs so air injection parts may be installed at the car assembly plant. These assemblies cannot be used at Flint.

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Sheet #3 of 6

DATE	SYM.	REVISION RECORD	AUTHORITY	DR.	CK.
12/28/65	A	1395625 Added			WHL
1-4-66	B	1395608 "X" Removed from LeSabre.			WHL
3-29-66	C	FLINT MFG. CODE REVISED	70492	JH	WHL
10-25-66	D	1395626 Removed, Note Added			PP

DO NOT SCALE REPORT ERRORS TOLERANCES UNLESS OTHERWISE SPECIFIED
± ALLOWED ON TWO PLACE DECIMALS
±.010 ALLOWED ON THREE PLACE DECIMALS
COMMERCIAL TOLERANCES APPLY TO STANDARD PARTS - ROLLED SECTIONS - SHEET METAL GAGES - DRILLED AND PUNCHED HOLES.
BURR ALL DRILLED HOLES. COUNTERSINK ALL TAPPED HOLES .030 X 90°

DWG. DATE: 11-65	SCALE	DR.
FIRST USED: 1967		CK
REFERENCE		APPR.
MATERIAL SPEC.		APPR.
NAME		
CHART-ENGINE IDENTIFICATION		
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BUICK MOTOR DIVISION
GENERAL MOTORS CORPORATION
FLINT, MICH., U. S. A.

1967 ENGINE IDENTIFICATION CHART - 4BBL 400 CUBIC INCH
ALL ENGINES ASSEMBLED IN FACTORY #36

ENGINE PREFIX	FLINT MFG CODE	PART NUMBER	TRANSMISSION		AIR COND	AIR INJECTION
			MAN	AUTO		
NR	PK	1395614		X		
NR	UL	1395615	X			X CALIF
NR	PM	1395638	X			X FLINT
NR	PN	1395618	X		X	
NR	UO	1395619	X		X	X CALIF
NR	PP	1395639	X		X	X FLINT
NR	PR	1395620		X		
NR	US	1395621	X			X CALIF
NR	PT	1395640		X		X FLINT
NR	PU	1395622		X	X	
NR	UV	1395623	X		X	X CALIF
NR	PW	1395641		X	X	X FLINT

* AIR INJECTION NOTES

X-Flint-This means the engine is assembled w th all air injection parts. These assemblies can only be used at Flint.

X-Calif-This means the engine is equipped with plugs so air injection parts may be installed at the car assembly plant. These assemblies cannot be used at Flint.

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DATE	SYM.	REVISION RECORD	AUTHORITY	DR.	CK.
3-29-66	A	FLINT MFG. CODE			
		REVISED, 1395615,			
		1395619, 1395621,			
		1395623 & AIR			
		INJECTION NOTES			
		REMOVED	70492	JH	1/2

DO NOT SCALE TOLERANCES UNLESS OTHERWISE SPECIFIED
 REPORT ERRORS
 ± ALLOWED ON TWO PLACE DECIMALS
 ±.010 ALLOWED ON THREE PLACE DECIMALS
 COMMERCIAL TOLERANCES APPLY TO STANDARD PARTS - ROLLED SECTIONS - SHEET METAL GAGES - DRILLED AND PUNCHED HOLES.
 BURR ALL DRILLED HOLES, COUNTERSINK ALL TAPPED HOLES .030 X 90°

DRG. DATE 11-11-65	SCALE	DR.
FIRST USED 1967		CK.
REFERENCE		APPR.
		APPR.

MATERIAL SPEC.

NAME
CHART-ENGINE IDENTIFICATION

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BUICK MOTOR DIVISION
GENERAL MOTORS CORPORATION
FLINT, MICH., U. S. A.

BUICK MOTOR DIVISION
GENERAL MOTORS CORPORATION
FLINT, MICH., U. S. A.

1967 ENGINE IDENTIFICATION CHART-4BBL 430 CUBIC INCH
ALL ENGINES ASSEMBLED IN FACTORY #36

ENGINE PREFIX	FLINT MFG CODE	PART NUMBER	COMP EXP	RATIO HI	TRANSMISSION		AIR COND	AIR INJECTION		ENGINE TYPE	
					MAN	AUTO		STD	L79		
ND	RA	1395595		X		X				X	
ND	VB	1395630		X		X		X	CALIF	X	
ND	RC	1395644		X		X			FLINT	X	
ND	RD	1395596		X		X	X			X	
ND	VE	1395631		X		X	X		X	CALIF	X
ND	RF	1395645		X		X	X		FLINT	X	
ND	VG	1395646		X		X					X
ND	VH	1395647		X		X			X	CALIF	X
ND	VJ	1395648		X		X			X	FLINT	X
ND	VK	1395649		X		X	X				X
ND	VL	1395650		X		X	X		X	CALIF	X
ND	VM	1395651		X		X	X		X	FLINT	X
NE	RN	1395628	X			X					X
NE	RO	1395629	X			X	X				X

~~* L79 Engine is Gran Sport Version with dress-up accessories.~~

~~* AIR INJECTION NOTES:~~

~~X Flint This means the engine is assembled with all air injection parts. These assemblies can only be used at Flint.~~

~~X Calif This means the engine is equipped with plugs so air injection parts may be installed at the car assembly plant. These assemblies cannot be used at Flint.~~

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Sheet #5 of 6

DATE	SYM.	REVISION RECORD	AUTHORITY	DR.	CK.
3-29-66	A	FLINT MFG. CODE			
		REVISED, 1395630,			
		1395631, 1395646,			
		1395647, 1395648,			
		1395649, 1395650,			
		1395651, AIR			
		INJECTION NOTES			
		& ENGINE TYPE			
		REMOVED	70492	JH	JK

DO NOT SCALE REPORT ERRORS
TOLERANCES UNLESS OTHERWISE SPECIFIED
± ALLOWED ON TWO PLACE DECIMALS
±.010 ALLOWED ON THREE PLACE DECIMALS
COMMERCIAL TOLERANCES APPLY TO STANDARD
PARTS - ROLLED SECTIONS - SHEET METAL GAGES -
DRILLED AND PUNCHED HOLES.
BURR ALL DRILLED HOLES. COUNTERSINK ALL
TAPPED HOLES .030 X 90°

DWG. DATE 11-11-65	SCALE	DR.
FIRST USED		CK
1967		APPR.
REFERENCE		APPR.
		APPR.
MATERIAL SPEC.		
NAME		
CHART-ENGINE IDENTIFICATION		

PART NO. 1379559	INDEX. 6-25
Sheet 5 of 6	

1 9 6 7 VENDEE ENGINE IDENTIFICATION CHART

DISPLACEMENT (CU. INCH)	ENG CODE NO PREFIX	FLINT MANUF CODE	PART NUMRER	COMP RATIO		CARRURETORS		
				EXP	STD HI	2BRL	4BBL	
225	NY	RT	1395632	X		X		Marine Engine-Low Profile, Sea Water
225	KNH	RU	1395616	X		X		Kaiser Jeep - Manual
225	KNH	RV	1395617	X		X		Kaiser Jeep-Automatic
300	NF	RW	1395633	X		X		Marine Engine-Sea Water Std Auto Rotation
430	NJ	RX	1395652	X			X	Marine Engine-Fresh Water Std. Auto Rotation
(A)225	NY	RZ	1395589	X		X		Marine Engine- High Profile Sea Water

BUICK MOTOR DIVISION
GENERAL MOTORS CORPORATION
FLINT, MICH., U. S. A.

1 3 7 9 5 5 9
Sheet #6 of 6

DATE	SYM.	REVISION RECORD	AUTHORITY	DR.	CK.
12/28/66	A	1395589 Added			JH
3-29-66	B	FLINT MFG. CODE			
		REVISED, ENG. CODE			
		NG TO NY & SEA			
		WATER (3-PLACES)			
		ADDED	70492	JH	JH

DO NOT SCALE REPORT ERRORS
TOLERANCES UNLESS OTHERWISE SPECIFIED
±. ALLOWED ON TWO PLACE DECIMALS
±.010 ALLOWED ON THREE PLACE DECIMALS
COMMERCIAL TOLERANCES APPLY TO STANDARD
PARTS - ROLLED SECTIONS - SHEET METAL GAGES -
DRILLED AND PUNCHED HOLES.
BURR ALL DRILLED HOLES. COUNTERSINK ALL
TAPPED HOLES .030 X 90°

DWG. DATE 11-11-65	SCALE	DR.
FIRST USED		CK
1 9 6 7		APPR.
REFERENCE		APPR.
		APPR.

MATERIAL SPEC.

NAME
CHART-ENGINE IDENTIFICATION

PART NO. 1379559 Sheet 6 of 6	INDEX 6-2.6
----------------------------------	----------------



1967 BUICK ASSEMBLY INSTRUCTION MANUAL

SPECIAL - SKYLARK 43000 - 44000 SERIES

ENGINES - THROTTLE CONTROLS & CRUISE CONTROL OPT. (SECTION 6)

ENGINE & TRANS. MOUNTS USAGE & IDENTIFICATION

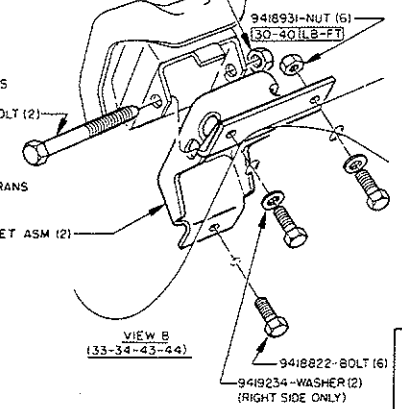
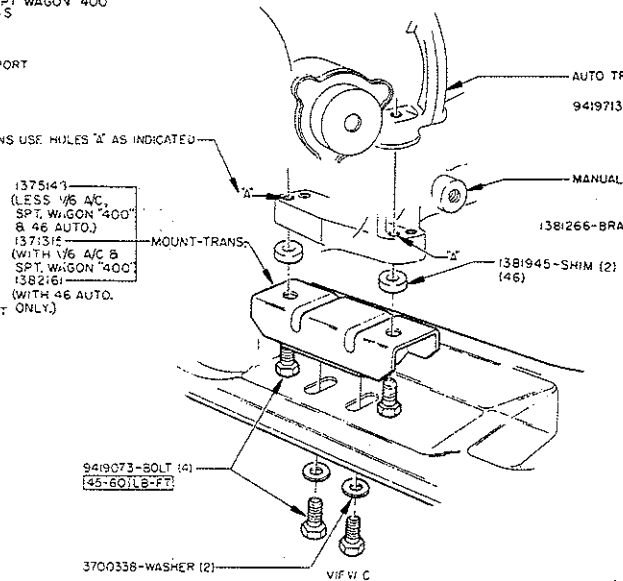
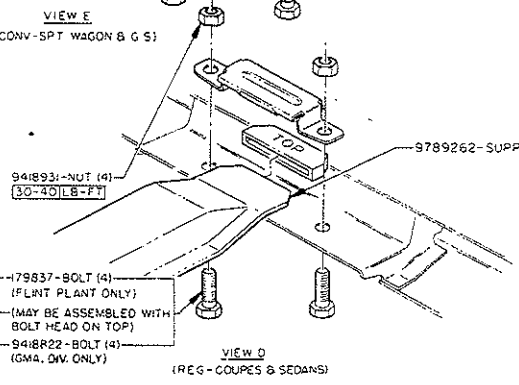
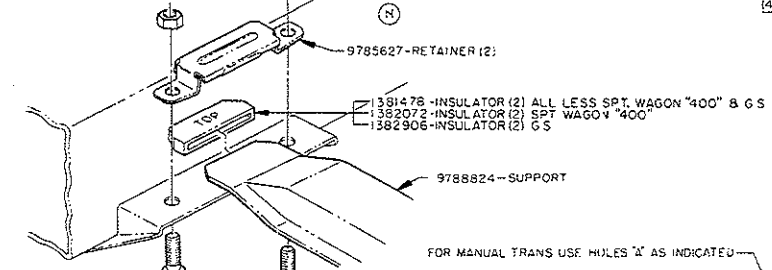
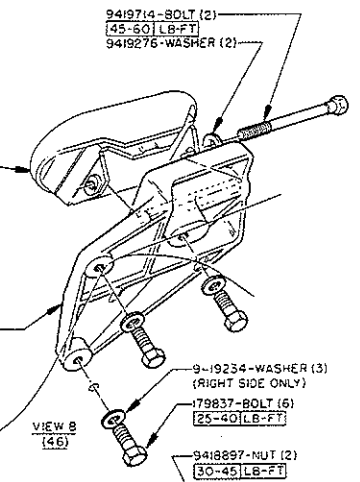
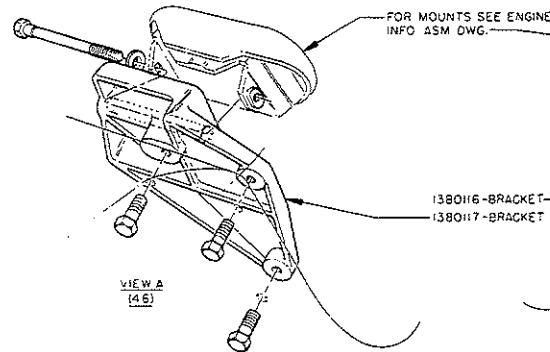
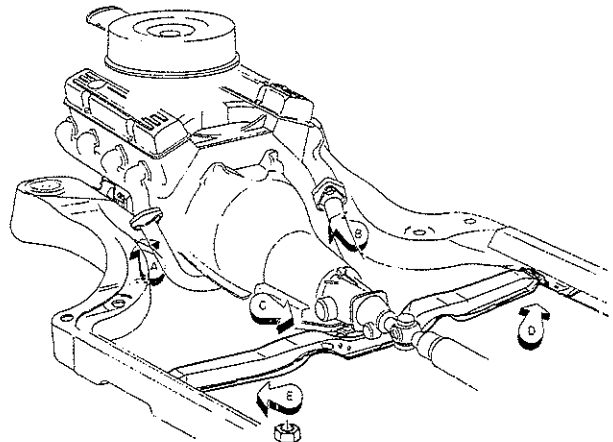
MODEL	ENG. MT. PART NO.	COLOR CODE	TRANS. MT. PART NO.	COLOR CODE
V 6 STD.	1369788 Rt. 1371313 Lt.	BLACK <hr/> BLACK	1375148	BLACK
V6 Air. Cond.	1375488 Rt. 1369657 Lt.	Orange <hr/> White	1371315	White
V8-300 & 340 cu. in.	1380965	Blue	1375148	Black
V8-340 cu. in. Sportwagon 448	1380965	Blue	1375148 3 Sp. Man & ST300 <hr/> 1371315 ST400 only	Black <hr/> White
V8-GS 400 cu. in.	1380064 Rt. 1380065 Lt.	Green <hr/> Pink	1382161 <hr/> ST400 1375148 Man.	Yellow <hr/> Black

