



1967 BUICK ASSEMBLY INSTRUCTION MANUAL

SPECIAL - SKYLARK 43000 - 44000 SERIES SHEET METAL - FRONT END - RADIATOR & GRILLE (SECTION 11)

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*6-27-66

PART NUMBER-1379480

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1967 BUICK ASSEMBLY INSTRUCTION MANUAL

SPECIAL - SKYLARK 43000 - 44000 SERIES

Sheet Metal-Front End-Radiator & Grille (Section 11)

1967 RADIATORS AND USAGE								
Usage	Part No.	Prod Code	Width	Height	Depth	Const.	No Lvrs.	Trans. Oil Cooler
V-6 Man	3005321	121SM	20.80	16.97	1.26	.30	68	None
V-6 Auto	3005322	122SR			1.26	.30	68	1 Pt. (1.50")
V-6 A.C.	3005323	123SS			1.26	.18	113	1 Pt. (1.50")
300 Man. Trans.	3000227	27BH			1.26	.19	107	None
340 Man. Trans.	3008320	120SA			1.26	.16	127	None
400 Man. Trans.	3010127	127SH			2.00	.18	113	1 Pt. (1.50")
300 Auto (Less Wgns)	3005325	125SF			1.26	.20	102	1 Pt.
*340 Auto & Sptwgn M-40	3000226	26BG			1.26	.16	127	1 Pt.
340 (Ext Wgn) Auto	3009924	124SE			1.26	.16	127	2 Pt.
400 Auto	3010127	127SH			2.00	.18	113	1 Pt.
300 A.C. (Less Wgns)	3005326	126SG			2.00	.22	92	1 Pt.
*340 A.C. & Sptwgn M-40 & Man.	3008329	129SK			2.70	.18	113	1 Pt.
*340 (Ext Wgn) A.C. M-33	3009930	130SL			2.70	.18	113	2 Pt.
400 A.C.	3010128	128SJ			2.70	.18	113	1 Pt.

* 7-10-66

PART NUMBER-1379480
PAGE NUMBER- 11-1.2



1967 BUICK ASSEMBLY INSTRUCTION MANUAL

SPECIAL - SKYLARK 43000 - 44000 SERIES

1967 RADIATOR HOSES - IDENTIFICATION CODE & USAGE

SERIES & USAGE	PART NO.	PROD. CODE	DESCRIPTION
V6 225 All All	1376774 1373027	XA XY	Inlet Outlet Asm. Hose 1373028 - Spring 1373029
"A" 300, 340 Less K19 With K19 *Less C60* With C60	1372789 1373825 1382662 1380626	XC XJ YD XE	Inlet Inlet Outlet Asm. Hose 1382663 - Spring 1366386 Outlet Asm. Hose 1380627 - Spring 1372792
"A" 446 All All	1378479 1378480	XG YT	Inlet Outlet Asm. Hose 1378481 - Spring 1366386
4500 Less K19 With K19	1377889 1374252 *1382662	YR YC YD	Inlet Inlet Outlet Asm. Hose 1382663 - Spring 1366386
46,48,49 All All	1377889 *1382662	YR YD	Inlet Outlet Asm. Hose 1382663 - Spring 1366386
4500 With K19	1377930	-	Hose Support
All All	9411656	-	Hose Clamps (Prod.)
All	1351813	-	Hose Clamps (Service)

*Common Part

*8-12-66

PART NUMBER-1379480

PAGE NUMBER- 11-1.3



1967 BUICK ASSEMBLY INSTRUCTION MANUAL

SPECIAL - SKYLARK 43000 - 44000 SERIES

SHEET METAL - FRONT END RADIATOR & GRILLE (SECTION 12)

COOLING SYSTEM FILL

THE FOLLOWING TABLE SHOWS THE COOLING SYSTEM CAPACITIES.

MODELS & SERIES	CAPACITY QTS.	ANTI. FREEZE -20° F. Qts.	AIR COND. CAPACITY	-20° F. ANTL FREEZE QTS.
"A" V6 - 225 with Heater	11.20	4.93 Non.A/C	11.20	.493
Less Heater	10.50			Not Available
A-V8-300 with Heater	12.70	5.58	14.00	6.16
V8-340 with Heater			14.70	6.48
less Heater	12.20		Not Available	
V-8-400 with A/C	17.00	7.42		
G.S. less A/C	16.70	7.35		
less Heater	15.80	6.97		

*300 Cu. In. A/C Wagons are the same capacity as 340 cu. in. A/C installation.

NOTE: - Cars shipped to Canada add 1.52 Qts. equal to 50% by volumn to give Protection to approximately minus 32° F.

Permanent Anti Freeze - 9985012 equal 44% by volumn to give Protection to approximately minus 20° F.

See Page 11-6.1 or 11-7.4 for additional information.

*9-21-66

PART NUMBER-1379480

PAGE NUMBER- 11-1.4



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

1-20-66

1967 RADIATOR HOSES AND USAGE (Continued)

Series & Usage	Part No.	Prod Code	Description	1966 Replaced Part
46, 48, 49 All	1377889	YR	Inlet	1372631 1372683
All	* 1378480	YT	Hose 1378481 Outlet Asm Spring 1366386	1372632
45000 With K19	1377930	--	Hose Support	C.O. (Except C60)
All All	9411656	--	Hose Clamps (Prod)	426661
All	1351813	--	Hose Clamps (Service)	C.O.

