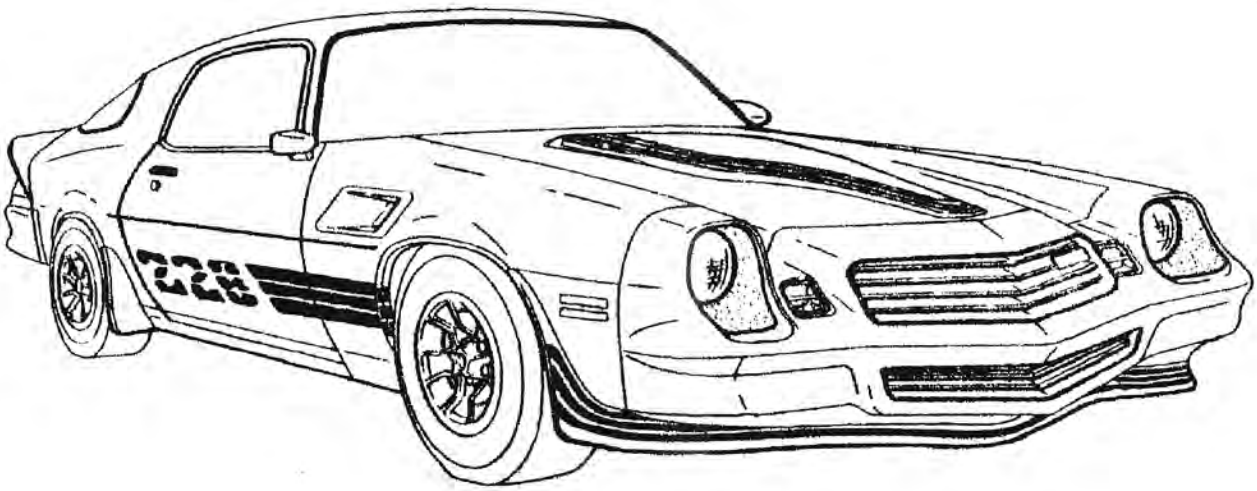
1981

CAMARO



ASSEMBLY MANUAL

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INTRODUCTION TO PRODUCT DESCRIPTION MANUAL (PDM)

FUNCTION & ORGANIZATION

The Product Description Manual depicts the design intent required for final assembly of the vehicle. It is to be considered as an authoritative source of information and placement of the various component parts of the vehicle. The views shown may be accompanied by instructions and/or procedures. However, the method of assembly and installation sequence is not determined by Product Engineering unless the instructions are requested by the responsible processing department in conjunction with Product Engineering.

The manual is divided up per the basic Uniform Parts Classification (UPC) Sections (0 thru 15), with a content sheet at the beginning of each section. Options have been integrated into the respective sub-sections of the major UPC sections to which the parts and assemblies are assigned at point of release. The manual content, thus, represents options and parts as released.

Every effort will be made to incorporate the latest authorized design into this manual. New and revised sheets, when received, should be inserted into their proper location so that maximum benefits may be derived from manual usage.

DESCRIPTION & SPECIFICATIONS

The description of parts illustrated is expressed as necessary to insure correct selection of build of vehicle. Refer to the Parts List for complete specifications on models, options, names, quantities and other conditions or restrictions. The word "ALL", when used, is intended to describe all usages that parts are released for and not to imply that parts are released for all models or conditions. Effort is made to depict parts so that quantity is countable, however, in some areas only the LH and RH side or one half of a part is illustrated and, thus, quantity should be logical.

DETAIL OF ILLUSTRATION

Illustrations are detailed only in the immediate area of assembly and only to the degree required to insure the proper assembly. For complete definition and information relative to the appearance of specific parts or assemblies, refer to the released detail part drawings when necessary. Reference background areas will be updated only if the operation being depicted is directly affected.

INQUIRIES & ADDITIONAL SHEETS

All inquiries pertinent to data in this manual or for additional copies should be directed to the Product Description Manual Illustration Group of this division.

PDM COORDINATION AGREEMENTS

The General Motors PDM Coordination Committee has negotiated agreements between Car and Truck Divisions to standardize instructions which are common to all vehicles. These sheets are usually "General Instructions" and have a common format in all manuals. The broad spectrum of coverage will, of necessity, include instructions not totally pertinent, in all instances, to this specific vehicle.

Many PDM sheets will display other GM car division headings. This will occur when instruction for a common design are originated by some other design responsible division. A single letter on the contents sheet under the column entitled Div. Resp. will signify the design responsible division. The letters are C-Chevrolet, B-Buick, O-Oldsmobile, P-Pontiac and D-Divisional. Usage of the letter D indicates each division is responsible for their own design.

MEASUREMENT SYSTEM

All values in this PDM are shown in the English system unless otherwise specified and the exception of torques. Torque values are shown in the Metric system of newton-meters (N·m).

INDEX CONTENTS

		DIV RESP	
INDEX-1	INTRODUCTION & INDEX CONTENTS	D	
INDEX-2	PRODUCT DESCRIPTION MANUAL FORMAT	C	
INDEX-3	UNIFORM PARTS CLASSIFICATION	D	
INDEX-4	OPTION UNIFORM PARTS CLASSIFICATION	D	(1 Thru 5)
INDEX-5	OPTION UNIFORM PARTS CLASSIFICATION	D	(6 Thru 11)
INDEX-6	OPTION UNIFORM PARTS CLASSIFICATION	D	(12 Thru 15 & SPL ITEMS)

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
		0				

DATE 11-17-80
DR J. MORENCY
CK
APPR
APPR
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APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

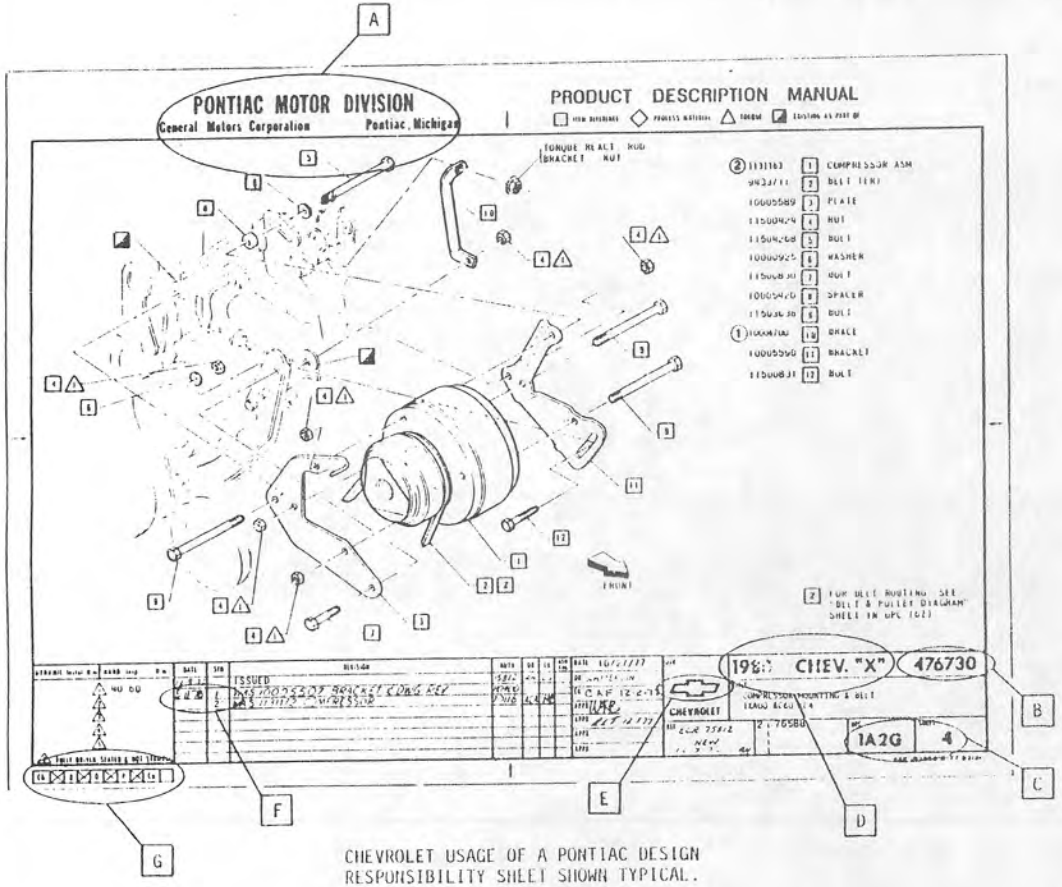
TITLE INTRODUCTION-INDEX CONTENTS
FA00 ALL

REF ECR 86448
NEW 15N079

UPC INDEX

SHEET 1

Ch X 1 0 P Co



CHEVROLET USAGE OF A PONTIAC DESIGN RESPONSIBILITY SHEET SHOWN TYPICAL.

A typical page is depicted here to illustrate the format of the Product Description Manual Sheets. It is a brief outline based on innovations added and effective with the usage of this format.

The following relates to this page and explains the conditions found thereon:

[A] Design responsible division (appearing at upper LH corner.) One division that is assigned this specific area of development, research, etc. for coordination among all participating automotive divisions. They are also accountable for the assembly instructions or graphics of this particular segment unless modified by the user division. It is possible that the design responsible and the divisional named PDM will be one and the same.

[B] Part number assigned to individual manual for the given model year.

[C] Numeric/alpha filing system based on the Uniform Parts Classification (UPC) and similar to the Production Parts List.

[D] Model Year and series number identification.

[E] Emblem of the specific Divisional Manual. All sheets within the manual should have only this identification at this location.

[F] File most recent date and/or highest numerical or alpha revision to insure usage of the latest issued sheet.

[G] Checking provision to control exchange distribution among the divisions. It is used for internal purposes only, not to be confused for filing and maintenance.

1981 CHEVROLET "A" 14020865*
1981 CHEVROLET "B" 14020866
1981 CHEVROLET "F" 14020867
1981 CHEVROLET "H" 14020868
1981 CHEVROLET "T" 14020869
1981 CHEVROLET "X" 14020871
1981 CHEVROLET "Y" 14020870

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
		02				

DATE 03JAN80
DR L. MORENCY
CK
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 ALL PASSENGER CARS*

TITLE PRODUCT DESCRIPTION MANUAL FORMAT ALL PASSENGER

REF ECR 86448 C/O 19N079 INDEX-1.1

UPC INDEX

SHEET 2

Ch | B | O | P | Ca

O CHARTS, INSTRUCTION DRAWINGS & GENERAL INFORMATION

1 BODY

1A1	PASS CAR BODIES AS PURCH
1A2A	FLOOR & SILL
1A2B	I/P PARTS
1A2C	BODY VENT & DEFOGGING
1A2D	WSW & WASHER
1A2E	MISCELLANEOUS PARTS
1A2F	EXT BODY ORNAMENTATION
1A2G	A/C COMPRESSOR
1A2H	HEATER & A/C AIR SYSTEM
1A2J	HEATER & A/C CONTROLS
1A2K	A/C REFRIGERANT SYSTEM
1A2L	HEATER WATER SYSTEM
1B	BODY MOUNTING
1Z	MISCELLANEOUS INFORMATION

2 FRAME

2B	FRAME
2C	DYNAMIC DAMPENERS
2Z	MISCELLANEOUS INFORMATION

3 FRONT SUSPENSION

3	
3A	FRONT SUSP ASM
3C	FRONT SPRINGS
3F	FRONT SHOCK ABSORBERS
3G	FRONT STABILIZERS
3Z	MISCELLANEOUS INFORMATION

4 REAR AXLE & REAR SUSPENSION

4	REAR AXLE & SUSP ASM
4A	RR AXLE ASM & PROP SHF
4B	REAR SPRINGS
4D	SPRING INSTL PARTS
4E	SHOCK ABSORBERS
4F	REAR STABILIZER
4Z	MISCELLANEOUS INFORMATION

5 BRAKES

5A	FRONT BRAKES
5C	BRK PEDAL & MASTER CYL CONN
5D	PARKING BRAKE
5E	HYD MASTER CYLINDER
5F	BRAKE LINES
5G	POWER BRAKE
5Z	MISCELLANEOUS INFORMATION

6 ENGINE

6	ENGINE ASSEMBLY
6B	ENGINE LABELS
6C	C/CASE, BAL & FLYWHEEL
6G	ENGINE LUBRICATION
6H	ENGINE VENTILATION
6J	ENGINE FRT END COVERS
6K	ENGINE COOLING
6L	ENG HEAT CON & MANIF
6M	ENGINE FUEL SYSTEM
6N	THROTTLE CONTROL
6Q	ENG & TRANS MOUNTING
6T	AIR INJECTION REACTOR
6Y	ENG ELEC SYSTEM
6Z	MISCELLANEOUS INFORMATION

7 TRANSMISSION

7	TRANSMISSION ASSEMBLY
7A	TRANS EXTERNAL CONTROLS
7B	CLU SYS & TRANS COOLING
7Z	MISCELLANEOUS INFORMATION

8 FUEL TANK & EXHAUST

8A	FUEL TANK
8B	FUEL LINES
8C	EXHAUST SYSTEM
8D	EVAP EMISSION CONT SYS
8E	CATALYTIC EMISSION CONT SYS
8Z	MISCELLANEOUS INFORMATION

9 STEERING MECHANISM

9A	STRG GEAR & COLUMN
9B	STEERING WHEEL
9C	STRG COLUMN SUPPORT
9D	STEERING LINKAGE
9E	POWER STEERING
9Z	MISCELLANEOUS INFORMATION

10 WHEELS & TIRES

10B	WHEELS & TIRES
10E	SPARE WHEEL MOUNTINGS
10Z	MISCELLANEOUS INFORMATION

11 CHASSIS SHEET METAL

11A	FRONT FENDERS
11D	HOOD
11E	MISC FRT END SHT METAL
11G	ORNAMENTATION
11Z	MISCELLANEOUS INFORMATION

12 ELECTRICAL—CHASSIS & BODY

12A	BATTERY & LEADS
12B	BATTERY SUPPORTS
12C	FRONT LMPS & TURN SIGNALS
12E	REAR LIGHTING
12G	HORN
12H	BULBS, CHAS & BODY WRG
12J	INSTRUMENTS & GAGES
12L	CONVENIENCE ITEMS
12Z	MISCELLANEOUS INFORMATION

13 RADIATOR & GRILLE

13A	RADIATOR ASSEMBLY
13B	RADIATOR MOUNTING
13C	RADIATOR GRILLE
13E	RADIATOR SHROUD
13Z	MISCELLANEOUS INFORMATION

14 BUMPERS & MISCELLANEOUS

14A	BUMPERS
14B	LUB & BULK MATERIALS
14C	LICENSE CARRIERS
14E	TOOL COMPT & KIT
14F	CAR NO. & IDENT PLATES
14G	SHPG PROTECTIVE ITEMS
14Z	MISCELLANEOUS INFORMATION

15 MISC PAINT & WATER TEST

15D	MISCELLANEOUS PAINT
15F	WATER TEST

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1981 CHEVROLET "F" 14020867
1981 CHEVROLET "H" 14020868
1981 CHEVROLET "T" 14020869
1981 CHEVROLET "X" 14020871

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
		03				

DATE 5-22-80
DR L. MORENCY
CK DEGOLLER / C
APPR
APPR
APPR
APPR

DIV CHEVROLET

TITLE 1981 ALL PASS* (exc "Y")

UNIFORM PARTS CLASSIFICATION
ALL PASSENGER (exc "Y") (0 Thru 15)

REF ECR 86448
C/O 19N079
INDEX-2

UPC INDEX

SHEET 3

Ch M B N D N P N Ca N

1 BODY

AN6	EQUIPMENT-Seat Back-Adjustable	.... [Y] [Z]
AU3	LOCK-Side Door (Electric)	
AV9	SEAT REQUIREMENTS-Export	
A01	GLASS-Body-Tinted	.... [Y] [Z]
A02	GLASS-Windshield-Tinted	.... [Y] [Z]
A31	WINDOW-Electrical	.... [Y] [Z]
A51	SEAT-Special Contour-Bucket	.... [Y] [Z]
BS1	BODY INSULATION	
B18	ORNAMENTATION-Interior-Deluxe	
B37	MATS-Floor (Front & Rear)	.... [Y] [Z]
B77	ORNAMENTATION-Reveal Molding	.... [Y] [Z]
B80	MOLDING-Roof Drip	.... [Y] [Z]
B81	ORNAMENTATION-Body Side (Delete)	
B84	MOLDING-Body Side	.... [Y] [Z]
B85	MOLDING-Belt Reveal	.... [Y] [Z]
B89	ORNAMENTATION-Reveal Molding	.... [Y] [Z]
B93	GUARDS-Door Edge	
B94	ORNAMENTATION-Body Emblem	
B97	ORNAMENTATION-Spoiler	
CC1	ROOF-Removable Hatch	
CD4	WASHER & WIPER-Pulse Windshield	
C41	HEATER-Standard	.... [Z]
C49	DEFOGGER-Rear Window-Electric	
C60	AIR CONDITIONING-All Weather	
(1) D28	MIRRORS-Outside Rear View-Delete (Export)	.... [Y] [Z]
D35	MIRROR-Outside-Rear View-Custom	.... [Y] [Z]
(3)		
D80	EXTENSION-Rear Compartment Lid	
D88	STRIPE-Sport	
D92	TAPE-Door Handle Decor	.... [Y] [Z]
D98	STRIPE-Rally	

2 FRAME

3 FRONT SUSPENSION

F41	SUSPENSION-Special Performance-Front & Rear
6AE thru 6MF	SPRING-Front LH
7AE thru 7MF	SPRING-Front RH

4 REAR AXLE & REAR SUSPENSION

GM8	AXLE-Rear (2.56 Ratio)	.... [Y]
GU2	AXLE-Rear (2.73 Ratio)	.... [Y]
GU4	AXLE-Rear (3.08 Ratio)	.... [Y]
GU5	AXLE-Rear (3.23 Ratio)	
G80	AXLE-Rear Locking Type	
G92	AXLE-Rear Performance	
8LB thru 8YP	SPRING-Rear LH	
9LB thru 9YP	SPRING-Rear RH	

5 BRAKES

(2) J50	BRAKES-Vacuum Power	
J61	BRAKE SYSTEM-(Export)	

[Y] Non-Illustrated Option

[Z] Fisher Body

DYNAMIC (Install) N·m	HAND (Insp.) N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM CAG
		19SEP80	1	OPT D28 ADDED	92440	CMP		
		24OCT80	2	OPT JE1 ADDED	92263	CMP		
		19MAR81	3	OPT D36 REMOVED	93996	ACV		

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE 03JA90
DR I. MORENCY
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE OPTION-UNIFORM PARTS CLASSIFICATION FAQO ALL (1 Thru 5)

REF ECR 86448
C/O 19N079
INDEX-3

UPC INDEX

SHEET 4

04

Ck X B O P Cu

6 ENGINE

	K05	HEATER-Engine Block
(1)	K35	CONTROL-Cruise-Resume Speed
	K77	GENERATOR-AC (55 Amp)
	LC3	V6 ENGINE "229" CID 2 Bbl Carb-3.8 Liter
	LD5	V6 ENGINE "231" CID 2 Bbl Carb-3.8 Liter
	LG4	V8 ENGINE "305" CID 4 Bbl Carb-5.0 Liter
	LM1	V8 ENGINE "350" CID 4 Bbl Carb-5.7 Liter
	LU8	V8 ENGINE "301" CID 4.9 Liter-Turbocharged
	L39	V8 ENGINE "267" CID 2 Bbl Carb-4.4 Liter

7 TRANSMISSION

	MV4	TRANSMISSION-3 Speed-Automatic THM 350C
	MV9	TRANSMISSION-3 Speed-Automatic THM 200C
	M33	TRANSMISSION-3 Speed-Automatic THM 350
	M64	TRANSMISSION-3 Speed-Manual (3.5 Ratio)

8 FUEL TANK & EXHAUST

	NA5	EMISSION SYSTEM-Federal
	NA6	EMISSION CONTROL-High Altitude
	NB1	EMISSION CONTROLS-Closed Loop
	NB2	EMISSION CONTROL-Mandatory California
(2)	NM4	EMISSION CONTROL-Non Closed Loop
	NM5	EMISSION SYSTEM-Canada
	NM6	EMISSION CONTROL-Canada Recalibration

9 STEERING MECHANISM

	N33	WHEEL-Steering-Tilt

10 WHEELS & TIRES

(3)	N18	LOCKING PACKAGE-Wire Wheel Covers
	N65	TIRE-Space Saver Spare
	N90	WHEEL-Aluminum
	PT1	WHEEL-14 X 7.00 .... [Y]
	P01	COVER-Wheel Trim
	QGR thru QKL	TIRES

11 CHASSIS SHEET METAL

[Y] Non-Illustrated Option

[Z] Fisher Body

DYNAMIC (Install) N·m	HAND (Insp.) N·m	DATE	SYM	REVISION	AUTH	DR	CK	ECR/CHG	DATE 4/1/80
		2/19/80	1	K35 VIA K30 CONTROL-SPEED & CRUISE	89091	GMP			DR L. MORENCY
		5/1/80	2	OPTIONS NA14, NA15 & NA16 ADDED	89091				CK
			3	N18 OPTION ADDED	90082	GMP	MS		APPR
									APPR
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									APPR

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1981 CHEV. "F" 14020867

TITLE OPTION-UNIFORM PARTS CLASSIFICATION FA00 ALL (6 Thru 11)

REF ECR 86448 C/O 19N079 INDEX-4

UPC INDEX

SHEET 5

12 ELECTRICAL—CHASSIS & BODY

D1A thru D1W GEAR-Speedometer Driven
E52 LESS ADAPTER-Speedo Gear
E6E thru E6N SLEEVE-Speedo Gear
E9Z LESS KEY-Speedo Gear

TR9 LAMP GROUP
TT4 HEADLAMP-Halogen
T63 BUZZER-Headlamp Warning
T70 HEADLAMPS-Special-Export
T89 LAMP ASM-Tail & Stop-Export .... [Z]
T90 LAMPS-Rear End-Export .... [Z]
T93 LAMP ASM-Tail & Stop-Special

UA1 BATTERY-Heavy Duty
UM2 RADIO-AM/FM Stereo Pushbutton & Tape Player
UN3 RADIO-AM/FM Stereo-Cassette Tape Player
UN9 RADIO-Suppression Equipment
UP6 RADIO-AM/FM Stereo With CB (40 Channel)
UP7 RADIO PROVISIONS-Monaural
UP8 RADIO PROVISIONS-Stereo
U05 HORN-Dual
U14 GAGE-Instrument
U18 SPEEDOMETER-Export
U25 LAMP-Luggage Compartment .... [Z]
U26 LAMP-Engine Compartment
U27 LAMP-Instrument Panel Compartment
U28 LAMP-Ash Tray
U29 LAMP-Courtesy
U35 CLOCK-Electric
U58 RADIO-Stereo
U63 RADIO-AM-Pushbutton
U69 RADIO-AM/FM-Pushbutton
U75 ANTENNA-Power
U76 ANTENNA-Windshield
U80 SPEAKER-Auxiliary
U83 ANTENNA-Power (AM/FM/CB)

13 RADIATOR & GRILLE

V08 RADIATOR-Heavy Duty

14 BUMPERS & MISCELLANEOUS

VE1 EXTENSION-Rear End Panel (Delete)
VJ9 EMISSION COMPLIANCE INFO-California
VK3 MOUNTING-License Plate-Front
V78 PLATE-Less Certificate of Compliance (Export)
V92 INFLATOR-Stowaway Spare Tire (Delete) (Export)

15 MISCELLANEOUS FINAL ASSEMBLY

SPECIAL ITEMS

(3) V84 GOVERNMENT ORDERS OF U.S. VEHICLES (EXPORT) [Y]
YF5 EMISSION CERTIFICATION-California
YK6 SEO IDENTIFICATION .... [Z]
YR1 SEAT-Front Custom
(1)
Z21 MOLDING-Exterior
Z28 SPECIAL PERFORMANCE PACKAGE
Z49 MANDATORY-Canadian Equipment
Z54 DECOR-Interior-Silent Sound Group
(2)
Z94 CONVERTER-Mandatory Canadian

11 thru 84 (L,U) COLOR COMBINATIONS
15 thru 75 (D,C,I,N,R) TRIM COMBINATIONS
159 thru 759 HARNESS-Seat & Shoulder
12 thru 78 (A) STRIPE-Sport

[Y] Non-Illustrated Option
[Z] Fisher Body

DYNAMIC (Instal) N·m	HAND (Insp.) N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
1		28MR80	1	RPO ZJ7 REMOVED	37679	CMP	RC	
2		01MY80	2	RPO Z85 REMOVED	80234	CMP	RC	
3		20JN80	3	OPTION V84 ADDED	94332	CMP	HB	
4								
5								

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DATE 15JA80
DR L. MORENCY
CK
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DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE OPTION-UNIFORM PARTS CLASSIFICATION
FA00 ALL (12 Thru 15 & SPL ITEMS)

REF ECR 86448
C/O 19N079
INDEX-5

UPC INDEX

SHEET 6

Ch X B O P Co

0A GENERAL INFORMATION

		DIV RESP
0A-1	CONTENTS	D
0A-2	MODELS CHART	D
0A-3	MODELS & SYMBOLS	D
0A-4	ASSEMBLY NOTES	C
0A-5	TORQUE INSTRUCTION	C
0A-6	STAPLING INSTRUCTION	C
0A-7	HOSE CLAMPING INSTRUCTIONS	C
0A-8	HOSE INSTALLATION INSTRUCTIONS (WITHOUT CLAMPS)	C
0A-9	RETAINER INSTRUCTIONS	C
0A-10	RETAINER INSTRUCTIONS	C
0A-11	RETAINER INSTRUCTIONS	C
0A-12	RETAINER INSTRUCTIONS	C
0A-13	ALUMINUM CORROSION PROTECTION	C
0A-14	ADHESIVE BONDED EMBLEMS & SCRIPTS	C
0A-15 ●	DECAL APPLICATION PROCEDURE	C
0A-15.1 ●	DECAL APPLICATION PROCEDURE	C
0A-16	ADHESIVE MOLDING INSTRUCTION-SOLUTION LACQUER (PLANT APPLIED ADHESIVE)	C
0A-17	ADHESIVE MOLDING INSTRUCTION-DISPERSION LACQUER (BUTYL ADHESIVE)	C
0A-18	ADHESIVE MOLDING INSTRUCTION-SOLUTION LACQUER (PRE-APPLIED ADHESIVE)	C
0A-19	ADHESIVE MOLDING INSTRUCTION-SOLUTION LACQUER (PRE-APPLIED ADHESIVE) WITH PROMOTER	C
0A-20	TRIM HEIGHTS	D

★ Instructions Carryover
● Waiting Info.

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
		07				

DATE 11 JAN 80
DR L. PLUNKETT
CK [illegible]
APPR
APPR
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DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
CONTENTS-GENERAL INFORMATION
FA00 ALL

REF ECR 86448
NEW 12N079

UPC 0A

SHEET 1

CA | N | B | D | P | Co

1981 PASSENGER CAR MODEL SYMBOL CHART

CHEVROLET ENGINEERING CENTER

	BODY	SERIES NAME	BODY STYLE	MODEL DESIGNATION	PASS. OR SEATS	REMARKS
	B CAR	IMPALA	4 Dr. Sedan	1BL69	6	*Third seat available as RPO on station wagons.
			2 Dr. Coupe	1BL47	6	
			4 Dr. Station Wagon	1BL35	2 Seat*	
		CAPRICE CLASSIC	4 Dr. Sedan	1BN69	6	
			2 Dr. Coupe	1BN47	6	
			4 Dr. Station Wagon	1BN35	2 Seat*	
	A CAR	MALIBU	2 Dr. Notchback Coupe	1AT27	6	GMC Pickup Delivery available as RPO on El Camino
			4 Dr. Sedan	1AT69	6	
			4 Dr. Station Wagon	1AT35	2 Seat	
		MALIBU CLASSIC	2 Dr. Notchback Coupe	1AW27	6	
			4 Dr. Sedan	1AW69	6	
			4 Dr. Station Wagon	1AW35	2 Seat	
		EL CAMINO	2 Dr. Pickup Delivery	1AW80	3	
	A SPEC.	MONTE CARLO	2 Dr. Sport Coupe	1AZ37	6	
(2)	X CAR (FWD)	CITATION	2 Dr. Hatchback Coupe	1XX08	5	
			4 Dr. Hatchback Sedan	1XX68	5	
	F CAR	CAMARO SPORT COUPE	2 Dr. Sport Coupe	1FP87	4	
		BERLINETTA	2 Dr. Sport Coupe	1FS87	4	
	T CAR	CHEVETTE	2 Dr. Hatchback Coupe	1TJ08	4	"Scooter"
(1)			2 Dr. Hatchback Coupe	1TB08	4	
			4 Dr. Hatchback Sedan	1TB68	4	
	Y CAR	CORVETTE	2 Dr. Sport Coupe	1YY87	2	

1981 CHEVROLET "A" 14020865*
1981 CHEVROLET "B" 14020866
1981 CHEVROLET "F" 14020867
1981 CHEVROLET "T" 14020869
1981 CHEVROLET "X" 14020871
1981 CHEVROLET "Y" 14020870

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
4/MAR80	1	1TX08 & 1TX68 MODELS CANCELED	33154			
	2	1XA11 MODELS CANCELED	37276			

DATE 3.1.80
DR E MORENCY
APPR
APPR
APPR
APPR

DIV CHEVROLET

TITLE 1981 ALL PASSENGER CARS*
MODEL CHART
ALL PASSENGER

REF ECR 86448
NEW 12DE79

UPC 0A

SHEET 2

C X B D P Co

MODELS

The following designations represent all models released for the vehicle indicated:

"A" AA00

"B" BA00
"F" FA00
(1) (2)

"T" TA00
"X" XA00
"Y" YA00

SYMBOLS

[1] Indicates cross referencing of part numbers.

[Z] Indicates cross referencing of notes.

△1 Indicates torque.

(1) or (A) Indicates a revision.

◇A Indicates cross reference of applied Process Material.

◪ Indicates existing as part of an assembly.

-|- Indicates a non-released part or other unavailable data.

1981 CHEVROLET "A" 14020865*
1981 CHEVROLET "B" 14020866
1981 CHEVROLET "F" 14020867
1981 CHEVROLET "T" 14020869
1981 CHEVROLET "X" 14020871
1981 CHEVROLET "Y" 14020870

DATE	SYM	REVISION	AUTH	DR	CK	ACM ENG
03JUL80	1	"H" REFERENCE REMOVED				
	2	MODEL DESIGNATION NOTE REMOVED (PCO-1)	8655	CMP	[illegible]	

09

DATE 03JUL80
DR L. MORENCY
CK [signature]
APPR
APPR
APPR
APPR

DIV CHEVROLET

REF ECR 8644B
NEW 03DE79

1981 ALL PASSENGER CARS*

TITLE
MODELS & SYMBOLS
ALL PASSENGER

SPC 0A

SHEET 3

Ch X B X O X P X Ca

QUANTITY

Quantity when shown, represents full amount per vehicle for usage indicated.

Quantity of staples represents number required per part.

Quantity of lubes, sealer and miscellaneous bulk items is shown at point of application whenever a measurable amount can practically be determined.

MISCELLANEOUS SHIPPING LIST

Pertains to loose items shipped with vehicle from assembly plants - itemized in "0c".

BELT TENSION

All belt tension specifications are shown in "6Z".

CRITICAL APPEARANCE SCREWS

Screws at certain attaching areas are considered to be major appearance items. Damage to the recess or hexagon head requires removal and replacement of screws since this causes early corrosion failure of plating.

MEASUREMENT SYSTEM

Measurement values in the PDM's are shown in either the Metric or English system. The Metric system uses Metric terms and values unless otherwise specified. Dimensions are in millimeters (m.m). The English system uses English standard units of measurement unless otherwise specified and the exception of torques. All torques are shown in newton-meters (N.m). See lead introduction sheet for identification of system used in this manual.

FLUID CARRYING PIPES

Pipes carrying fluids such as gasoline, oil, brake fluid, etc. must be free of all inclusions prior to installation.

CLEARANCE DIMENSIONS

Dimensions shown are **nominal** unless otherwise specified.

LUBRICANT GREASE

Lubrication operations on all affected parts (e.g. swivels, rods, bushings, bolts or shafts) must be accomplished prior to sub-assembly, except for items incorporating lubrication fittings.

MICROINCAPSULATED BOLT

Microincapsulated bolts are not to be reused.

IDENTIFICATION

A color coding, finish coating or other distinguishing feature of a part is shown selectively when it is determined critical and necessary for identification purposes.

INSTALLATION

All fasteners are to be installed in the direction shown unless an optional direction is specified.

The torque symbol is shown adjacent to the fastener to be driven. The mating threaded fastener must not turn during the application of the specified torque.

METHODS OF INSPECTING TORQUE

There are currently two basic methods of inspecting torque in the assembly plant. These two methods are explained more fully below but, in general, they involve the use of a hand torque wrench of a torque transducer. The two methods do not necessarily produce torque measurements which correlate. However, in cases where no dynamic installation torque range is specified and torque control is to be based on a torque transducer, the power tool should be controlled so that a hand checking torque measurement is within the specified limits.

Hand Checking Torque: The Hand Checking Torque is the torque measured immediately after tightening using a hand torque wrench. Hand checking torque measurements are taken on the same fastener as was tightened. Thus, when the nut is tightened on the assembly line, hand checking torque measurements are to be taken on the nut. The mating fastener must not turn while hand checking torque measurements are being made. In making a hand checking torque measurement, the torque wrench is to be pulled in a smooth, uniform motion in the tightening direction and the maximum torque value occurring in the first few degrees of fastener rotation is the value recorded as the hand checking torque.

Dynamic Installation Torque: Dynamic Installation Torque is the torque occurring during the actual tightening of the fastener and is always measured using a torque transducer. The torque transducer used to measure the dynamic installation torque may be a portable, "add-on" unit or may be internal within the power tool. Torque transducers cannot be used with impact tools.

Residual Checking Torque: In some instances, the design of the joint or the characteristics of the materials to be clamped cause a very rapid drop in the torque remaining on a fastener after installation. In these cases, a minimum residual checking torque will be specified.

Check for Stripped Threads-(May not apply to soft joints made up of soft materials such as gaskets, rubber, etc.) Stripped threads may be checked by using a hand torque wrench and applying torque in a tightening direction. If the torque remains at the same level or drops off, the fastener is stripped; however, if strippage is not present, the torque will increase at a uniform rate.

REPAIR TORQUE

The nominal specified torque shall be used for repair line installation.

POWER TOOL USAGE

It is recommended that prevailing torque nuts and bolts be driven with an air stall tool with a free speed slower than 350 RPM. This will prevent possible galling or damage to the locking feature.

It is recommended that self drilling screws to be driven with an air stall tool with a free speed of 1800 to 3000 RPM. Operator pressure should not exceed 265 newtons force because it will inhibit drilling efficiency.

STAPLING

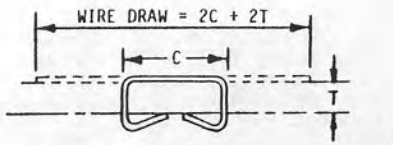


FIGURE 1

C = CROWN SIZE

T = THICKNESS OF WORK

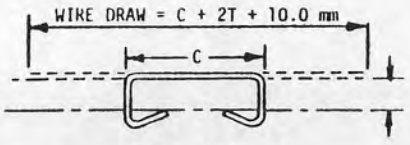
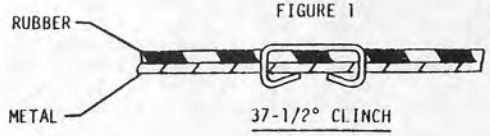
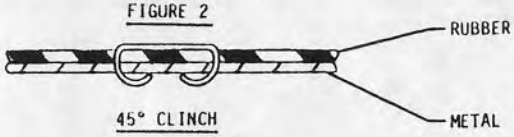


FIGURE 2



37-1/2° CLINCH



45° CLINCH



FLAT CLINCH



37-1/2° CLINCH SHOWN - 45° & FLAT CLINCH TYPICAL

NOTE Staples must not be countersunk in the rubber more than twice the diameter of the staple wire to avoid tearing rubber.

In order to insure quality stitching it is essential that the wire draw (amount of wire fed for each stitch) be the correct length for the work to be stitched. The length of the wire draw is dependent upon the crown size of the staple to be used and the thickness of the work to be stitched.

As a general rule, stitches having a crown width size within the range of 4.0 mm through 12.7 mm should have sufficient wire draw so that the clinched legs of the staple just about meet. (See Fig. 1). For stitches in this range of crown sizes the correct length of wire draw would be: twice the crown size plus twice the thickness of work to be stitched or, when reduced to a formula: Wire Draw = 2C + 2T.

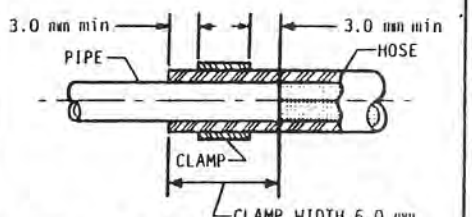
For example: If crown size of stitch is 12.0 mm and the thickness of work to be stitched is 4.0 mm, 2 times 12.0 mm (or 24.0 mm) plus 2 times 4.0 mm (or 8.0 mm), equals 32.0 mm wire draw.

Stitches having crown sizes greater than 12.7 mm should have sufficient wire draw so that each clinched leg of the staple is 5.0 mm in length. (See Fig. 2). For stitches in this range of crown sizes the correct wire draw would be: crown size plus twice the thickness of work to be stitched plus 10.0 mm, or when reduced to a formula: Wire Draw: C + 2T + 10.0 mm.

For example: If crown size of stitch is - 28.0 mm and the thickness of work to be stitched is 12.0 mm, the correct wire draw would be 28.0 mm, plus 2 times 12.0 mm, (or 24.0 mm), plus 10.0 mm, equals 62.0 mm wire draw.

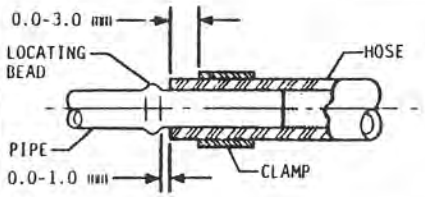
The above formulas do not take into consideration the type of material to be stitched. Some materials might require staple leg lengths different than those shown in Figs. 1 & 2. However, as a general rule the formula given in Fig. 1 can be used for stitches having crown size within the range of 4.0 mm through 12.7 mm, while the formula given in Fig. 2 can be used for stitches having crown sizes greater than 12.7 mm.

METHOD A



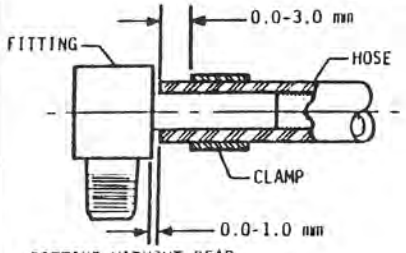
PIPE WITH NO BEADS

METHOD D



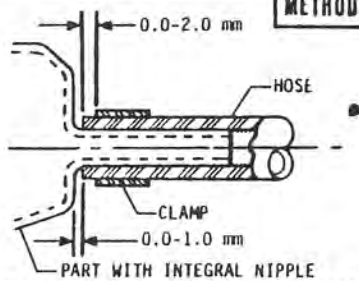
STRAIGHT PIPE WITH LOCATING BEAD

METHOD G



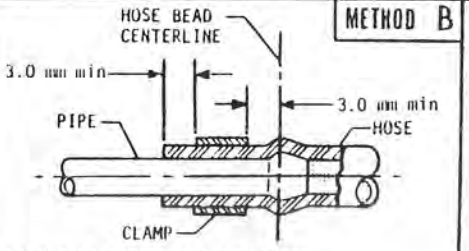
FITTING WITHOUT BEAD

METHOD K



INTEGRAL PART SHORT NIPPLE WITHOUT BEAD

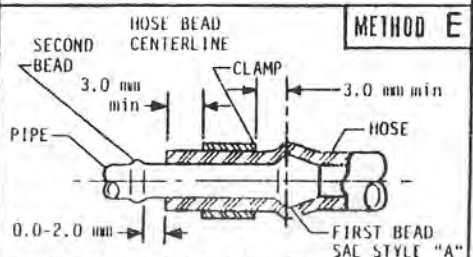
METHOD B



SINGLE BEAD PIPE SAE STYLE "A"

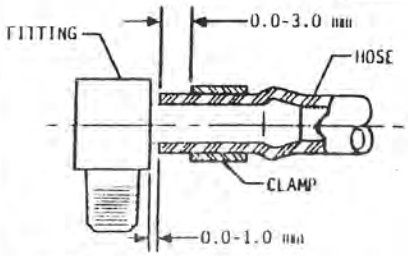
APPLIES TO ALL SIZES OF PIPES, HOSES & CLAMPS.

METHOD E



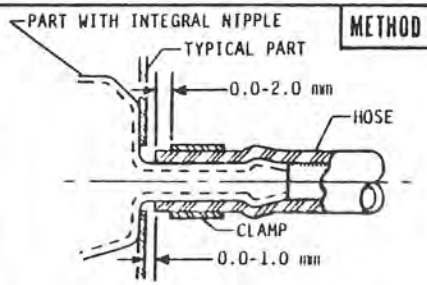
DOUBLE BEAD PIPE SAE STYLE "A"

METHOD H



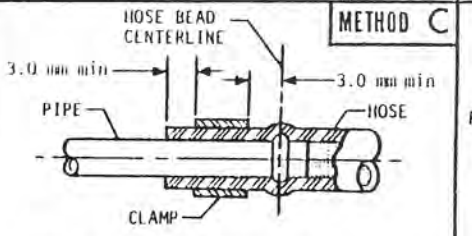
FITTING WITH BEAD

METHOD L



INTEGRAL SHORT NIPPLE WITH BEAD THRU A PART

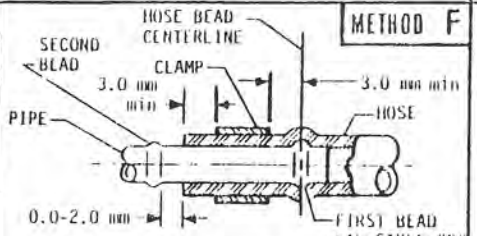
METHOD C



SINGLE BEAD PIPE SAE STYLE "B"

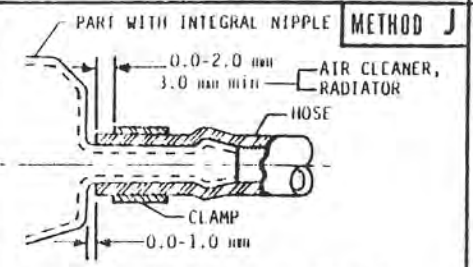
APPLIES TO ALL SIZES OF PIPES, HOSES & CLAMPS.

METHOD F



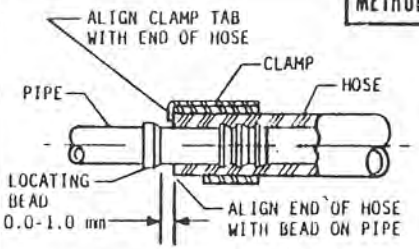
DOUBLE BEAD PIPE SAE STYLE "B"

METHOD J



INTEGRAL PART SHORT NIPPLE WITH BEAD

METHOD M



HOSE BARB PIPE WITH TAB CLAMP

1981 CHEVROLET "A" 14020865*
1981 CHEVROLET "B" 14020866
1981 CHEVROLET "F" 14020867
1981 CHEVROLET "H" 14020868
1981 CHEVROLET "T" 14020869
1981 CHEVROLET "X" 14020871
1981 CHEVROLET "Y" 14020870
1981 TRUCK "C-K" 14020862
1981 TRUCK "G" 14020863
1981 TRUCK "P" 14020864

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG

DATE
DR E. MORENCY
APPD
APPD
APPD
APPD

DIV CHEVROLET

1981 ALL VEHICLES*

TITLE
HOSE CLAMPING INSTRUCTIONS
ALL VEHICLES

ALT ECR 86448
C/O 1980/9
0A-/

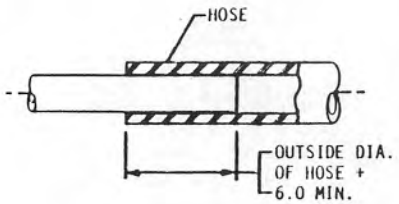
UPC 0A

SHEET 7

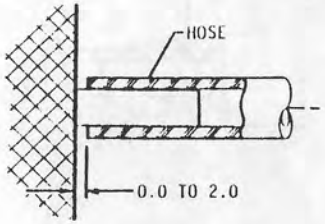
13

Ck B O P Ca

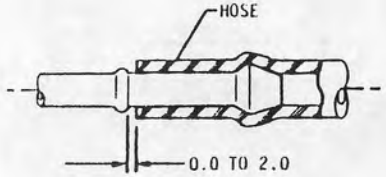
METHOD A



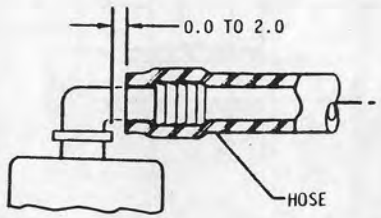
METHOD D



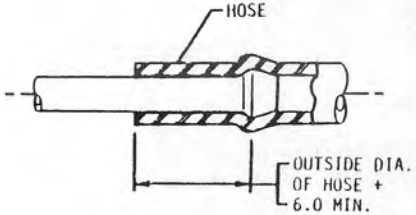
METHOD G



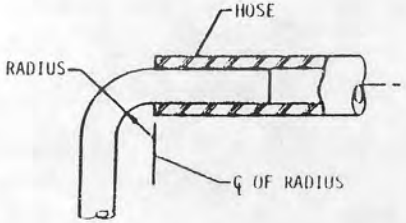
METHOD K



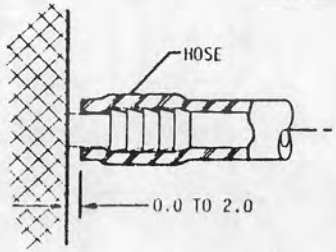
METHOD B



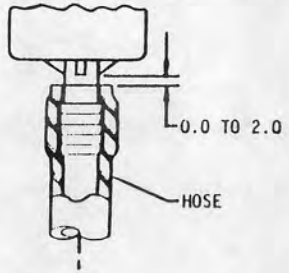
METHOD E



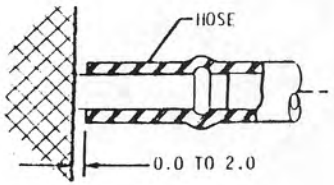
METHOD H



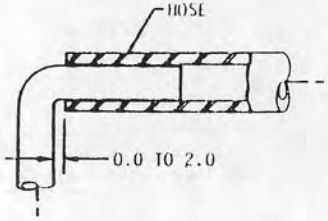
METHOD L



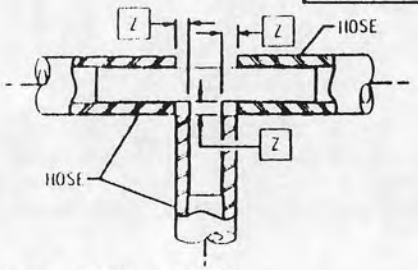
METHOD C



METHOD F



METHOD J



Z 0.0 TO WALL THICKNESS OF HOSE

METHOD M

1981 CHEVROLET "A" 14020865*	DATE	SYM	REVISION	AUTH	DR	CK	ACM ENG	DATE 3-30-81
1981 CHEVROLET "B" 14020866								DR L. MORENCY
1981 CHEVROLET "F" 14020867								
1981 CHEVROLET "H" 14020868								APPR
1981 CHEVROLET "J" 14020869								APPR
1981 CHEVROLET "X" 14020871								
1981 CHEVROLET "Y" 14020870								APPR
1981 TRUCK "C-K" 14020862								
1981 TRUCK "G" 14020863			14					APPR
1981 TRUCK "P" 14020864								

Ck ☒ B ☒ D ☒ P ☒ Ca ☒

DIV CHEVROLET

1981 ALL VEHICLES*

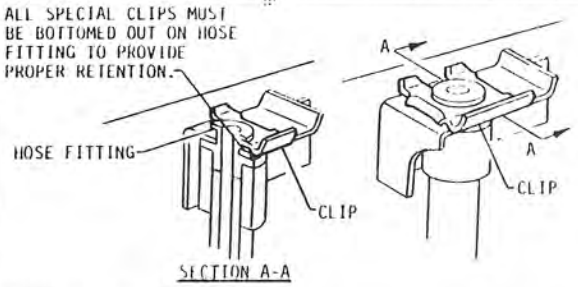
TITLE HOSE INSTALLATION INSTRUCTIONS (WITHOUT CLAMPS) ALL VEHICLES

REF ECR 80448 C/O 19N079 0A-8 -

UPC 0A

SHEET 8

ALL SPECIAL CLIPS MUST BE BOTTOMED OUT ON HOSE FITTING TO PROVIDE PROPER RETENTION.

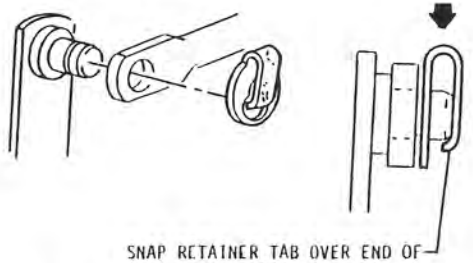


SPRING YOKE BRAKE CLIP



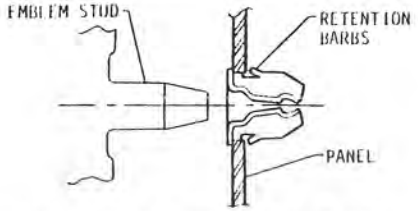
RETAINER MUST BE INSTALLED AS SHOWN.

RETAINER



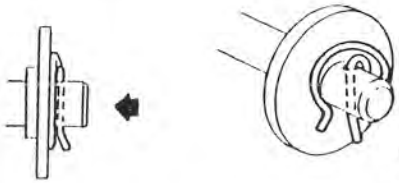
SNAP RETAINER TAB OVER END OF STUD IN DIRECTION OF ARROW.

RETAINER



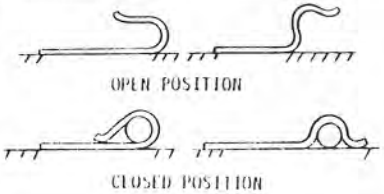
INSTALL TUBULAR CLIP IN HOLE IN PANEL SO THAT RETENTION BARBS ARE ENGAGED ON BACK OF PANEL, THEN PUSH STUD INTO CLIP UNTIL BACK OF EMBLEM CONTACTS PANEL.

TUBULAR CLIP



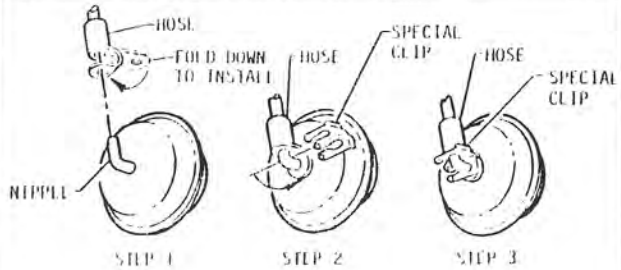
RETAINER MUST BE INSTALLED AS SHOWN TO PROVIDE END LOAD IN DIRECTION OR ARROW.

RETAINER



ALL NON-HARDENED STEEL CLIPS ARE TO BE CLINCHED CLOSED AFTER WIRES, TUBES OR BOWDEN CABLES ARE INSTALLED.

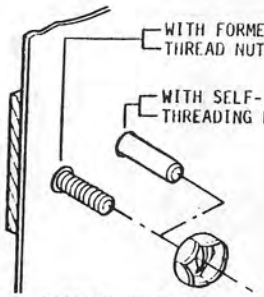
CLIP CLINCHING



SPECIAL CLIP

1981 CHEVROLET "A" 14020865*	DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG	DATE	DIV	1981 ALL VEHICLES*
1981 CHEVROLET "B" 14020866								EMERGENCY		
1981 CHEVROLET "I" 14020867										
1981 CHEVROLET "N" 14020868								APPR	CHEVROLET	TITLE RETAINER INSTRUCTIONS ALL VEHICLES
1981 CHEVROLET "T" 14020869								APPR		
1981 CHEVROLET "X" 14020871								APPR		
1981 CHEVROLET "Y" 14020870								APPR		
1981 TRUCK "C-K" 14020862									REF ECR 86448 C/O 19N079 0A-9	UPC 0A SHEET 9
1981 TRUCK "G" 14020863										
1981 TRUCK "P" 14020864			15							

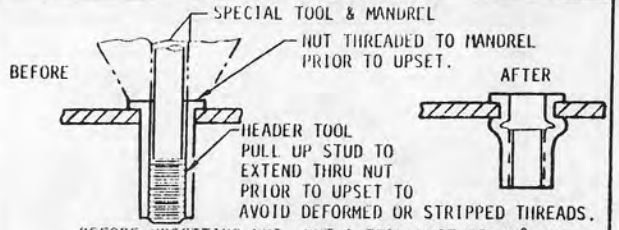
Ch ☒ B ☒ O ☒ P ☒ Cu ☒



ASSEMBLE WITH OPEN SIDE AWAY FROM STUD

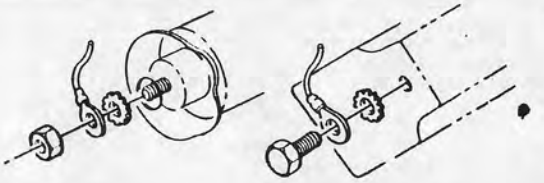
CAUTION If nut is assembled with open end toward stud it will strip mating stud before proper installation torque is obtained.

REGULAR TYPE STAMPED NUT



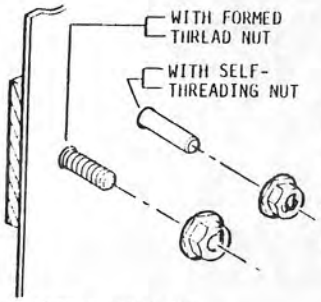
BEFORE UPSETTING NUT, NUT & TOOL MUST BE 90° TO MATING SURFACE AND HELD FLUSH AGAINST THAT SURFACE DURING UPSETTING. NUT MUST NOT ROTATE AFTER INSTALLATION.

SPECIAL NUT BLIND HOLES (RIVNUT OR JACK NUT TYPE)



LOCK WASHERS MUST BE POSITIONED AS SHOWN TO INSURE A PROPER GROUND.

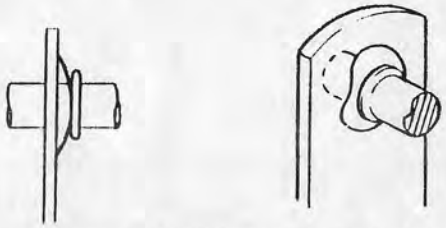
LOCK WASHER



ASSEMBLE WITH OPEN SIDE TOWARD STUD

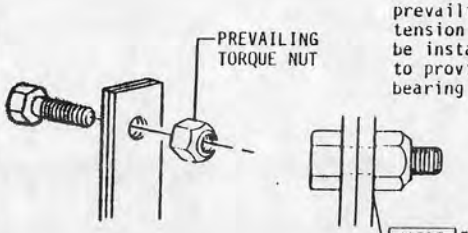
CAUTION If nut is assembled with open end away from stud it will strip mating stud before proper installation torque is obtained.

WASHER TYPE STAMPED NUT



MUST BE INSTALLED AS SHOWN TO FUNCTION PROPERLY

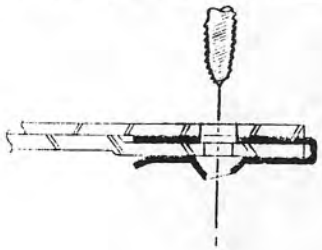
SPRING OR WAVE WASHERS



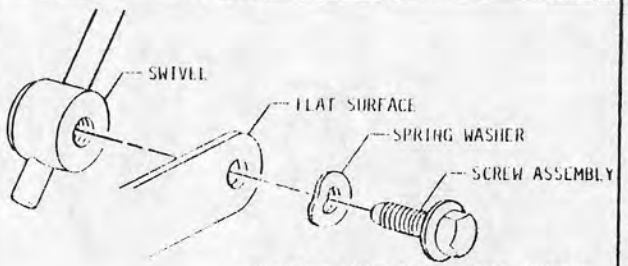
All metal directional prevailing torque-tension hex nuts must be installed as shown to provide proper bearing surface.

NOTE Flat surface is the bearing surface.

PREVAILING TORQUE NUT



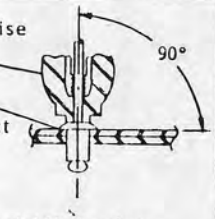
U-NUTS & J NUTS



INSTALL SPRING WASHER WITH CONCAVE SIDE AGAINST FLAT SURFACE TO PROVIDE PROPER TENSION.

SPRING WASHER

Riveter Tool and Blind Rivet must be perpendicular to panel unless otherwise specified when Rivet is upset.



Underside of Blind Rivet Head must be flush to panel for complete 360° contact with panel before setting the Rivet.

Hole that is drilled at assembly must be drilled using a drill fixture and the hole size must be controlled to the dimensions shown in the respective installation view. Holes must also be perpendicular to panel surface unless otherwise specified.

BLIND RIVET PART INSTALLATION

1981 CHEVROLET "A"	14020865 *		
1981 CHEVROLET "B"	14020866		
1981 CHEVROLET "I"	14020867		
1981 CHEVROLET "N"	14020868		
1981 CHEVROLET "T"	14020869		
1981 CHEVROLET "X"	14020871		
1981 CHEVROLET "Y"	14020870		
1981 TRUCK "C-K"	14020862		
1981 TRUCK "G"	14020863		
1981 TRUCK "P"	14020864		

DATE	SYM	REVISION

AUTH	DR	CK	DATE
			EMERGENCY
			APPR
			APPR
			APPR

DIV CHEVROLET

1981 ALL VEHICLES*

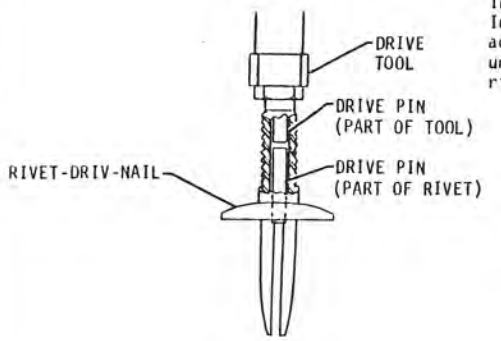
TITLE RETAINER INSTRUCTIONS ALL VEHICLES

ALT LCR 86348 C/O 19N079 0A-10

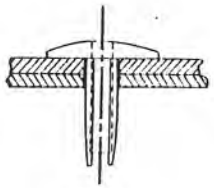
UPC 0A

SHEET 10

Ch B O P Ca



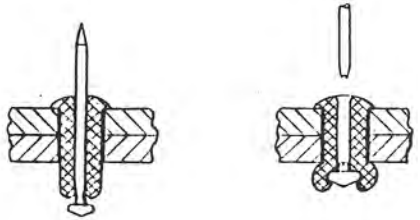
Install rivet into drive tool nose piece. Insert rivet thru panels as shown and actuate tool driving rivet pin into rivet until the pin is flush with top of the rivet head.



BEFORE AFTER

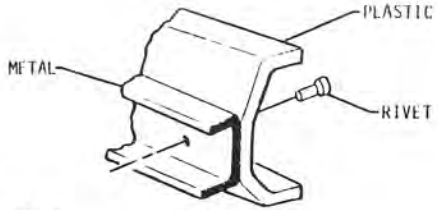
RIVET - DRIV-NAIL

MATERIALS TO BE FASTENED MUST BE HELD TOGETHER BEFORE FASTENING RIVET.



BEFORE AFTER

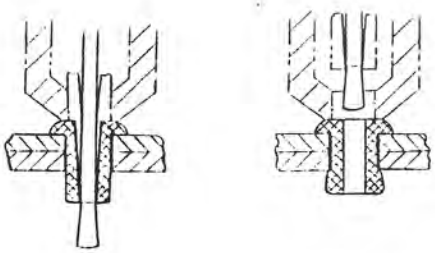
TYPE P DOME HEAD BLIND RIVETS (OPEN OR CLOSED)



Rivet attachment between plastic & metal must be upset on metal side.

RIVET

MATERIALS TO BE FASTENED MUST BE HELD TOGETHER BEFORE FASTENING RIVET.



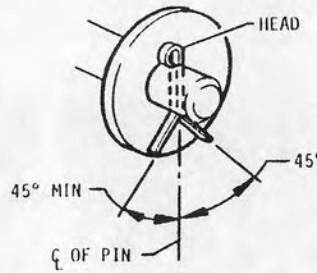
BEFORE AFTER

TYPE D DOME HEAD BLIND RIVETS (OPEN)

1981 CHEVROLET "A" 14020865*	DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG	DATE	DIV	1981 ALL VEHICLES*	
1981 CHEVROLET "D" 14020866								DR EMERGENCY	CHEVROLET	TITLE RETAINER INSTRUCTIONS ALL VEHICLES	
1981 CHEVROLET "E" 14020867								CK			
1981 CHEVROLET "H" 14020868								APPR			
1981 CHEVROLET "I" 14020869								APPR			
1981 CHEVROLET "X" 14020871								APPR			
1981 CHEVROLET "Y" 14020870								APPR			
1981 TRUCK "C-K" 14020862									REF ECR 8644B C/O 19N079 DA-11		UPC 0A SHEET 11
1981 TRUCK "G" 14020863											
1981 TRUCK "P" 14020864											

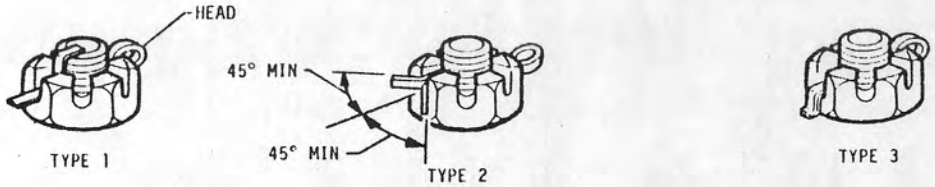
17

Ch ☒ B ☒ O ☒ P ☒ Ca ☒



COTTER PINS

COTTER PINS USED IN THIS TYPE APPLICATION MUST BE SECURED BY SPREADING EACH LEG AWAY FROM CENTERLINE OF THE PIN NOT LESS THAN 45° WITH HEAD OF PIN SHOULDERED ON STUD.



(1) TYPES 1, 2, & 3 ARE OPTIONAL INSTALLATIONS. AFTER REACHING TORQUE REQUIRED, INSTALL COTTER PIN. IF SLOT IN NUT IS NOT ALIGNED WITH PIN HOLE, NUT MUST ALWAYS BE TIGHTENED (UP TO 1/6 TURN) FURTHER, NEVER BACK-OFF, TO INSERT COTTER PIN. INSTALL COTTER PIN TIGHTLY INTO NUT SLOT WITH HEAD OF PIN SHOULDERED AND BEND ONE OR BOTH LEGS AS SHOWN ABOVE.

COTTER PINS WITH CASTELLATED NUTS

1981 CHEVROLET "A" 14020865*	DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG	DATE 05-01	DIV	1981 ALL VEHICLES*
1981 CHEVROLET "B" 14020866	11/0/80	1	NOTE REVISED (EE-1432)	88945	ADI	[illegible]		DR L. MORENCY	CHEVROLET	TITLE RETAINER INSTRUCTIONS ALL VEHICLES
1981 CHEVROLET "F" 14020867								CK [illegible]		
1981 CHEVROLET "H" 14020868								APPR		
1981 CHEVROLET "T" 14020869								APPR		
1981 CHEVROLET "X" 14020871								APPR		
1981 CHEVROLET "Y" 14020870								APPR		
1981 TRUCK "C-K" 14020862									REF ECR 86448 C/O 19N079 0A-12	UPC 0A SHEET 12
1981 TRUCK "G" 14020863										
1981 TRUCK "P" 14020864										

18

Ch B O P Co

INFORMATION ALERT

Many aluminum components have been incorporated in these models. Aluminum in contact with steel may corrode rapidly if not protected by means of a special finish or isolator.

Assembly Plants are hereby advised to avoid substitution of otherwise similar fasteners in locations where the fasteners coated with GM 6173-M or GM 6174-M are specified to provide improved fastener corrosion protection.

GM 6173-M is a Zinc organic finish. (Usually Silver in color).

GM 6174-M is a Phosphate and Paint Finish. (Usually Black in color).

INSTALLATION AND TESTING OF EMBLEMS AND SCRIPTS

1. BODY AND EMBLEM OR SCRIPT PREPARATION

   A. Clean area of body surface where emblem or scripts are to be applied (maximum of three (3) job lengths prior to emblem or script installation) with a suitable solvent (ISO-PROPYL ALCOHOL 50-50 MIXTURE BY VOLUME WITH WATER, HIGH-FLASH NAPTHA OR EQUIVALENT). Use clean cloth only, change minimum of every two (2) hours.

   B. Dry surface with clean cloth (replace cloth minimum of every two (2) hours). Care should be taken to insure there is no surface re-contamination previous to emblem or script installation.

   C. Emblems or scripts are to be removed from cartons and placed on heat table (adhesive side to heat).

   D. Body and part temperature at time of emblem or scripts application must be 80° F (26° C) minimum or 10° F above the air temperature in the application area, whichever is higher (105° F (40° C) maximum). Part must be uniformly heated (to insure that both body surface and emblem or scripts are free of moisture during installation).

2. EMBLEM OR SCRIPT APPLICATION TO BODY

   A. Load emblem or scripts in fixture and remove protective liner immediately prior to installation in an atmosphere free of obvious contaminants (dirt, dust, adhesive sprays, fibers, etc). Adhesive surface must not be touched or brought in contact with any surface or foreign matter.

   B. Apply the emblem or script to the body surface and clamp to obtain .015 in. (.38 mm) minimum compression of foam tape for bonding, maintaining the temperature and cleanliness requirements as previously described. SEE VIEW A.

