



1967 BUICK ASSEMBLY INSTRUCTION MANUAL

SPECIAL - SKYLARK 43000 - 44000 SERIES

BRAKES (SECTION 5)

	<u>PAGE NO.</u>		<u>PAGE NO.</u>
Brakes - General Information	5-1.1	Brake Initial Filling & Bleeding Info.	5-8.1
Storage & Handling - Hoses - Pipes & Junction Blocks		Final Check - and care and storage of brake fluid	
* Master Cylinder Usage & Identification	5-1.2	Parking Brake Installations Cable Guides - Connectors Routing - Light Switch & Pedal Installation - 1967 Pedal Covers - Color (Black only)	5-9.1
Brake & Wheel Information Assy. & Drum Special Paint Requirements when Chrome Wheel Option is specified	5-2.1		
Brake & Wheel Information Assy. & Drum Special Paint Requirements with Chrome Wheel Option	5-3.1		
Disc Brake Pipe & Master Cylinder Installations. For further info., see 5-5.1 - 5-6.1 - 5-7.1 or Front Brake & Wheel Info. Page 5-2.1	5-4.1		
Brake Pipes - Installations (ALL MODELS)	5-5.1		
Brake Pedal & Master Cylinder Installations (Manual) with Manual or Auto. Transmission Stoplight Switch & Hole use instructions	5-6.1		
Brake Pedal & Master Cylinder Installations - (Power) with Manual or Auto. Transmission - Stoplight switch - pipe and hose	5-7.1		

* 7/6/66

PART NUMBER-1379480

PAGE NUMBER- 5-1.0



1967 BUICK ASSEMBLY INSTRUCTION MANUAL

SPECIAL - SKYLARK 43000 - 44000 SERIES
BRAKES (SECTION 5)

GENERAL INFORMATION

RECEIVING, STORAGE AND HANDLING INFORMATION.

BRAKE HOSES, BRAKE PIPES, JUNCTION BLOCKS.

CLEANLINESS PRECAUTIONS

Parts which comprise the chassis hydraulic portion of the brake system must be shipped, stored, handled and assembled in a manner that will prevent contamination of the hydraulic fluid by water, dirt, oil, gasoline or any other impurity.

HANDLING PRECAUTIONS

Brake pipes, rubber hoses, gaskets and junction blocks are to be handled in a manner which will minimize the possibility of impact damage to threaded fittings, bending, kinking or crushing of metal pipes.

Parts which have been damaged are to be destroyed and discarded.

*NOTE: Brake fill bleed and test procedure shown on page 5-8.1

*SEE : Buick Specification No. 1122 for Brake Pipe Distributor and Switch assembly test specification, available in Plant Specification Department.

*9-8-66

PART NUMBER-1379480

PAGE NUMBER- 5-1.1



1967 BUICK ASSEMBLY INSTRUCTION MANUAL

SPECIAL - SKYLARK 43000 - 44000 SERIES
BRAKES (SECTION 5)

MASTER CYLINDER IDENTIFICATION

GENERAL INFORMATION

BRAKE MASTER CYLINDERS ARE IDENTIFIED BY LABEL TAG ATTACHED ABOUT THE BAIL WIRE ON MANUAL BRAKES AND WILL BE SLIPPED OVER THE BARBS OF THE VACUUM CHECK VALVE ON POWER BRAKE CYLINDERS.

<u>USAGE</u>	<u>ASM. NO.</u>	<u>I.D. CODE</u>
Power - (Drum)	5456009	UA
Power - Disc	5460280	TH
Manual Brake	5452480	RK

* Brake Drum Identification Color

* The Front Brake and Wheel Assemblies as shipped by Factory 31 are color-coded on the backing plate below the Steering Arm for usage identification as follows:

1. Cast iron drums - All A Series except GS - (White Paint Daub)
2. Aluminum Drums - 446 GS (White Daub)
3. Aluminum Drums - 448 Sportwagons (Black Daub)

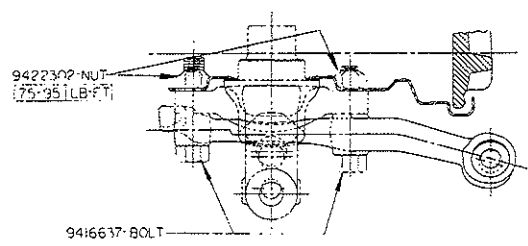
* Note: Braques must be used as released due to specific brakeshoe Assembly for the GS and Sportwagon.

*9-15-66

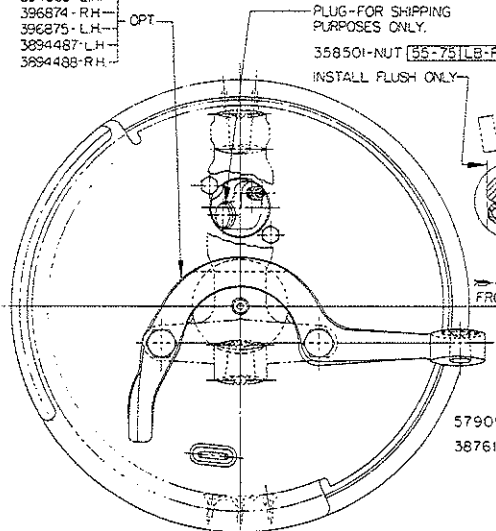
PART NUMBER-1379480

PAGE NUMBER- 5-1.2

NO.	DESCRIPTION	QTY.	REMARKS
1	379502 DRUM ASM.	1	
2	1380005 LINER	1	
3	1380007	1	
4	1380008	1	
5	1380009	1	
6	1380010	1	
7	118208257 R L W	1	
8	1380003 BOLT	1	
9	1380004 GASKET	1	
10	1359633 HUB	1	
11	1380001 HUB & DRUM ASM.	1	