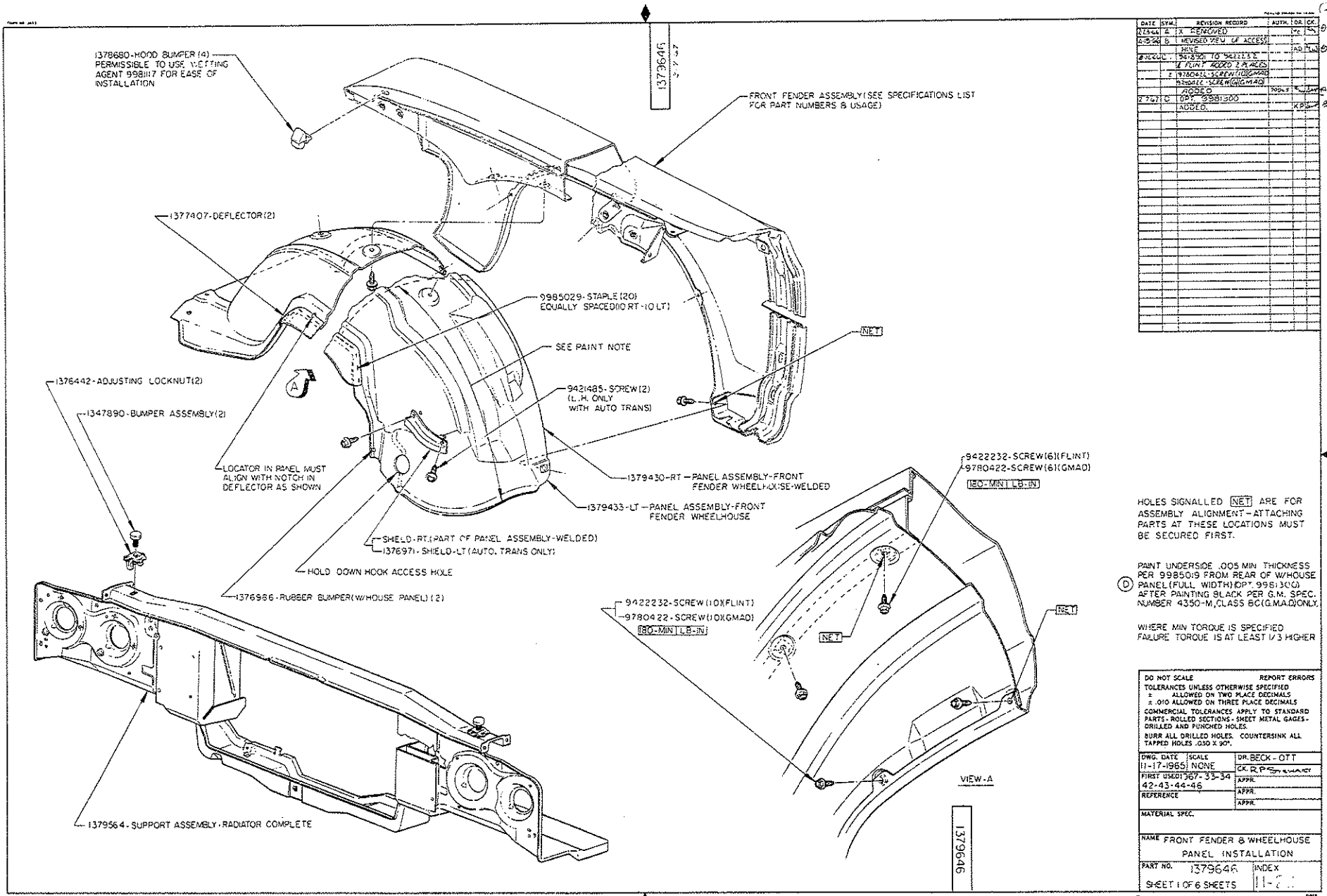
* Common Part

PART NUMBER-1379480

PAGE NUMBER- 11-1.5

GM

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



1379646
2-7-57

1379646

DATE	SYM.	REVISION	RECORD	AUTH.	CHK.
12-24-44	A	EX	REMOVED	DR	DR
1-25-54	B		REVISED VIEW OF ACCESS	DR	DR
			NOTE		
			REVISION TO SPECIFIC		
			IF PAINT ACCESS PLACES		
			2 19780422 SCREW (10) (G.M.A.D.)		
			2 9421485 SCREW (2) (G.M.A.D.)		
2-7-57	D	OPT. 9981300	ADDED.	KPM	KPM

Holes signalled [NET] are for assembly alignment - attaching parts at these locations must be secured first.

PAINT UNDERSIDE .005 MIN THICKNESS PER 9985015 FROM REAR OF W/HOUSE PANEL (FULL WIDTH) (OPT. 9981300) AFTER PAINTING BLACK PER G.M. SPEC. NUMBER 4330-M, CLASS 60 (G.M.A.D.) ONLY.

WHERE MIN TORQUE IS SPECIFIED FAILURE TORQUE IS AT LEAST 1/3 HIGHER

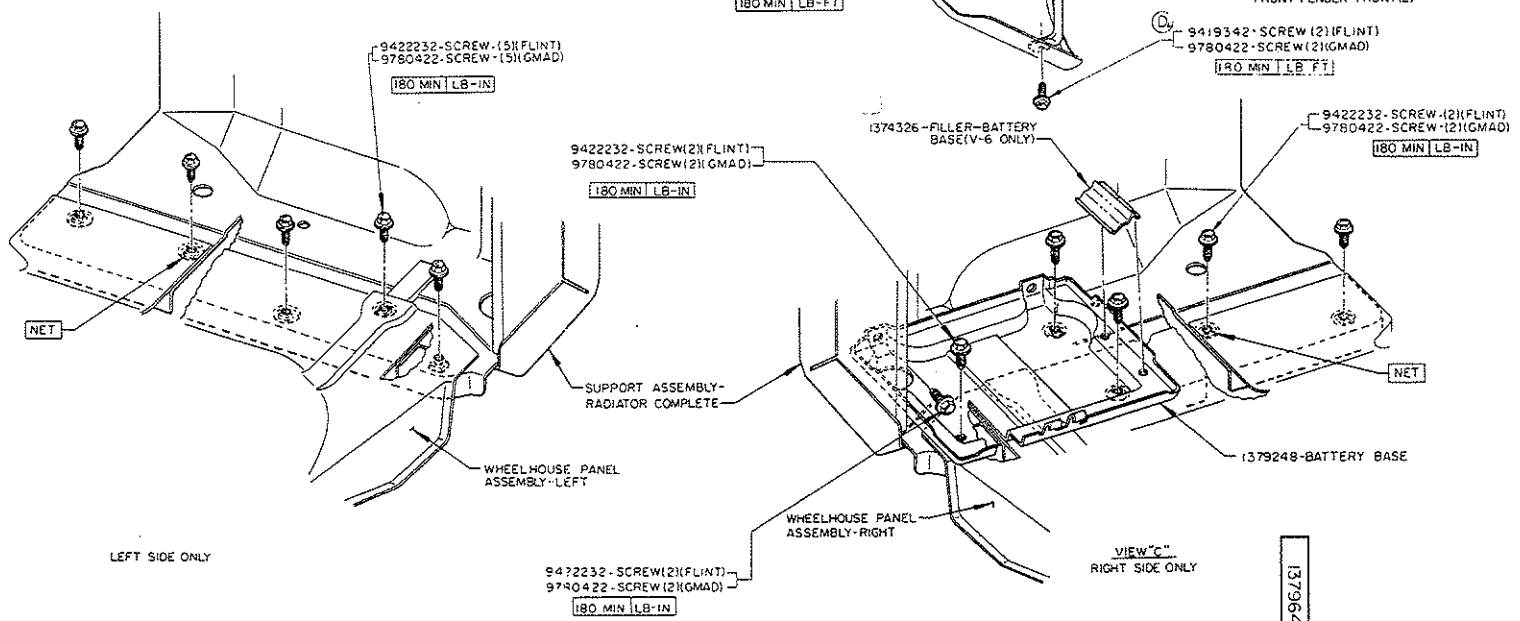
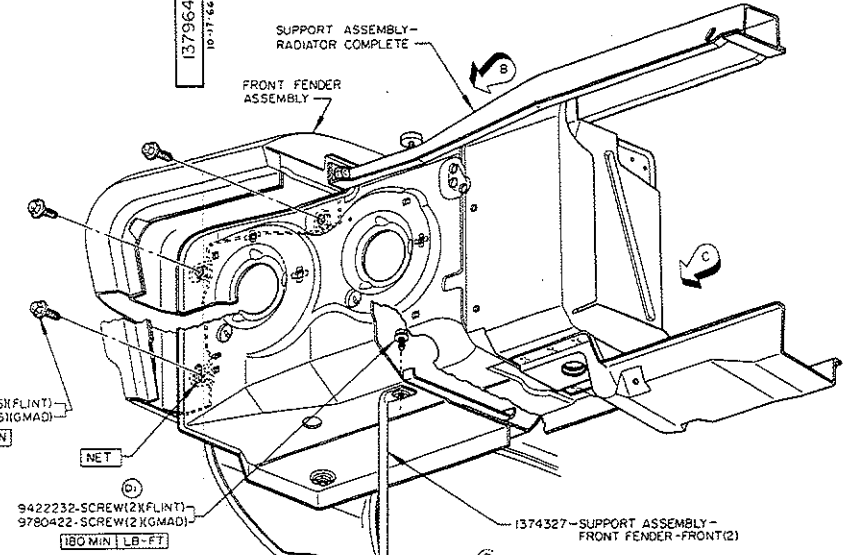
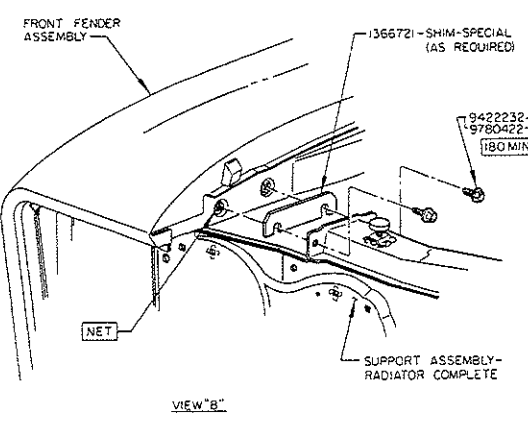
DO NOT SCALE REPORT ERRORS
TOLERANCES UNLESS OTHERWISE SPECIFIED
± ALLOWED ON TWO PLACE DECIMALS
± .010 ALLOWED ON THREE PLACE DECIMALS
COMMERCIAL TOLERANCES APPLY TO STANDARD PARTS - ROLLED SECTIONS - SHEET METAL GAGES - DRILLED AND PUNCHED HOLES.
BURR ALL DRILLED HOLES. COUNTERSINK ALL TAPPED HOLES .030 X 30°.