*9-15-66

PART NUMBER-1379480

PAGE NUMBER- 6-3.0

1378724



DATE	BY	REVISION RECORD	AUTH.	IGN.	CHK.
1-19-66	A	X REMOVED			R.S.
2-14-66	B	9418822-BOLT (2) RELOCATED. PARTS ADDRESS ENG. MTS. REVISED TO DETAIL			R.S.
2-14-66	C	46 AUTO REPORTED FROM 1371266 (46 AUTO) ADDED			R.S.
3-8-66	D	ENG. MTS. REVISED BY 1371266 (46 AUTO) 9418822-BOLT (2) 9418822-BOLT (2) ADDED			R.S.
3-24-66	E	1371266 (46 AUTO) 9418822-BOLT (2) 9418822-BOLT (2) ADDED			R.S.
3-24-66	F	1371266 (46 AUTO) 9418822-BOLT (2) 9418822-BOLT (2) ADDED			R.S.
3-24-66	G	1371266 (46 AUTO) 9418822-BOLT (2) 9418822-BOLT (2) ADDED			R.S.
3-24-66	H	1371266 (46 AUTO) 9418822-BOLT (2) 9418822-BOLT (2) ADDED			R.S.
3-24-66	I	1371266 (46 AUTO) 9418822-BOLT (2) 9418822-BOLT (2) ADDED			R.S.
3-24-66	J	1371266 (46 AUTO) 9418822-BOLT (2) 9418822-BOLT (2) ADDED			R.S.
3-24-66	K	1371266 (46 AUTO) 9418822-BOLT (2) 9418822-BOLT (2) ADDED			R.S.
3-24-66	L	1371266 (46 AUTO) 9418822-BOLT (2) 9418822-BOLT (2) ADDED			R.S.
3-24-66	M	1371266 (46 AUTO) 9418822-BOLT (2) 9418822-BOLT (2) ADDED			R.S.
3-24-66	N	1371266 (46 AUTO) 9418822-BOLT (2) 9418822-BOLT (2) ADDED			R.S.

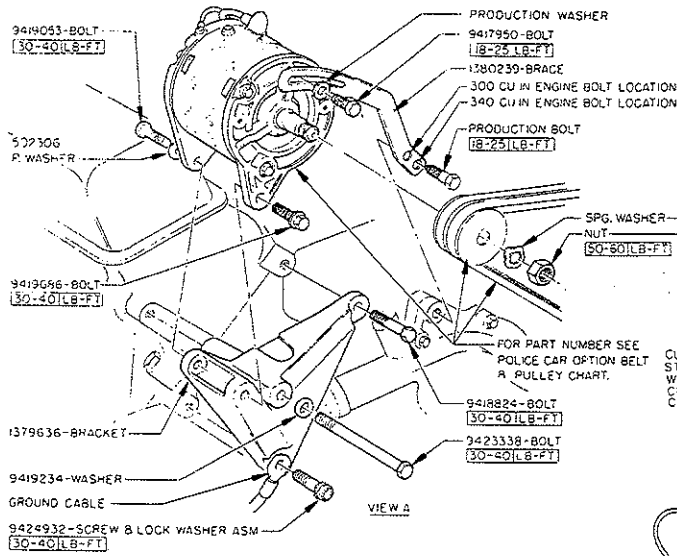
DO NOT SCALE REPORT ERRORS
TOLERANCES UNLESS OTHERWISE SPECIFIED
± .010 ALLOWED ON TWO PLACE DECIMALS
± .010 ALLOWED ON THREE PLACE DECIMALS
COMMERCIAL TOLERANCES APPLY TO STANDARD
PARTS - ROLLED SECTIONS - SHEET METAL GAGES -
DRILLED AND PUNCHED HOLES
BURR ALL DRILLED HOLES. COUNTERSINK ALL
TAPPED HOLES .030 X 90°

DWG. DATE 8-20-65 SCALE DR. R. J. SHIER
33-34-43-44-46 APPR. [Signature]
FIRST USED 1967
REFERENCE BL-15723 B BL-16335 APPR.
MATERIAL SPEC.

NAME ENGINE & TRANSMISSION
MOUNTING INFORMATION ASSEMBLY
PART NO. 1378724 INDEX 6-3.1

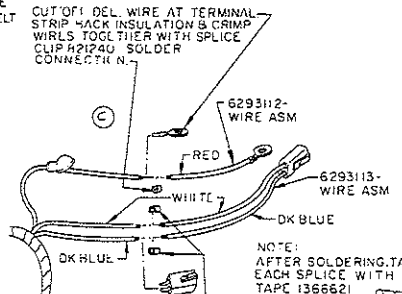
1378724

DATE: 12-6-65

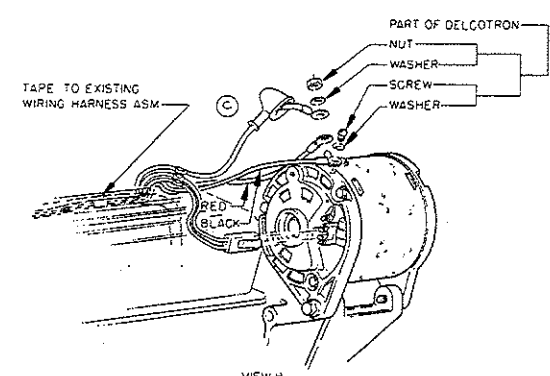


VIEW A

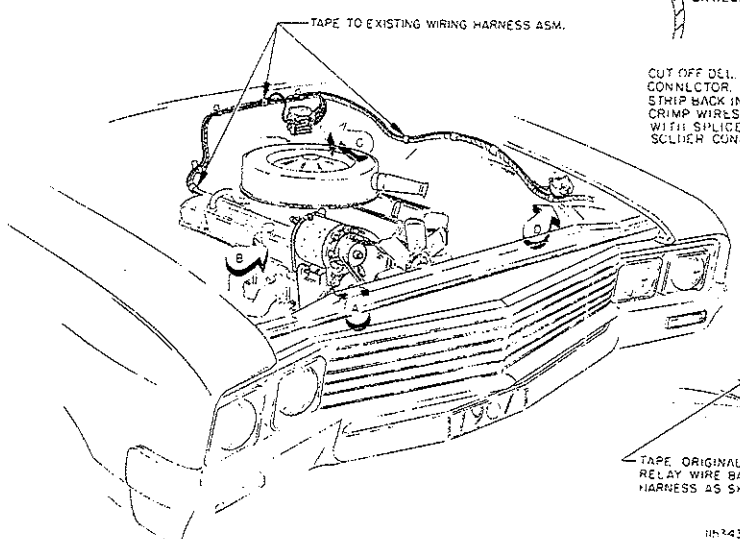
FOR PART NUMBER SEE POLICE CAR OPTION BELT & PULLEY CHART.



VIEW B



VIEW C

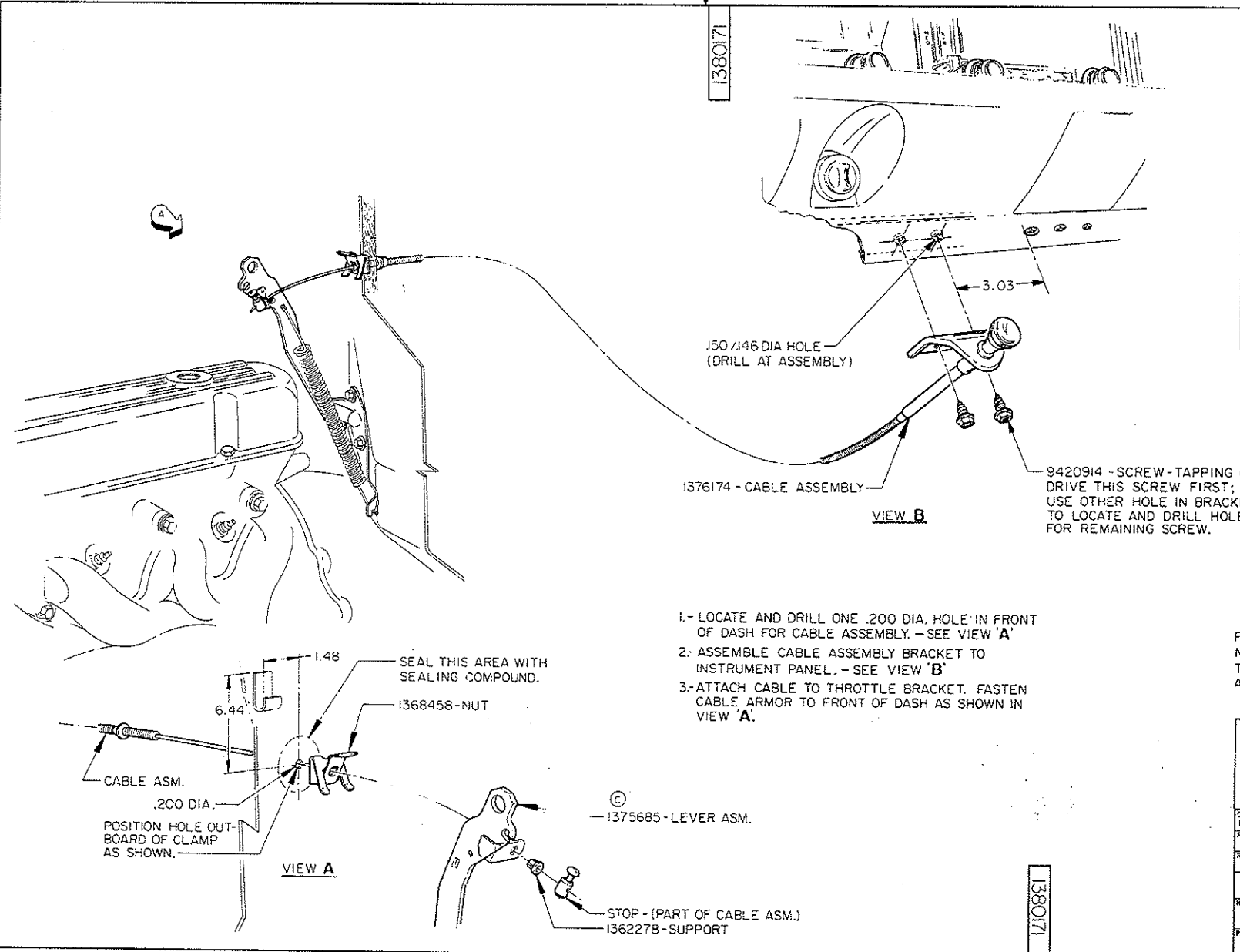


VIEW D

DATE	SYMBOL	REVISION RECORD	AUTH.	DR.	CHK.
12-6-65	A	PRELIMINARY			
12-6-65	B	VIEW C, SCREW, SL. DEL. WIRING REMOVED			
12-6-65	C	DEL. WIRING REMOVED			
		VIEW OF WIRE SPlicing ADDED			

DO NOT SCALE	REPORT ERRORS
TOLERANCES UNLESS OTHERWISE SPECIFIED	± ALLOWED ON TWO PLACE DECIMALS
± .010 ALLOWED ON THREE PLACE DECIMALS	COMMERCIAL TOLERANCES APPLY TO STANDARD PARTS - ROLLED SECTIONS - SHEET METAL GAGES - DRILLED AND PUNCHED HOLES.
BURR ALL DRILLED HOLES. COUNTERSINK ALL TAPPED HOLES .030 X 90°.	
DWG. DATE: 12-6-65	SCALE: DR. R. SHIER
FIRST USED: 1967	CK. APPR.
13-36-45-40	APPR.
REFERENCE:	APPR.
225, 300 & 340 CU. IN. ENGINES	
NAME POLICE CAR OPTION	
INFO ASM (DELCOTRON)	
PART NO. 1380120	INDEX 6-41

1380120



1380171

1380171

DATE	SYMBOL	REVISION RECORD	AUTH.	DR.	CHK.
1967-08-05		REVISED TO			
1967-08-05		REVISED TO			

- 1.- LOCATE AND DRILL ONE .200 DIA. HOLE IN FRONT OF DASH FOR CABLE ASSEMBLY. - SEE VIEW 'A'
- 2.- ASSEMBLE CABLE ASSEMBLY BRACKET TO INSTRUMENT PANEL. - SEE VIEW 'B'
- 3.- ATTACH CABLE TO THROTTLE BRACKET. FASTEN CABLE ARMOR TO FRONT OF DASH AS SHOWN IN VIEW 'A'.