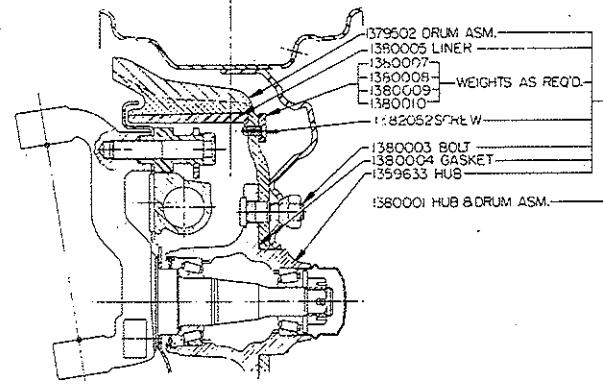


- 394568-RH
- 394569-LH
- 396874-RH
- 396875-LH
- 3984487-LH
- 3984488-RH



PLUG-FOR SHIPPING PURPOSES ONLY.
 358501-NUT [55-75]LB-F.T
 INSTALL FLUSH ONLY

FOR BALANCE WEIGHT INFORMATION OF WHEEL & TIRE BALANCE INFORMATION ASSEMBLY, FOR PART NUMBER SEE ENGINEERING RELEASES & TABULATED SHEET 9421500



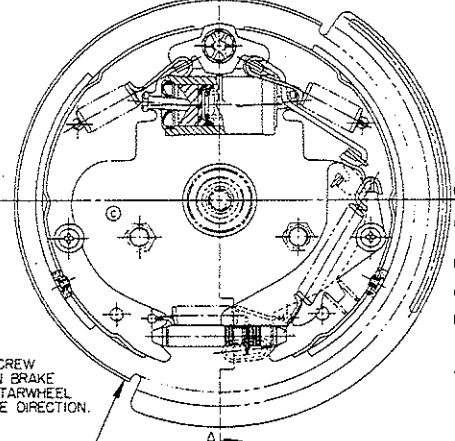
- 379502 DRUM ASM.
- 1380005 LINER
- 1380007
- 1380008
- 1380009
- 1380010
- 118208257 R L W
- 1380003 BOLT
- 1380004 GASKET
- 1359633 HUB
- 1380001 HUB & DRUM ASM.

SECTION A-A
 46 & 44-46 SPT WAGONS
 O.S.A. 33-34-43-44 REG. A

- 9423879-BOLT [80-105]LB-F.T
- 1359512
- 1359514
- 1359515
- 1359516
- 1375383-ASM
- 1358741-DISC
- 579116
- 1359633
- 7450631
- 7450628
- 1377136-ASM

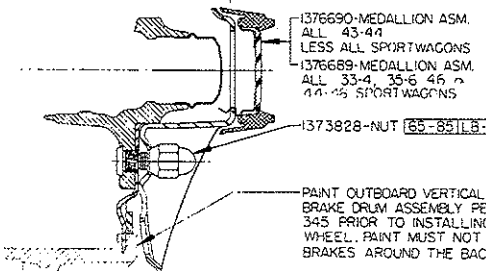
- 1366235
- 1369761-COTTER PIN
- 378137-SEE NOTE
- 3775189
- 7450629-7450627-ASM.
- 7450632-7450630-ASM.

TO TIGHTEN BRAKE ROTATE SCREW IN THIS DIRECTION TO LOOSEN BRAKE LIFT ACTUATOR AWAY FROM STARWHEEL & ROTATE SCREW IN OPPOSITE DIRECTION.



- 1380814
- ASSEMBLY PROCEDURE:
- (1) - ENGAGE T-READS OF BOLT IN STEERING KNUCKLE BY HAND
 - (2) - SEAT BOLT WITH MAX. OF 10LB-F.T. OF TORQUE.
 - (3) - BACK BOLT OUT 1/2 TO 1 TURN.
 - (4) - IF BOLT SEATS AND BACKS OUT FREELY WITHOUT SEIZURE APPLY SPECIFIED ASSEMBLY TORQUE.
 - (5) - IF BOLT DOES NOT SEAT WITH 10LB-F.T. TORQUE OR DOES NOT BACK OUT FREELY HOLD ENTIRE ASSEMBLY FOR INSPECTION FOR CAUSE OF SEIZURE. DO NOT REPAIR UNTIL INSPECTION HAS BEEN COMPLETED.

- 5468354-LH-33-34-43-44-46 & REG. WAGONS
- 5468355-RH- WAGONS
- 5468318-LH-44-46 SPORT WAGONS
- 5468319-RH-



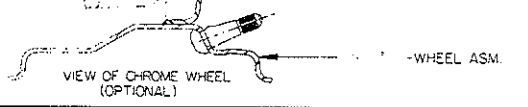
1376690-MEDALLION ASM. ALL 43-44 LESS ALL SPORT WAGONS
 1376689-MEDALLION ASM. ALL 33-4, 35-6 46 & 44-46 SPORT WAGONS
 1373828-NUT [65-85]LB-F.T

PAINT OUTBOARD VERTICAL SURFACE OF BRAKE DRUM ASSEMBLY PER BUICK SPEC. 345 PRIOR TO INSTALLING THE CHROME WHEEL. PAINT MUST NOT ENTER THE BRAKES AROUND THE BACKING PLATE.