DWG. DATE 11-17-1965 SCALE DR. BECK - OTT
FIRST USED 12-7-33-34 EX. R.P. S. W. H. A. T.
42-43-44-46 APPR.
REFERENCE APPR.
MATERIAL SPEC. APPR.

NAME FRONT FENDER & WHEELHOUSE
PANEL INSTALLATION
PART NO. 1379646 INDEX
SHEET 1 OF 6 SHEETS 11-2

V4 PMS L

1379646



DATE	BY	REVISION RECORD	AUTH	CHK
11-9-65	DR	1	BECK	CRAFT
		2		
		3		
		4		
		5		
		6		
		7		
		8		
		9		
		10		
		11		
		12		
		13		
		14		
		15		
		16		
		17		
		18		
		19		
		20		

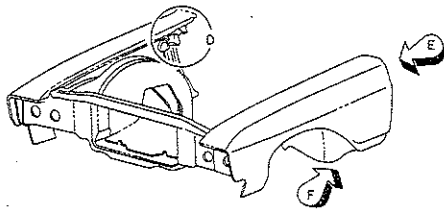
HOLES SIGNALLED [NET] ARE FOR ASSEMBLY ALIGNMENT-AT TACHING PARTS AT THESE LOCATIONS MUST BE SECURED FIRST.

WHERE MINIMUM TORQUE IS SPECIFIED, FAILURE TORQUE IS AT LEAST 1/3 HIGHER

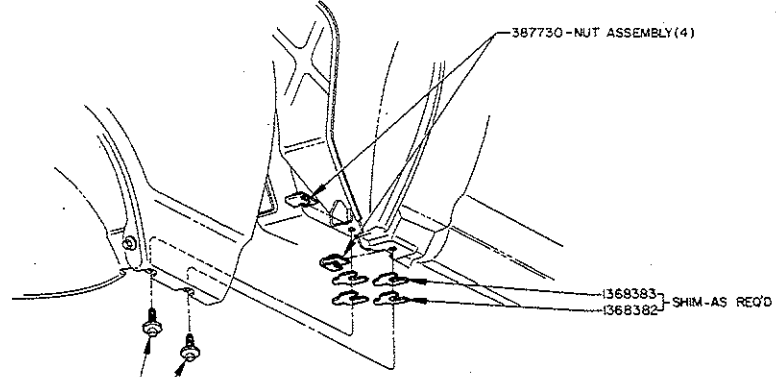
DO NOT SCALE TOLERANCES UNLESS OTHERWISE SPECIFIED	REPORT ERRORS UNLESS OTHERWISE SPECIFIED
ALLOWED ON TWO PLACE DECIMALS	
±.010 ALLOWED ON THREE PLACE DECIMALS	
COMMERCIAL TOLERANCES APPLY TO STANDARD PARTS-ROLLED SECTIONS-SHEET METAL GAGES-DRILLED AND PUNCHED HOLES	
BURR ALL DRILLED HOLES. COUNTERSINK ALL TAPPED HOLES .030 X 90°.	
DWG. DATE 11-9-65	SCALE NONE
FIRST USED 1967-33-34	DR. BECK-CRAFT
REFERENCE 42-43-44-46	CHK. R.D. CRAFT
	APPR.
	APPR.
MATERIAL SPEC.	
NAME FRONT FENDER & WHEELHOUSE PANEL INSTALLATION	
PART NO. 1379646	INDEX
SHEET 2 OF 6 SHEETS	11-22

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

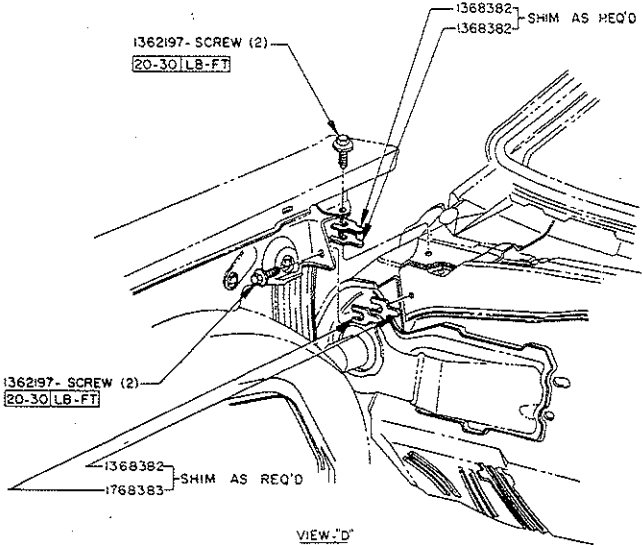
GENERAL MOTORS CORPORATION
PONTIAC, MICH. U. S. A.