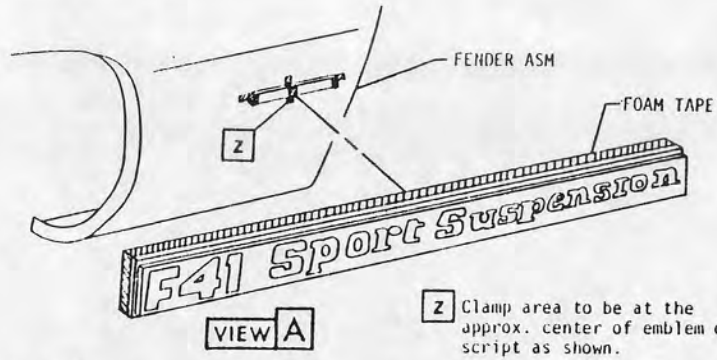
3. ADHESIVE TEST REQUIREMENT

   A. Emblems or scripts shall not exhibit any evidence of bond failure when subjected to a force of 35 pounds (155 newtons) applied normal to emblem mounting surface as shown in View A.

      Emblem or script to be conducted at an ambient temperature, not to exceed 90° F (32° C) and after a minimum of two (2) hours aging.

   B. Emblem or script must be uniformly bonded for entire length.

NOTE Any section of emblem or script removed after once in contact with the body surface must not be reused. See data drawing #1740857 for approved repair procedure.



VIEW A

Z Clamp area to be at the approx. center of emblem or script as shown.

NOTE The cleaning and drying operation may be eliminated where facilities permit installation of emblems and scripts immediately following paint ovens and the surface temperature complies with Item 1-E.

1981 CHEVROLET "A" 14020865 *	DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG	DATE 6/1/80	DIV	1981 ALL VEHICLES*
1981 CHEVROLET "B" 14020866								DR L. MORENCY	CHEVROLET	TITLE ADHESIVE BONDED EMBLEMS & SCRIPTS ALL VEHICLES
1981 CHEVROLET "F" 14020867								CK		
1981 CHEVROLET "H" 14020868								APPR		
1981 CHEVROLET "T" 14020869								APPR		
1981 CHEVROLET "X" 14020871								APPR		
1981 CHEVROLET "Y" 14020870								APPR		
1981 TRUCK "C-K" 14020862									REF ECR 86448 C/O 19N079 0A-14	REF DWG NO. 1725123.
1981 TRUCK "G" 14020863										UPC 0A
1981 TRUCK "P" 14020864			20							SHEET 14

Ch B O P Ca

INSTALLATION PROCEDURE

1. Wipe clean the entire body surface, door hem flange, fender flange, etc. to be covered with a sponge or equivalent dampened with 9981293 Iso-propyl alcohol in a 50-50 mixture, with water, 9981062 (FS1062) high flash Naptha, or equivalent.
2. Wipe cleaned surfaces dry with clean cloth.
3. For large decals or those applied on rubber (non-rigid) surfaces, use the "WET" method of application.
   A. Prior to application of transfer, wet down the complete surface with a solution of 1/4 ounce (7 Grams) of neutral detergent cleaner (must not contain oils, perfumes or bleaches) per one gallon (3.785 liters) of clear water. It is essential that no substitute for this solution be used and that the specified proportions be maintianed.
   B. While the entire area is still wet with solution, remove paper backing from transfer, locate and press on lightly.
   C. Start at center of transfer and squeegee from middle to edges, removing all air bubbles and wetting solution to assure a satisfactory bond. Use Teflon-backed plastic squeegee only. (REF. DI-NOE Company P.A.-1). Do not use thumbs or fingers as adequate pressure can not be applied or maintained.

      The "WET" method must be used on rubber surfaces to reduce the potential of bubble formation under the decal due to out-gassing of the non-rigid material. It may also be used on any decal application to aid in aligning to proper specifications especially under hot, humid conditions.
4. For relatively small decals or narrow stripes on rigid surfaces the "DRY" method is suitable. Follow the general principle outlines in 3B and C, leaving out the wetting solution.
5. Remove the clear protective paper face from the tape stripes pulling it parallel with the stripes. Do not pull the clear protective paper face out at right angle to the stripes because this will tend to lift the stripes off of the job.
6. All wrap-around (fender, door hem, etc.) and truck (fender to valance) areas should be heated to approximately 90° F (32°C) with a heat gun and then re-pressurized as a final operation.
7. The maximum temperature that the tape should be subjected to is 175°F (79°C) (paint repair oven temperature). No tape stripe jobs should be left in a paint repair oven during lunch or between shifts as damage to the tape may occur. (Max temperature of 175 F(79 C) does not apply to paintable premask decals.) Best results are obtained when metal temperature is 70 to 90 F(21 to 32 C). (1)
8. The tape will not be affected by any of the cleaning solvents, waxes, or detergents now being used at the assembly plants. Acrylic lacquer solvents will affect the clear coating over the vinyl.
9. This tape stripe highlights metal imperfections so that all dings and rough metal must be repaired before applying.
10. If after application of stripes, there appears to be bubbles in the surface of the tape stripes, piercing them with an ordinary safety pin will relieve the entrapped air so that the bubble can be smoothed out.

REPAIR:

A. If the tape is damaged.
B. The paint is damaged as the tape is pulled back for realignment or to release trapped air.

The following repair procedure is recommended:

A. If the tape is ruined with no paint being removed, the surface should be wiped with Du Pont Prep-sol to insure a smooth and clean surface, another section of tape would then be applied according to the application procedure.
B. If a section of paint is removed when the tape is pulled away, the area must be repainted and feathered into the adjoining surfaces. Another section of tape should be applied according to the application procedure.

I. Body and decal preparation
   A. Application temperature
      Body surfaces and decals to be maintained between 70° - 100°F (21°-38°C). Auxiliary heat sources to warm body surfaces and decals is required if temperature is below 70°F (21°C). Never apply decals when temperatures are below 60°F (15°C).
   B. Body surface preparation
      1. Surfaces to be smooth and free of paint defects such as pits, rought two-tone paint break lines, etc.
      2. Thoroughly clean body surface areas where decals are to be applied with a suitable solvent (9981293 Iso-propyl alcohol) 50 - 50 mixture by volume with water, 9981062 high flash Naptha, or equivalent). Use clean cloth.
      3. Dry surfaces with clean cloth. Do not allow surface re-contamination prior to decal installation.
   C. Decal preparation - liner (backing paper) removal
      1. Special instructions
         Some decals require a special technique for removal of backing paper. If a special technique is required it will be described on backside of decal or decal container packaging. Follow these instructions.
      2. Remove protective liner paper by sharply bending corner edge of decal toward front face of decal by flicking with fingernail. The sharp bend at corner will cause the paper backing to break away from the decal and carrier paper materials. Always remove the backing from the decal - never the decal from the paper backing.

Continued

	DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
1981 CHEVROLET "A" 14020865*	20MAR	1	NOTE REVISED (EC-3104)	[illegible]	ADI	[illegible]	
1981 CHEVROLET "B" 14020866							
1981 CHEVROLET "F" 14020867							
1981 CHEVROLET "H" 14020868							
1981 CHEVROLET "I" 14020869							
1981 CHEVROLET "X" 14020871							
1981 CHEVROLET "Y" 14020870							
1981 TRUCK "C-K" 14020862							
1981 TRUCK "G" 14020863							
1981 TRUCK "P" 14020864							

DATE 13FEB80
DR J. MALENIC
CK Richard Clarke
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 ALL VEHICLES*

TITLE DECAL APPLICATION PROCEDURE ALL VEHICLES

REF ECR 86448 NEW 11JA80

UPC 0A

SHEET 15

C ☒ D ☒ O ☒ P ☒ Cs ☐

II. Decal application to body
- A. "DRY" application method
  1. The dry application method is suitable for installation of relatively small decals or narrow stripes to rigid body surfaces.
  2. Apply dry decal to surface using techniques noted under general application method below.
- B. "WET" application method
  1. The wet application method is recommended for application of larger decals or wide stripes or stripes on non-rigid surfaces such as soft fascias, bumpers, bumper fillers, etc., to reduce the potential of bubble formation under the decal due to out-gassing of the non-rigid material.
     The wet application is also useful in facilitating decal installation under hot, humid conditions by minimizing film stretch and pre-adhesion.
  2. Prior to proceeding with general application mehtod below thoroughly wet the body surfaces with a solution of 1/4 ounce of neutral detergent cleaner (must not contain oils, perfumes or bleaches) per 1 gallon (3.785 liters) of clean water. Remove backing paper and apply to body while surfaces are wet.
- C. General application method
  1. Major body surfaces - locate the wet or dry decal or stripe to surface as defined on the installation instructions (locate to body openings, flanges, crease lines, tooling aids as dictated by dimensional locations, etc.).
     Lightly tack the decal in place, begin pressuring decal in place with appropriate plastic applicator. Use firm, over-lapping strokes working from the center toward the edges to ensure proper adhesive contact to surface. Thumb or finger pressure is not adequate for proper application.
     Carefully work out all air or water bubbles from under the decal. Bubbles which will not squeeze out should be pierced with a pin to release the water or air and then re-squeezed to ensure adhesive contact.
     Repressure all edges to ensure adhesive contact to surface.
  2. Wrap or flange areas & ends - pressurize decal on to surface, soften with heat, and re-pressuirze.

III. Carrier paper removal & inspection
- A. Remove carrier paper by pulling it back over itself at 180 degree angle. Avoid pulling against the direction of decal features such as points, sharp corners, etc., so as not to pull decal loose from surface. Re-pressurize all decal edges to ensure intimate contact with the adhesive.
- B. Inspect all areas for blisters or bubbles due to trapped air or water. All blisters must be worked out with the squeegee, or pierced with a sharp needle to release the air or water and then re-squeeged to ensure adhesive contact.

IV. Repair
- A. Repair is required if decal or paint is damaged or decal is mis-located. To repair decals, remove existing decal and apply new decal using above listed application procedure.

V. General notes
- A. The maximum temperature that the decals should be subjected to is 175°F (79°C.) (Paint repair oven.) No jobs should be left in repair oven over lunch or between shifts as damage may occur.
- B. The tape will not be affected by any of the cleaning solvents, waxes, or detergents now being used at the assembly plants with the exception of acrylic lacquer solvents.
- C. Shelf life of decals is 90 days at a maximum temperature of 105°F (40°C).

VI. Adhesion test requirement (mandatory for Chev. "B" & "F" vehicles.)
Removal of decal should cause it to be permanently damaged. Test to be conducted at an abient temperature not to exceed 90°F (32°C) and after a minimum of 72 hours aging.

	DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
1981 CHEVROLET "A" 14020865*							
1981 CHEVROLET "B" 14020866							
1981 CHEVROLET "F" 14020867							
1981 CHEVROLET "H" 14020868							
1981 CHEVROLET "T" 14020869							
1981 CHEVROLET "X" 14020871							
1981 CHEVROLET "Y" 14020870							
1981 TRUCK "C-K" 14020862							
1981 TRUCK "G" 14020863							
1981 TRUCK "P" 14020864							

DATE 2FEB80
DR L. MALONEY
CK [illegible]
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 ALL VEHICLES*

TITLE DECAL APPLICATION PROCEDURE ALL VEHICLES

REF ECR 86448 NEW 11JA80

UPC 0A

SHEET 15.1

C ☒ B ☒ O ☒ P ☒ Ca ☐

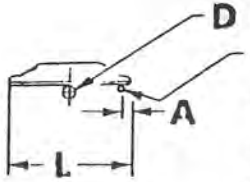
INSTALLATION & TESTING OF URETHANE & HOT METAL MOLDINGS

I. PREPARATION
- A. Body Preparation - non required
- B. Molding Preparation
  1. Apply urethane (9981815) and hot metal (9981816) to primed undersurface of molding (9081800 primer-applied to moldings at hardware plant)
  2. Quantity of urethane is determined by cross section size of molding - See chart for bead size.
  3. Urethane coverage after IID below - Must cover 65% of the area between the hot metal beads and terminate no less than 6.4 mm from end of part.
  4. Hot metal bead diameter is 1.6 mm for all section sizes.

II. MOLDING APPLICATION TO BODY
- A. Molding assemblies that incorporate spear ends are to be bent to insure flatness of spear end. Bent spear ends must be allowed to recover to a flat position prior to installation.
- B. Apply the moldings to the body surface using the specified assembly fixture.
- C. Moldings to be tack rolled to the body for entire length. Roller pressure to be 44.0 N (min).
- D. Final roller application - One (1) pass at 31.0 to 53.0 N when measured at the roller contact point within three (3) job lengths of the application.
- E. In all installation systems, particular attention to rolling of the molding ends is required. (Picture frames, spears, etc.)

III. ADHESION TEST REQUIREMENTS
- A. Performance check on hot-melt 9981816 (uncured urethane) - Molding assemblies shall not exhibit any evidence of failure when subjected to 45.0 N (min) pull force directed 90° to the body panel surface, and at a pull rate of 63.0 mm plus or minus 13.0 mm per minute. (See F.B.T.M. 45-91 for specific location and clamp design information.) Molding tests to be conducted at an ambient temperature, not to exceed 90° F and after a minimum of two (2) hours aging.
- B. Visual check for presence of urethane 9981815 (uncured urethane) - The ends of each molding assembly are to be subjected to a pull force sufficient to cause ultimate failure of bond. Bond area is to be visually inspected for the presence of urethane residue on both molding and body surface. Molding test to be conducted at temperature and time as stated above in IIIA.
- C. Performance check of urethane 9981815 (cured urethane) - Molding assemblies shall not exhibit any evidence of failure when subjected to a pull force of 270.0 N (min) and at a pull rate and location as specified in paragraph IIIA. Molding test to be conducted at an ambient temperature and after a minimum of seventy-two (72) hours aging.

IV. GENERAL BODY CLEAN-UP - PRIOR TO OR AFTER MOLDING INSTALLATION
- A. Body clean-up must be restricted to 9981062 high flash naptha (use of 9981293 isopropyl alcohol is strictly forbidden when urethane is present.)



D DIA. URETHANE BEAD

1.6 DIA. HOT MELT BEAD

IF L LESS THAN 25.4, THEN A = 2.25 + 1.0 - 0.0

IF L EQUAL TO OR GREATER THAN 25.4,

THEN A = 2.25 + 1.5 - 0.0

L DIMENSION				URETHANE MIN. DIA. D	
INCHES		MILLIMETERS			
FROM	TO	FROM	TO	INCHES	MM's
.600	.690	15.25	17.5	.078	2.0
.691	.830	17.6	21.1	.090	2.3
.831	1.160	21.2	29.5	.120	3.0
1.170	1.530	29.7	38.9	.160	4.0

INSTALLATION AND TESTING OF BUTYL ADHESIVE BONDED MOLDINGS

I. BODY AND MOLDING PREPARATION

A. Clean area of body surface where moldings are to be applied (maximum of three (3) job lengths prior to molding installation) with a suitable solvent (9981293 isopropyl alcohol 50-50 mixture by volume with water, 9981062 flash naptha or equivalent). Use clean cloth - change minimum of every two (2) hours.

D. Dry surface with clean cloth (replace cloth minimum of every two (2) hours). Care should be taken to insure there is no surface re-contamination previous to molding installation.

C. Molding assemblies are to be removed from cartons and placed on heat table. (Adhesive side to heat.)

D. Heat table temperature must be 65-75° F (18-24° C). If plant ambient temperature is above this range, moldings are to be installed at ambient temperature.

E. Body temperature at time of molding application must be 80° F (26° C) minimum or 10° above the air temperature in the application area, whichever is higher - 105° F (40° C) maximum. (To insure that both molding and body surface are free of moisture during installation.)

II. MOLDING APPLICATION TO BODY

A. Remove protective liner from warm moldings immediately prior to installation in an atmosphere free of obvious contaminants (dirt, dust, adhesive sprays, fibers, etc). Adhesive surface must not be touched or brought in contact with any surface or foreign matter.

B. Apply the moldings to the body surface using the specified assembly fixture and maintaining the temperature and cleanliness requirements as previously described.

C. Moldings to be "tack" rolled to the body for entire length (roller pressure 3 to 10 lbs (13.4 to 44.5 N) - moldings and body must be at the specified temperature.

D. High pressure roller application to have one (1) pass at 20-30 lbs (88.9-177.8 N) when measured at the roller and molding contact point immediately after tack roll while molding and body are at specified temperatures.

E. In all installation systems particular attention to rolling of the molding ends is required. (Picture frames, spears, etc.)

NOTE: The adhesive bonded molding is not to overlap the door edge guard, door edge, lock cylinder or body opening on any installation. Moldings must be uniformly bonded for the entire length.

Any section of molding once in contact with any surface must not be reused, except by approved repair procedure (Drawing #3072504).

III. ADHESION TEST REQUIREMENTS

Molding assemblies shall not exhibit any evidence of bond failure when subjected to the following pull forces directed 90° to the body panel surface and at a pull rate of 2-1/2 inches (63.5 mm) plus or minus 1/2 inch (12.7 mm) per minute. (See F.B.T.M. 45-91 for specific location and clamp design information. Molding tests to be conducted at an ambient temperature, not to exceed 90° F (32° C) and after a minimum of two (2) hours aging.

The moldings (tape width = 22.9 mm (.90 in.) must meet pull force of 155.8 N (35 lbs) minimum.

INSTALLATION AND TESTING OF ADHESIVE MOLDINGS LESS PROMOTER 9981801

I. BODY AND MOLDING PREPARATION

A. Clean area of body surface where moldings are to be applied (maximum of three job lengths prior to molding installation) with a suitable solvent (9981293 isopropyl alcohol 50-50 mixture by volume with water, 9981062 high flash naptha or equivalent). Use clean cloth - change minimum of every two (2) hours.
B. Dry surface with clean cloth (replace cloth minimum of every two (2) hours). Care should be taken to insure there is no surface recontamination previous to molding installation.
C. Molding assemblies are to be removed from cartons and placed on heat table. Heat table temperature range to be 65° F to 80° F (18° C to 27° C).
D. Moldings are to be installed at ambient temperature. (If plant ambient temperature exceeds C - above, moldings are to be installed at plant ambient.)
E. Body temperature at time of molding application must be 80° F (27° C) minimum or 10° F above the air temperature in the application area, whichever is higher (105° F (40° C) maximum). (To insure that both moldings and body surface are free of moisture during installation.)

II. MOLDING APPLICATION TO BODY

A. Remove protective liner from moldings immediately prior to installation in an atmosphere free of obvious contaminants (dirt, dust, adhesive sprays, fibers, etc). Adhesive surface must not be touched or brought in contact with any surface or foreign matter.
B. Apply adhesive 9981744 droplets to each end of molding. (See PDM Sheets for droplet size and location.)
C. Apply the moldings to the body surface using the specified assembly fixture and maintaining the temperature and cleanliness requirements as previously described.

1. APPLICATION OF MOLDING USING ROLLER TYPE ASSEMBLY FIXTURE:

A. Moldings to be "Tack" rolled to the body for entire length (Roller Pressure 3 to 10 pounds (13.4 to 44.5 N). Moldings and body must be at the specified temperature.
B. High pressure roller applications to have two passes as specified below:
   a) First roll immediately after tack roll while molding and body are at specified temperatures. Roll pressure to be 20 lbs (88.9 N) minimum when measured at the roller and molding contact point.
   b) Second roll to be a power roller located within two (2) car lengths from the first roller application. Roll pressure to be 40 lbs (177.8 N) minimum when measured at the roller and molding contact point.

2. APPLICATION OF MOLDING USING SHELF AND CAPSULE TYPE ASSEMBLY FIXTURE:

A. Moldings to be hand applied to body for entire length. Moldings and body must be at the specified temperature.
B. Moldings to be "Tack" rolled to the body immediately upon installation, while molding and body are at specified temperature. "Tack" roller pressure to be 20 lbs (88.9 N) minimum.
C. Moldings to have a high pressure roll. One pass (minimum at 40 lbs (177.8 N) when measured at the roller and molding contact point. High pressure power roller to be within two (2) car lengths from first "Tack" roll application.
D. In all installation systems, particular attention to rolling of the molding ends is required. (Picture frames, spears, etc.)

III. ADHESION TEST REQUIREMENTS

Molding assemblies shall not exhibit any evidence of bond failure when subjected to the following pull forces directed 90° to the body panel surface and at a pull rate of 2-1/2 inches (63.5 mm) plus or minus 1/2 inch (12.7 mm) per minute. (See F.B.T.M. 45-91 for specific location and clamp design information.) Molding tests to be conducted at an ambient temperature, not to exceed 90° F (32° C) and after a minimum of twenty-four (24) hours aging.

A. Moldings with tape widths from 0.43 inches (10.9 mm) to 0.72 inches (18.3 mm) wide must meet pull force values of 45 lbs (200.2 N) minimum.
B. Moldings with tape widths of 0.73 inches (18.5 mm) and greater must meet pull force values of 70 lbs (311.4 N) minimum.

NOTE: The adheisve bonded molding is not to overlap the door edge, door edge guard, lock cylinder, or body opening on and installation. Moldings must be uniformly bonded for the entire length.

Any section of molding once in contact with any surface must not be used except for approved repair procedure (Data - Drawing #1725048).

For installation and testing of adhesive molding with adhesion promoter - See Data Drawing #3081288

INSTALLATION AND TESTING OF ADHESIVE MOLDINGS WITH PROMOTER 9981801

I. BODY AND MOLDING PREPARATION

A. Clean area of body surface where moldings are to be applied (maximum of three job lengths prior to molding installation) with a suitable solvent (9981293 isopropyl alcohol 50-50 mixture by volume with water, 9981062 high flash naptha or equivalent). Use clean cloth - change minimum of every two (2) hours.
B. Dry surface with clean cloth (replace cloth minimum of every two (2) hours). Care should be taken to insure there is no surface recontamination previous to molding installation.
C. Molding assemblies are to be removed from cartons and placed on work table.
D. Moldings are to be installed at ambient temperature.
E. Body temperature at time of molding application must be 80° F (26° C) minimum or 10° F (6° C) above the air temperature in the application area, whichever is higher (105° F (40° C) maximum). (To insure that both moldings and body surface are free of moisture during installation.)

II. MOLDING APPLICATION TO BODY

A. Remove protective liner from moldings immediately prior to installation in an atmosphere free of obvious contaminants (dirt, dust, adhesive sprays, fibers, etc). Adhesive surface must not be touched or brought in contact with any surface or foreign matter.
B. Apply an even (consistant) wet coating of adhesion promoter #9981801 to full length and width of molding - use applicator tool as specified on O.D. Sheet.
C. The application of adhesion promoter to the tape surface of molding (Step B) and the installation of molding to body (Step D) must not exceed the dry time of the Adhesion Promoter Material #9981801.

IMPORTANT - Dry time is evident when, upon applying a (clean) finger to the tape surface, the finger sticks firmly to the tape. (Approximate dry time: 1-3 minutes depending on ambient temperature and application thickness.)

D. Apply the moldings to the body surface using the specified assembly fixture and maintaining the temperature and cleanliness requirements as previously described.

1. APPLICATION OF MOLDING USING ROLLER TYPE ASSEMBLY FIXTURE:

A. Moldings to be "Tack" rolled to the body for entire length (Roller Pressure 3 to 10 pounds (13.4 to 44.5 N). Moldings and body must be at the specified temperature.
B. High pressure roller applications to have two passes as specified below:
   a) First roll immediately after tack roll while molding and body are at specified temperatures. Roll pressure to be 20 lbs (88.9 N) minimum when measured at the roller and molding contact point.
   b) Second roll to be a power roller located within two (2) car lengths from the first roller application. Roll pressure to be 40 lbs (177.8 N) when measured at the roller and molding contact point.

2. APPLICATION OF MOLDING USING SHELF AND CAPSULE TYPE ASM FIXTURE:

A. Moldings to be hand applied to body for entire length. Moldings and body must be at the specified temperature.
B. Moldings to be "Tack" rolled to the body immediately upon installation, while molding and body are at specified temperature. "Tack" roller pressure to be 20 lbs (88.9 N) minimum.
C. Moldings to have a high pressure roll. One pass (minimum at 40 lbs (177.8 N) when measured at the roller and molding contact point. High pressure power roller to be within two (2) car lengths from first "Tack" roll application.

[NOTE] 1) "Squeeze Out" of excessive adhesion promoter #9981801 in contact with body will cause immediate paint damage.
2) A molding with adhesive promoter #9981801 applied, once in contact with body surface, will result in body paint damage if re-positioned or re-aligned.

D. In all installation systems particular attention to rolling of the molding ends is required. (Picture frames, spears, etc).

III. ADHESION TEST REQUIREMENTS

Molding assemblies shall not exhibit any evidence of bond failure when subjected to the following pull forces directed 90° to the body panel surface and at a pull rate of 2.50 inches (63.5 mm) plus or minus .50 inch (13 mm) per minute. (See F.B.T.M. 45-91 for specific location and clamp design information.) Molding tests to be conducted at an ambient temperature, not to exceed 90° F (32° C) and after a minimum of seventy-two (72) hours aging.

A. Moldings with tape widths from .43 inches (10.9 mm) to .72 inches (18.3 mm) wide must meet pull forces of 45 lbs (200 N) minimum.
B. Moldings with tape widths of .73 inches (18.5 mm) and greater must meet pull force values of 70 lbs (311.4 N) minimum.

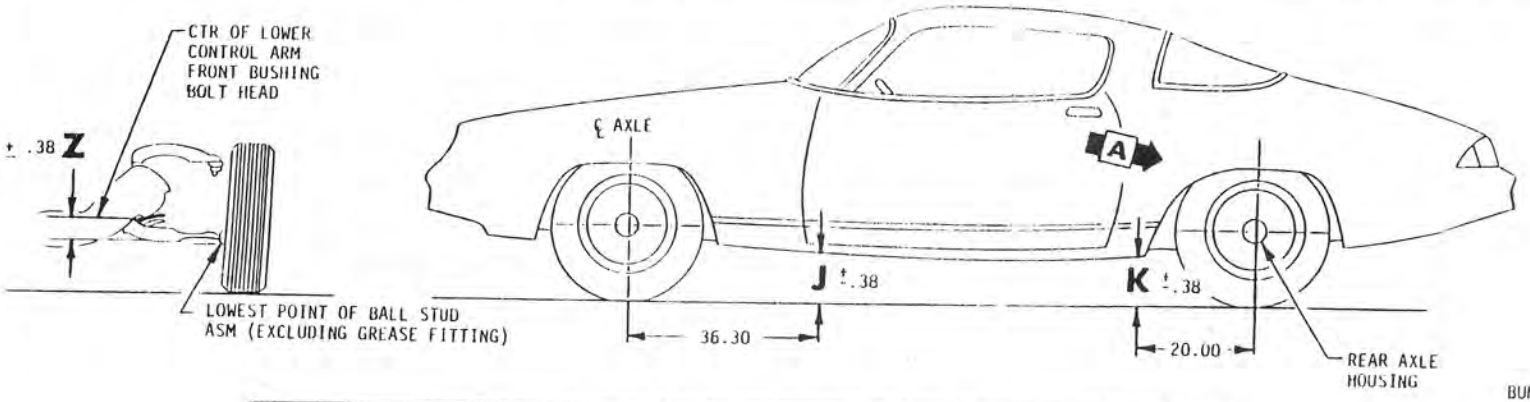
[NOTE] The adhesive bonded molding is not to overlap the door edge, door edge guard, lock cylinder, or body opening on any installation. Moldings must be uniform bonded for the entire length.

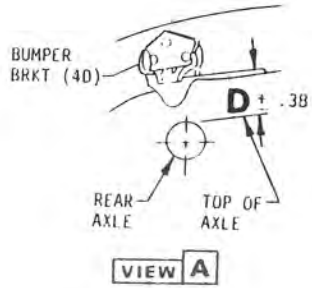
Any section of molding once in contact with any surface must not be used; except by approved repair procedure (Data - Drawing #1725048).

For installation and testing of adhesive moldings without promoter - See Data Drawing #1651142.

1981 CHEVROLET "A" 14020865*	DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG	DATE	DIV	1981 ALL PASSENGER CARS*
1981 CHEVROLET "B" 14020866								DR L. MORENCY		
1981 CHEVROLET "F" 14020867								CK	CHEVROLET	TITLE ADHESIVE MOLDING INSTRUCTION- WITH PROMOTER SOLUTION LACQUER ALL PASSENGER
1981 CHEVROLET "H" 14020868								APPR		
1981 CHEVROLET "T" 14020869								APPR		
1981 CHEVROLET "X" 14020871								APPR		
1981 CHEVROLET "Y" 14020870								APPR	EFF ECR 86448 C/O 19R079 GA-16.1	REF DWG NO. 3081288 / UPC 0A / SHEET 19

CL X B X O X P X Ca X





MODEL	Z		D		J		K	
	SHIPPED	CURB	SHIPPED	CURB	SHIPPED	CURB	SHIPPED	CURB
V8 WITH P205-75 R14	1.98	2.11	5.40	4.78	8.33	8.20	8.37	7.85
ALL WITH P225/70 R15	1.31	1.41	4.52	4.05	8.30	8.20	8.26	7.85
V6 WITH P205-75 R14	1.97	2.11	5.40	4.78	8.32	8.20	8.37	7.85

VEHICLE HEIGHTS

"Z" & "J" DIMENSIONS-Lift front bumper of vehicle up approximately 1.50. Gently remove hands and let vehicle settle on its own. Repeat twice for a total of 3 times. Measure "Z" & "J" dimensions. Push front bumper of vehicle down approximately 1.50. Gently remove hands and let vehicle rise on its own. Repeat twice for a total of 3 times. Measure "Z" and "J" dimensions. True Heights are the average of the high and low measurements.

"D" & "K" DIMENSIONS-Lift rear bumper of vehicle up approximately 1.50. Gently remove hands and let vehicle settle on its own. Repeat twice for a total of 3 times. Measure "D" and "K" dimensions. Push rear bumper of vehicle down approximately 1.50. Gently remove hands and let vehicle rise on its own. Repeat twice for a total of 3 times. Measure "D" and "K" dimensions. True Heights are the average of the high and low measurements.

LOADING CONDITIONS

SHIPPING WEIGHT-Vehicle is built to production parts list specifications including coolant to capacity and three (3) gallons of gasoline.
CURB WEIGHT-Vehicle is built to production parts list specifications including coolant to capacity and full tank of gasoline.

RECOMMENDED TIRE PRESSURE

TRIM HEIGHT AND AUDIT CHECK-Set pressure to agree with vehicles tire pressure sticker for loading "Up to vehicle capacity".

DYNAMIC (Install) N·m	HAND (Insp.) N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG

DATE 11JAS0
DR L MARENCY
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE TRIM HEIGHTS F&00 ALL

REF ECR 86448 NEW 17DE79

UPC 0A

SHEET 20

27

0_B LABEL, PLATE & STICKER LOCATIONS

(3) NOTE See Chart # 14021763, Miscellaneous Literature Functional Usage, for additional information.

			DIV RESP
	OB-1	CONTENTS	D
	OB-2	ENGINE TUNE-UP EMISSION LABEL	D
	OB-3	COMBINED TIRE PRESS. & CERT & CANADIAN SAFETY LABELS	D
	OB-4	COMBINED TIRE PRESS. & CERT PRINTED INFO	C
(1)	OB-4.1	SPECIFICATIONS-PRICE LABEL (U.S.)	O
	OB-5	NOTICE TO BUYER, EPA FUEL ECONOMY-PRICE LABELS	D
	OB-6	EXPORT LABEL INFORMATION VC5	D
	OB-7	EPA FUEL ECONOMY PRINTED INFORMATION	O
	OB-8	CONSIGNMENT UNDER LIMITED CERT LABEL	D
(2)	OB-9	FUEL ECONOMY & PRICE LABEL PRINTED INFORMATION Z49	O
	OB-10	UNLEADED FUEL DECAL	D
	OB-11	AUTO. JACK USAGE LABEL	D

0_C MISCELLANEOUS SHIPPING LIST

		DIV RESP
OC-1	MISCELLANEOUS SHIPPING LIST	D

★ Instructions Carryover
● Waiting Info.

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
JUN80	1	SHEET OB-4.1 ADDED	86448	CMP	MC	
JAN81	2	TITLE REVISED	87121	CMP	CJ	
29OCT80	3	CHART NO ADDED	1K718	ADI		

28

DATE 11-JAN-80
DR [illegible]
CK
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE CONTENTS-LABELS & MISCELLANEOUS SHIPPING FA00 ALL

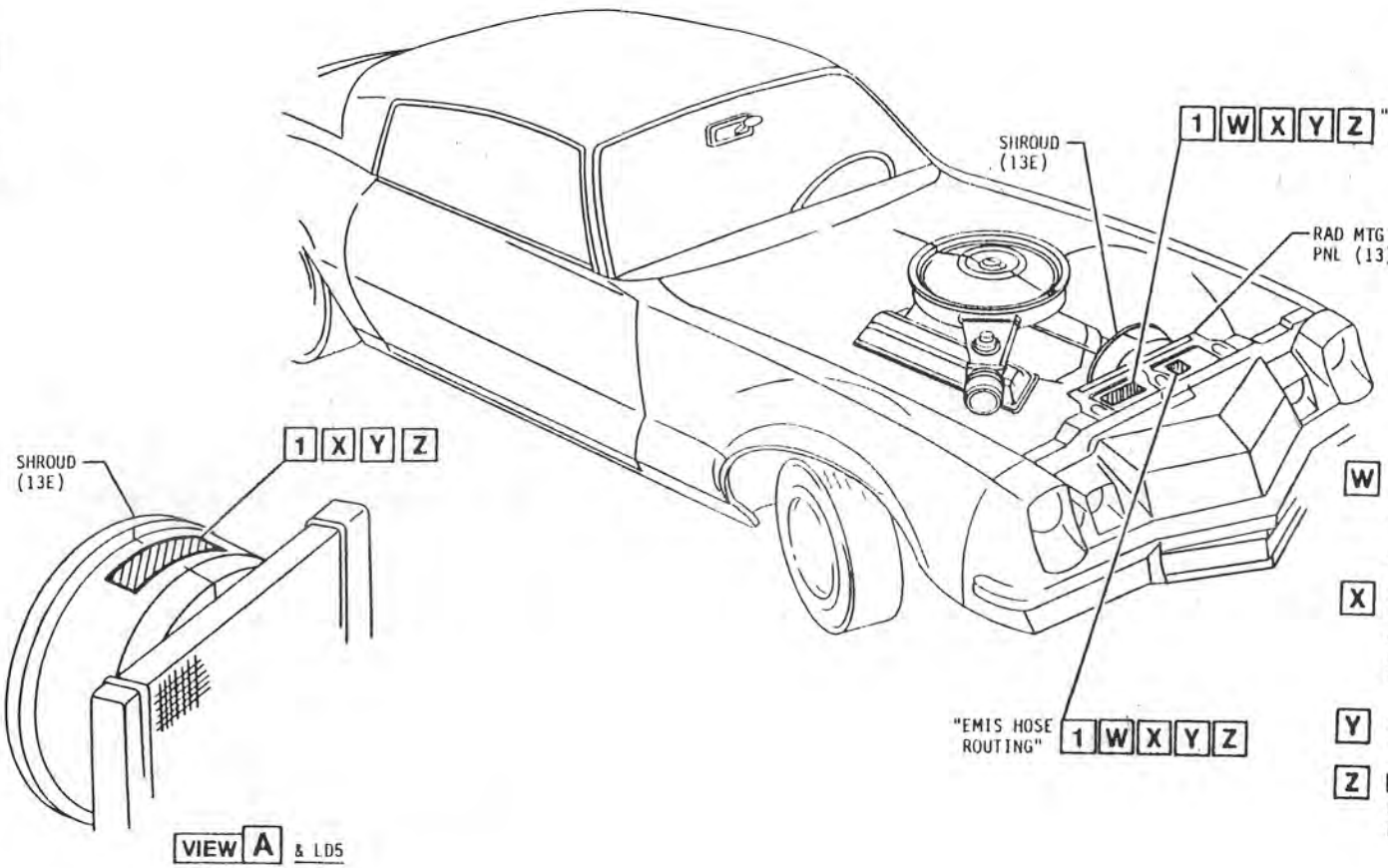
REF ECR 86448 NEW 170C79

UPC OB

SHEET 1

Ch X B O P Ca

14031180 [1] LABEL-VEH EMIS CONT INFO (SHOWN) For specific releasing & additional part numbers, see Parts List.



VIEW A & LD5

[W] Separate Label Asm & position the "Emis Control Info" Label on left side of Rad Mtg Panel. Position "Emis Hose Routing" on right side as shown.

[X] EMISSION STICKER - POSITION MANDATORY - Must be positioned within area as shown. Takes precedence over adjacent Labels or Stickers.

[Y] Position label right side up & readable from outside of vehicle.

[Z] CAUTION This label is required by law & must be on vehicle in position noted when shipped.

DYNAMIC (Instal) N·m	HAND (Insp.) · N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
1 2 3 4 5								
⚠ FULLY DRIVEN, SEATED & NOT STRIPPED				29				

DATE 7-16-80
DR L.MORENCY / GMP
CK
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE ENGINE TUNE-UP EMISSION LABEL FA00 ALL

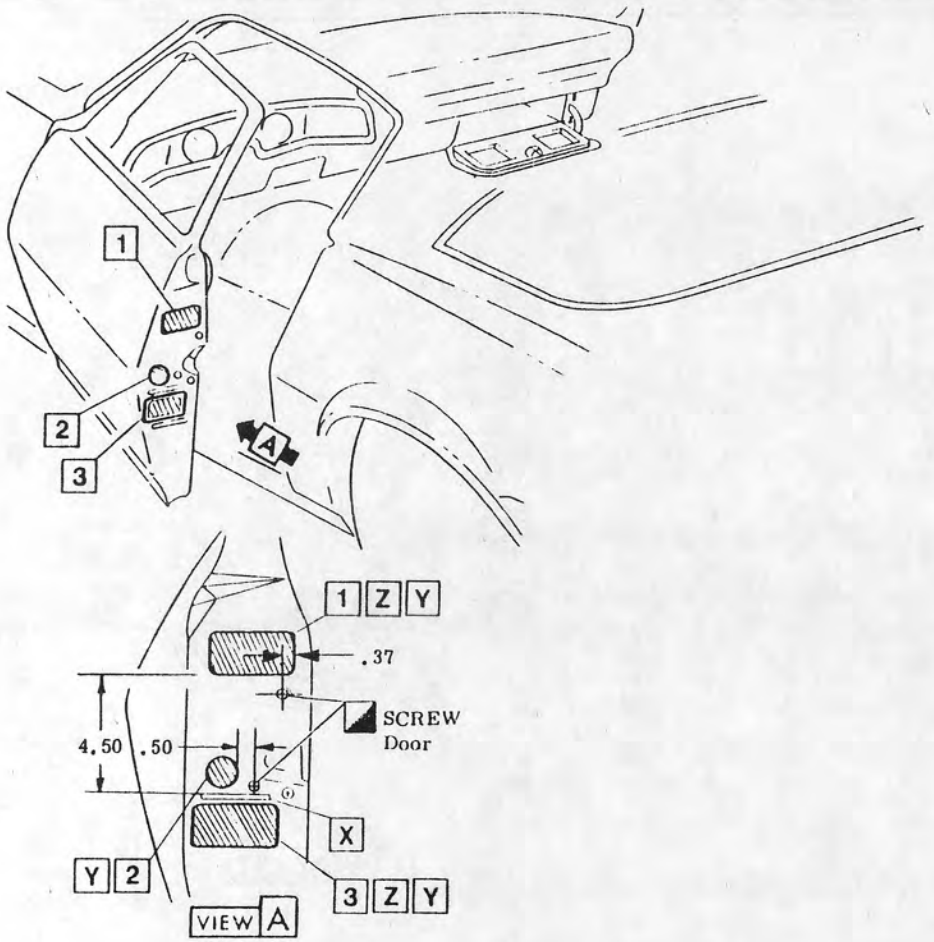
REF ECR 86448 C/O 20FE80 OB-2

L- L- L- L-

UPC 0B

SHEET 2

CK B O P Co



14021726	1	LABEL ASM-CERTIFICATION (EXC V78)
736762	2	LABEL-CANADIAN SAFETY & Z49 (14F)
14021727	3	LABEL ASM-TIRE PRESS

X Locating bead.

Y Attach Label with print in upright position.

Z Refer to combined Tire Press. & Certification Label Instruction sheet for proper nomenclature that must appear on label.

DYNAMIC (Install) N·m	HAND (Insp) N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
				30				

1 2 1 4 5

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE [illegible]
DR L. MORENCY
CK D. FOWLER/G
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

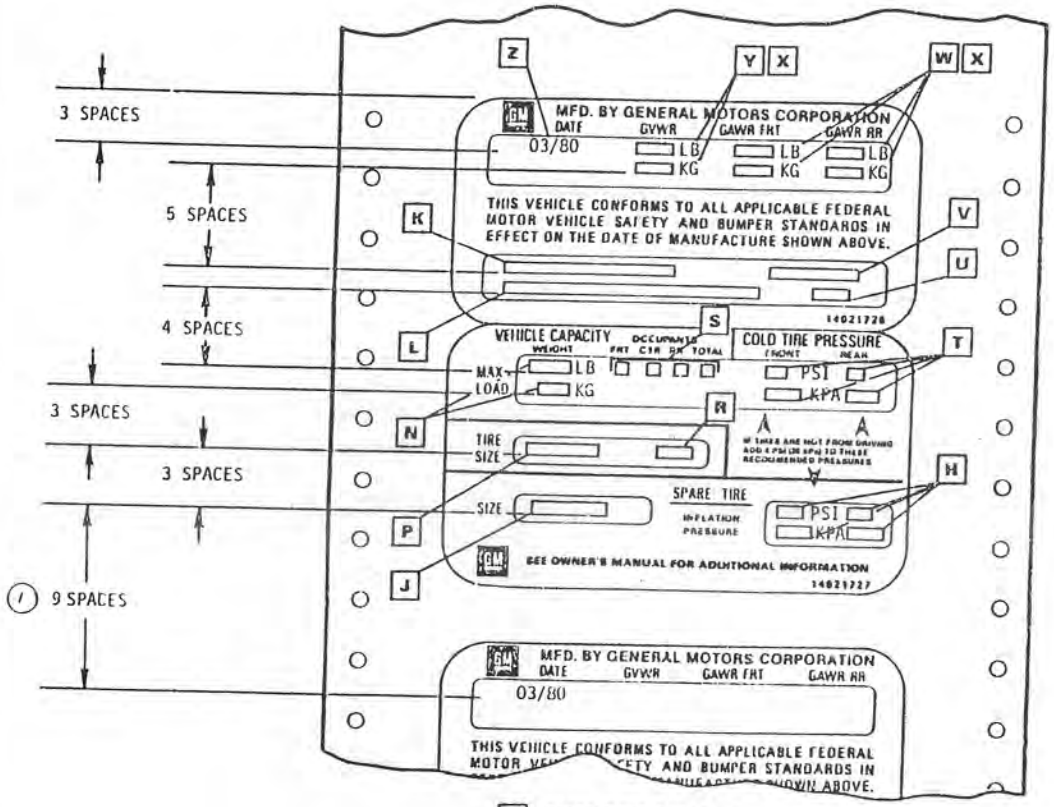
TITLE COMBINED TIRE PRESSURE & CERT & CANADIAN SAFETY LABELS FA00 ALL

REF ECR 86448 C/O 15JA80 08-3 ·

UPC 08

SHEET 3

Ch X B O P Co



H SPARE TIRE PRESSURE

J SIZE OF SPARE TIRE

K VEHICLE IDENTIFICATION NUMBER

ASSEMBLY PLANT INSTRUCTIONS

1. Adjust impact force of teletype or line printer to produce a solid dark imprint. Label may be printed without a machine carbon ribbon, however, carbon ribbon is preferred.
2. Set up a test print pattern of 3 lines with 24 characters each, 4 line spaces (no printing), 2 lines with 24 characters each, 6 line spaces.
3. At the beginning of each length of labels adjust the printers such that the printing is centered in the window areas. All printing must clearly fall within the window area.
4. The beginning of each line of printing the req information (date, GVWR, etc.) should be indexed 1 character space to the right of beginning of test pattern.
5. Letters in block capitals & numerals not less than .10 in. high at asm plant. (11 point type preferred)

L TIRE USAGE INFORMATION

N MAXIMUM VEHICLE CAPACITY WEIGHT

P TIRE SIZE

R TIRE LABEL CODE

S MAXIMUM OCCUPANTS

Y TIRE PRESS. WITH MAXIMUM OCCUPANTS FRT & RR

U SEE CONSUMER INFO CHART FOR ENTRY

V VEH CLASS TYPE: "PASS. CAR" exc for AA80 Type: "TRUCK"

W GROSS AXLE WEIGHT RATING-FRT & RR

X To add GVWR & GAWR information use "AS MANUFACTURED" date from vehicle rating plate instruction, chart or car manifest.

Y GROSS VEHICLE WEIGHT RATING

Z DATE

1981 CHEVROLET "A" 14020865*
1981 CHEVROLET "B" 14020866
1981 CHEVROLET "F" 14020867
1981 CHEVROLET "I" 14020869
1981 CHEVROLET "X" 14020871
1981 CHEVROLET "Y" 14020970

DATE	SYM	REVISION	AUTH	CR	CK	ASM ENG
07MY80	1	WAS 10 SPACES	91405	LM	JJ	

31

DATE 26MR80
CR L. MORENCY
CK Tom Hayes TH
APPR
APPR J. J. Lee
APPR
APPR

DIV CHEVROLET

1981 ALL PASSENGER*

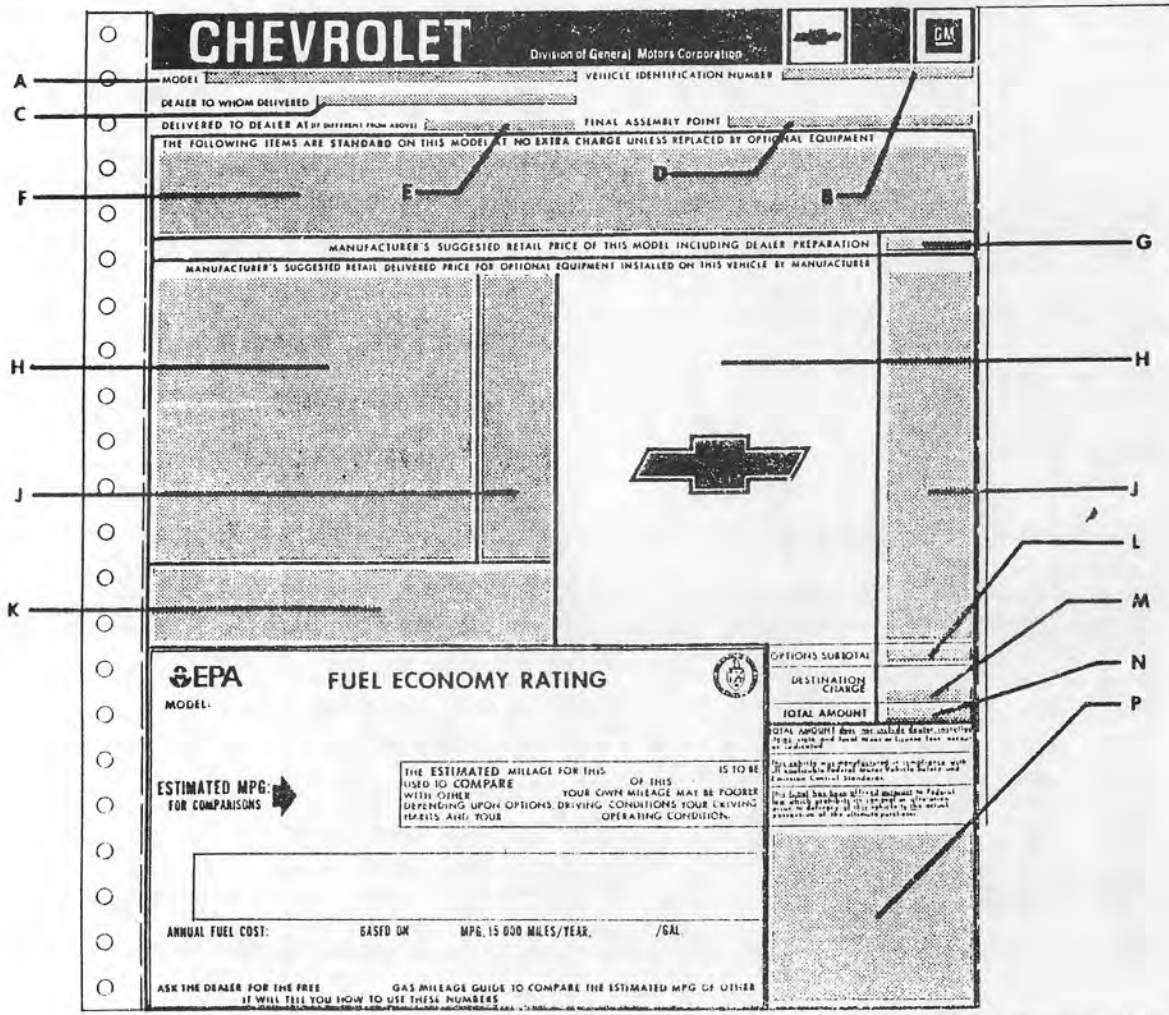
TITLE
COMBINED TIRE PRESS. & CERT, LABEL PRINTED INFO
ALL PASSENGER

REF ECR 86448
NEW 04MR80

UPC 08

SHEET 4

CA ☒ B ☒ D ☒ P ☒ Co ☐



A - YEAR, MODEL, BODY STYLE
B - V.I.N.
C - NAME AND LOCATION
D - ASSEMBLY PLANT NAME
E - NAME AND LOCATION
F - LIST OF NO EXTRA CHARGE ITEMS
G - RETAIL PRICE BEFORE OPTIONS
H - OPTION CODE AND NAME
J - OPTION RETAIL COST
K - ENGINE DISCLOSURE STATEMENT
L - TOTAL OPTIONS COST
M - SHIPPING COST
N - TOTAL COST
P - CALIFORNIA DISCLOSURE STATEMENT (NOT USED BY ALL DIVISIONS)

SEE OB-7 FOR FUEL ECONOMY LABEL CONTENT

1981 CHEVROLET "A" 14020865*
1981 CHEVROLET "H" 14020866
1981 CHEVROLET "F" 14020867
1981 CHEVROLET "T" 14020869
1981 CHEVROLET "X" 14020871
1981 CHEVROLET "Y" 14020870
1981 TRUCK "C-K" 14020862
1981 TRUCK "G" 14020863

DATE	SYM	REVISION	AUTH	DR	LR	ASM ENG
(EARLIER)		ISSUED	80-1-17	[illegible]	[illegible]	

DATE 11JAN80
DR M. JAROUS
APPR [signature]
APPR [signature]
APPR
APPR

DIV CHEVROLET

1981 ALL VEHICLES* (exc "P")

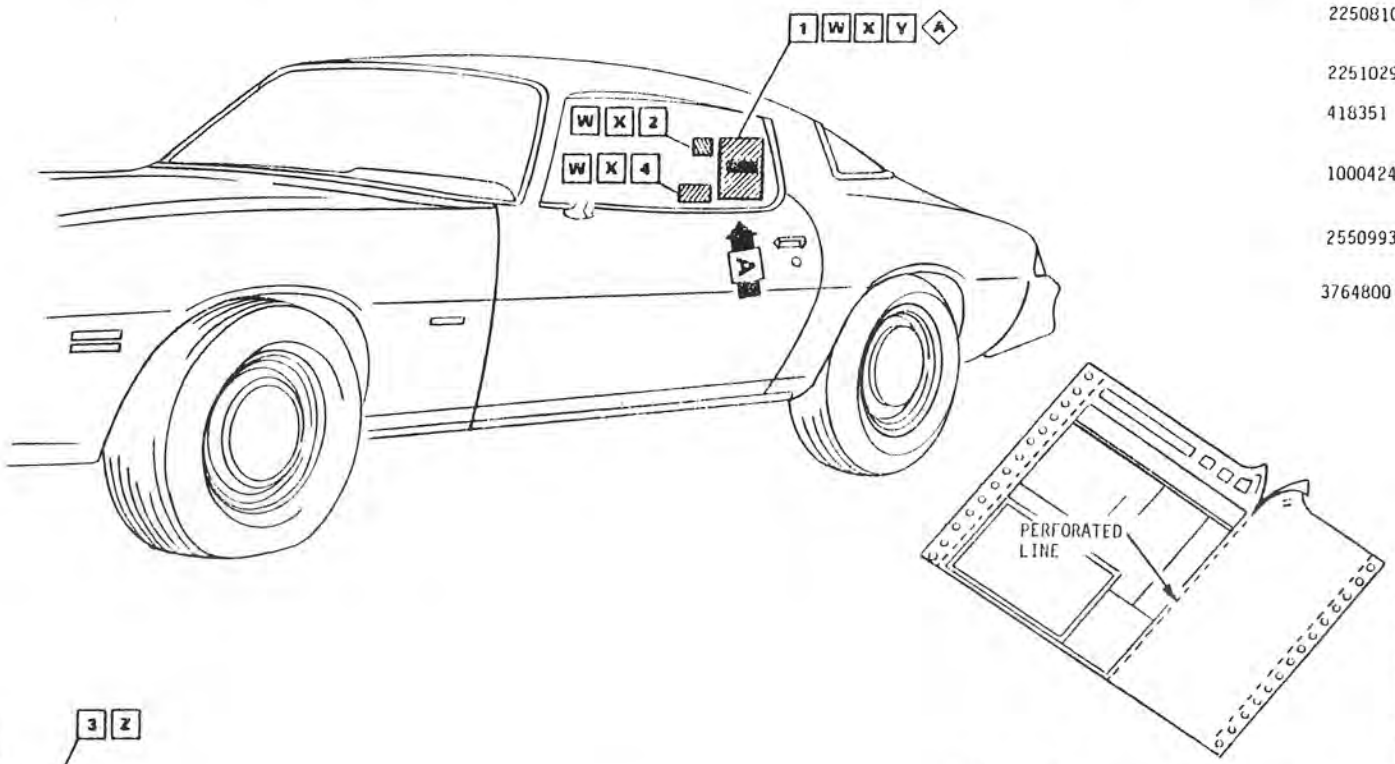
TITLE
SPECIFICATIONS-PRICE LABEL (U.S.)
ALL VEHICLES (exc. "P")

REF ECR 86447
NEW 23FE80
OB-22 LM

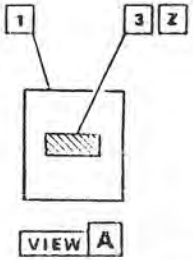
UPC OB

SHEET 4.1

Ch ✓ B ✓ O P ✓ Ca ✓



22508105	1	LABEL-PRICE &FUEL ECONOMY EXC Z49 (14F)
22510295	1	&Z49 (14F)
418351	2	LABEL-NOTICE TO BUYER &NB2 (14F)
10004244	3	LABEL-MILEAGE ACCUMULATION EXC V78/Z49 (14F)
25509931	4	LABEL-CLUTCH TYPE TORQUE &MV4/MX2/MX3/M31 (7)
3764800	A	ADHESIVE .005L (14F)



W Position Label on inside of window, right side up, and readable from outside of vehicle.

X After Label has been affixed to inside of glass, a squeegee should be used to remove all air pockets.

Y Remove RH portion (Dealer Copy) of Label and place in instrument compartment. Affix LH portion to window.

Z Affix Label to back of 1 & readable from inside of vehicle. Chevrolet General Director of Reliability will advise which vehicle will be tested and labeled.

NOTE Window should be in fully raised position before labels are affixed. Location for installation of temporary customer labels (Price & Fuel Economy, and notice to buyer) is LH rear side glass with overflow on driver's glass. Care should be taken to insure label installation is neat and that it does not present unnecessary driver field of view obstruction. Labels should be in close proximity to each other. Although a side post may separate them. They should be as far rearward as possible. Refer to Price or EPA Fuel Economy printed information sheet for proper nomenclature that must appear on label.

DYNAMIC (Install) N·m	HAND (Insp.) N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM LAB
		30NOV	2	REDRAWN & REDESIGNED				

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE 22NOV80
DR L. MONENCY/GMP
CK Richard Chine RC
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE NOTICE TO BUYER, EPA FUEL ECONOMY-PRICE, MILEAGE ACCUM, & TORQUE TRANS LABELS FA00

REF ECR 86448 NEW 21MY80

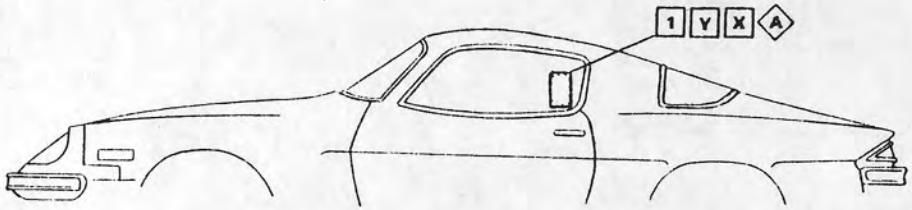
UPC OB

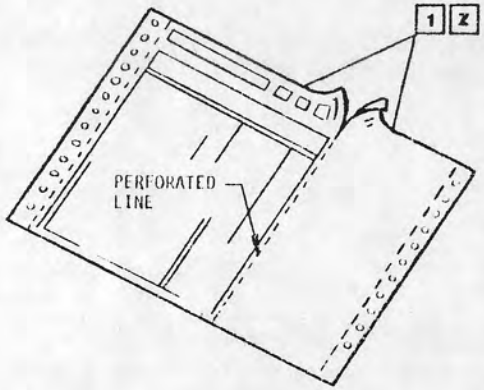
SHEET 5

Ch X B U P Co

22508105 [1] LABEL-PRICE (14F)

(1) 3764800 ◇A ADHESIVE .005L (14F)





[X] Position on inside of window right side up, and readable from outside of vehicle.

[Y] After Label has been affixed to inside of glass, a squeegee should be used to remove all air pockets.

[Z] Remove RH portion (Dealer Copy) of label and place in instrument compartment. Affix LH portion to window.

NOTE Window should be in fully raised position before labels are affixed. Location for installation of temporary customer labels (Price & Fuel Economy, and notice to buyer) is LH rear side glass with overflow on driver's glass. Care should be taken to insure label installation is neat and that it does not present unnecessary obstruction of driver's field of view. Labels should be in close proximity to each other, but as far rearward on driver's window as possible. Refer to Price-Fuel Economy printed information sheet for proper nomenclature that must appear on label.

DYNAMIC (Install) N·m	HAND (Insp.) N·m	DATE	SYM	REVISION	ASSY	DR	CK	ASM CAT
		19JN81	1	QUANTITY WAS .0293C				

DATE 20JN80
DR L. NARENCY
CK H.J. Buck HB
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE EXPORT LABEL INFORMATION FA00 &VC5

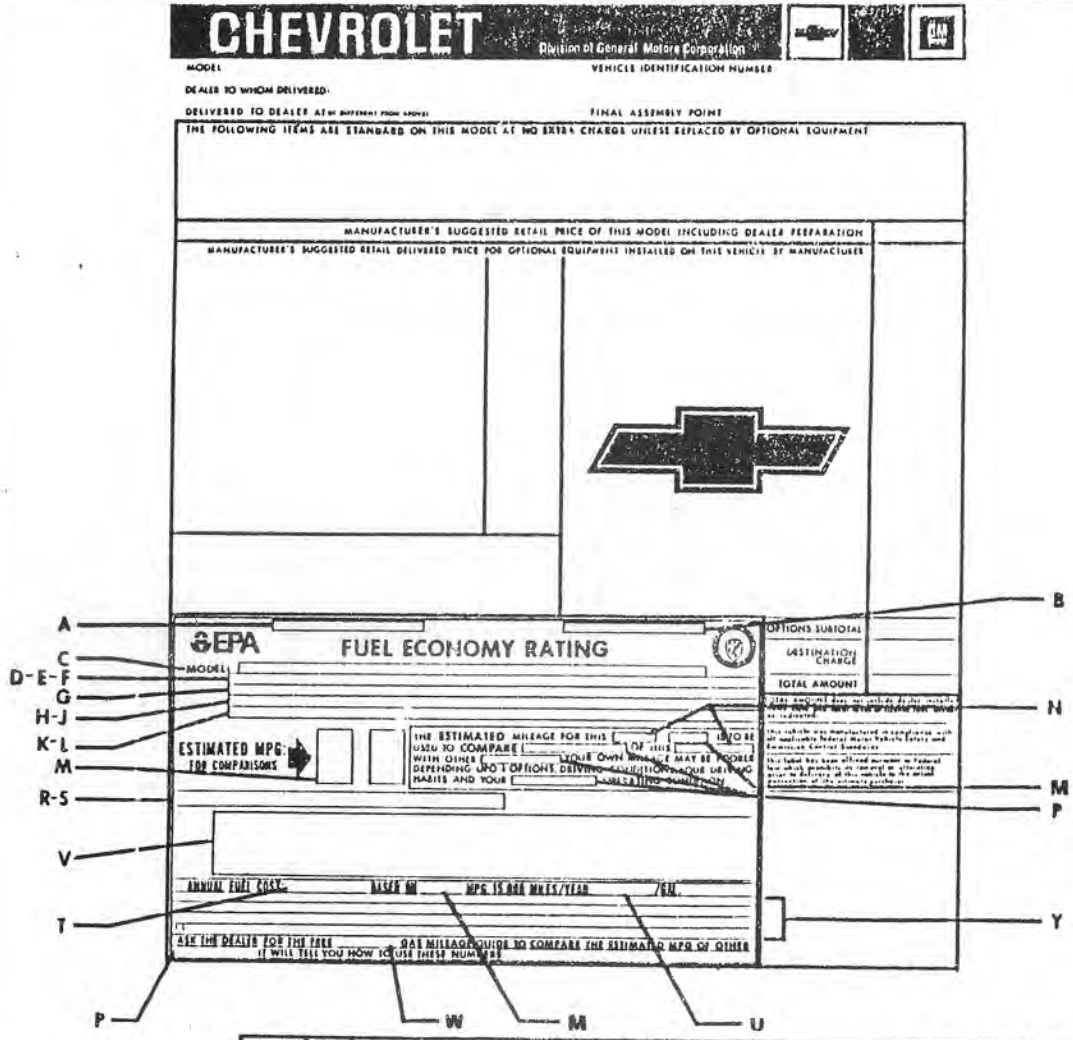
REF ECR 86448 NEW 20JN80

UPC 0B

SHEET 6

1 FULLY DRIVEN, SEATED & NOT STRIPPED

Ch X B O P Co



A - V.I.N.
B - F. E. LABEL CODE
C - MODEL, YEAR, VEHICLE NAME
D - LITER DISPLACEMENT
E - NO. OF CYLINDERS
F - TYPE OF ENGINE
G - ENGINE MANUFACTURING DIVISION
H - TYPE - CARBURETOR
J - TYPE - TRANSMISSION
K - CATALYST
L - CALIF. EMISSION CONTROL SYSTEM
M - AVERAGE MILES PER GALLON
N - TYPE: MODEL
P - TYPE: CARS OR TRUCKS
R - TYPE: OTHER
S - TYPE: CLASS NAME THAT APPLIES (IE: COMPACT)
T - ANNUAL FUEL COST
U - TYPE: $0.80 FOR GAS ENGINES
V - TYPE: A RANGE OF NUMBERS FOR OTHER CAR MODELS OF SIMILAR SIZE WAS NOT AVAILABLE WHEN THIS CAR WAS LABELED.
W - CURRENT YEAR
Y - GAS GUZZLER STATEMENT (IF REQUIRED)

1981 CHEVROLET "A" 14020865*
1981 CHEVROLET "B" 14020866
1981 CHEVROLET "F" 14020867
1981 CHEVROLET "T" 14020869
1981 CHEVROLET "X" 14020871
1981 CHEVROLET "Y" 14020870
1981 TRUCK "C-K" 14020862
1981 TRUCK "G" 14020863

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
09AP80		ISSUED	86448	CMP		

DATE 28NO79
DR N.L. HANSEN
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 ALL VEHICLES* (exc "P")

TITLE
EPA FUEL ECONOMY PRINTED INFORMATION
ALL VEHICLES exc "P" (exc Z49)

REF ECR 86448
NEW 09AP80

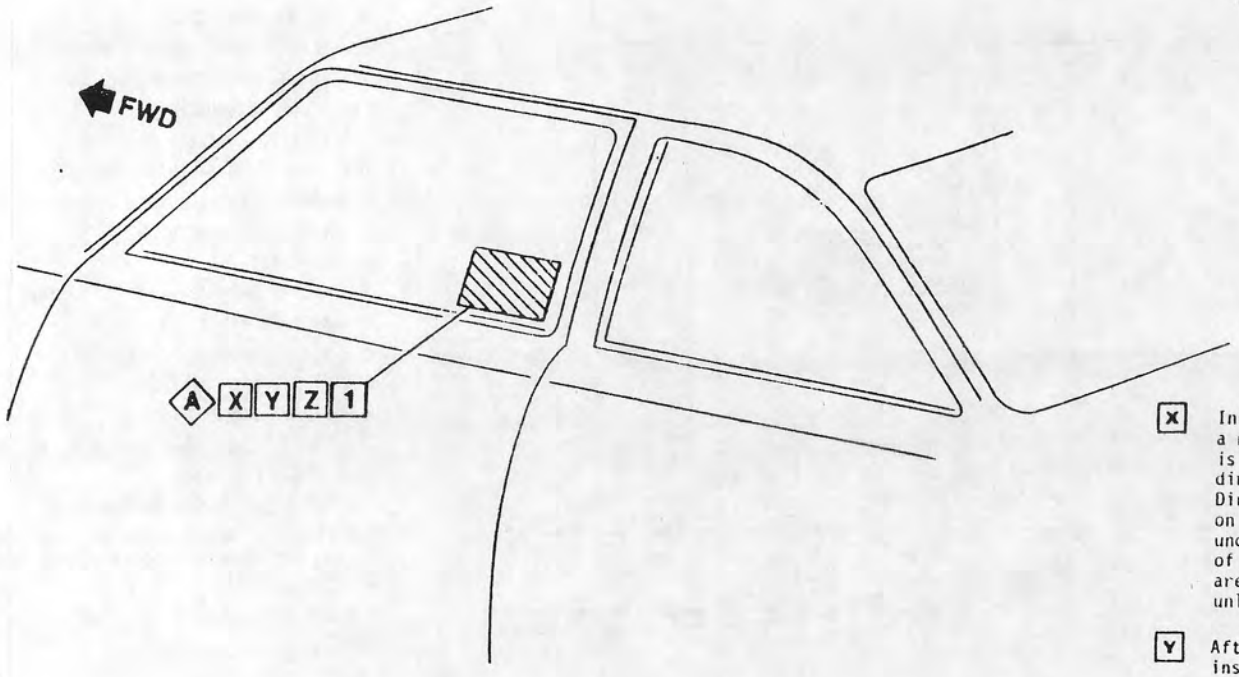
MPC OB

SHEET 7

Ch | | B | | O | | P | | Ca |

14014402 [1] LABEL-CONSIGNMENT UNDER LIMITED CERT & NA5/NA6/NB2

3764800 (A) ADHESIVE .002 L



[X] Installation of this label is not a normal assembly operation. It is to be used only when and if directed by the Chevrolet General Director of Financial Procedure on vehicles that are to be shipped under an EPA limited certificate of conformity. Installation costs are not to be billed to Chevrolet unless label is used.

