

1967 BUICK ASSEMBLY INSTRUCTION MANUAL

SPECIAL - SKYLARK 43000 - 44000 SERIES
AXLE - REAR SUSPENSION & DRIVELINE (SECTION 4)

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2-15-67

PART NUMBER-1379480

PAGE NUMBER- 4-1.0



1967 BUICK ASSEMBLY INSTRUCTION MANUAL

SPECIAL - SKYLARK 43000 - 44000 SERIES
AXLE & REAR SUSPENSION (SECTION 4)

REAR UPPER AND LOWER CONTROL ARM ASSEMBLY IDENTIFICATION

Control Arm Assemblies are identified by a yellow stamp identification. .75" high letters on top face of the arm.

UPPER ARM ASSEMBLIES

PART NO.	BUSHING PART NO.	IDENTIFICATION	USAGE
1373775	1368451	AE	Auto Trans. Less H.D., 46 G.S. & Less Wagons
1381608	1370101	AK	A Series Reg. H.D. 46 G.S. & All Wagons

LOWER ARM ASSEMBLIES

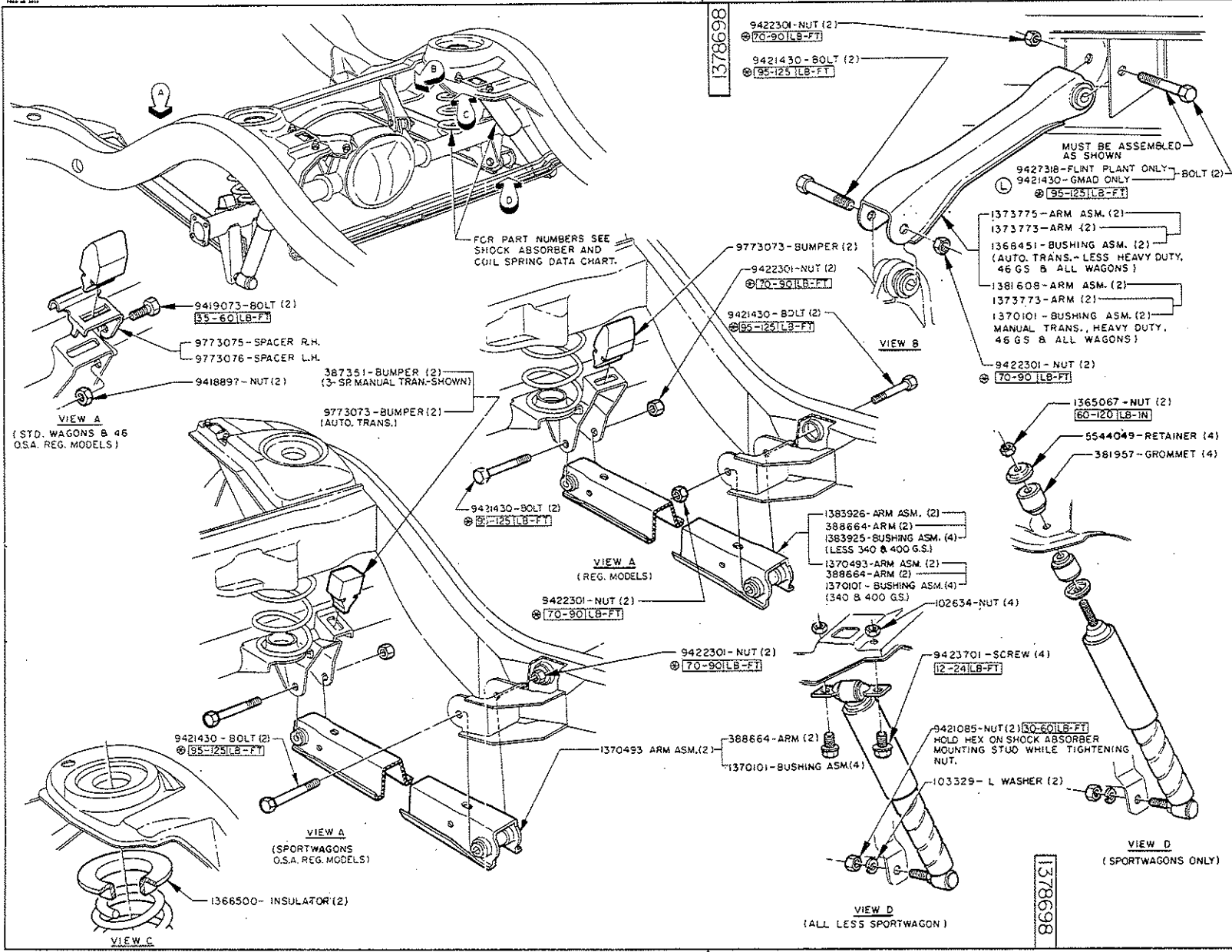
*1370493	1370101	AL	Sportwagon, 340 & 400 G.S. (Reg.)
*1383926	1383925	AU	All Less Sportwagon, 340 & 400 G.S.
*1384454	1370101	AW	340 G.S. (H.D.)