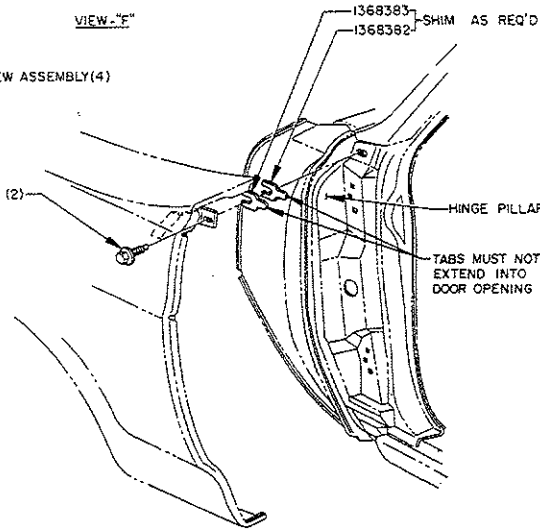
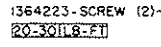
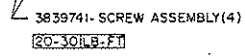
1379646



VIEW-"E"



VIEW-"D"



VIEW-"E"

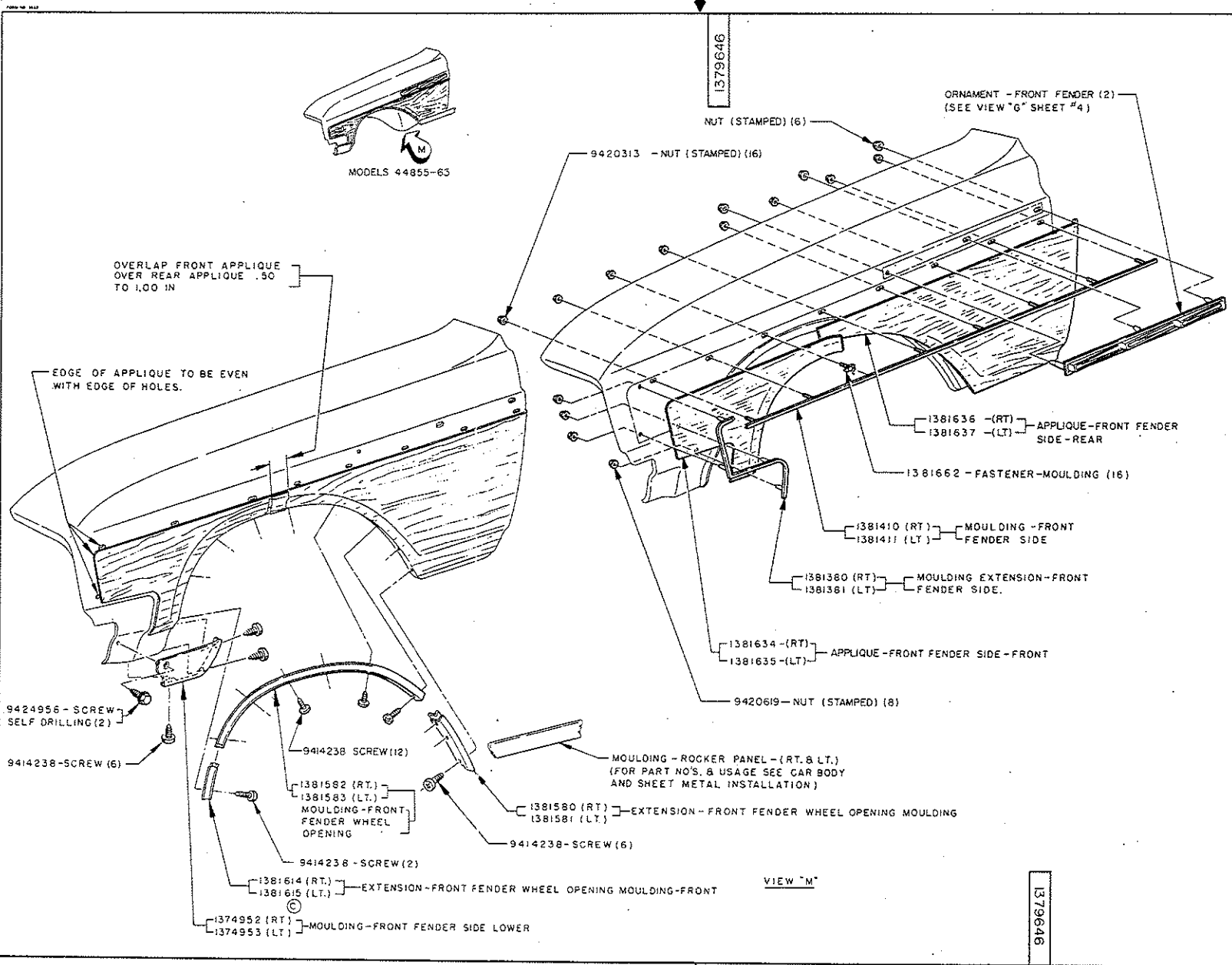
1379646

DATE	SYMBOL	REVISION RECORD	AUTH. I.D.R. CLK.
2-23-66	A	X REMOVED	1/2 M

WHERE MINIMUM TORQUE ONLY IS SPECIFIED, FAILURE TORQUE IS AT LEAST 1/3 HIGHER

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. DOHERTY-CRAFT
11-16-65	NONE	CK. G.P.S.
FIRST USED 1967-33	APPR.	
34-42-43-44-46	APPR.	
REFERENCE	APPR.	
MATERIAL SPEC.		
NAME FRONT FENDER & WHEELHOUSE		
PANEL INSTALLATION		
PART NO.	1379646	INDEX
SHEET 3 OF 6 SHEETS		11-23