[Y] After Label has been affixed to inside of glass, a squeegee should be used to remove all air pockets.

[Z] Position Label on inside of window, right side up, and readable from outside of vehicle.

1981 CHEVROLET "A" 14020865*
1981 CHEVROLET "B" 14020866
1981 CHEVROLET "F" 14020867
1981 CHEVROLET "T" 14020869
1981 CHEVROLET "Y" 14020870

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
		36				

DATE 10MAY80
DR L MURENCY
CK
APPR
APPR
APPR
APPR

DIV CHEVROLET

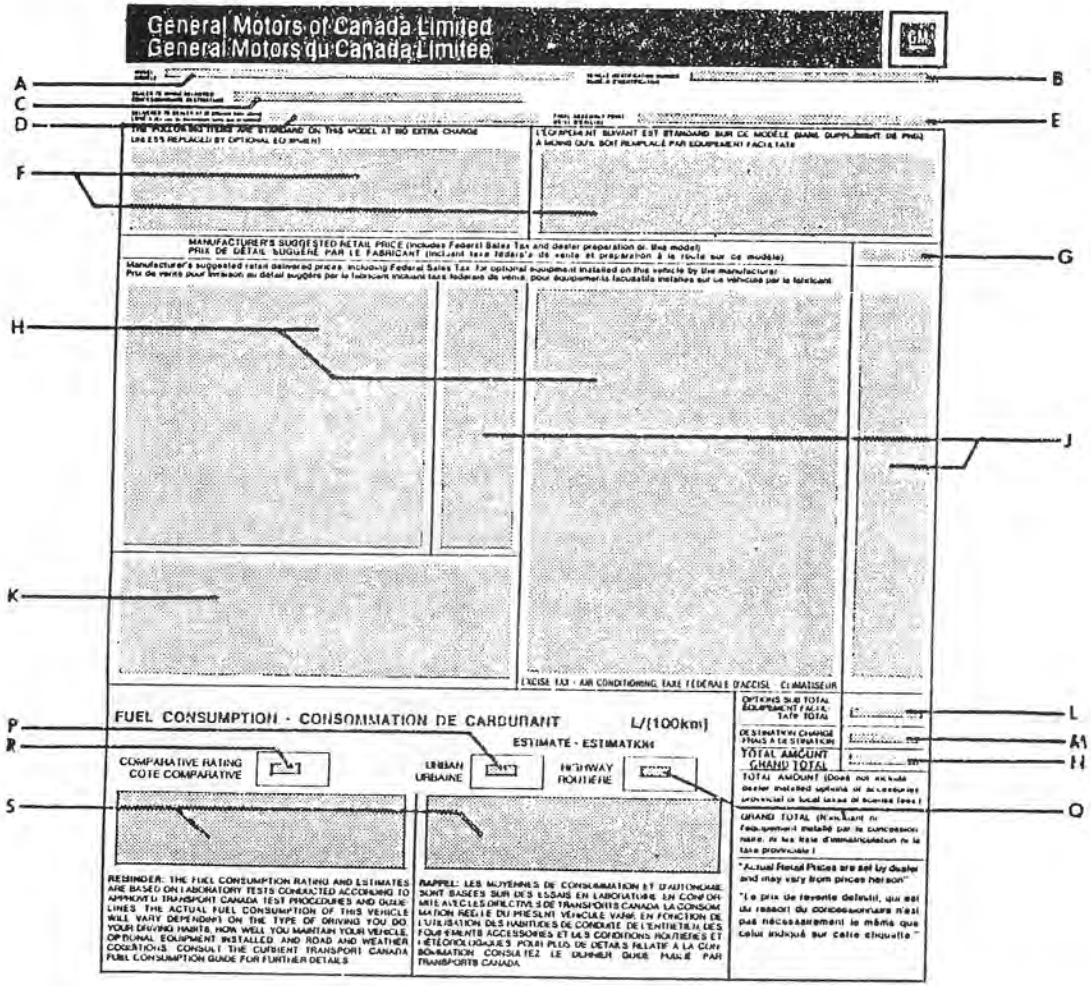
1981 ALL PASS* (exc "X")

TITLE CONSIGNMENT UNDER LIMITED CERT LABEL ALL PASSENGER exc "X"

REF ECR 86448 C/O 15FE80 08-8

UPC 08

SHEET 6



A - MODEL, YEAR AND VEHICLE NAME
B - V.I.N.
C - DEALER TO WHOM DELIVERED
D - DELIVERED TO DEALER(IF DIFFERENT THAN C)
E - FINAL ASSEMBLY POINT
F - STANDARD ITEMS(BI-LINGUAL)
G - MANUFACTURERS SUGGESTED RETAIL PRICE
H - OPTIONS & ACCESSORIES(BI-LINGUAL)
J - SUGGESTED RETAIL DELIVERED PRICES
K - ENGINE DISCLOSURE STATEMENT(BI-LINGUAL)
L - OPTIONS SUB-TOTAL
M - DESTINATION CHARGE
N - TOTAL AMOUNT
P - ESTIMATED CITY MILEAGE
Q - ESTIMATED HIGHWAY MILEAGE
R - ESTIMATED AVERAGE MILEAGE
S - DISPLACEMENT,& NO. OF CYLINDERS
CARBURETOR TYPE
TRANSMISSION TYPE
CATALYST EQUIPPED

1931 CHEVROLET "A" 14020865*
1981 CHEVROLET "B" 14020866
1981 CHEVROLET "F" 14020867
1981 CHEVROLET "T" 14020869
1991 CHEVROLET "X" 14020871
1981 CHEVROLET "Y" 14020870
1981 TRUCK "C-K" 14020862
1991 TRUCK "G" 14020863

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
09MY80		ISSUED	B6448	LM	RH	

DATE 24-APR-80
DR R. Baugh
CK Robert Jones
APPR R.E. Coull
APPR
APPR
APPR

DIV CHEVROLET

1981 ALL VEHICLES*(exc "P")

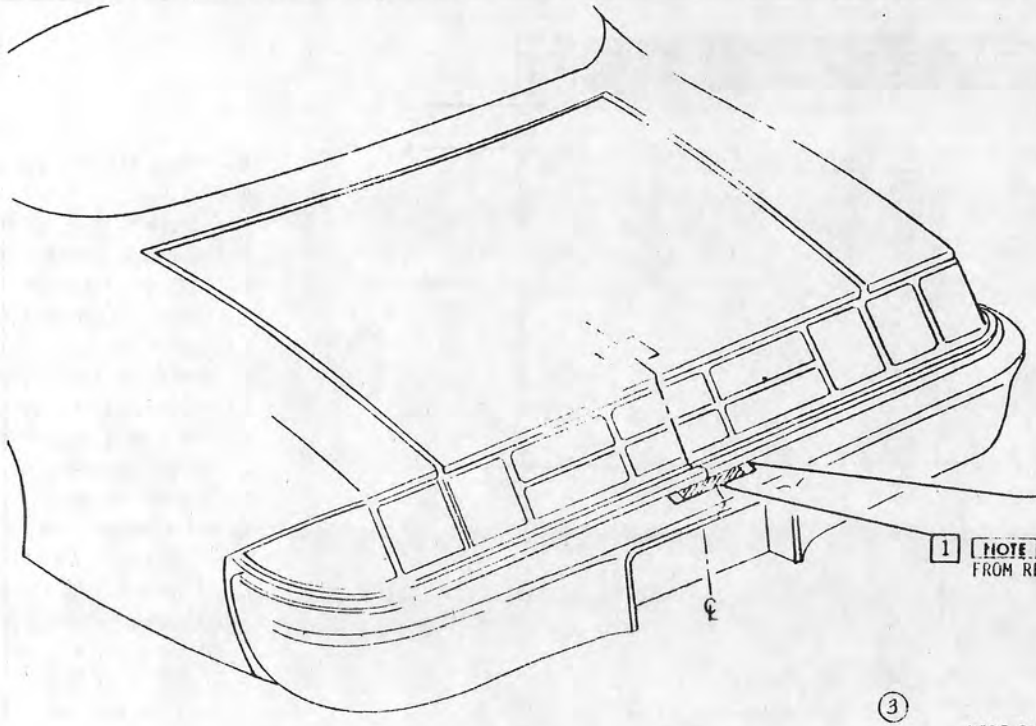
TITLE FUEL ECONOMY & PRICE LABEL PRINTED INFORMATION &Z49 ALL VEHICLES (exc "P")

REF ECR 86448 NEW 09MY80

UPC 08

SHEET 9

Ch ✓ B ✓ D 5/C 9 ✓ Co ✓



(1)	1686875	[1]	LABEL-UNLEADED FUEL &NA5/NB2 EXC Z49 (8A)
	740808	[1]	&Z49 (8A)

(3) LABEL APPLICATION

WIPE BUMPER WITH MINERAL SPIRIT SOLVENT PART NO. 9980793 OR EQUIVALENT.

REMOVE PROTECTIVE LINER FROM REVERSE SIDE.

APPLY LABEL ABOUT CENTERLINE OF BUMPER.

PRESS LABEL DOWN.

REMOVE PREMASK.

DYNAMIC (Install) N·m	HAND (Insp.) - N·m
1	
2	
3	
4	
5	

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
4SJN81	1	LABEL WAS DECAL & OPT ADDED				
	2	TITLE REVISED				
	3	APPLICATION NOTE REVISED	94930	401		

38

DATE 17JA80
DR L.MORENCY
CK D.FOWLER
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

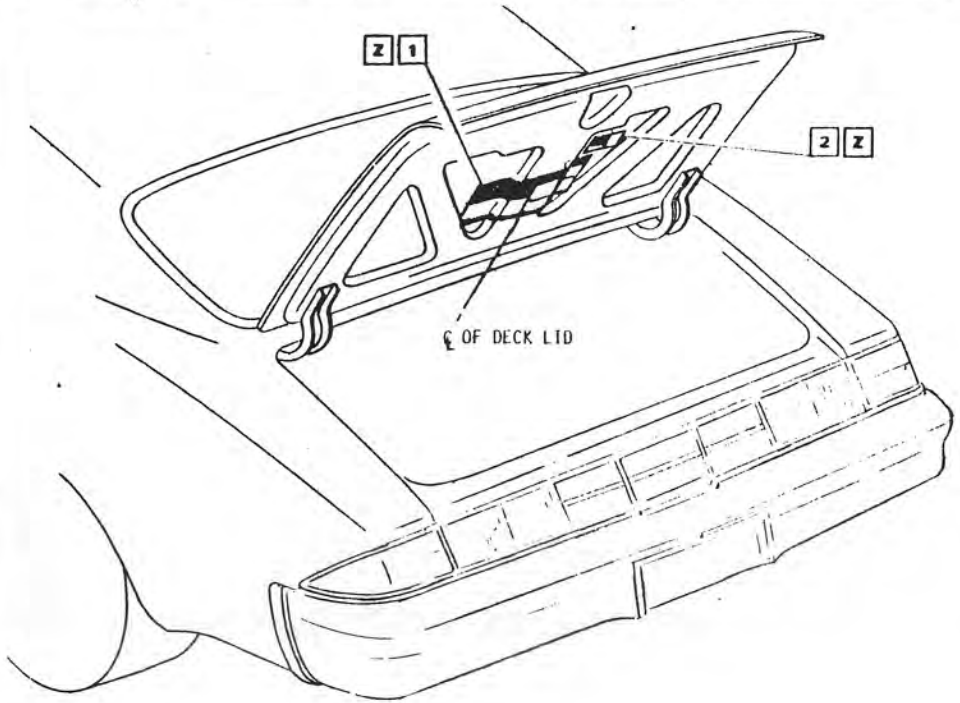
TITLE (2) UNLEADED FUEL LABEL FA00 ALL

REF ECR 86448
C/O 15JA80
OB-1

UPC 0B

SHEET 10

Ck X B O P Co



14032195	1	LABEL-AUTO JACK USAGE (14E)
10000182	2	LABEL-CAUTION &N90

Z Label to be readable when door is in open position.

DYNAMIC (Install) N·m	HAND (Insp.) N·m
1	
2	
3	
4	
5	

⚠ FULLY DRIVEN SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM Chg
		39				

DATE 25APR80
DR L. MORENCY
CK
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE AUTO JACK USAGE LABEL FA00 ALL

REF ECR 86448 C/O 25AP80 0B-11

1- 96735-S
1-
1-
1-

UPC 0B

SHEET 11

Ch X B 0 P Co

UPC GROUP	PART NO.	PART NAME	QTY	SHPG INFO
1A2A	1242652 353960	MAT-FRT FLR MAT-RR FLR	2	[W] [V]
10B	337284 362089 474362 14009860 14012635 14023356	CAP UNIT-HUB FP00 &PE1 &ZJ7 &Z28 &N90 OR Z28 FP00 &N90 EXC Z28, FS00 &N90	1	[W]
	14018259 14034425	COVER UNIT-WHL TR FP00 &P01 FS00 EXC N90		
	475018 352979 362091	RING UNIT-WHL TR FP00 &P01 FP00 &Z28 EXC N90 FP00 &PE1		
	474361	BEZEL-WHL FP00 &ZJ7	24	
	10013782	NUT UNIT-SECURITY WHL LKG FS000 &N18	1	
	14035311	LOCKING UNIT-WHL TR CVR FS00 &N18		
	9590439	FOLDER-TIRE OWNERS GDE & GUARANTEE		[Z] [V]
	9590313	FOLDER-COMPACT SPARE TIRE OWNERS GDE & GUARANTEE		
12L	16010780	MANUAL-CB RDO OWNERS &UP6		[Z]
14C	499728	BRACKET-FRT LIC &VK3		[X]
	329716 14005980	ATTACHMENT UNIT-RR LIC &VK3		

UPC GROUP	PART NO.	PART NAME	QTY	SHPG INFO
14F	14021745	MANUAL-OWNERS	1	[Z]
	14021777	FOLDER CONSUMER INFO EXC V78 OR Z49		[Y]
	14021731 746697	FOLDER-VEH MAINT &L39 &NA5; &LC3/LD5/LG4/LM1 &L39 &NM6		[Z]
	52350481 14021736 14021737	FOLDER-CANADIAN PASS. VEHICLE WARR &Z49 &NA5 &NB2		
	14021798 52350568	SUPPLEMENT-WARRANTY FOLDER &Z49		
	9798083	ENVELOPE-OWNER INFO BKLT		
	746680	SUPPLEMENT-OWNERS MANUAL &NM4		

[W] PLACE IN LUGGAGE AREA DIRECTLY ON THE LOAD FLOOR TO THE REAR OF THE COMPARTMENT AND COVER WITH LUGGAGE MAT.

[X] PLACE IN TRUNK OR STORAGE AREA.

[Y] PLACE WITH OWNERS MANUAL.

[Z] PLACE IN INSTRUMENT PANEL COMPARTMENT.

[V] FOR SPECIFIC RELEASING AND ADDITIONAL PART NUMBERS, SEE PARTS LIST.

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHK	DATE
09/09/80	12	REDRAWN FOR ISSUE 0					

40

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE MISCELLANEOUS SHIPPING LIST
F400 ALL

ENG ECR 8L448
NEW 14DE79

DOC 0c

SHEET 1

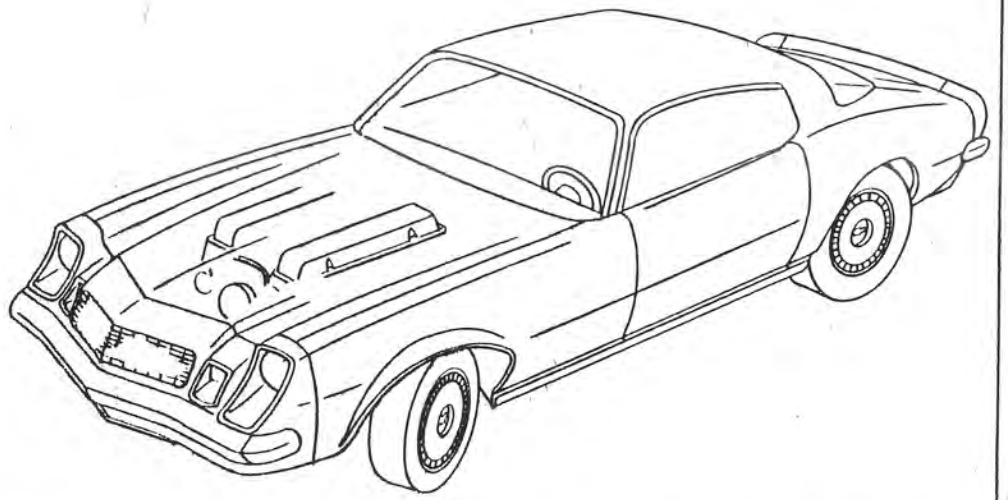
E | X | 0 | 0 | F | 0c

OD REPAIR PROCEDURES

			DIV. RESP.
	OD-1	CONTENTS	D
(2)	OD-2	TRANSFERRED	
	OD-2.5	TRANSFERRED	
	OD-3	TRANSFERRED	

OE PAINT & TRIM EXTERIOR ORNAMENTATION

	OE-1	PAINT & TRIM EXTERIOR ORNAMENTATION FP87		D
	OE-2	PAINT & TRIM EXTERIOR ORNAMENTATION FS87		D
	OE-3	OPEN		
	OE-4	● PAINT & TRIM EXTERIOR ORNAMENTATION FQ87	....Z28	D
	OE-5	PAINT & TRIM EXTERIOR ORNAMENTATION FS87	....CC1 or C87	D



DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
18APR80	1	SHEET OE-3 REMOVED	8644B	HD	[illegible]	
20JN80	2	SHEETS OD-2, OD 2.5 & OD-3 TRANSFERRED TO UPC 15 R	8644B	ACA	HB	

41

★ Instructions Carryover
● Waiting Info.

DATE 14FEB0
DR L. DAVIS
CK [illegible] HB
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

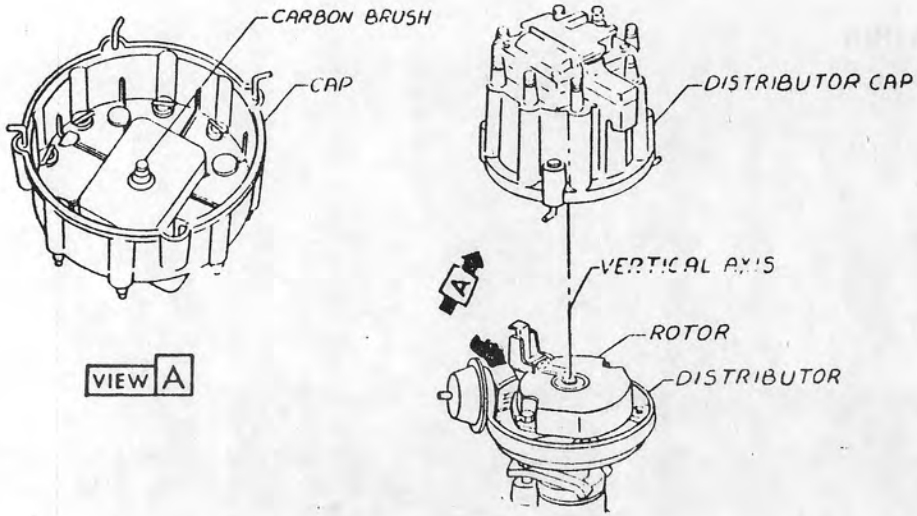
TITLE CONTENTS-REPAIRS & ORNAMENTATION
FA00 ALL

REF ECR 8644B
NEW 06N079

UPC OD

SHEET 1

C ☒ B 0 P Co



REMOVAL & INSTALLATION OF DISTRIBUTOR CAP

When removing and reinstalling cap, align on a vertical axis as shown, failure to comply with procedure could result in damage to carbon brush.

INFORMATION TRANSFERRED SEE SECTION 6E2

ASSEMBLY PLANT PROCEDURE

I. Passenger Frames - This procedure defines, by type of defect, those repairs which the assembly plant can make to a frame. No repairs, not specifically covered in this procedure, may be made. It is the responsibility of the assembly plant to assure that any permitted repair returns the frame to the Engineering specified condition.

A. Metal Splits - Splits that do not exceed 3mm in width. No splits can be repaired which occur in front or rear suspension mounting areas, steering gear mounting area or any splits which extend into any contoured area. Split repair is to be accomplished through MIG, gas or arc welding following good welding practices.

B. Missing or Incomplete Welds - Such weld repair cannot be made where butt welds are involved. Weld repair in suspension or steering gear mounting areas may be made only if such welding is limited to repair of incomplete welds. No attempt should be made to fixture suspension or steering brackets or spacers. Welds must be made in conformance to good welding practices.

C. Excess or Short Material - Removal of excess material is permitted if such removal does not adversely affect the frame. Such material removal should only be done after receiving permission from Chevrolet Product Assurance. There is no repair for the short material condition where function is affected.

D. Holes
1. Missing - Those holes not involved in suspension, steering gear or geometry must be drilled using local built fixtures to assure proper size and location.

2. Off location - only those holes involved with brake, fuel or emission pipe clips can be repaired. Such repairs must place the hole in proper location. In the case of oversize holes, fastener substitution requires Engineering deviation.

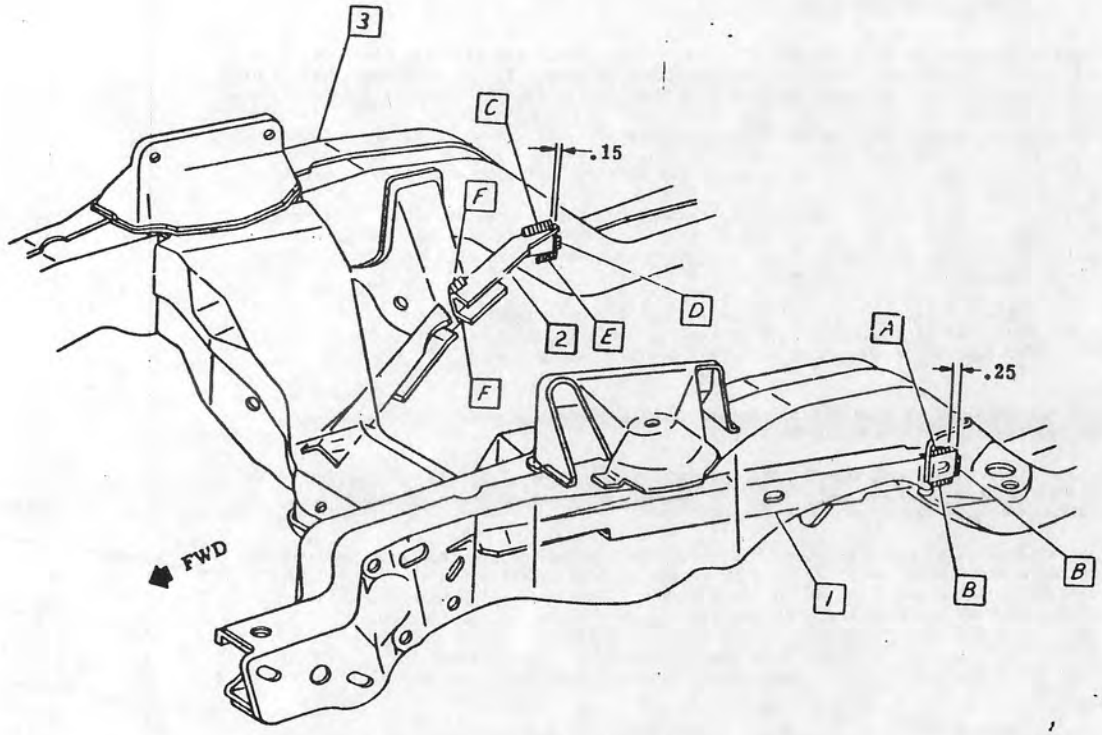
E. Missing Parts - Repair is limited to body brackets, transmission brackets and reinforcements. Repair must be made with MIG, gas or arc weld using proper fixturing to assure correct location and following good welding practices. Major structural members including suspension cross members, suspension mounting brackets, energy absorbing attaching brackets and steering gear spacers are not to be repaired.

F. Damage - Minor damage requiring local straightening to accept mating parts. Bent flanges or local kinks may be repaired. Such repairs can be made only if such repair can be done by hand tools without heating of parts or surfaces.

G. Rivets - No rivet repairs are permissible. If a bolt/nut substitution is required, Engineering Deviation must be issued.

H. Frame Coating - Any repair which involves removal of the frame coating must be recoated with the specified coating. This coating material must be obtained from Engineering approved sources.

INFORMATION TRANSFERRED SEE SECTION 15R.



Ref 2B [1] BRACE-FRT C/CMBR LH & LG3 or LM1; & L22 (exc NB2)

Ref 2B [2] BRACE-FRT C/MBR RH & LG3/LM1/L22

Ref 2B [3] SIDE & C/MBR ASM

[A] 1 Arcweld [1] to [3] 1.88 long.
[B] 2 Arcwelds [1] to [3] 1.00 long.
[C] 1 Arcweld [2] to [3] 1.00 long.
[D] 1 Arcweld [2] to [3] .75 long.
[E] 1 Arcweld [2] to [3] 1.25 long.
[F] 2 Arcwelds [2] to [3] 1.31 long.

INFORMATION TRANSFERRED SEE SECTION 15R

DYNAMIC (Install) N·m	HAND (Insp.) · N·m	DATE	SYM	REVISION	ALTH	DR	CK	ASM CHG
		15FEB80	1	SHEET TRANSFERRED	86448	HD	RS	

1 2 3 4 5 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE 15FEB80
DR L. DAVIS
CK HJ Buck HB
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE REPAIR PROCEDURE-FRONT CROSSMEMBER BRACE FA00 ALL

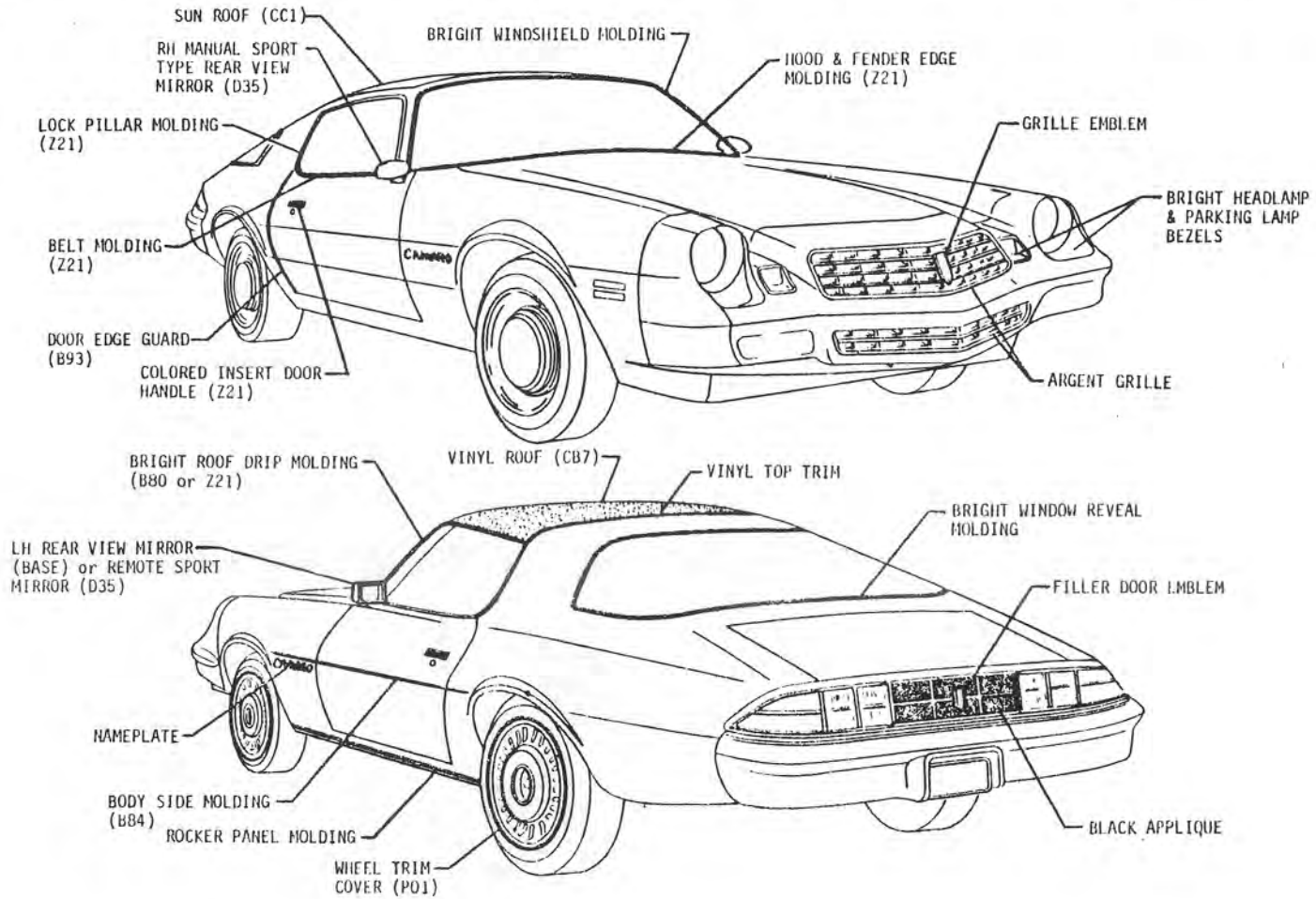
REF ECR 86448 C/O 30N079 OD-3

L-17912-S
L-
L-
L-

UPC OD

SHEET 3

Ch X 8 O P Ca



DYNAMIC (Install) N·m	HAND (Insp.) · N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG

△1 △4 △3 △4 △5

△1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE 11APR80 | DR L.DAVIS | CK | APPR | APPR | APPR | APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

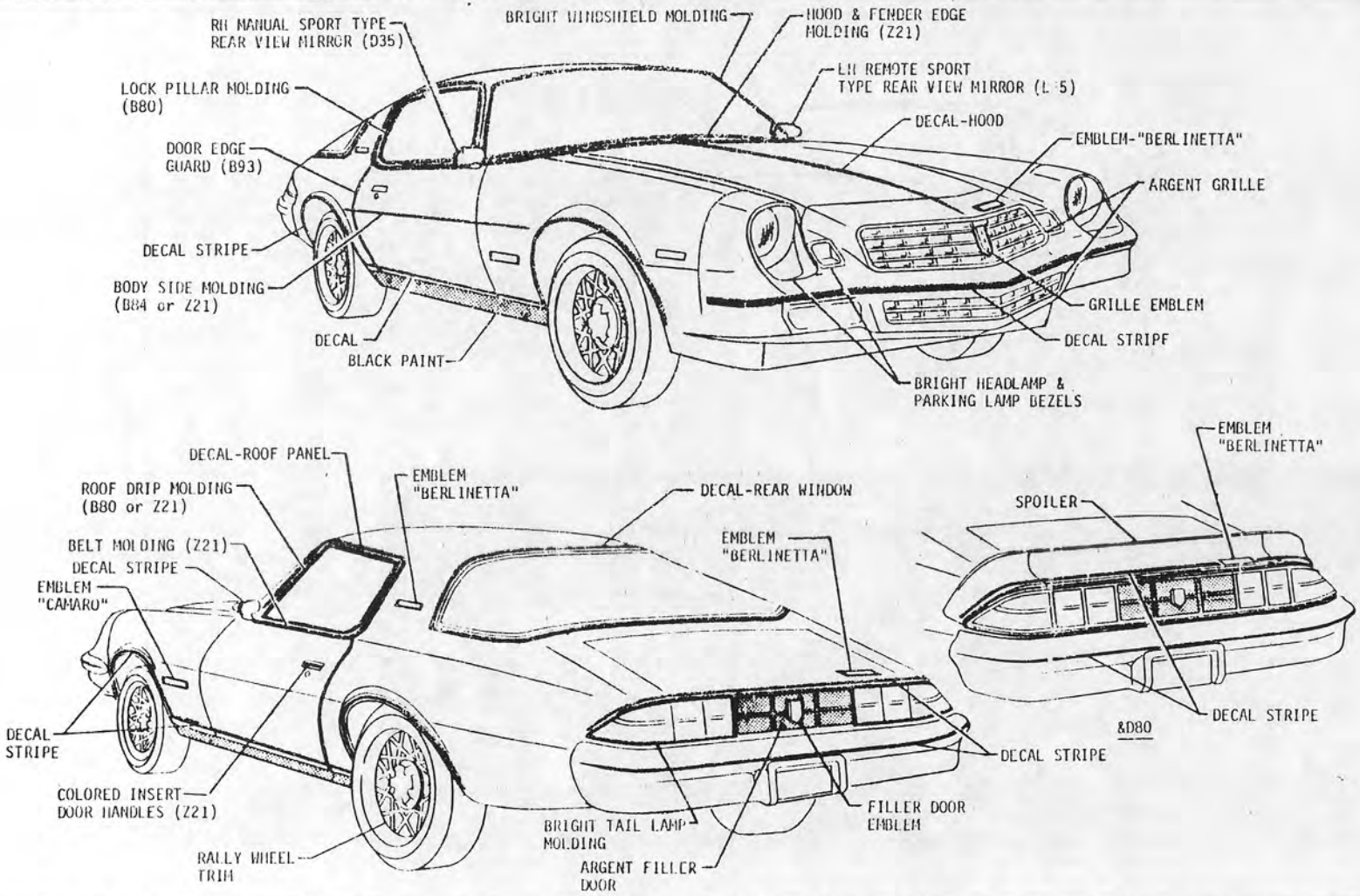
TITLE PAINT & TRIM EXTERIOR ORNAMENTATION FP87 ALL

REF ECR 86448 C/O 04AP80 0E-1

UPC 0E

SHEET 1

Ch X B O P Ca



DYNAMIC (Install) N·m	HAND (Insp.) N·m	DATE	SYM	REVISION	AUTH.	DR	CK	ASM CHG

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE 11AP80
DR L.DAVIS
CK
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

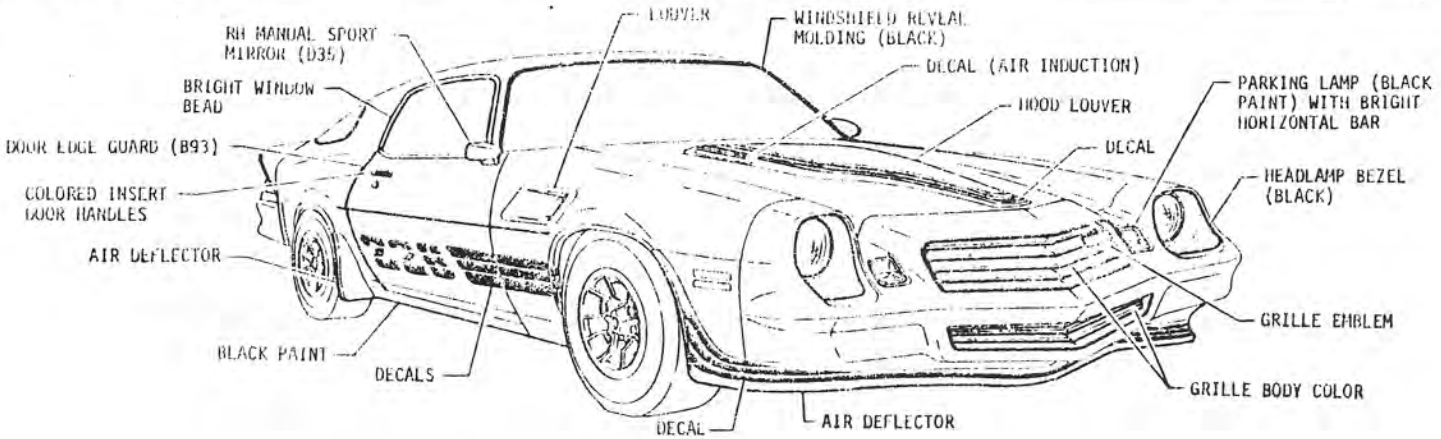
TITLE PAINT & TRIM EXTERIOR ORNAMENTATION
FS87 ALL

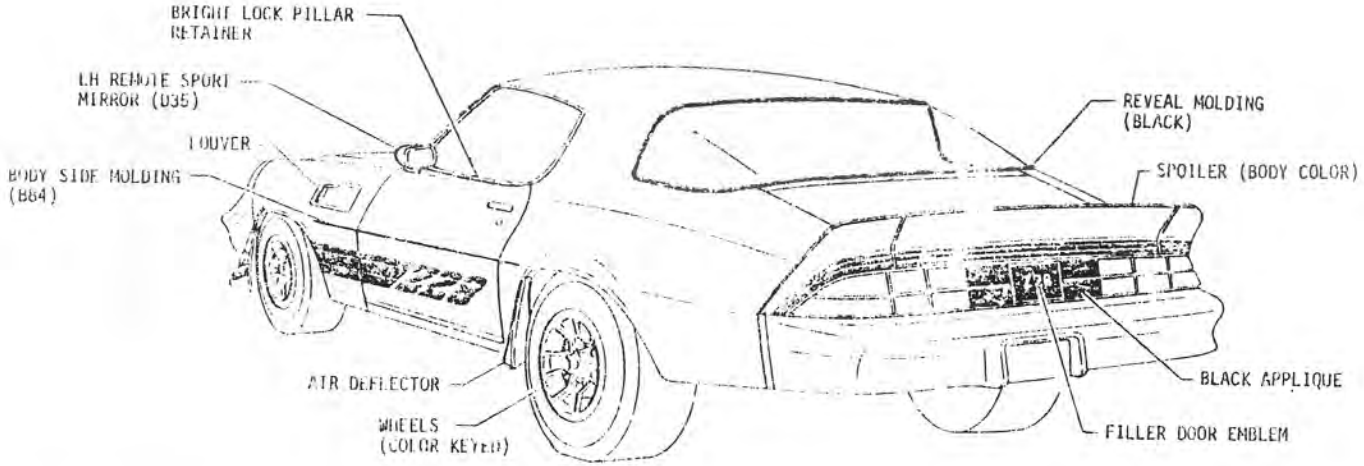
REF ECR 86448
C/O 04AP80
0E-2

UPC 0E

SHEET 2

Ch X B O P Ca





DYNAMIC (Instal) N·m	HAND (Insp.) N·m	DATE	SYM	REVISION	AUTH	QR	CK	ASM CK

1 FULLY DRIVEN, SEATED & NOT STRIPPED

47

DATE 2SAUG0
DR L.DAVIS/ACA
CK HJ Buck 118
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE PAINT & TRIM EXTERIOR ORNAMENTATION FP87 &Z28

REF ECR 86448 NEW 07AU80

UPC CE

SHEET 4

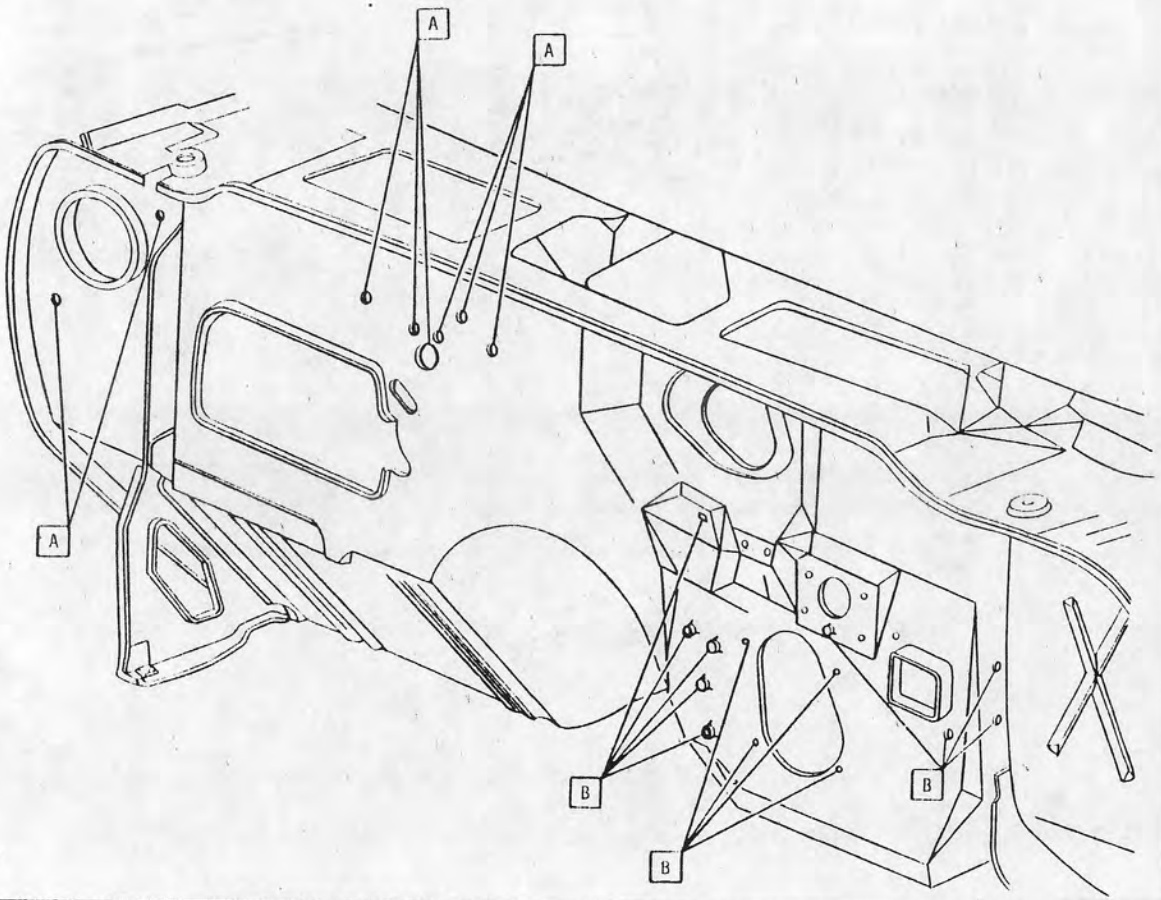
CA X B O P Co

1 BODY

			DIV RESP
	1A1-1	CONTENTS	D

1A1 BODY AS PURCHASED

(1)	A	1A1-2	COWL & DASH ASM-EXISTING HOLE & DIMPLE IDENT	D
	B	1A1-3	COWL & DASH ASM-EXISTING HOLE & DIMPLE IDENT LEFT SIDE	D



DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
8/4/80	1	SHEETS 1A1-2 & 3 TITLES REVISED	BCA82	MCA	MB	

DATE 18 JAN 80
DR R. SIENKIEWICZ
CK 7/9 Buick HB
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE CONTENTS-BODY AS PURCHASED
FA00 ALL

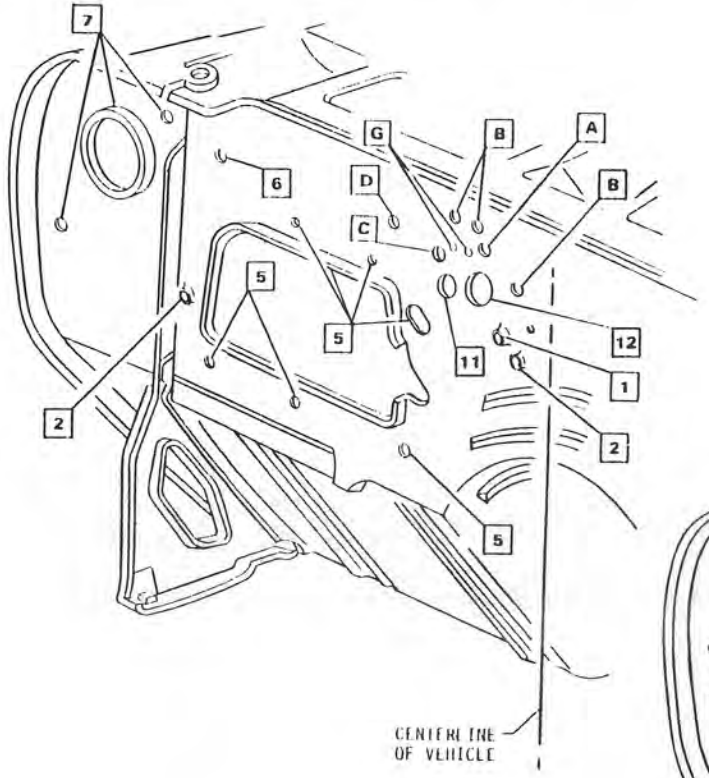
REF ECR 86448
NEW 07SE79

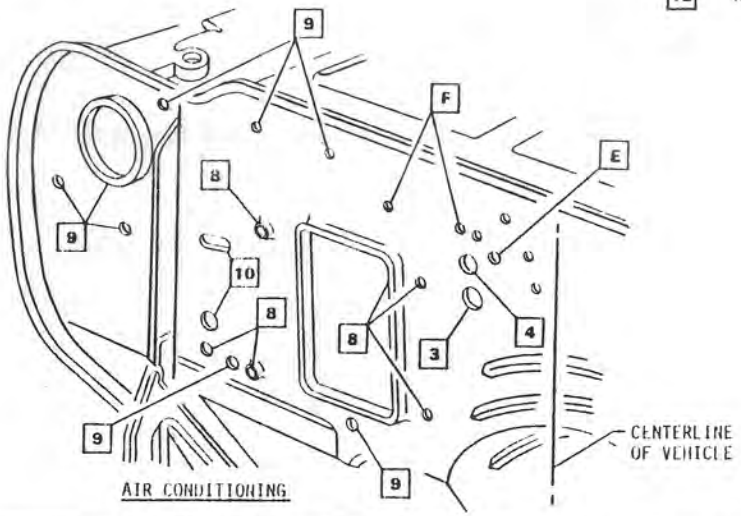
UPC 1A1

SHEET 1

★ Instructions Carryover
● Waiting Info.

LH ☒ B ☐ D ☐ P ☐ Co ☐





AIR CONDITIONING

- A DIMPLE-Power Clip (12H)
- B DIMPLES-(2)-Choke Vacuum Tank
- C DIMPLE-Ground Wire (6Y)
- D DIMPLE-Radio Capacitor (12)
- E DIMPLE-A/C Ground Wire (12H)
- F DIMPLES-(2)-Vacuum Tank (1A2J)
- G DIMPLES-(2)-M.A.P. Sensor (6H)

- 1 HOLE-Radio Ground Strap (12L)
- 2 HOLES (2)-Dash Mat (1A2A)
- 3 HOLE-A/C Harness (12H)
- 4 HOLE-A/C Vacuum Hose (1A2J)
- 5 HOLES (7)-Heater Asm (1A2H)
- 6 HOLE-Front Fender (11A)
- 7 HOLES (3)-Htr Blower Motor (1A2H)
- 8 HOLES (6)-A/C & Heater Asm (1A2H)
- 9 HOLES (8)-Evap & Blower Asm (1A2K)
- 10 HOLES (2)-Htr Core Pipe (1A2H)
- 11 HOLE-Heater Harness Asm (12H)
- 12 HOLE-Emission System (California)(12H)

DYNAMIC(Install) N·m	HAND (Insp.) N·m
1	
2	
3	
4	
5	

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
09AP80	1	TITLE REVISED	36448	ACA	[illegible]	

49

C ☒ B ☐ O ☐ P ☐ Co ☐

DATE 11APR80
DR R.SIENKIEWICZ
CK [signature]
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

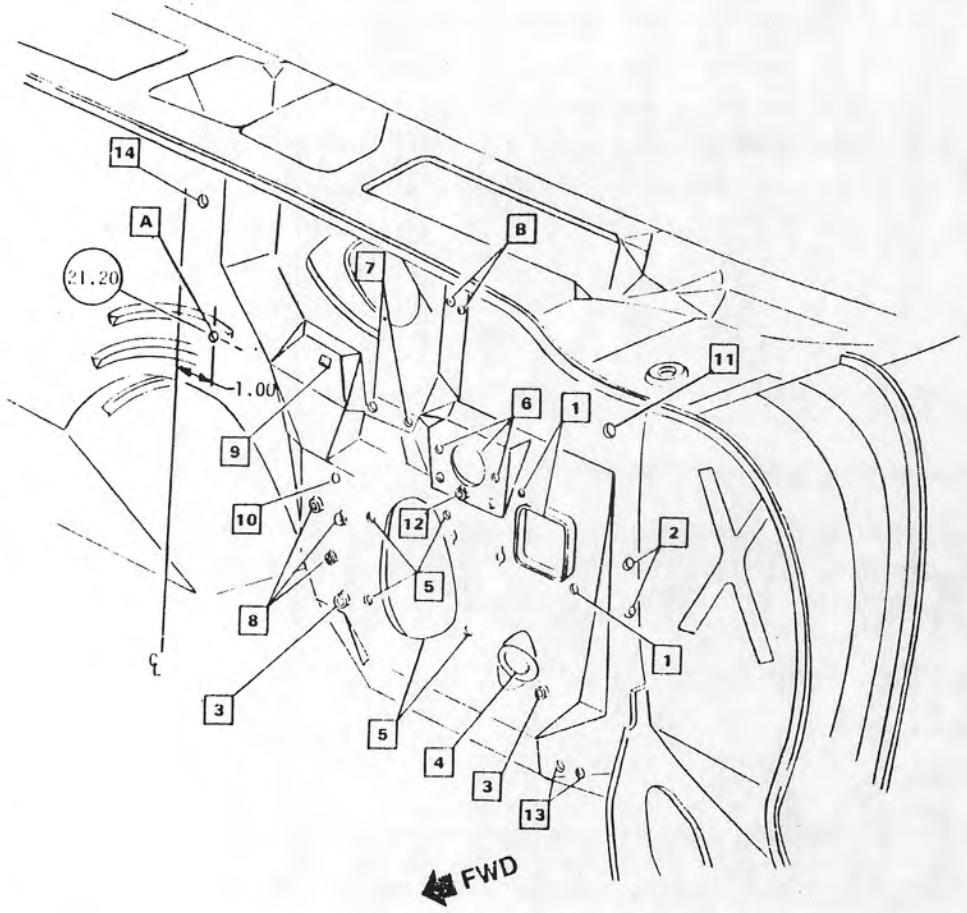
TITLE COWL & DASH ASM-EXISTING HOLE & DIMPLE IDENTIFICATION FA00 ALL (1)

REF ECR 86448
C/O 09AP80
1A1-2

L-19051-S
2 L-89731-S
L-
L-

UPC 1A1

SHEET 2



1 HOLES (3)-Fuse Panel (12H)
2 HOLES (2)-Parking Brake (5D)
3 HOLES (2)-Steering Trim Cover (9A)
4 HOLE-Speedo Cable (12J)
5 HOLES (5)-Steering Column (9A)
6 HOLES (5)-Brake Main Cyl (5C) (5E) (5G)
7 HOLES (2)-Interlock Relay (12H)
8 HOLES (3)-Acc. Rod Support (6N)
9 HOLE-Accelerator Cable (6N)
10 HOLE-Engine Harness Clip (12H)
11 HOLE-Front Fender (11A)
12 HOLE-Dash Mat (1A2A)
13 HOLES (2)-Dimmer Switch (12C)
14 HOLE-A/C Harness Clip (12H)

A Tach Filter U14
B DIMPLES (2)-Horn Relay (12G)

NOTE See 1A2E for additional holes provided at assembly.

DYNAMIC (Instal) N·m	HAND (Insp) N·m
1	
2	
3	
4	
5	

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

Ch X B O P Ca

DATE	SYM	REVISION	AUTH	DR	CK	ASM CNG
09AP80	1	TITLE REVISED	82448	RCA		

50

DATE 19APR80
DR R.SIENKIEWICZ
CK
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE COWL & DASH ASM-EXISTING HOLE & DIMPLE IDENTIFICATION LEFT SIDE FA00 ALL (1)

REF ECR 86448
C/O 09AP80
1A1-3

L-89731-S
L-08168-S
L-08399-S
L-19043-S

UPC 1A1

SHEET 3

BODY

				DIV RESP
	1A2-1	CONTENTS		D

1A2A FLOOR & SILL

A	1A2A-1	DASH MAT ASM		D
B (11)	1A2A-2	INSULATORS, FRT FLOOR PNL & SILL PLATES		D

1A2B INSTRUMENT PANEL

C	1A2B-1	INST PANEL REINF CTR UPR & LWR & W/S PLR REINF		D
	1A2B-2	INST PANEL LOWER TIE BAR		D
	1A2B-3	INST PANEL PAD & LWR PANELS		D
	1A2B-3.1	TRIM PNL-RADIO		D
D	1A2B-4	COVERS-RADIO & SPEAKER		D
(10)	1A2B-4.1	STEERING COLUMN TRIM FILLER		D
E	1A2B-5	INST PNL COMPT		D
	1A2B-6	INST PNL COMPT DOOR		D

1A2C BODY VENTILATION & DEFOGGING

F	1A2C-1	UPPER LEVEL VENTILATION		D

1A2D WINDSHIELD WIPER & WASHER

G	1A2D-1	OPEN		
	1A2D-2	W/S WASHER SWITCH	....CD4	D
	1A2D-3	W/S WASHER SPRAY PATTERN		D
	1A2D-4	W/S WASHER JAR,HOSES & NOZZLES		D

1A2E MISCELLANEOUS PARTS

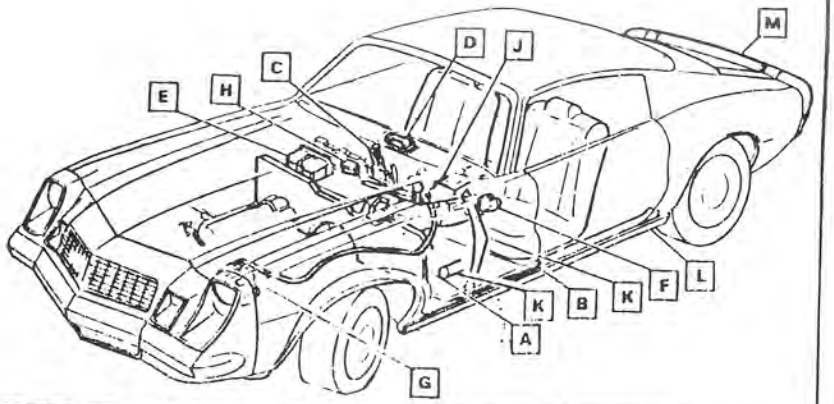
H	1A2E-1	ASH TRAY ASM		D
	1A2E-2	COWL PLUG		D
(9)	1A2E-2.1	DASH PANEL PLUG		D
J	1A2E-3	CONSOLE, DOOR ASM & PLATES	....NM4	D
	1A2E-3.1	BRACKET-CONSOLE		C
K	1A2E-4	FRT FENDER SEAL	....BS1	D
	1A2E-5	SHROUD SIDE FINISHING PANEL	....C60	D
	1A2E-6	FRONT OF DASH SEALING		D
(12)	1A2E-7	COWL & DASH ASM HOLE PIERCING & DIMPLE IDENT		D

1A2F EXTERIOR BODY ORNAMENTATION

L	1A2F-1	BODY SILL MOLDING	....FP00	D

1A2F EXTERIOR BODY ORNAMENTATION (Continued)

				DIV RESP
M	1A2F-2	RR SPOILER	....D80	C
	1A2F-3	CANCELED		
	1A2F-4	CANCELED		
	1A2F-4.1	DECAL-HOOD LOUVER	....FP00 &Z28	D
	1A2F-5	DECAL-FRONT PANEL & FENDER FLARE	....FP00 &Z28	D
	1A2F-6	REAR BUMPER MOLDING ASM		D
	1A2F-7	DECAL-DOOR	....FP00 &Z28	D
	1A2F-8	DECAL-REAR COMP LID & QTR PNL EXT	....FP00 &Z28	D
	1A2F-9	STRIPE-SAIL PANEL & DOOR UPPER	....FS87	D
	1A2F-9.5	STRIPE-SAIL PANEL & DOOR UPPER	....FS87 &B80 or Z21	D
	1A2F-10	STRIPE-RR DECK LID	....FS87	D
	1A2F-11	STRIPE-SPROT MIRROR	....FS87	D
	1A2F-12	STRIPE-REAR WINDOW	....FS87	D
	1A2F-13	STRIPE-DOOR LOWER & RR WHEELHOUSE OPENING	....FS87	D
	1A2F-14	STRIPE-REAR COMP LID & QTR PNL EXT	....FS87 &D80	D
	1A2F-15	CANCELED		
	1A2F-16	STRIPE-ROOF	....FS87 &CC1	D
	1A2F-17	REAR QTR AIR DEFLECTOR	....FP00 &Z28	D
	1A2F-18	EMBLEM-REAR SPOILER	....FP00 &L08	D
	1A2F-19	STRIPE-HOOD CTR & FRT BUMPER	....FS87	D
	1A2F-20	STRIPE-FRONT FENDER W/HOUSE OPENING	....FS87	D
	1A2F-21	STRIPE-HOOD REAR & FRONT FENDER	....FS87	D
	1A2F-22	STRIPE-REAR BUMPER COVER	....FS87	D



★ Instructions Carryover
● Waiting Info.

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
6/11/80	9	SHEET 1A2E-2.1 ADDED	83091	MCA	RD	
11/6/80	10	SHEET 1A2B-4.1 TITLE REVISED	83213	MCA	RD	
	11	SHEET 1A2A-2 TITLE REVISED	83293	MCA	RD	
03/16/81	12	SHEET 1A2E-7 TITLE REVISED	PL448	MCA	RD	

51

DATE	18JAN80
DR	R.STENKIEWICZ
CK	RJ Buick HB
APPR	
APPR	
APPR	
APPR	

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE CONTENTS-BODY
FA00 ALL

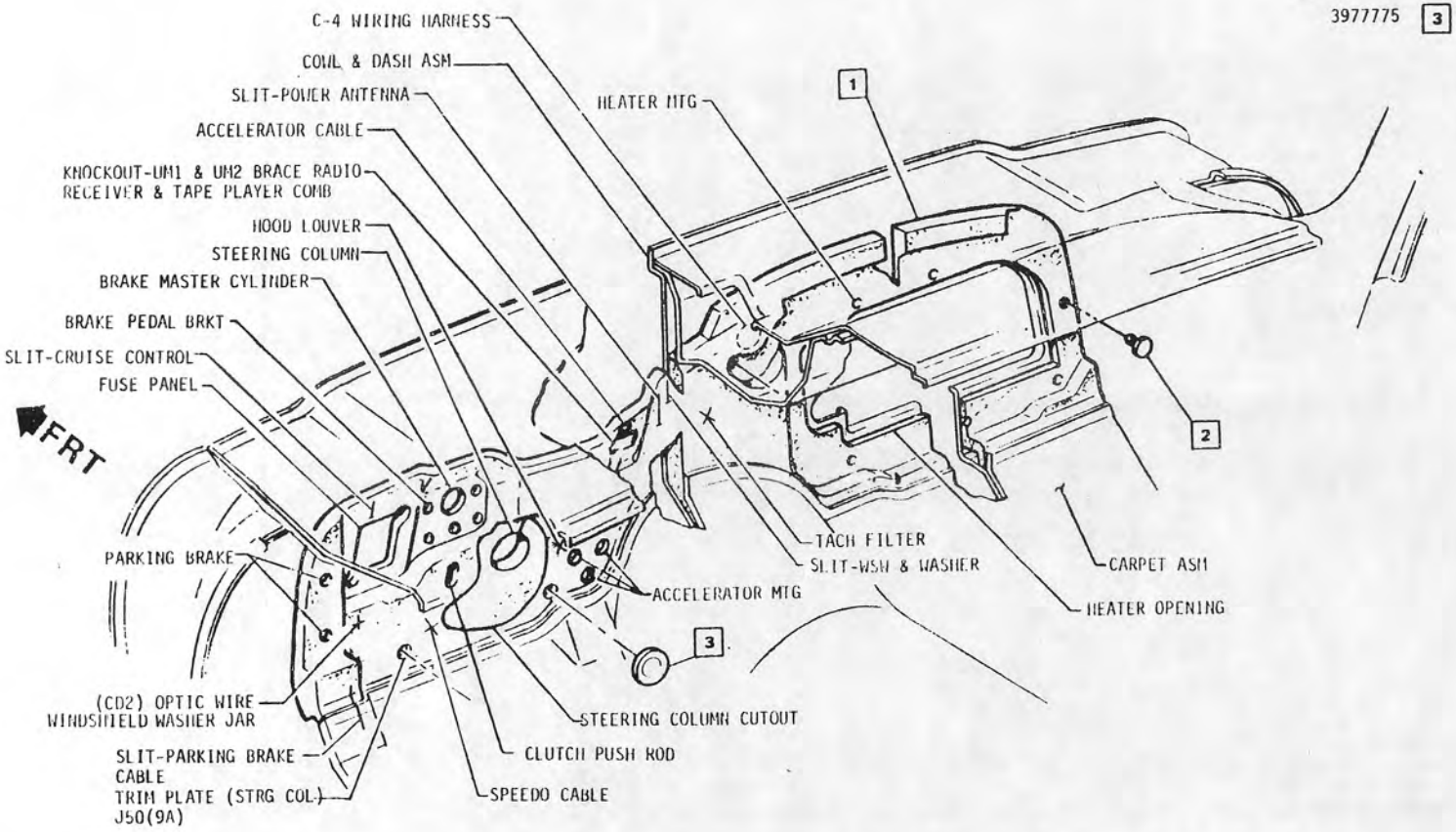
REF ECR 86448
NEW 07SE79

UPC 1A2

SHEET 1

Ch X B D F Co

1	14015167	1	INSULATOR-DASH PNL
	14015168	1	&C60
2	3868790	2	RETAINER
	3977775	3	RETAINER &JL6



DYNAMIC (Install) N·m	HAND (Insp)	N·m
1		
2		
3		
4		
5		

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
11/14	1	WAS NAT ASM - DASH				
	2	WAS FASTENER	83293	[illegible]		

DATE 14JAN80
DR STENKIEWICZ/ACA
CK J.J. Buch HB
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE INSUL DASH PNL FA00 ALL

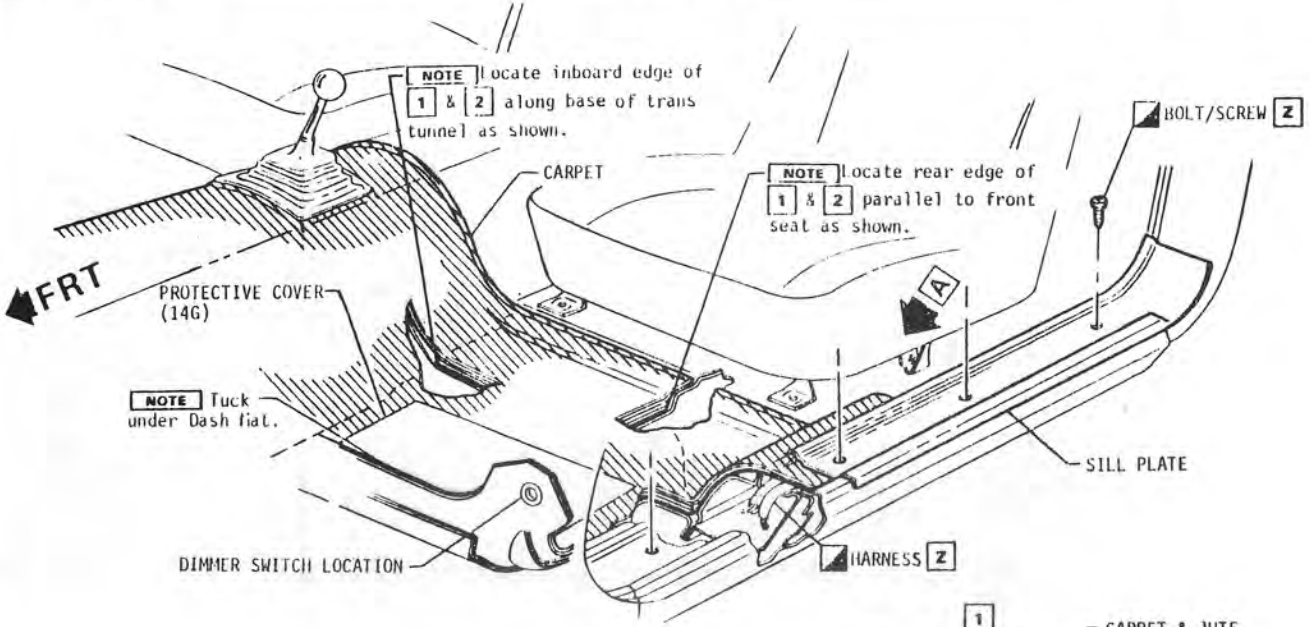
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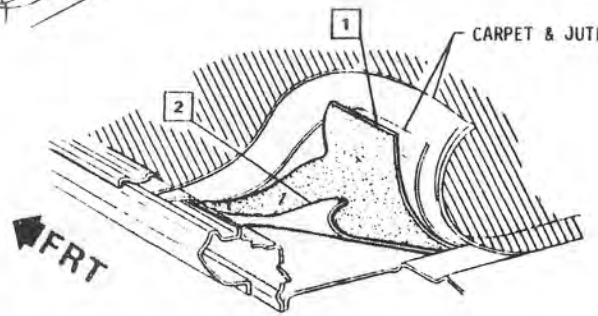
L-92019-S L-89731-S L- L-

UPC 1A2A

SHEET 1

Ch X B O P Ca





VIEW A

3984067 1 INSULATOR-FRT FLOOR PAN-LH (1)
3984065 2 INSULATOR-FRT FLOOR PAN-LH &Z54

Z See Fisher Body Operation Description (OD).