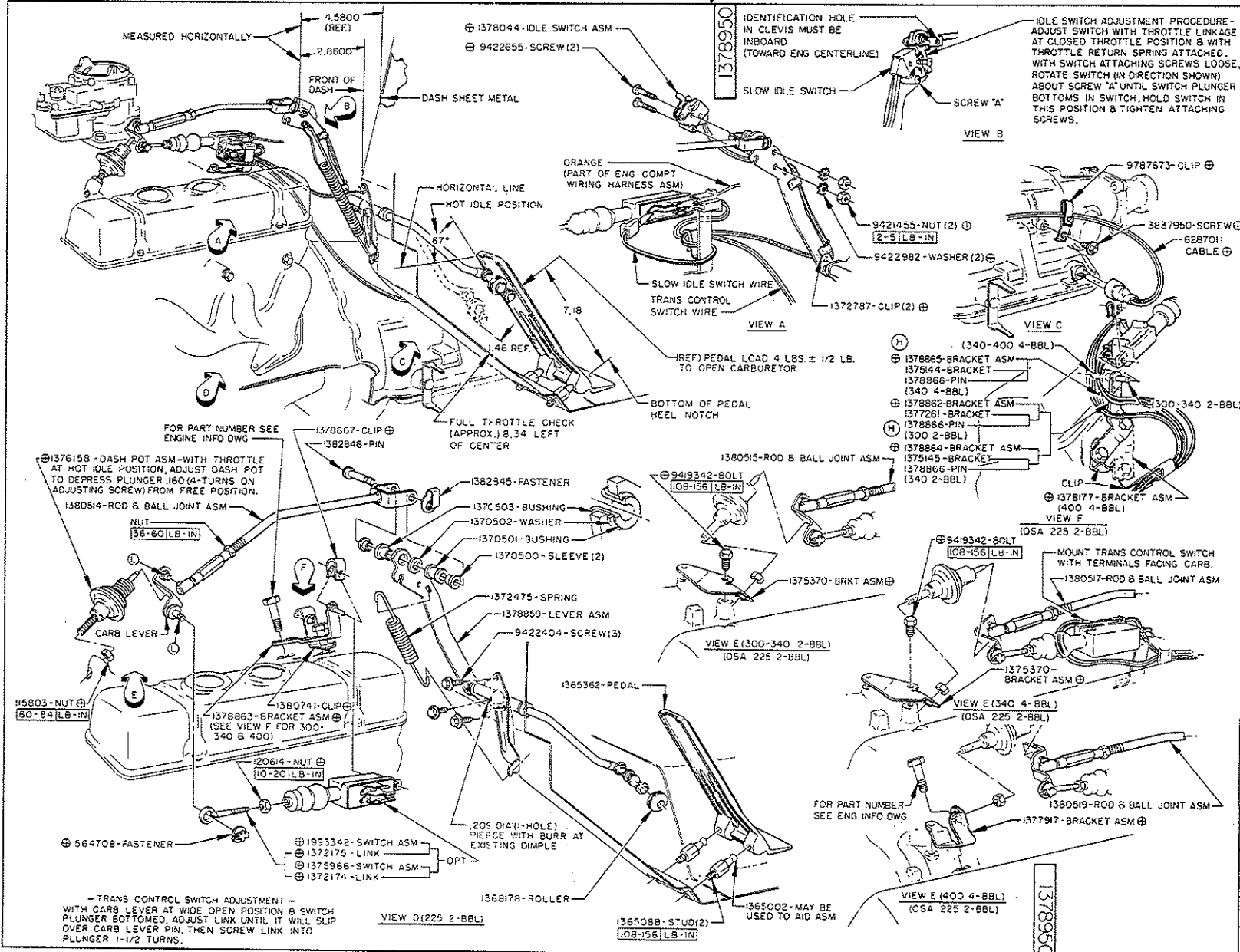
FOR PARTS AND PART NUMBERS NOT SHOWN SEE THROTTLE CONTROL INFO ASM. DRAWING

DO NOT SCALE
TOLERANCES UNLESS OTHERWISE SPECIFIED
± .001 ALLOWED ON TWO PLACE DECIMALS
± .010 ALLOWED ON THREE PLACE DECIMALS
COMMERCIAL TOLERANCES APPLY TO STANDARD PARTS - ROLLED SECTIONS - SHEET METAL GAGES - DRILLED AND PUNCHED HOLES.
BURR ALL DRILLED HOLES. COUNTERSINK ALL TAPPED HOLES .030 X 90°.

DR. DATE 12-8-65
SCALE
FIRST USED 1967-34-44
REFERENCE BL-16376

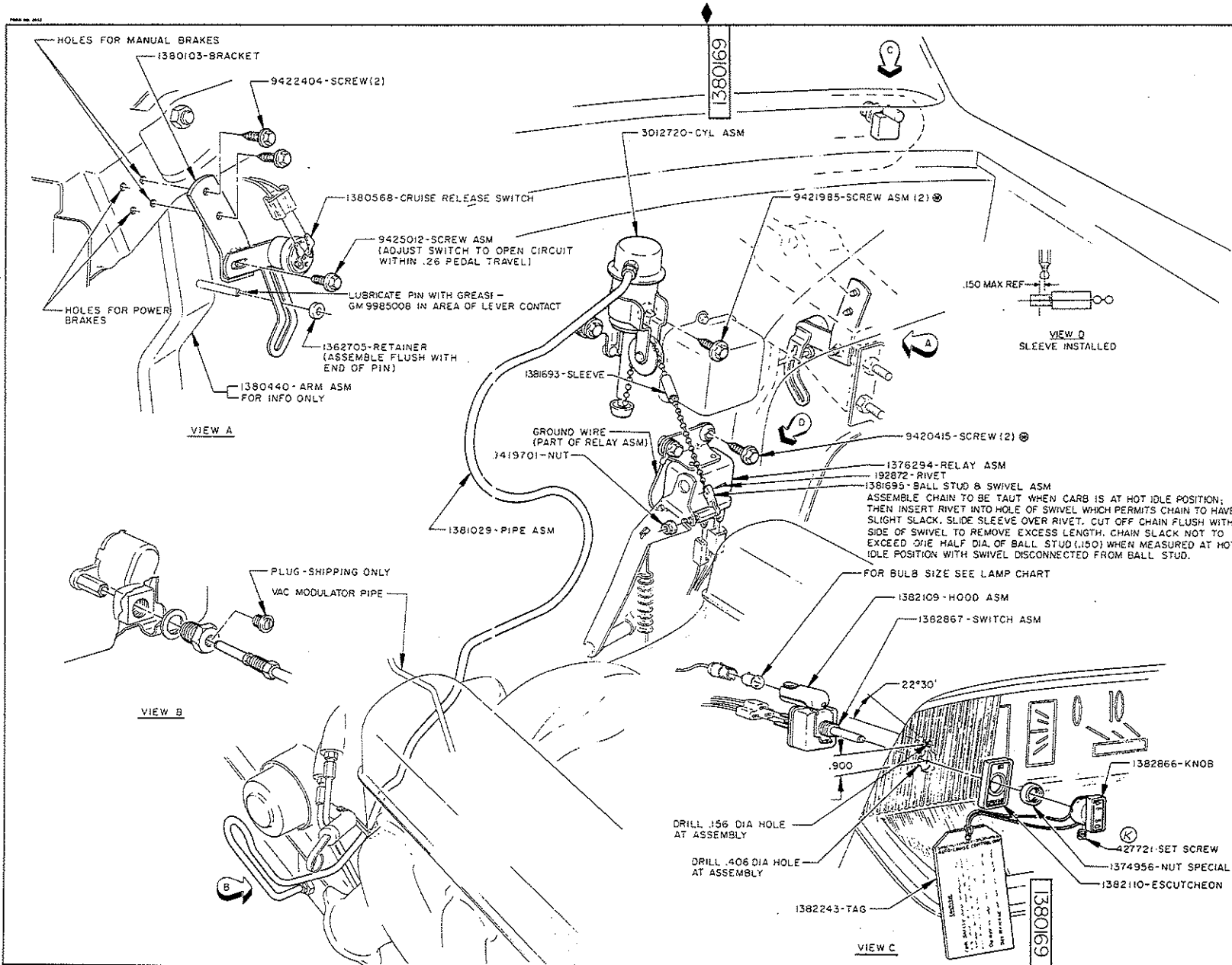
DR. MODERN ENG. CK. APPR. APPR. APPR.

NAME FAST IDLE
CABLE INSTALLATION
PART NO. 1380171 INDEX 6-51



DATE (YR.)	REVISION RECORD	AUTH.	DR. (CK.)
11-25-64	A	72	REMOVED
11-25-64	B	1502976	TO 9787673
		942910	TO 1372950
		1307	REMOVED E 2287011
			ADDED
11-25-64	C	1377916	TO 1377917
		10438	REMOVED
11-25-64	D	1378865	TO 1378866
			RELOCATED & NOTE ADDED 10640
11-25-64	E	1378865	TO 1382846
			1378866 ADDED 371
			1378866 ADDED 371
11-25-64	F	1378866	TO 1382846
		105351	TO 1382846
11-25-64	G	1378866	TO 1378867
		1382846	TO 1382846
		1378866	TO 1382846
		1378866	TO 1382846
		1378866	TO 1382846
		1378866	TO 1382846

GENERAL MOTORS CORPORATION
FLINT, MICH., U.S.A.



DATE	BY	REVISION RECORD	AUTH.	DR.	CL.
3-22-66	A	"X" REMOVED		JA	JA
4-28-66	B	1374017 TO 1380169			
		1381695 192872 1			
		VIEW D ADDED.		70516	MM
3-10-66	C	VIEW D REVISED.			
3-24-66	D	ALL SE SCREWS REMOVED		70521	IF
3-31-66	E	1381991 TO 1381028			
		1375331 TO 1381155			
		1381956 TO 1382111			
		1381289 TO 1381160			
		440 TO 900, NONE			
		REQUIRED: 1268			
		1164 - REMOVED		10119	JA
3-26-66	F	1381218 TO 1381245		10211	JA
3-30-66	G	NOTE ADDED		10236	MM
3-14-66	H	1382111 410A TO 1382111			
		1382159 SWITCH TO			
		1382267			
3-24-66	I	REVISOR TO DETAIL		71124	MM
3-24-66	K	AL 326 TO 237721		7181	MM

⊗ PIERCE .209 DIA HOLES AT ASM. FOR MOUNTING HOLE LOCATION. SEE DASH HOLE DRILLING INFO ASSEMBLY.

FOR TRANSMISSION, SEE TRANS ASSEMBLY DRAWING.

FOR WIRING, SEE WIRING INFO ASM.

DO NOT SCALE REPORT ERRORS TOLERANCES UNLESS OTHERWISE SPECIFIED = ALLOWED ON TWO PLACE DECIMALS .010 ALLOWED ON THREE PLACE DECIMALS COMMERCIAL TOLERANCES APPLY TO STANDARD PARTS - ROLLED SECTIONS - SHEET METAL GAGES - DRILLED AND PUNCHED HOLES. BORE ALL DRILLED HOLES. COUNTERSINK ALL TAPPED HOLES .030 X 90°.

