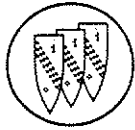




1967 BUICK ASSEMBLY INSTRUCTION MANUAL

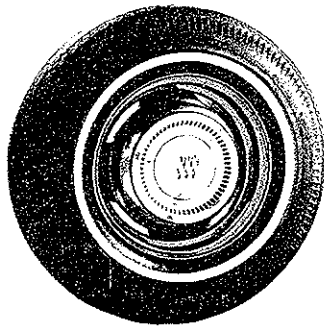
SPECIAL - SKYLARK 43000 - 44000 SERIES
WHEEL - TIRES & CAR JACK (SECTION 10)

| | |
|---|--------|
| Wheel Covers (Pictorial) | 10-1.1 |
| *Tires Size-Chart | 10-1.2 |
| Wheels & Tires Balancing Information | 10-2.1 |
| Spare Wheel - Jack and Jack Instruction Label Installation. (Except Wagons) Includes Spare Tire Cover For Specific Models | 10-3.1 |
| Spare Wheel - Jack-Spare Tire Cover and Jack Instruction Label - Installations, (Wagons) (tire Vover Furnished by Fisher) | 10-3.2 |
| <p>NOTE: Hub Caps & Wheel Covers are to be packaged and placed in rear compartment for Dealer Installation</p> | |
| <p>*8-9-66</p> | |
| <p>PART NUMBER-1379480</p> | |
| <p>PAGE NUMBER-10-1.0</p> | |

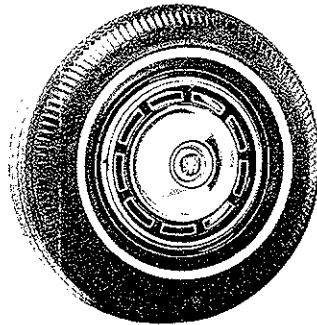


1967 BUICK ASSEMBLY INSTRUCTION MANUAL

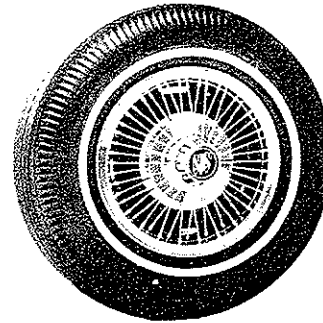
SPECIAL - SKYLARK 43000 - 44000 SERIES WHEELS - TIRES & CAR JACK (SECTION 10)



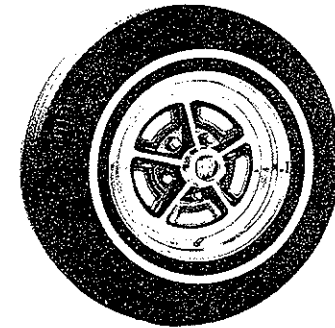
SPECIAL - SPECIAL DELUXE - SKYLARK
G.S. 400 - SPORTWAGON



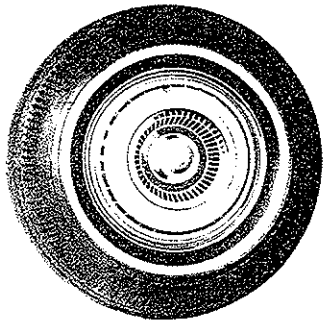
SPECIAL - SPECIAL DELUXE
G.S. 400 - SPORTWAGON



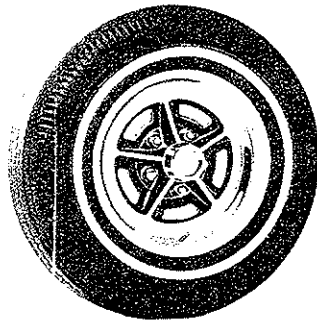
G.S. 400 - SPORTWAGON



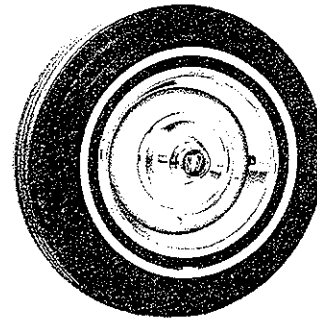
SPECIAL - SPECIAL DELUXE -
G.S. 400 - SPORTWAGON