DYNAMIC (Install) N·m	HAND (Insp.) N·m
(3) ⚠	
⚠	
⚠	
⚠	
⚠	
⚠ FULLY DRIVEN, SEATED & NOT STRIPPED	

DATE	SYM	REVISION	AUTH	DR	CK	ASSG CHG
17JA80	1	WAS DEADENER				
	2	TITLE REVISED				
	3	TORQUE (1.6-2.2 N·m) REMOVED	93293	ACA	NB	

57

DATE 17JA80
DR SIENKIEWICZ/ACA
CK 7/ Bur L. 11B
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE INSULATORS-FRONT FLOOR PNL & SILL PLATE (2)
FA00 ALL

REF ECR 86448
C/O 210E79
1A2A-2

L-89800-S
L-93392-S
L-
L-

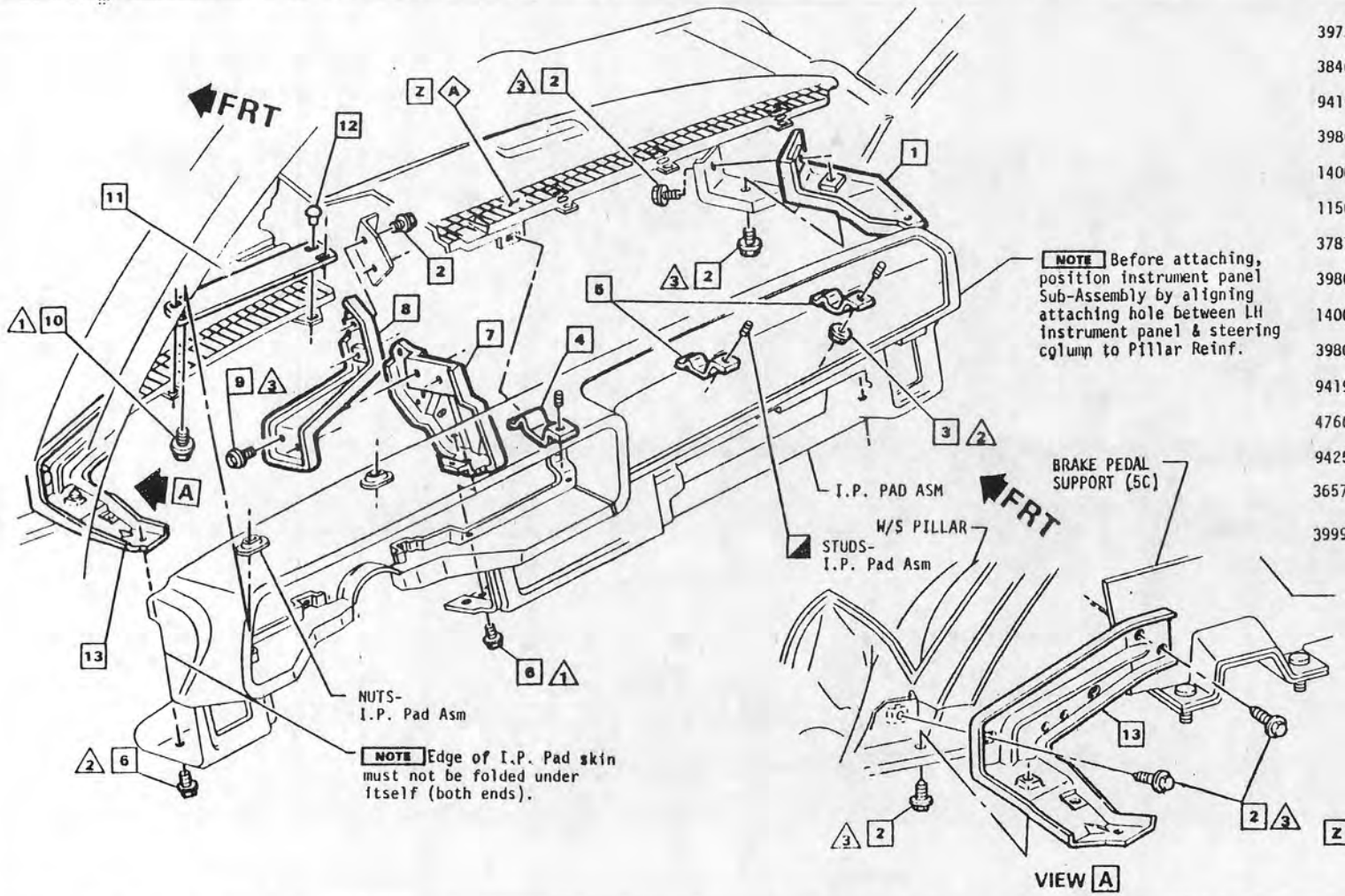
UPC 1A2A

SHEET 2

Ch X B D P Cu

PRODUCT DESCRIPTION MANUAL

□ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF



3972078	1	SUPT ASM	
3846202	2	BOLT/SCREW	
9419784	3	NUT	
3980355	4	RETAINER	
14003621	5	RETAINER	
11503395	6	BOLT/SCREW	
378723	7	SUPT ASM-I/P CTR	
3980356	8	BRKT ASM-I/P CTR SUPT	
14003636	8	&C49 or U75/U83	
3980360	9	BOLT/SCREW	
9419303	10	BOLT/SCREW	
476676	11	BRKT-I/P UPR	
9425415	12	RIVET	
365748	13	SUPT-I/P STG COL	
3999491	A	LUBRICANT-.006 Kg	

DYNAMIC (Install) N·m	HAND (Insp) N·m
1 1.2 - 1.6	
1 1.6 - 2.8	
1 14 - 20	
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
20JN80	1	REDRAWN & REDESIGNED	83293	N	AHB	

DATE 14JA80
DR SIENKIEWICZ/ACA
CK NJBuck HB
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE INSTRUMENT PANEL SUPPORT CTR UPPER & LOWER & W/S PILLAR REINFORCEMENT FA00 ALL

REF ECR 86448 C/O 21DE79 1A2B-3

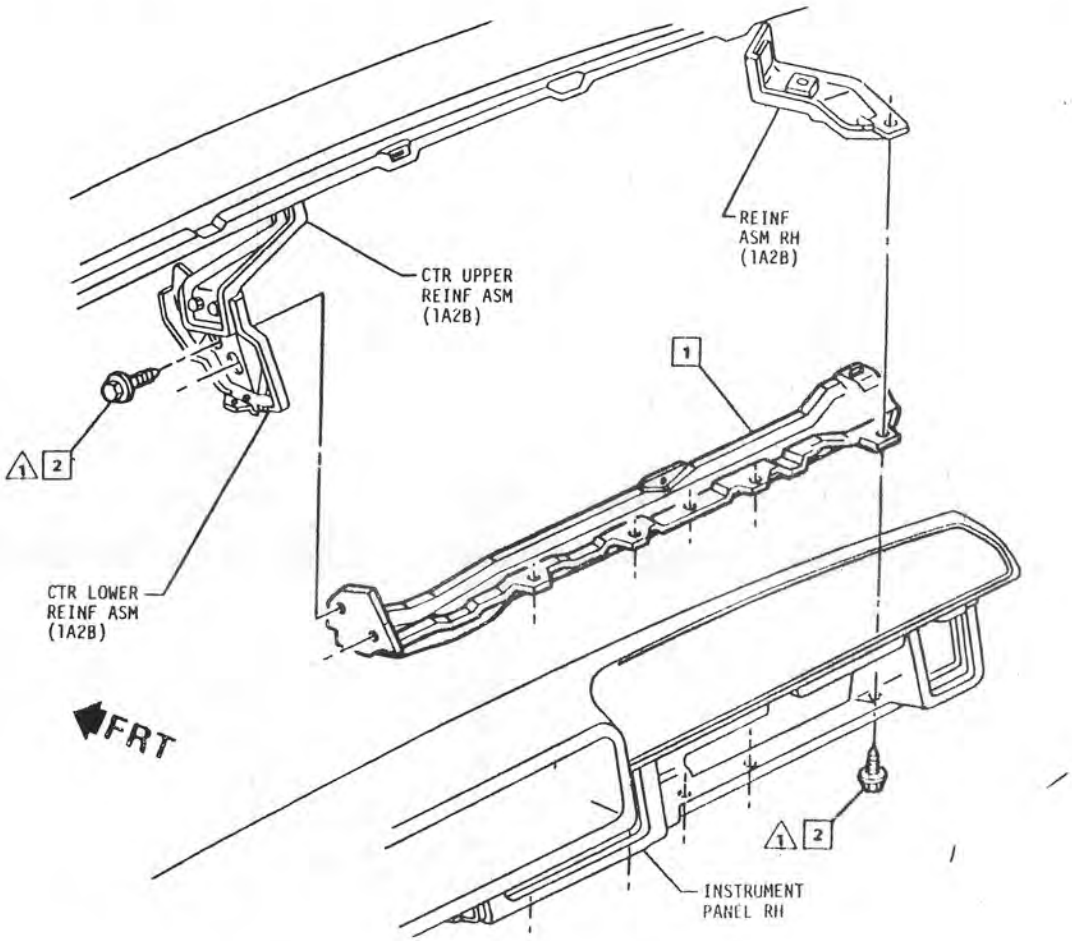
L-18262-S
L-
L-
L-

UPC 1A2B

SHEET 1

Ch X B O F Ca

6264782 [1] BAR-I/P LWR TIE (2)
11503395 [2] BOLT/SCREW



DYNAMIC (Install) N·m	HAND (Insp) N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
	△1 1.2 - 1.6	20JN80	1	TITLE REVISED				
			2	WAS REINF RH INST PNL	83293	ACA	MB	

△1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE 14JA80
DR R. SIENKIEWICZ
CK HJ Buck & IIB
APPR S
APPR
APPR
APPR

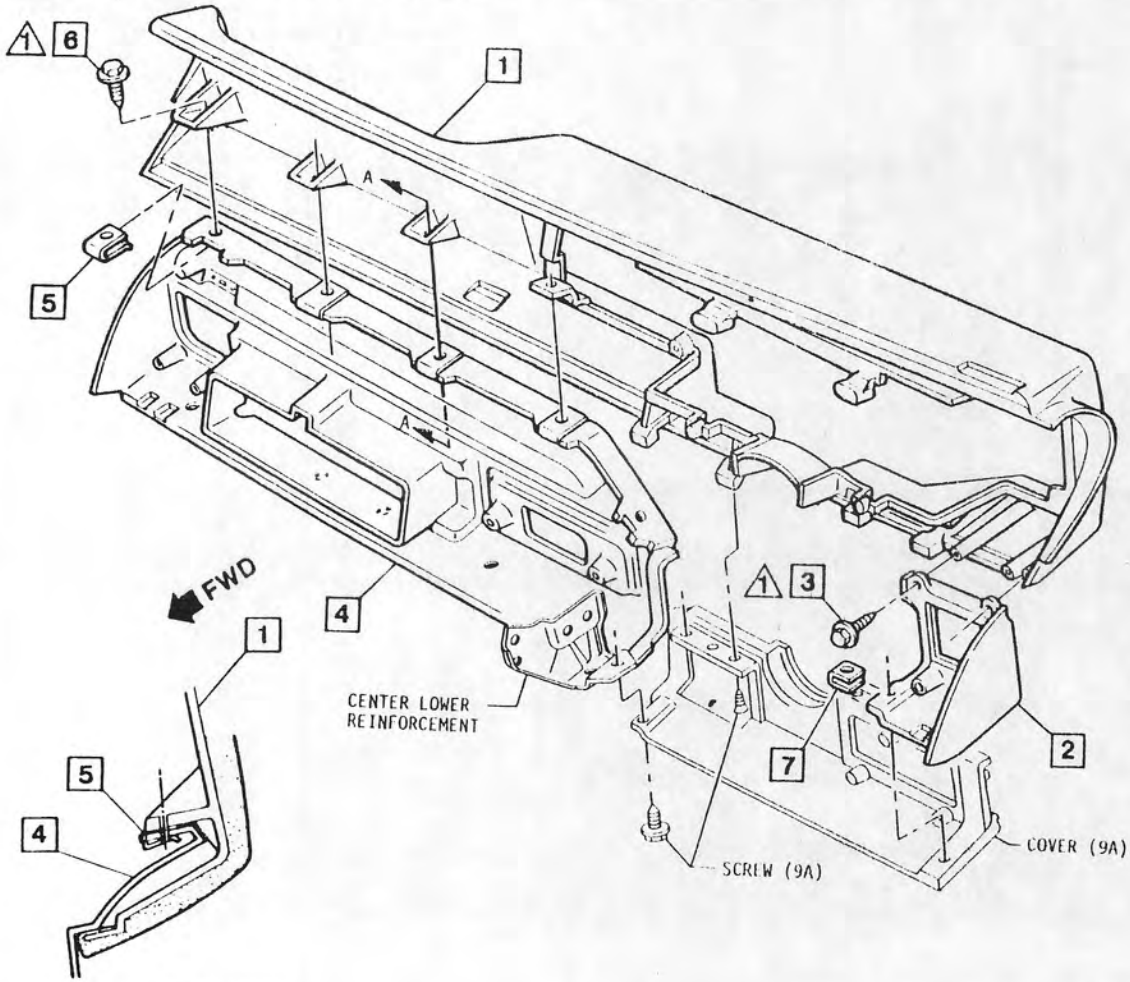
DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE INSTRUMENT PANEL LOWER TIE BAR
FA00 ALL (1)

NEXT ASSY	USED ON	UPC	SHEET
ECR 86448 C/O 21DE79 1A2B-2	L-18262-S L- L- L-	1A2B	2

Ch X B O P Cu



+476640	1	*CHART-PAD ASM-I/P
+332121	2	*CHART-PANEL LH
11503393	3	BOLT/SCREW
+14015856	4	*CHART-PANEL RH
9431530	5	"U" NUT
11503395	6	BOLT/SCREW
9427761	7	"U" NUT

SECTION A-A (INSTALLED)

*(UPC "0"-P/L)

DYNAMIC (Install) N·m | HAND (Insp.) N·m

△1 1.2 - 1.6
△2
△3
△4
△5

△1 FULLY DRIVEN SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
		56				

DATE 14JA80
DR R.STENKIEWICZ
CK H.J.Kuck HB
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE INSTRUMENT PANEL PAD & LOWER PANELS FA00 ALL

REF ECR 86448
C/O 21DE79
1A2B-3

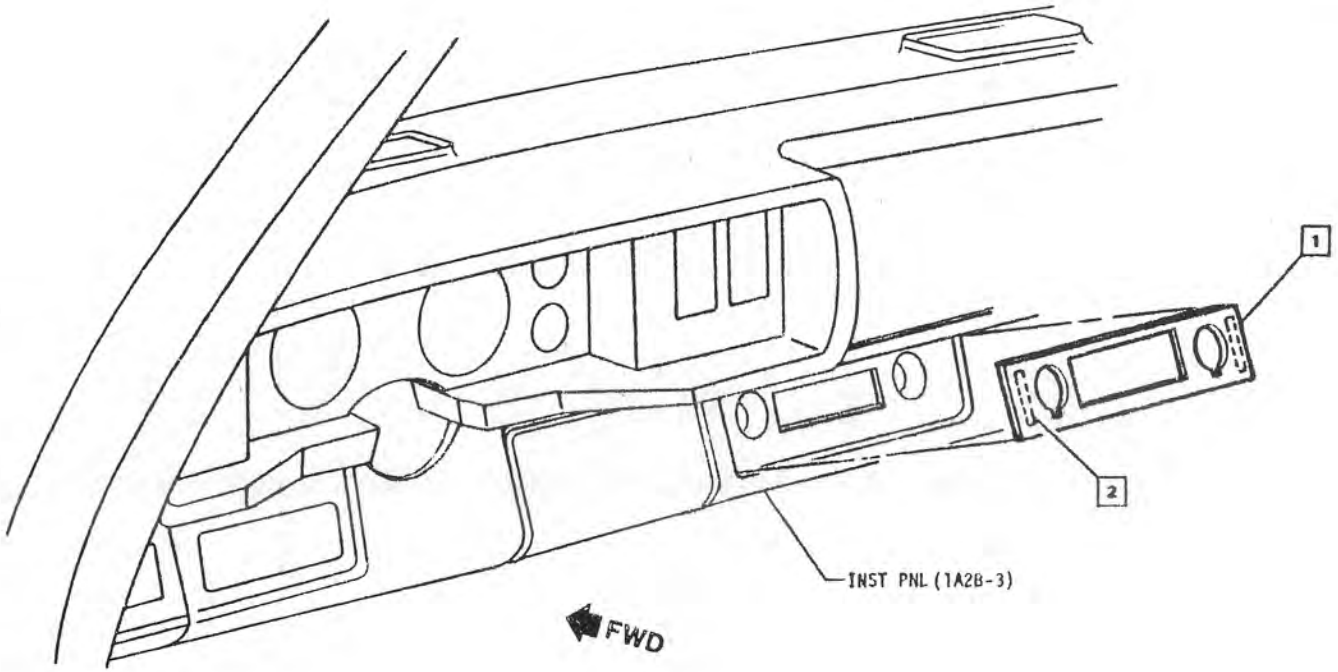
L-18262-S

UPC 1A2B

SHEET 3

Ch | B | D | P | Co

14015867	1	PANEL-FS00+FP00 &Z54
(1)14028093	1	FP00 &Z28
9985274	2	TAPE-ADHESIVE (Width as req'd)



DYNAMIC (Install) N.m	HAND (Insp.) N.m
1 2 1 4 1	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

Ck X B O P Co

DATE	SYM	REVISION	AUTH	DR	CK	ASN CHG
11AP80	1	WAS 14015868 PANEL	98201	ACA	[illegible]	

DATE 14JA80
DR SIENKIEWICZ/ACA
CK MJ Buick HB
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE TRIM PANEL-RADIO
FA00 ALL

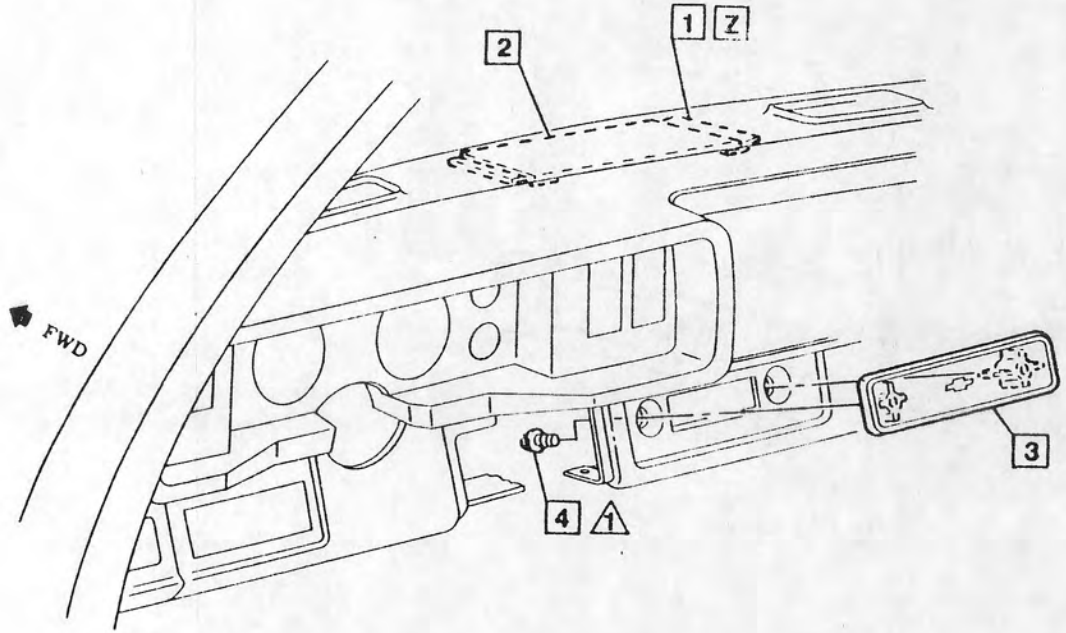
REF ECR 86448
C/O 21DE79
1A2B-3.1

L- 13307-S
L-
L-
L-

UPC 1A2B

SHEET 3.1

9985142	1	TAPE
3975828	2	COVER-SPKR HOLE
378721	3	COVER-RADIO HOLE
11503491	4	BOLT/SCREW



Z 5 in. 2 places.

DYNAMIC (Instal) N·m	HAND (Insp) N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
	1 1.2 - 1.6							
	2							
	3							
	4							
	5							

1 FULLY DRIVEN, SEATED & NOT STRIPPED

58

DATE 14JA80
DR R.SIENKIEWICZ
CK H/J Buick HB
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
COVERS-RADIO & SPEAKER
FA00 ALL

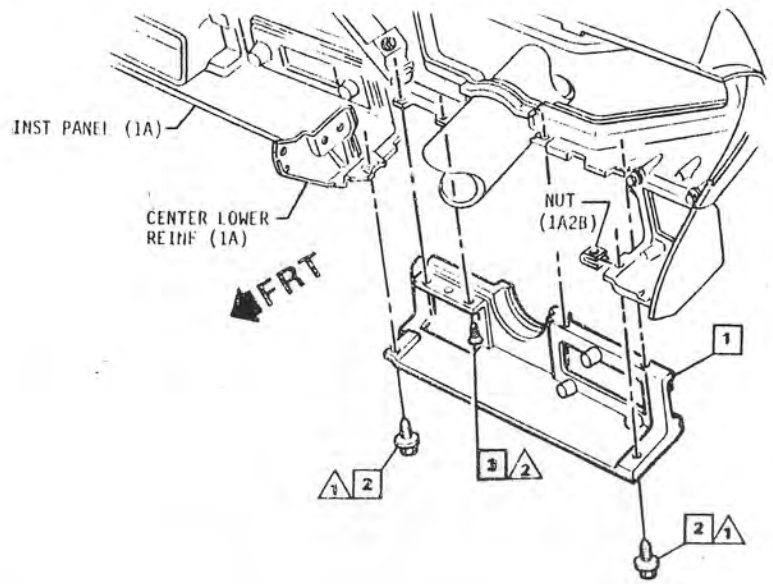
REF ECR 86448
C/O 210E79
1A2B-4

L-22191-S
L-90947-S
L-11307-S
L-93016-S

UPC 1A2B

SHEET 4

CH / B 0 P Co



(1) 469951	1	FILLER-INST PNL STRG COL OPEN'G (SHOWN) For specific releasing & additional part numbers, see Parts List.
11502836	2	BOLT/SCREW
11503409	3	BOLT/SCREW

DYNAMIC (Instal) N·m	HAND (Insp.) N·m
1	1.2 - 1.6
2	0.6 - 1.2
3	
4	
5	
1 FULLY DRIVEN, SEATED & NOT STRIPPED	

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
30JN80	1	WAS COVER INST PNL COL HOLE				
	2	TITLE REVISED	B329.3	4CA	HB	

DATE 14JA80
DR R.SIENKIEWICZ
CK HJ Buck HB
APPR S
APPR
APPR
APPR

59

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE STEERING COLUMN FILLER (2)
FA00 ALL

REF ECR 86448
C/O 14DE79
1A2B-4.1

L-90947-S
L-92889-S
L-93350-S
L-92019-S

UPC 1A2B

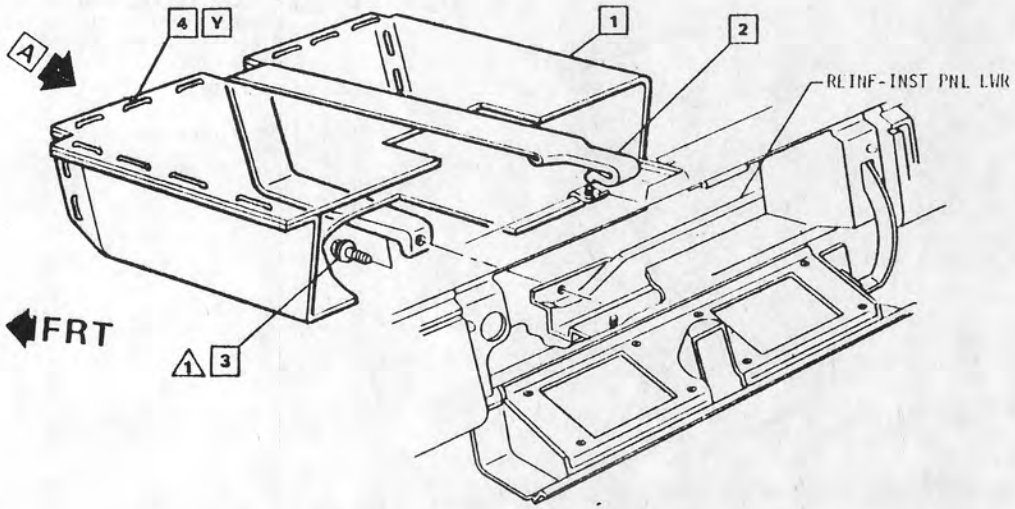
SHEET 4.1

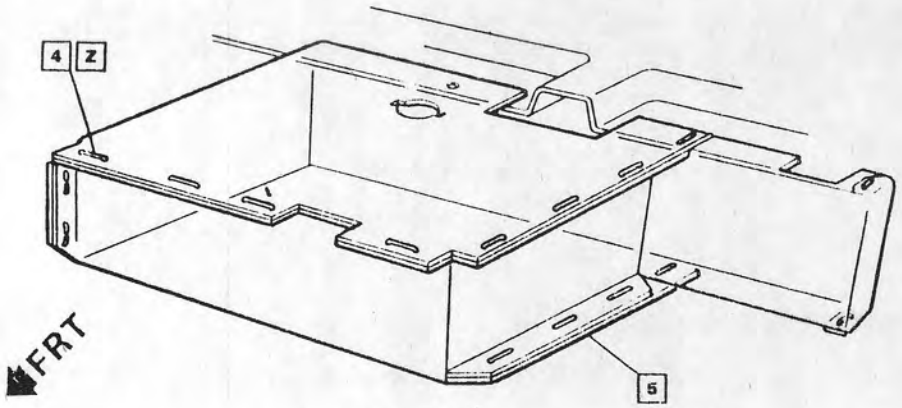
Ch X B O P Co

General Motors Corporation
CHEVROLET MOTOR DIVISION

PRODUCT DESCRIPTION MANUAL

☐ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF





VIEW A C60

3975883	1 COMPARTMENT ASM
3975885	2 STRAP
11502836	3 BOLT/SCREW
9423663	4 STAPLE
(/) 9985028	4 STAPLE-OPT
3975884	5 COMPARTMENT ASM &C60

Y STAPLE-14 places
Z STAPLE-16 places

DYNAMIC (Instal) N·m	HAND (Insp.) N·m
1	2.2 - 3.4
2	
3	
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
11/80	1	WAS WIRE OPT	93293	RCA	AE	

60

DATE 14JA80
DR R. SIENKIEWICZ
CK NJ Buck 11B
APPR S
APPR
APPR
APPR

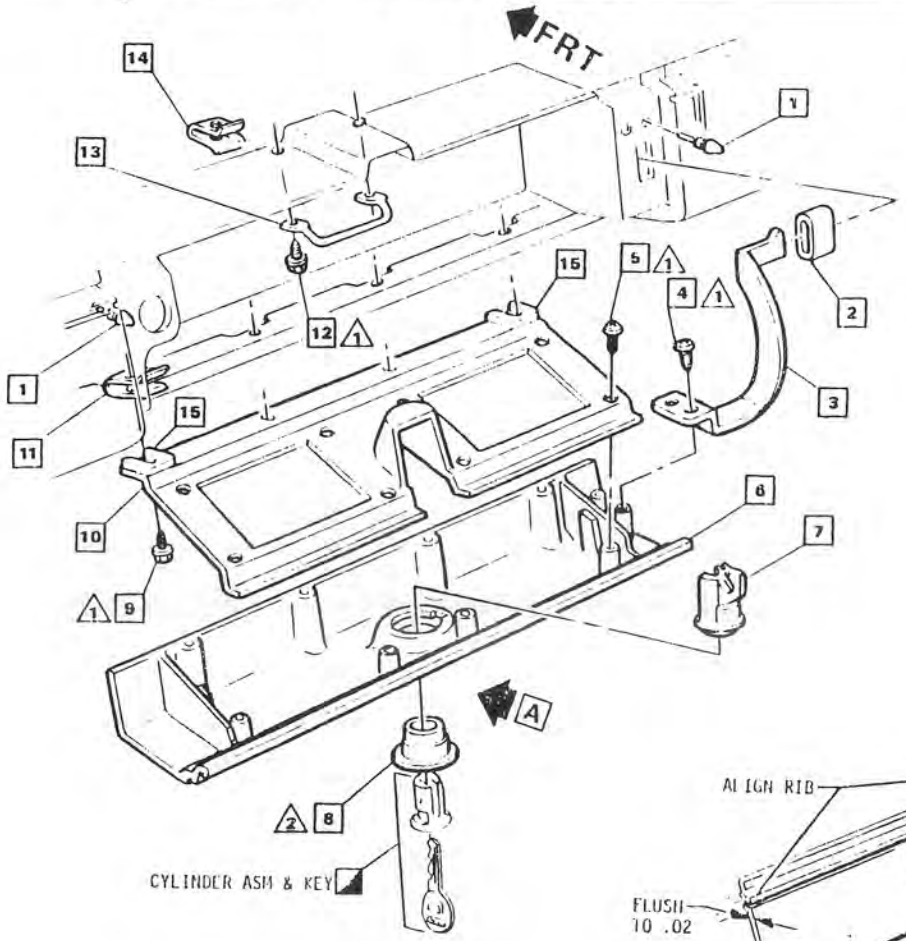
DIV CHEVROLET

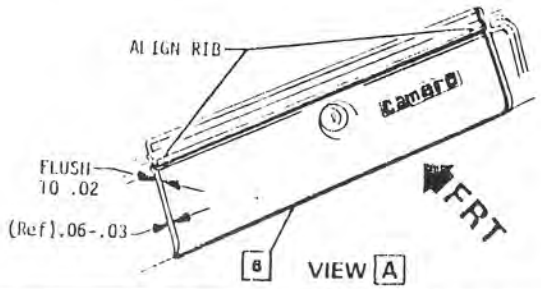
1981 CHEV. "F" 14020867

TITLE INSTRUMENT PANEL COMPARTMENT FA00

REF ECR 86448 C/O 30N079 1A2B-5
L- 90947-S L- 92426-S L- 95263-S L-
UPC 1A2B
SHEET 5

Ch X D O P Ca





3957096	1	BUMPER	
3820023	2	BUMPER STOP	
3994597	3	STOP	
11501012	4	BOLT/SCREW	
11501111	5	BOLT/SCREW	
14003602	6	*CHART-DOOR OUTER	
3991767	7	CASE	
(1) 3957093	8	BEZEL	
11503598	9	BOLT/SCREW	
(2) 3999447	10	PANEL-DR INR	
3975842	11	"U" NUT	
11503392	12	BOLT/SCREW	
3975839	13	STRIKER	
9427761	14	"U" NUT	
14007955	15	SHIM (As required approx 1 per job)	

INSTRUMENT PANEL COMPARTMENT
DOOR ADJUSTMENT

Install Instrument Panel Compartment Door and adjust striker for flush surface fit.

Align .05 wide rib on Instrument Panel or with mating rib on Instrument Panel by shimming as required the end attachments only on the Door Hinge.

*(UPC "0"-P/L)

DYNAMIC (Install) N·m	HAND (Insp.) N·m
1 1.2 - 1.6	
2 2.2 - 2.8	
3	
4	
5	
1 FULLY DRIVEN, SEATED & NOT STRIPPED	

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
11/1/80	1	WAS ESCUTCHEON				
	2	WAS DOOR-INR	8329	ACA	ME	

DATE 14JAN80
DR SIENKIEWICZ/ACA
CK 7/1 Buick 11B
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE INSTRUMENT PANEL COMPT DOOR
FA00 ALL

REF ECR 86448
C/O 30N079
1A2B-6

L-90947-S
L-18262-S
L-
L-

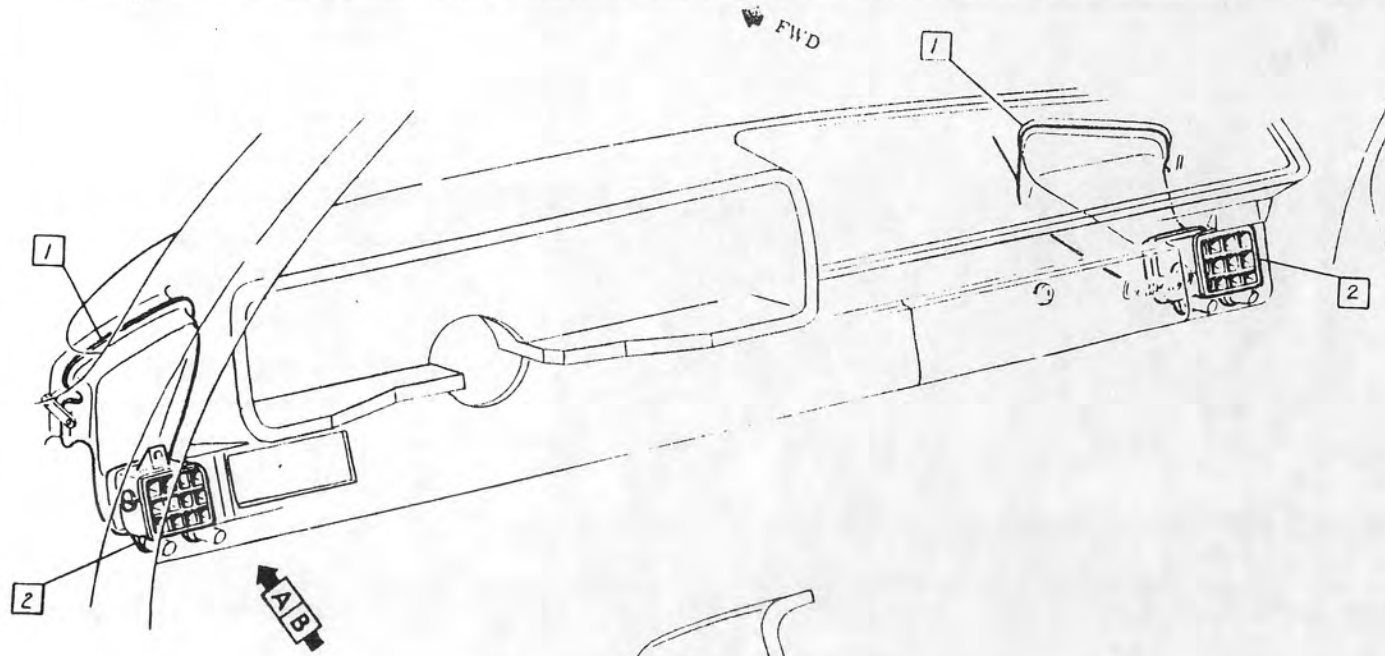
UPC 1A2B

SHEET 6

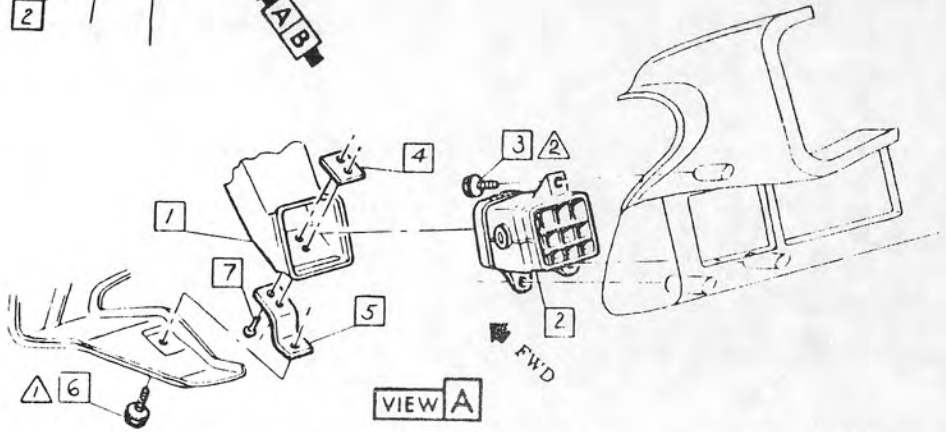
Ch X B O P Ca

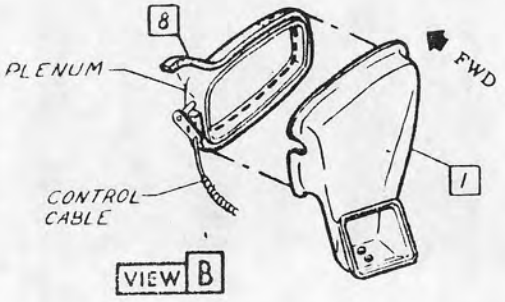
PRODUCT DESCRIPTION MANUAL

☐ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF



3967927-8	1	DUCT L & RH
6262667-8	2	OUTLET ASM L & RH
11503393	3	BOLT/SCREW
3967942	4	REINF
3967941	5	BRACKET
9419303	6	BOLT/SCREW
9428358	7	RIVET
3973733-4	8	SEAL L & RH





DYNAMIC (Install) N·m	HAND (Insp.) N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
	△1 2.2 - 3.4							
	△1 1.6 - 2.2							
	△1							
	△1							
	△1							

△1 FULLY DRIVEN, SEATED & NOT STRIPPED

62

DATE 14JA80
DR SIENKIEWICZ/ACA
CK 7/9 Buick HB
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
UPPER LEVEL VENTILATION
FA00 ALL

REF ECR 86448
C/O 30N079
1A2C-1

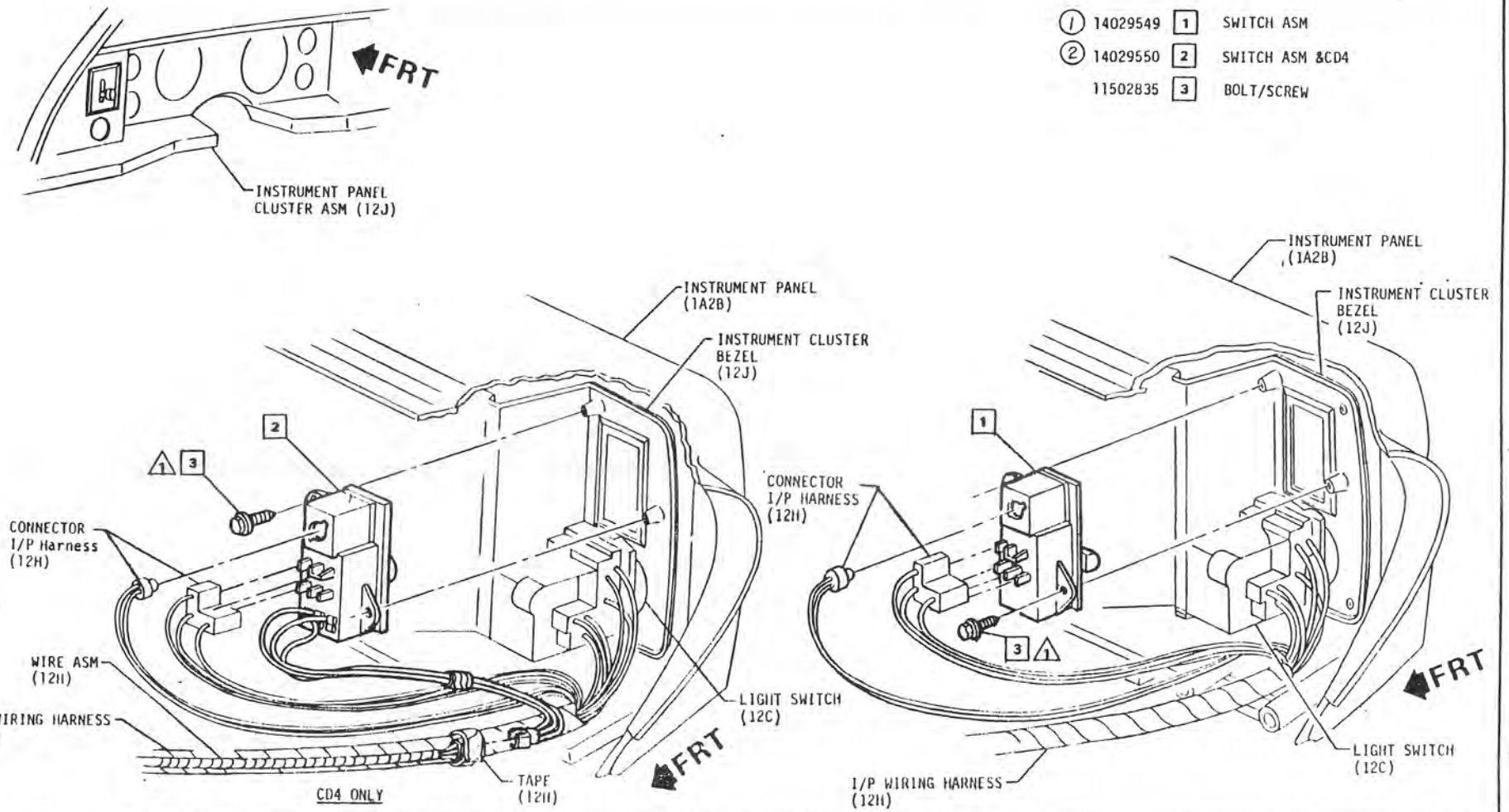
L-90947-S
L-91875-S
L-
L-

UPC **1A2C**

SHEET **1**

Ch X B D P Co

(1)	14029549	1	SWITCH ASM
(2)	14029550	2	SWITCH ASM &CD4
	11502835	3	BOLT/SCREW



DYNAMIC (Install) N·m	HAND (Insp) N·m
1	1.6 - 2.2
2	
3	
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
20JN80	1	WAS 14001501 SWITCH ASM				
	2	WAS 14009296 SWITCH ASM	85220	MCA	HB	

63

DATE 18JA80
DR C.KINGSLEY
CK R/J Buick HB
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE WINDSHIELD WASHER SWITCH FA00 &CD4

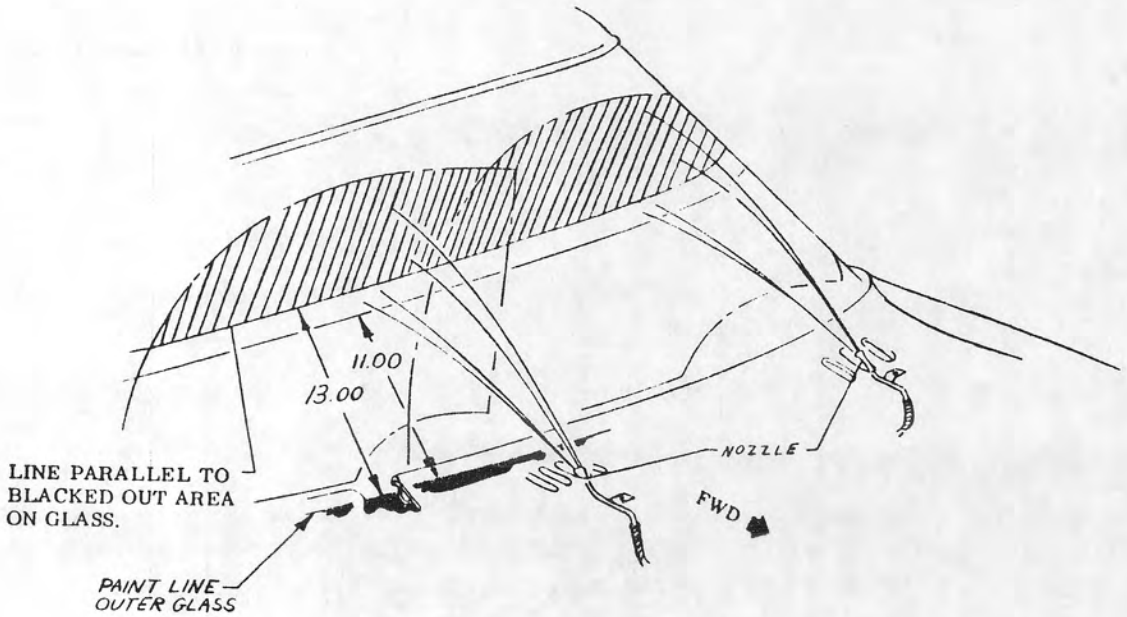
REF ECR 86448
C/O 18JA80
1A2D-2

L-13889-S
L-22004-S
L-
L-

UFC 1A2D

SHEET 2

Ch X B O P Cu



NOZZLE AIM

AIM BOTH NOZZLES SO THAT SPRAY IS WITHIN WIPER PATTERN & ABOVE 13 INCH LINE.

NOTE One stream from each nozzle may fall between 11 & 13 inch lines provided other stream is in specified target area.

DYNAMIC (Instal) N·m	HAND (Insp) N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
1 2 3 4 5								

1 FULLY DRIVEN SEATED & NOT STRIPPED

DATE 7/AJABO
DR C. KINGSLEY/ACA
CK R.J. Rau R. HB
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE WINDSHIELD WASHER SPRAY PATTERN FA00 ALL

REF ECR 86448 C/O 30H079 1A2D-3

1-08591-S

UPC 1A2D

SHEET 3

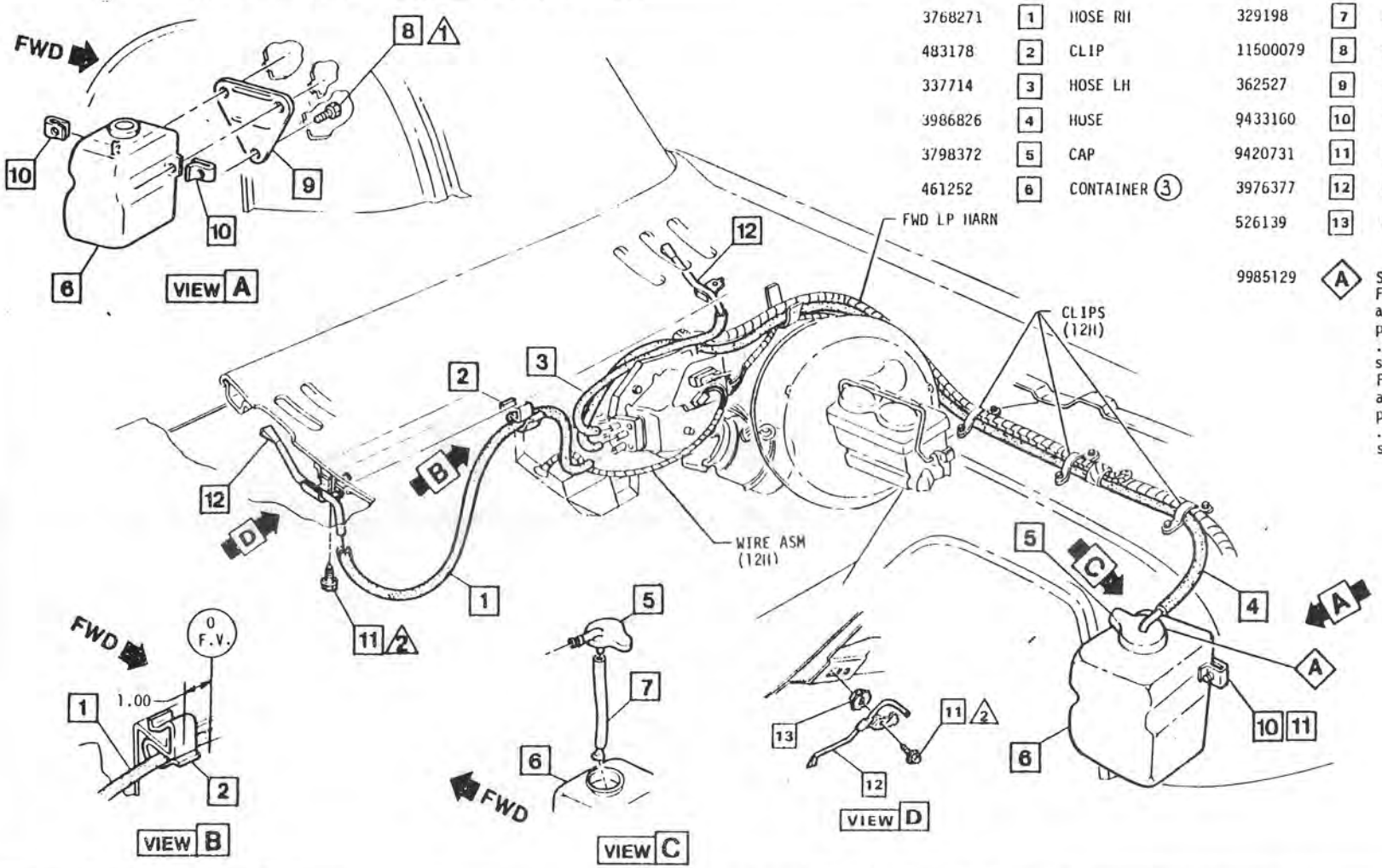
Ch B O P Co

PRODUCT DESCRIPTION MANUAL

□ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF

3768271	1	HOSE RH		329198	7	HOSE ASM (2)
483178	2	CLIP		11500079	8	BOLT/SCREW
337714	3	HOSE LH		362527	9	BRACKET
3986826	4	HOSE		9433160	10	"U" NUT
3798372	5	CAP		9420731	11	BOLT/SCREW
461252	6	CONTAINER (3)		3976377	12	NOZZLE ASM
FWD LP HARN				526139	13	NUT
				9985129	A	SOLVENT

SOLVENT
From Oct 1 to Mar 31 approx. .04 Gal. solvent per job to be mixed with .08 Gal. water to protect system to approx. 0°F.
From April 1 to Sept 30 approx. .01 Gal. solvent per job to be mixed with .11 Gal. water to protect system to approx. +24°F.



DYNAMIC (Install) N·m	HAND (Insp.) N·m
	1 4.6 - 7.0
(1)	1 1.4 - 2.0
	1
	1
	1

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
4/MAY/80	1	TORQUE (2) WAS 1.2-1.6 N·m (PC0550)	88765	ACA		
20JUN80	2	WAS FILTER				
	3	WAS JAR	86816	ACA		

65

DATE 18JA80
DRC. KINGSLEY/ACA
CK NJ Buick HB
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE WINDSHIELD WASHER JAR, HOSES & NOZZLES
FA00 ALL

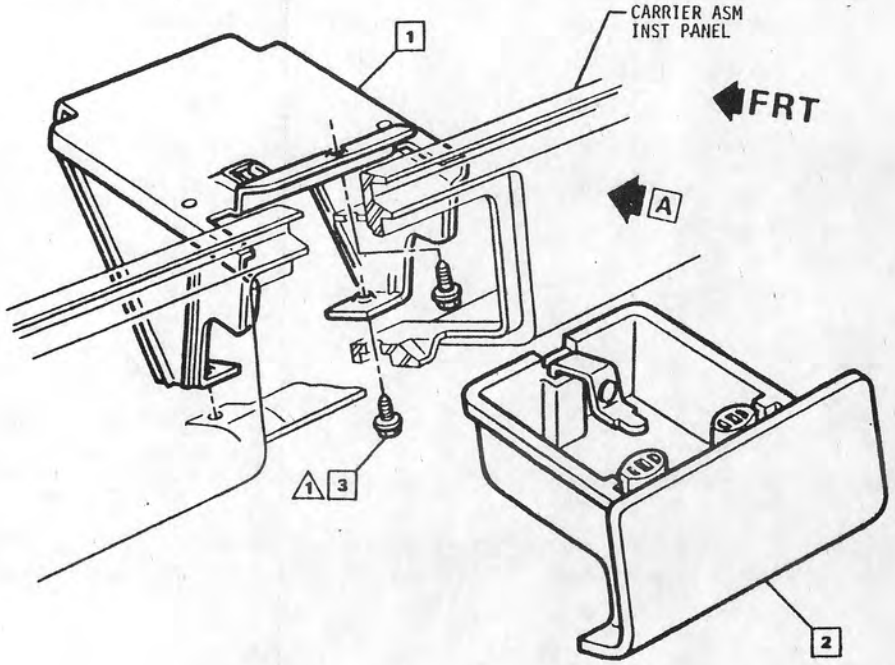
REF ECR 86448
C/O 18JA80
1A2D-4

L- 08591-S
L-
L-
L-

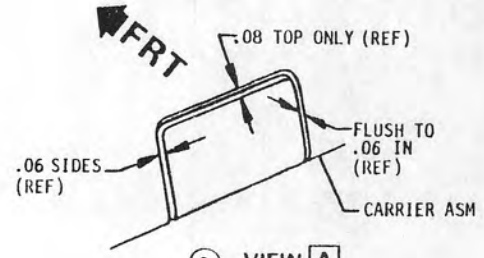
UPC 1A2D

SHEET 4

Ch X B O P Co



1	332028	HOUSING ASM
2	14013883	CHART-TRAY ASM (UPC "0"-P/L)
3	11503395	BOLT/SCREW



② VIEW A INSTALLED

DYNAMIC (Install) N·m	HAND (Insp.) - N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
	1.6 - 2.2	11JL80	1	WAS RETAINER ASM	86816	ACA	[illegible]	
		09AP81	2	"REF" ADDED TO ALL DIMENSIONS IN VIEW A (PC0598)	88765	ACA	[illegible]	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

Ch X B D P Co

66

DATE 14JA80
DR SIENKIEWICZ/ACA
CK FJ Buick HB
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE ASH TRAY ASSEMBLY
FA00 ALL

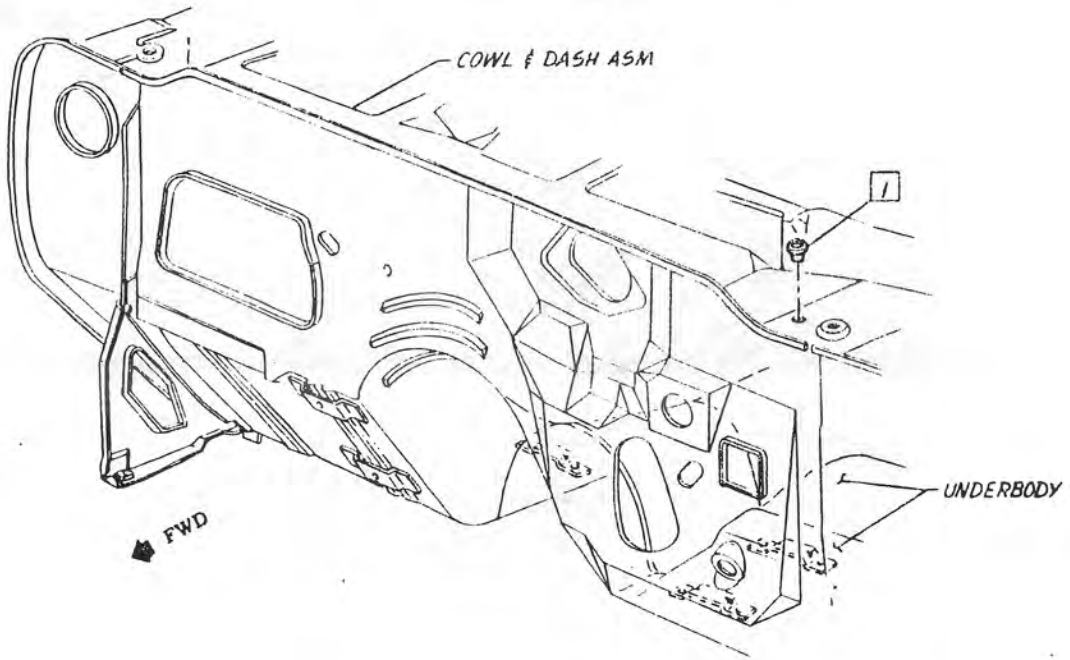
REF ECR 86448
C/O 30N079
1A2E-1

L-02454-S
L-
L-

UPC 1A2E

SHEET 1

1238221 [1] PLUG



DYNAMIC (Install) N·m	HAND (Insp.) N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
⚠1 FULLY DRIVEN SEATED & NOT STRIPPED								

DATE 14JA80
DR R.STENKIEWICZ/ACA
CK 7/9 Rec'd HB
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
COWL PLUG
FA00 ALL

REF ECR 86448
C/O 30N079
1A2E-2

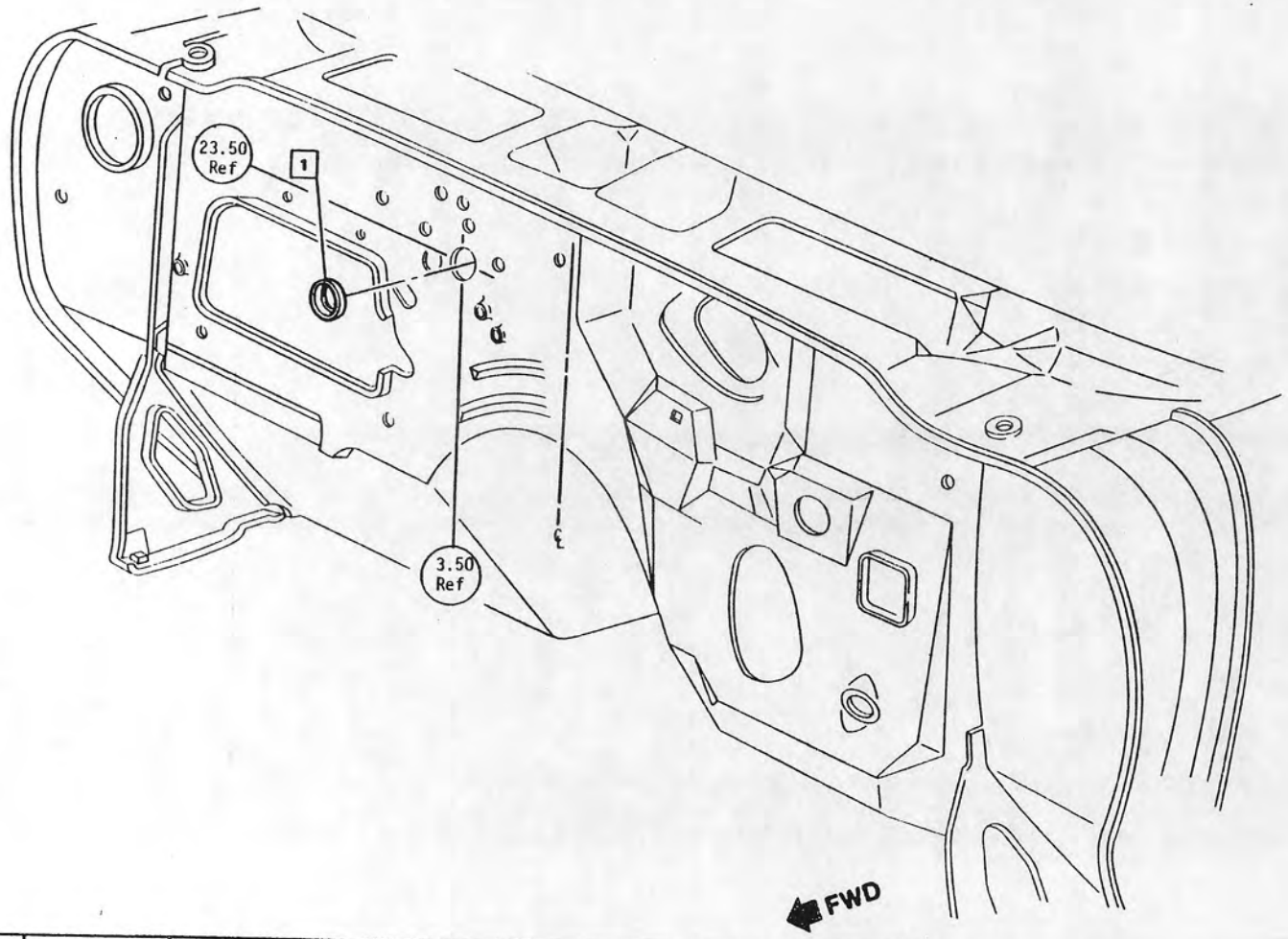
L 89800-S
L 06097-S

UPC 1A2E

SHEET 2

Ch | B | U | P | Co

20218490 [1] PLUG



DYNAMIC (Instal) N·m	HAND (Insp.) N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
1								
2								
3								
4								
5								

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

Ch X B O P Ca

68

DATE 16MY80
DR R.SIENKIEWICZ
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

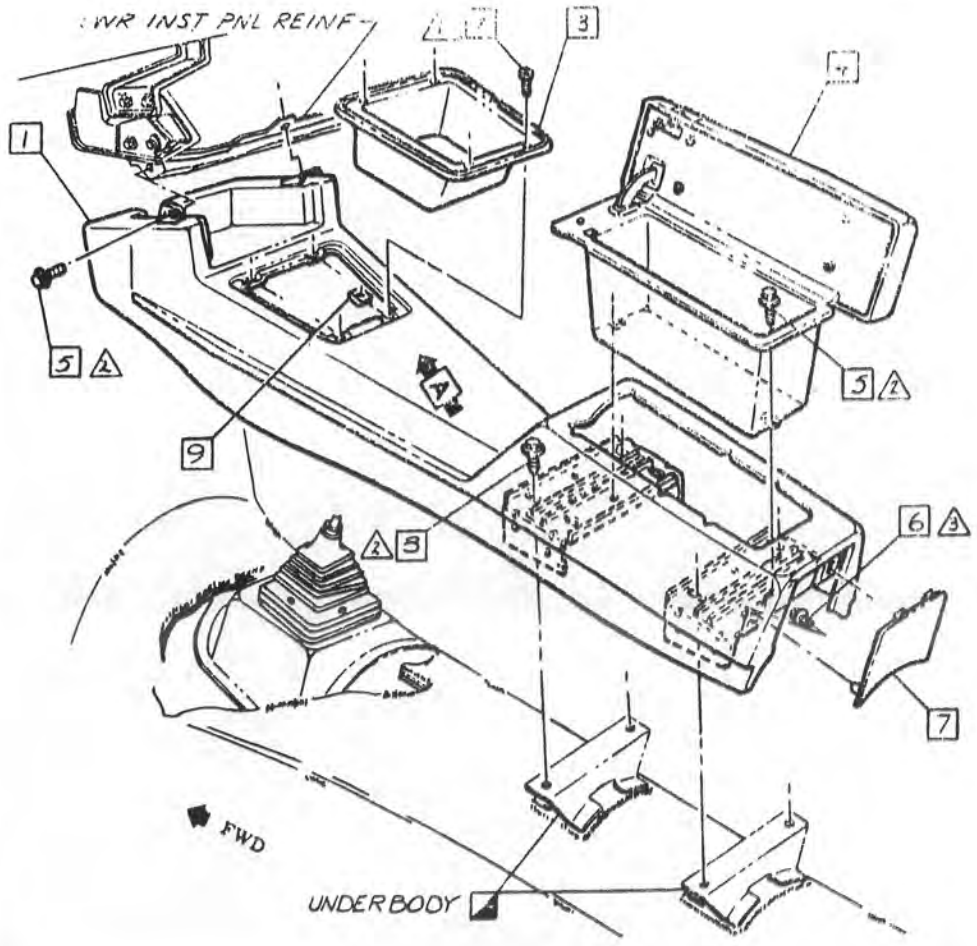
TITLE
DASH PANEL PLUG
FA00 &NM4

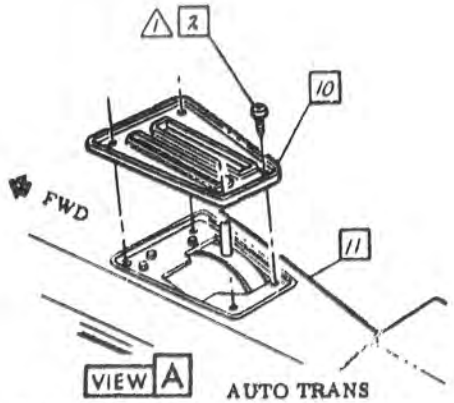
REF ECR 89091
NEW 16MY80

11-22003-S
1-
1-
1-

UPC 1A2E

SHEET 2.1





+	332145	1	*CHART-PANEL ASM
	489941	2	BOLT/SCREW
	478571	3	PLATE ASM
+	332133	4	*CHART-DOOR & COMPT ASM
	9419322	5	BOLT/SCREW
	9419305	6	BOLT/SCREW
+	332153	7	*CHART-PLATE
	9422601	8	BOLT/SCREW
	480133	9	NUT
+	14013897	10	*CHART-PLATE ASM
+	332141	11	*CHART-PNL ASM & M33

AUTO TRANS

*(UPC "0" - P/L)

DYNAMIC (Install) N·m | HAND (Insp.) N·m

△1 1.6 - 2.2
△2 2.2 - 3.4
△3 1.2 - 1.6
△4
△5

△1 FULLY DRIVEN SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG

DATE 1-15-80
DR STENATEWICZ/ACA
CK [illegible] Buck HB
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE CONSOLE, DOOR ASM, & PLATES
FA00 ALL

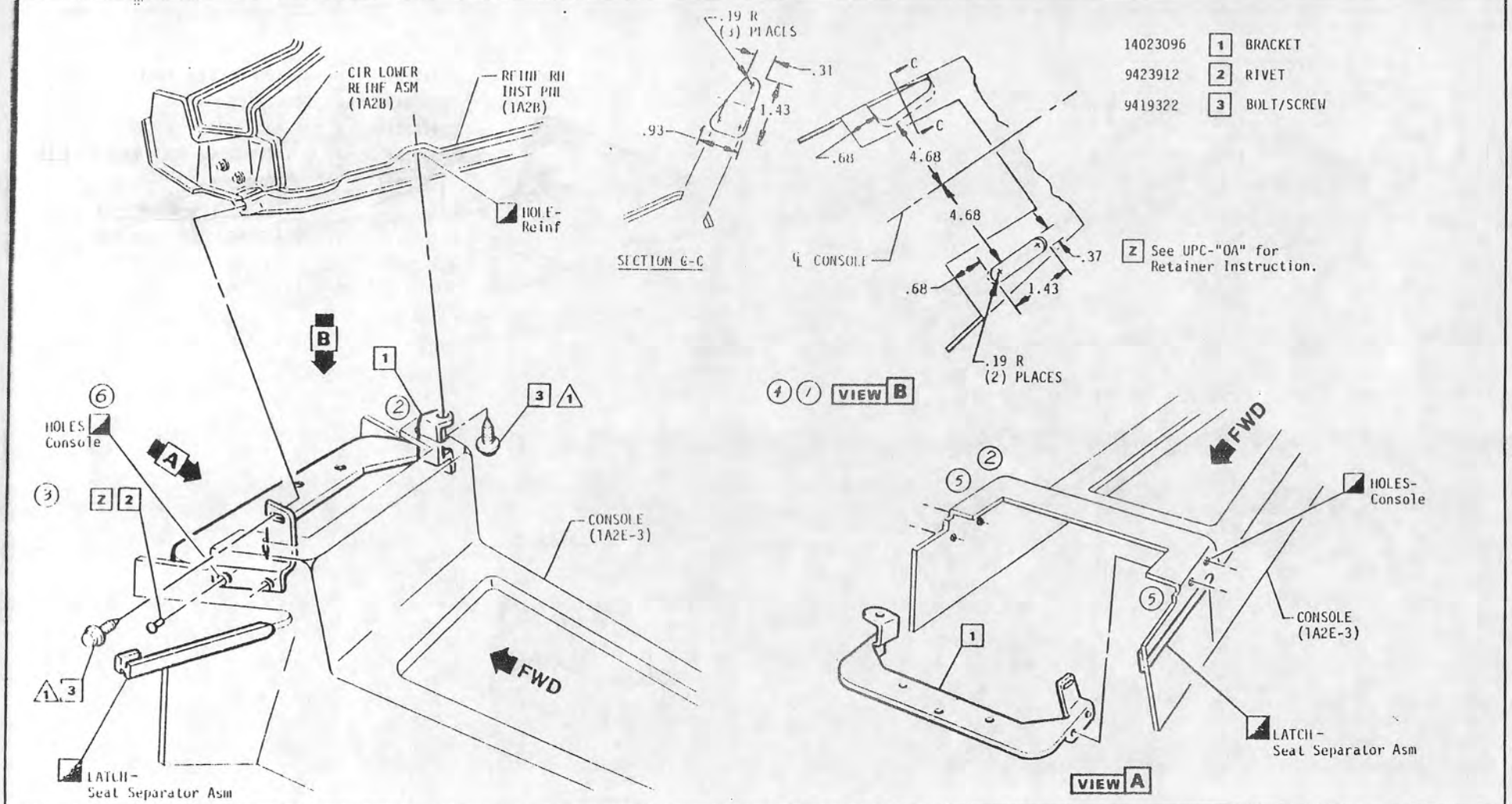
REF FCR 86448
C/O 30N079
1A2E-3

01216-S

UPC 1A2E

SHEET 3

Ch [X] B [ ] O [ ] P [ ] Cu [ ]



DYNAMIC (Install) N·m	HAND (Insp.) N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
	1 2.2 - 3.4	8/JAN/80	1	VIEW "B" ADDED				C
	2		2	CONSOLE DRAWING REVISED (2) PLACES				
	3		3	HOLE INFO ADDED	B9303	ACA	RC	C
	4	09/NOV/81	4	VIEW "B" REVISED				
	5		5	CONSOLE DRAWING REVISED (2) PLACES	B9303	ACA	[illegible]	
	6	15/FEB/83	6	WAS .218 DIA (4) HOLES; LOCATING DIMENSIONS REMOVED	B5448	ACA	[illegible]	C

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE 18JAN80
DR STENKIEWICZ/ACA
CK H.J. Buck HB
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE BRACKET-CONSOLE
FA00 ALL

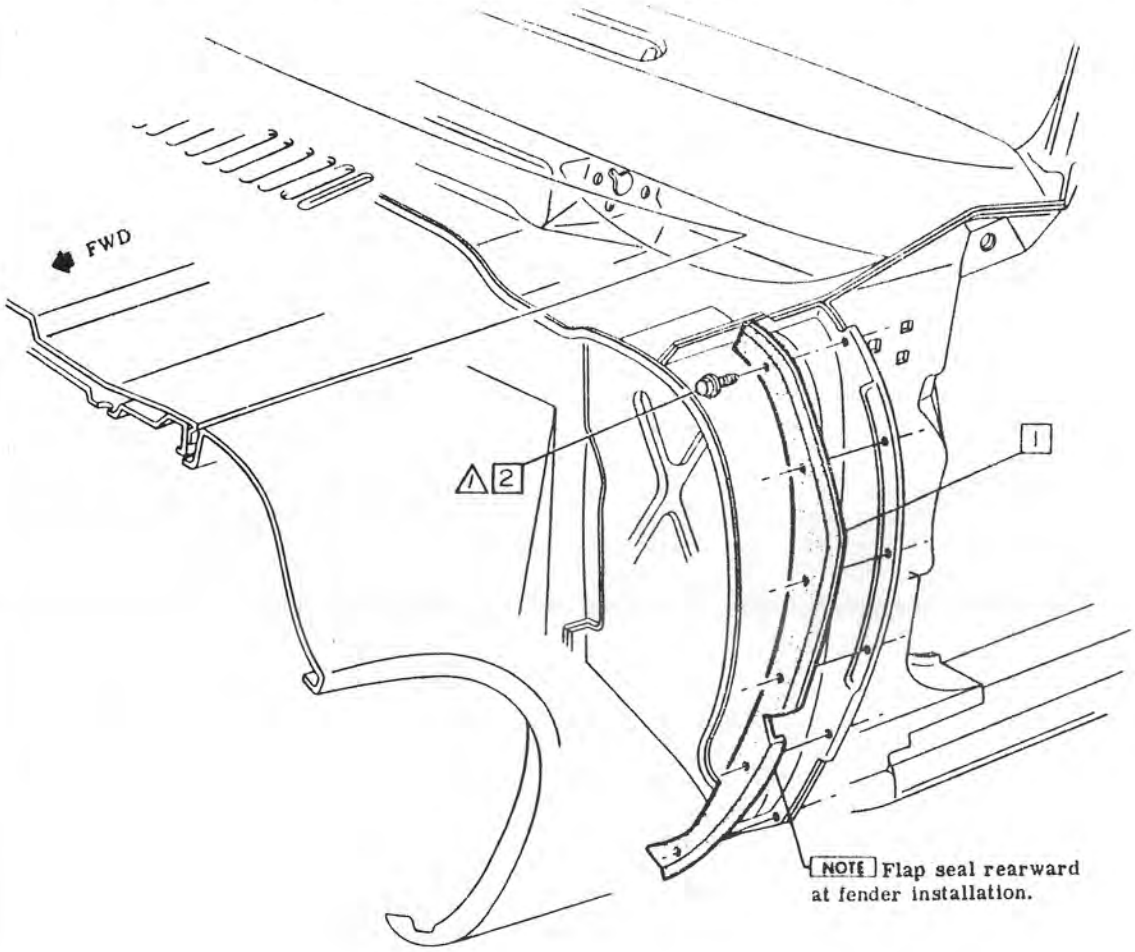
REF ECR 86448
NEW 240C79

L-01216-S
L-
L-
L-

UPC 1A2E

SHEET 3.1

C X B O P Co



3967116	1	SEAL
11503382	2	BOLT/SCREW

NOTE Flap seal rearward at fender installation.