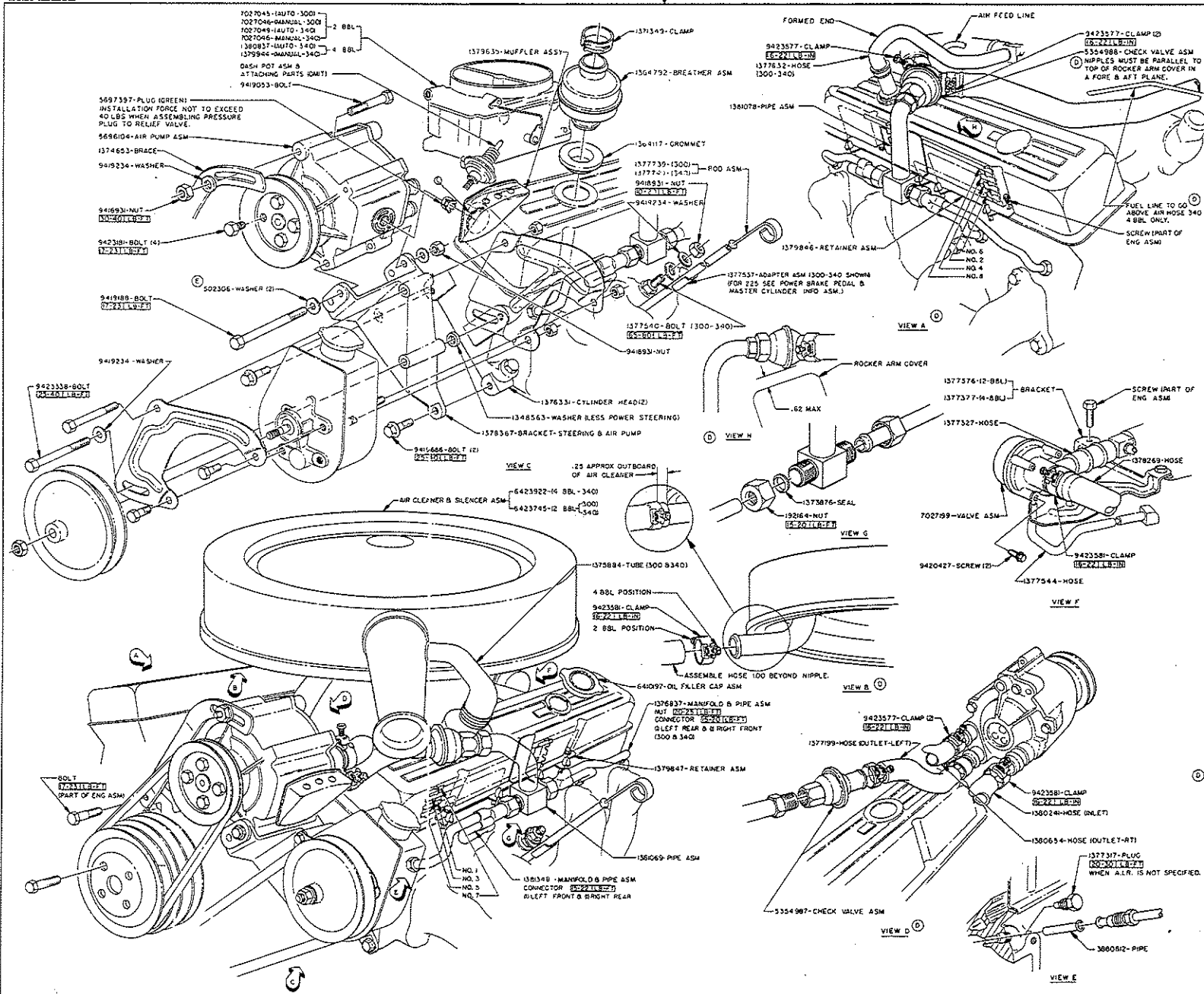
DRG. DATE	SCALE	DR.	J. ALLEN
1-14-66	NONE	CK.	<i>JA</i>
FIRST USED		APPR.	
33-34-43-44		APPR.	
REFERENCE		APPR.	
BL-16336, BL-16358		APPR.	

HYDRAULIC OPERATED
ST-300 AUTO

NAME
CRUISE CONTROL INFO ASM

PART NO. **1380169** INDEX **6-8.1**

BUICK MOTOR DIVISION
 General Motors Corporation
 WARREN, MICH. U.S.A.



NO.	DESCRIPTION	QTY	UNIT
1	137756	1	ASSEMBLY
2	137756	1	ASSEMBLY
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99	137756	1	ASSEMBLY
100	137756	1	ASSEMBLY

FOR BELT & PULLEY PART NOS SEE BELT & PULLEY CHART.

FOR VACUUM CONNECTIONS SEE VACUUM CONNECTION INFO ASM DRAWING.

FOR AREAS MARKED (1), USE 1365002 TO ADJ ASM.

FOR RADIATOR HOSES & ATTACHING PARTS SEE, RADIATOR GRILLE, & FRONT END SHEET METAL INSTALLATION DRAWING.

(2) ASSEMBLE HOSE CLAMPS IN ANGULAR POSITION SHOWN, 20 DEG FROM END OF HOSE UNLESS OTHERWISE SPECIFIED.

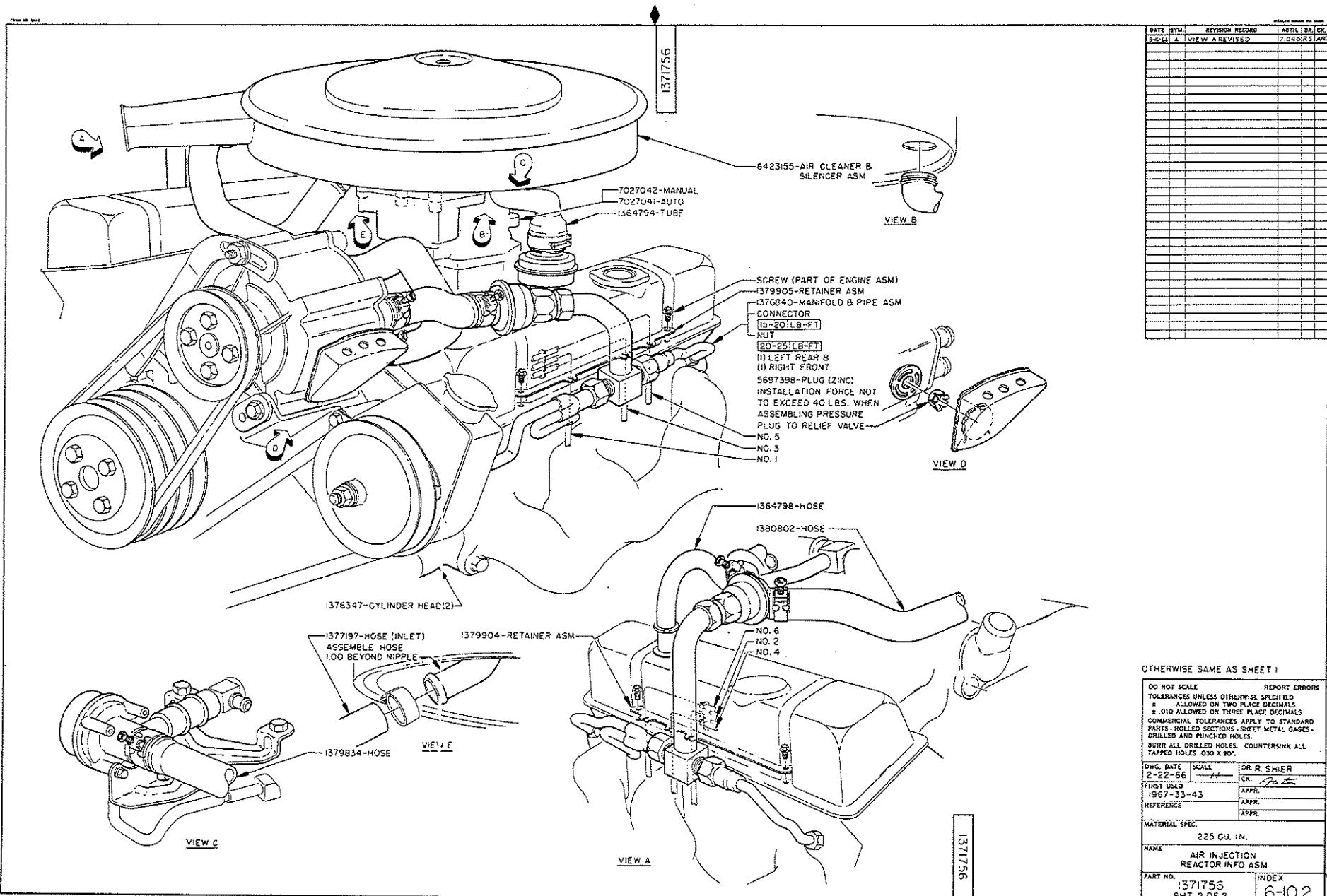
FOR POWER STEERING PUMP MOUNTING SEE STEERING GEAR, PUMP & LINKAGE INFO ASM DRAWING.

DO NOT SCALE DIMENSIONS UNLESS OTHERWISE SPECIFIED. DIMENSIONS ARE GIVEN IN INCHES UNLESS OTHERWISE SPECIFIED. DIMENSIONS IN PARENTHESES ARE FOR REFERENCE ONLY. DIMENSIONS IN BRACKETS ARE FOR INFORMATION ONLY.

DATE: 1-21-66
 PART: 137756-137756-1
 137756-137756-1
 137756-137756-1

REVISIONS:
 NO. 1
 NO. 2
 NO. 3
 NO. 4
 NO. 5

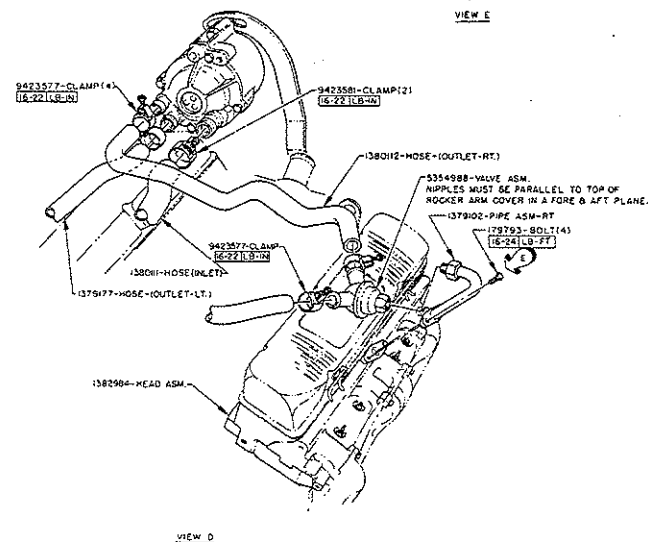
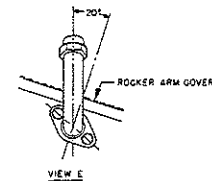
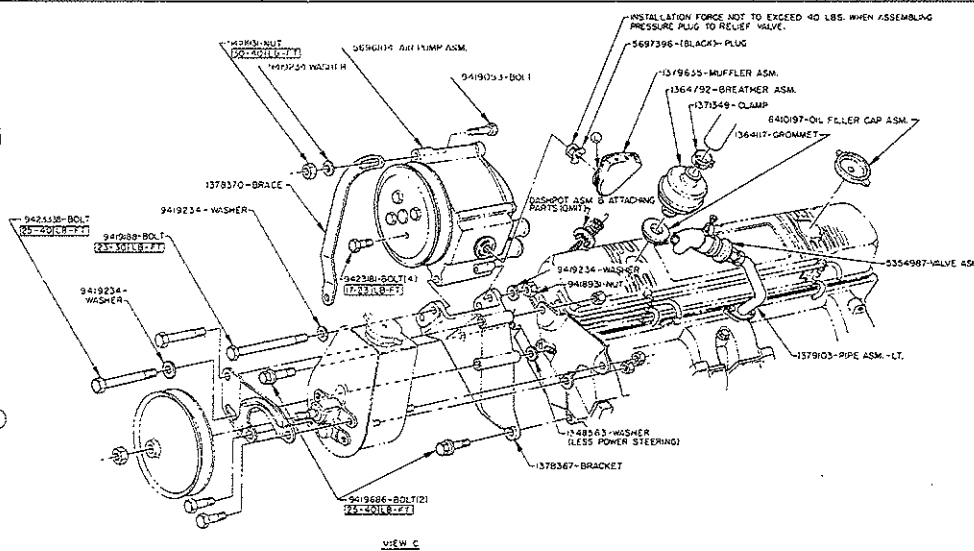
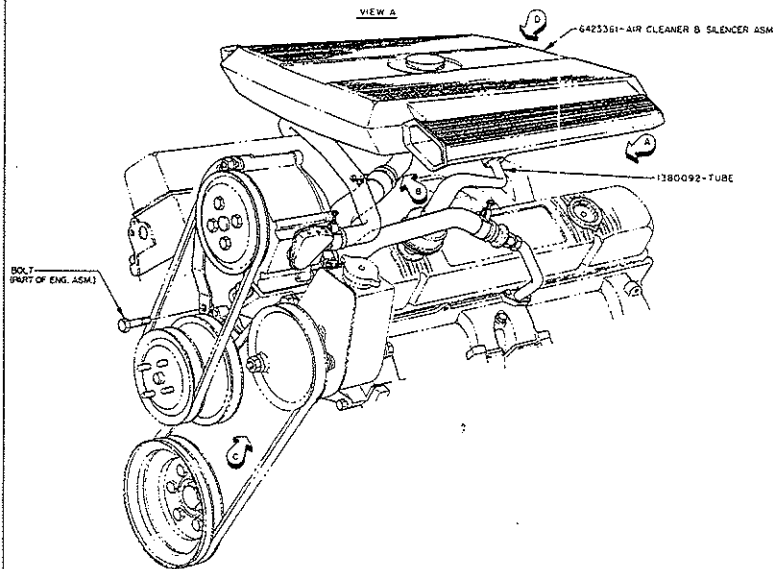
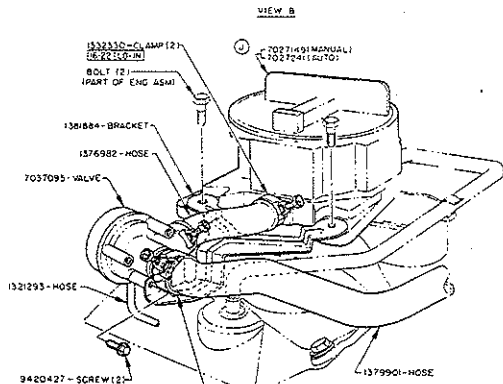
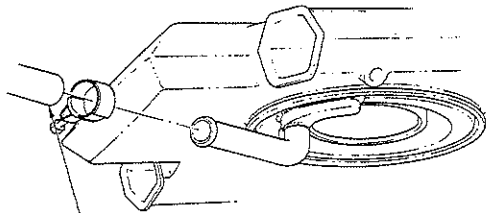
137756 - 6-10.1