NOTE:
 WHILE WHEEL ROTATES ONE TURN MINIMUM, TORQUE SPINDLE NUT TO [18-20]LB-F.T. BACK-OFF UNTIL BEARINGS ARE LOOSE.
 RE-TORQUE SPINDLE NUT TO [80-84]LB-F.T.
 (1) IF A COTTER PIN HOLE IN SPINDLE IS IN LINE WITH A SLOT IN NUT BACK-OFF 1/2 REVOLUTION, INSTALL COTTER PIN.
 (2) IF A COTTER PIN HOLE IN SPINDLE DOES NOT LINE UP WITH A SLOT IN NUT BACK-OFF 1/2 REVOLUTION MINIMUM, 1/8 REVOLUTION MAXIMUM, INSTALL COTTER PIN.

(3) THIS ADJUSTMENT SHOULD GIVE .002 TO .006 HUB END PLAY ON SPINDLE.

SECTION A-A
 GROUND LINE (33-34-43-44)
 R1 U31 A11



VIEW OF CHROME WHEEL (OPTIONAL)

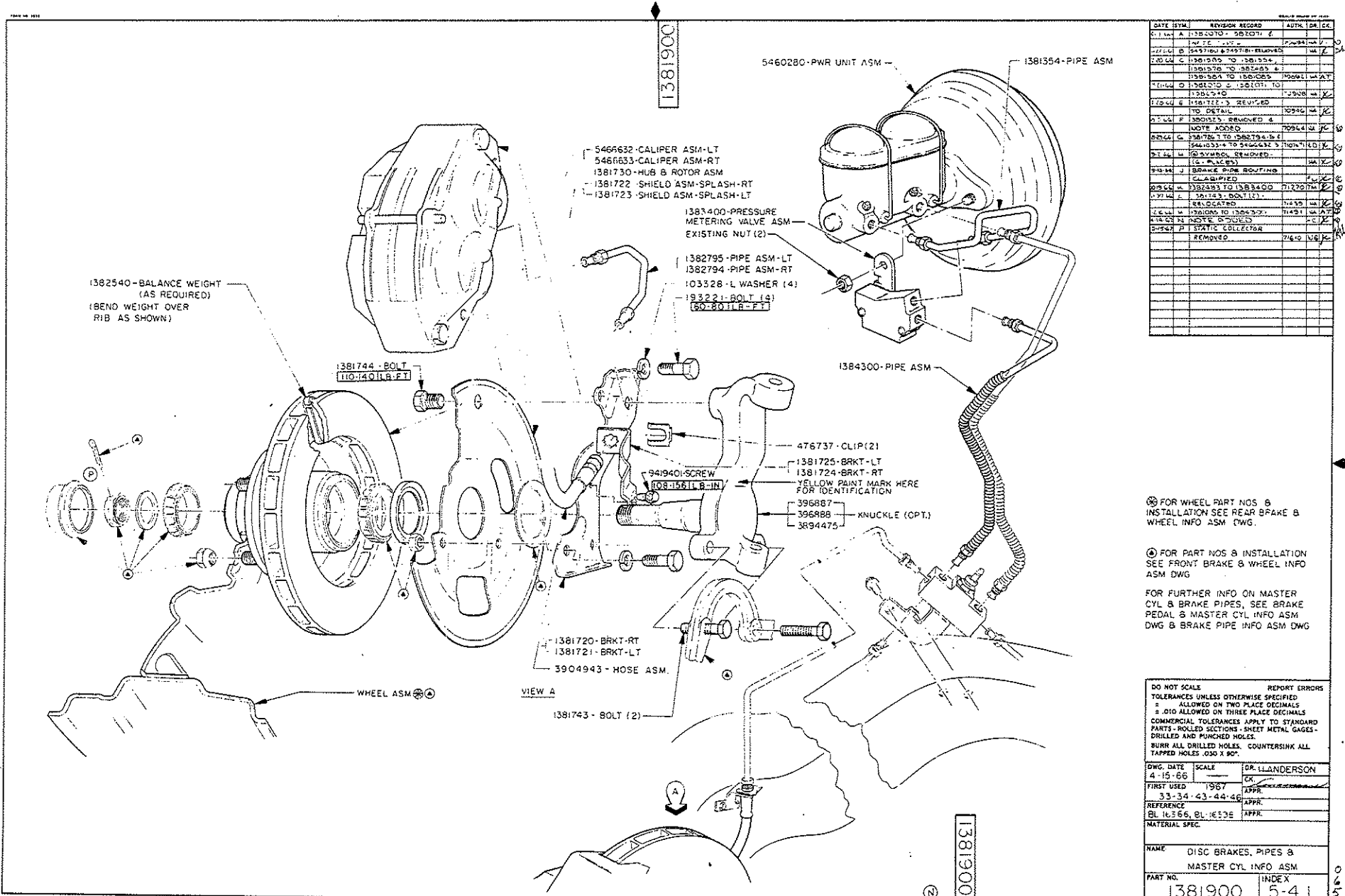
BUICK MOTOR DIVISION
 WARREN, MICH. U.S.A.