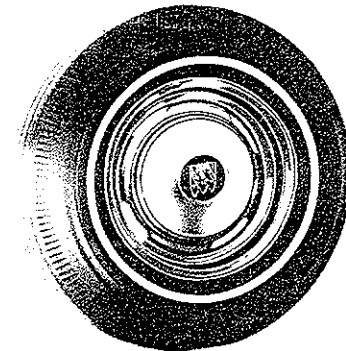
SKYLARK



SKYLARK



SPECIAL - SPECIAL DELUXE & SKYLARK
G.S. 400 SPORTWAGON
DISC BRAKE OPTION ONLY



LESABRE - STD. 452 SERIES

WHEEL COVERS TO BE PACKAGED AND SHIPPED IN REAR
COMPARTMENT FOR DEALER INSTALLATION

PART NUMBER-1379480

PAGE NUMBER- 10-1.1

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

1382631

| SERIES | DOMESTIC OR EXPORT OPTIONS | | | | | | | | | | | EXPORT OPTIONS ONLY | | | | | |
|--|----------------------------|------------|------------|------|----------|------------|------------|------------|------------|------------|------------|---------------------|------------------------|------------|----------|--------------------------|----------|
| | BASIC SIZE | | | | | | | | | | RADIAL PLY | OVERSIZE TIRE | TIRE AND WHEEL ASM 15' | WALL COLOR | | OVERSIZE WHITE P-50 P-37 | |
| | WALL COLOR | | | | | | | | | | | | | WHITE P-16 | RED P-17 | | |
| | BLK. STD. | WHITE PW-7 | WHITE P-26 | PV-1 | RED PV-2 | BLACK PW-8 | BLACK N-82 | WHITE N-83 | WHITE P-33 | BLACK P-29 | WHITE P-30 | BLACK N-77 | WHITE N-78 | | | WHITE P-16 | RED P-17 |
| 43307-39-69 43517-69 44307 | | | | | | | | | | | | | | | | | |
| 43407-39-69 43617-39-69 44407-17-39-67-69 | A | --- | B | --- | --- | --- | --- | D | E | F | K | L | C | --- | X | | G |
| 43417 | | W | | | | | | | | | | | | | | | |
| 44607-17-67 | ⊙ | W | --- | --- | X | --- | --- | D | --- | --- | K | L | C | --- | --- | | --- |
| 44455-65 44555-65 | E | --- | F | --- | --- | --- | H | J | D | --- | --- | --- | G | --- | --- | | --- |
| 45267-39-69 45487-39-67-69 46487-39-67-69 46987-39-67 | N | --- | P | --- | --- | --- | --- | M | T | --- | --- | --- | S | Z | --- | | V |
| 45457 | N | --- | R | --- | --- | --- | --- | M | --- | --- | --- | --- | S | Z | --- | | --- |
| 49487 G. S. | X | --- | --- | --- | --- | --- | --- | M | --- | --- | --- | --- | --- | --- | --- | | --- |
| 40257-39-69 48457-39-67-69 | T | --- | U | --- | --- | --- | --- | M | --- | --- | --- | --- | V | --- | --- | | --- |