DATE	BY	REVISION RECORD	AUTH.	DR. CK.
8-14-66	A	VIEW A REVISED		TIDGORS/AVC

OTHERWISE SAME AS SHEET 1

DO NOT SCALE		REPORT ERRORS	
TOLERANCES UNLESS OTHERWISE SPECIFIED			
# ALLOWED ON TWO PLACE DECIMALS			
± 010 ALLOWED ON THREE PLACE DECIMALS			
COMMERCIAL TOLERANCES APPLY TO STANDARD PARTS - ROLLED SECTIONS - SHEET METAL GAGES - DRILLED AND PUNCHED HOLES.			
BURN ALL DRILLED HOLES. COUNTERSINK ALL TAPPED HOLES .030 X 90°.			
DWG. DATE	SCALE	DR. R. SHIER	
2-22-66	1:1	CK. <i>Shier</i>	
FIRST USED		APPR.	
1967-33-43		APPR.	
REFERENCE		APPR.	
MATERIAL SPEC. 225 CU. IN.			
NAME AIR INJECTION REACTOR INFO ASM			
PART NO. 1371756			INDEX
SHT 2 OF 2			6-10.2



1381087			
REV.	DESCRIPTION	DATE	BY
1	ISSUED FOR PRODUCTION	11-16-66	
2	REVISED TO REFLECT	11-16-66	
3	REVISED TO REFLECT	11-16-66	
4	REVISED TO REFLECT	11-16-66	
5	REVISED TO REFLECT	11-16-66	
6	REVISED TO REFLECT	11-16-66	
7	REVISED TO REFLECT	11-16-66	
8	REVISED TO REFLECT	11-16-66	
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23	REVISED TO REFLECT	11-16-66	
24	REVISED TO REFLECT	11-16-66	
25	REVISED TO REFLECT	11-16-66	

1381087

FOR VACUUM CONNECTIONS SEE
VACUUM CONNECTION INFO. ASM.
DRAWINGS.

FOR BELT & PULLEY PART NO. SEE
BELT & PULLEY CHART.

FOR POWER STEERING PUMP MOUNTING
SEE STEERING GEAR, PUMP &
LINKAGE INFO. ASM. DRAWING.

FOR AREAS MARKED (D) USE
1385002 TO AID ASSEMBLY.

ASSEMBLE HOSE CLAMPS IN
ANGULAR POSITION SHOWN .20 BACK
FROM END OF HOSE UNLESS
OTHERWISE SPECIFIED.

FOR RADIATOR HOSES & ATTACHING
PARTS SEE RADIATOR, GRILLE &
FRONT END INSTALLATION DRAWING.

DO NOT SCALE REPORT ERRORS
TOLERANCES UNLESS OTHERWISE SPECIFIED
& ARE ALLOWED ON THESE PLACE DETAILS
DIMENSIONAL TOLERANCES APPLY TO STANDARD
PARTS-ROLLED SECTIONS UNLESS OTHERWISE
SPECIFIED UNLESS OTHERWISE SPECIFIED

ALL HOLES UNLESS NOTED OTHERWISE ARE
DRILLED UNLESS OTHERWISE SPECIFIED

DO NOT SCALE REPORT ERRORS

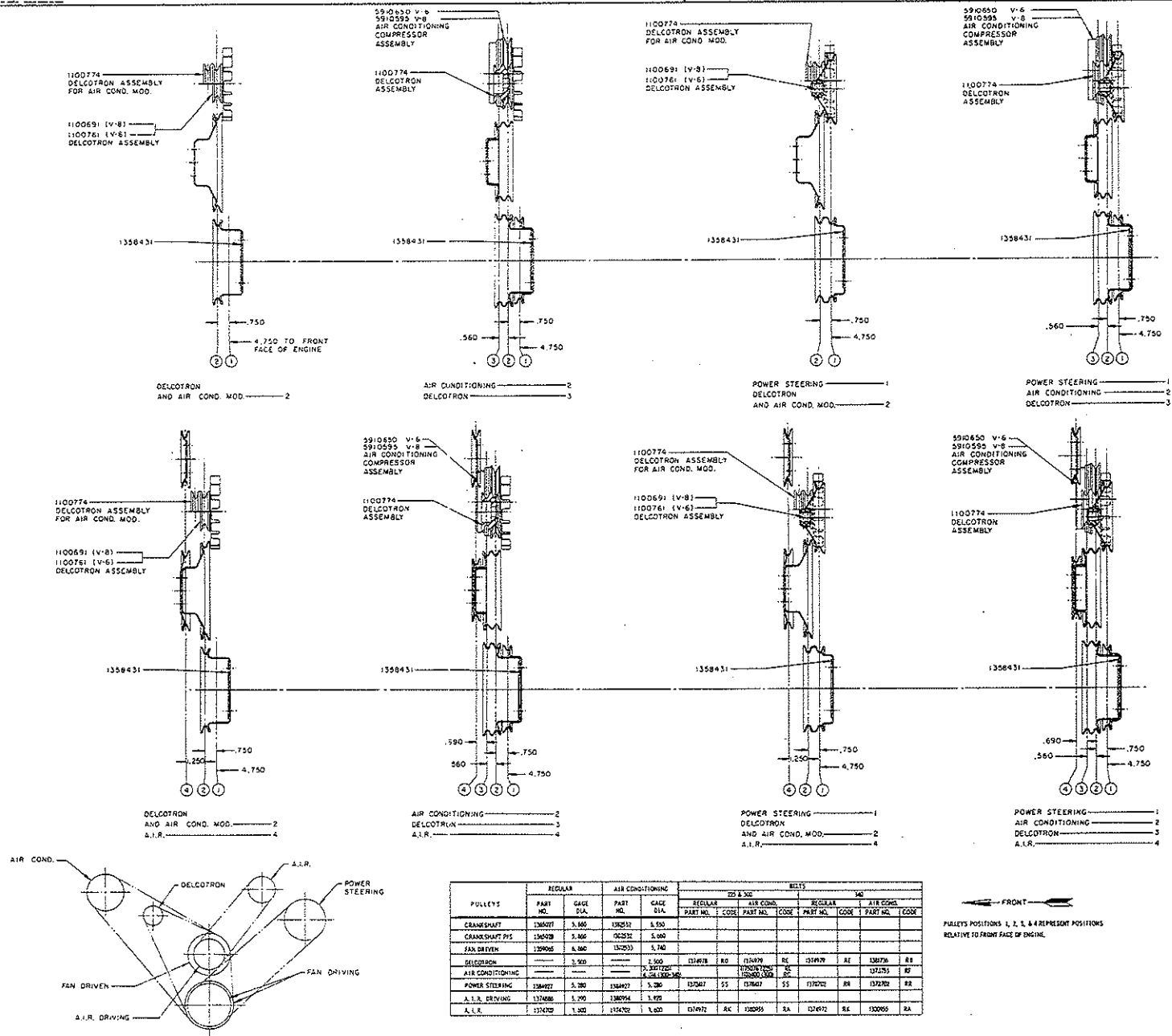
REV.	DATE	BY
1-16-66	11-16-66	
2-16-66	11-16-66	
3-16-66	11-16-66	
4-16-66	11-16-66	
5-16-66	11-16-66	
6-16-66	11-16-66	
7-16-66	11-16-66	
8-16-66	11-16-66	
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18-16-66	11-16-66	
19-16-66	11-16-66	
20-16-66	11-16-66	
21-16-66	11-16-66	
22-16-66	11-16-66	
23-16-66	11-16-66	
24-16-66	11-16-66	
25-16-66	11-16-66	

400 CU IN ENG.

AIR INJECTION
REACTOR INFO. ASM.

1381087 16-111

BUNCK MOTOR DIVISION
 GENERAL MOTORS CORPORATION
 PART 1380553



PULLEYS	REGULAR		AIR CONDITIONING		BELTS			
	PART NO.	GAGE DIA.	PART NO.	GAGE DIA.	25 & 302		140	
					REGULAR	AIR COND.	REGULAR	AIR COND.
CRANK SHAFT	136027	5.500	136251	5.500				
CRANK SHAFT P/S	136028	5.562	020532	5.600				
FAN DRIVEN	136006	6.560	137003	5.740				
DELCOTRON		5.500		5.500	131478	RD	131479	RE
AIR CONDITIONING		5.500		5.500	131478	RD	131479	RE
POWER STEERING	136497	5.280	136497	5.280	137267	SS	137267	SS
A. I. R. DRIVING	137408	5.700	136794	5.470				
A. I. R.	137470	5.500	135470	5.600	014972	RC	132895	RA

FRONT

PULLEY POSITIONS 1, 2, 3, 4 REPRESENT POSITIONS RELATIVE TO FRONT FACE OF ENGINE.

1380553

REV.	DATE	DESCRIPTION	BY	CHK.
1	11-10-53	ISSUED FOR PRODUCTION		
2	12-15-53	REVISION TO 1380553		
3	1-10-54	REVISION TO 1380553		
4	3-10-54	REVISION TO 1380553		
5	5-10-54	REVISION TO 1380553		
6	7-10-54	REVISION TO 1380553		
7	9-10-54	REVISION TO 1380553		
8	11-10-54	REVISION TO 1380553		
9	1-10-55	REVISION TO 1380553		
10	3-10-55	REVISION TO 1380553		
11	5-10-55	REVISION TO 1380553		
12	7-10-55	REVISION TO 1380553		
13	9-10-55	REVISION TO 1380553		
14	11-10-55	REVISION TO 1380553		
15	1-10-56	REVISION TO 1380553		
16	3-10-56	REVISION TO 1380553		
17	5-10-56	REVISION TO 1380553		
18	7-10-56	REVISION TO 1380553		
19	9-10-56	REVISION TO 1380553		
20	11-10-56	REVISION TO 1380553		
21	1-10-57	REVISION TO 1380553		
22	3-10-57	REVISION TO 1380553		
23	5-10-57	REVISION TO 1380553		
24	7-10-57	REVISION TO 1380553		
25	9-10-57	REVISION TO 1380553		
26	11-10-57	REVISION TO 1380553		
27	1-10-58	REVISION TO 1380553		
28	3-10-58	REVISION TO 1380553		
29	5-10-58	REVISION TO 1380553		
30	7-10-58	REVISION TO 1380553		
31	9-10-58	REVISION TO 1380553		
32	11-10-58	REVISION TO 1380553		
33	1-10-59	REVISION TO 1380553		
34	3-10-59	REVISION TO 1380553		
35	5-10-59	REVISION TO 1380553		
36	7-10-59	REVISION TO 1380553		
37	9-10-59	REVISION TO 1380553		
38	11-10-59	REVISION TO 1380553		
39	1-10-60	REVISION TO 1380553		
40	3-10-60	REVISION TO 1380553		
41	5-10-60	REVISION TO 1380553		
42	7-10-60	REVISION TO 1380553		
43	9-10-60	REVISION TO 1380553		
44	11-10-60	REVISION TO 1380553		
45	1-10-61	REVISION TO 1380553		
46	3-10-61	REVISION TO 1380553		
47	5-10-61	REVISION TO 1380553		
48	7-10-61	REVISION TO 1380553		
49	9-10-61	REVISION TO 1380553		
50	11-10-61	REVISION TO 1380553		

1380553

2. USING GAGE 91-10-ACB, OR EQUIVALENT, BELT TENSION SHOULD BE:
 DELCOTRON 110-125 LBS.
 POWER STEERING 135-150 LBS.
 AIR CONDITIONING 135-150 LBS.
 A. I. R. 40-60 LBS.