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



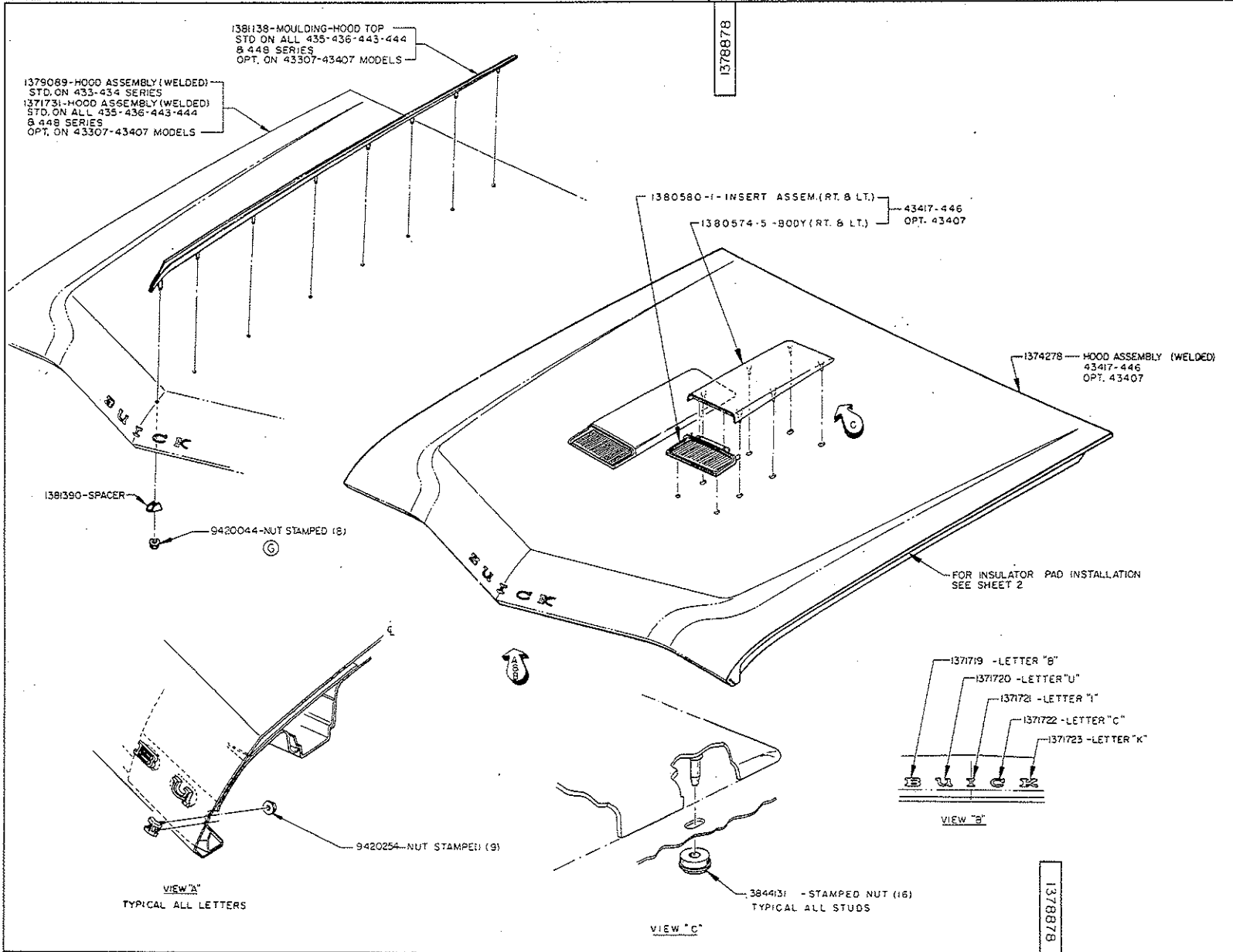
VIEW "M"

DATE	BY	REVISION	RECORD	AUTH.	DR.	CK.
10-24-66	D	REWORK	2-22-66			
10-24-66	C	1381636 TO 1381635				

TO APPLY APPLIQUE WET FENDER SURFACE WITH SOLUTION PER BUICK SPEC 325 AS REQUIRED.

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-DRIELED AND FINISHED HOLES.			
BURR ALL DRILLED HOLES. COUNTERSINK ALL TAPPED HOLES .030 X 90°.			
DWG. DATE	SCALE	DR.	B. BORROMEY
2-22-66	NONE	CK.	J. WOZNIAK
FIRST USED	1967-33-34	APPR.	
REFERENCE	35-36-43-44-46-48	APPR.	
MATERIAL SPEC.			
NAME FRONT FENDER & W/HOUSE PANEL INSTALLATION			
PART NO.	1379646	INDEX	
SHEET 6 OF 6 SHEETS		11-2.6	

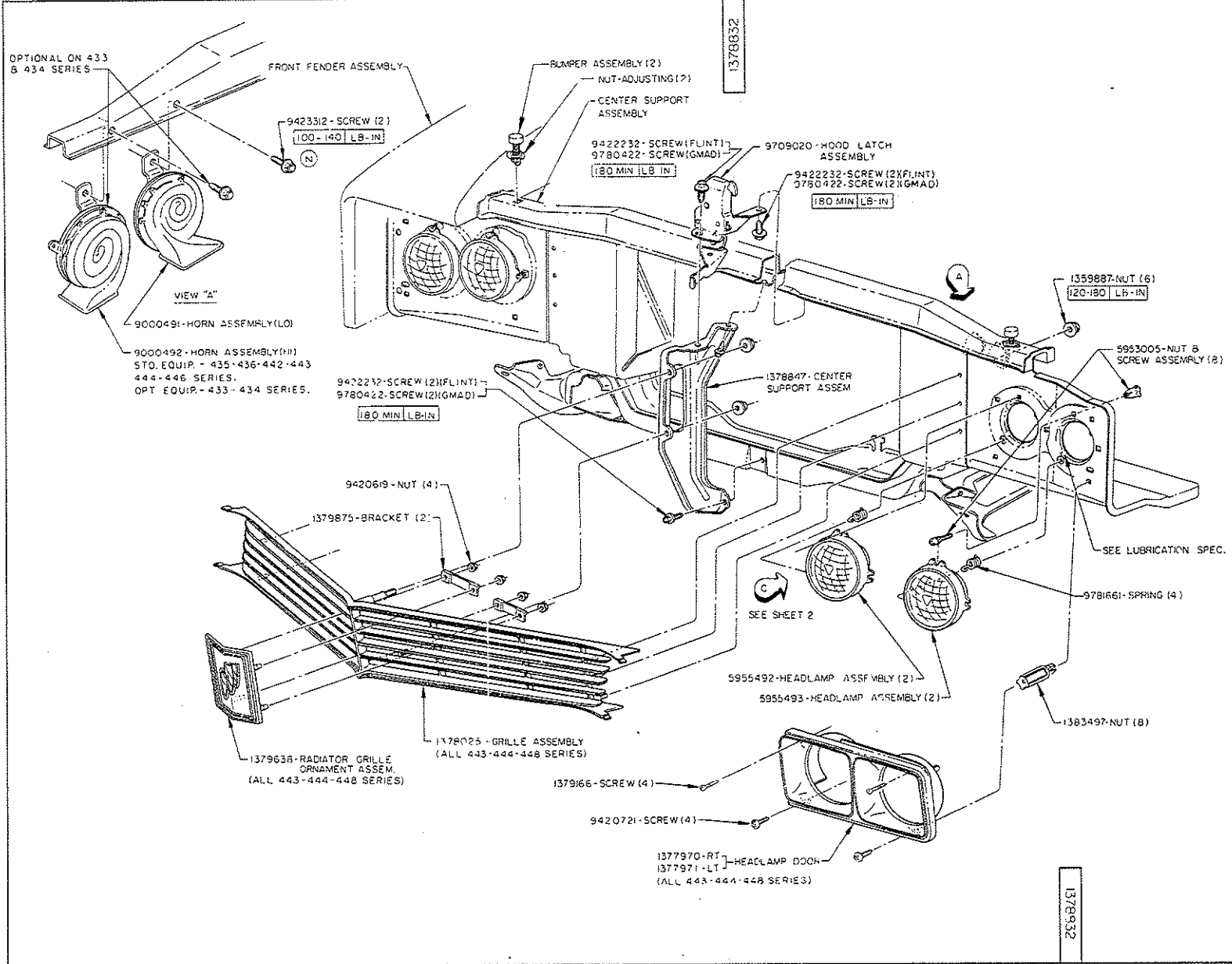
BUICK MOTOR DIVISION
GENERAL MOTORS CORPORATION
FLINT, MICH., U. S. A.