- * PV-1 OPTION IS STD. ON 49487 G. S. OPTION.
- ⊙ PW-7 OPTION IS STD. ON 44607-17-67
- INCLUDES RIM

| CODE | TIRE UNIT PART NUMBERS | | | | TIRE SIZE | PLY | | WALL COLOR |
|------|------------------------|-----------|----------|----------|-----------|---------|--------|------------|
| | UNI ROYAL | FIRESTONE | GOODRICH | GOODYEAR | | ACTUAL | RATING | |
| A | 3908821 | 3908880 | 3867669 | 3908882 | 7.75x14 | 7 | 4 | BLACK |
| B | 3908881 | 3908892 | 3883578 | 3908882 | | 4 | 4 | WHITE |
| C | --- | 3883520 | --- | --- | | | | |
| E | 397401 | 397402 | 390003 | 397404 | 8.25x14 | 7 | 4 | BLACK |
| F | 397406 | 397407 | 392192 | 397409 | | 4 | 4 | BLACK |
| G | --- | 392111 | --- | --- | | 2 | 4 | WHITE |
| H | --- | 390062 | --- | 382003 | | 4 | 8 | BLACK |
| J | --- | 392121 | --- | 388013 | | 4 | 8 | WHITE |
| K | 388101 | 388101 | 388102 | 388107 | 7.75x15 | 7 | 4 | BLACK |
| L | 388151 | 388150 | 388153 | 388152 | | 7 | 4 | WHITE |
| N | 1382295 | 1381530 | 1381531 | 1381532 | 8.45x15 | | | BLACK |
| P | 1382274 | 1381538 | 1381539 | 1381540 | | | | |
| R | --- | 1381548 | --- | 1381549 | | 2 | 4 | --- |
| S | --- | 1381669 | --- | --- | | 4 | 4 | WHITE |
| T | 1382297 | 1382298 | 1381552 | 1381553 | 8.85x15 | 2 | 4 | BLACK |
| U | 1382276 | 1382277 | 1381556 | 1381557 | | 4 | 4 | --- |
| V | --- | 1381670 | --- | --- | | 4 | 4 | WHITE |
| W | --- | 3909681 | --- | 3909682 | F-70-14 | 2 | 4 | WHITE |
| X | --- | 39-6676 | --- | 3909678 | | | | RED |
| Y | --- | 9778559 | --- | 9777910 | H-70-15 | 2 | 4 | WHITE |
| Z | --- | 9777772 | --- | 9777909 | | | | RED |
| Q | 398225 | 3981206 | 398227 | 398228 | 205R-14 | 2 + 4 | 4 | WHITE |
| M | 1382502 | 1382502 | 1382503 | 1382504 | | 225R-15 | 2 + 4 | 4 |

| DATE | BY | REVISION RECORD | AUTH. | DR. |
|----------|----|--------------------------|-------|--------------|
| 8-27-66 | P. | INDEX AND C.L.T.O. | | |
| 10-1-66 | | | | |
| 10-10-66 | B | 9778686 9779034 | | |
| | | 9778687 1381545 | | |
| | | 1381542 A.D.M. | | |
| | | Rev. Rechecked | | |
| | | PV-1, PV-2, PV-8 | | |
| | | Options N-78-75 & | | |
| | | Options M-78-75 & | | |
| | | Options P-29-30 | | |
| 10-23-69 | C | 3908882 to 3908881 | | |
| | | 3908880 to 3908879 | | |
| | | 3908878 to 3908877 | | |
| | | 3908876 to 3908875 | | |
| | | 3908874 to 3908873 | | |
| | | NOTE ADDED | | 70894 T.P.P. |
| 10-24-66 | A | 1381533 Option 2982-14 & | | |
| | | Options 15 Tires Added | | 71317 T.P.P. |
| 1-12-67 | F | PW-1, P-27, P-29, P-37 | | |
| | | 2 Notes 45417 & 5341 | | |
| | | Added PV-8 to PW-8 | | 71326 T.P.P. |

AIR CONDITIONED EQUIPPED CARS REQUIRE NO SPECIAL TIRE USAGE
B - SPECIAL APPEARANCE WALL 13-STRIPED
--- INDICATES NOT AVAILABLE

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. G. LANG
5-27-66 NONE T.C.K. *B. Campbell*
FIRST USED 1967 + ALL APPR.
REFERENCE APPR.
MATERIAL SPEC. APPR.