NO.	DESCRIPTION	QTY.	REMARKS
1	379502 DRUM ASM.	1	
2	1380005 LINER	1	
3	1380007	1	
4	1380008	1	
5	1380009	1	
6	1380010	1	
7	118208257 R L W	1	
8	1380003 BOLT	1	
9	1380004 GASKET	1	
10	1359633 HUB	1	
11	1380001 HUB & DRUM ASM.	1	

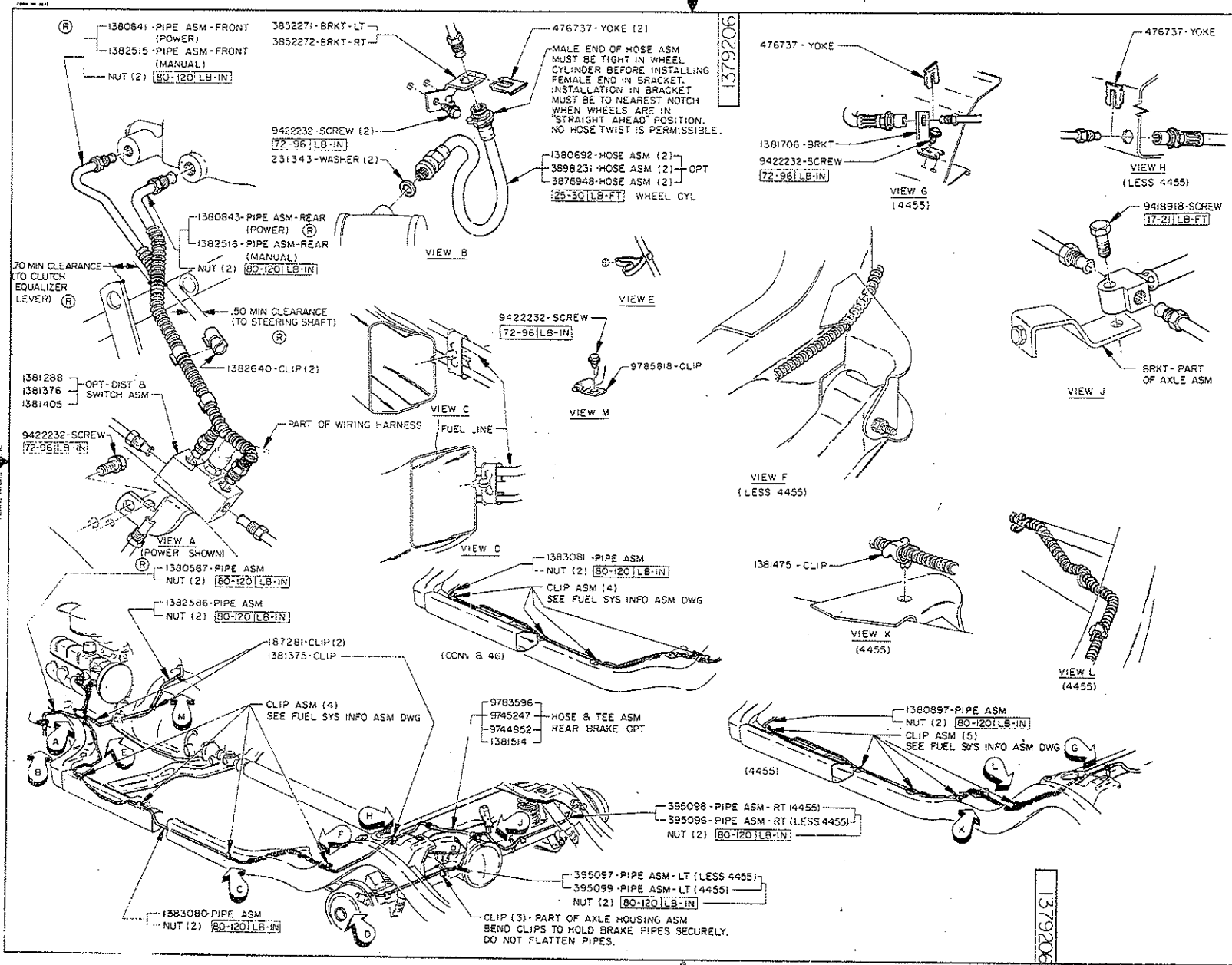
DO NOT SCALE DIMENSIONS UNLESS OTHERWISE SPECIFIED
 1. DIMENSIONS ON THIS DRAWING ARE UNLESS OTHERWISE SPECIFIED
 COMMERCIAL TOLERANCES APPLY TO STANDARD PARTS UNLESS OTHERWISE SPECIFIED WITH OTHER DIMENSIONS AND FINISHED HOLES
 HUB END FINISHED HOLES GOVERN OVER ALL OTHER HOLES 200 & UP
 DIMENSIONS IN PARENTHESES ARE FOR REFERENCE ONLY
 DIMENSIONS IN PARENTHESES ARE FOR REFERENCE ONLY
 DIMENSIONS IN PARENTHESES ARE FOR REFERENCE ONLY
 DIMENSIONS IN PARENTHESES ARE FOR REFERENCE ONLY

FRONT
 BUICK MOTOR DIVISION
 WARREN, MICH. U.S.A.
 1380814 5-21

BUICK MOTOR DIVISION
GENERAL MOTORS CORPORATION
Warren, Mich., U.S.A.