*1-10-67

PART NUMBER-1379480

PAGE NUMBER- 4-1.1

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



DATE	BY	REVISION	REASON	AUTH.	DR.	CR.
8-18-65	J.W.M.	1	REVISED		J.W.M.	
8-18-65	J.W.M.	2	REVISED		J.W.M.	
8-18-65	J.W.M.	3	REVISED		J.W.M.	
8-18-65	J.W.M.	4	REVISED		J.W.M.	
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8-18-65	J.W.M.	100	REVISED		J.W.M.	

SHOCK ABSORBER AND CONTROL
ARM BUSHING BOLTS TO BE
TIGHTENED WITH SUSPENSION
IN NORMAL LOAD POSITION.
TORQUING OF NUT OR BOLT
TO BE OPTIONAL.

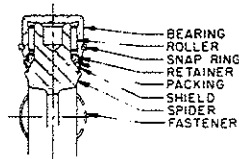
DO NOT SCALE REPORT ERRORS
TOLERANCES UNLESS OTHERWISE SPECIFIED
± ALLOWED ON TWO PLACE DECIMALS
± 0.10 ALLOWED ON THREE PLACE DECIMALS
COMMERCIAL TOLERANCES APPLY TO STANDARD
PARTS-ROLLED SECTIONS-SHEET METAL GAGS-
DRILLED AND PUNCHED HOLES.
BURR ALL DRILLED HOLES. COUNTERSINK ALL
TAPPED HOLES. 3X30 X 90°.

DWG. DATE SCALE DR. J.W. MYERS
8-18-65 CR
FIRST USED 1967-33-4
43-44-46 APPR.
REFERENCE APPR.
L-69433 BL-15812 APPR.
MATERIAL SPEC.

NAME REAR WHEEL SUSPENSION
INFORMATION ASSEMBLY
PART NO. 1378698 INCHES 4-31

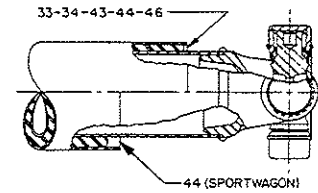
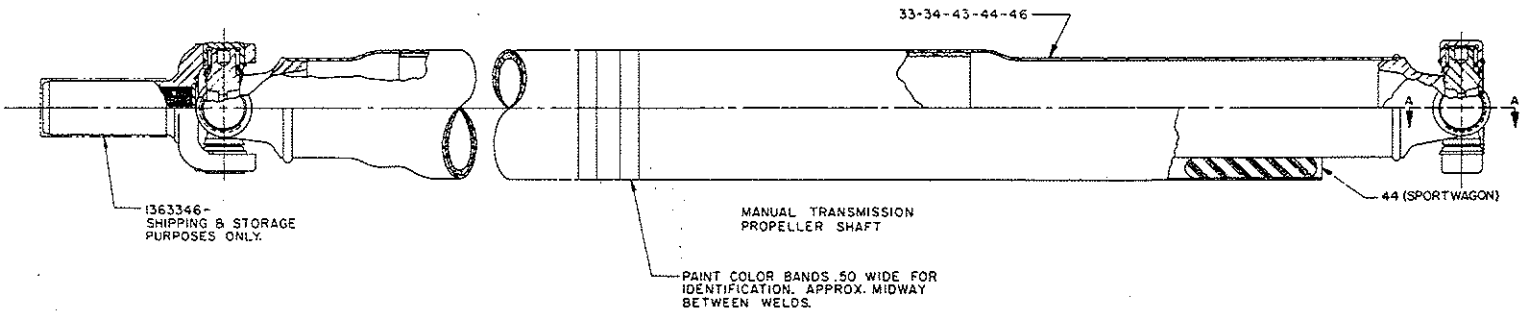
Insert Long Sheet 4-5.1 Here

GENERAL MOTORS CORPORATION
 FLMT. M. U.S.A.