NAME
CHART - TIRE USAGE
PART NO. 1382631 INDEX 10-12

1382631

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

| MER. | TIRE UNIT | CASING | VALVE STEM |
|-----------|-----------|-----------|------------|
| UNIROYAL | 1381525 | 1372876 ⊕ | 274083 |
| BLACKWALL | | | |
| FIRESTONE | 1381526 | 1372877 ⊕ | 274083 |
| BLACKWALL | | | |
| GOODRICH | 1381527 | 1372878 Δ | 274083 |
| BLACKWALL | | | |
| GOODYEAR | 1381528 | 1372879 ⊕ | 274083 |
| BLACKWALL | | | |
| GENERAL | 1381541 | 1381558 ⊕ | 274083 |
| BLACKWALL | | | |
| UNIROYAL | 1381533 | 1376470 ⊕ | 274083 |
| WHITEWALL | | | |
| FIRESTONE | 1381534 | 1376471 ⊕ | 274083 |
| WHITEWALL | | | |
| GOODRICH | 1381535 | 1376472 Δ | 274083 |
| WHITEWALL | | | |
| GOODYEAR | 1381536 | 1376473 ⊕ | 274083 |
| WHITEWALL | | | |
| GENERAL | 1381542 | 1381559 ⊕ | 274083 |
| WHITEWALL | | | |

1381524

8.15 x 15 2/4 TUBELESS
 ⊕ RAYON
 ⊖ POLYESTER
 Δ NYLON

| DATE | SYM. | REVISION RECORD | AUTHORITY | DR. | CK. |
|------|------|-----------------|-----------|-----|-----|
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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 4-6-66 | SCALE - | DR. JM |
| FIRST USED 1967 | | CK. <i>E. Caputo</i> |
| REFERENCE 67.108-6 | | APPR. |
| MATERIAL SPEC. | | APPR. |
| NAME TIRE UNIT (TAB. SHEET) | | |

| | |
|---------------------|-----------------|
| PART NO. 1381524 | Index 10-1.2 |
| SHEET 1 OF 4 SHEETS | |

FORM 884-A-1 PART DE-05587 24 1-65

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

| MFR. | TIRE UNIT | CASING | VALVE STEM |
|-----------|-----------|-----------|------------|
| UNIROYAL | 1381529 | 1372884 ⊕ | 274083 |
| BLACKWALL | | | |
| FIRESTONE | 1381530 | 1381545 ⊕ | 274083 |
| BLACKWALL | | | |
| GOODRICH | 1381531 | 1372886 △ | 274083 |
| BLACKWALL | | | |
| GOODYEAR | 1381532 | 1381546 ⊖ | 274083 |
| BLACKWALL | | | |
| GENERAL | 1381543 | 1381560 ⊕ | 274083 |
| BLACKWALL | | | |
| UNIROYAL | 1381537 | 1376474 ⊕ | 274083 |
| WHITEWALL | | | |
| FIRESTONE | 1381538 | 1379515 ⊕ | 274083 |
| WHITEWALL | | | |
| GOODRICH | 1381539 | 1376476 △ | 274083 |
| WHITEWALL | | | |
| GOODYEAR | 1381540 | 1379517 ⊖ | 274083 |
| WHITEWALL | | | |
| GENERAL | 1381544 | 1381561 ⊕ | 274083 |
| WHITEWALL | | | |

1381524

3.45 x 15 2/4 TUBELESS
 ⊕ RAYON
 ⊖ POLYESTER
 △ NYLON

| DATE | SYM. | REVISION RECORD | AUTHORITY | DR. | CK. |
|------|------|-----------------|-----------|-----|-----|
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DO NOT SCALE TOLERANCES UNLESS OTHERWISE SPECIFIED
 REPORT ERRORS 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 4-6-66 | SCALE - | DR. JIM |
| FIRST USED 1967 | | APPR. <i>[Signature]</i> |
| REFERENCE 67, 10B-6 | | APPR. _____ |
| MATERIAL SPEC. | | APPR. _____ |
| NAME TIRE UNIT (TAB. SHEET) | | |
| PART NO. 1381524 | Index | |
| SHEET 2 OF 4 SHEETS | 10-1.3 | |