DYNAMIC (Install) N·m	HAND (Insp.) N·m
1 1.6	
2	
3	
4	
5	

1 FULLY DRIVEN SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG

DATE 11/21/80
DR C. LEWANDOWSKI/ACA
CK [illegible]
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE FRONT FENDER SEAL F A00 &BS1

REF ECR 86448 C/O 210L79 1A2E-4

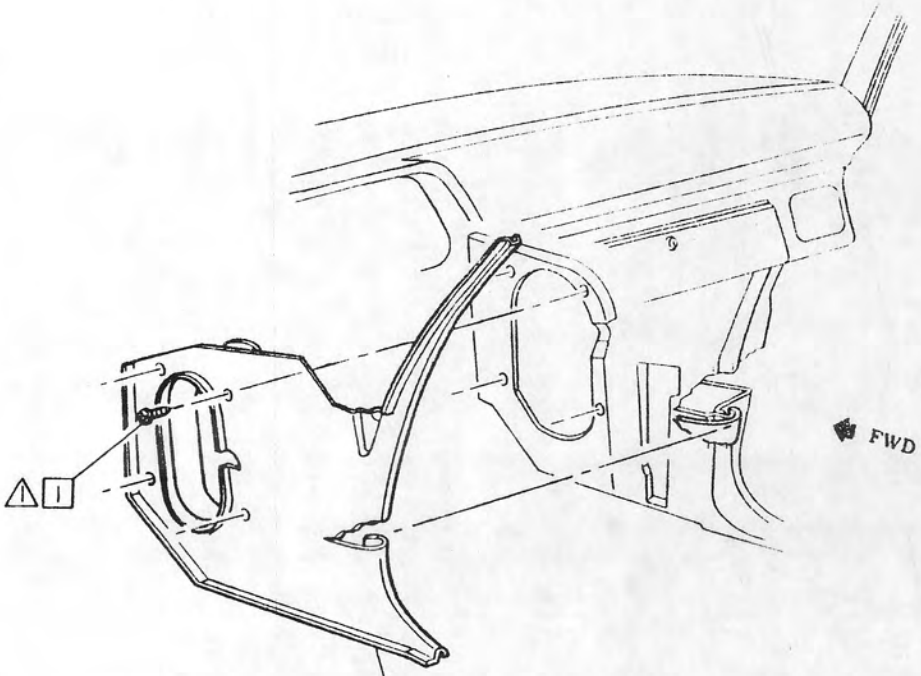
E 89731-

UPC 1A2E

SHEET 4

Ch [illegible] B [illegible] U [illegible] P [illegible] Ca [illegible]

20007112 [1] BOLT/SCREW



PANEL-SHROUD SIDE FINISHING
Fisher Body

DYNAMIC (install) N·m	HAND (insp) N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
	△1 1.6 - 2.7							
	△2							
	△3							
	△4							
	△5			72				
	△ FULLY DRIVEN SEATED & NOT STRIPPED							

DATE 14JAN80
DR SMOTHERMAN/ACA
CK H. Black-HB
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE SHROUD SIDE FINISHING PANEL
FA00 &C60

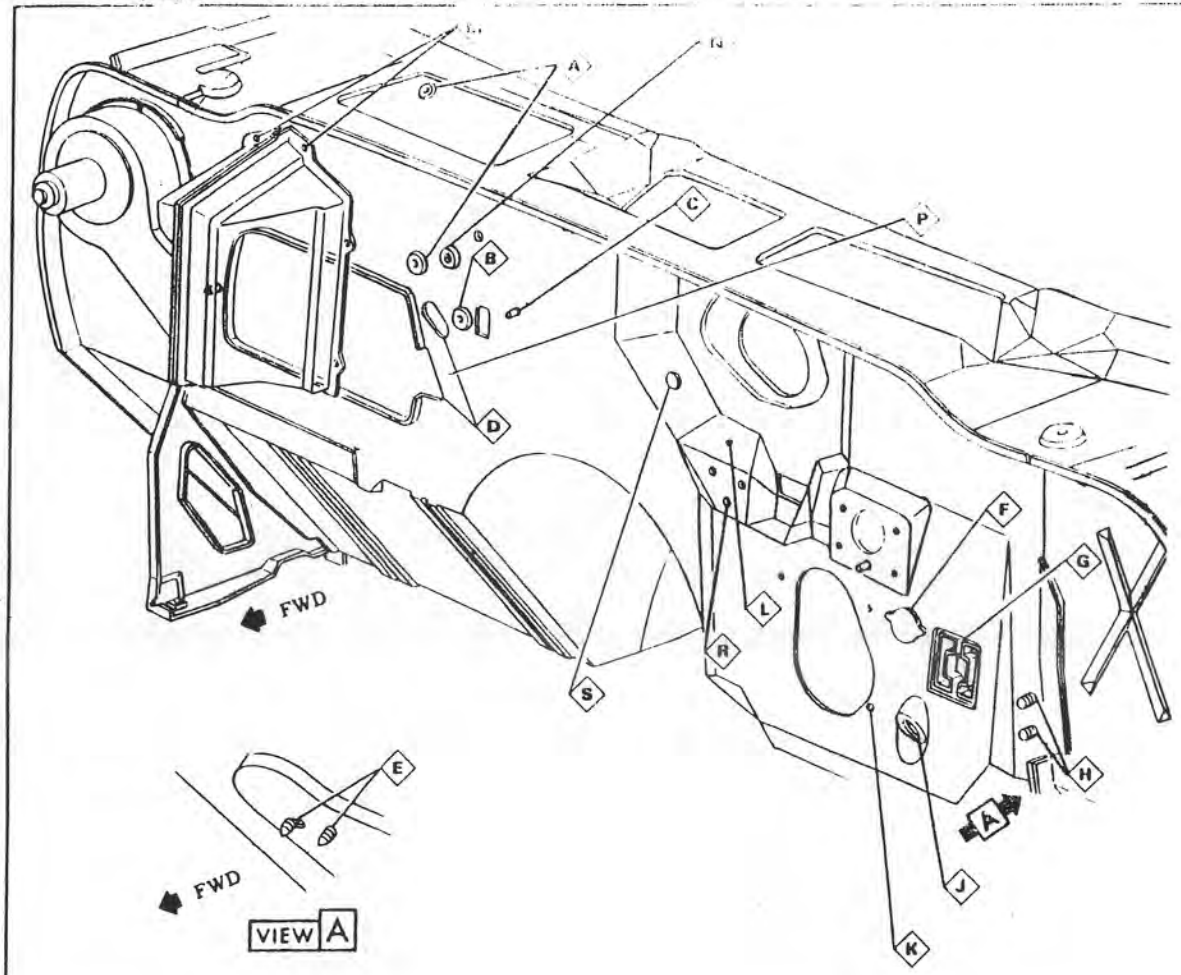
REF ECR 86448
C/O 21DE79
1A2E-S

L 9543-S
L
L
L

UPC 1A2E

SHEET 5

S | B | G | F | Co



#9980664 Ⓐ	SEALER A/C VACUUM HOSE GROMMET TO DASH .10 OZ.
Ⓑ	A/C HARN GROMMET .10 OZ.
Ⓒ	DASH MAT RETAINERS (3) .50 OZ.
Ⓓ	HEATER PIPES .30 OZ.
Ⓔ	DIMMER SWITCH ASM-.10 OZ.
Ⓕ	CLUTCH HOLE SEAL .10 OZ.
Ⓖ	FUSE PANEL ASM .20 OZ. Attacning Screws only.
Ⓗ	PARK BRAKE HOLE .10 OZ.
Ⓙ	SPEED CABLE GROMMET DASH .10 OZ.
Ⓚ	STRG COLUMN LWR MTG TO DASH .20 OZ.
Ⓛ	ACCEL CONT CABLE TO DASH .006 LBS
Ⓜ	EVAP BLOWER ASM-5.00 OZ.
Ⓝ	HEATER HARN GROM-.10 OZ.
Ⓟ	HEATER PIPES SEAL CUTOUT -.20 OZ.
Ⓡ	ACCEL PEDAL ROD BRKT-.006 LBS
Ⓢ	PULSE WSW SWITCH ASM GROMMET-.10 OZ.

DYNAMIC (Install) N·m	HAND (Insp) N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG

1 FULLY DRIVEN SEATED & NOT STRIPPED

DATE 14JA80
DR SIENKIEWICZ/ACA
CK HJ Beck LHB
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
FRONT OF DASH SEALING
FA00 ALL

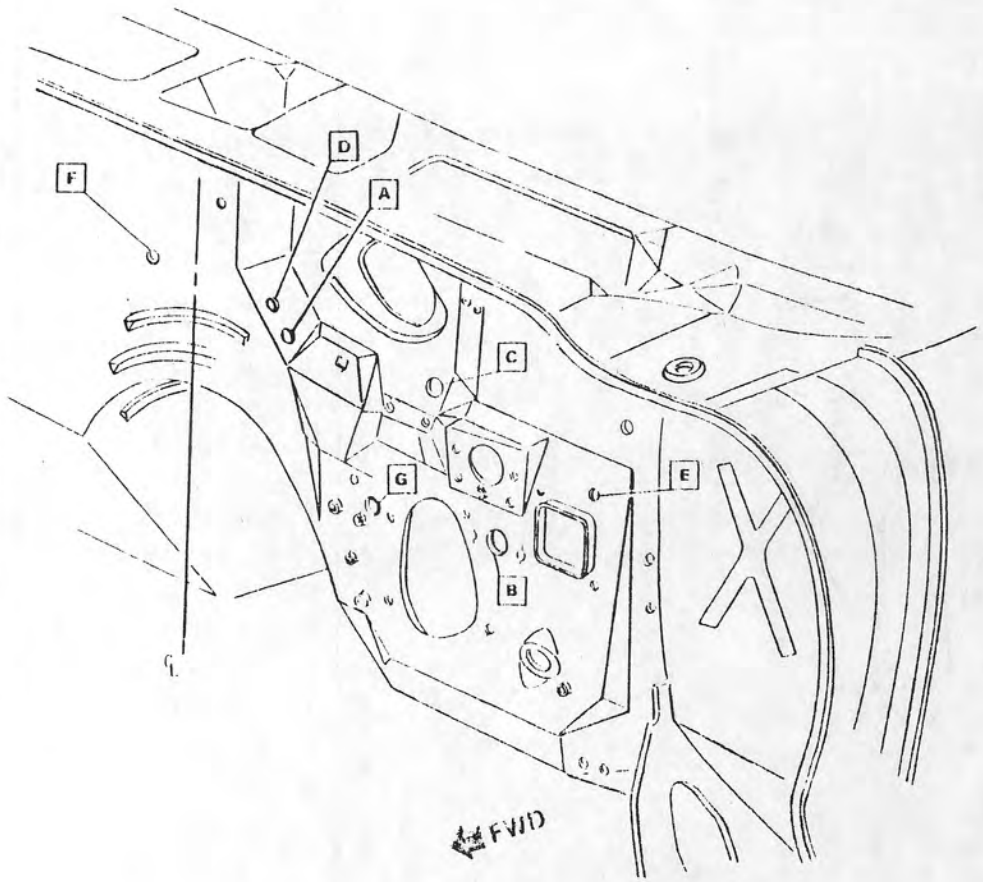
REF ECR 86448
C/O 21DE79
1A2E-6

L- 96414-S
L- 13889-S
L-
L-

UPC 1A2E

SHEET 6

Ch - B O P Co



[A] 1.50 DIA HOLE-At existing dimple U83

[B] 2.00 DIA HOLE-At existing dimple (/6) M15/M20/M21

[C] .75 DIA HOLE-At existing dimple for Tach wire U14

[D] 13.0mm DIA HOLE-AT EXISTING dimple for WSW Pulse Cont Wire CD4

1.50 DIA HOLE-At existing dimple for Cruise Control Wire K35

[F] 2.17 (55.0 mm) DIA HOLE-At existing dimple for CLCC Harness NB2

[G] 1.00 Dia Hole - At existing dimple for hood louver solenoid Z28

[NOTE] See 1A1 for existing hole & dimple location.

DRAWING (Initial)	HARD (Temp)	NEW
1		
2		
3		
4		
5		

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ENG CHG
[illegible]	7	TITLE REVISED	[illegible]	[illegible]	[illegible]	

DATE [illegible]
DR R. STEMPIENIEWICZ
CK [illegible] TH
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE COWL & DASH ASM-HOLE PIERCING & DIMPLE IDENTIFICATION FA00 ALL (1)

REF ECR 86448
C/O 09AP80
1A2E-7

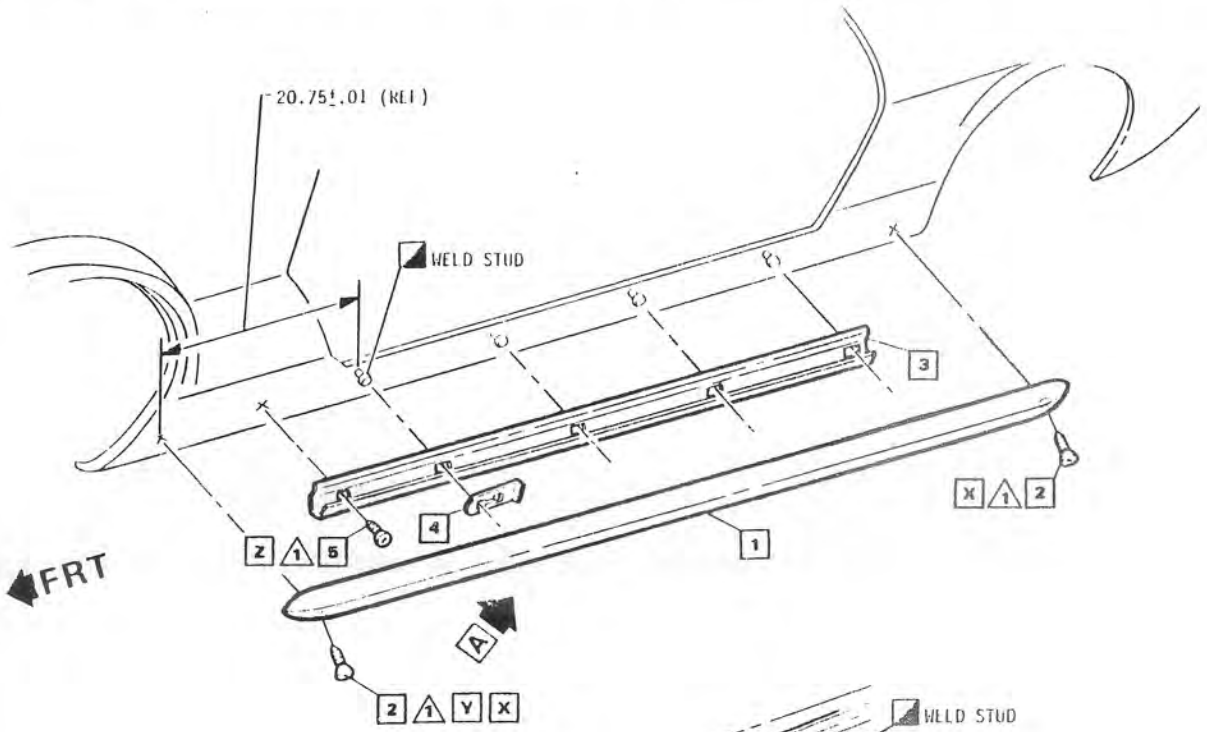
L-89731-S
L-08168-S
L-08399-S
L-19051-S

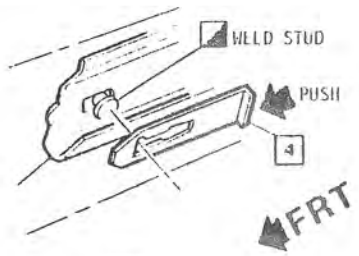
UPC 1A2E

SHEET 7

74

CK X I O P Co





VIEW A

480846	1 MOLDING
11503544	2 BOLT/SCREW
3899871	3 RETAINER
/ 4510031	4 RETAINER
11501609	5 BOLT/SCREW

X Refer to UPC 0-A for appearance item screws
Y Use 1 as Template.
Z Use 3 as Template.

DYNAMIC (Install) N·m	HAND (Insp.) N·m
△1 1.2-1.6	
△2	
△3	
△4	
△5	

△1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
4/1/80	1	W/S CLIP	38274	MCA	RZ	

DATE 14JAN80
DR R.SIENKIEWICZ
CK HJ Buick HB
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE BODY SILL MOLDING
FP00 ALL

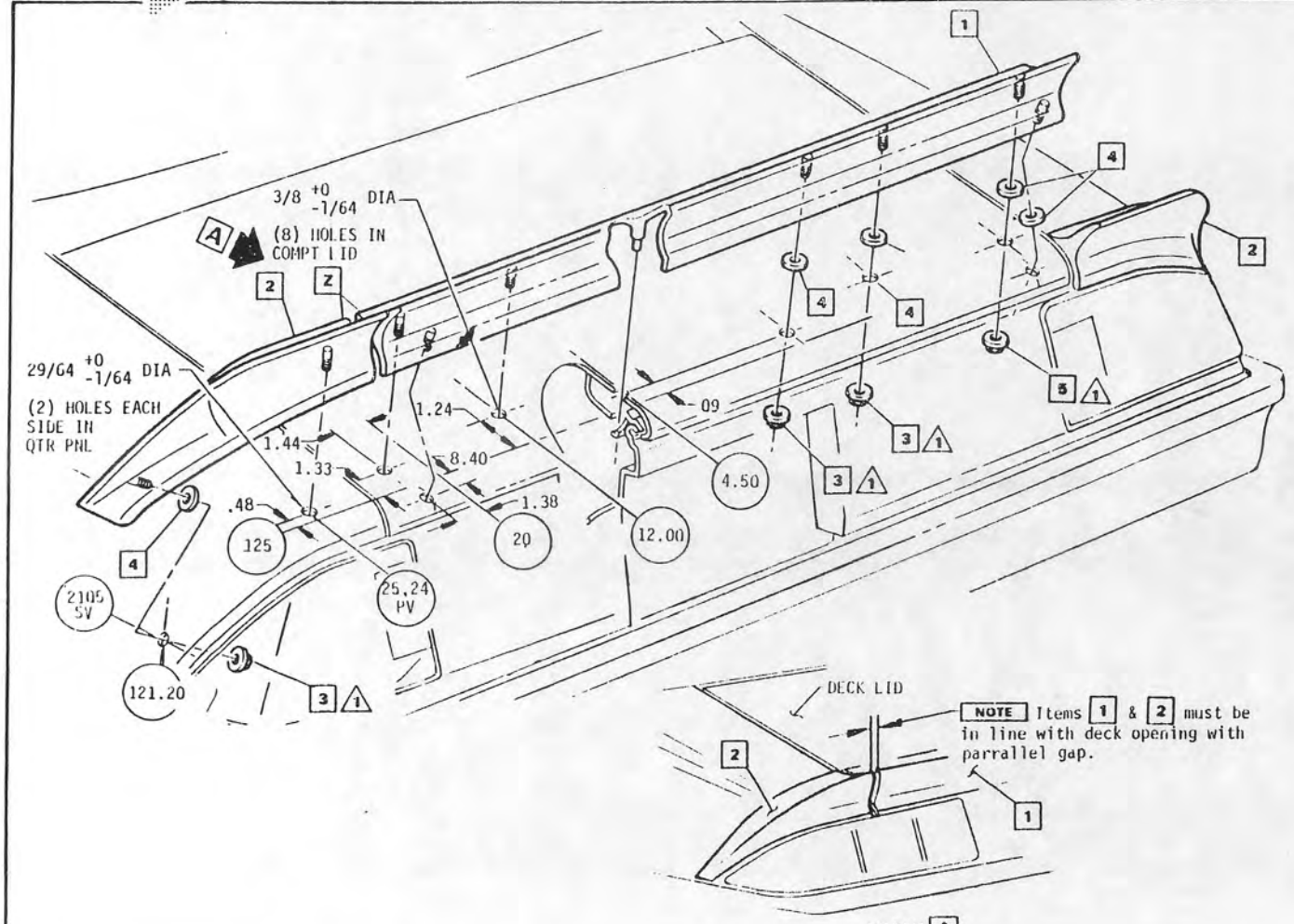
REF ECR 86448
C/O 21DE79
1A2F-1

L-12038-S
L-
L-
L-

UPC 1A2F

SHEET 1

Ck X B O P Co



480161	1 SPOILER ASM
339433-4	2 EXT ASM-OUTER L & RH
4801719	3 NUT ASM
7583551	4 SEAL
4821092	5 NUT ASM

VIEW A

NOTE Items 1 & 2 must be in line with deck opening with parrallel gap.

Z Care must be taken to align 1 & 2 fore & aft.

DYNAMIC (Install) N·m	HAND (Insp.) N·m
1	5.0 - 8.0
2	
3	
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
11/1/80	1	WAS EXTENSION ASM				
	2	WAS WASHER	86816	ACME		

DATE 14JA80
DR SIENKIEWICZ/ACA
CK WJ Buck 1/16
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE REAR SPOILER FA00 &D80

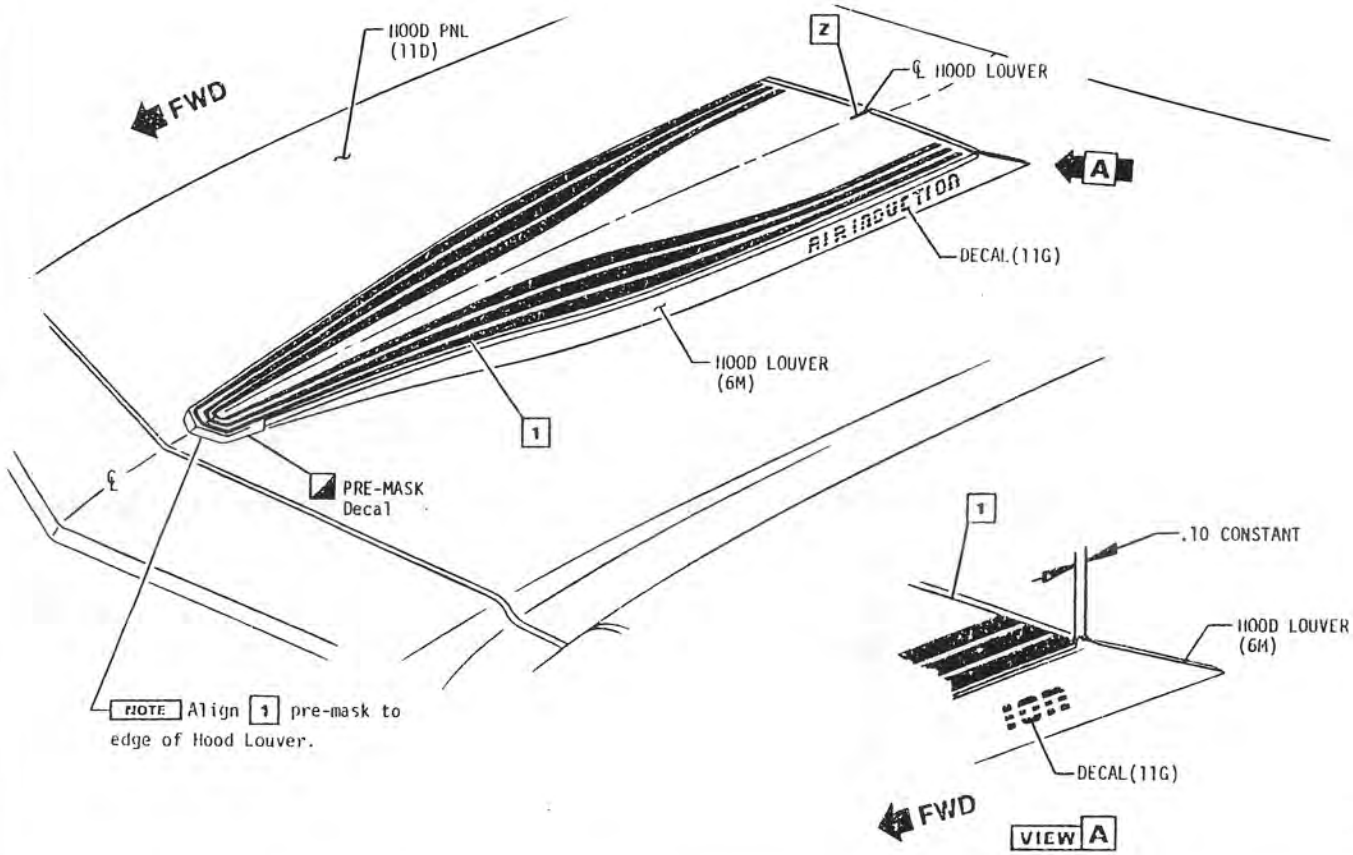
REF ECR 86448 C/O 21DE79 1A2F-2

L-02692-S L-96362-S L- L-

UPC 1A2F

SHEET 2

14018480 [1] CHART-BODY DECAL (UPC "0"-P/L)



NOTE All dimensions are on surface.

NOTE Refer to UPC-"0A" Decal Application Procedure for proper installation.

Z Align centerline mark on pre-mask with centerline of Hood Louver.

DYNAMIC (Install) N·m	HASD (Insp.) N·m
1	
2	
3	
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
9MY80	1	REDRAWN & REDESIGNED 59494	99843	ACH	ZH	

DATE 15FEB0
DR SIENKIEWICZ/ACA
CK WJ Buick 11B
APER S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE DECAL-HOOD LOUVER FP00 &Z28

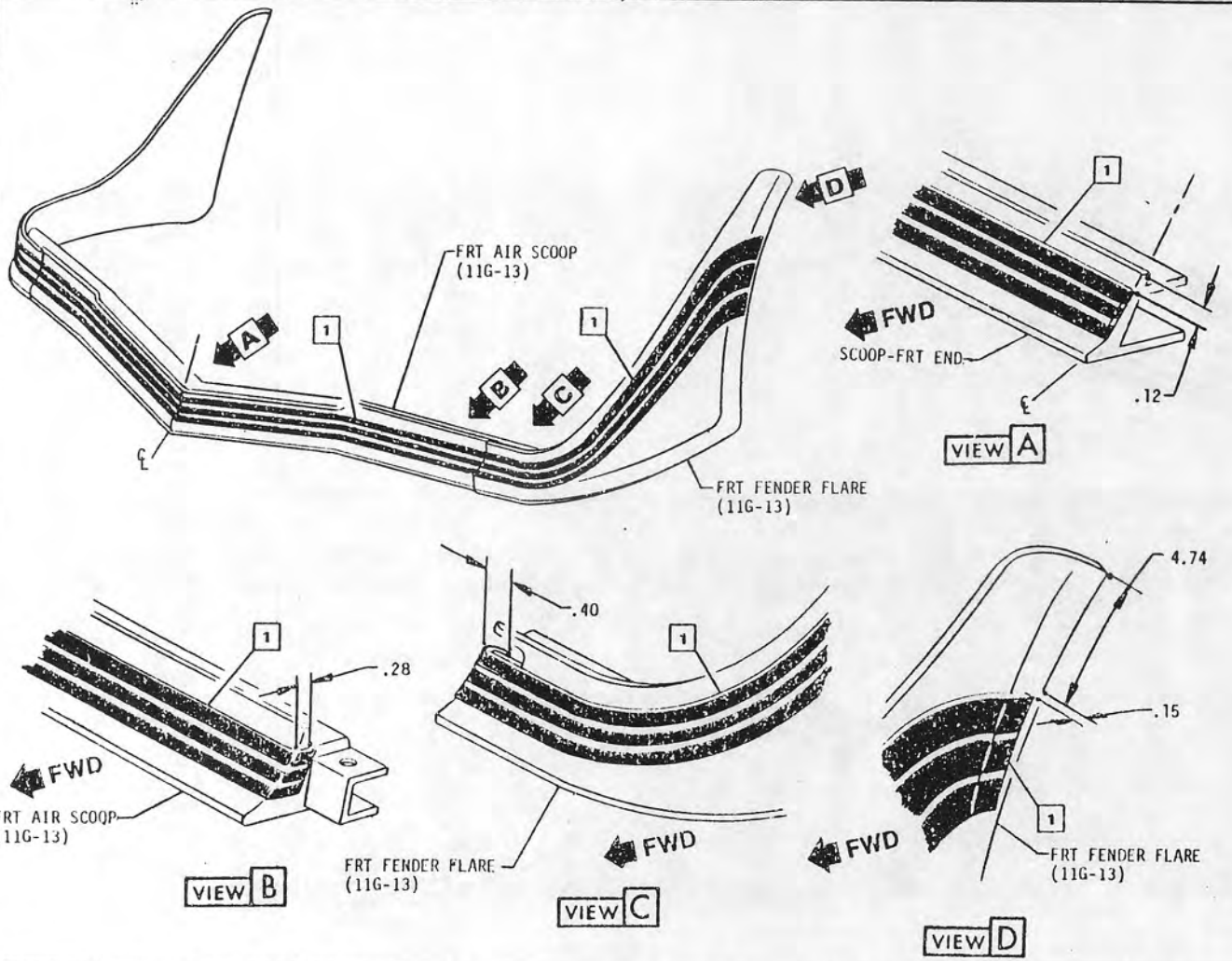
REF ECR 86448 NEW 06FEB0

11-21308-S
L-
L-
L-

UPC 1A2F

SHEET 4.1

Ch X B O P Co



Ref 1A2F-4.1 [1] CHART-BODY DECAL (UPC "O"-P/L)

NOTE After installation of [1], (then this Sub-Asm to be placed in container(11G-14). See Misc shipping list UPC "OC".

NOTE Refer to UPC-"0A" Decal Application Procedure for proper installation

NOTE All dimensions are on surface.

NOTE See 11G for Sub-Assembly, Front Bumper Air Deflector.

DYNAMIC (Instal) N·m	HAND (Insp.) N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
		09MAY80	1	REDRAWN & REDESIGNED 84494	81843	AA	RJ	C

DATE 15FEB80
DR SIENKIEWICZ/ACA
CK RJ Buck 118
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE DECAL-FRONT PANEL & FENDER FLARE FP00 &Z28

REF ECR 86448 NEW 12FEB80

11-21308-S
11-
11-

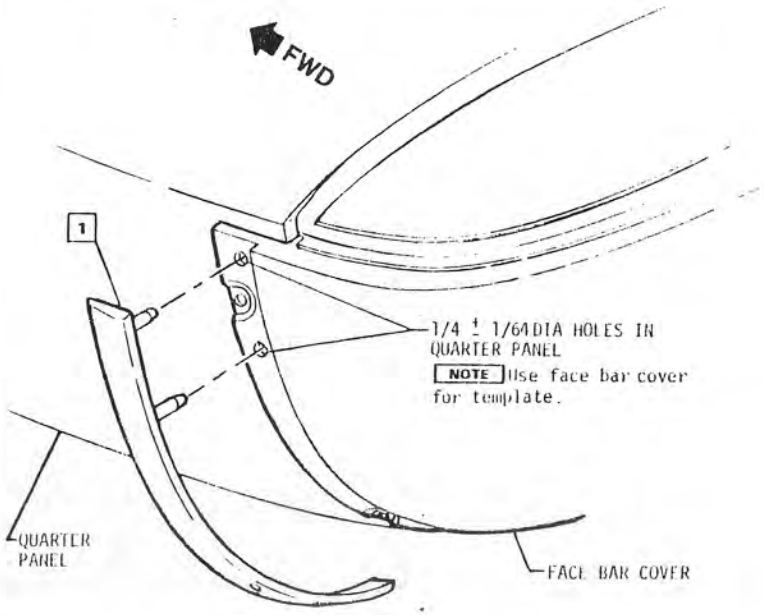
UPC 1A2F

SHEET 5

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

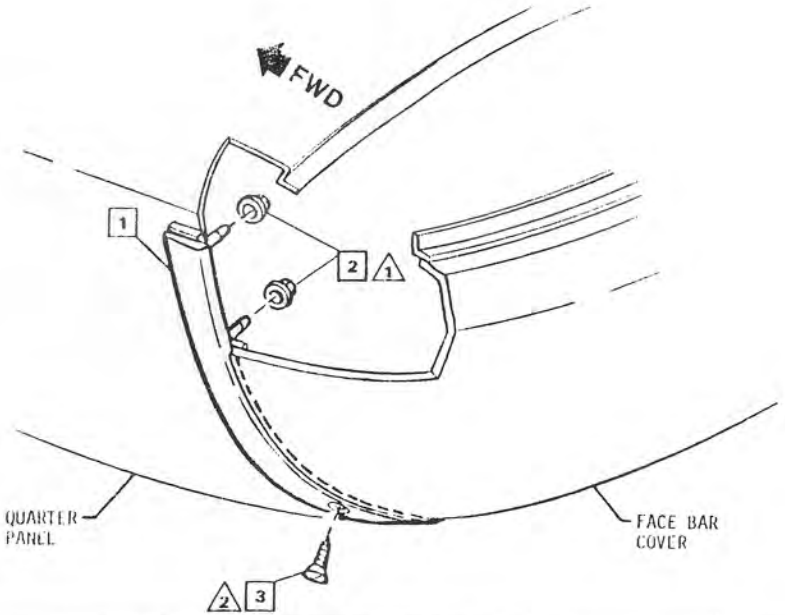
Ch X B O P Co

477001	1	CHART COVER MOLDING (UPC "0"-P/L)
9433046	2	NUT (SEALING)
11503656	3	BOLT/SCREW



MANDATORY ASSEMBLY SEQUENCE FOR ATTACHMENT OF MOLDINGS TO QUARTER PANEL

1. DRIVE NUT [2] ONTO LWR STUD LOCATION
2. DRIVE BOTTOM SCREW [3] IN QUARTER PANEL
3. DRIVE NUT [2] ONTO TOP STUD LOCATION



DYNAMIC (Install) N·m	HAND (Insp.) N·m
1 2.8 - 4.0	
1 1.2 - 1.6	
1	
1	
1	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
		79				

DATE	OCFE80
DR	SIENKIEWICZ/ACA
CK	AJ Pieck 11B
APPR	S
APPR	
APPR	
APPR	

DIV CHEVROLET

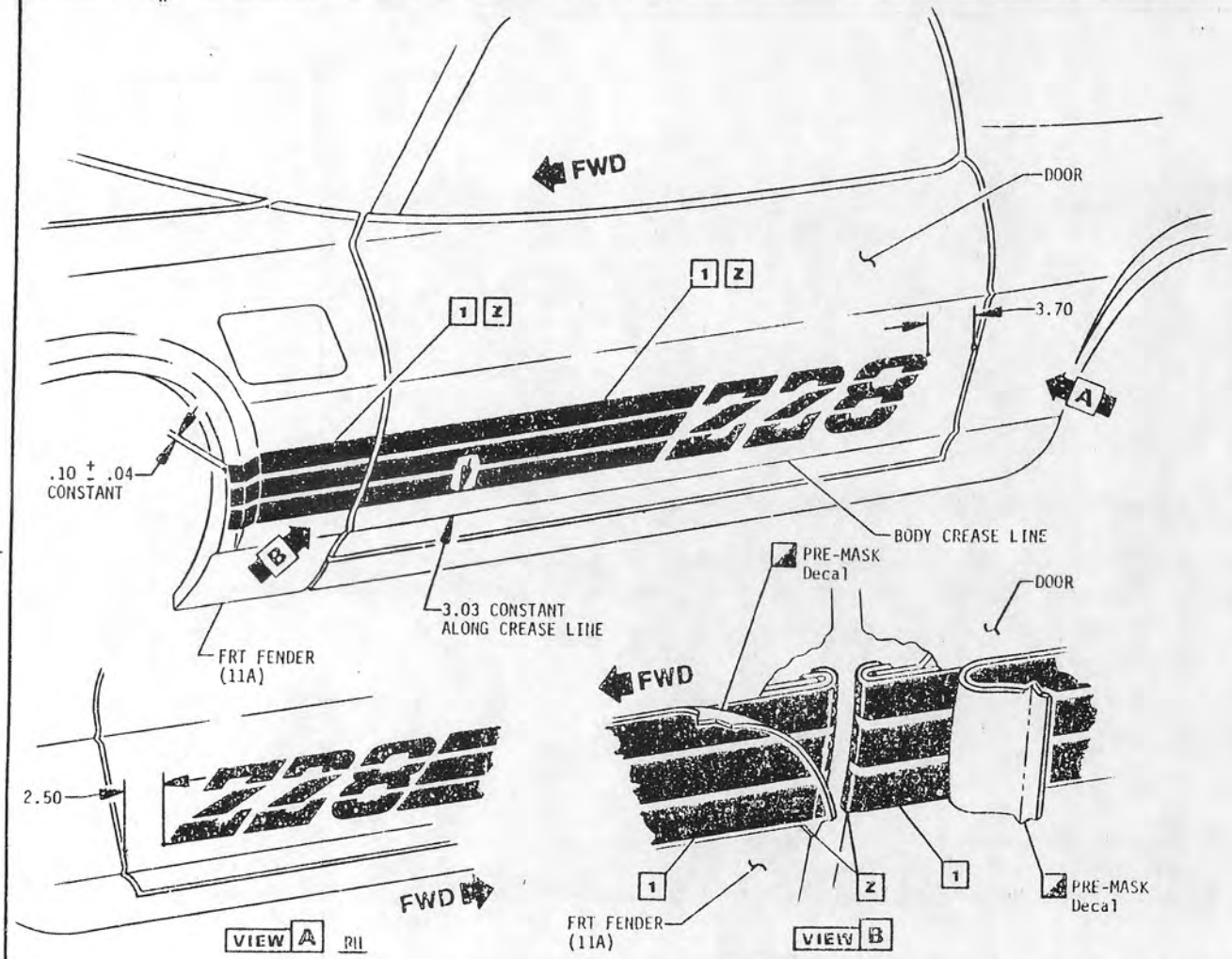
1981 CHEV. "F" 14020867

TITLE
REAR BUMPER MOLDING ASM
FA00 ALL

REF		UPC	SHEET
ECR 86448 C/O 20DE79 1A2F-6	L-14424-S L- L- L-	1A2F	6

Ch [X] B [ ] O [ ] P [ ] Ca [ ]

Ref 1A2F-4.1 [1] CHART-BODY DECAL (UPC "O"-P/L)



NOTE All dimensions are on surface.

NOTE Refer to UPC-"OA" Decal Application Procedure for proper installation.

Z Align 1 Pre-mask darts to door opening and wrap excess Decal around edge.

DYNAMIC (Instal) N·m	HAND (Insp.) N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
		09MY80	1	REDRAWN & REDESIGNED 89494	35843	ACA	7H	C

1 2 3 4 5 ⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE 15FEB0
DR SIENKIEWICZ/ACA
CK J/J Buick HB
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE DECALS-DOOR FP00 &Z28

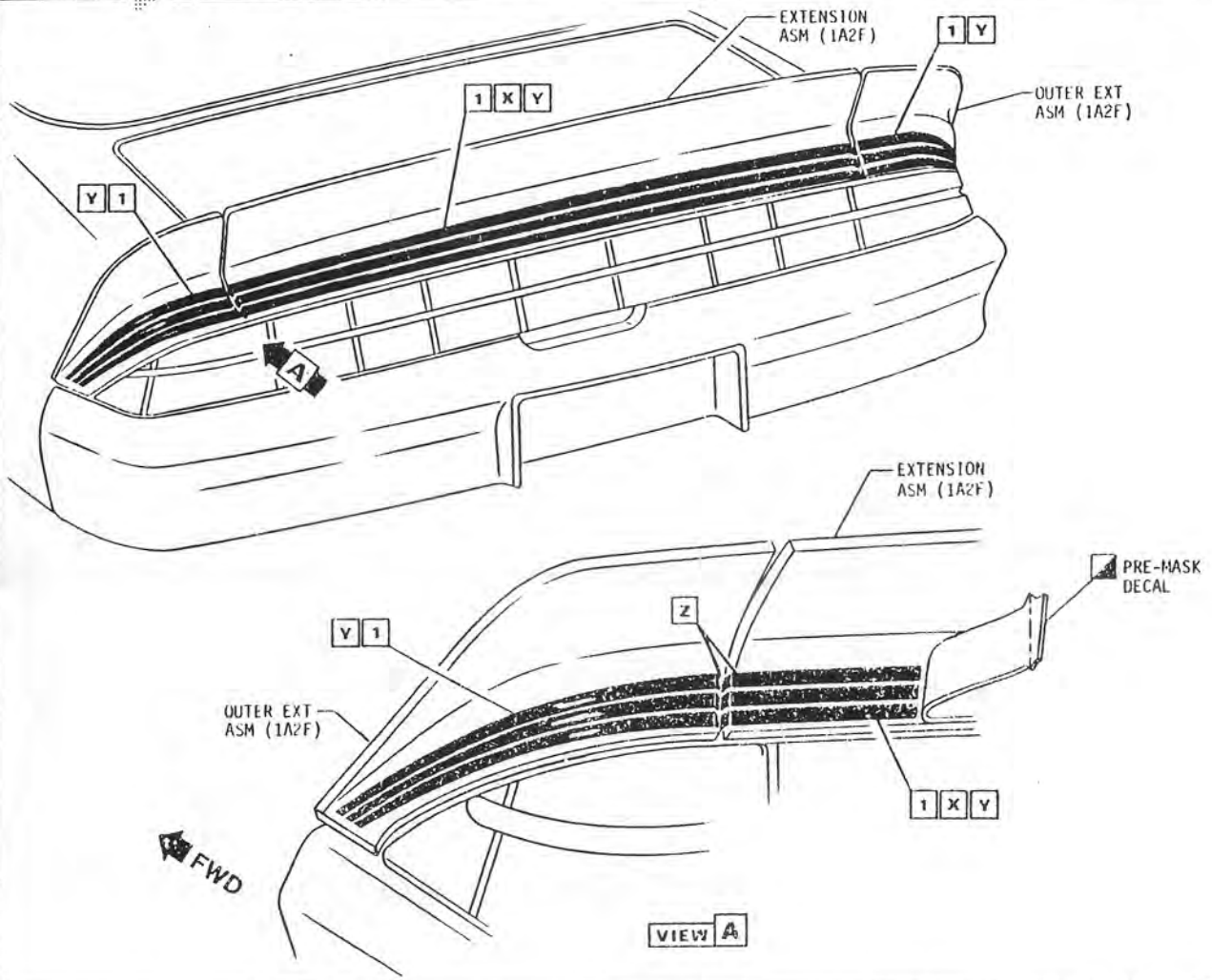
REF ECR 86448 NEW 06FE80

11-21308-S

UPC 1A2F

SHEET 7

Ch ☒ B ☐ O ☐ P ☐ Ca ☐



Ref 1A2F-4.1 [1] CHART-BODY DECAL (UPC "O"-P/L)

NOTE Refer to UPC-"OA" Decal Application Procedure for proper installation.

[X] Align [1] pre-mask darts to outside edge of extension and wrap excess Decal around edge.

[Y] Align [1] pre-mask to lower edge of extension.

[Z] Decal on ext asm must be wrapped into gap between the deck lid and quarter panel and then trimmed at the gap between the ext asm and the deck lid or quarter panel. Do Not wrap stripe around inside of deck lid.

DYNAMIC (Instal.) N·m	HAND (Insp.) N·m
1	
2	
3	
4	
5	

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	EK	ASD ENG
09MY80	1	REDRAWN & REDESIGNED 89843	89494	ACA	EK	

DATE 15FEB80
DR SIENKIEWICZ/ACA
CK NJ Rueck HB
APPR S
APPR
APPR
APPR

DIV CHEVROLET

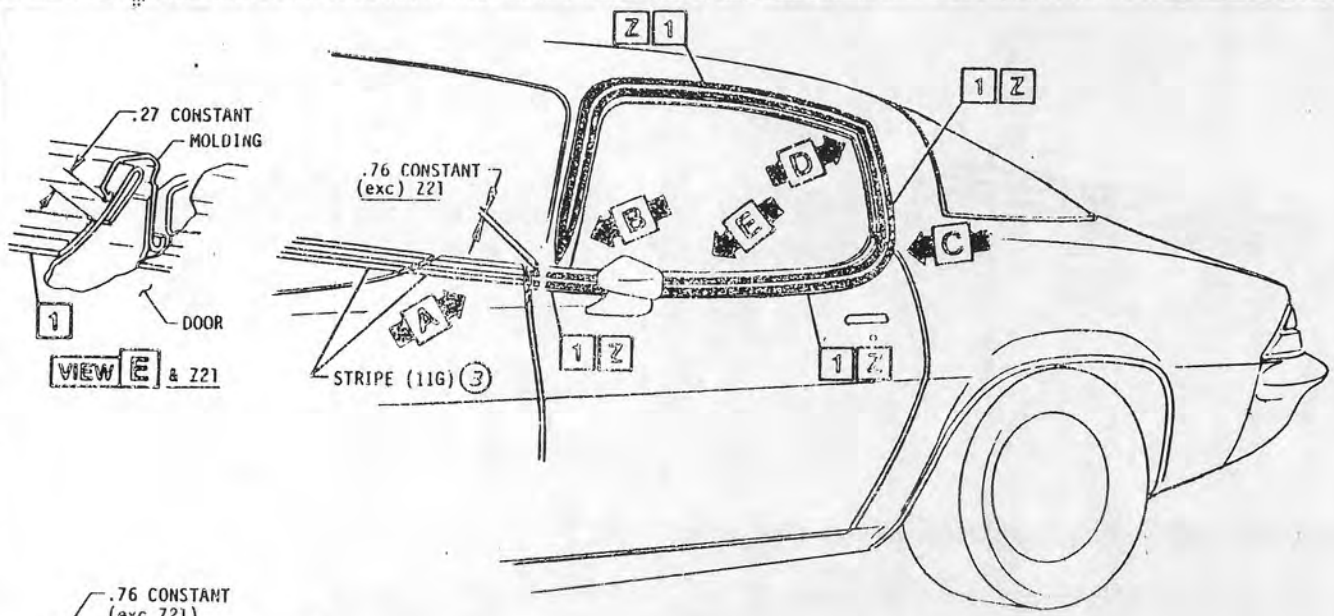
1981 CHEV. "F" 14020867

TITLE
DECAL-RR COMP LID & QTR PNL EXTENSION
FP00 &Z28

REF	UPC	SHEET
ECR 86448 NEW 06FEB80	1A2F	8

11-21308-S
L-
L-
L-

Ch X B D P Ca

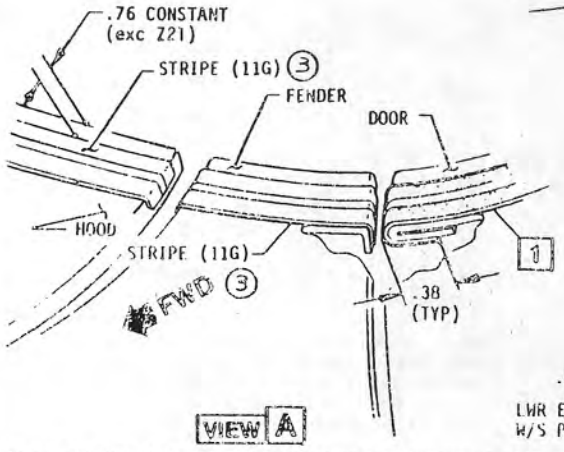


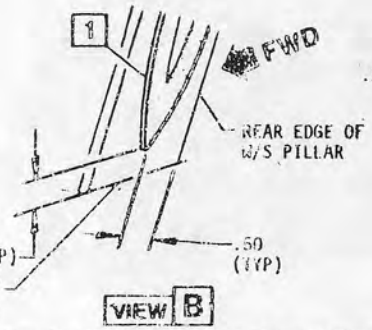
/ 14017620 [1] CHART-STRIPE (UPC "O"-P/L)

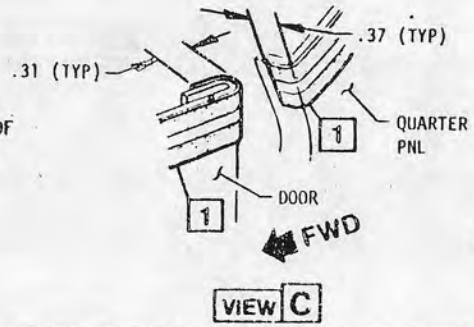
/ 14003300 [1] CHART-STRIPE (UPC "O"-P/L)

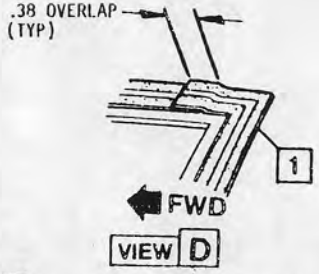
NOTE Refer to UPC-"OA" Decal Application Procedure for proper installation.

NOTE All dimensions are on surface.









4 Z See 1A2F-9.5 for installation of 1 with B80 or Z21 & without B80 or Z21.

DYNAMIC (Insert) Item	NAMD (Insert) Item	DATE	SYM	DIVISION	AUTH	DR	CK	ENGR CHG
		7/31/80	1	WRS BODY DECAL PLACES				
			2	TITLE REVISED				
			3	WRS DECAL PLACES	BRUCE			
			4	2 NOTE REVISED	KATE			

1 HEAT DRIVER, SEALED & HOT STAMPED

DATE 7/31/80
DR R. SIENKIEWICZ
CK 78 Buick HB
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

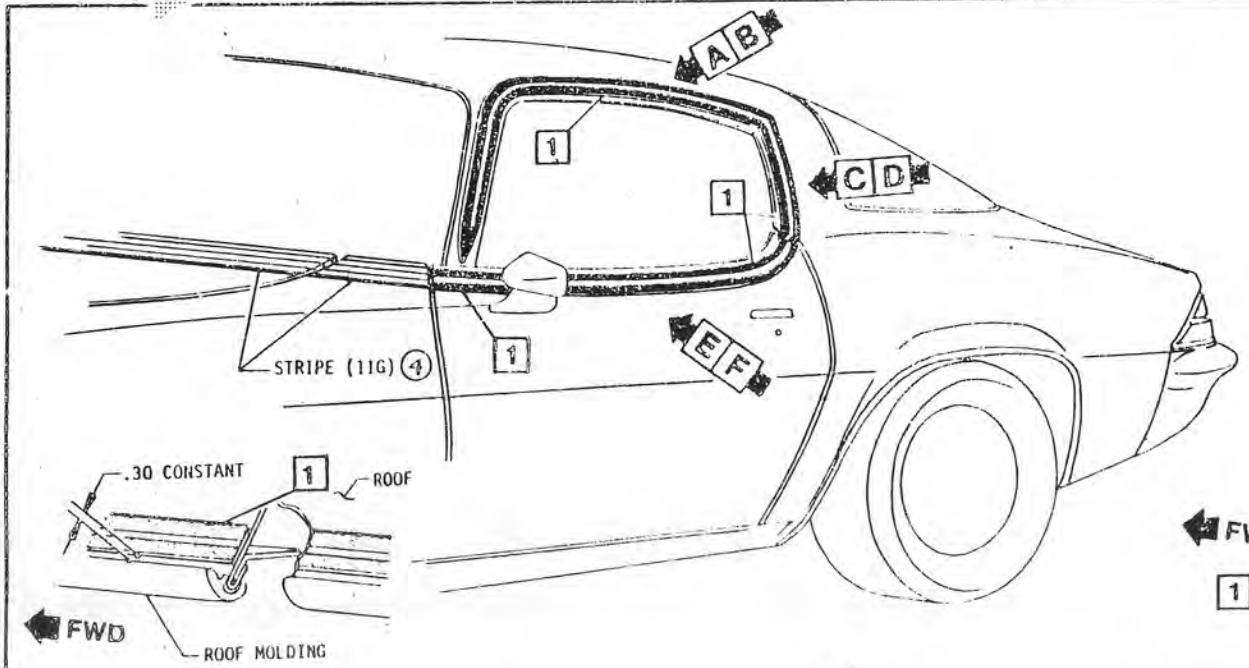
TITLE
2 STRIPE-SAIL PANEL & DOOR UPPER
FS87 ALL

REF ECR 86448
C/O 21DE79
1A2F-9

L-18482-S
L-21185-S
L-
L-

UPC 1A2F

SHEET 9

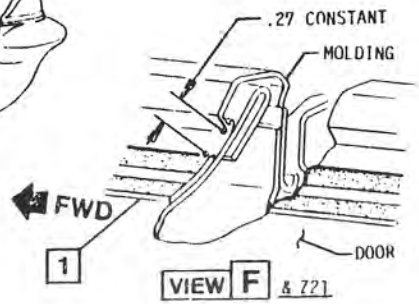


(1) Ref 1A2F-9 [1] CHART-STRIPE (UPC "0"-P/L)

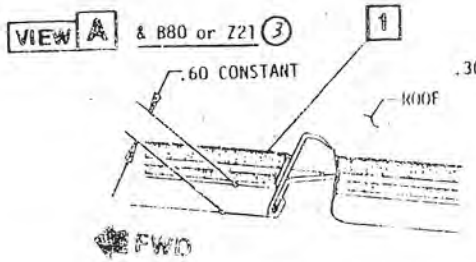
(2)

NOTE Refer to UPC-"0A" Decal Application Procedure for proper installation.

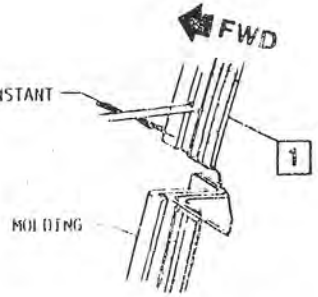
NOTE All dimensions are on surface.



VIEW F & Z21

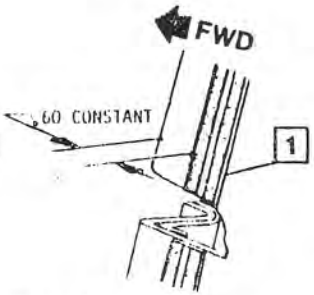


VIEW A & B80 or Z21 (3)

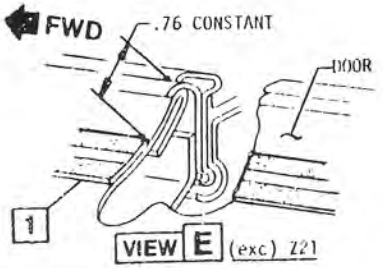


VIEW B (exc) B80 or Z21 (3)

VIEW C & B80 or Z21 (3)



VIEW D (exc) B80



VIEW E (exc) Z21

DYNAMIC (Install) Kom	RANG (Eng.)	DATE	STA	REVISION	AUTH	DR	CK	ASSY LTR	DATE 14JA80
			1	WAS [illegible]					DR STENKIEWICZ/ACA
			2	[illegible]					TR 1U Page 4.116
			3	[illegible]					APPR S
			4	WAS [illegible]					APPR
			5	[illegible]					APPR

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

89

DIV CHEVROLET

1981 CHEV. "F" 14020867

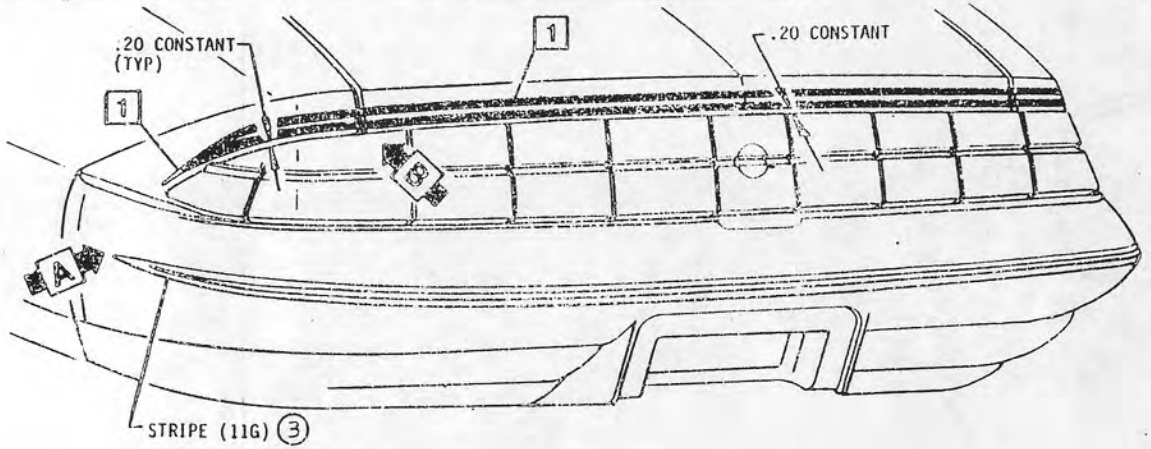
TITLE (5) STRIPE-SAIL PANEL & DOOR UPPER FS87 &B80 or Z21

REF ECR 86448 C/O 14DE79 2A2F-9.5

1- 10402-S
1- 21185-S
1-
1-

UPC 1A2F

SHEET 9.5

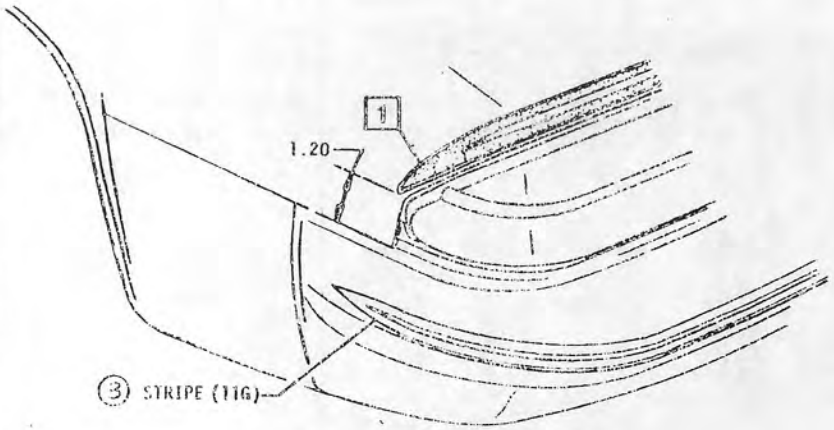


(1) Ref 1A2F-9 [1] CHART-STRIPE (UPC "O"-P/L)

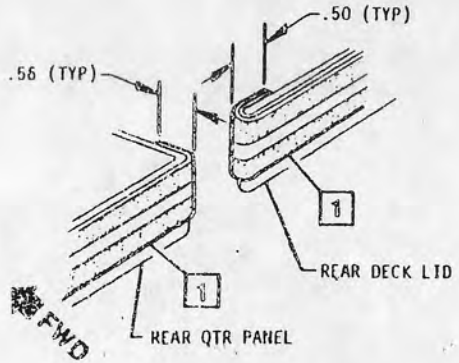
(2)

NOTE Refer to UPC-"OA" Decal Application Procedure for proper installation.

NOTE All dimensions are on surface.