SECTION A-A
ACTUAL SIZE

1379110



AUTOMATIC TRANSMISSION
PROPELLER SHAFT OTHERWISE
SAME AS MANUAL.

PROP SHAFT ASM	3- SPEED MANUAL	4- SPEED MANUAL	ST-300 AUTO	ST-400 AUTO	COLOR CODE STRIPE
5695094	44 (SPORTWAGON)				(1)RED(1)BLACK
5695101	33-34-43-44	46			(1)RED(1)BROWN
5698008	46				(1)RED(1)BLUE
7800854			33-43		(2)BLUE
5697057			44 (SPORTWAGON)		(1)BLACK
7801275				46	(2)BLACK
7801246				44 (SPORTWAGON)	(1)WHITE (1)PINK
7800855			34-44		(1) RED

(G)
(F)

1379110

DATE	SYM.	REVISION RECORD	AUTH.	DR.	CHK.
2-17-68	A	"X" REMOVED		D.C.A.	
2-26-68	B	NO GOLD OR BLACK STRIPE TO BLUE STRIPE ON 5697057		L.K.A.	
3-17-68	C	5697030 TO 7800854			
		DATA REVISED			
		PROOFS - 7800854			
		DATA ADDED			
3-23-68	D	COLOR CODE STRIPE			
		REVISED			
4-25-68	E	RED TO GREEN STRIPE			
		TO 10 BLUE STRIPE			
		ON 7800854			
5-24-68	F	TRANSFER TO PROOFS			
5-24-68	G	TRANSFER TO PROOFS			
		DATA REVISED			

FOR PROPELLER SHAFT
INSTALLATION SEE 1380179

DO NOT SCALE		REPORT ERRORS
TOLERANCES UNLESS OTHERWISE SPECIFIED		
X ALLOWED ON TWO PLACE DECIMALS		
.5 DIA 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. O. COUSINEAU
10-11-65		CHK. J. THOMAS
FIRST USED 1967		APPR.
33-34-43-44-46		APPR.
REFERENCE BL-15723		APPR.
BL-14508 BL-14283		APPR.
MATERIAL SPEC.		

NAME		PROPELLER SHAFT INFORMATION ASSEMBLY
PART NO.	INDEX	
1379110	4-6.1	

1379110

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

AXLE RATIO	GEAR		PINION		DIFFERENTIAL CASE		PINION AXIS MTG. DISTANCE	TRANSMISSION ASM.		SPEEDO DRIVING WORM		SPEEDO DRIVEN GEAR			SLEEVE ASM	TIRE SIZE	ADAPTER		
	PART NO.	NO. OF TEETH	PART NO.	NO. OF TEETH	REG.	POSITIVE TRACTION		TYPE	MODEL CODE	PART NO.	NO. OF TEETH	PART NO.	NO. OF TEETH	IDENTIFYING COLOR			DRIVEN GEAR	RATIO	COLOR
2.56	1357559	41	1357561	16	1376752		2.76000	2-SPEED AUTO	MR, MJ, ML	1371878	17	9734413	34	LT. GREEN	1362284	F-70-14	1367641	1.202	BLACK & WHITE
												1362048	40	BLACK	1362285	205R-14			
												1359273	39	BROWN	1362284	8.25 x 14 7.75 x 15			
2.78	1358151	39	1358150	14	1376752	9784110	2.7600	2-SPEED AUTO	LJ, LZ	1371877	16	9780387	35	ORANGE	1362284	F-70-14	1367642	1.1250	NONE
												9778413	34	LT. GREEN		205R-14			
												1359272	38	BLUE		8.25 x 14 7.75 x 15			
												1359271	37	RED		F-70-14			
												1359270	36	WHITE		205R-14			
												9780387	35	ORANGE		8.25 x 14 7.75 x 15			
2.93	1382267	41	1382149	14	1376753 LESS 4600 1302265 4600	1382389	2.6600	2-SPEED AUTO	LJ, LZ	1371877	16	1359273	39	BROWN	1362284	F-70-14			
												1359270	36	WHITE		205R-14			
												9780387	35	ORANGE		8.25 x 14 7.75 x 15			
								3-SPEED AUTO	MR, MJ, MZ, MX, MY	1371378	17	1359273	39	BROWN	1362284	F-70-14			
												1359272	38	BLUE		205R-14			
												1359271	37	RED		8.25 x 14 7.75 x 15			
								3-SPEED MANUAL	RJ	3108144	8	1359273	39	BROWN	1362284	F-70-14			
												1359272	38	BLUE		205R-14			
												1359271	37	RED		8.25 x 14 7.75 x 15			
3.23	1358153 LESS SPORTWAGON	42	1377434	13	1376753	9784111 LESS SPORTWAGON	2.5000	2-SPEED AUTO	LJ, LZ	1371877	16	1362195	41	YELLOW	1362285	F-70-14			
												1362048	40	BLACK		205R-14			
												1359273	39	BROWN		1362284			
	3-SPEED AUTO	MR, MJ, MX, MY, MZ, ML	1371878	17	1362156	43	PURPLE	1362285	F-70-14										
					1362049	42	GREEN		205R-14										
					1362195	41	YELLOW		8.25 x 14 7.75 x 15										
	3-SPEED MANUAL	QP, RJ	3108144	8	1362156	43	PURPLE	1362293	F-70-14										
					1362195	41	YELLOW		205R-14										
					3660343	20	BLUE		8.25 x 14 7.75 x 15										