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

| MFR. | TIRE UNIT | CASING | VALVE STEM |
|------------------------------------|-----------|-----------|------------|
| | | | |
| FIRESTONE 3-STRIPE WHITEWALL | 1381548 | 1379523 ⊕ | 274083 |
| | | | |
| GOODYEAR 3-STRIPE WHITEWALL | 1381549 | 1379525 ⊕ | 274083 |
| | | | |
| FIRESTONE REDWALL | 1381563 | 1378437 ⊕ | 274083 |
| | | | |
| GOODYEAR REDWALL | 1381562 | 1378436 ⊕ | 274083 |
| | | | |

1381524

8.45 x 15 2/4 TUBELESS
 ⊕ RAYON
 ● POLYESTER
 △ NYLON

| DATE | SYM. | REVISION RECORD | AUTHORITY | DR. | CK. |
|------|------|-----------------|-----------|-----|-----|
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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 4-6-66 | SCALE - | DR. JM |
| FIRST USED 1967 | | CK <i>D. Carpenter</i> |
| REFERENCE 67.10B-6 | | APPR. |
| MATERIAL SPEC. | | APPR. |

NAME
 TIRE UNIT (TAB. SHEET)

| | |
|---------------------|--------------|
| PART NO. 1381524 | Index 10-1.4 |
| SHEET 3 OF 4 SHEETS | |

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

| MFR. | TIRE UNIT | CASING | VALVE STEM |
|-----------|-----------|-----------|------------|
| UNIROYAL | 1381550 | 1372892 ⊕ | 274083 |
| BLACKWALL | | | |
| FIRESTONE | 1381551 | 1372893 ⊕ | 274083 |
| BLACKWALL | | | |
| GOODRICH | 1381552 | 1372894 △ | 274083 |
| BLACKWALL | | | |
| GOODYEAR | 1381553 | 1381547 ● | 274083 |
| BLACKWALL | | | |
| UNIROYAL | 1381554 | 1376478 ⊕ | 274083 |
| WHITWALL | | | |
| FIRESTONE | 1381555 | 1376479 ⊕ | 274083 |
| WHITWALL | | | |
| GOODRICH | 1381556 | 1376480 △ | 274083 |
| WHITWALL | | | |
| GOODYEAR | 1381557 | 1379521 ● | 274083 |
| WHITWALL | | | |

| DATE | STM. | REVISION RECORD | AUTHORITY | DR. | CK. |
|------|------|-----------------|-----------|-----|-----|
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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°

| | | |
|-----------------------------|---------|-------------------------|
| DATE 4-6-66 | SCALE - | DR. JM |
| FIRST USED 1967 | | CK. <i>D. Carpenter</i> |
| REFERENCE 67.10B-6 | | APPR. |
| MATERIAL SPEC. | | |
| NAME TIRE UNIT (TAB. SHEET) | | |
| PART NO. 1381524 | | Index 10-1.5 |
| SHEET 4 OF 4 SHEETS | | |