VIEW A (TYPICAL)



VIEW B (TYPICAL)

DYNAMIC (tested) Item	STATIC (insp.) Item	DATE	SYM	REVISION	AUTH	GR	CK	DATE
		02NOV80	1	WAS 1A2F-10 CHART				15JA80
			2	1A2F-8300 CHART REMOVED				
			3	WAS DECAL (2) PLCS				
			4	TITLE REVISED				

1 FULLY DRIVEN SEATED & NOT STRIPPED

84

DIV CHEVROLET

1981 CHEV. "F" 14020867

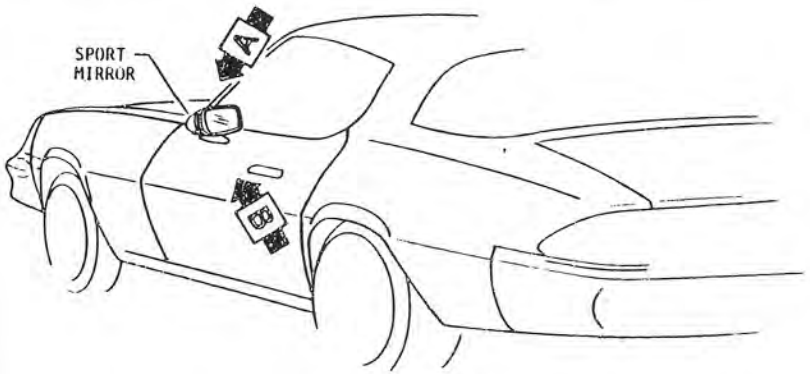
TITLE (4) STRIPE-REAR DECK LID FS87 ALL

SEE ECR 86448 C/O 14DE79 1A2F-10

L- 18482-S
L- 21185-S

UPC 1A2F

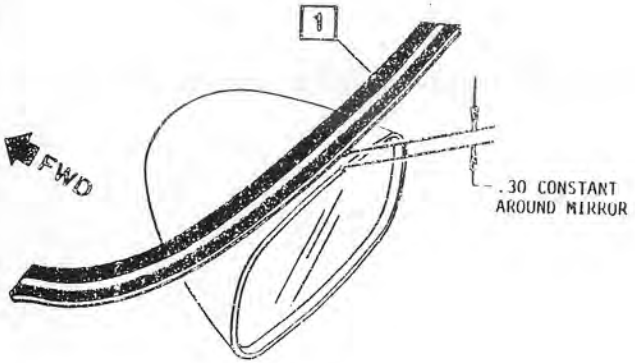
SHEET 10



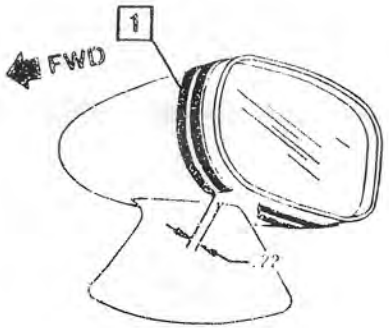
(1) Ref 1A2F-9 [1] CHART-STRIPE (UPC "0"-P/L)

NOTE Refer to UPC-"0A" Decal Application for proper installation.

NOTE All dimensions are on surface.



VIEW A



VIEW B

DYNAMIC (Instal) N·m	HAND (Insp.) N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
		(illegible)	1	WAS 3004 DECAL				
			2	TITLE & OPTIONS REVISED	[illegible]	[illegible]	[illegible]	

⚠ FULLY DRIVER SEATED 2 HOG Stripped

85

DATE 15 JAN 80
DR R. SIENKIEWICZ
CK 10 Buick HB
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE (2) STRIPE-SPORT MIRROR FS87 ALL

REF ECR 8644B C/O 30N079 1A2F-11

L-18482-S L-21185-S L- L-

UPC 1A2F

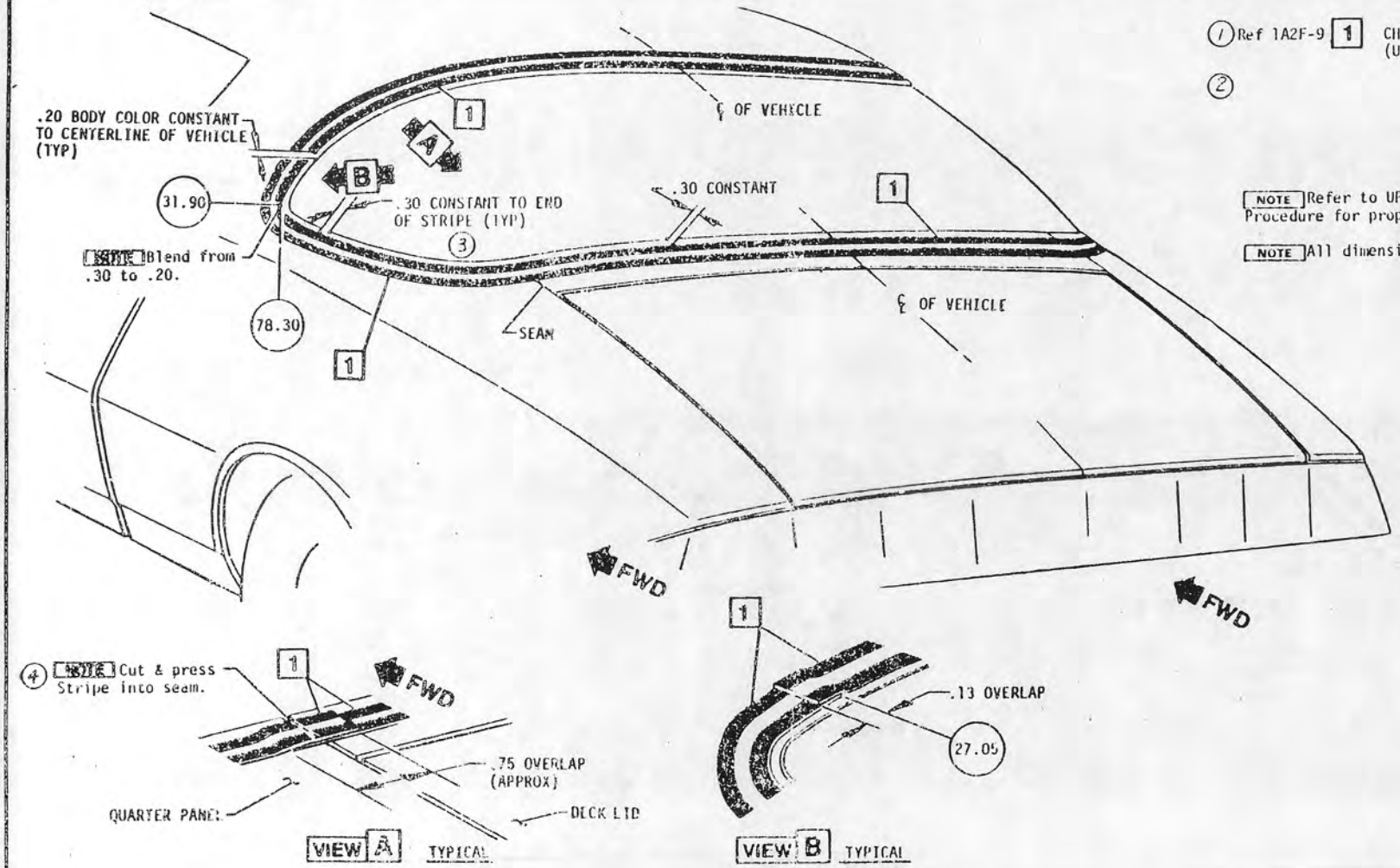
SHEET 11

Drafting Graphic

General Motors Corporation
CHEVROLET MOTOR DIVISION

PRODUCT DESCRIPTION MANUAL

☐ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF



DATE	SYM	REVISION	AUTH	DS	CK	CSM Eng
2/11/80	1	WAS 1A01A 20 CHART				
	2	1A01A30 CHART REMOVED				
	3	WAS DECAL				
	4	STRIPE NOTE REVISED				
	5	TITLE REVISED				

DATE 1/5/80
DR STENKIEWICZ/ACA
CK 10 Back HB
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE (5) STRIPE-REAR WINDOW FS87 ALL

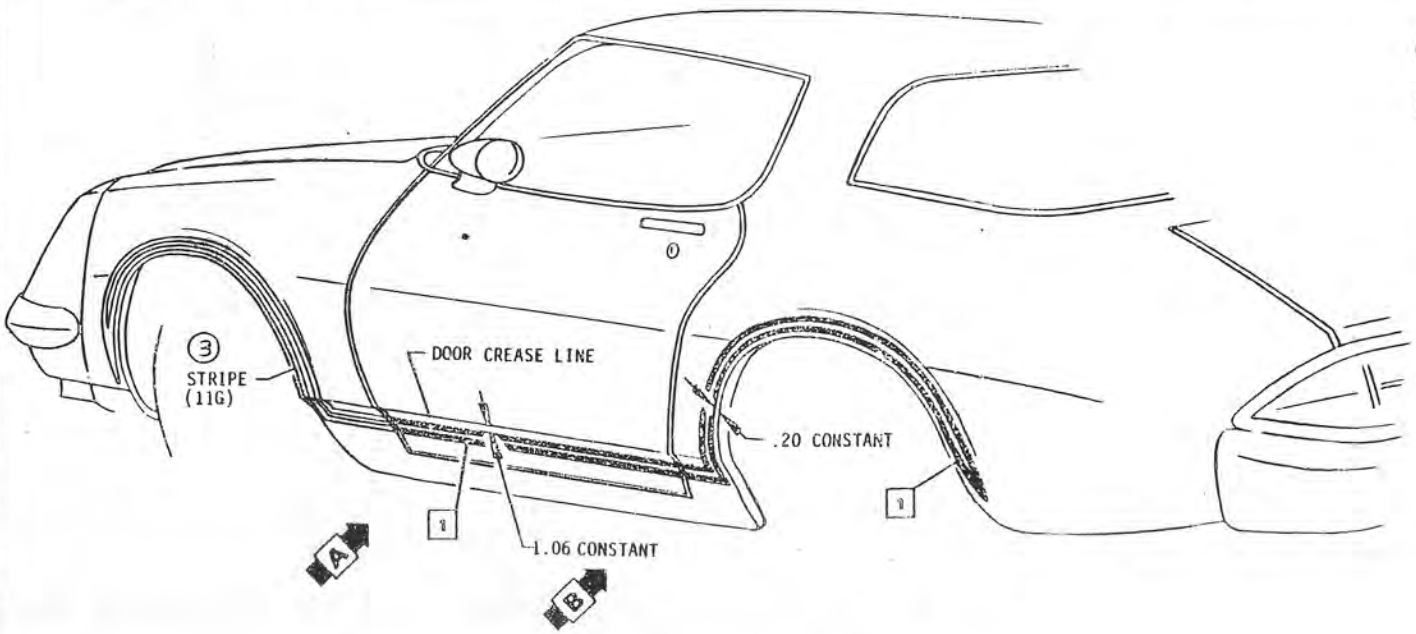
REF ECR 86448 C/O 14DE79 1A2F-12

L- 18482-S
L- 21185-S
L-
L-

UPC 1A2F

SHEET 12

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

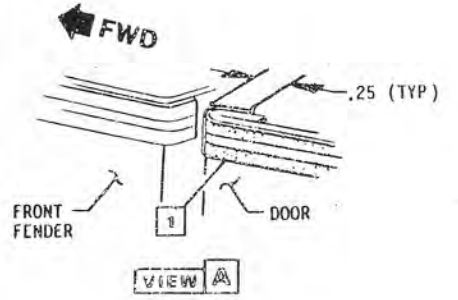


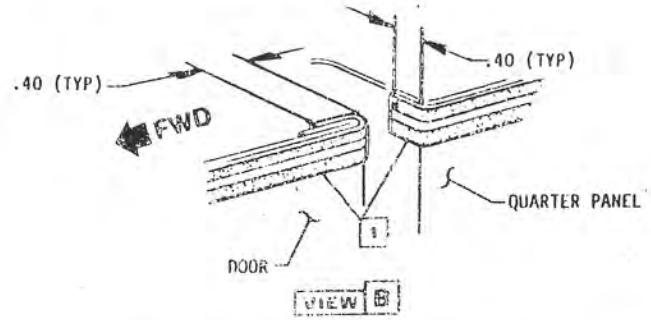
(1) Ref 1A2F-9 [1] CHART-STRIPE (UPC "0"-P/L)

(2)

NOTE Refer to UPC-"0A" Decal Application Procedure for proper installation.

NOTE All dimensions are on surface.





DYNAMIC (Install Item)	HAND (Insp.)	DATE	SYM	REVISION
		02APR80	1	WAS 14A2F-10 NOW 14A2F-9
			2	ADDED COLOR REQUIRED
			3	WAS DECAL
			4	TITLE REVISED

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

AUTH	CE	CR	ASE ENG
GRIN			

DATE 15JA80
DR STENKIEWICZ/ACA
CK J.G. Buick HB
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
④ STRIPE-DOOR LOWER & REAR WHEELHOUSE OPENING
FS87 ALL

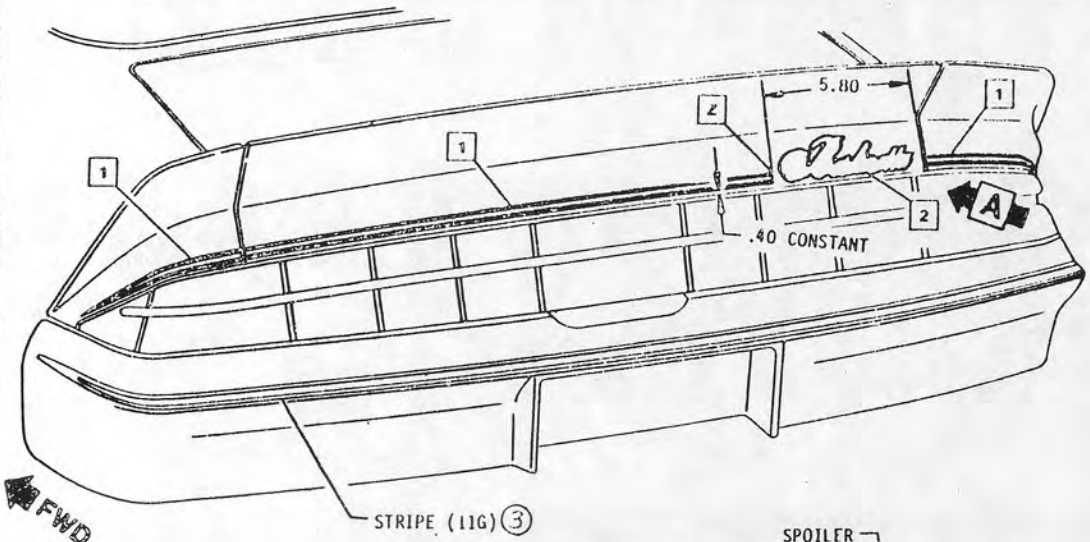
REF ECR 86448
C/O 14DE79
1A2F-13

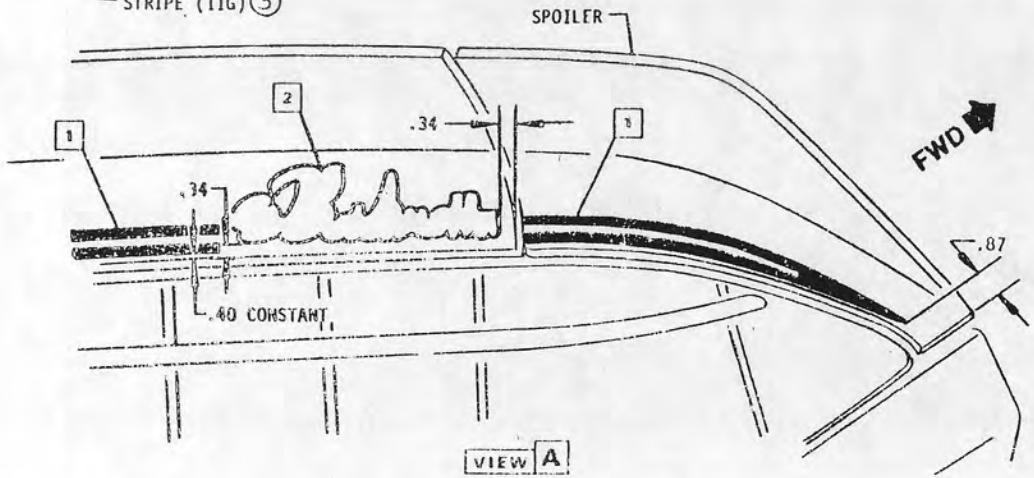
L- 8482-S
L- 21185-S
L-
L-

UPC 1A2F

SHEET 13

87





①	Ref 1A2F-9	1 CHART-STRIPE (UPC "0"-P/L)
②		1
+	20099001	2 PLATE-NAME

NOTE Refer to UPC-"0A" Decal Application Procedure for proper installation.

NOTE All dimensions are on surface.

Z Trim 1 on RH side only.

DYNAMIC (Install) N·m	HAND (Insp.) N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
		03MAR80	1	WAS 1901620 CHART				
			2	1901330 CHART REMOVED	4415			
			3	W.S.S. DECAL				
			4	TITLE REVISED	0810E	AA	AA	

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE 15JA80
DR STENKIEWICZ/ACA
CK NJBuick HB
APPR S
APPR
APPR
APPD

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE ④ STRIPE-RR COMP LID & QTR PNL EXT FS87 &D80

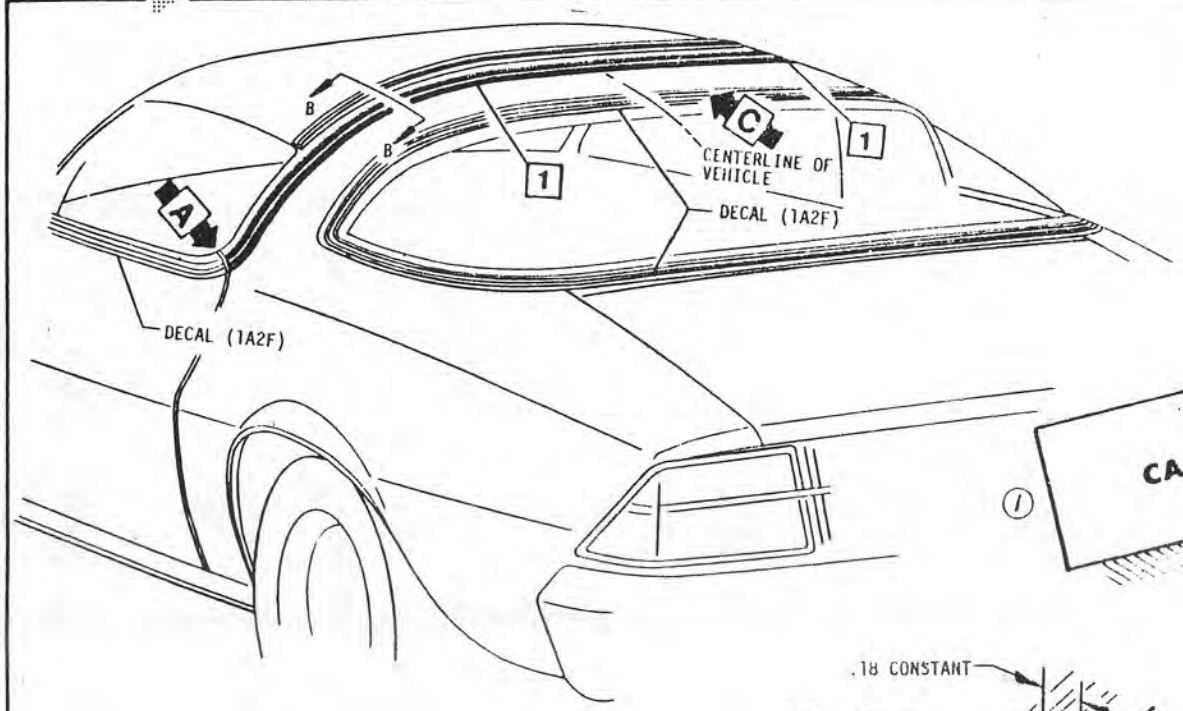
REF ECR 86448 C/O 14DE79 .1A2F-14
L-18482-S
L-21185-S
L-
L-

UPC 1A2F

SHEET 14

89

0 0 0 F 0



14017620 [1] CHART-BODY DECAL (UPC "0"-P/L)

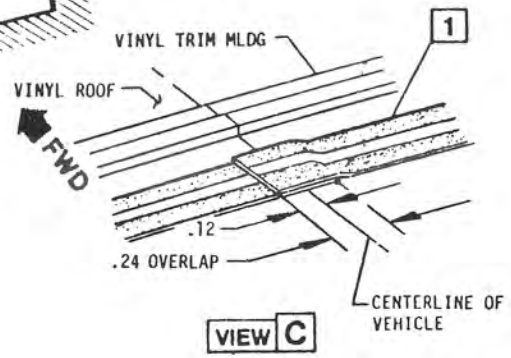
14003300 [1] CHART-BODY DECAL (UPC "0"-P/L)

NOTE Refer to UPC-"0A" Decal Application Procedure for proper installation.

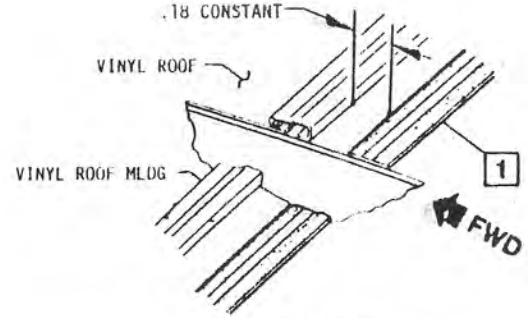
NOTE All dimensions are on surface.

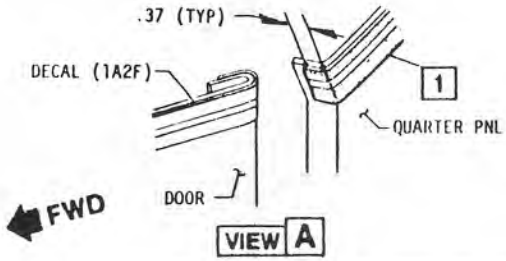
CANCELED

1



VIEW C





VIEW A

SECTION B-B

DYNAMIC (Install) N·m	HAND (Insp.) N·m
1	
2	
3	
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
15FEB80	1	SHEET CANCELED	SHEET	AA	HB	

DATE 15JAB0
DR R.SIENKIEWICZ
CK H.J.Buck HB
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE DECAL-ROOF FS87

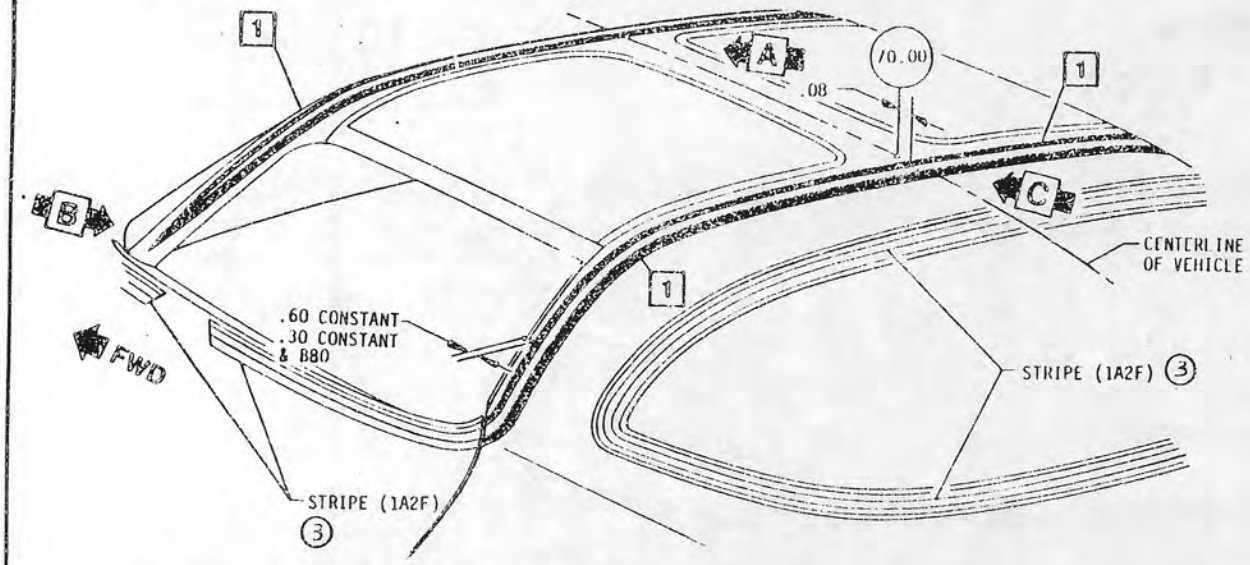
REF ECR 86448 C/O 14DE79 1A2F-15

L- 18482-S
L- 21185-S
L-
L-

UPC 1A2F

SHEET 15

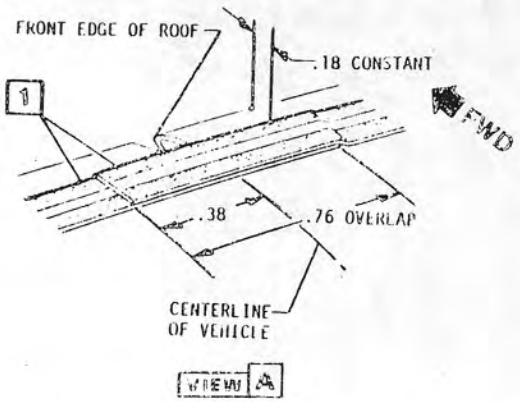
Ck X B D P Ca

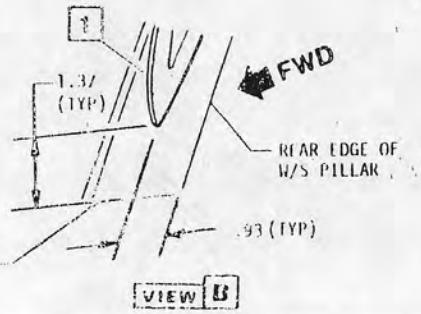


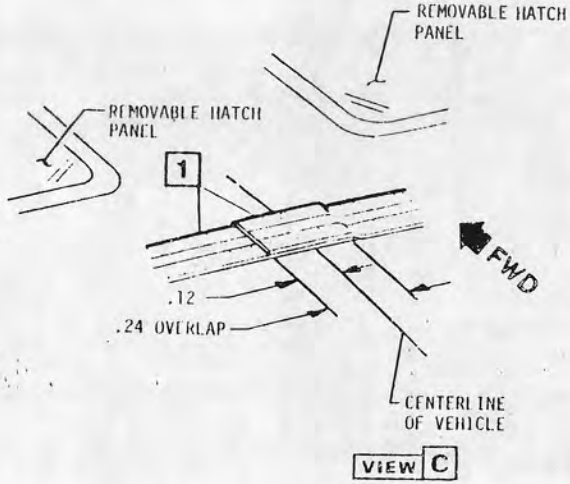
① Ref 1A2F-9 [1] CHART-STRIPE (UPC "O"-P/L)
②

NOTE Refer to UPC-"OA" Decal Application Procedure for proper installation.

NOTE All dimensions are on surface.







DYNAMIC (Tested) Item	HAND (Insp.)	Item	DATE	SYM	REVISION	AUTH	DR	CK	ASS'D ENG
			1-30-80	1	INCR. SKU'S ON CHART				
				2	CHANGED PART NUMBER				
				3	ADD DECAL (2) PLCS				
				4	TITLE REVISED				

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE 1-30-80
DR R. STENKIEWICZ
CK H. Hauck HB
APPR S
APPR
APPR
APPR

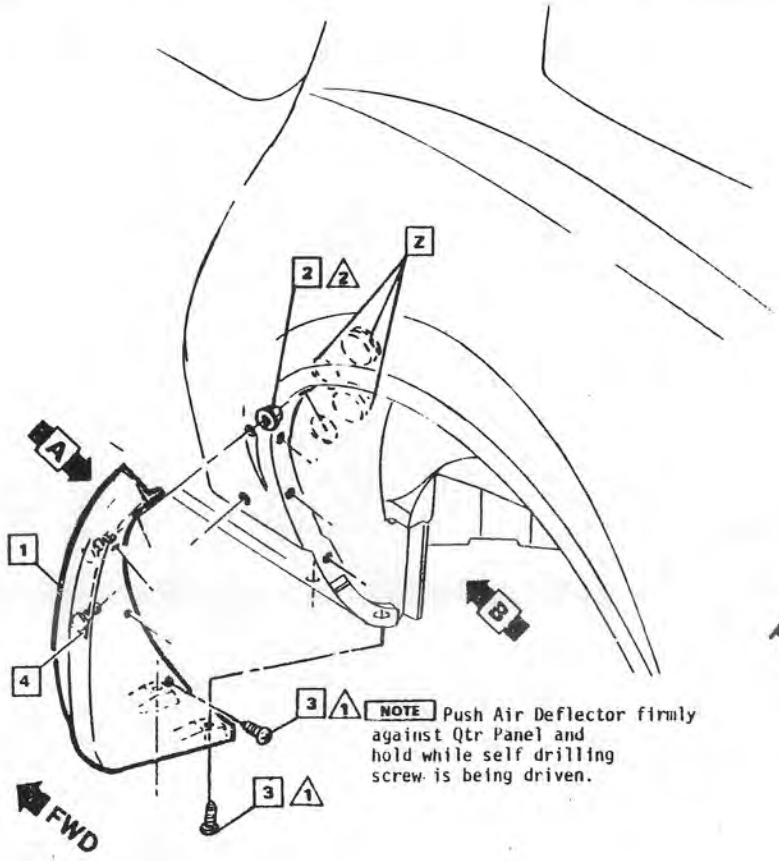
DIV CHEVROLET

1981 CHEV. "F" 14020867

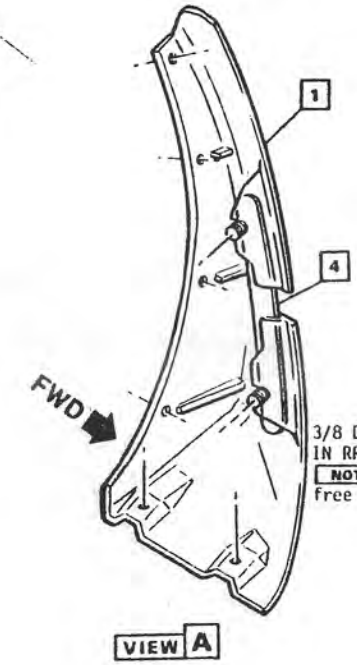
TITLE
④ STRIPE-ROOF
FS87 &CC1

REF			UPC	SHEET
ECR 86448 C/O 14DE79 1A2F-16	L- 18482-S L- 21185-S L- L-		1A2F	16

14005950	1	CHART-RR WHEEL OPNG DEFLECTOR (UPC "0"-P/L)
4801719	2	NUT ASM
20007300	3	BOLT/SCREW
14016839	4	RETAINER ASM



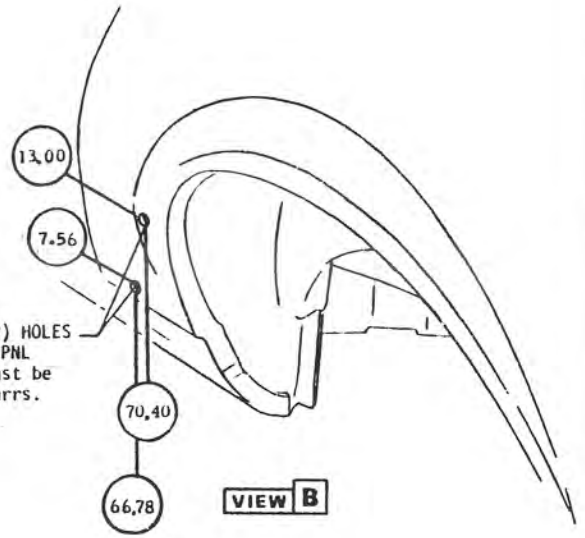
NOTE Push Air Deflector firmly against Qtr Panel and hold while self drilling screw is being driven.



VIEW A

3/8 DIA (2) HOLES IN RR OTR PNL

NOTE Must be free of burrs.



VIEW B

Z See Fisher Body Operation Description (OD).

DYNAMIC (lbs-ft) N·m	HAND (lbs.) N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
	1 1.2 - 1.6 2 4.5 - 7.0 3 4 5							

1 FULLY DRIVEN, SEATED & NOT STRIPPED

C ☒ B ☐ D ☐ P ☐ Ca ☐

DATE 15JA80
DR R.SIENKIEWICZ
CK H.J.Leuck 11B
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE REAR QTR AIR DEFLECTOR FP00 &Z28

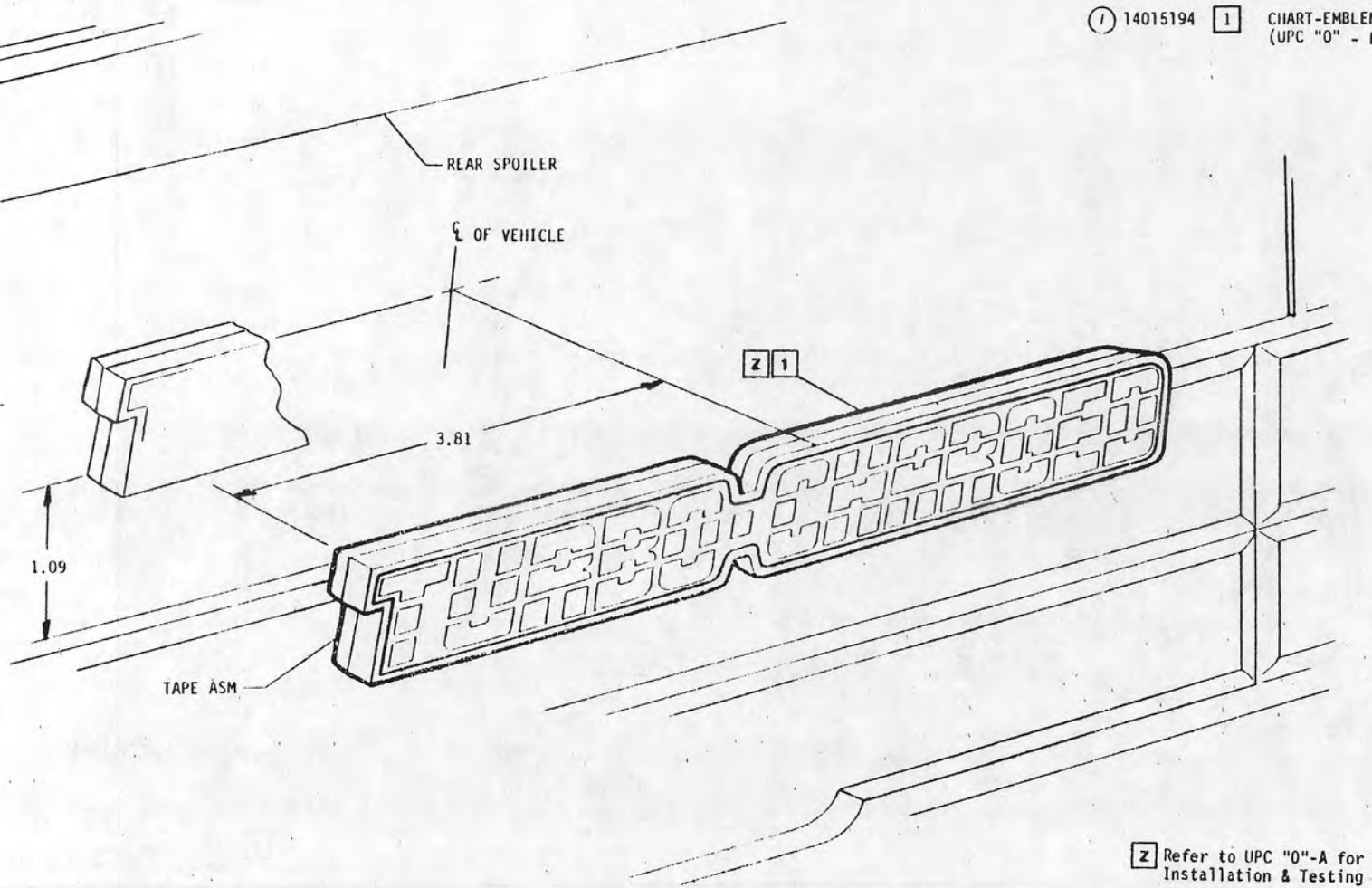
REF ECR 86448
C/O 21DE79
1A2F-17

L-18934-S
L-
L-
L-

UPC 1A2F

SHEET 17

(1) 14015194 [1] CHART-EMBLEM ASM (UPC "0" - P/L)



[Z] Refer to UPC "0"-A for Emblem Installation & Testing Procedure.

DYNAMIC (Install) N.m	HAND (Insp.) N.m	DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
		4/1/80	1	WAS 14031624 CHART	39260	VA		

1 2 3 4 5

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE 15JAN80
DR STENKIEWICZ/CK
CK TJ Buick 11B
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE EMBLEM-REAR SPOILER FP00 &LU8

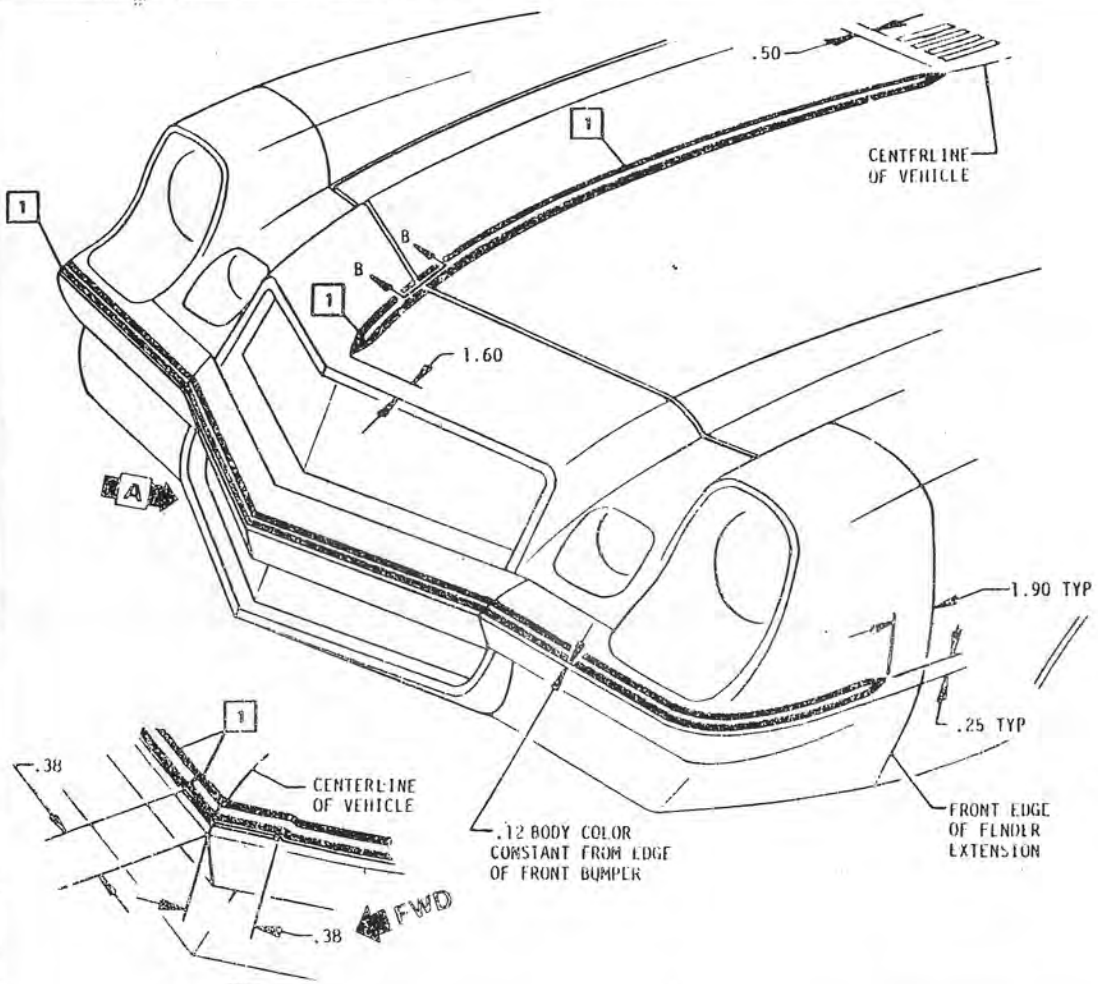
REF ECR 86448 C/O 14DE79 1A2F-18

L-23391-S L- L- L-

UPC 1A2F

SHEET 18

Ch X B 0 P Ca

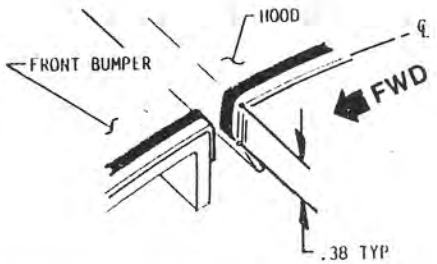


VIEW A

Ref 1A2F-9 [1] CHART-STRIPE (UPC "0"-P/L)

NOTE Refer to UPC "0A" Decal Application Procedure for proper installation.

NOTE All dimensions are on surface.



SECTION B-B

DYNAMIC (Instal) ft-lb	HAND (Insp) ft-lb	DATE	SYM	REVISION	AUTH	DR	CK	ASSY ENG

⚠ FULLY DRIVEN SEATED & NOT STRIPPED

DATE 02/18/80
DR SIENKIEWICZ/ACA
CK
APPR S
APPR
APPR
APPR

DIV CHEVROLET

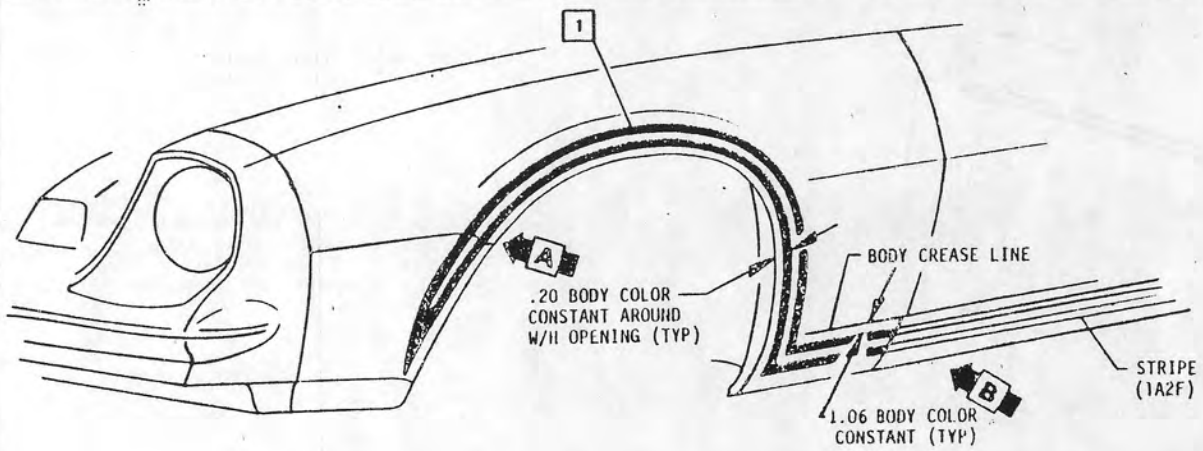
1981 CHEV. "F" 14020867

TITLE STRIPE-HOOD CTR & FRT BUMPER FS87 ALL

REF LCR 86448 NEW 22FE80 | L-18482-S L-21185-S L- L-

UPC 1A2F

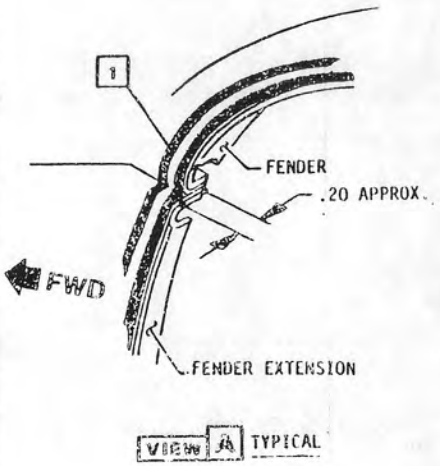
SHEET 19



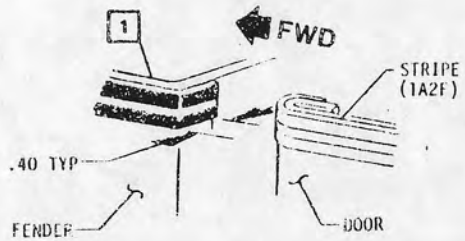
Ref 1A2F-9 [1] CHART- STRIPE (UPC "0"-P/L)

NOTE Refer to UPC -"0A" Decal Application Procedure for proper installation.

NOTE All dimensions are on surface.



VIEW A TYPICAL



VIEW B

DYNAMIC (Instrl) H-w	HARD (Instr) - H-w	DATE	SYM	REVISION	AUTH	DR	CK	ASM LDR	DATE 07JAN80
⚠ FULLY DRIVEN SEATED & NOT STRIPPED									DR STENKIEWICZ/ACA
									CK
									APPR S
									APPR
									APPR
									APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

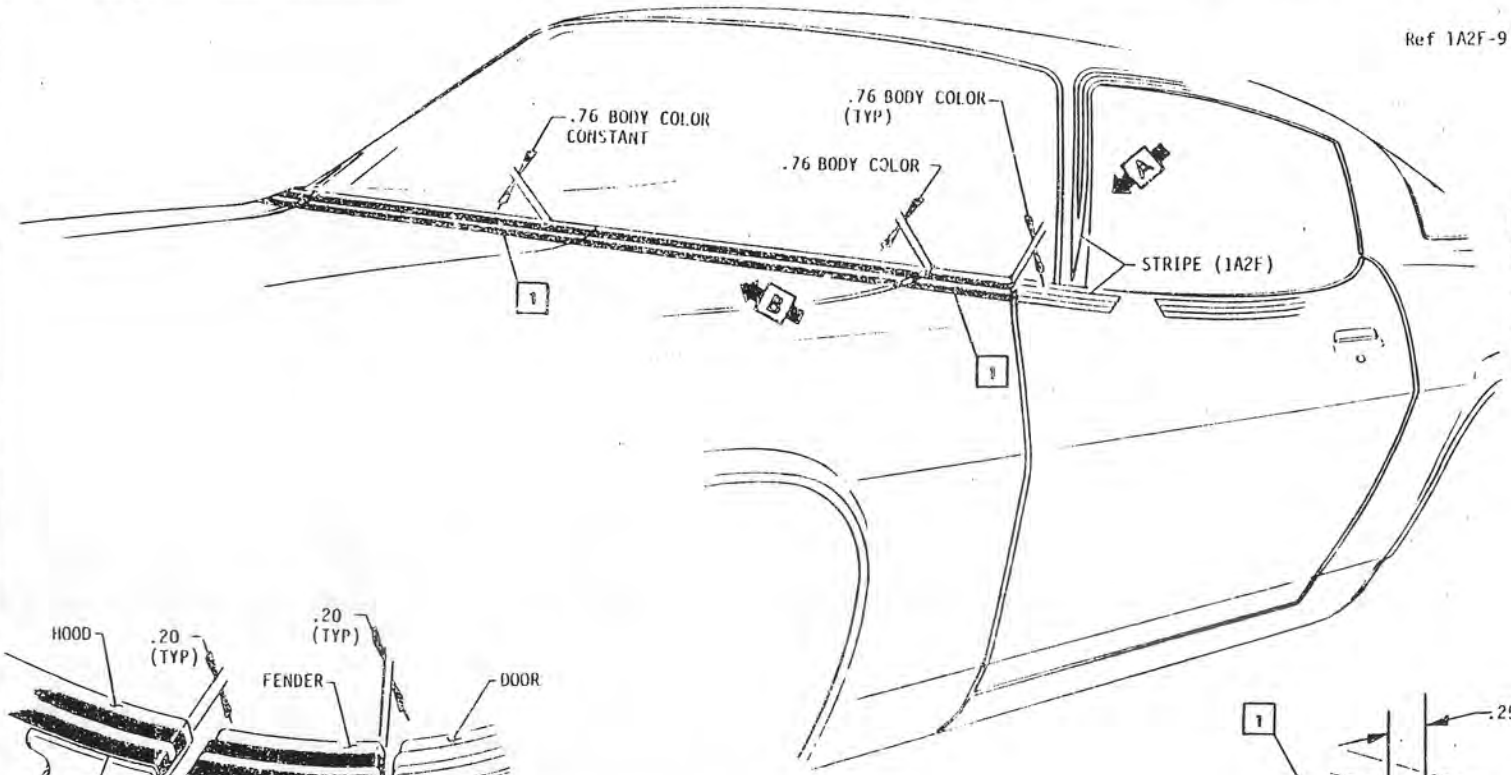
TITLE STRIPE-FRONT FENDER W/HOUSE OPENING
FS87 ALL

REF ECR 86448 NEW 22FEB80

L-18482-S
L-21185-S
L-
L-

UPC 1A2F

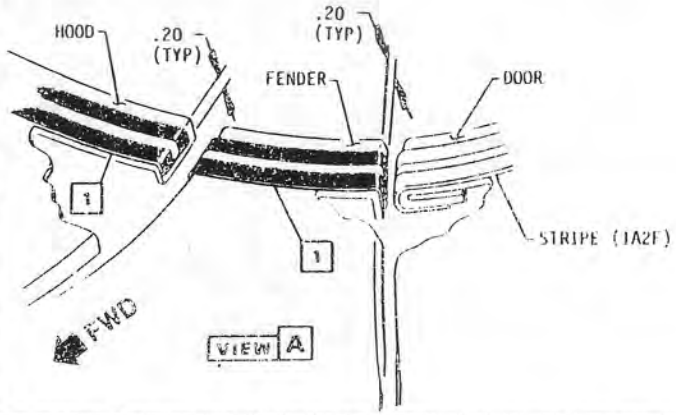
SHEET 20

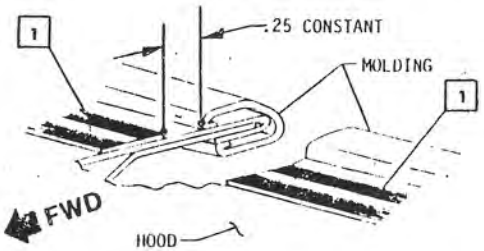


Ref 1A2F-9 [1] CHART- STRIPE (UPC-"0" P/L)

NOTE Refer to UPC -"0A" Decal Application Procedure for proper installation.

NOTE All dimensions are on surface.





VIEW B & Z21

DYNAMIC (Instal) N·m	HAND (Insp)	d·m	DATE	SYM	REVISION	AUTH	DR	CK	ASE Eng
					95				

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE 07MAR80
DR SIENKIEWICZ/ACA
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

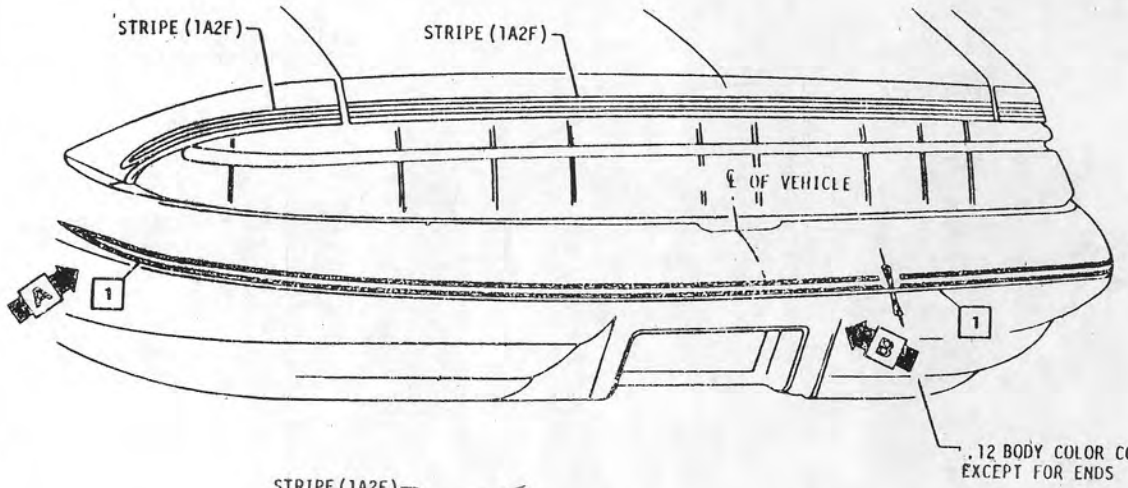
TITLE STRIPE-HOOD REAR & FRONT FENDER
FS87 ALL

REF ECR 86448
NEW 22FE80

L- 18482-S
L- 21185-S
L-
L-

UPC 1A2F

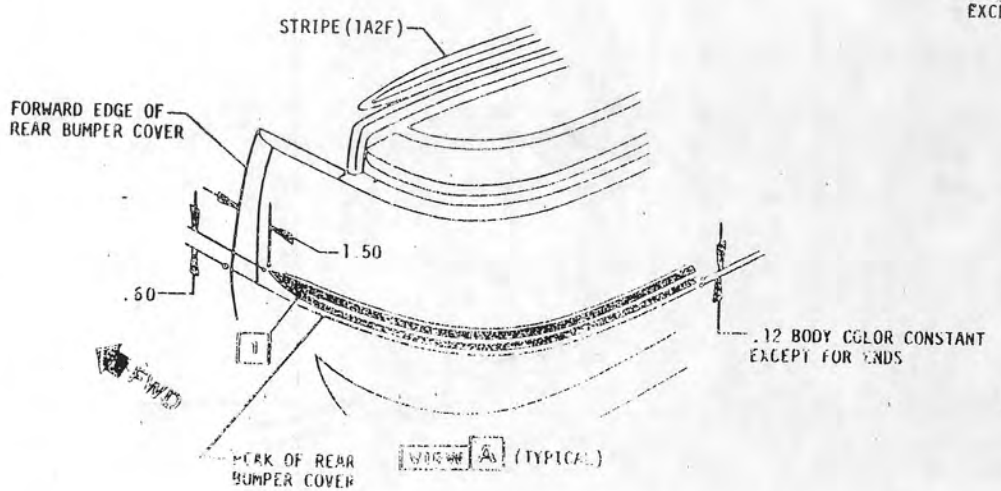
SHEET 21

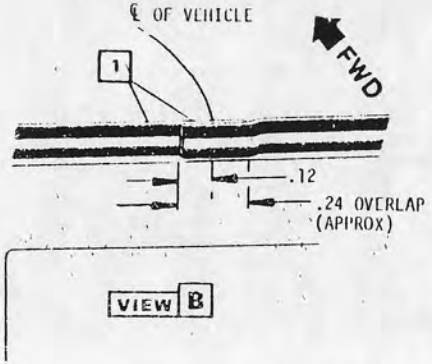


Ref 1A2F-9 [1] CHART-STRIPE (UPC "0"-P/L)

NOTE Refer to UPC -"0A" Decal Application Procedure for proper installation.

NOTE All dimensions are on surface.





DYNAMIC (Install) N·m	HAND (Inst.) N·m	DATE	STA	REVISION	AUTH	DS	CK	ASM ENG

⚠ FULLY ABUSED, SEATED & HOT STRIPPED

96

DATE 07/31/80
DR SIENKIEWICZ/ACA
CK
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE STRIPE-REAR BUMPER COVER
FS87 ALL

RET		UPC	SHEET
ECR 86448 NEW 22FE80	1-18482-S 1-21185-S	1A2F	22

				DIV RESP
	1A2G-1	CONTENTS		D
	1A2G-2	CONTENTS 1A2K THRU 1Z		D

1A2G AIR CONDITIONING COMPRESSOR

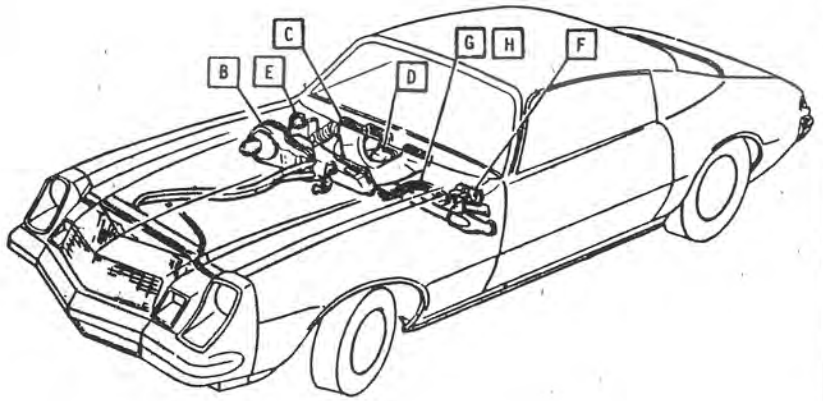
A	1A2G-3	OPEN		
	1A2G-4	COMPRESSOR & BELT MOUNTING	...LC3/LG4/LM1/L39 &C60 (2)	C
	1A2G-5	COMPRESSOR MOUNTING	....LC3/LG4/LM1/L39 &C60 (2)	C
	1A2G-6	OPEN		
	1A2G-7	COMPRESSOR MOUNTING	....LD5 &C60 (2)	D
	1A2G-8	OPEN		
	1A2G-9	OPEN		
	1A2G-10	OPEN		
(1)	1A2G-11	CANCELED		

1A2H HEATER AND AIR CONDITIONING AIR SYSTEM

B	1A2H-1	HEATER & DEFROSTER ASM		P
	1A2H-2	HTR CONT OUTLET DUCT		P
C	1A2H-3	SELECTOR & DIST DUCTS	....C60	P
	1A2H-4	HTR OUTLET & A/C DIST DUCT		D
	1A2H-5	HTR & DEFROSTER OUTLET		
D	1A2H-6	UPPER & LWR AIR DIST DUCTS & SEALS	....C60	D
	1A2H-6.5	AIR DIST UPR DUCT ASM TO INSTR PANEL	....C60	D
	1A2H-7	CENTER OUTLET DEFLECTOR ASM	....C60	D
	1A2H-8	SIDE OUTLETS, DUCT & HOSE	....C60	D
	1A2H-9	LWR OUTLETS & HOSES	....C60	D

1A2J HEATER AND AIR CONDITIONING CONTROLS

E	1A2J-1	SIDE SHROUD VALVE	....C60	P
	1A2J-2	PLENUM VALVE	....C60	P
	1A2J-3	PLENUM VALVE & BAFFLE	....C60	P
F	1A2J-4	HTR CONTROL ASM		D
	1A2J-5	CONTROL ASM	....C60	D
G	1A2J-6	INST PNL VAC ROUTING	....C60	D
H	1A2J-7	HTR CONTROL CABLES		D
	1A2J-8	TEMP CONTROL CABLES	....C60	D
	1A2J-9	RELAY & RESISTORS		P
	1A2J-10	VACUUM TANK ASM	....C60	P
	1A2J-11	VACUUM HARNESS DIAGRAM	....C60	D



DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
07NOV80	1	SHT 1A2G-11 CMPR MTG TURBO CANCELED	91222	CU	EJ	
12DEC80	2	E C60 ADDED (3) PLCS	86448	CU	EJ	

DATE 18JAN80
DR R. HEROMINSKI
CK [illegible] HB
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE CONTENTS-HEATER & AIR CONDITIONING
FA00 ALL

REF ECR 86448
NEW 07SE79

UPC 1A2G

SHEET 1

Ch X B D P Ca

1A2K AIR CONDITIONING REFRIGERANT SYSTEM

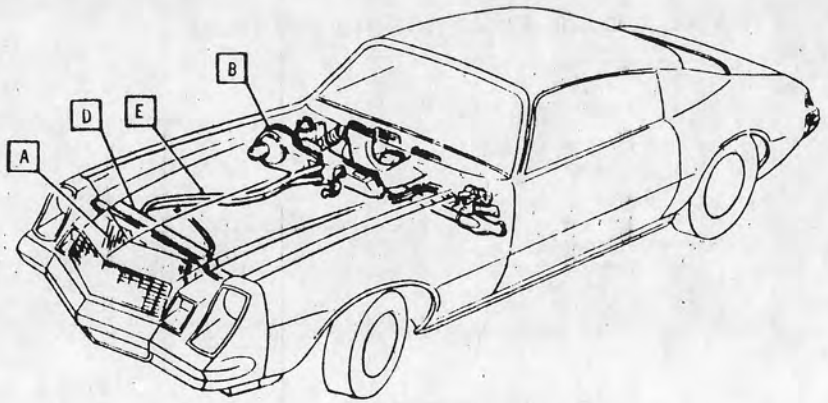
				DIV RESP
A	1A2K-1	CONDENSER ASM	....C60	P
B	1A2K-2	EVAP & BLOWER ASM	....C60	P
C	1A2K-3	OPEN		
D	1A2K-4	FITTING & HOSE ASM	....L39/LG4/LM1	C
(1)	1A2K-5	REFRIG TUBE ASM	....C60	
			....LC3/LD5/L39/LG4/LM1 (exc LU8)	C
	1A2K-6	FITTING & MUFFLER ASM-V6 ENG	....LC3	C
	1A2K-7	OPEN		
	1A2K-8	OPEN		
	1A2K-9	REFRIG HOSES & TUBES	....LD5	D
	1A2K-10	ACCUMULATOR MOUNTING	....LU8	P
(2)	1A2K-11	TUBE ASM & HOSE & FITTING ASM	LU8 &C60	P

1A2L HEATER WATER SYSTEM

E	1A2L-1	HEATER HOSES	....L39/LG4/LM1	C
	1A2L-2	HEATER HOSES	....LC3/L39/LG4/LM1 &C60	C
	1A2L-3	OPEN		
	1A2L-4	OPEN		
	1A2L-5	HOSE ROUTING GEN ARRANGEMENT-V8 ENG	....L39/LG4/LM1 &C60	C
	1A2L-6	OPEN		
	1A2L-7	HEATER HOSES	....LD5	D
	1A2L-8	HEATER HOSES	....LD5 &C60	D
	1A2L-9	OPEN		
	1A2L-10	HEATER HOSES TURBO	....LU8	P
(3)	1A2L-11	HEATER HOSES TURBO	....LU8 &C60	P

1Z

1A2Z-1	TEST PROCEDURE	....C60	P
1A2Z-2	GENERAL SPECS & PROCEDURE	....C60	P



DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
26FEB80	1	TITLE REVISED & C60 ADDED				
	2	TITLE REVISED	87611	ACR		
31MAR80	3	1A2L-12 HEATER & REFRIG HOSE ROUT & TURBO LU8 C60 P REM'D	86448	PHH		

DATE 18JA80
DR R. HEROMINSKI
CK H J Buck HB
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
CONTENTS-HEATER & AIR CONDITIONING
FA00 ALL

REF ECR 86448
NEW 07SE79

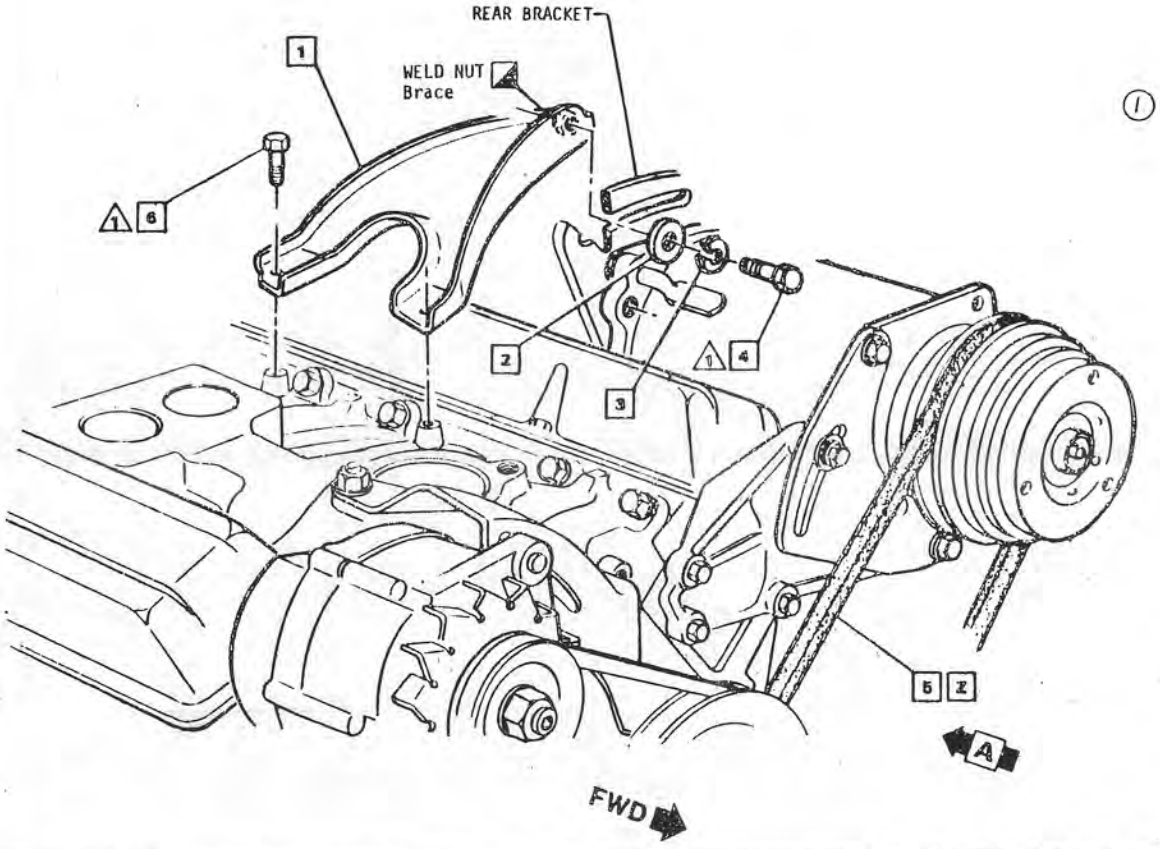
UPC 1A2G

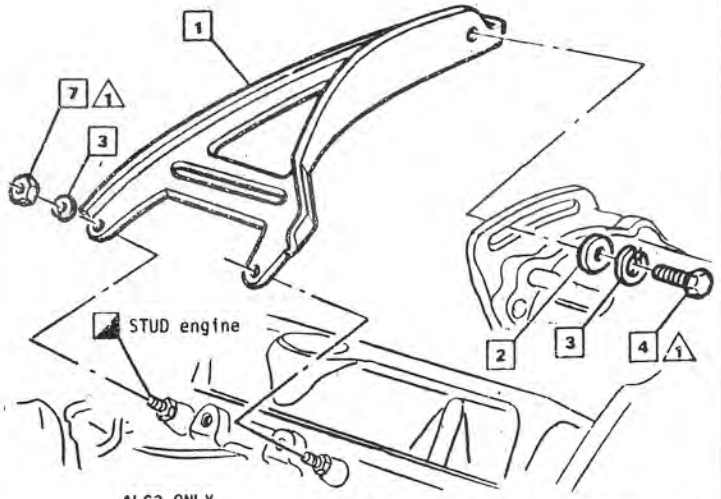
SHEET 2

★ Instructions Carryover
● Waiting Info.