DATE	BY	REVISION	RECORD	AUTH	OR	CHK.
10-27-66	K	1358000 & 1376753	1358151			
1-19-67	K	1358000 & 1376753	1358151			
		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 3-1-66 SCALE DR. pp
FIRST USED 1967 33-34-43-44-46 APPR.
REFERENCE APPR.
MATERIAL SPEC. APPR.

NAME
CHART - SPEEDOMETER & REAR AXLE GEARS
PART NO. 1357732 IND. X
REV. 1 OF 3 DTS. 4-71

C2V4 P14S 17

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

1371732

DATE 1967 REVISION RECORD AUTH. 1371732
10-27-66 F. Radtrow & Revised 11/17/66 PP 206

AXLE RATIO	GEAR		PINION		DIFFERENTIAL CASE		PINION AXIS HPG. DISTANCE	TRANSMISSION ASM		SPEEDO DRIVING WORM		SPEEDO DRIVEN GEAR			SLEEVE ASM	TIRE SIZE	ADAPTER		
	PART NO.	NO. OF TEETH	PART NO.	NO. OF TEETH	REG.	POSITIVE TRACTION		TYPE	MODEL CODE	PART NO.	NO. OF TEETH	PART NO.	NO. OF TEETH	IDENTIFYING COLOR			DRIVEN GEAR	RATIO	COLOR
3.90	1365994	39	1377437	10		9786645	2.4000	2-SPEED AUTO	LJ LZ	1371877	16	1362048	40	BLACK	1362285	F-70-14 20SR-14	1367643	.8095	LT. GREEN
												1362195	39	BROWN		7.75 x 14			
												1362195	38	BLUE		8.25 x 14 7.75 x 15			
									MR, MJ, ML, MX, MY, MZ	1371878	17	1362049	42	GREEN	1362285	F-70-14 20SR-14	1367643	.8095	LT. GREEN
												1362195	41	YELLOW		7.75 x 14			
												1362048	40	BLACK		8.25 x 14 7.75 x 15			
	3-SPEED AUTO	BW BA	8623312	17	1362049	42	GREEN	1362293	F-70-14 20SR-14	1367643	.8095	LT. GREEN							
					1362195	41	YELLOW		7.75 x 14										
					1362048	40	BLACK		8.25 x 14 7.75 x 15										
	3-SPEED MANUAL	QP RJ	3708144	8	3860343	20	BLUE	3775589	F-70-14 20SR-14	1367643	.8095	LT. GREEN							
					3860342	19	NATURAL		7.75 x 14 8.25 x 14 7.75 x 15										
		QB	9777230	8	3860343	20	BLUE	3775589	F-70-14 20SR-14										
3860342					19	NATURAL	7.75 x 14 8.25 x 14 7.75 x 15												
1-SPEED MANUAL	HE	3708144	8	3860342	19	NATURAL	3775589	F-70-14 20SR-14	396338	.785	YELLOW								
4.30	1357560	43	1377438	10	9786645	2.4000	1-SPEED AUTO	BA	8623312	17	1362049	42	GREEN	1362293	F-70-14 20SR-14	1367644	.7333	RED	
											1362195	41	YELLOW		7.75 x 14				
											1362048	40	BLACK		8.25 x 14 7.75 x 15				
								2-SPEED MANUAL	QB	9777230	8	3860343	20	BLUE	3775589	F-70-14 20SR-14	1367644	.7333	RED
												3860344	21	RED		7.75 x 14 8.25 x 14 7.75 x 15			
												3860344	21	RED		7.75 x 14			
	4-SPEED MANUAL	HE	3708144	8	3860344	21	RED	3775589	F-70-14 20SR-14	396338	.785	YELLOW							
					3860343	20	BLUE		8.25 x 14 7.75 x 15										
					3860343	20	BLUE		7.75 x 15										