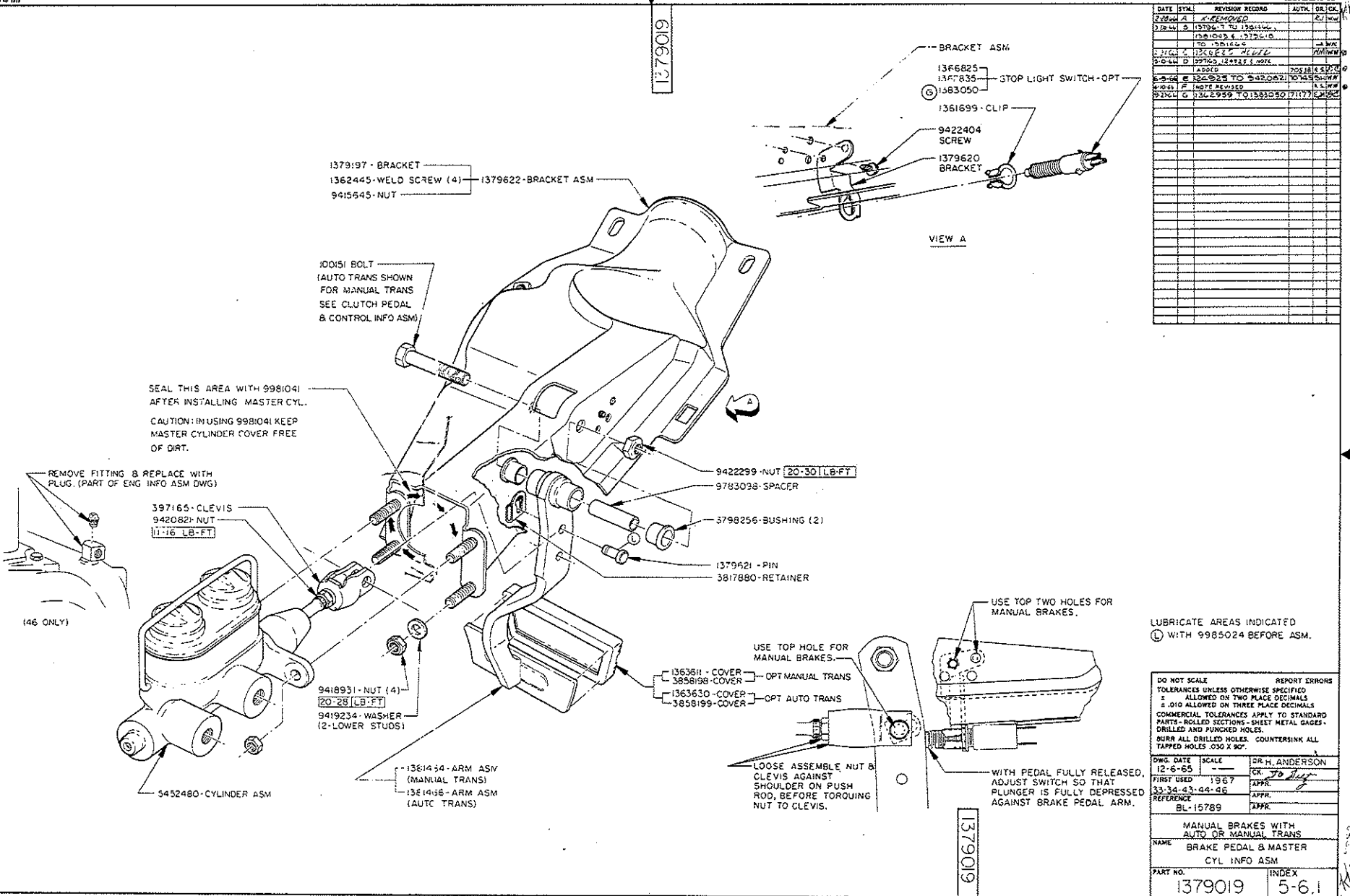
BUICK MOTOR DIVISION
GENERAL MOTORS CORPORATION
FLINT, MICH. U.S.A.