DATE	BY	REVISION RECORD	AUTH.	CHK.
12-22-66	A	REVISED		TRP
12-22-66	B	1381138-MOULDING-HOOD TOP TOP 9423363-NUT STAMPED (6) X VIEW ADDED. 1381138-SPACER ADDED		TRP
12-22-66	C	1371731-HOOD ASM (WELDED) 43307-43407 MODELS		TRP
12-22-66	D	ADDED		TRP
12-22-66	E	1380580-1-INSERT ASSEM (RT & LT) 1380574-5-NUT TO 1380574-5 OPT. 43407 ADDED		TRP
12-22-66	F	43417-446 TO 1380580-1-INSERT ASSEM		TRP
12-22-66	G	1374278		TRP
12-22-66	H	3844131-NUT (16) TO 9420044-NUT (6)		TRP

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 .000 X 90°.		
OWN. DATE	SCALE	DR. BECK-BACH
2-1-66	NONE	CHK. J. WOZNIAK
FIRST USED 1967-33-34	APPR.	
REFERENCE 42-43-44-45	APPR.	
MATERIAL SPEC.	APPR.	
NAME	HOOD INSTALLATION	
PART NO. 1378878	INDEX	
SHEET 1 OF 2 SHEETS	11-3.1	

1967-68 1378832



DATE	SYN	REVISION RECORD	AUTH.	DR	CHK.
12-1-65	A	X REMOVED			
12-22-65	B	LOCATING LUGS ADDED TO 137928-ORNAMENT			
1-16-66	C	137804 REMOVED TO DE-PAIL			
3-24-66	D	1378114 REMOVED			
3-24-66	E	3419752 TO 9420619 NUT (2 PLACES)			
6-30-66	F	9420211 SCREW (4) TO DRILLING SCREW (2)			
8-11-66	G	1378115 TO 1378116 REVISED 2 SCREWS			
12-7-66	H	1378115 TO 1378116 REVISED 2 SCREWS			
8-16-66	J	1378115 TO 1378116 REVISED TORQUE NOTE ADDED			
9-16-66	K	VIEW B, 1379282 ORN. 1379280 BRKT. REMOVED, SERIES REVISED FOR 1379280			
2-23-67	L	1378115 TO 1378116 REVISED TORQUE NOTE ADDED			
3-23-67	N	1379023 TO 1379024 TORQUE NOTE REVISED			

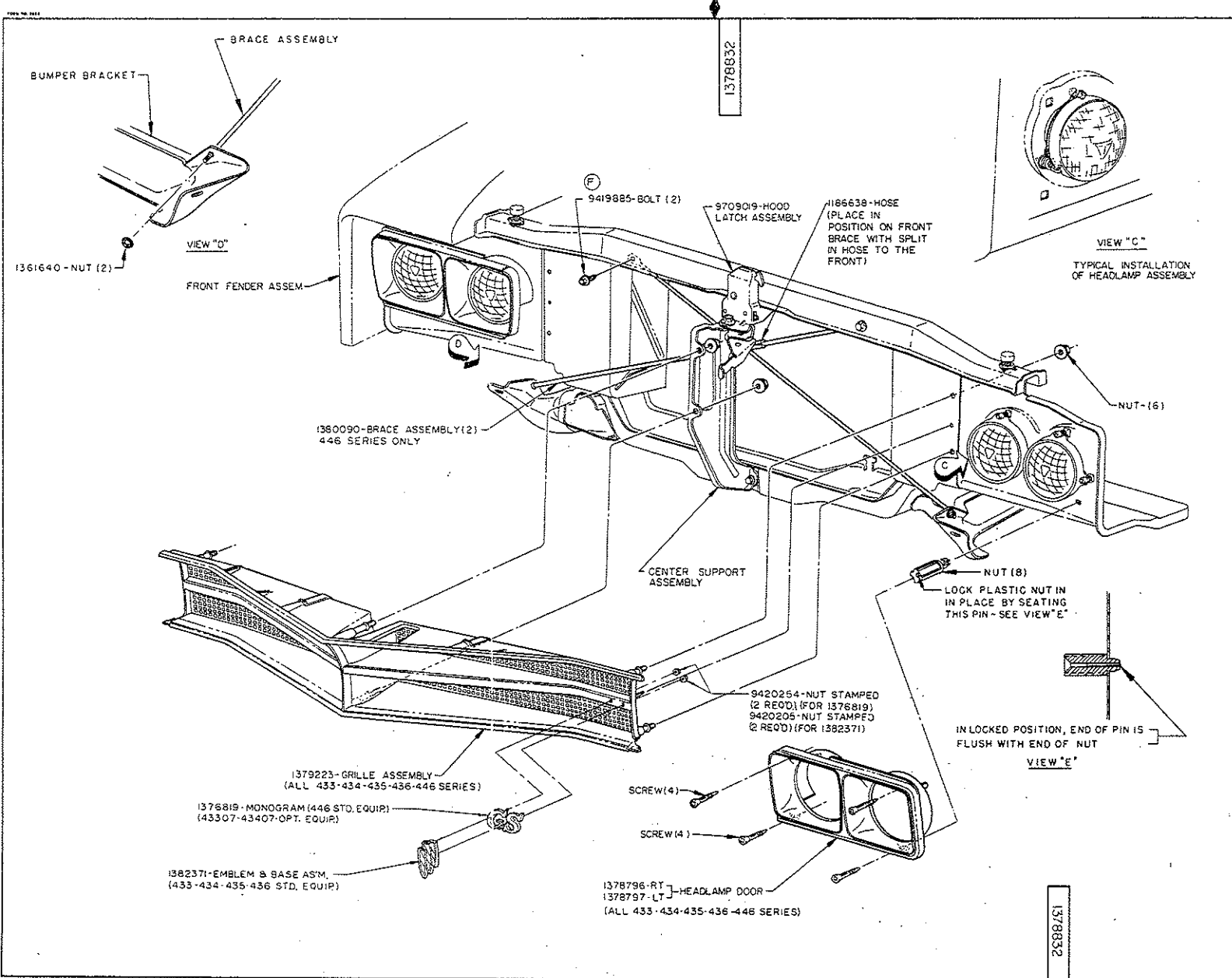
LUBRICANT, SPEC # 9385024
 APPLY TO LOBES ON RADIATOR SIDE BAFFLE
 3-PLACES AT EACH HEADLAMP OPENING
 WHERE MIN. TORQUE ONLY IS SPECIFIED, FAILURE TORQUE IS AT LEAST 1/3 HIGHER.