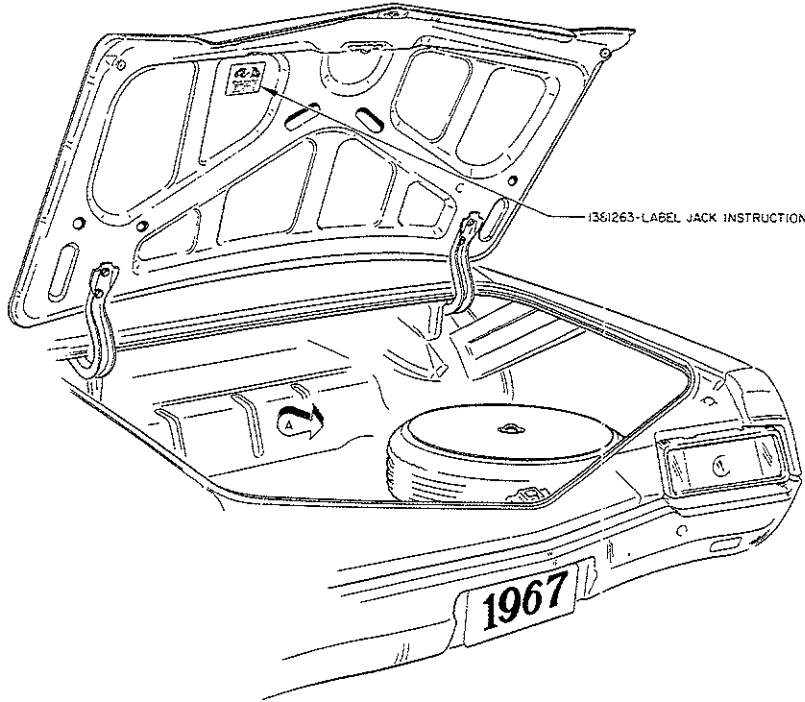
1381524

8.85 x 15 2/4 TUBELESS

⊕ RAYON

● POLYESTER

△ NYLON



1380167

INSTALL VALVE SIDE DOWN -
CHROME WHEELS & WHEELS WITH COVERS

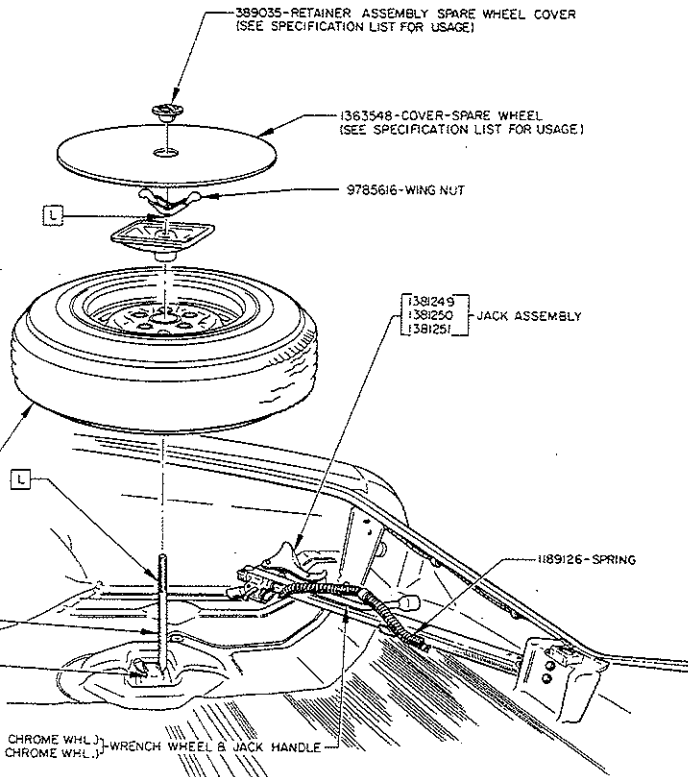
1374900-ROD

BACKET PART OF BODY

© 3809176-(LESS CHROME WHL.) WRENCH WHEEL & JACK HANDLE
3899548-(WITH CHROME WHL.)