DATE	SYM.	REVISION RECORD	AUTH.	OR. CK.
11-8-65	A	REVISED TO 4455	DR. H. ANDERSON	
11-8-65	B	1381501 TO 1381532 (3 PLACES), 1380692 (1380690 ADDED)		
3-0-66	C	0743475, 361777 (1380640) (OPT TO 1380640), 387441, 387442, 387443 TO 387445, 387446 TO 387448, 387449 TO 387451, 387452 TO 387454, 387455 TO 387457, 387458 TO 387460, 387461 TO 387463, 387464 TO 387466, 387467 TO 387469, 387470 TO 387472, 387473 TO 387475, 387476 TO 387478, 387479 TO 387481, 387482 TO 387484, 387485 TO 387487, 387488 TO 387490, 387491 TO 387493, 387494 TO 387496, 387497 TO 387499, 387500 TO 387502, 387503 TO 387505, 387506 TO 387508, 387509 TO 387511, 387512 TO 387514, 387515 TO 387517, 387518 TO 387520, 387521 TO 387523, 387524 TO 387526, 387527 TO 387529, 387530 TO 387532, 387533 TO 387535, 387536 TO 387538, 387539 TO 387541, 387542 TO 387544, 387545 TO 387547, 387548 TO 387550, 387551 TO 387553, 387554 TO 387556, 387557 TO 387559, 387560 TO 387562, 387563 TO 387565, 387566 TO 387568, 387569 TO 387571, 387572 TO 387574, 387575 TO 387577, 387578 TO 387580, 387581 TO 387583, 387584 TO 387586, 387587 TO 387589, 387590 TO 387592, 387593 TO 387595, 387596 TO 387598, 387599 TO 387601, 387602 TO 387604, 387605 TO 387607, 387608 TO 387610, 387611 TO 387613, 387614 TO 387616, 387617 TO 387619, 387620 TO 387622, 387623 TO 387625, 387626 TO 387628, 387629 TO 387631, 387632 TO 387634, 387635 TO 387637, 387638 TO 387640, 387641 TO 387643, 387644 TO 387646, 387647 TO 387649, 387650 TO 387652, 387653 TO 387655, 387656 TO 387658, 387659 TO 387661, 387662 TO 387664, 387665 TO 387667, 387668 TO 387670, 387671 TO 387673, 387674 TO 387676, 387677 TO 387679, 387680 TO 387682, 387683 TO 387685, 387686 TO 387688, 387689 TO 387691, 387692 TO 387694, 387695 TO 387697, 387698 TO 387700, 387701 TO 387703, 387704 TO 387706, 387707 TO 387709, 387710 TO 387712, 387713 TO 387715, 387716 TO 387718, 387719 TO 387721, 387722 TO 387724, 387725 TO 387727, 387728 TO 387730, 387731 TO 387733, 387734 TO 387736, 387737 TO 387739, 387740 TO 387742, 387743 TO 387745, 387746 TO 387748, 387749 TO 387751, 387752 TO 387754, 387755 TO 387757, 387758 TO 387760, 387761 TO 387763, 387764 TO 387766, 387767 TO 387769, 387770 TO 387772, 387773 TO 387775, 387776 TO 387778, 387779 TO 387781, 387782 TO 387784, 387785 TO 387787, 387788 TO 387790, 387791 TO 387793, 387794 TO 387796, 387797 TO 387799, 387800 TO 387802, 387803 TO 387805, 387806 TO 387808, 387809 TO 387811, 387812 TO 387814, 387815 TO 387817, 387818 TO 387820, 387821 TO 387823, 387824 TO 387826, 387827 TO 387829, 387830 TO 387832, 387833 TO 387835, 387836 TO 387838, 387839 TO 387841, 387842 TO 387844, 387845 TO 387847, 387848 TO 387850, 387851 TO 387853, 387854 TO 387856, 387857 TO 387859, 387860 TO 387862, 387863 TO 387865, 387866 TO 387868, 387869 TO 387871, 387872 TO 387874, 387875 TO 387877, 387878 TO 387880, 387881 TO 387883, 387884 TO 387886, 387887 TO 387889, 387890 TO 387892, 387893 TO 387895, 387896 TO 387898, 387899 TO 387901, 387902 TO 387904, 387905 TO 387907, 387908 TO 387910, 387911 TO 387913, 387914 TO 387916, 387917 TO 387919, 387920 TO 387922, 387923 TO 387925, 387926 TO 387928, 387929 TO 387931, 387932 TO 387934, 387935 TO 387937, 387938 TO 387940, 387941 TO 387943, 387944 TO 387946, 387947 TO 387949, 387950 TO 387952, 387953 TO 387955, 387956 TO 387958, 387959 TO 387961, 387962 TO 387964, 387965 TO 387967, 387968 TO 387970, 387971 TO 387973, 387974 TO 387976, 387977 TO 387979, 387980 TO 387982, 387983 TO 387985, 387986 TO 387988, 387989 TO 387991, 387992 TO 387994, 387995 TO 387997, 387998 TO 387999		