DO NOT SCALE REPORT ERRORS
TOLERANCES UNLESS OTHERWISE SPECIFIED
X .010 ALLOWED ON TWO PLACE DECIMALS
X .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. (30° X 90°)

DATE 3-1-66 SCALE DR PP
FIRST USED CK
1967 33-34-53-44-46 APPR.
REFERENCE APPR.

MATERIAL SPEC.

NAME

CHART - SPEEDOMETER & REAR AXLE GEARS
PART NO. 1371732 INDEX
SHT. 3 OF 3 SHTS. 4-7.3

1371732

C 2Y4 P14527

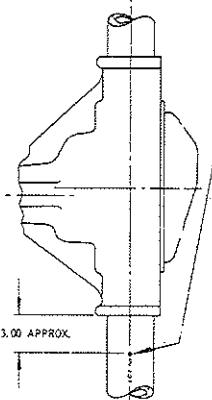
BUICK MOTOR DIVISION
GENERAL MOTORS CORPORATION
FLINT, MICH. U.S.A.

1380644

SERIES	ENGINE	TRANSMISSION	AXLE ASSEMBLY RATIOS																							
			STANDARD				ECONOMY				PERFORMANCE				SPECIAL CAR ORDER - POSITIVE TRACTION											
			RATIO	REGULAR	CODE	POSITIVE TRACTION	CODE	RATIO	REGULAR	CODE	POSITIVE TRACTION	CODE	RATIO	REGULAR	CODE	POSITIVE TRACTION	CODE	RATIO	NO. 1	CODE	RATIO	NO. 2	CODE	RATIO	NO. 3	CODE
43307-67-69 43507-17-69 44307-17-39-67	225 V-6	3-SP. MANUAL																								
2-SP. AUTO (A/C)		2.23	1395540	LC	1395541	LP																				
2-SP. AUTO		2.93	1395536	OB	1395537	OW	2.78	1395534	LA	1395535	LN	3.23														
43335 43535	340 V-6	3-SP. MANUAL																								
2-SP. AUTO		3.23	1395540	LC	1395541	LF	2.93	1395536	OB	1395537	OW	3.26														
43407-67-69 43607-17-69 44407-17-39-67	300 & 340 V-8	3-SP. MANUAL																								
2-SP. AUTO		2.78	1395534	LA	1395535	LN	2.56	1395532	LK																	
3-SP. MANUAL		3.23	1395540	LC	1395541	LP	2.78	1395534	LA	1395535	LN	3.26														
43435 43635	340 - V-6	2-SP. AUTO																								
3-SP. MANUAL		2.93	1395536	OB	1395537	OW	2.78	1395534	LA	1395535	LN	3.26														
43471	340 - V-6	3-SP. MAN. 2-SP. AUTO																								
44255-65 44455-65	340 V-8	3-SP. MANUAL																								
2-SP. AUTO		3.23	1395540	MG	1395541	M																				
44607-17-67	400 V-8	3-SP. AUTO																								
3 & 4-SP. MANUAL		3.26	1395538	LJ	1395539	LX																				
3-SP. AUTO		2.93	1395791	OE	1395792	OF																				
45287-39-69 45487-39-67-69	340 V-8	3-SP. MANUAL																								
2-SP. AUTO		3.26	1395797	NG	1395798	NH																				
3-SP. AUTO		2.93	1395799	NJ	1395800	NZ	2.78	1395801	NL	1395802	NY	3.26														
46487-39-67-69 46687-39-67	430 V-8	3-SP. AUTO																								
3-SP. AUTO		3.07	1395707	PG	1395708	PV	2.78	1395777	PL	1395788	PO	3.42														
48257-39-69 48457-39-67-69 48487	430 V-8	3-SP. AUTO																								
3-SP. AUTO		2.70	1395777	PL	1395788	PI	2.56	1395779	PB	1395778	PN	3.42														
3-SP. AUTO		3.07	1395783	PJ	1395782	PK																				
49487 - G. S.		3-SP. AUTO																								
			3.42																							