Ch X B O P Ca

462640	1	BRACE ASM-RR &LC3
6271051	1	&LG4/LM1/L39
331247	2	WASHER
103321	3	WASHER
9418823	4	BOLT/SCREW
469582	5	BELT-COMPRESSOR &LC3 or LM1; &LG4 &Z28
469594	5	&L39 or LG4 (exc Z28)
9418821	6	BOLT/SCREW &LG4/LM1/L39
120377	7	NUT





&LC3 ONLY

Z For belt routing & tensioning. See UPC 6Z.

DYNAMIC (Install) N·m	HAND (Insp.) - N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
1 27 - 40		030CB0	1	BELT ROUTING VIEW REM	BCA43	CU	RCT	
2								
3								
4								
5								

1 FULLY DRIVEN, SEATED & NOT STRIPPED

CL ☒ B ☐ O ☐ P ☒ Cu ☐

DATE 15JA80
DR E. LUTH
CK [illegible] HB
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

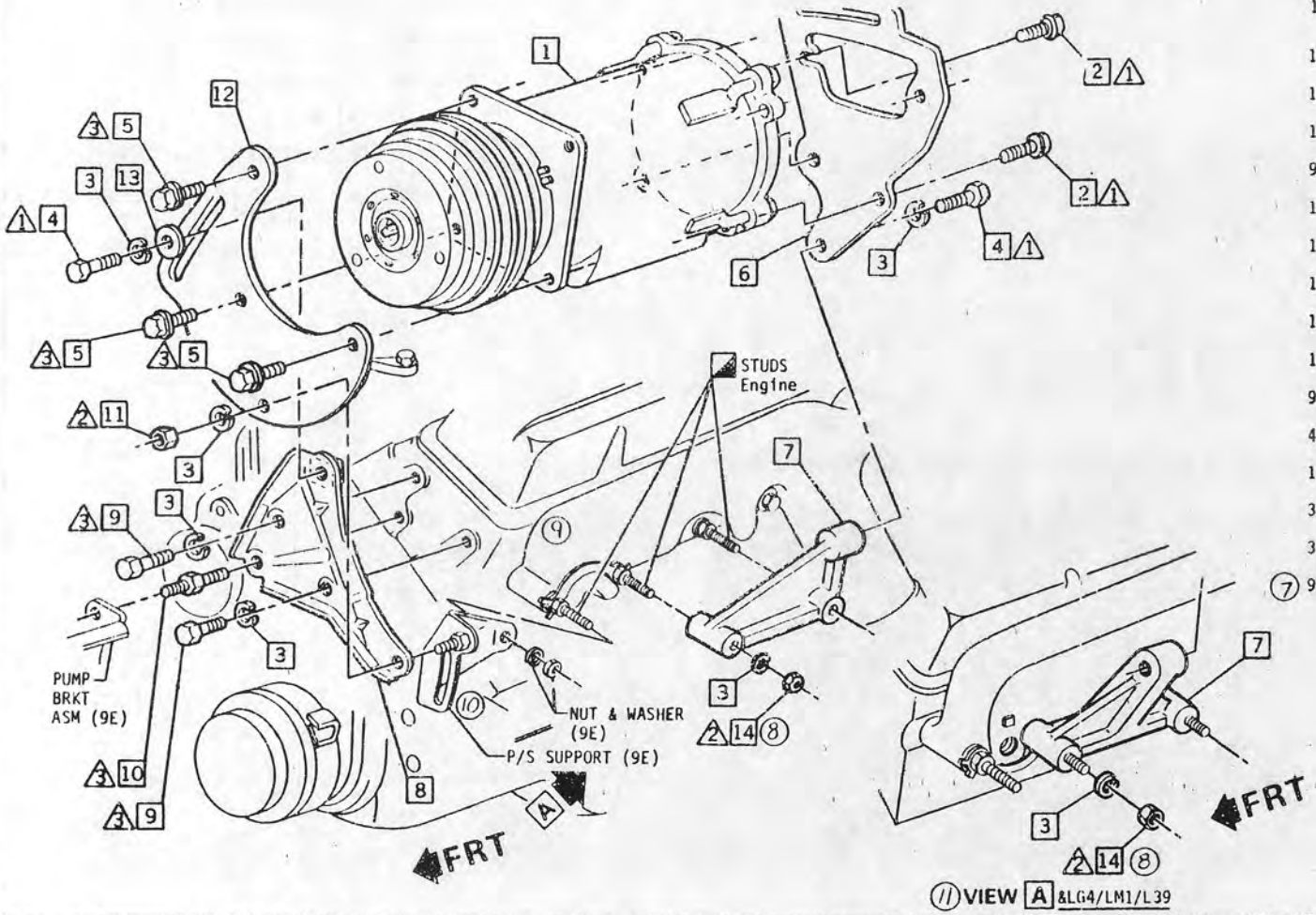
TITLE COMPRESSOR & BELT MOUNTING LC3/LG4/LM1/L39 &C60

REF ECR 86448 C/O 14DE79 1A2G-4

L-91651-S
L-98696-S
L-
L-

UPC 1A2G

SHEET 4



(11) VIEW A &LG4/LM1/L39

1131197	1	COMPRESSOR ASM &L39 or LG4 (exc Z28)
1131191	1	&LC3 or LM1; &LG4 &Z28
11502606	2	BOLT/SCREW
103321	3	WASHER
9418823	4	BOLT/SCREW
11502693	5	BOLT/SCREW
14015519	6	BRKT-RR
14026157	7	SUPT-RR BRKT &LC3
14026188	7	&LG4/LM1/L39
14017790	8	SUPT ASM
9418967	9	BOLT/SCREW
460780	10	STUD
120377	11	NUT
3932433	12	BRKT-FRT
331247	13	WASHER
(7) 9418931	14	NUT

DYNAMIC (Install) N·m | HAND (Insp.) - N·m
1 26 - 38
2 26 - 40
3 20 - 40
4
5
1 FULLY DRIVEN SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHK
030CB0	7	ITEM 14 ADDED				
	8	ITEM 14 WAS 11 (2) PLCS				
	9	MANIFOLD DWG REV				
	10	P/S SUPPORT (9E) DWG REV				
	11	VIEW "A" REV 83293	9906	VJM		

DATE 15JA80
DR E. LUTH
CK H.J. Busch HB
APPR S
APPR
APPR
APPR

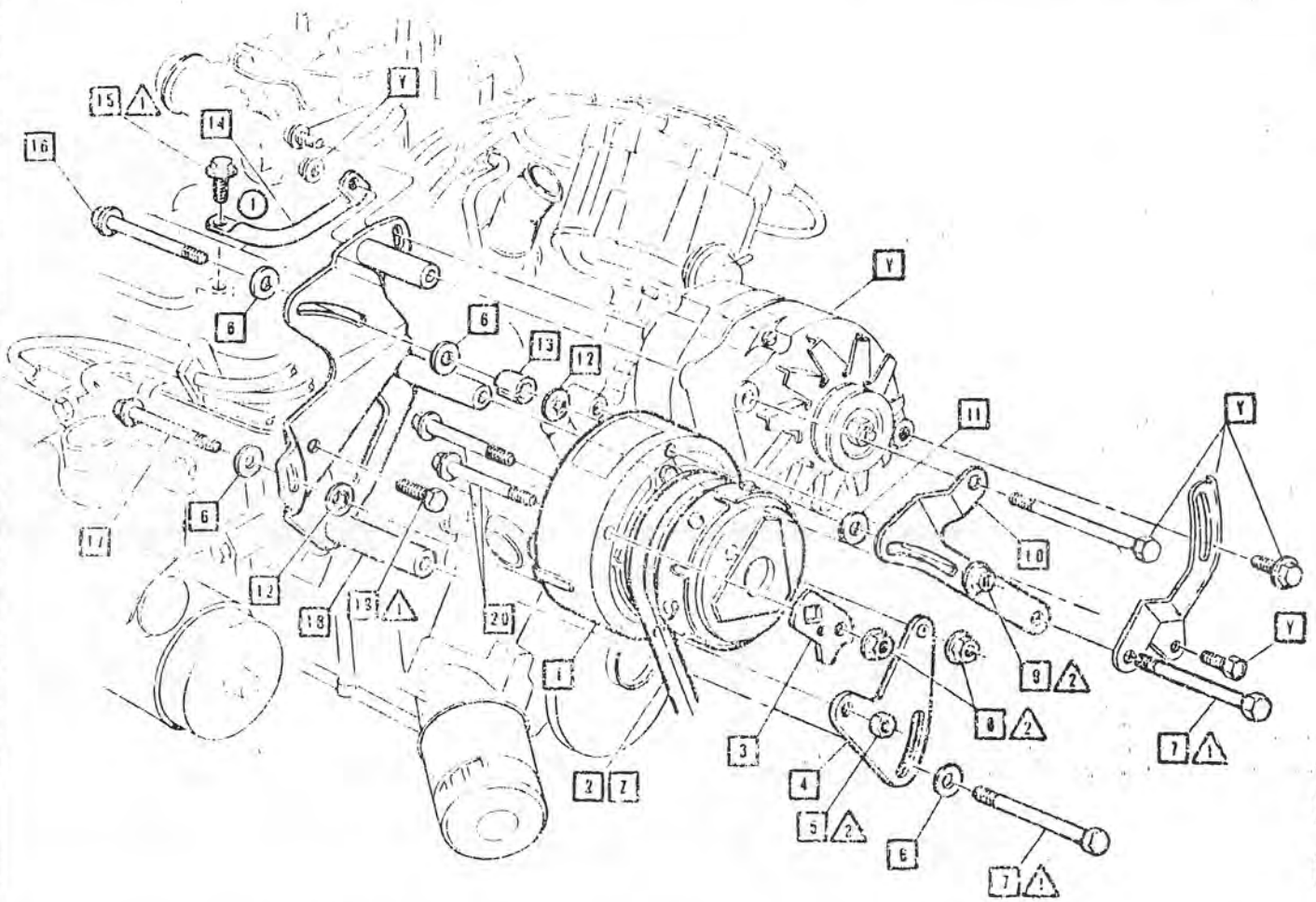
DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE COMPRESSOR MOUNTING LC3/LG4/LM1/L39 &C60

REF ECR 86448 C/O 14DE79 1A2G-5
L- 13621-S L- 13023-S L-
UPC 1A2G
SHEET 5

Ck X B | O | P X Ca



1131198	1	COMPRESSOR ASM
9433752	2	BELT
25503369	3	TAB
25503368	4	ADAPTER
9418931	5	NUT
502306	6	WASHER
9437247	7	BOLT
11501850	8	NUT
1378333	9	NUT
10013949	10	BRACKET
1241106	11	WASHER
11502759	12	NUT-SPRING
1256205	13	SPACER
10013950	14	BRACE
3987930	15	BOLT
9423281	16	BOLT
9419066	17	BOLT
10013946	18	BRACKET ASM.
9420462	19	BOLT
11504967	20	BOLT

Y SEE UPC 6Y-2.1 FOR PART NUMBERS AND INSTALLATION.

Z FOR BELT ROUTING SEE PULLEY AND BELT DIAGRAM-UPC 6Z

DYNAMIC (Instal) N·m | RAND (Insp.) N·m

1 50-70
2 40-54
3
4
5

1 FULLY DRIVEN SEATED & NOT STRIPPED

DATE	SYM	REVISION	ACTD	CK	CR	ENG CHG
10 JAN 80		ISSUED				
12 JAN 81	2	REDRAWN & REDESIGNED				

DATE 28 APR 80
DR
CH
APP
DATE
APP
DATE

GM CHEVROLET

1981 CHEV. "F" 14020867

TITLE
COMPRESSOR MOUNTING
F400 &L05 ACCO

EFF ECR 80446
C/O 17JA20
1A2G-7

21-78593

DTC 1A2G

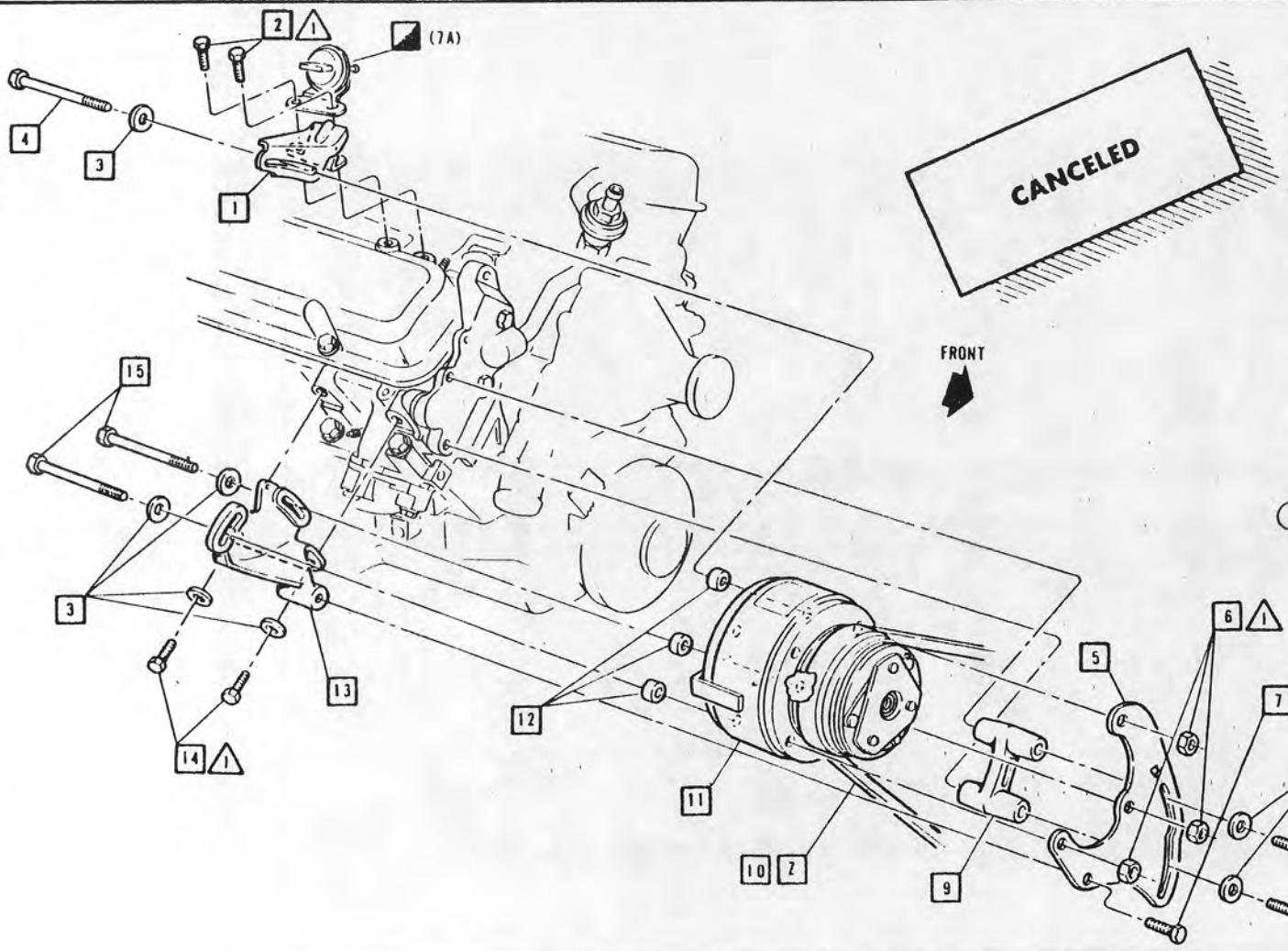
SHEET 7

PONTIAC MOTOR DIVISION

General Motors Corporation Pontiac, Michigan

PRODUCT DESCRIPTION MANUAL

□ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF



+10009578	1	BRACKET
+9428638	2	BOLT (EXC. K30)
502306	3	WASHER
9419187	4	BOLT
546764	5	BRACKET
9418931	6	NUT
180123	7	BOLT
9423688	8	BOLT
10010147	9	SPACER
9433766	10	BELT
1131201	11	COMPRESSOR
(1) 527347	12	SPACER
+10010164	13	BRACKET
+180124	14	BOLT
9419188	15	BOLT

Z FOR BELT ROUTING, SEE "BELT & PULLEY DIAGRAM" - UPC 6Z.

DYNAMIC (Install) N·m	HAND Insp. N·m
△ 26-48	
△	
△	
△	
△	

△ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
15JA80		ISSUED	86448	RH	WB	
24APR80	1	WAS 527345 SPACER	87095	ACA		
07NOV80	2	SHEET CANCELED	DIRR	CU	EZ	

102

DATE
DR P.P. BIERI
CK
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE A/C COMPRESSOR MOUNTING FA00 &C60 &LU8 WITH CH2

REF ECR 86448 C/O 11JA80 1A2G-11

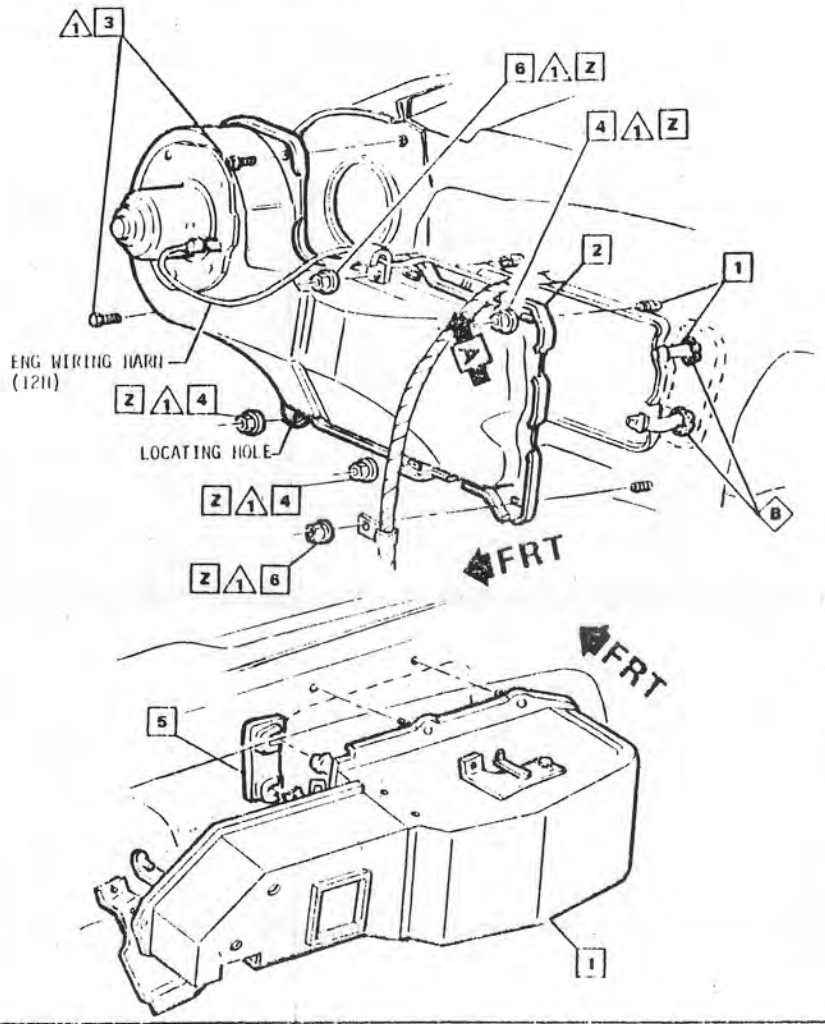
21-77562-S

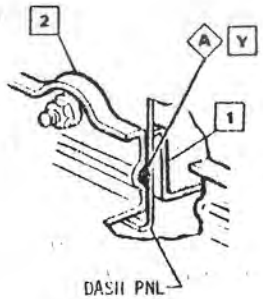
UPC 1A2G

SHEET 11

K&E 18 1283 8-77 3313-

Ch X B O P Co





VIEW A
ASSEMBLED

3023736	1	HEATER & DEFR ASM
3014734	2	BLOWER & INLET ASM
14005067	3	BOLT/SCREW
9419845	4	NUT
3929024	5	GASKET
4786092	6	NUT
(2) 9985059	A	SEALER .114 L
(1) 9980664	B	CEMENT .001 L

Y At time of application, sealer bead must be .38 dia minimum-measured perpendicular to flange & applied in groove around entire periphery of 2

Z Tighten nut to the specified installation torque. The residual torque on nut must register a minimum torque of 10 lbs in after 24 hours.

TORQUE (Install) N·m	HAND (Insp.) N·m
1	2.2 - 4.0
2	
3	
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
12/7/79	1	WAS SEALER .03 02	90931			
	2	WAS SEALER .03 GAL.	90816	MC	AS	

103

DATE 15JAN80
DR HEROMINSKI/ACA
CK HJ Buck 118
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE HEATER & DEFROSTER ASM
FA00 ALL

REF ECR 86448
C/O 14DE79
1A2H-1

L- 88415-S
L- 92282-S
L-
L-

UPC 1A2H

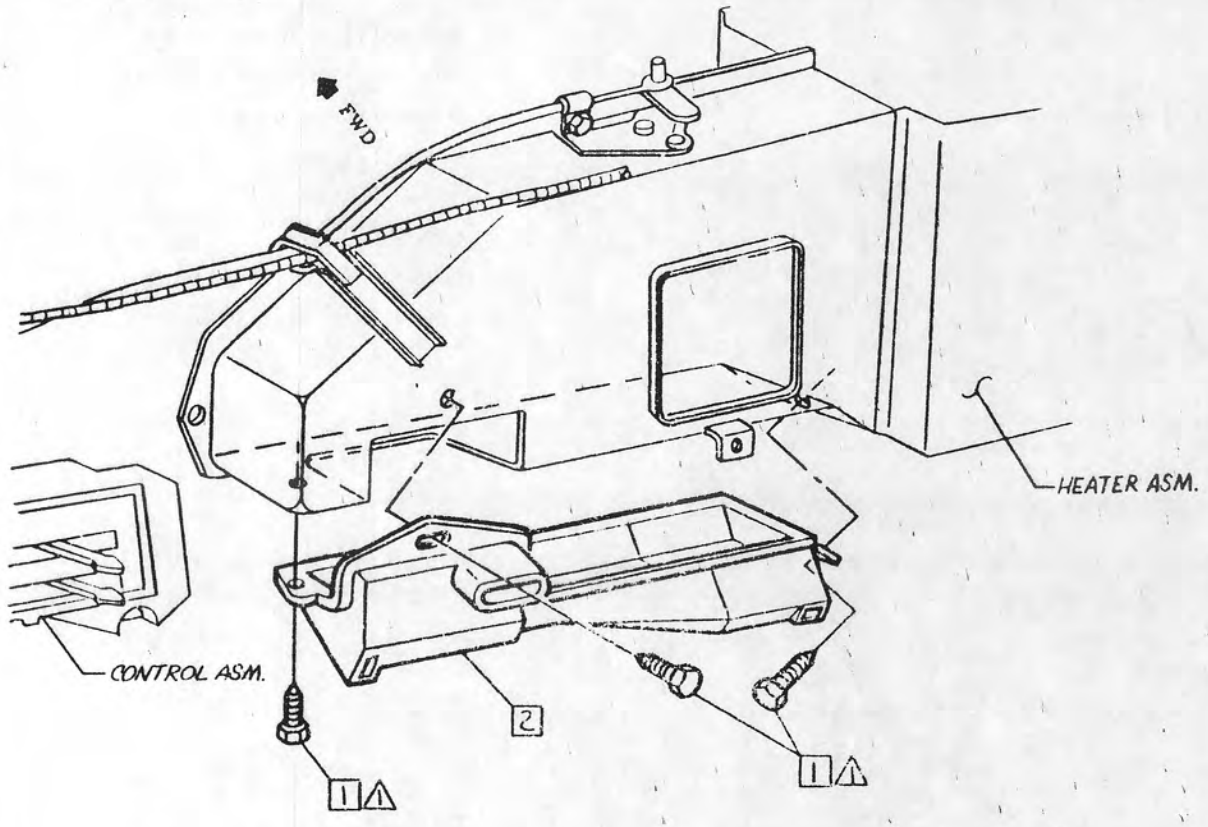
SHEET 1

Ch X B O P Co

General Motors Corporation
CHEVROLET MOTOR DIVISION

PRODUCT DESCRIPTION MANUAL

☐ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF



9427326 [1]	BOLT/SCREW
3973723 [2]	DUCT

TORQUE (Install) N·m	HAND (Insp.) N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM EFF
⚠1 2.2 - 3.4								
⚠2								
⚠3								
⚠4								
⚠5								

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

104

DATE 15JA80
DR HEROMINSKI/ACA
CK WJ Buck HB
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE HEATER CONTROL OUTLET DUCT
FA00 ALL

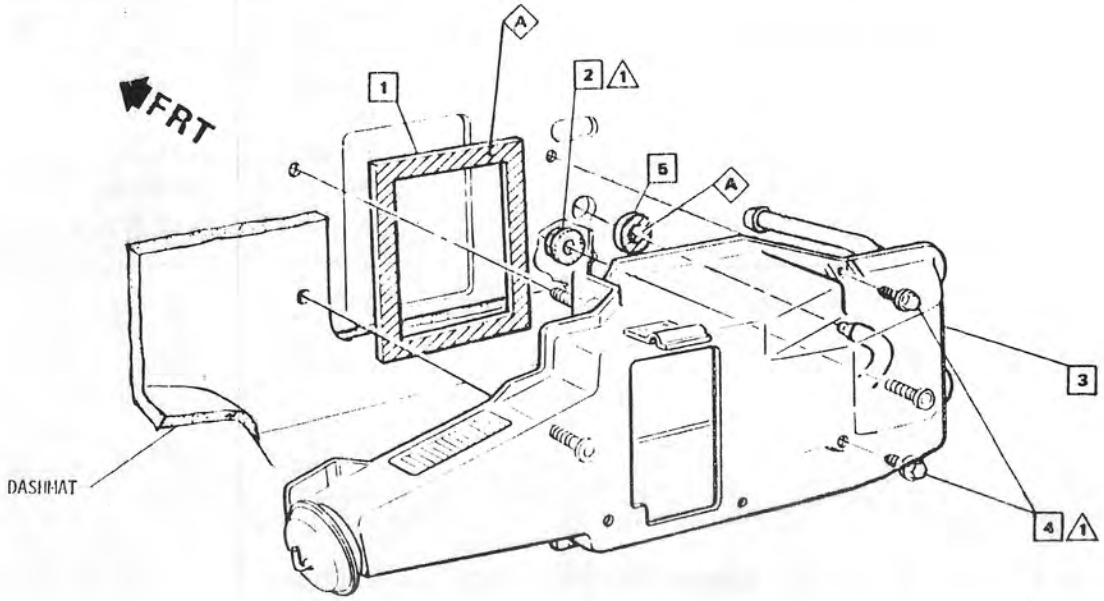
REF ECR 86448
C/O 140E79
'1A2H-2

UPC 1A2H

SHEET 2

PRODUCT DESCRIPTION MANUAL

☐ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF



3963725	1	GASKET
4786092	2	NUT ASM
3035036	3	DUCT-SELECTOR
14005067	4	BOLT/SCREW
3973717	5	SEAL-CORE PIPE-1A2L
/ 9981098	A	ADHESIVE-.001 L

DYNAMIC (Install) N·m	HAND (Insp) N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
1 2.2 - 4.0		11-11-80	L	WAS .04 02.	9093	ACA	ACA	
2								
3								
4								
5								
				105				

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE 15JAN80
DR HEROMINSKI/ACA
TK 71/9 Buick 118
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
SELECTOR & DISTRIBUTOR DUCTS
FA00 &C60

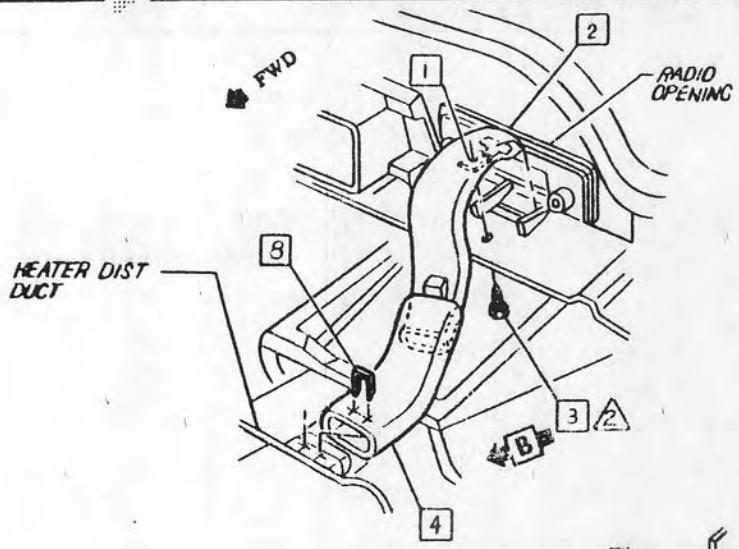
REF ECR 8644B
C/O 14DE79
1A2H-3

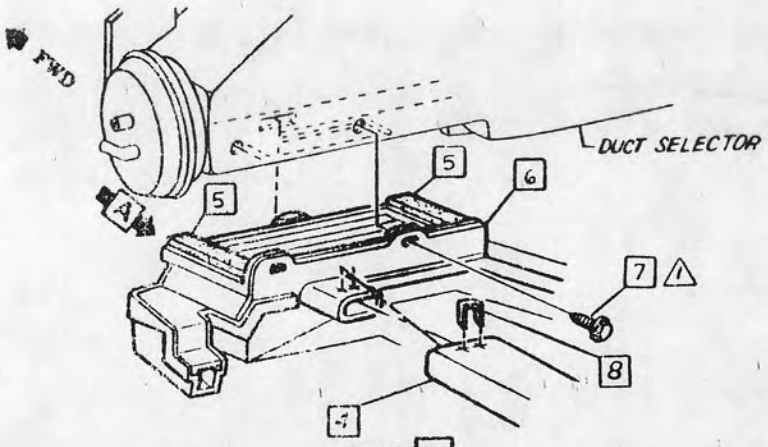
L-90608-S
L-91760-S
L-
L-

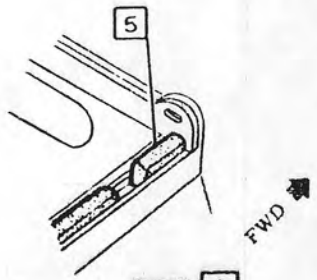
UPC 1A2H

SHEET 3

Ch X B O P Co







VIEW A

VIEW B
CEO ONLY

ITEM	PART NO.	QTY	DESCRIPTION
	9431530	1	NUT
	3967993	2	OUTLET-HEATER
	11503395	3	BOLT/SCREW
	3992108	4	HOSE-HEATER
	3967994	4	&C60
	3967990	5	SEAL
	3967989	6	DUCT ASM
	9433190	7	BOLT/SCREW
	4574015	8	STAPLE

DYNAMIC (tested) N-m	HAND (insp.) - N-m
1	2.2 - 3.4
2	1.6 - 2.2
3	
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
		106				

DATE 15JA80
DR HEROMINSKI/ACA
CK HJBuck HB
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

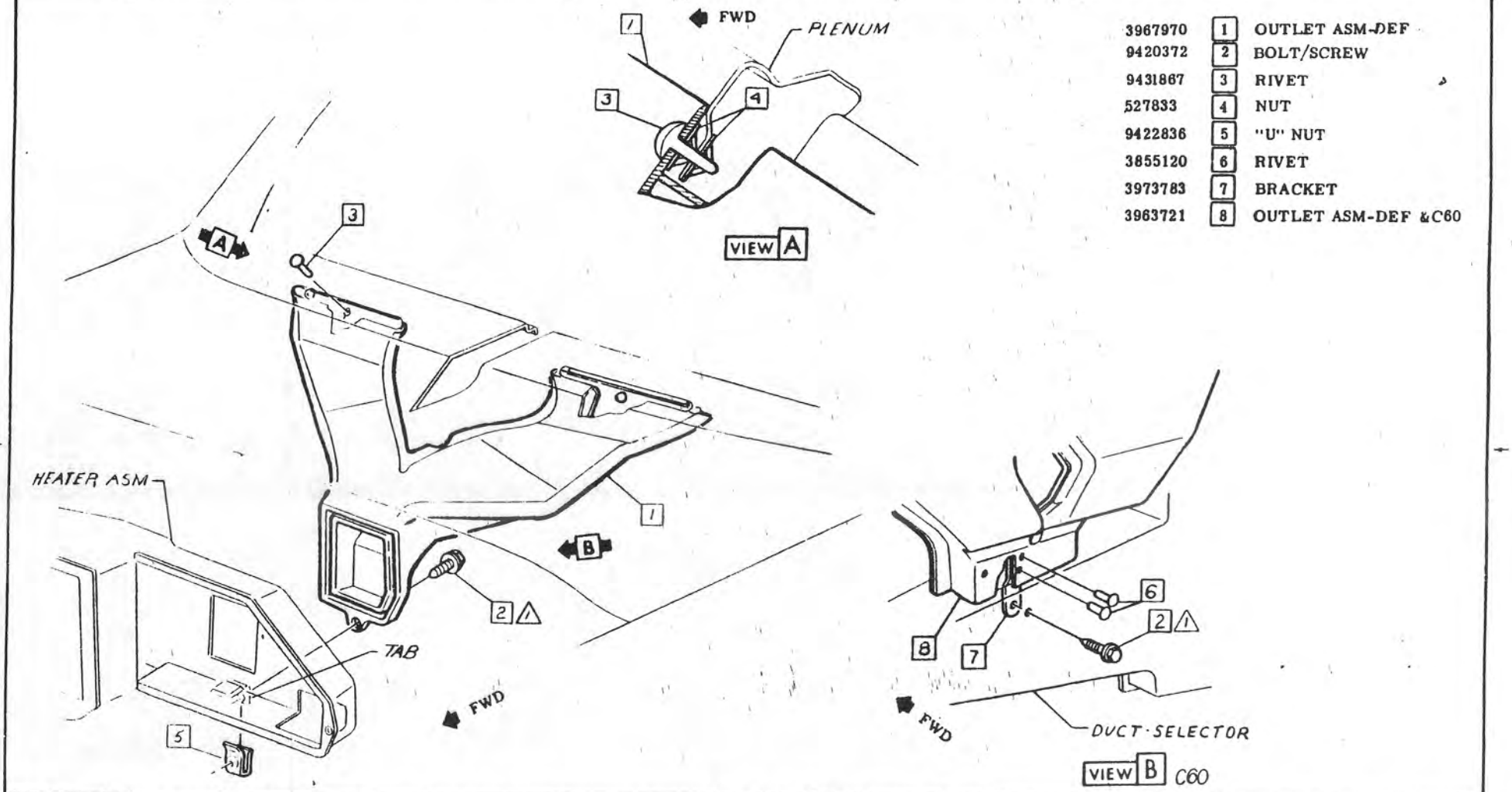
TITLE HEATER OUTLET & A/C DIST DUCT
FA00 ALL

REF ECR 86448
C/O 14DE79
1A2H-4

L-90603-S
L-
L-
L-

UPC 1A2H

SHEET 4



3967970	1	OUTLET ASM-DEF
9420372	2	BOLT/SCREW
9431867	3	RIVET
527833	4	NUT
9422836	5	"U" NUT
3855120	6	RIVET
3973783	7	BRACKET
3963721	8	OUTLET ASM-DEF &C60

DYNAMIC (Install) N·m	HAND (Insp.) N·m
△1	2.8 - 4.0
△2	
△3	
△4	
△5	

△1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASSY CAG
		107				

DATE 15JA80
DRR.HEROMINSKI
CK R.J.Buck HB
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
HEATER & DEFROSTER OUTLET
FA00 ALL

REF ECR 86448
C/O 14DE79
1A2H-5

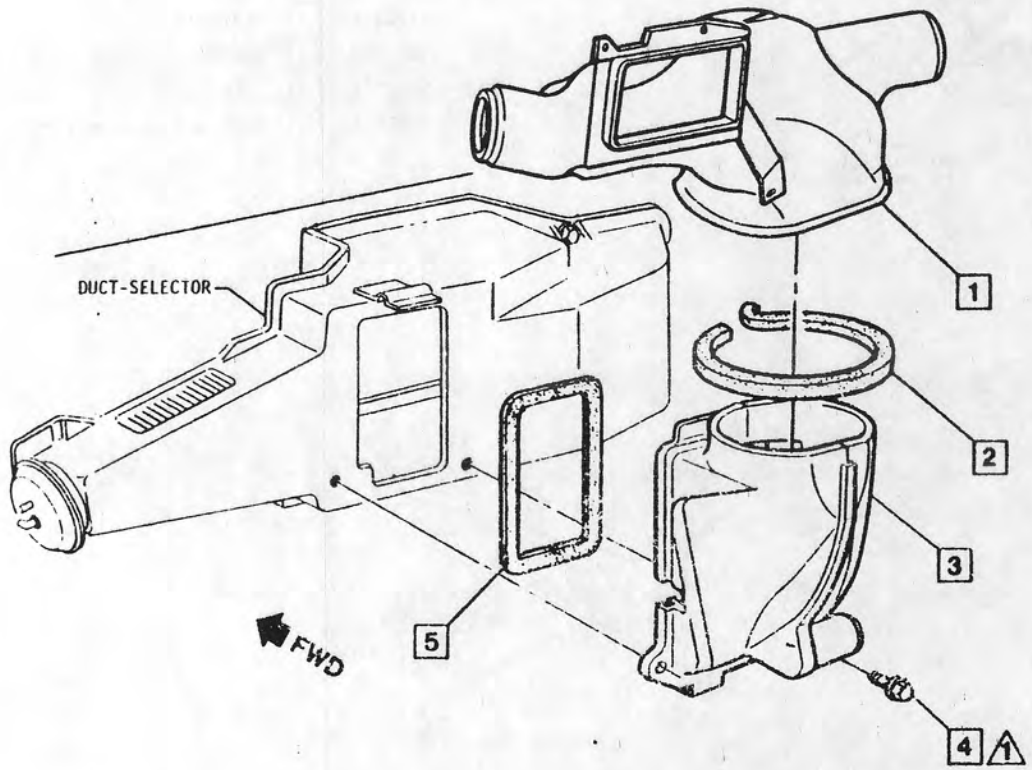
L-92282-S
L-
L-
L-

UPC 1A2H

SHEET 5

Ch - B O P Ca

14001588	1	DUCT ASM-UPPER
3967955	2	SEAL
3963783	3	DUCT ASM-LOWER
9433190	4	BOLT/SCREW
3937167	5	SEAL



DYNAMIC (Instrl) N·m | HAND (Insp.) N·m

1 2.2 - 3.4
2
3
4
5

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	PSM CHG
		108				

DATE 15JAN80
DR HEROMINSKI/ACA
CK 7J Buick HB
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
UPPER & LOWER AIR DIST DUCTS & SEALS
FA00 &C60

REF ECR 86448
C/O 21DE79
1A2H-6

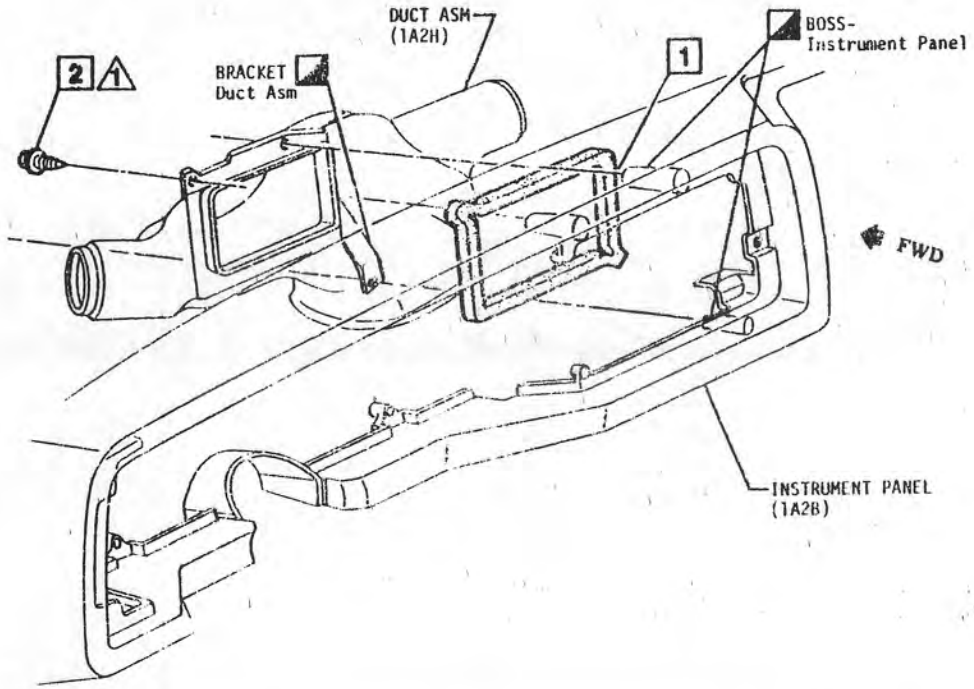
L-18367-S
L-91760-S
L
L

UPC 1A2H

SHEET 6

CS | X | 1 | 0 | P | Ca

14001590	1	SEAL
11502835	2	BOLT/SCREW



DYNAMIC (Install) N·m	HAND (Insp.) N·m	DATE	STA	REVISION	AUTH	DR	CK	ASM ENG
1 1.8 - 2.2								
2								
3								
4								
5				109				

2 FULLY DRIVEN, SEATED & NOT STRIPPED

FS X | E | D | F | Cu

DATE 15JA80
DR HEROMINSKI/ACA
CK NJ Buck 118
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE AIR DIST UPPER DUCT ASM TO INSTRUMENT PANEL FA00 &C60

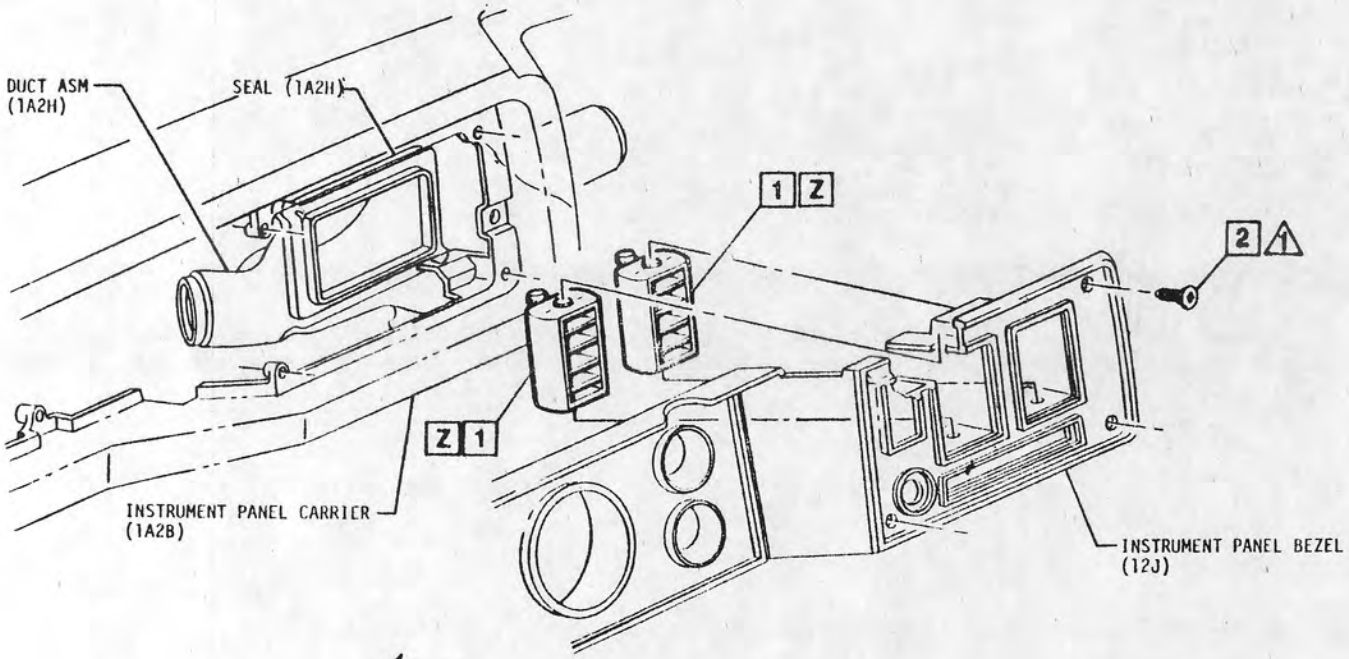
REF ECR 86448
C/O 21DE79
1A2H-6.5

L-18367-S
L-18262-S
L-
L-

UPC 1A2H

SHEET 6.5

(/) 14029571 [1] DEFLECTOR ASM
Ref 12J [2] BOLT/SCREW



Z Install 1 with Felt Washer in the down position.

DYNAMIC (Install) N·m	HAND (Insp.) N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
		14APR80	1	WAS 377513 DEFLECTOR	88201	ACA	TK	

△1 △2 △3 △4 △5 △1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE 15JAN80
DRR. HEROMINSKI/ACA
CK 71 Buick HB
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
CENTER OUTLET DEFLECTOR ASM
FA00 &C60

REF ECR 86448
C/O 21DE79
1A2H-7

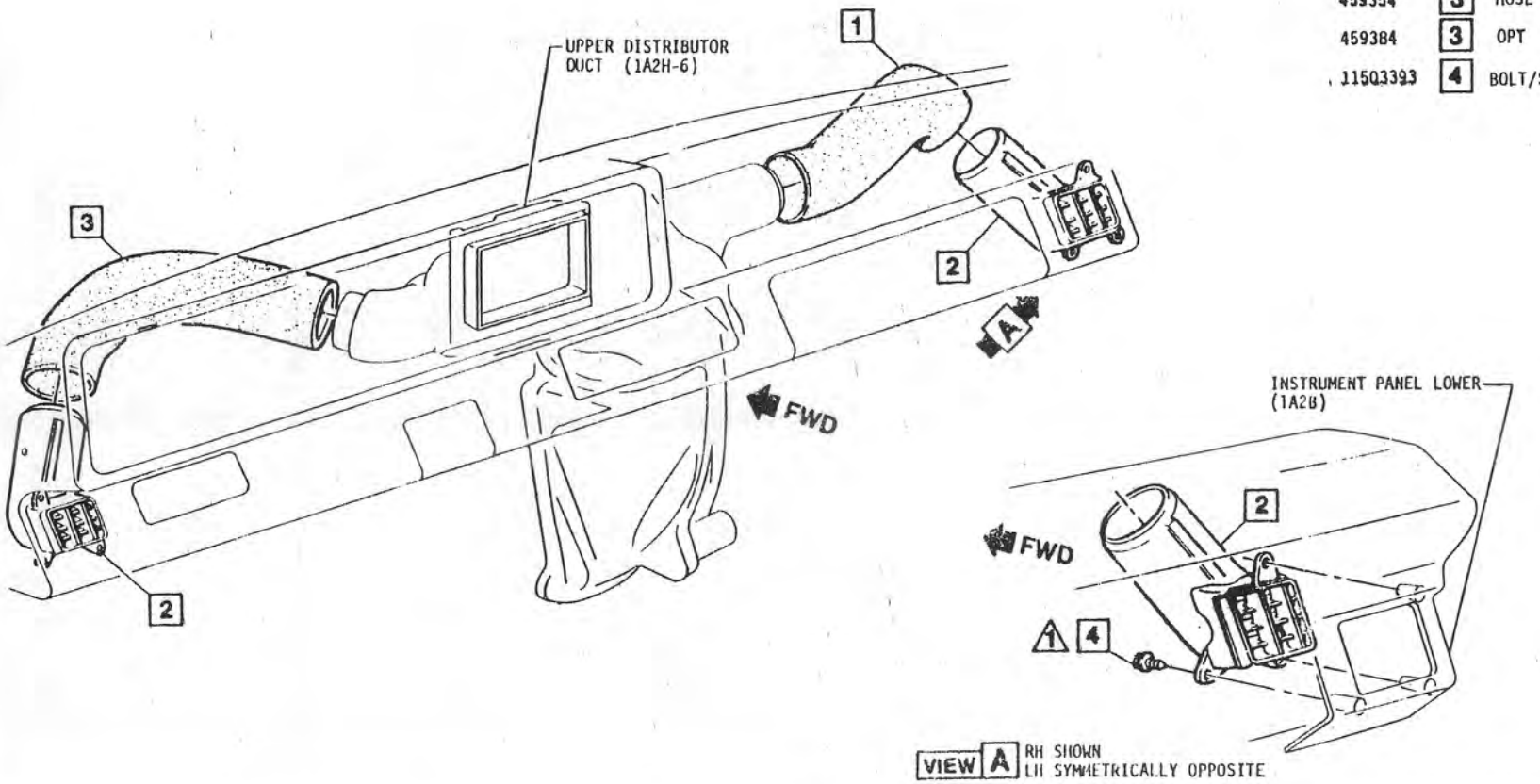
L-18367-S
L-18262-S
L-
L-

UPC 1A2H

SHEET 7

Ck ☒ B ☐ O ☐ P ☐ Co ☐

3946930	1	HOSE RH
364068	1	OPT
/1 14032009	2	CHART-OUTLET ASM SI (UPC "0"-P/L)
459354	3	HOSE LH
459384	3	OPT
11503393	4	BOLT/SCREW (SD)



VIEW A RH SHOWN
LH SYMMETRICALLY OPPOSITE

DYNAMIC (Install) N·m | HAND (Insp.) · N·m

1 1.2 - 1.6

1

1

1

1

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
11APR80	1	VAS 354727 CHART	88201	ACA	[illegible]	

DATE 15JA80
DRR. HEROMINSKI/ACA
CK HJ Buick HB
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE SIDE OUTLET, DUCT & HOSE FA00 &C60

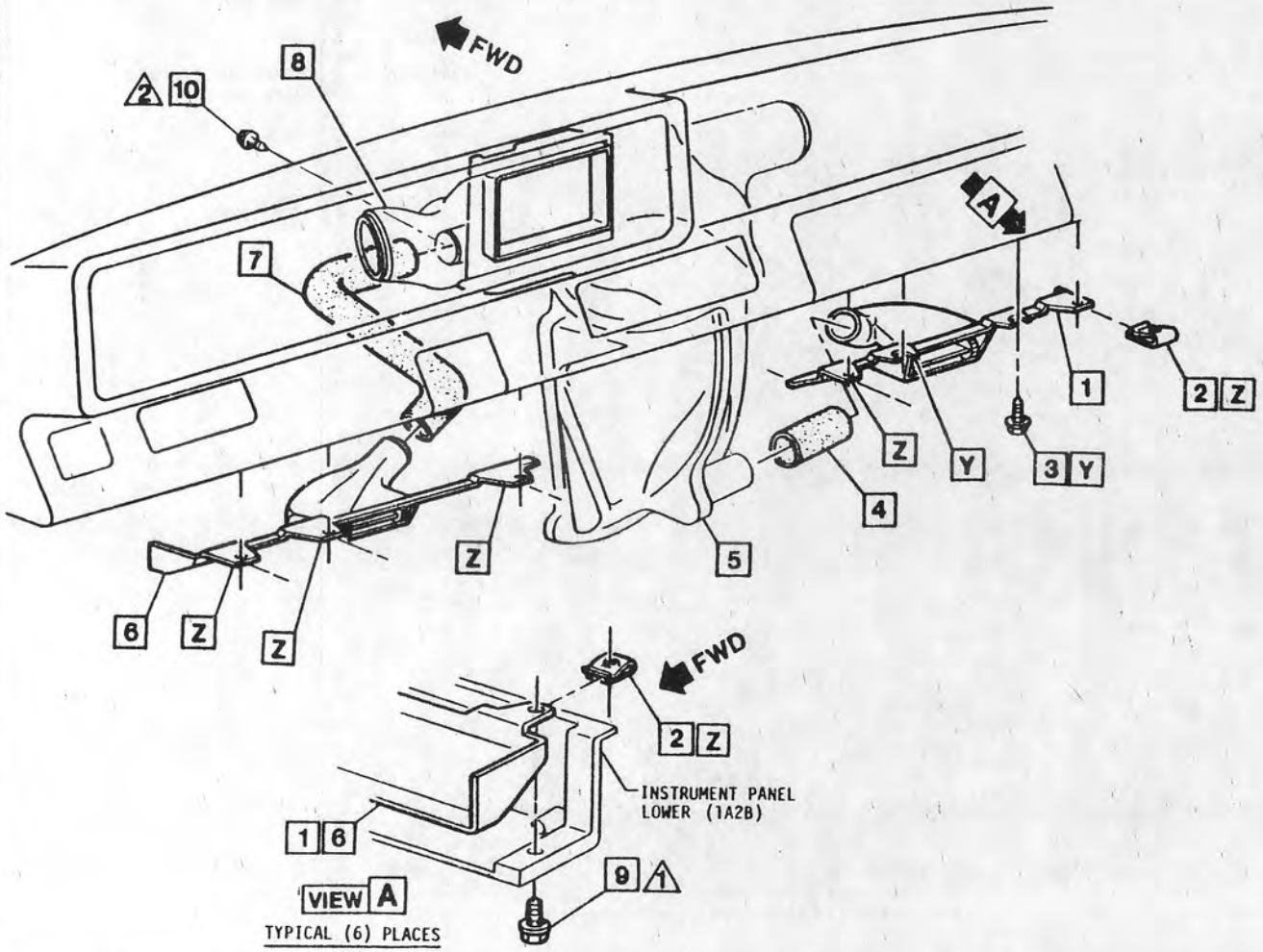
REF ECR 86448 C/O 21DE79 1A2H-8

L-91334-S L-18262-S L-18367-S L-86983-S

UPC 1A2H

SHEET 8

Ch X B O P Ca



340460	1	*CHART-OUTLET LOWER RH
9427761	2	"U" NUT
Ref 1A2B	3	BOLT/SCREW
3967999	4	HOSE
364070	4	OPT
Ref 1A2H-6	5	DIST DUCT LOWER
340469	6	*CHART-OUTLET LOWER LH
3777948	7	HOSE
364070	7	OPT
Ref 1A2H-6	8	DIST DUCT-UPPER
11503395	9	BOLT/SCREW
11503393	10	BOLT/SCREW

Y Use 3 this location only.
Z Use 2 this location only.

*(UPC "0"-P/L)

DYNAMIC (Install) N·m	HAND (Insp.) N·m
1	1.6 - 2.2
2	0.6 - 1.0
3	
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
		112				

DATE 15JA80
DR HEROMINSKI/ACA
CK HJ Buck HB
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
LOWER OUTLETS & HOSES
FA00 &C60

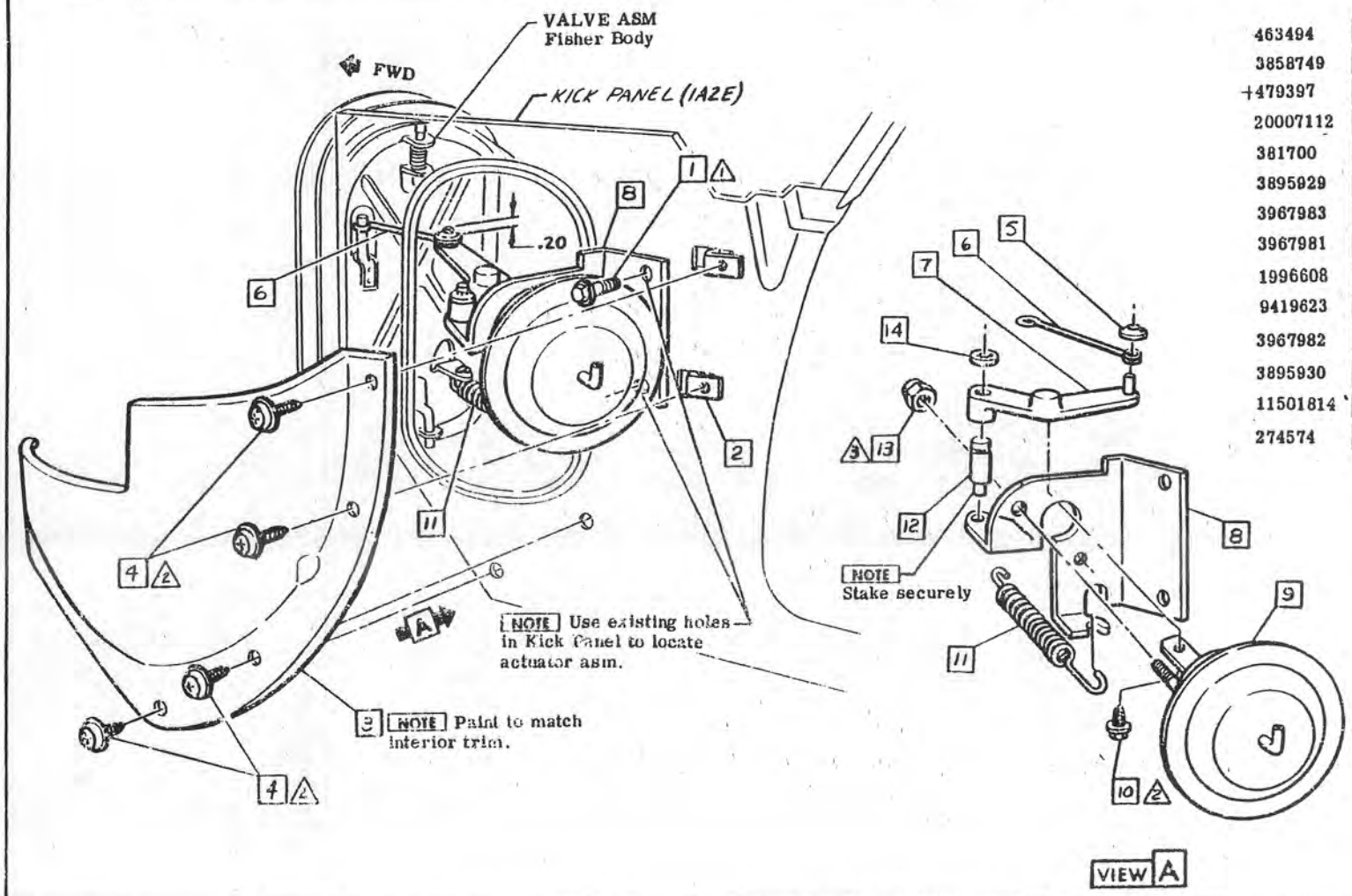
REF ECR 86448
C/O 21DE79
1A2H-9

L-18262-S
L-91418-S
L-18367-S
L-

UPC 1A2H

SHEET 9

Ch X B O P Ca



463494	1	BOLT/SCREW	
3858749	2	"J" NUT	
+479397	3	COVER	
20007112	4	BOLT/SCREW	
381700	5	NUT	
3895929	6	LINK	
3967983	7	ARM	
3967981	8	BRACKET	
1996608	9	ACTUATOR ASM	
9419623	10	BOLT/SCREW	
3967982	11	SPRING	
3895930	12	PIN	
11501814	13	NUT	
274574	14	RETAINER	

DYNAMIC (Initial) N·m | HAND (Insp.) N·m

△1 4.0 - 5.5
△2 1.6 - 2.2
△3 2.2 - 3.4
△4
△5

△ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG

DATE 15JA80
DR HEROMINSKI/ACA
CK HJ Buck. HB
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

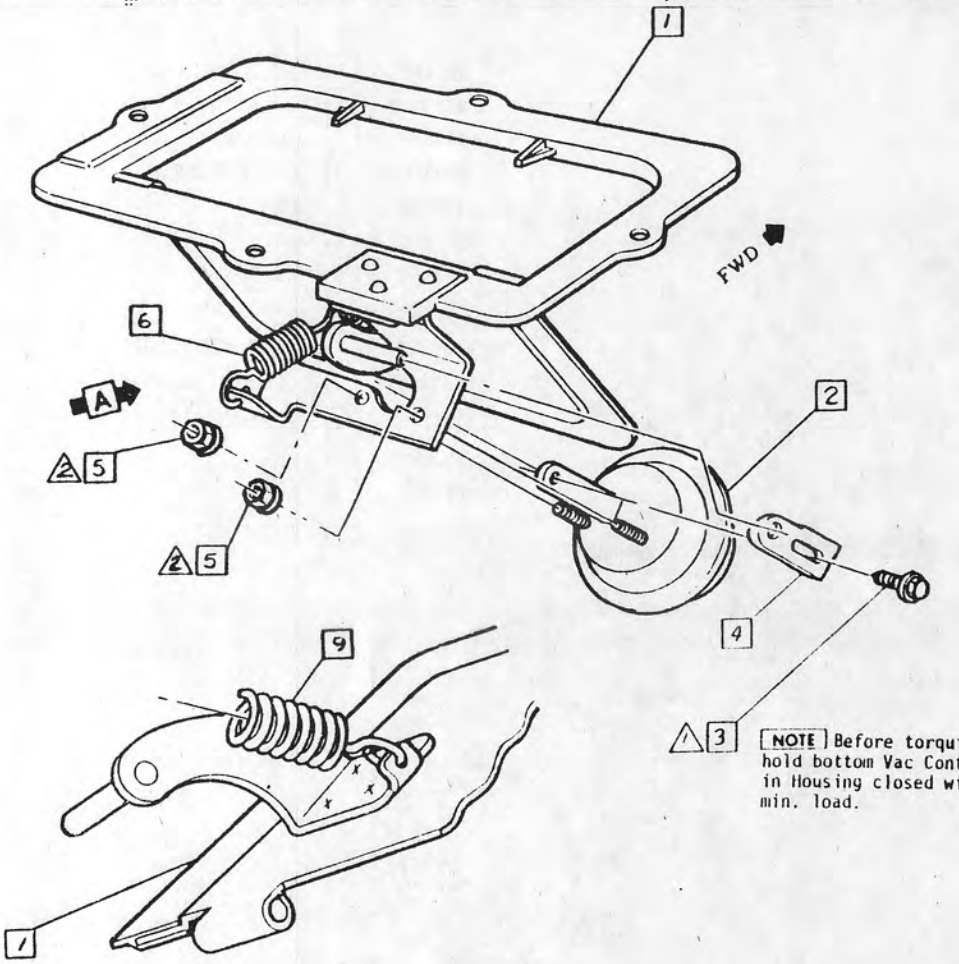
TITLE SIDE SHROUD VALVE
FA00 &C60

REF ECR 8644B
C/O 21DE79.
1A2J-1

L-91543-S
L-
L-

UPC 1A2J

SHEET 1



3979732	1 INLET ASM -1A2H
1996597	2 ACTUATOR
558688	3 BOLT/SCREW
3963736	4 LINK
11501814	5 NUT ASM
3891706	6 SPRING

DYNAMIC (Install) N·m	HAND (Insp.) N·m
	△1 1.6 - 2.2
	△2 2.2 - 3.4
	△3
	△4
	△5

△1 FULLY DRIVEN SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
		1 1 6				

DATE 15JA80
DR HEROMINSKI/ACA
CK HJBuck HB
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE PLENUM VALVE FA00 &C60

REF ECR 86448 C/O 21DE79 1A2J-2

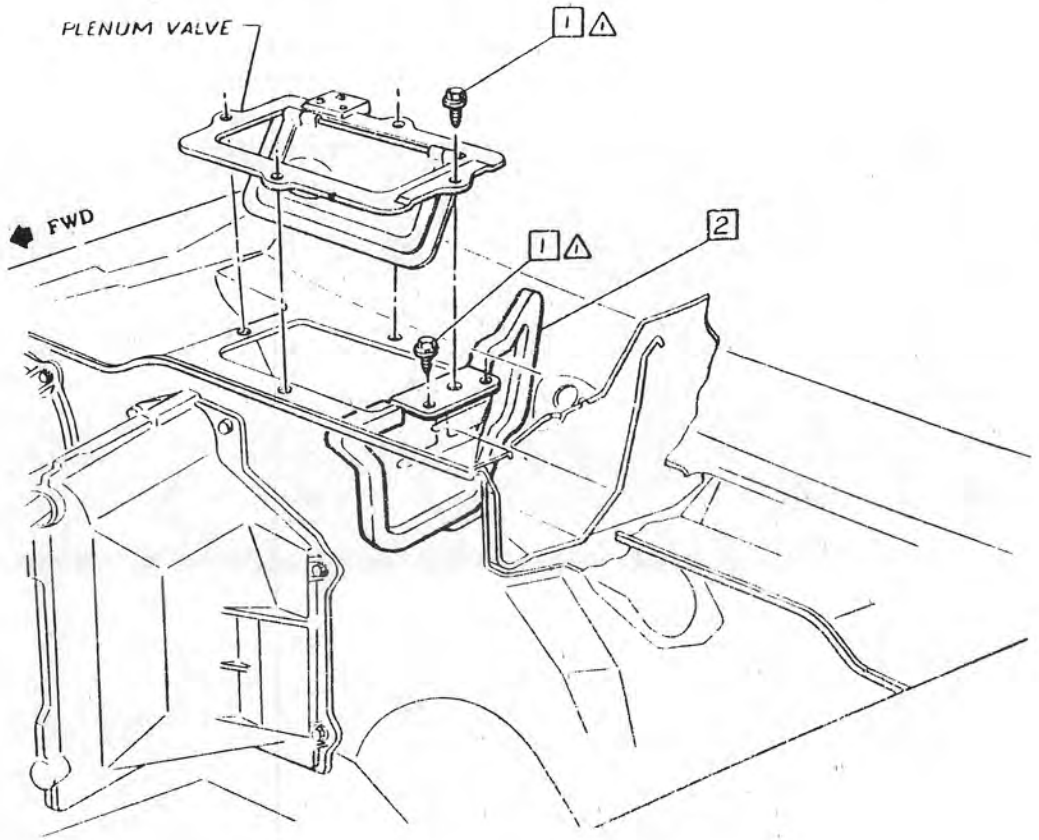
L-90755-S

UPC 1A2J

SHEET 2

Ch X B D P Ca

9419303	1	SCREW
3998417	2	BAFFLE ASM



DYNAMIC (Install) N·m	HAND (Insp.) N·m
1 △	1.6 - 2.4
2	
3	
4	
5	

△ FULLY DRIVEN SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
15JAP0		ISSUED	EC-446	RH	HA	

DATE 13AP79
DR
CK
APPR S
APPR
APPR
S. PW

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE PLENUM VALVE & BAFFLE
FA00 &C60

REF ECR 86446
C/O 11JAB0
1A2J-3

L 90775-S

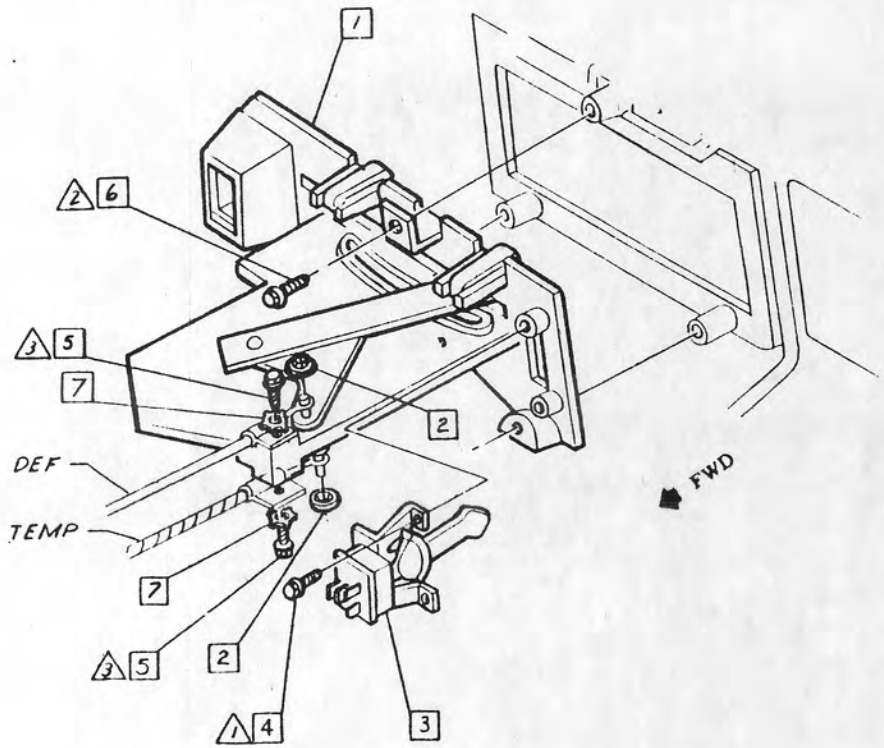
UPC 1A2J

SHEET 3.