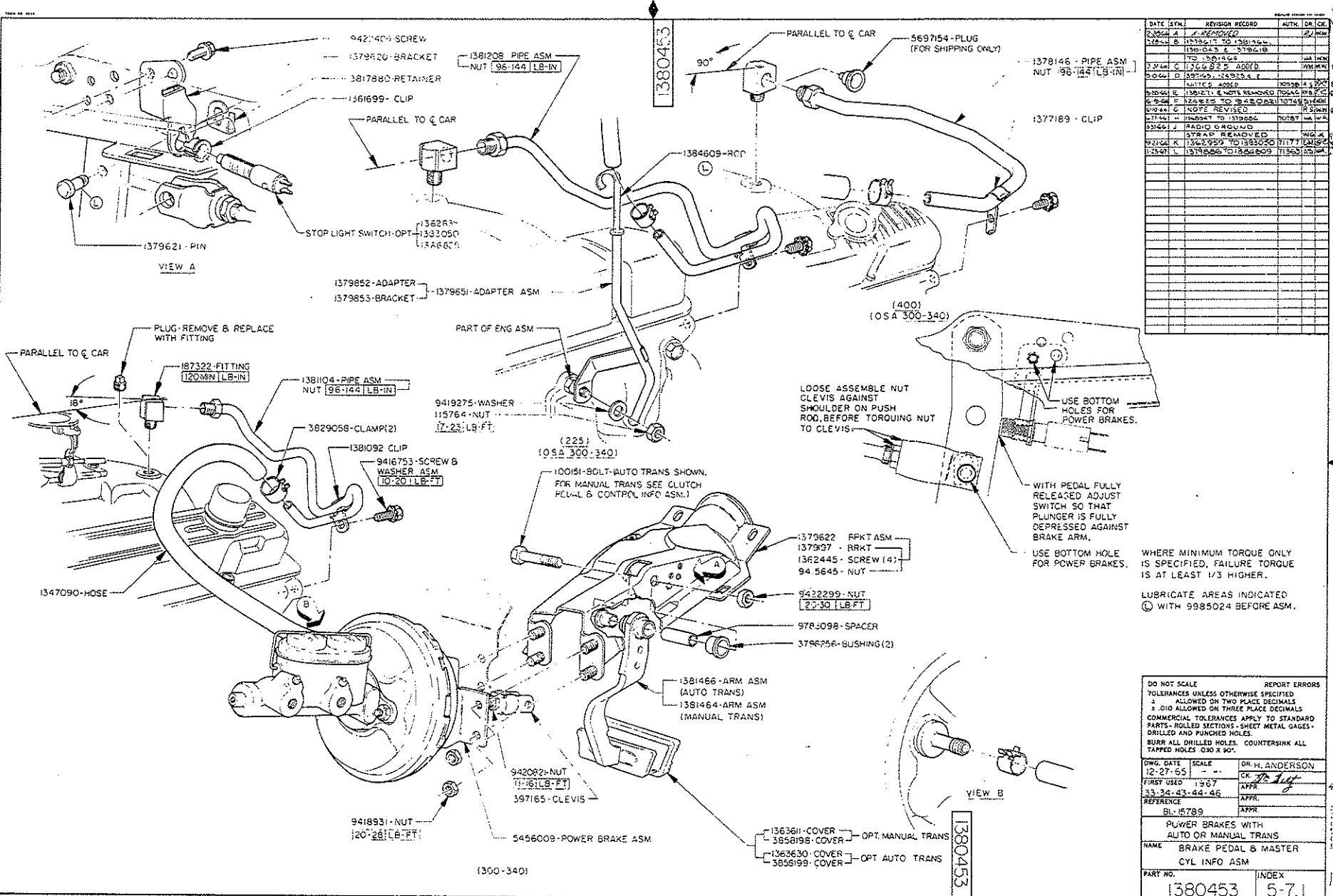
FOR FILLING & BLEEDING INFORMATION SEE 1380197.

DO NOT SCALE		REPORT ERRORS	
TOLERANCES UNLESS OTHERWISE SPECIFIED		± .010 ALLOWED ON TWO 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. H. ANDERSON	
11-8-65			
FIRST USED	3-3-64	APP. [Signature]	
REFERENCE	BL-15806	APP. [Signature]	
MATERIAL SPEC.			
NAME BRAKE PIPE INFORMATION ASSEMBLY			
PART NO.	INDEX		
1379206	5-5.1		



DATE	DRAWN	REVISION RECORD	AUTH.	DR.	CHK.
2-24-61	A	REMOVED			
3-28-61	B	1379621 TO 1379622			
		1361003 & 1379610			
3-27-61	C	1379621 - PLUG			
3-20-61	D	1379621 - NOTE			
		ADDED	20618	6	5/10
6-2-64	E	1362445 TO 1362446	10145		
		WORKS			
9-29-64	G	1362959 TO 1363080	71177		