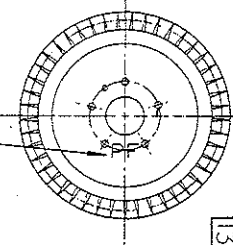
DATE	BY	REVISION	REASON	INITIALS	DATE
8-22-64	A	1	REMOVED		
8-24-64	B	2	ADD DATA		
8-24-64	C	3	ADD DATA		
8-24-64	D	4	ADD DATA		
8-24-64	E	5	ADD DATA		
8-24-64	F	6	ADD DATA		
8-24-64	G	7	ADD DATA		
8-24-64	H	8	ADD DATA		
8-24-64	I	9	ADD DATA		
8-24-64	J	10	ADD DATA		
8-24-64	K	11	ADD DATA		
8-24-64	L	12	ADD DATA		
8-24-64	M	13	ADD DATA		
8-24-64	N	14	ADD DATA		
8-24-64	O	15	ADD DATA		
8-24-64	P	16	ADD DATA		
8-24-64	Q	17	ADD DATA		
8-24-64	R	18	ADD DATA		
8-24-64	S	19	ADD DATA		
8-24-64	T	20	ADD DATA		
8-24-64	U	21	ADD DATA		
8-24-64	V	22	ADD DATA		
8-24-64	W	23	ADD DATA		
8-24-64	X	24	ADD DATA		
8-24-64	Y	25	ADD DATA		
8-24-64	Z	26	ADD DATA		

AXLE ASSEMBLY MARKINGS FOR MANUFACTURING INFORMATION ONLY		
COLOR CODE		
GEAR RATIO	STANDARD AXLES	POSITIVE TRACTION AXLES
2.56	SILVER	SILVER & ORANGE
2.78	BLACK	BLACK & ORANGE
2.93	DARK BLUE	DARK BLUE & ORANGE
3.07	WHITE	WHITE & ORANGE
3.23	GREEN	GREEN & ORANGE
3.36	YELLOW	YELLOW & ORANGE
3.42	LIGHT BLUE	LIGHT BLUE & ORANGE
3.55	PINK	PINK & ORANGE
3.90	PURPLE	PURPLE & ORANGE
3.91	PURPLE	PURPLE & ORANGE
3.92	LILAC	LILAC & ORANGE



FOR FIELD IDENTIFICATION, ALL AXLE ASSEMBLIES TO BE STAMPED WITH LETTERS 3/16 HIGH ON BOTTOM OF AXLE TUBE AS INDICATED FROM CHART. SAMPLE MARKING FOR 3.07 RATIO, (FOR 46 MODEL) DATE JULY 22, (DAY IN THE YEAR MFG'D.) WOULD BE STANDARD AXLES PG 203. POSITIVE TRACTION AXLES © PV 203.

(ASSEMBLY PLANT IDENTIFICATION) MFG. AXLE CODE LETTERS 1.5 INCHES HIGH STAMPED IN YELLOW INK ON LEFT BRAKE STUM IN AREA OF WHEEL BOLTS.



1380644

DO NOT SCALE REPORT ERRORS
TOLERANCES UNLESS OTHERWISE SPECIFIED
± ALLOWED ON TWO PLACE DECIMALS
0.010 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 2-3-66 SCALE DR. F. C. MYERS
FIRST USED CK. J. B. [Signature]
1967 - ALL APPR. [Signature]
REFERENCE APPR. [Signature]

MATERIAL SPEC.

NAME CHART - REAR AXLE ASSEMBLY MARKING

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