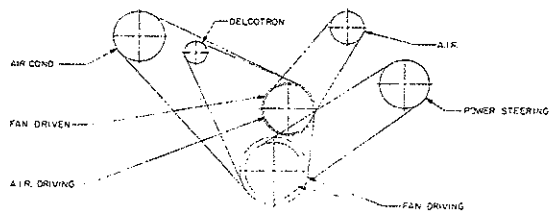
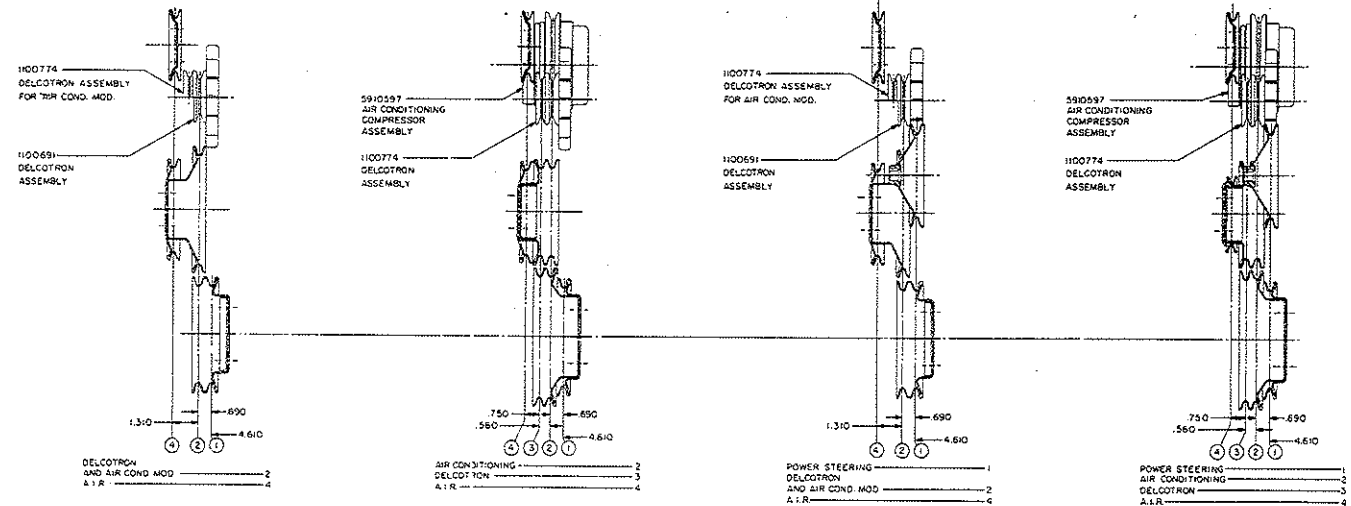
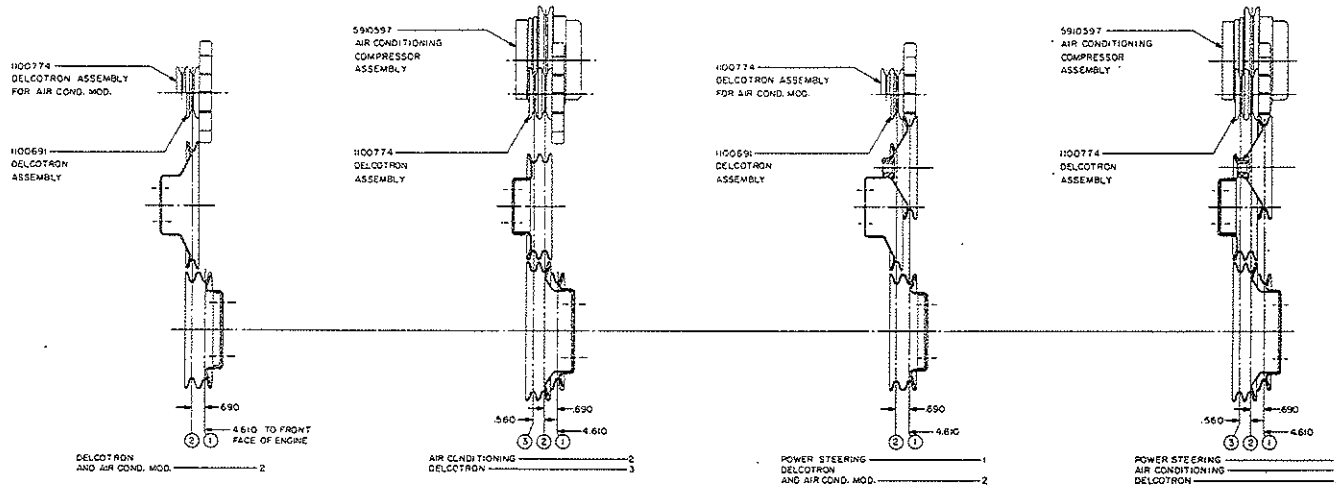
DO NOT SCALE REPORT NUMBER

TOLERANCES UNLESS OTHERWISE SPECIFIED
 ± .005 ALLOWED ON TWO PLACE DECIMALS
 ± .010 ALLOWED ON THREE PLACE DECIMALS
 GEOMETRIC TOLERANCES APPLY TO FEATURES PARTLY MOUNTED BETWEEN MOUNT METAL CARBIDES DRILLED AND PUNCHED HOLES.
 BORN ALL DRILLED HOLES. COUNTERSINKS ALL PUNCHED HOLES UNLESS NOTED.

DATE	SCALE	DR. R. BATES
1-10-53	1:1	OK
1-10-54	1:1	OK
1-10-55	1:1	OK
1-10-56	1:1	OK
1-10-57	1:1	OK
1-10-58	1:1	OK
1-10-59	1:1	OK
1-10-60	1:1	OK
1-10-61	1:1	OK

DATE: 1380553
 DRAWING: 6-12.1
 CHECKED: 7 PULLEYS & BELTS
 INDEX: 1380553 6-12.1

BUICK MOTOR DIVISION
GENERAL MOTORS CORPORATION
WARREN, MICH. U.S.A.



PULLEYS	REGULAR		AIR CONDITIONING		REGULAR		DELTS		AIR COND.	
	PART NO.	GAGE DIA.	PART NO.	GAGE DIA.	PART NO.	CODE	PART NO.	CODE	PART NO.	CODE
CRANKSHAFT	117542	6.50	117542	7.50						
CRANKSHAFT PUL	137112	6.00	137112	6.00						
FAN DRIVE PUL	137112	6.00	137112	6.50						
DELCO PUL		5.50		5.50	137112	SS	137112	SS		
AIR COND. PUL		5.50		5.50	137112	SS	137112	SS		
POWER STEERING	138072	5.50	138072	5.50	138072	SS	138072	SS		
A.I.R. DRIVING	137112	5.50	137112	5.50						
A.I.R.	138072	5.50	138072	5.50	138072	SS	138072	SS		

FRONT
PULLEY POSITIONS 1, 2, 3 & 4 REPRESENT POSITIONS RELATIVE TO FRONT FACE OF DIALING

1380681

DATE	REV.	DESCRIPTION	BY	CHK.
	1	ISSUED		
	2	REVISION		
	3	REVISION		
	4	REVISION		
	5	REVISION		
	6	REVISION		
	7	REVISION		
	8	REVISION		
	9	REVISION		
	10	REVISION		
	11	REVISION		
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	13	REVISION		
	14	REVISION		
	15	REVISION		
	16	REVISION		
	17	REVISION		
	18	REVISION		
	19	REVISION		
	20	REVISION		

1380681

USING GAGE 187-3145-ACR, OR EQUIVALENT, BELT TENSION SHOULD BE:
DELCO PUL 125 LBS.
POWER STEERING 150-200 LBS.
AIR CONDITIONING 125-150 LBS.
A.I.R. 85-100 LBS.

DO NOT SCALE REPORT DIMENSIONS UNLESS OTHERWISE INDICATED
1 JAW ALLOWED ON THREE PLACE DECIMALS
COMMERCIAL TOLERANCES APPLY TO STANDARD
PARTS UNLESS OTHERWISE SPECIFIED
SMALLER AND PUNCHED HOLES
BOTH HOLE TYPES MUST BE CONFORMANT WITH
TAPPED HOLES 330 X 90°

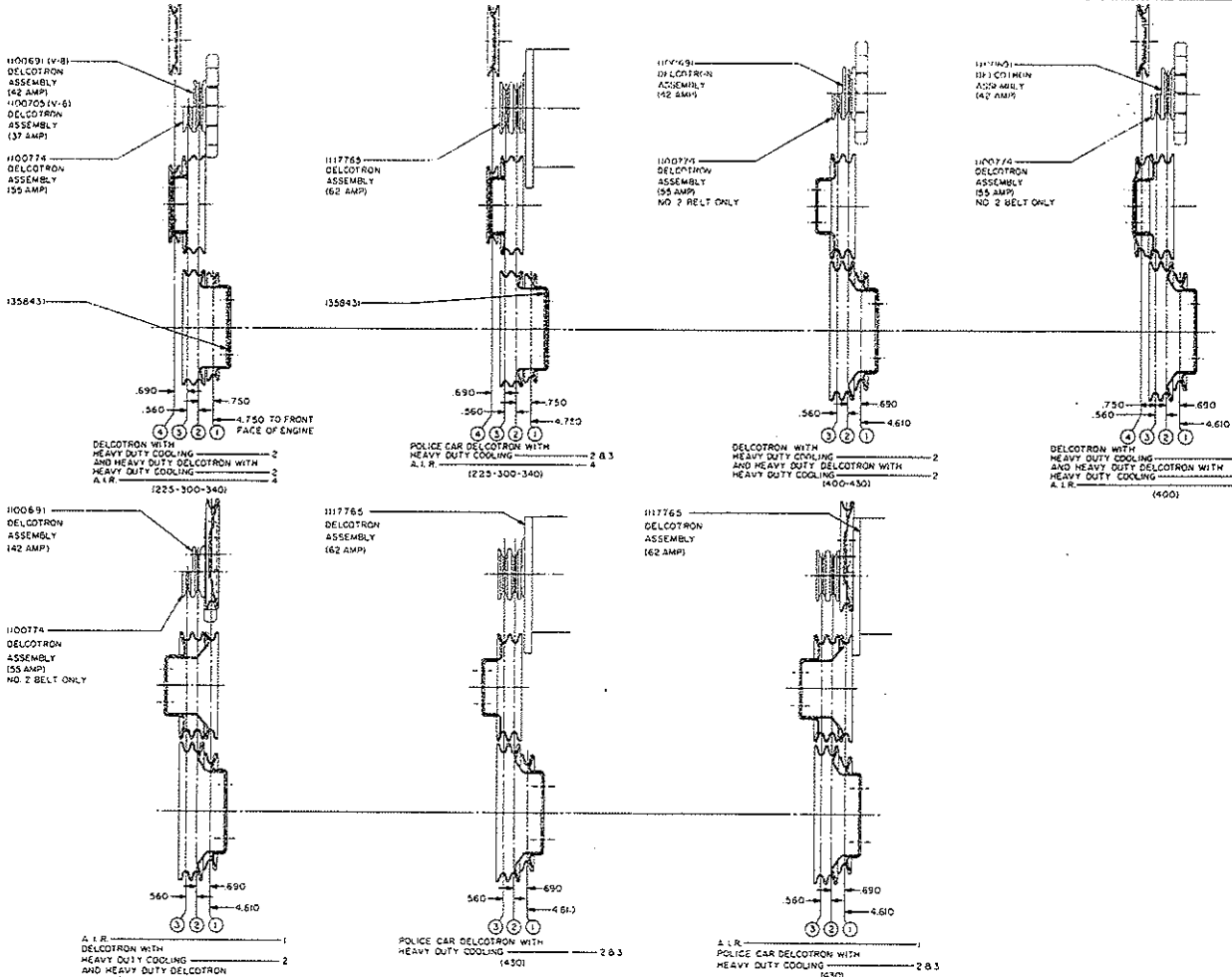
SPEC. DATE SCALE DR. DIMENSIONS
1 1/8" 16 G.S. J.P.P.
REFERENCE 18-137112 18-13722 J.P.P.
MATERIAL, S.A.C.