VIEW A

1380167



| DATE SYN | REVISION RECORD | AUTH. | LOC. |
|----------|-----------------|----------------------------|----------|
| 1074 | A | X1 REMOVED | 17P |
| 1074 | B | 1374424 & TIRE | |
| | | WRENCH REMOVED FROM ASSEM. | |
| 1074 | C | 11381249 TO 1381249 | |
| | | 11381247 TO 1381250 | |
| | | 11381248 TO 1381251 | |
| 1074 | D | 3899547 WRENCH | |
| | | TO 3899548 | |
| | | | 71175 DC |

CONTROL LEVER TO BE IN LOCK POSITION TO REDUCE RATTLE

LUBRICATE AREAS INDICATED WITH 9985008 BEFORE ASSEM.

DO NOT SCALE REPORT ERRORS
TOLERANCES UNLESS OTHERWISE SPECIFIED
 2 ALLOWED ON TWO PLACE DECIMALS
 2 .010 ALLOWED ON THREE PLACE DECIMALS
 COMMERCIAL TOLERANCES APPLY TO STANDARD PARTS-ROLLED SECTIONS-SHEET METAL GAGES-DRILLED AND PUNCHED HOLES.
 FINISH ALL DRILLED HOLES. COUNTERSINK ALL TAPPED HOLES .050 X 90°.

| | | |
|------------|-------------------|----------|
| DRW. DATE | SCALE | DR. FILM |
| 3-10-66 | NONE | CK |
| FIRST USED | 1967-33-34 | APPR. |
| REFERENCE | 35-36-42-43-44-46 | APPR. |
| | | APPR. |

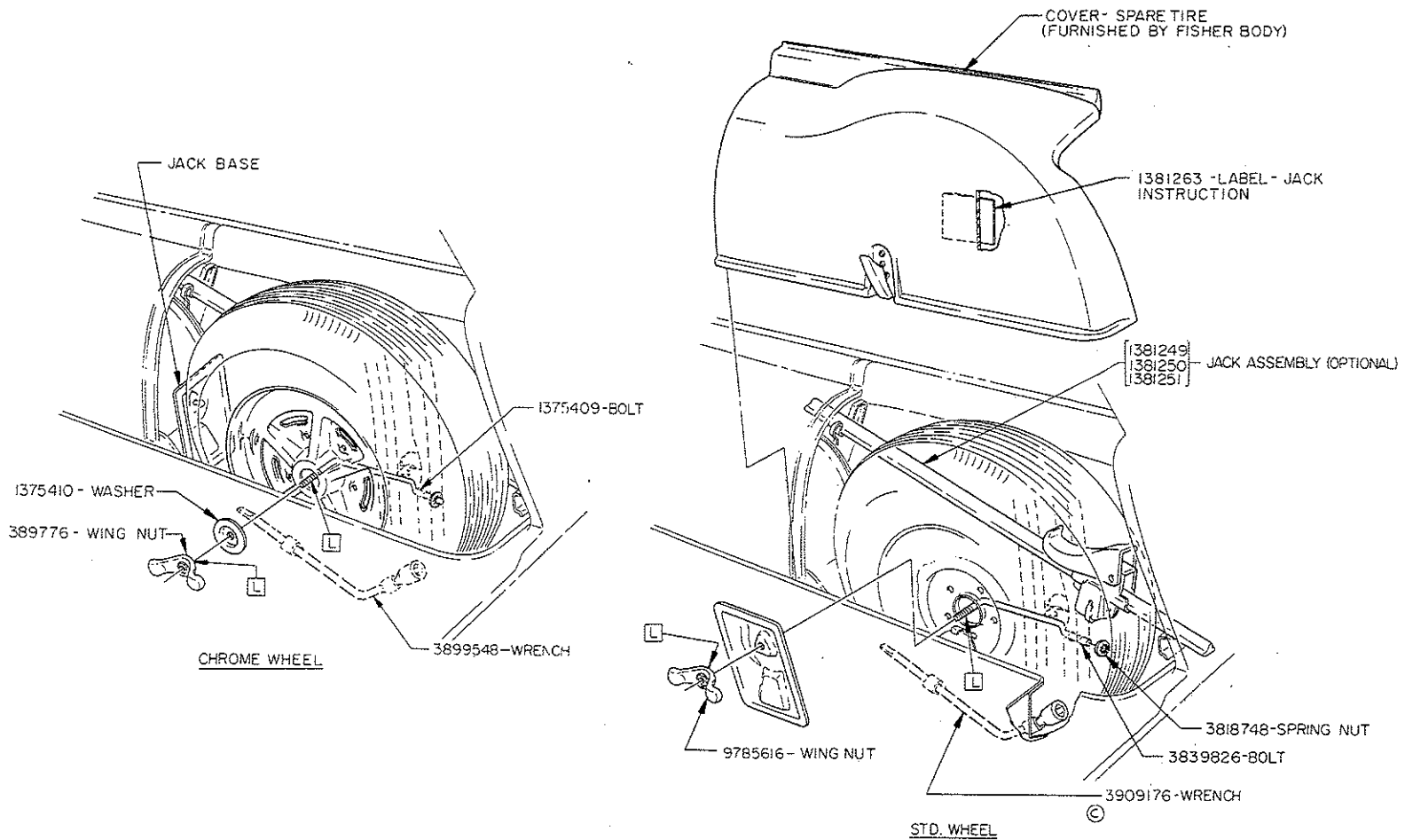
| | |
|---------------------|---------------------------------|
| ALL LESS WAGONS | |
| NAME | WHEEL & JACK INSTALLATION-SPARE |
| PART NO. | 1380167 |
| SHEET 1 OF 2 SHEETS | INDEX 10-31 |