DO NOT SCALE		REPORT ERRORS
TOLERANCES UNLESS OTHERWISE SPECIFIED		
2 - ALLOWED ON TWO PLACE DECIMALS		
8 - 010 ALLOWED ON THREE PLACE DECIMALS		
COMMERCIAL TOLERANCES APPLY TO STANDARD PARTS - ROLLED SECTIONS - SHEET METAL GAGES - DRILLED AND PUNCHED HOLES.		
SURF ALL DRILLED HOLES - COUNTERSINK ALL TAPPED HOLES .030 X 90°.		
DWG. DATE	SCALE	DR. DOMROESE
12-1-65	NONE	CHK. J. W. CZERNIAK
FIRST USED 1967-33-34		APPR.
35-36-42-43-44		APPR.
REFERENCE		APPR.

MATERIAL SPEC.	
ALL SERIES LESS 446	
NAME RADIATOR GRILLE & FRONT END INSTALLATION	
PART NO. 1378832	INDEX
SHEET 1 OF 5 SHEETS	11-4.1

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

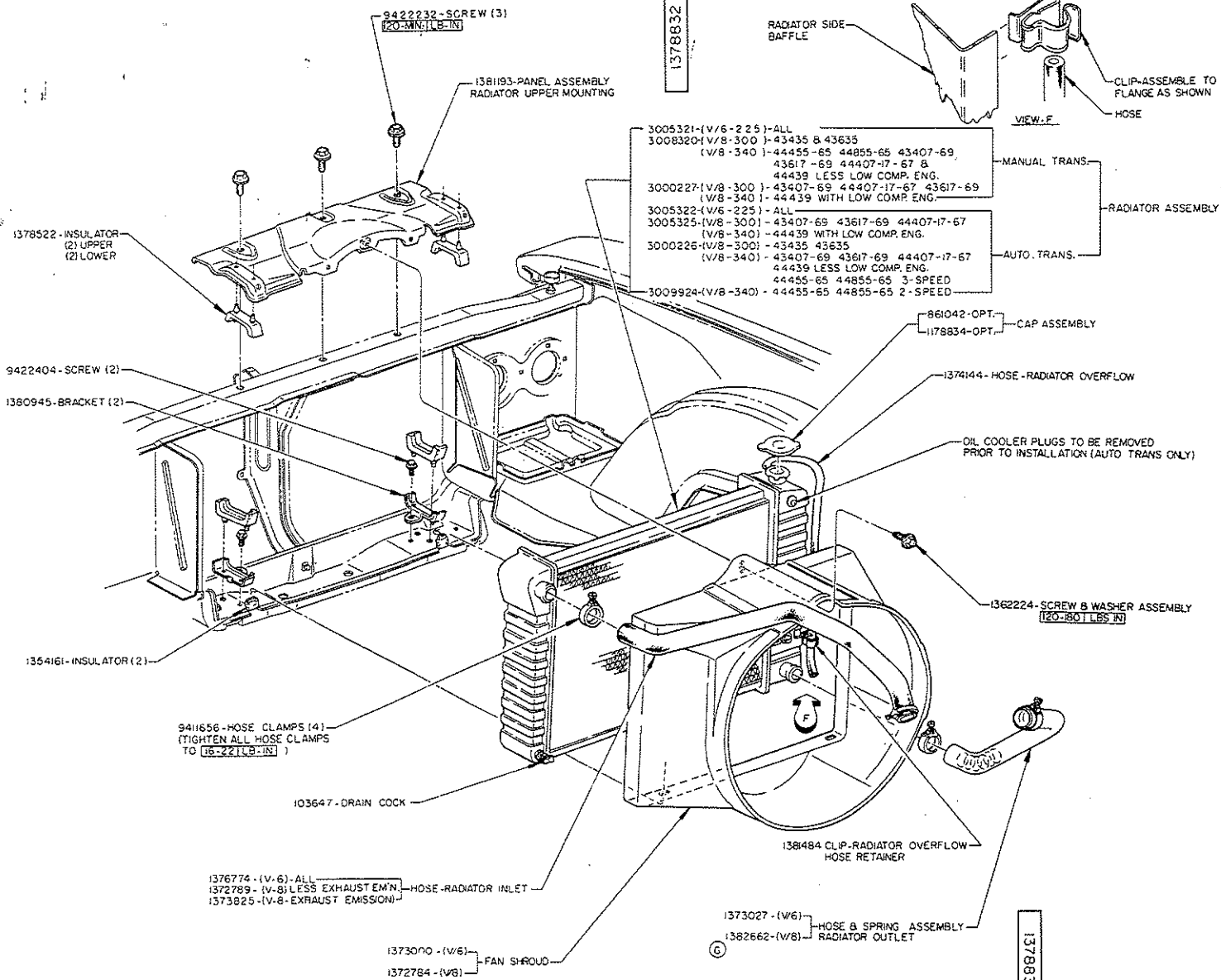
BUICK MOTOR DIVISION
GENERAL MOTORS CORPORATION
FLINT, MICH. U.S.A.



DATE	BY	REVISION RECORD	AUTH.	ORIG.
12-22	A	TX REMOVED		BBJ
12-22	D	VIEW 'E' REVISED		BBJ
6-8-60	C	OPT. 43307-43407		
		MODELS ADDED		206680001
		ADDED TO 5 SHEETS TO 5 SHEETS 10642 10643		
7-17-62	E	9420254-NUT, 9420205-NUT 1376819-MONOGRAM		
		1382371-EMBL. CH. 1		
		REPL. 9419885		
		REVISED E ADDED		10657 10658
8-24-67	F	9419885 TO 9419885		11410

FOR ATTACHING PARTS, SEE 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-DRIILLED AND PUNCHED HOLES.	
BURN ALL DRILLED HOLES. COUNTERSINK ALL TAPPED HOLES .030 X .90°	
ENG. DATE 12-7-65	SCALE NONE
FIRST USED 1967-33-34	DR. DOMROESE
REFERENCE 35-36-42-43-44	CK. J. WOZNIAK
	APPR.
	APPR.
446 SERIES & OPT. ON 43307-43407 MODELS	
NAME RADIATOR-GRILLE & FRONT END INSTALLATION	
PART NO. 1378832	INDEX 11-4.2
SHEET 2 OF 5 SHEETS	



DATE	BY	REVISION RECORD	AUTH	CHK
10-22-61	A	REVISED		
12-22-61	B	1372790 CHANGED TO 1378480		
3-24-62	C	1344827 TO 1378522		
		INSULATOR 1344821 TO 1380945 BRKT-4439		
		ADDED TO RAD STYLE'S -		
		DRAIN COCK NOTE RE-		
		MOVED, 1378480 TO		
		1374253 HOSE		
		1379981 TO 138193-PANEL		
3-10-62	D	1351170/137482		
		CLIP		
		4 SHEETS TO 5 SHEETS (2008) (137482)		
7-19-62	F	RADIATOR UPPER ASSEMBLY & NOTE		
		REVISED		
9-26-62	G	1374233 TO 1307402		

99850/2 ANTI-FREEZE MAY BE USED TO ASSIST RADIATOR HOSE INSTALLATION.

COOLING SYSTEM IS TO BE PRESSURE CHECKED FOR LEAKS WITH 14 TO 17 LBS. AIR PRESSURE AT RADIATOR NECK.