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



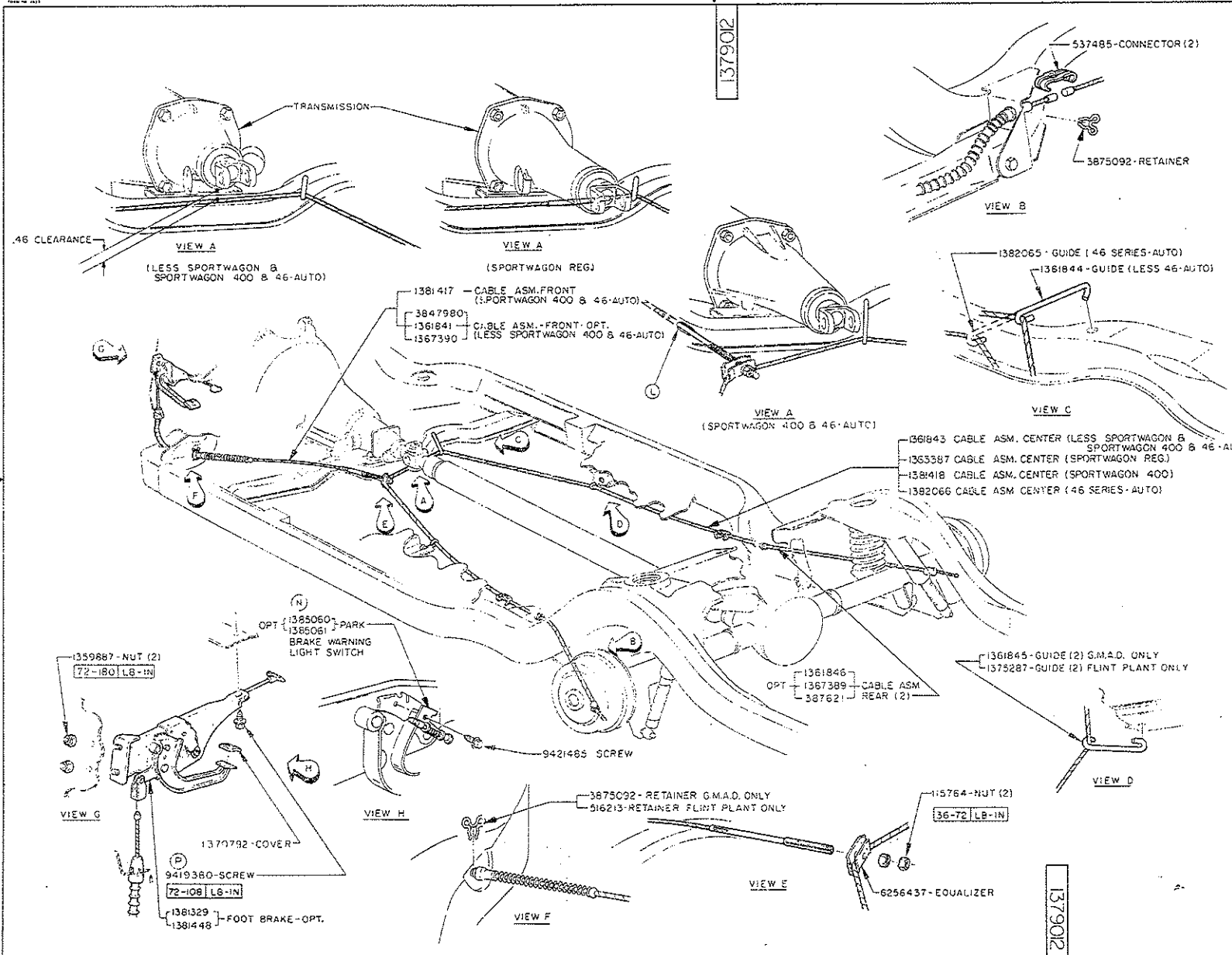
DATE	SYN.	REVISION RECORD	AUTH.	DR.	CHK.
12-27-65		1380453 & 1379622			
1-24-66		1380453 & 1379622			
2-24-66		1380453 & 1379622			
3-24-66		1380453 & 1379622			
4-24-66		1380453 & 1379622			
5-24-66		1380453 & 1379622			
6-24-66		1380453 & 1379622			
7-24-66		1380453 & 1379622			
8-24-66		1380453 & 1379622			
9-24-66		1380453 & 1379622			
10-24-66		1380453 & 1379622			
11-24-66		1380453 & 1379622			
12-24-66		1380453 & 1379622			
1-24-67		1380453 & 1379622			
2-24-67		1380453 & 1379622			
3-24-67		1380453 & 1379622			
4-24-67		1380453 & 1379622			
5-24-67		1380453 & 1379622			
6-24-67		1380453 & 1379622			
7-24-67		1380453 & 1379622			
8-24-67		1380453 & 1379622			
9-24-67		1380453 & 1379622			
10-24-67		1380453 & 1379622			
11-24-67		1380453 & 1379622			
12-24-67		1380453 & 1379622			

DO NOT SCALE		REPORT ERRORS	
TOLERANCES UNLESS OTHERWISE SPECIFIED		3 ALLOWED ON TWO PLACE DECIMALS	
1.010 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 90° X 90°.		DR. H. ANDERSON	
OWG. DATE	SCALE	CHK.	APPR.
12-27-65			
FIRST USED	1967	APPR.	
REFERENCE	33-34-43-44-46	APPR.	
REFERENCE	BL-15789	APPR.	
POWER BRAKES WITH AUTO OR MANUAL TRANS			
NAME BRAKE PEDAL & MASTER CYL INFO ASM			
PART NO.	INDEX		
1380453	5-7.1		

8- V7 P14S15

BUICK MOTOR DIVISION
GENERAL MOTORS CORPORATION
WARREN, MI 48090 U.S.A.

137902



DATE	BY	REVISION RECORD	AUTH	OR	CHK
2-6-65	A	#1 REMOVED			SP/AC
	B	1364259 TO 1361329			
		1365224 TO 1364430			
		SPORTWAGON 400			
		INFO. 13718 & 7			
		1343183 ADD'D			
		1370792 REVISED			
		TO DETAIL			
		NOTE REMOVED			
		1370792 ADD'D			
		1381417 REVISED			
		1367390 & 1367068			
		ADD'D			
		1381417 REVISED TO			
		DETAIL			
		1364259 REMOVE			
		ADD'D			
		1370792 TO 1361043			
		1361329 & 136721 OPT INFO (W/1367390)			
		1363387 TO 1363421 (FROM 1363387)			
		1361844 TO 1361843			
		1361844 TO 1361843			
		1361844 TO 1361843			
		1365061 ADD'D			
		1365061 TO 9419380			

LUBRICATE AREAS INDICATED (L) WITH 9985024 BEFORE ASSEMBLY

ADJUST REAR CABLE TENSION IN RELEASED POSITION TO PRODUCE A PEDAL LOAD OF 80-100 LBS. FOR 7 CLICKS TRAVEL OF PEDAL.

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-DRIILLED AND PUNCHED HOLES.
BURR ALL DRILLED HOLES. COUNTERSINK ALL TAPPED HOLES .030 X 90°.

OWG. DATE 9-29-65 SCALE DR. P. JOHNSON
FIRST USED 1967 CR. J. JOHNSON
33-34-43-44-46 APPR.
REFERENCE BL 16340 APPR.
DL-14808 DL-14852 APPR.

NAME PARKING BRAKE
INFORMATION ASSEMBLY
PART NO. 137902 INDEX 5-9.1

V5 P14 515