BLYB 917515

1380167

| DATE SYM. | REVISION RECORD | AUTH. | DR. | CHK. |
|-----------|----------------------|-------|-----|------|
| 1380167 | A X REMOVED | | | |
| 1380167 | B 1380167 TO 1380169 | | | |
| 1380167 | C 1380167 TO 1380150 | | | |
| 1380167 | D 1380167 TO 1380151 | | | |
| 1380167 | E 1380167 TO 1380152 | | | |
| 1380167 | F 1380167 TO 1380153 | | | |
| 1380167 | G 1380167 TO 1380154 | | | |
| 1380167 | H 1380167 TO 1380155 | | | |
| 1380167 | I 1380167 TO 1380156 | | | |
| 1380167 | J 1380167 TO 1380157 | | | |
| 1380167 | K 1380167 TO 1380158 | | | |
| 1380167 | L 1380167 TO 1380159 | | | |
| 1380167 | M 1380167 TO 1380160 | | | |
| 1380167 | N 1380167 TO 1380161 | | | |
| 1380167 | O 1380167 TO 1380162 | | | |
| 1380167 | P 1380167 TO 1380163 | | | |
| 1380167 | Q 1380167 TO 1380164 | | | |
| 1380167 | R 1380167 TO 1380165 | | | |
| 1380167 | S 1380167 TO 1380166 | | | |
| 1380167 | T 1380167 TO 1380167 | | | |

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



CONTROL LEVER TO BE IN LOCK POSITION TO REDUCE RATTLE.

LUBRICATE AREAS INDICATED [L] WITH 9985008 BEFORE ASSEMBLY.

| | | | |
|--|-------|-------------------------------------|---------|
| DO NOT SCALE | | REPORT ERRORS | |
| TOLERANCES UNLESS OTHERWISE SPECIFIED | | | |
| = — ALLOWED ON TWO PLACE DECIMALS | | = — 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. | J ALLEN |
| 12-8-65 | | CK. | L JANKO |
| FIRST USED 1967 | 33-34 | APPR. | |
| 33-36-42-43-44-46 | | APPR. | |
| REFERENCE | | APPR. | |
| | | APPR. | |

| | |
|---------------------|---------------------------------|
| STATION WAGONS | |
| NAME | WHEEL & JACK INSTALLATION-SPARE |
| PART NO. | 1380167 |
| SHEET 2 OF 2 SHEETS | INDEX 10-32 |

1380167