WHERE MIN. TORQUE ONLY IS SPECIFIED FAILURE TORQUE IS AT LEAST 1/3 HIGHER.

SEALING SURFACE INSIDE RADIATOR FILLER NECK MUST BE CLEAN AND FREE OF FOREIGN MATERIAL WHEN CAP IS INSTALLED.

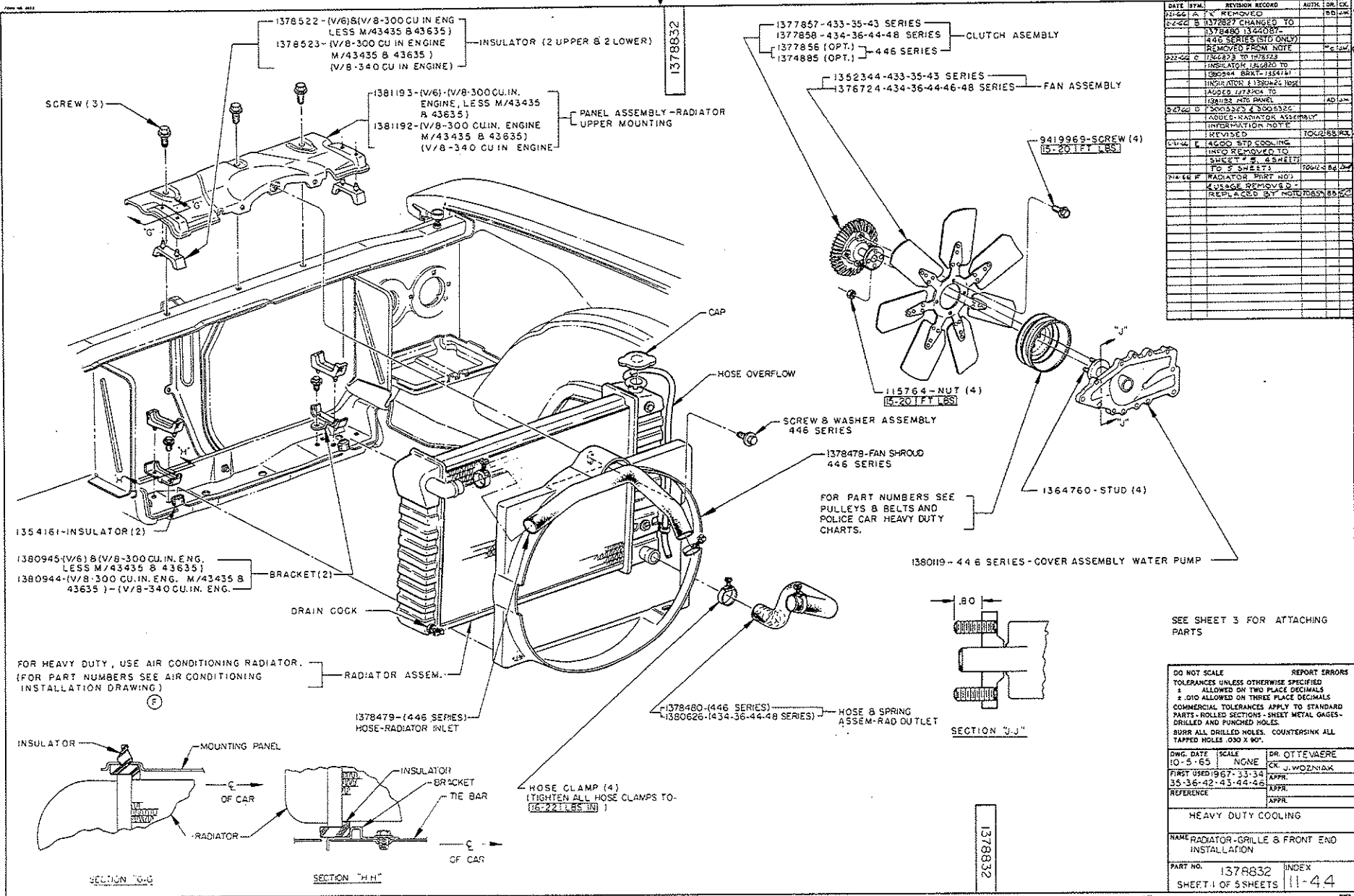
INSTALL 1163105 SEALING COMPOUND INTO RADIATOR TOP TANK AT INLET AND 2 OZ. 99850/17 EMULSIFYING CORROSION INHIBITING OIL IN RADIATOR FILLER NECK.

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.
SURR ALL DRILLED HOLES. COUNTERSINK ALL TAPPED HOLES .030 X 90°.

DWG. DATE	SCALE	DR. DOMROESE
10-5-65	NONE	CK. J. WOZNIAK
FIRST USED 1967-33-34		APPR.
35-36-43-44-46-48		APPR.
REFERENCE		APPR.

ALL SERIES-(LESS 44600 & H.D.)
NAME RADIATOR - GRILLE & FRONT END
INSTALLATION

PART NO. 1378832 INDEX
SHEET 3 OF 5 SHEETS 11-4.3



DATE	BY	REVISION RECORD	AUTH.	CHK.
11-22-65	A	FAN REMOVED		BDJ/LJK
12-22-65	B	1372827 CHANGED TO 1374885 1320074 446 SERIES (STD ONLY) REMOVED FROM NOTE		
02-22-66	C	1376673 TO 1378228 INSULATOR 134880 TO 1380944 BRKT-1384718 INDICATOR 1380424 HOSE ADDED 1378478 TO 138019 INTX PANEL 1380325 & 1380326 ADDED-RADIATOR ASSEMBLY INFORMATION NOTE REVISED		
01-14-66	E	1400 STD COOLING INFO REMOVED TO SHEET 2 & 3 SHEETS TO 5 SHEETS		TOU/ESS/REL
04-16-66	F	RADIATOR PART NO'S USAGE REMOVED - REPLACED BY MOTORGRASS 88022		

SEE SHEET 3 FOR ATTACHING PARTS

DO NOT SCALE		REPORT ERRORS	
TOLERANCES UNLESS OTHERWISE SPECIFIED			
1. ALLOWED ON TWO PLACE DECIMALS			
2. .010 ALLOWED ON THREE PLACE DECIMALS			
COMMERCIAL TOLERANCES APPLY TO STANDARD PARTS - ROLLED SECTIONS - SHEET METAL GAGES - GRILLED AND PUNCHED HOLES.			
BURR ALL DRILLED HOLES. COUNTERSINK ALL TAPPED HOLES .030 X 90°.			
DWG. DATE	SCALE	DR. OTTEVAERE	
10-5-65	NONE	CK. J. WOZNIAK	
FIRST USED	1967-33-34	APPR.	
REFERENCE	35-36-42-43-44-45	APPR.	
HEAVY DUTY COOLING			
NAME RADIATOR-GRILLE & FRONT END INSTALLATION			
PART NO.	1378832	INDEX	
SHEET 1 OF 5 SHEETS		11-44	

Insert long sheets 11-5.1 and 11-8.1 here.