1380681 6-132

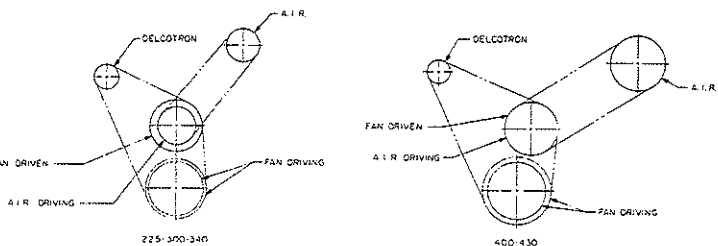
1380682

REV.	DESCRIPTION	DATE	BY	CHK.
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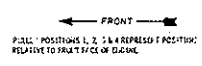
BUICK MOTOR DIVISION
GENERAL WIRE CONNECTION
PART NO. 1380682



1380682



PULLEY S	225-300-340				400			
	HEAVY DUTY		POLICE CAR		HEAVY DUTY		POLICE CAR	
	PART NO.	GAUGE DIA.	PART NO.	GAUGE DIA.	PART NO.	GAUGE DIA.	PART NO.	GAUGE DIA.
CRANK SHAFT	13220	4.35	13220	4.55	13216	4.75	13216	5.25
FAN DRIVE	13220	5.25	13221	5.20	13216	5.25		
DELCO ROL		2.5	1.6	2.42	2.42			
A.I.R. DRIVING	13220	1.90	13220	1.90	13220	1.90		
F.I.R.	2.2	5.1	2.2	5.1	2.2	5.1		



PULLEYS	225-300-340		POLICE CAR		400				600				400			
	PART NO.	GAUGE DIA.	PART NO.	GAUGE DIA.	HEAVY DUTY	POLICE CAR	HEAVY DUTY	POLICE CAR	HEAVY DUTY	POLICE CAR	HEAVY DUTY	POLICE CAR	HEAVY DUTY	POLICE CAR	HEAVY DUTY	POLICE CAR
CRANK SHAFT	13220	4.35	13220	4.55	13216	4.75	13216	5.25	13216	4.75	13216	5.25	13216	4.75	13216	5.25
FAN DRIVE	13220	5.25	13221	5.20	13216	5.25										
DELCO ROL		2.5	1.6	2.42	2.42											
A.I.R. DRIVING	13220	1.90	13220	1.90	13220	1.90										
F.I.R.	2.2	5.1	2.2	5.1	2.2	5.1										

FOR POWER STEERING - SEE PARTS LIST & 1380682-2-4, 2-5 & 1380682-4, 5, 6 & 7

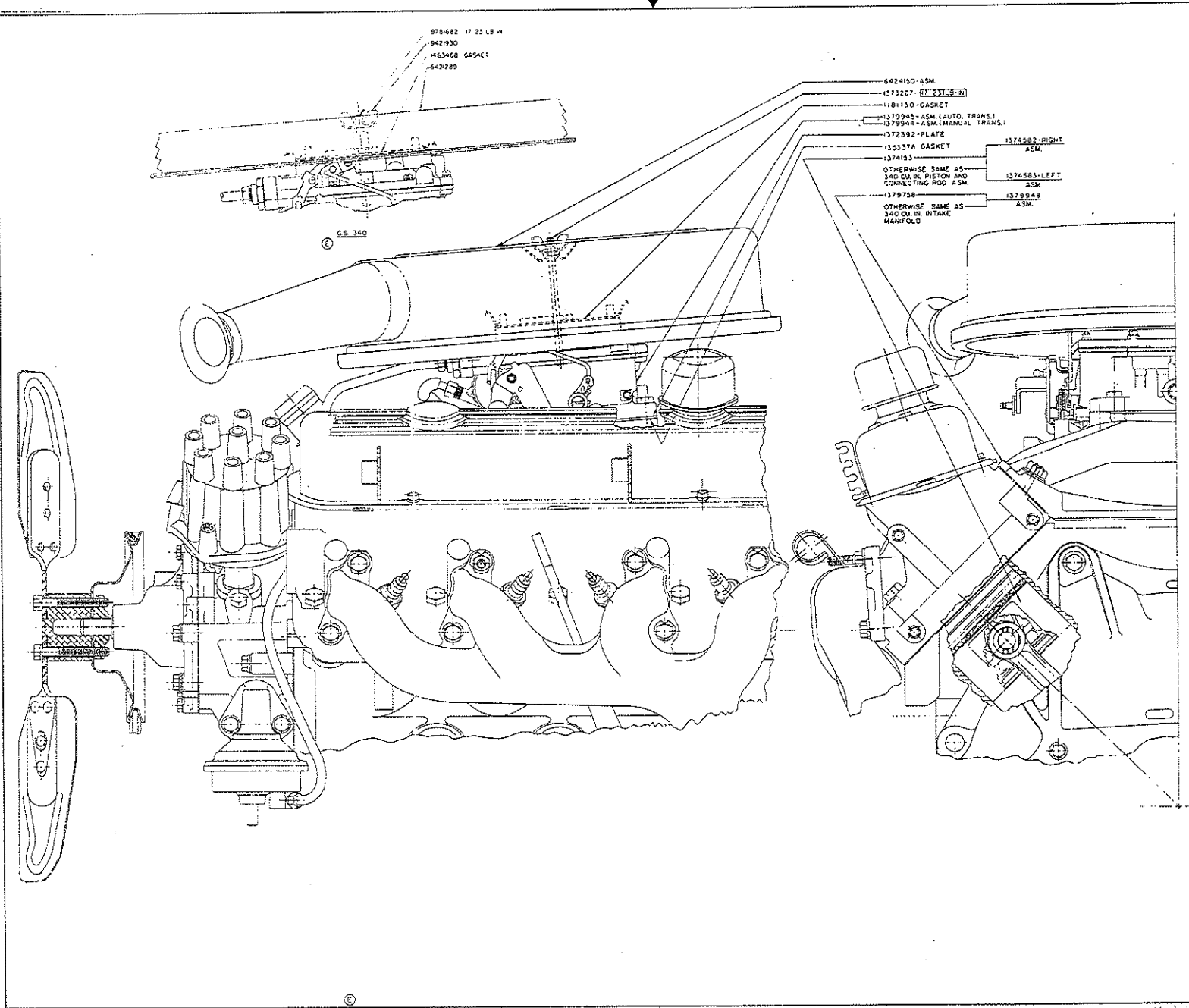
USE IN PLACE OF 1380682-1 & 1380682-2 EQUIPMENT, DELCO FENSION S-400 & DELCO FENSION S-400-2

A.I.R. IS 8-10-10

DO NOT SCALE				REPORT DIMENSIONS			
TOLERANCES UNLESS OTHERWISE SPECIFIED				A			
FRACTIONS				DECIMALS			
AND ALLOWED ON THREE PLACE DECIMALS							
COMMERCIAL TRADING				SHOTS TO STANDARD			
PARTS ROLLED SECTIONS-SHEET METAL GAGES-				DRILLED AND FINISHED HOLES			
BURN ALL DRILLED HOLES				COUNTERSINK ALL			
TAPPED HOLES USE 60°							
DATE	SCALE	SHEET	TOTAL	DATE	SCALE	SHEET	TOTAL
1380682	1:1	1	1	1380682	1:1	1	1
MADE IN U.S.A. - ALL DIMENSIONS IN INCHES							
DATE: 10-1-74							
PART NO: 1380682							
REV: 1-1-74							
1380682				6-14-1			

Insert long sheets 6-15.2, 6-16.2, and 6-17.2 here.

BUICK MOTOR DIVISION
 GENERAL MOTORS CORPORATION
 WARREN, MICH. U.S.A.



137174B

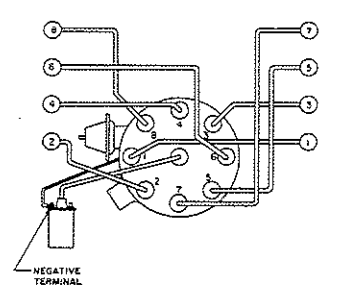
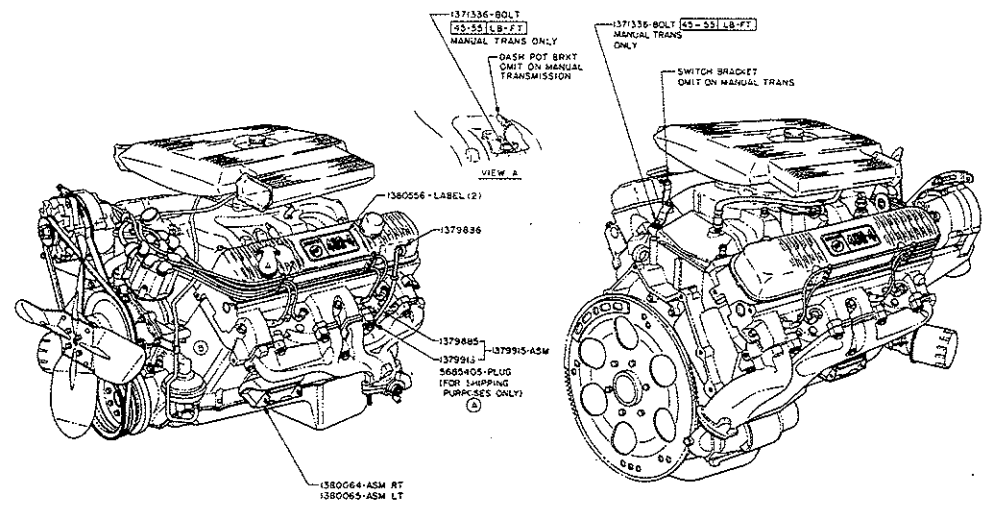
DATE	BY	REVISION	DESCRIPTION
11/13/67		1	ISSUED
		2	REVISED
		3	REVISED
		4	REVISED
		5	REVISED
		6	REVISED
		7	REVISED
		8	REVISED
		9	REVISED
		10	REVISED
		11	REVISED
		12	REVISED
		13	REVISED
		14	REVISED
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		16	REVISED
		17	REVISED
		18	REVISED
		19	REVISED
		20	REVISED

137174B

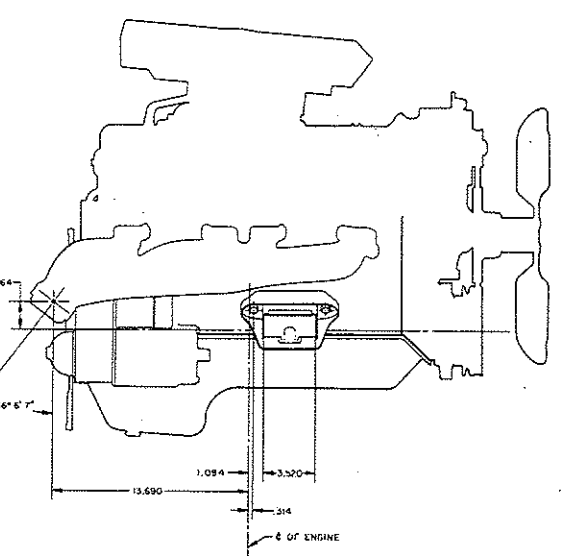
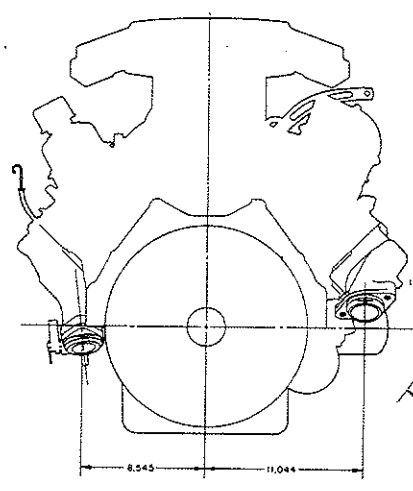
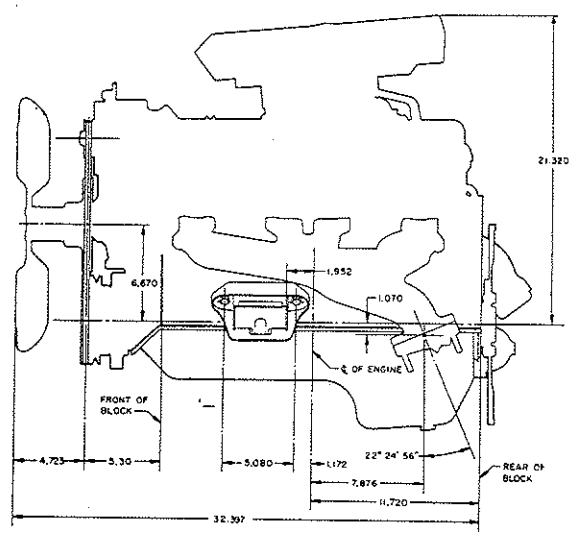
OTHERWISE SAME AS 340 CU. IN. ENGINE ASM.

DO NOT SCALE		REPORT ERRORS	
TOLERANCES UNLESS OTHERWISE SPECIFIED		FRACTIONS ARE TO BE USED	
1/16" ALLOWED ON TWO PLACE DECIMALS		1/32" ALLOWED ON THREE PLACE DECIMALS	
COMMERCIAL TOLERANCES APPLY TO STANDARD PARTS UNLESS OTHERWISE SPECIFIED			
HARDENED AND PHOSPHATED FINISH			
BURN ALL DRILLED HOLES COUNTERSINK ALL TAPPED HOLES 50° X 90°			
DATE	BY	CHK.	DR. PART/MOUNT.
11-13-67			
YEAR USED	1967	YEAR	
REFERENCE		DATE	
MATERIAL SPEC.			
340 CU. IN. (1M) PERFORMANCE			
NAME			
ENGINE INFORMATION ASSEMBLY			
PART NO. 137174B INDEX			
SHEET 2 OF 2 SHEETS 6-18.2			

MAKE SURE PARTS NUMBER
 AND QUANTITY ARE CORRECT
 PART NO. 6-19-1



1380139		
REV	DESCRIPTION	DATE
1	ISSUED FOR CONSTRUCTION	
2	ISSUED FOR CONSTRUCTION	
3	ISSUED FOR CONSTRUCTION	
4	ISSUED FOR CONSTRUCTION	
5	ISSUED FOR CONSTRUCTION	
6	ISSUED FOR CONSTRUCTION	
7	ISSUED FOR CONSTRUCTION	
8	ISSUED FOR CONSTRUCTION	
9	ISSUED FOR CONSTRUCTION	
10	ISSUED FOR CONSTRUCTION	
11	ISSUED FOR CONSTRUCTION	
12	ISSUED FOR CONSTRUCTION	
13	ISSUED FOR CONSTRUCTION	
14	ISSUED FOR CONSTRUCTION	
15	ISSUED FOR CONSTRUCTION	



1380139

OTHERWISE SAME AS 1380138

DO NOT SCALE REPORT ERRORS

FINISHES UNLESS OTHERWISE SPECIFIED

Ø - DIMENSIONS ON THIS BLOCK

2-DIGIT ALLOWED ON THOSE PLACE DECIMALS

CONSTRUCTION DIMENSIONS ONLY TO STANDARD

PARTS-HOLDER SECTIONS-SHEET METAL SHEET

SHIELD AND TYPED HELDS

SOME ALL DRILLED HELDS

CONTOURING ALL

TYPED HELDS AND DIM

DATE	1-20-66	NONE	DR. PIONEER
PREPARED BY	DR. PIONEER		
REFERENCE	46 D.S.	DR. PIONEER	
PARTIAL SPEC			400 C.I.H.

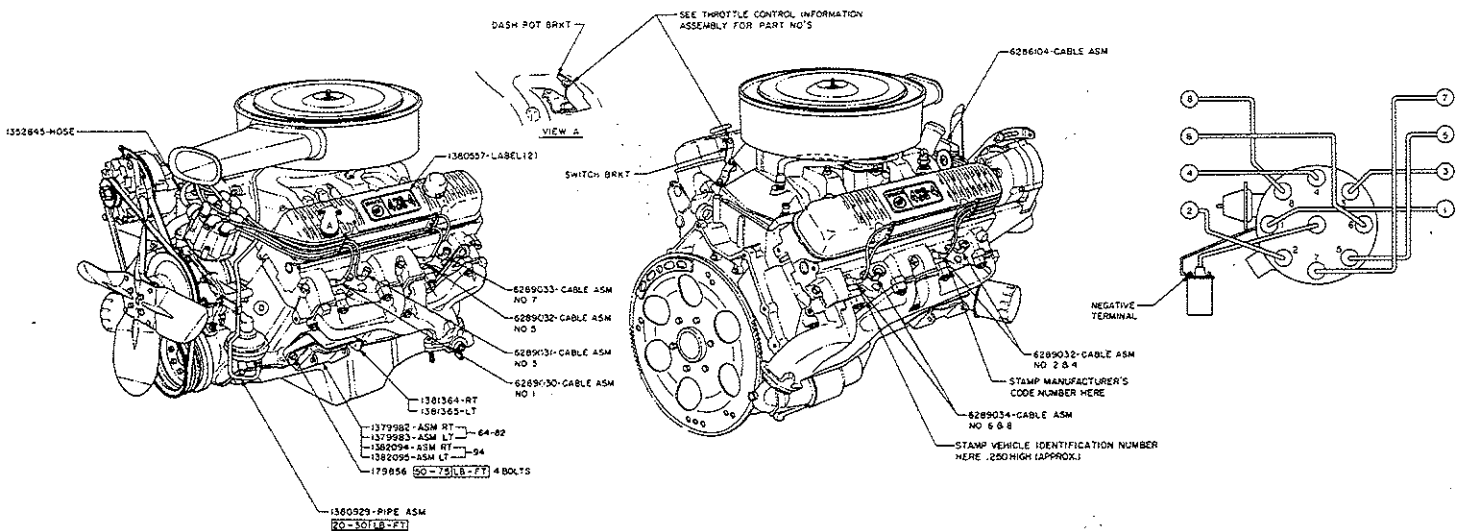
ENGINE INFORMATION ASSEMBLY

PART NO. 1380139 INDEX

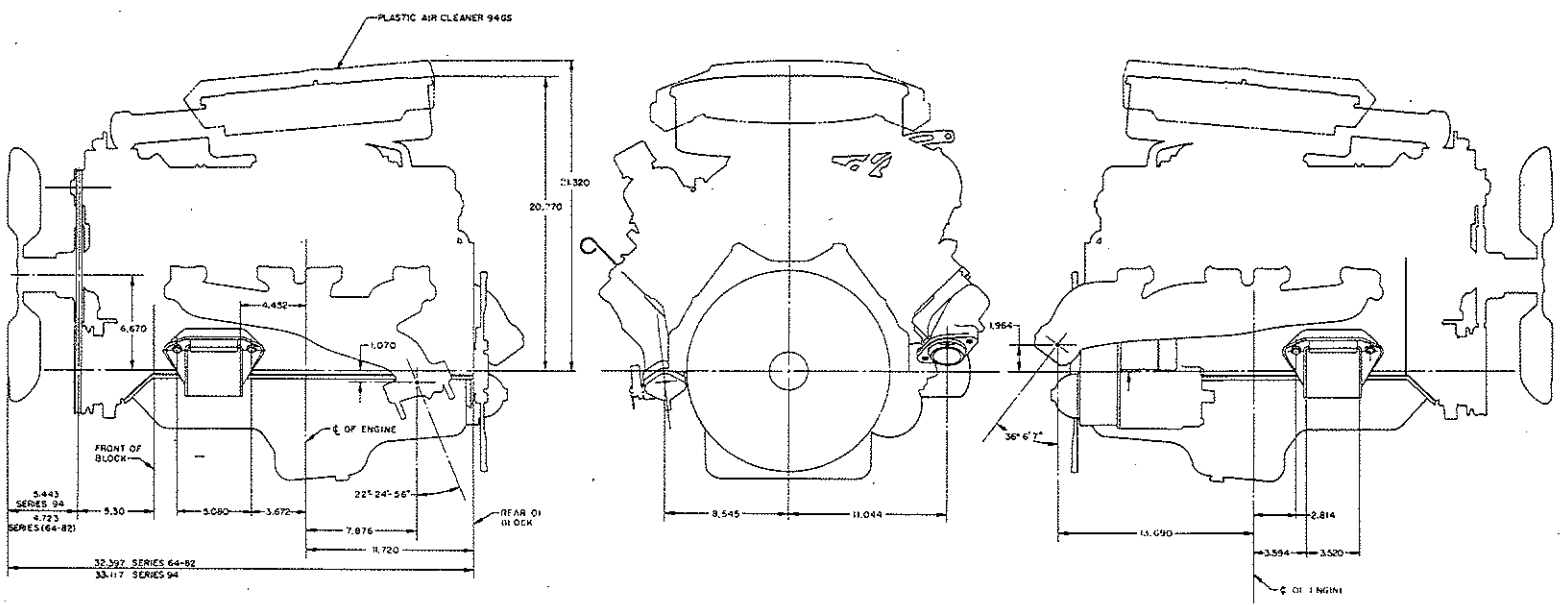
SHEET OF 2 SHEETS G-19-1 V.D.

1380138

REV	DATE	BY	CHKD	DESCRIPTION
1	11-21-66	None	None	Initial Release
2	04-22-68	None	None	Change Part No. 1380138
3	04-22-68	None	None	Change Part No. 1380138
4	04-22-68	None	None	Change Part No. 1380138
5	04-22-68	None	None	Change Part No. 1380138
6	04-22-68	None	None	Change Part No. 1380138
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48	04-22-68	None	None	Change Part No. 1380138
49	04-22-68	None	None	Change Part No. 1380138
50	04-22-68	None	None	Change Part No. 1380138



1380138



DO NOT SCALE	REPORT DIMS
TOLERANCES UNLESS OTHERWISE SPECIFIED	± .001
± .005	± .005
± .010	± .010
± .015	± .015
± .020	± .020
± .030	± .030
± .040	± .040
± .050	± .050
± .060	± .060
± .070	± .070
± .080	± .080
± .090	± .090
± .100	± .100
± .120	± .120
± .150	± .150
± .200	± .200
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± .750	± .750
± .800	± .800
± .850	± .850
± .900	± .900
± .950	± .950
± 1.000	± 1.000
± 1.100	± 1.100
± 1.200	± 1.200
± 1.300	± 1.300
± 1.400	± 1.400
± 1.500	± 1.500
± 1.600	± 1.600
± 1.700	± 1.700
± 1.800	± 1.800
± 1.900	± 1.900
± 2.000	± 2.000
± 2.100	± 2.100
± 2.200	± 2.200
± 2.300	± 2.300
± 2.400	± 2.400
± 2.500	± 2.500
± 2.600	± 2.600
± 2.700	± 2.700
± 2.800	± 2.800
± 2.900	± 2.900
± 3.000	± 3.000
± 3.100	± 3.100
± 3.200	± 3.200
± 3.300	± 3.300
± 3.400	± 3.400
± 3.500	± 3.500
± 3.600	± 3.600
± 3.700	± 3.700
± 3.800	± 3.800
± 3.900	± 3.900
± 4.000	± 4.000
± 4.100	± 4.100
± 4.200	± 4.200
± 4.300	± 4.300
± 4.400	± 4.400
± 4.500	± 4.500
± 4.600	± 4.600
± 4.700	± 4.700
± 4.800	± 4.800
± 4.900	± 4.900
± 5.000	± 5.000
± 5.100	± 5.100
± 5.200	± 5.200
± 5.300	± 5.300
± 5.400	± 5.400
± 5.500	± 5.500
± 5.600	± 5.600
± 5.700	± 5.700
± 5.800	± 5.800
± 5.900	± 5.900
± 6.000	± 6.000
± 6.100	± 6.100
± 6.200	± 6.200
± 6.300	± 6.300
± 6.400	± 6.400
± 6.500	± 6.500
± 6.600	± 6.600
± 6.700	± 6.700
± 6.800	± 6.800
± 6.900	± 6.900
± 7.000	± 7.000
± 7.100	± 7.100
± 7.200	± 7.200
± 7.300	± 7.300
± 7.400	± 7.400
± 7.500	± 7.500
± 7.600	± 7.600
± 7.700	± 7.700
± 7.800	± 7.800
± 7.900	± 7.900
± 8.000	± 8.000
± 8.100	± 8.100
± 8.200	± 8.200
± 8.300	± 8.300
± 8.400	± 8.400
± 8.500	± 8.500
± 8.600	± 8.600
± 8.700	± 8.700
± 8.800	± 8.800
± 8.900	± 8.900
± 9.000	± 9.000
± 9.100	± 9.100
± 9.200	± 9.200
± 9.300	± 9.300
± 9.400	± 9.400
± 9.500	± 9.500
± 9.600	± 9.600
± 9.700	± 9.700
± 9.800	± 9.800
± 9.900	± 9.900
± 10.000	± 10.000

BLACK MOTOR DIVISION
DETROIT, MICH. U.S.A.

NAME ENGINE INFORMATION ASSEMBLY
PART NO 1380138 INDEX
SHEET 1 OF 2 SHEETS 6-20.1