CA M B O P Co

PRODUCT DESCRIPTION MANUAL

□ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF



14022052	1	CONTROL ASM
381700	2	NUT
3963769	3	SWITCH ASM
11502833	4	BOLT/SCREW
9418857	5	BOLT/SCREW
11503395	6	BOLT/SCREW
138479	7	WASHER

DYNAMIC (Instal) N·m	HAND (Insp.) N·m
1	1.2 - 1.6
2	1.6 - 2.2
3	1.4 - 2.0
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG

DATE 16JA80
DR. HEROMINSKI/ACA
CK HJ Bruck HB
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE HEATER CONTROL ASM
FA00 ALL

REF ECR 86448
C/O 14DE79
1A2J-4

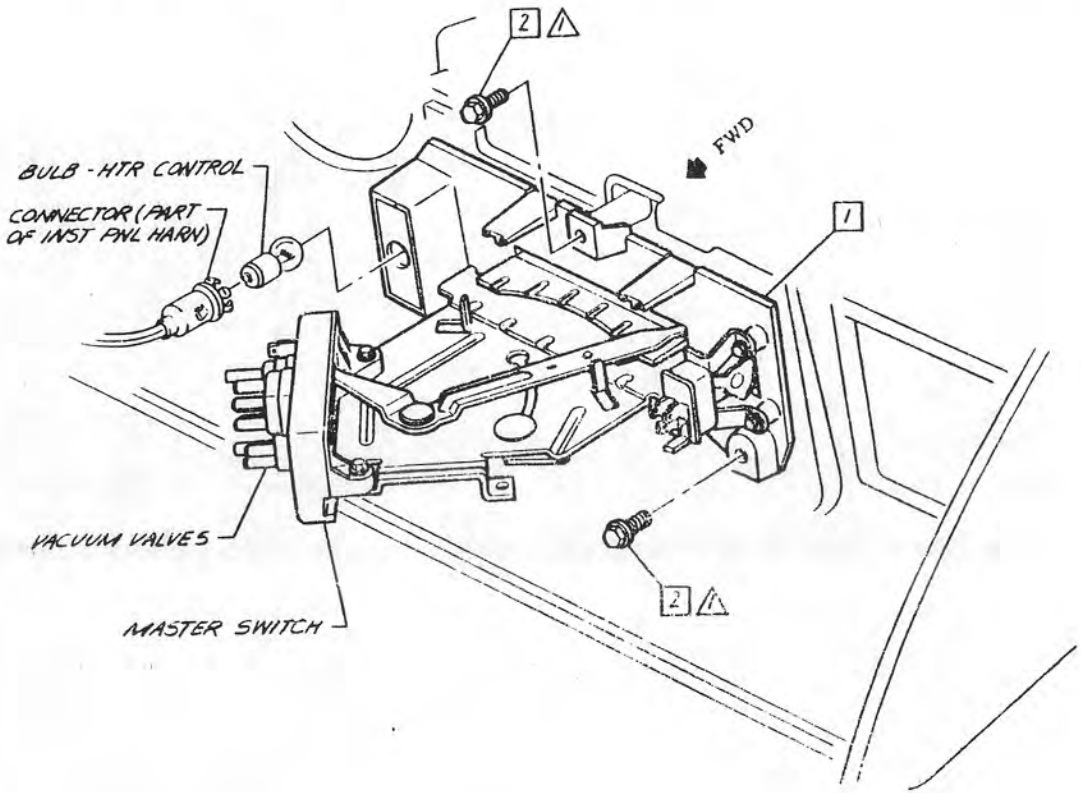
L-92292-S
L-92353-S
L-
L-

UPC 1A2J

SHEET 4

Ck | | D | | O | | P | | Ca | |

14022054	1	CONTROL ASM
11503395	2	BOLT/SCREW



DYNAMIC (Install) N·m	HAND (Insp.) N·m
△1	1.6 - 2.2
△2	
△3	
△4	
△5	

△1 FULLY DRIVEN SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG

DATE 16JA80
DR HEROMENSKI/ACA
CK HG Buck 11B
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE CONTROL ASM F&00 &C60

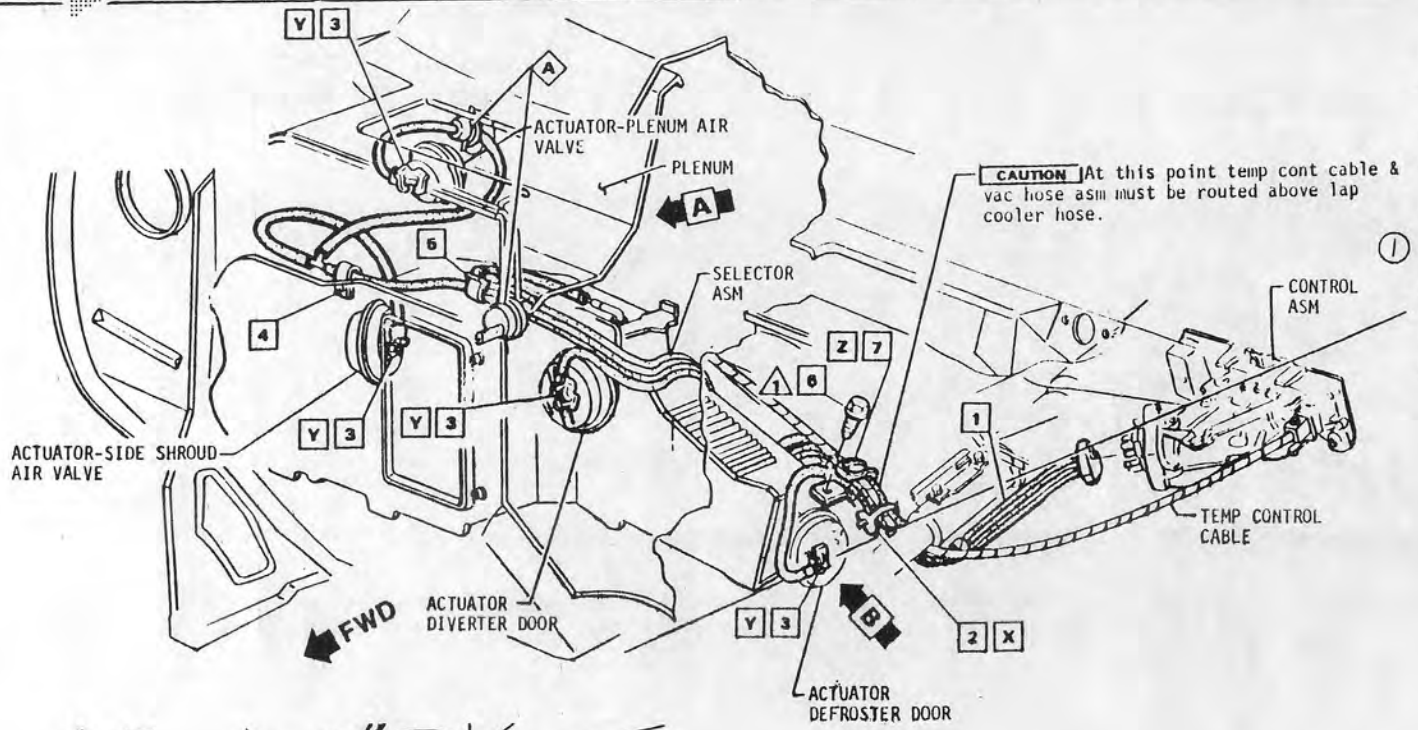
SEE ECR 86448 C/O 140E79 1A2J-5

1-03261-S

UPC 1A2J

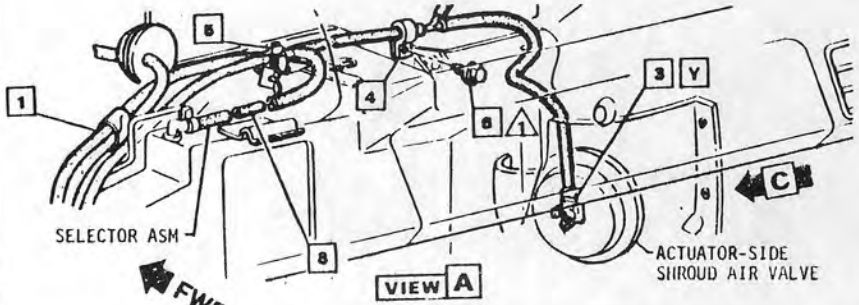
SHEET 5

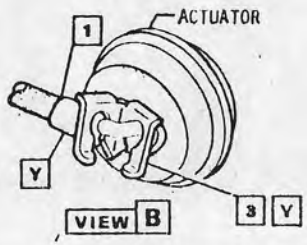
CL - B D P Co

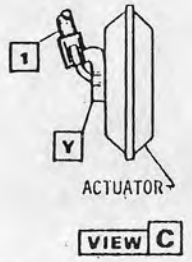


CAUTION At this point temp cont cable & vac hose asm must be routed above lap cooler hose.

370162	1	HOSE ASM-VACUUM
9422033	2	STRAP
3984660	3	CLIP
9425316	4	CLIP
3827371	5	CLIP
(1) 9419303	6	BOLT/SCREW
9796611	7	CLIP
3949848	8	CONNECTOR
9980664	A	SEALER-.10 OZ.







X Locate approx 2.0 inboard from steering column.

Y Typical 4 places.

Z Position harness in clip 20.50 from connector (control end).

DYNAMIC (Install) N·m	HAND (Insp.) N·m
△1	1.6 - 2.2
△2	
△3	
△4	
△5	

△1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
20JN80	1	WAS 9427326 BOLT/SCREW	86816	ACA	HB	

DATE 18AP80
DR HEROMINSKI/ACA
CK
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
INSTRUMENT PANEL VACUUM ROUTING
FA00 &C60

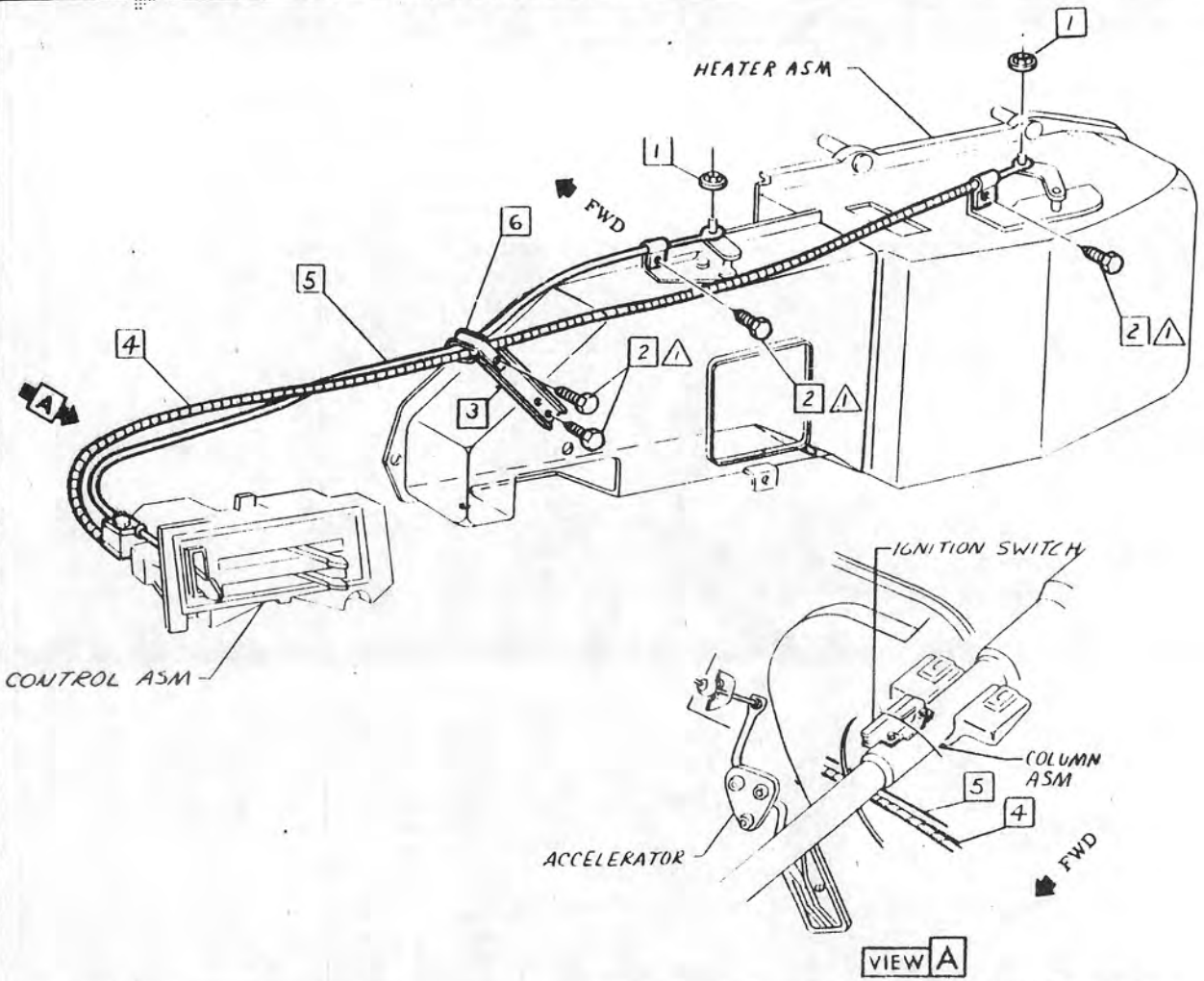
REF ECR 86448
C/O 08AP80
1A2J-6

1-90608-S
1-90775-S
1-92053-S
1-

UPC 1A2J

SHEET 6

Cb X B O P Co



381700	1	NUT - PUSH ON
9419303	2	BOLT/SCREW
3992135	3	SUPPORT
3973736	4	CABLE ASM (TEMP)
3973737	5	CABLE ASM (DEF)
3992136	6	CLIP

DYNAMIC (Install) N·m	HAND (Insp) N·m
1	1.6 - 2.4
2	
3	
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG

DATE 16JA80
DR SIENKIEWICZ/ACA
CK H J Buck HB
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
HEATER CONTROL CABLES
FA00 ALL

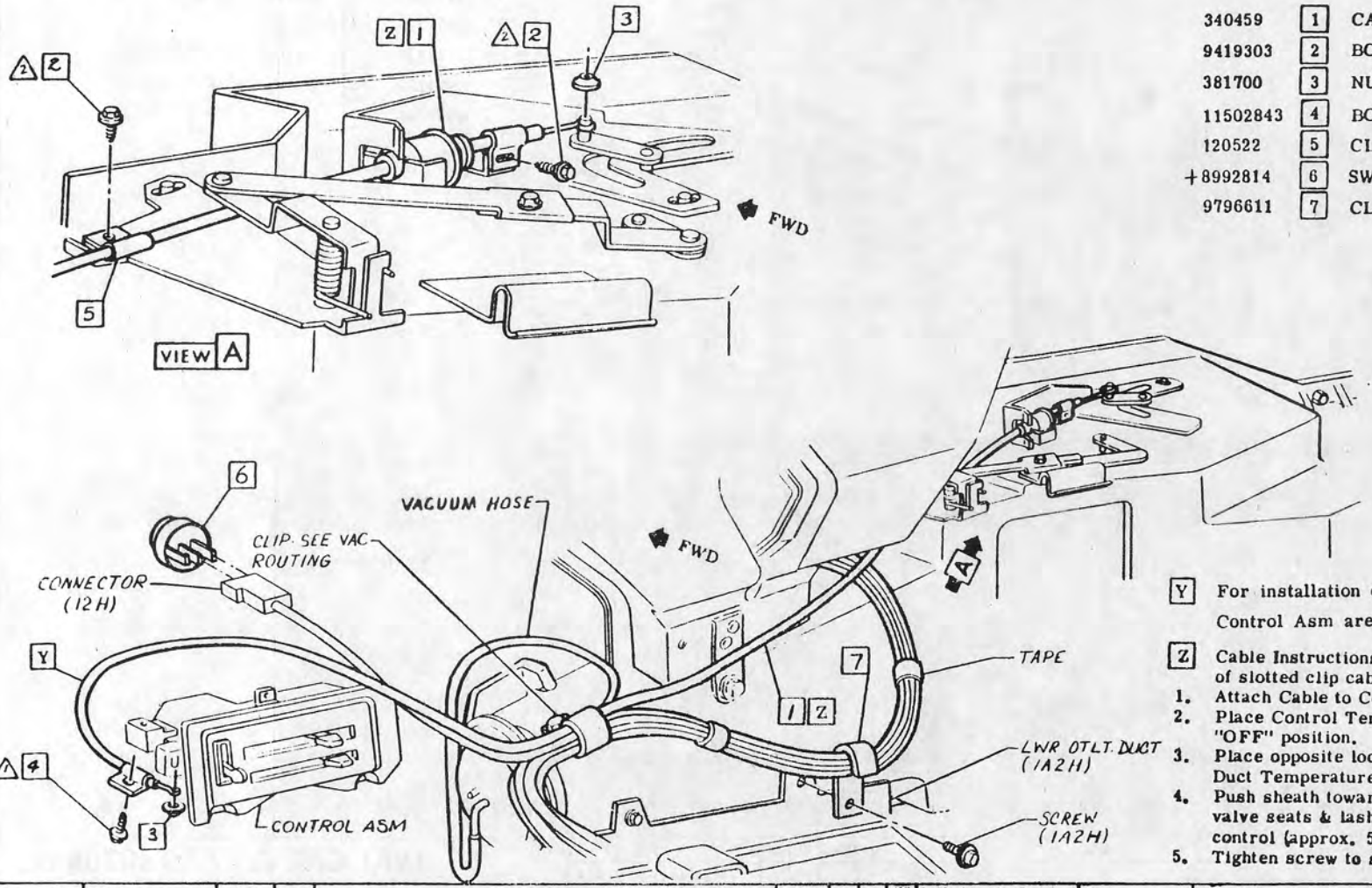
REF ECR 86448
C/O 14DE79
1A2J-7

L- 92282-S
L-
L-
L-

UPC 1A2J

SHEET 7

Ch | I | O | P | Co



340459	1	CABLE ASM
9419303	2	BOLT/SCREW
381700	3	NUT - PUSH ON
11502843	4	BOLT/SCREW
120522	5	CLIP
+8992814	6	SWITCH ASM
9796611	7	CLIP

Y For installation of 1 in Control Asm area, see 1A2J-6.

Z Cable Instructions for installation of slotted clip cables:

1. Attach Cable to Control Asm.
2. Place Control Temperature Lever in "OFF" position.
3. Place opposite loop of cable on Selector Duct Temperature Lever Pin.
4. Push sheath toward Heater Lever until valve seats & lash is out of cable and control (approx. 5 lbs.).
5. Tighten screw to secure cable.

DYNAMIC (Initial) N·m	HAND (Insp.) N·m
△1	1.6 - 2.2
△2	2.2 - 3.4
△3	
△4	
△5	

△ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG

DATE 16JA80
DR. HEROMINSKI/ACA
CK HJBuck HR
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE TEMPERATURE CONTROL CABLE FA00 &C60

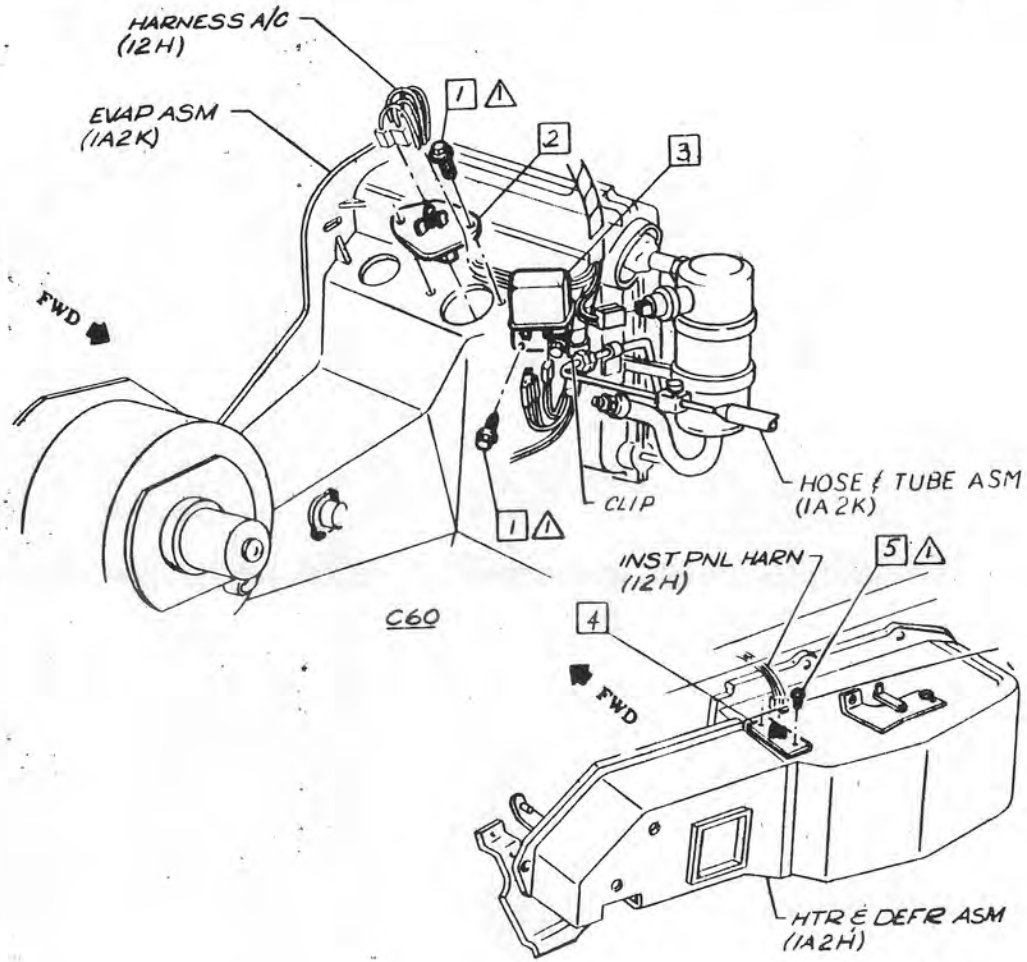
REF ECR 86448 C/O 14DE79 1A2J-8

L-90608-S L-90616-S L-92053-S L-

UPC 1A2J

SHEET 8

125



9420731	1	BOLT/SCREW
6262655	2	RESISTOR ASM
(1) 14036273	3	RELAY ASM
3929052	4	RESISTOR ASM
9419303	5	BOLT/SCREW

exc C60

DYNAMIC (Install) N·m	HAND (Insp.) N·m
△1	1.6 - 2.2
△2	
△3	
△4	
△5	

△ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
15NOV80	1	WAS 463468 RELAY	92494	CU	KC	

121

DATE 16JA80
DR HEROMINSKI/ACA
CK NJ Buck HB
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE RELAY & RESISTORS
FA00 ALL

DEF ECR 86448
C/O 14DE79
1A2J-9

L-93854-S
L-90608-S
L-11611-S
L-

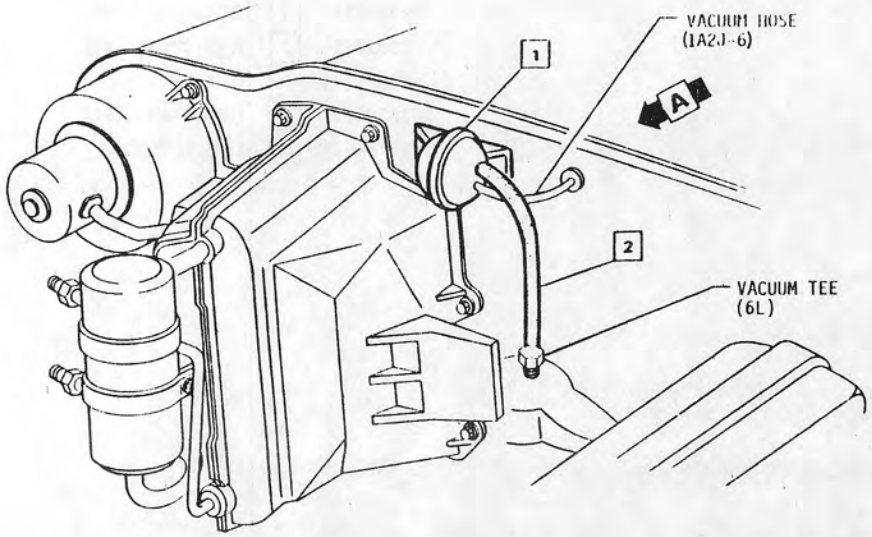
UPC 1A2J

SHEET 9

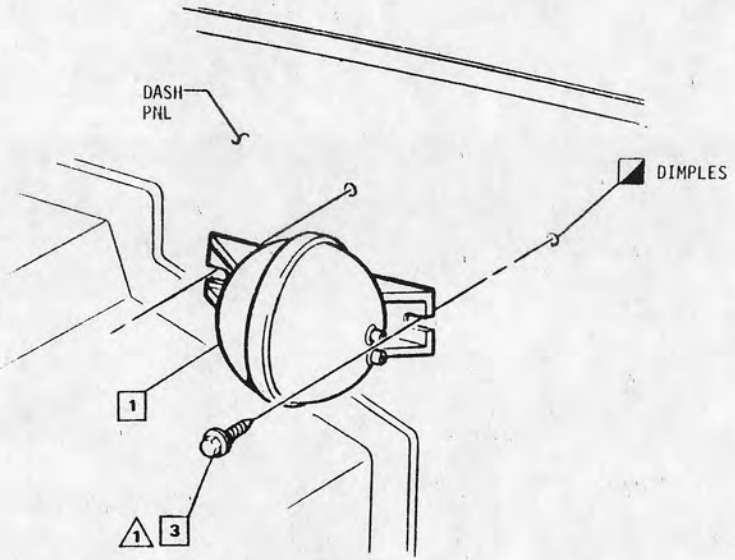
Ch X B O P Ca

PRODUCT DESCRIPTION MANUAL

□ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF



340482	1	VACUUM TANK ASM
340483	1	OPT
3749016	2	HOSE
330553	2	&LD5
3430492	2	&LU8
11505141	3	BOLT/SCREW (SD)



VIEW A

DYNAMIC (Install) N·m	HAND (Insp.) N·m
1	1.8 - 2.6
2	
3	
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
		175				

DATE 3/APR/80
DR HEROMINSKI/ACA
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE VACUUM TANK ASM
FA00 & C60

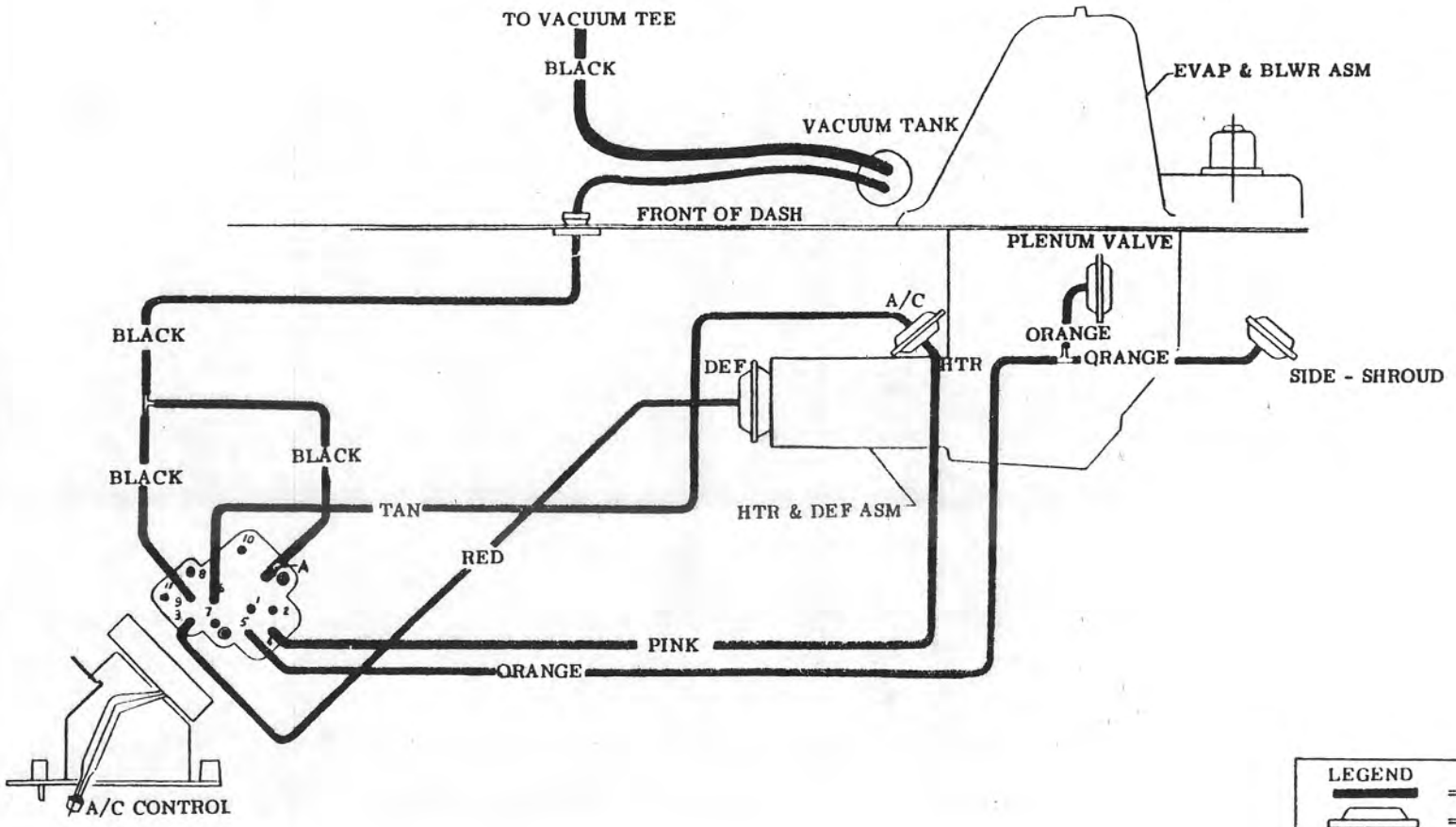
REF ERC 86448
NEW 18AP80

L-01897-S
L-09535-S
L-89731-S
L-

UPC **1A2J**

SHEET **10**

C X B O P Ca



DYNAMK (Install) N·m	HAND (Insp.) N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG

DATE 16JAN80
DR R.HEROMINSKI/ACA
CK J.J Buck HB
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE VACUUM HARNESS DIAGRAM
FA00 &C60

REF ECR 86448
C/O 30N079
1A2J-11

UPC 1A2J

SHEET 11

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

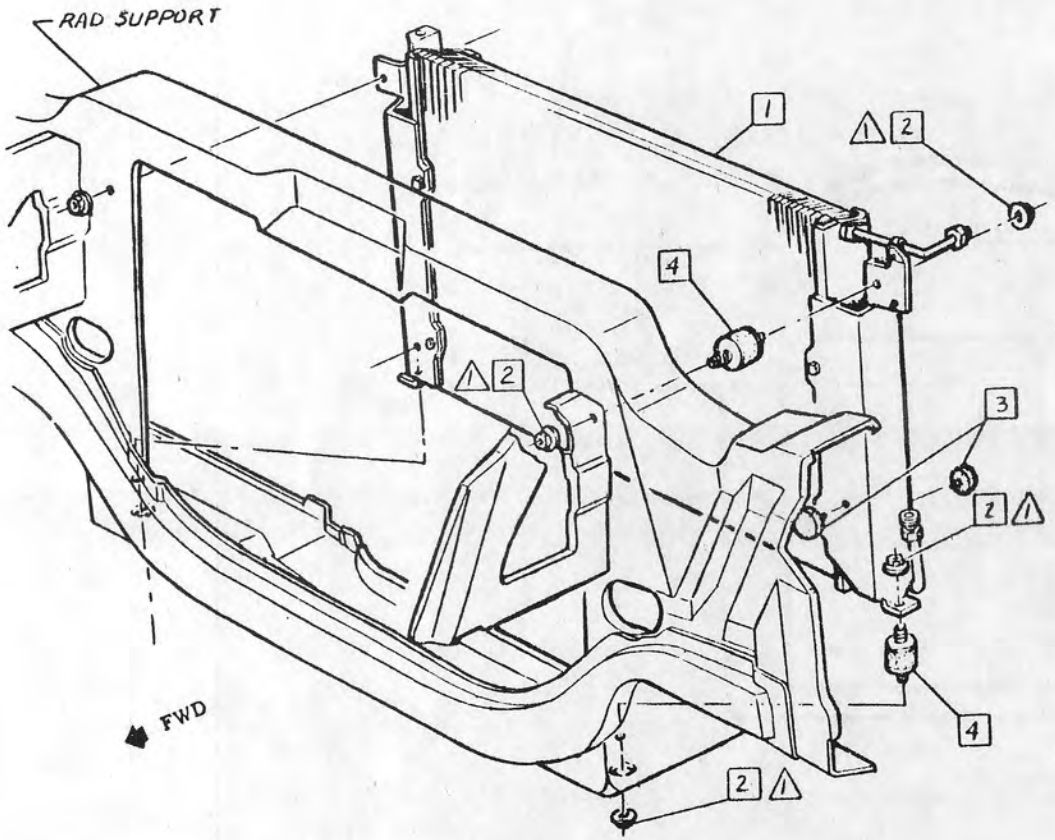
123

PONTIAC MOTOR DIVISION

General Motors Corporation Pontiac, Michigan

PRODUCT DESCRIPTION MANUAL

☐ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF



(1)	3046763	1	CONDENSER ASM
	1359887	2	NUT
	6262618	3	BUMPER
	331959	4	INSULATOR

DYNAMIC (Install) N·m	HAND (Insp.) N·m
△1	15 - 20
△2	
△3	
△4	
△5	

△1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
16JA80		ISSUED	86448	RH	HB	
22AP80	1	WAS 3031783 CONDENSER & DWG REV	87611	RA	RS	

124

DATE 13AP79
DR
CK
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
CONDENSER ASM
FA00 &C60

REF ECR 86448
C/O 11JA80
1A2K-1

L-01897-S
L-
L-
L-

UPC 1A2K

SHEET 1

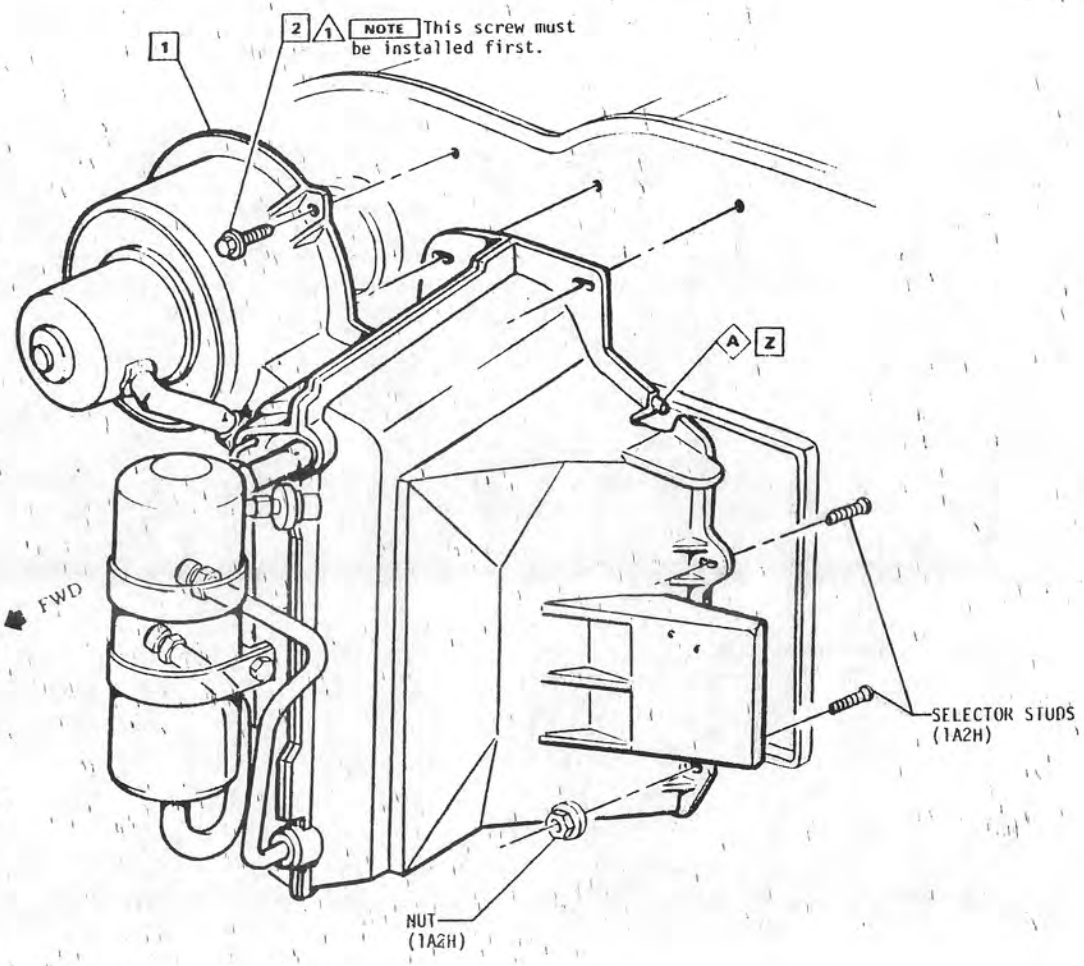
CK | X | P | 0 | | P | | Ca |

PONTIAC MOTOR DIVISION

General Motors Corporation Pontiac, Michigan

PRODUCT DESCRIPTION MANUAL

□ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF



3042353	1	EVAP & BLOWER ASM
3043034	1	&LU8
14005067	2	SCREW ASM
9985059	A ◇	SEALER-ADHESIVE .04 GAL.

Z At time of application, sealer bead must be .38 dia minimum measured perpendicular to flange & in the groove around the entire periphery of 1 & to baffle to case joint with no visible gaps.

DYNAMIC (Install) N·m	HAND (Insp.) N·m
1 2.2 - 3.4	
2	
3	
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
16JA80		ISSUED	BC448	RH	WB	

DATE 02MAY79

DR

CK

APPR S

APPR

APPR

APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE EVAPORATOR & BLOWER ASM FA00 &C60

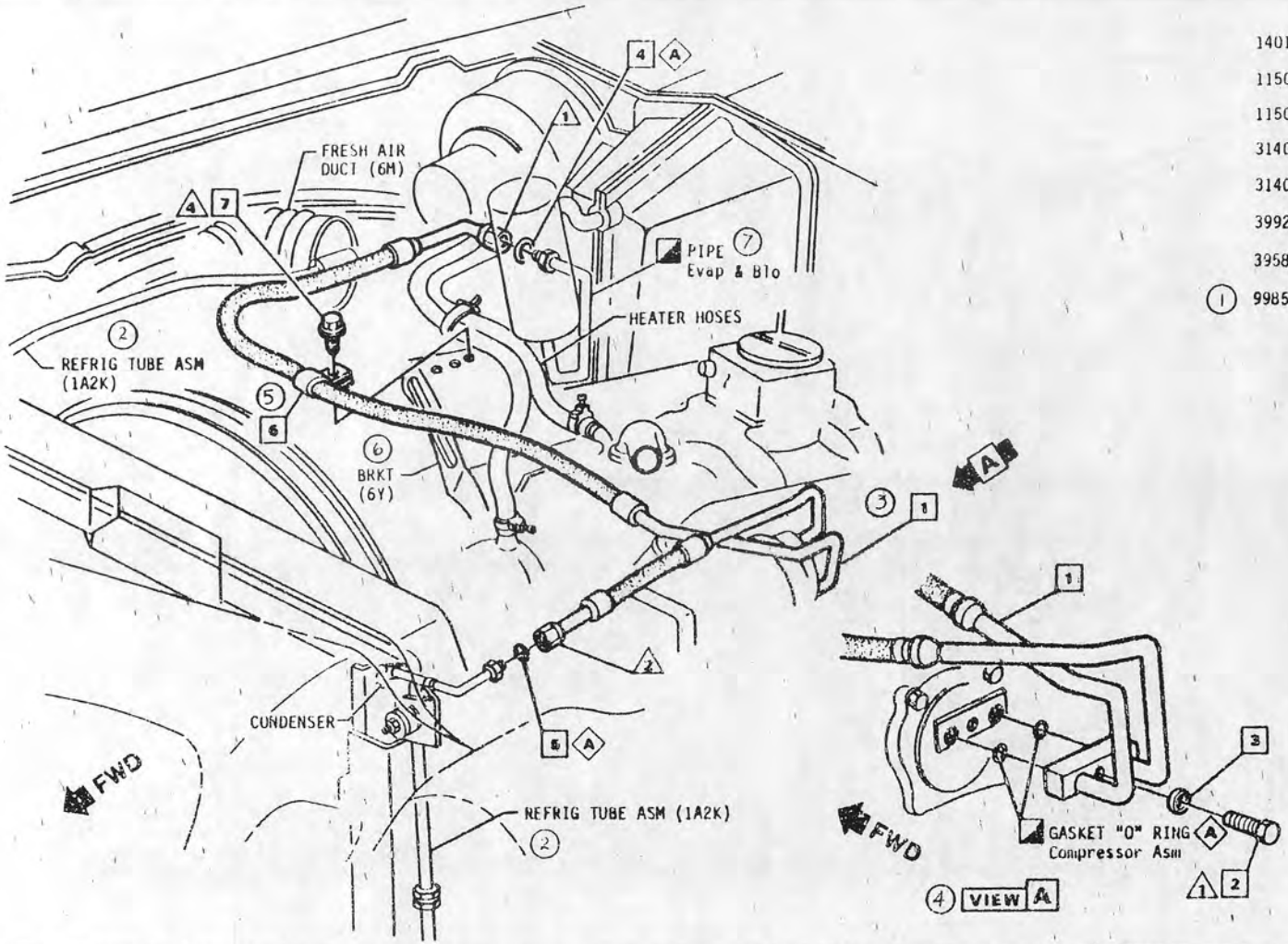
REF ECR 86448 C/O 11JA80 1A2K-2

L-01897-S L-90608-S L-

UPC 1A2K

SHEET 2

Ck | B | D | P | Ca



14016207	1	FITTING ASM	
11500331	2	BOLT/SCREW	
11500046	3	WASHER	
3140852	4	GASKET-"O" RING	
3140600	5	GASKET-"O" RING	
3992185	6	CLIP	
3958062	7	BOLT/SCREW	
(1) 9985006	A	OIL-REFRIGERANT .001 L PER GASKET	

DYNAMIC (Install) N·m	HAND (Insp) N·m
1	27-40
2	20-27
3	38-44
4	9-13
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASG Eng	DATE
07MAR80	1	WAS 9985000 OIL & QUANTITY REVISED				C	16JA80
	2	REFRIG TUBE REF ADDED (2) PLACES	87611	KA	AS		DR E. LUTH
MALIBU	3	ITEM 1 DWG REV				C	CK
	4	VIEW "A" REV				C	APPR S
	5	ITEM 6 DWG REV				C	APPR
	6	"BRKT (6Y)" REF ADDED				C	APPR
	7	"PIPE-EVAP-BLO" REF ADDED ITEM 7 DWG REV (PC 0065)	98155	CU	AS	C	APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
FITTING & HOSE ASM
FA00 ALL &L39/LG4/LM1 &C50

REF ECR 86448
C/O 21DE79
1A2K-4

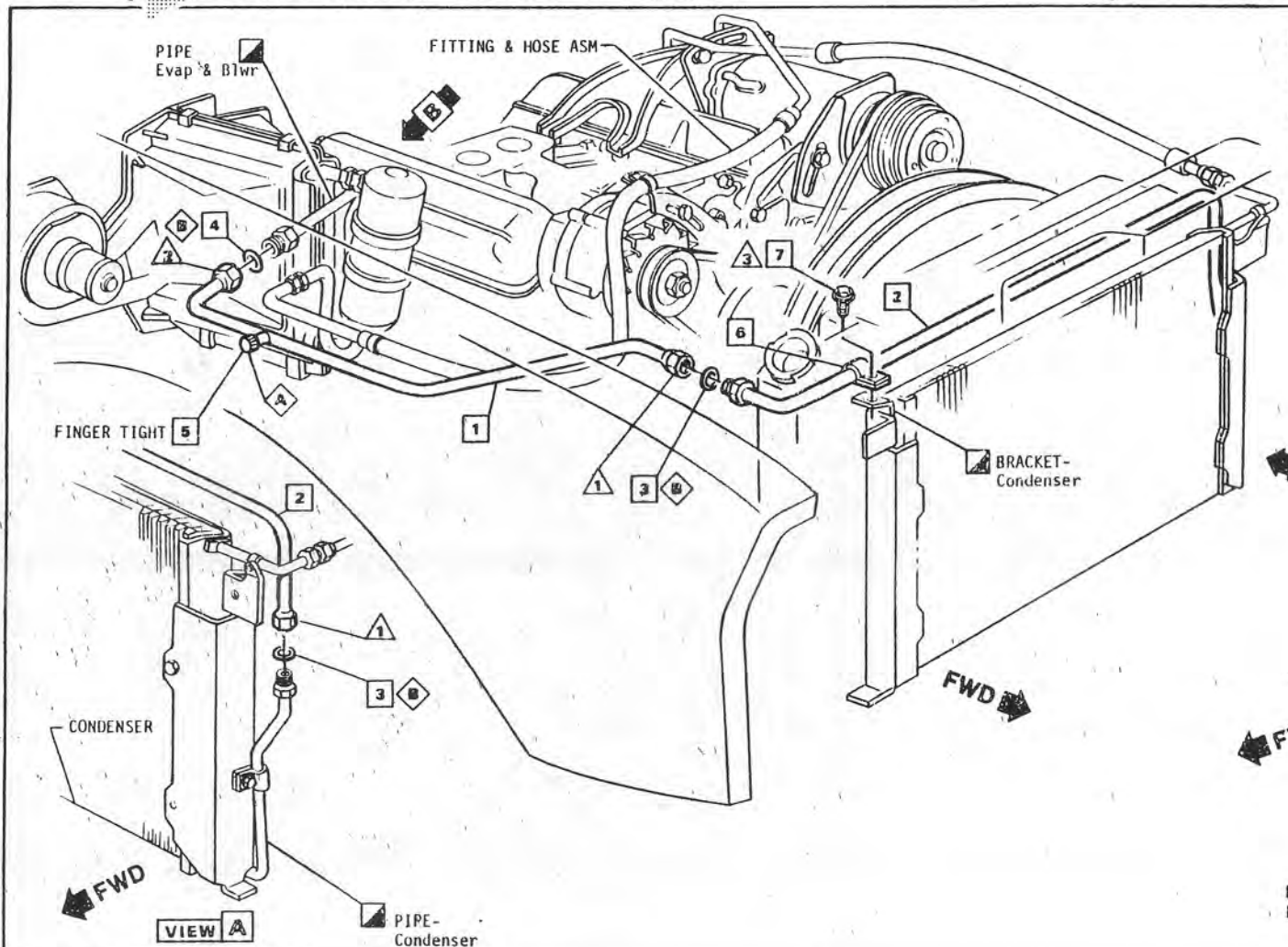
1-13606 (S)

UPC 1A2K

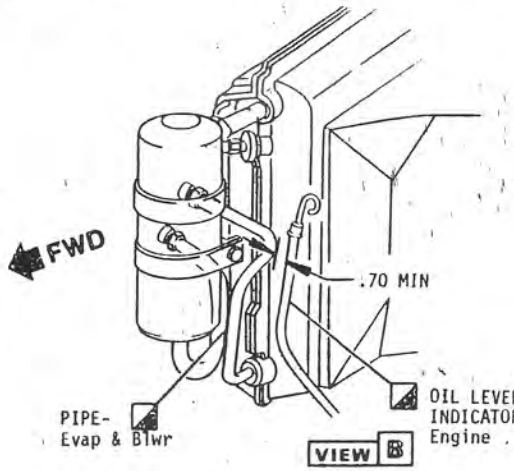
SHEET 4

PRODUCT DESCRIPTION MANUAL

□ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF



(10)		1		(6)
(7)	14039614	1	TUBE ASM-INLET	(12)
(11)		2		(8)
(9)	14039613	2	TUBE ASM-OUTLET	(12)
	8526398	3	GASKET-"O" RING	
	3140600	4	GASKET-"O" RING	
	6551267	5	CAP ASM	
	3033973	5	OPT	
	3033974	5	OPT	
	3037699	6	CLAMP	
	11502843	7	BOLT/SCREW	
	9985016	A	REFRIGERANT 3.25 LBS	
	9985006	B	OIL-REFRIG .001 L per gasket	



DYNAMIC (Instal) N·m	HAND (Insp.) N·m
1	15 - 18
2	20 - 27
3	2.2 - 3.4
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASSY CAG
08DEC80	6	"INLET" ADDED				
	7	14039614 TUBE ADDED				
	8	"OUTLET" ADDED				
	9	14039613 TUBE ADDED	93191	CU	RC	
12FEB81	10	14029869 TUBE REM				
	11	14029568 TUBE REM				
	12	"&LC3 OR LD5" REM (2) PLCS	93191	CU	RC	

DATE 16JAB1
DR E. LUTH
CK [illegible] HB
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
REFRIG TUBE ASM
FA00 &C60

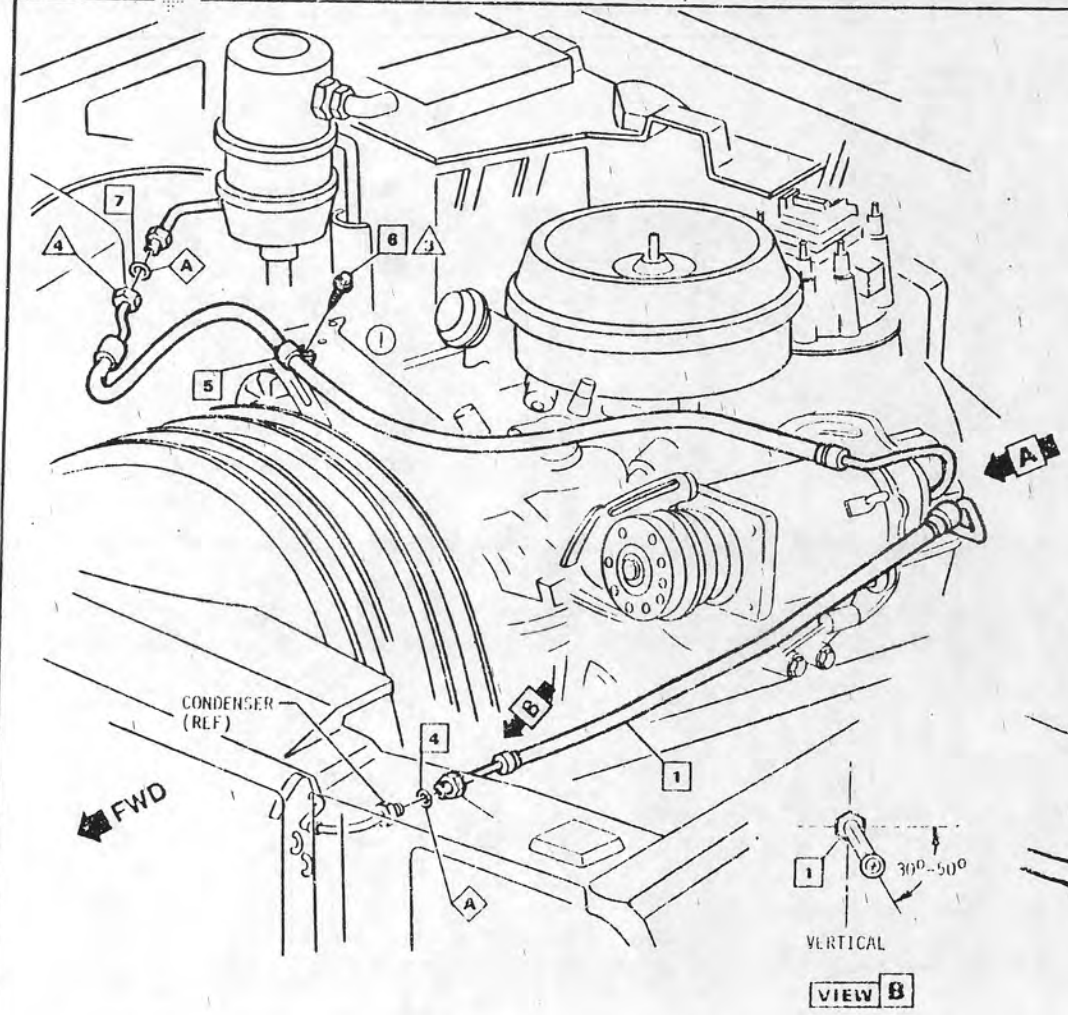
REF ECR 86448
C/O 30N079
1A2K-5

L- 22103-S
L-
L-
L-

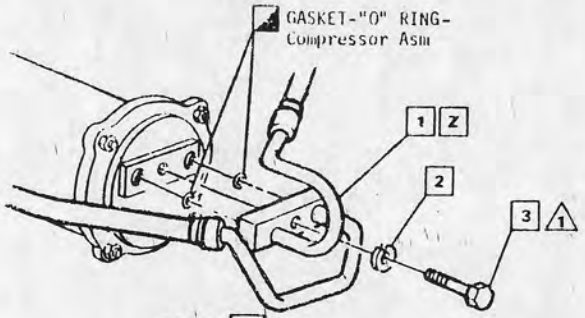
UPC 1A2K

SHEET 5

C ☒ B ☐ D ☐ P ☒ Co ☐



VIEW B



VIEW A

14009247	1	FITTING ASM	
11500046	2	WASHER	
11500831	3	BOLT/SCREW	
3140600	4	GASKET-"O" RING	
3992185	5	CLIP	
3958062	6	BOLT/SCREW	
3140852	7	GASKET-"O" RING	
+ 9985006	A	OIL REFRIG. .001 L PER GASKET	

Z For clearance see note on 1Z-1.

DYNAMIC (Install) N·m	HAND (Insp.) N·m
1	30 - 40
2	20 - 27
3	9 - 13
4	38 - 44
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
18 JL 80	1	WAS 3 HOLES SHOWN (PC 12-0025)	8870	EL	TH	

DATE 17JA80
DR HERCMINSKI/ACA
CK NJBuch HB
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
FITTING & MUFFLER ASM
FA00 &LC3 &C60

REF ECR 86448
C/O 04JA80
1A2K-6

UPC 1A2K

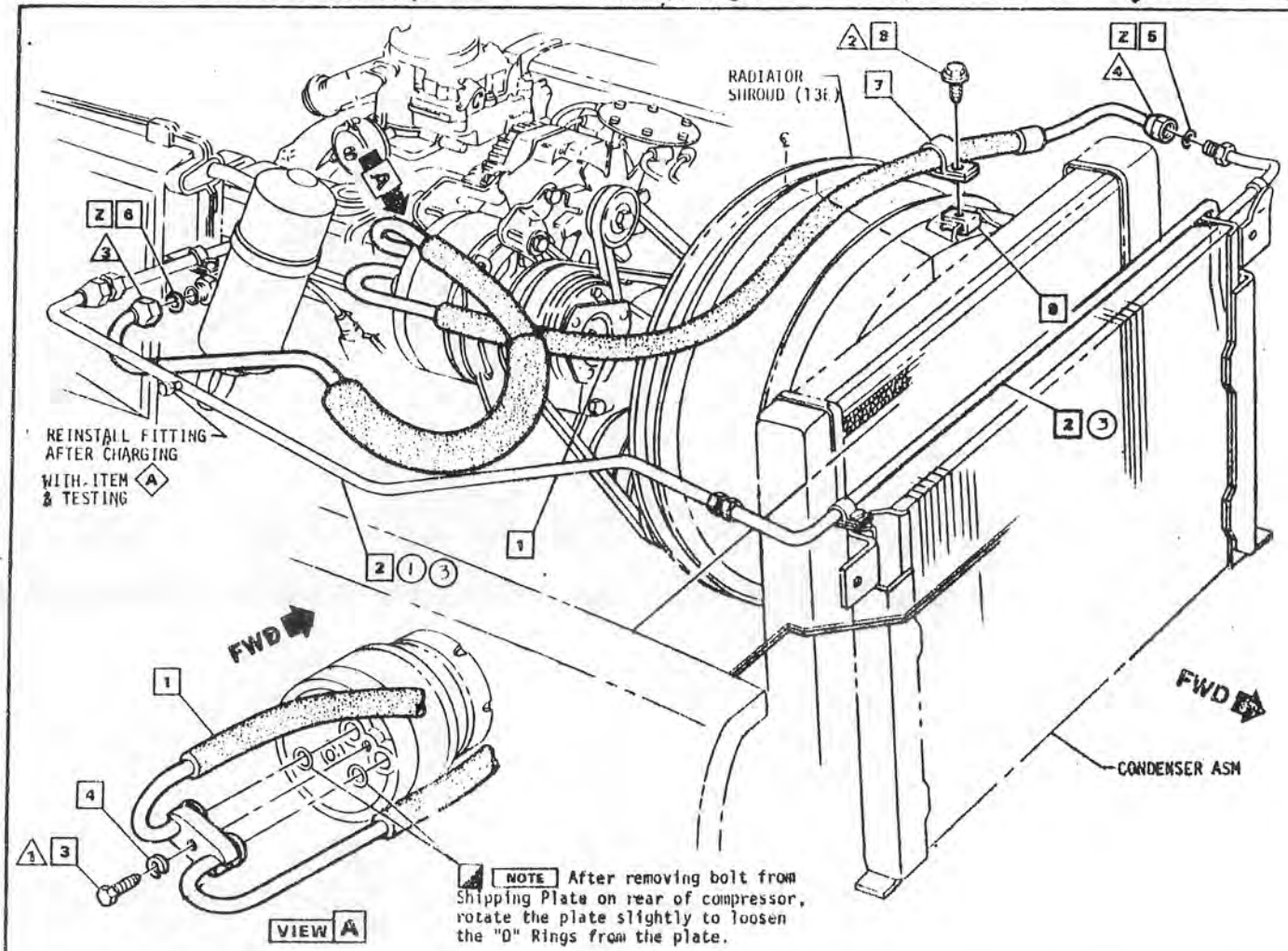
SHEET 6

Ch B D P Ca

PONTIAC MOTOR DIVISION
General Motors Corporation Pontiac, Michigan

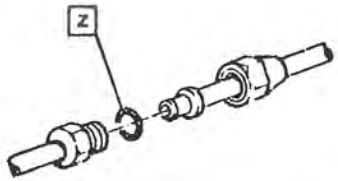
PRODUCT DESCRIPTION MANUAL

☐ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF



14016218	1	FITTING & HOSE ASM
Ref 1A2K-5	2	TUBE ASM
11500832	3	BOLT
11500046	4	L. WASHER
3140600	6	GASKET "O" RING
3140852	6	GASKET "O" RING
3970894	7	CLIP
11500985	8	SCREW
9433160	9	"U" NUT
9985016	(A)	REFRIGERANT 3.25 LBS
(2) 9985006	(B)	OIL .001 L

NOTE All Refrigerant Hoses are to be installed without any twist assembled into them.



TYPICAL GASKET INSTALLATION

NOTE After removing bolt from Shipping Plate on rear of compressor, rotate the plate slightly to loosen the "O" Rings from the plate.

Z Coat "O"-Ring Gasket with Item (B) Oil.

DYNAMIC (Install) N·m	HAND (Insp) N·m
1	26 - 40
2	4.5 - 7.0
3	38 - 46
4	20 - 27
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
KJA80		ISSUED	86448	RH	HB	
23 FEB 80	1	TUBE REF ROUTING REVISED				C
	2	OIL QUANTITY REVISED	87611	KA	KB	
APR 80	3	ITEM 2 DWG REV (2) PLACES	91394	CU	KB	C

DATE	20/NO/78
DR	DR/TIP
CK	R.A.
APPR	S
APPR	
APPR	
APPR	

DIV CHEVROLET

1981 CHEV. "F" 14020867

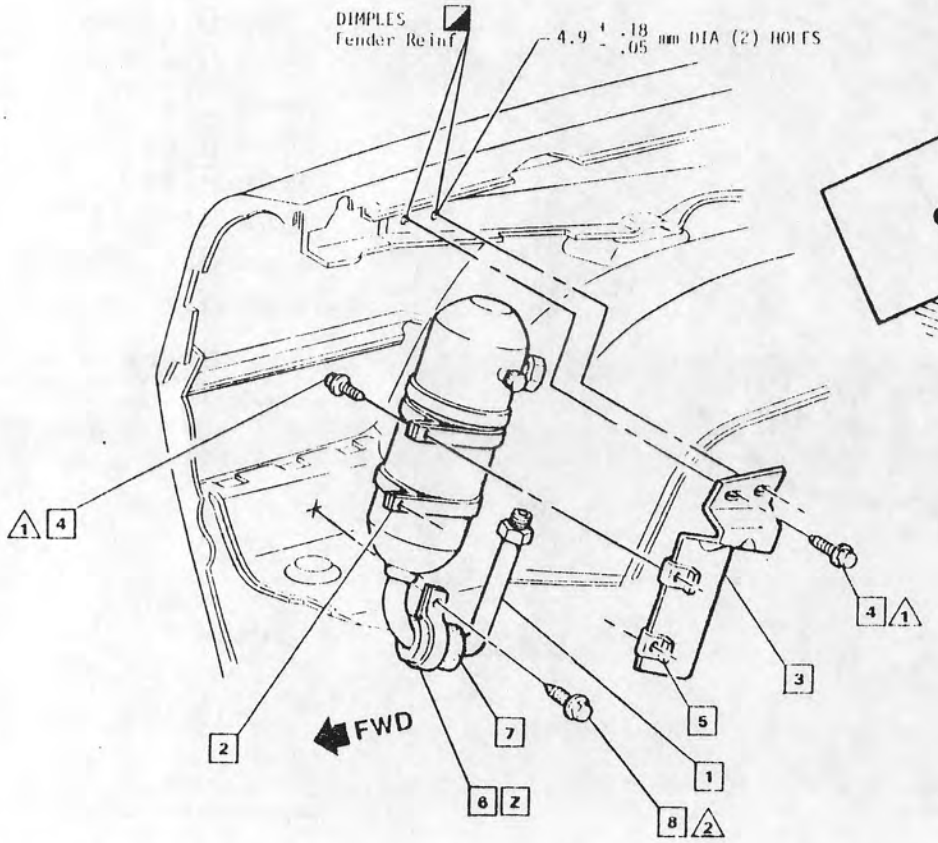
TITLE REFRIGERANT HOSES, TUBES FA90 &LD5 &C60

REF ECR 86448 C/O 11JA80 1A2K-9

UPC 1A2K

SHEET 9

Ch X B D P Co



1131276	1	ACCUMULATOR ASM
3035664	2	CLAMP
14020049	3	BRACKET
11500079	4	SCREW
9431532	5	"U" NUT
Ref 1A2K-11	6	CLIP
Ref 1A2K-11	7	INSULATOR
11501608	8	SCREW (SD)

Z After 6 is assembled to 1, use 6 as template for 8.

DYNAMIC (Install) N·m	HAND (Assy) N·m
1	4.5 7D
2	1.2 - 1.6
3	
4	
5	

1 FULLY DRIVEN SEATED & NOT STRIPPED

Ch X B O F Ca

DATE	SYM	REVISION
11 JAN 80		ISSUED
5 NOV 80	1	SHEET CANCELED

DATE	2 FE 78
DR	DEFILIPPI
CK	KP
APPR	
APPR	
APPR	
APPR	

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE ACCUMULATOR MOUNTING FA00 &LU8 &C60

REF ECR 86448
C/O 11 JAN 80
1A2K-10

1-1-21530

GPC 1A2K

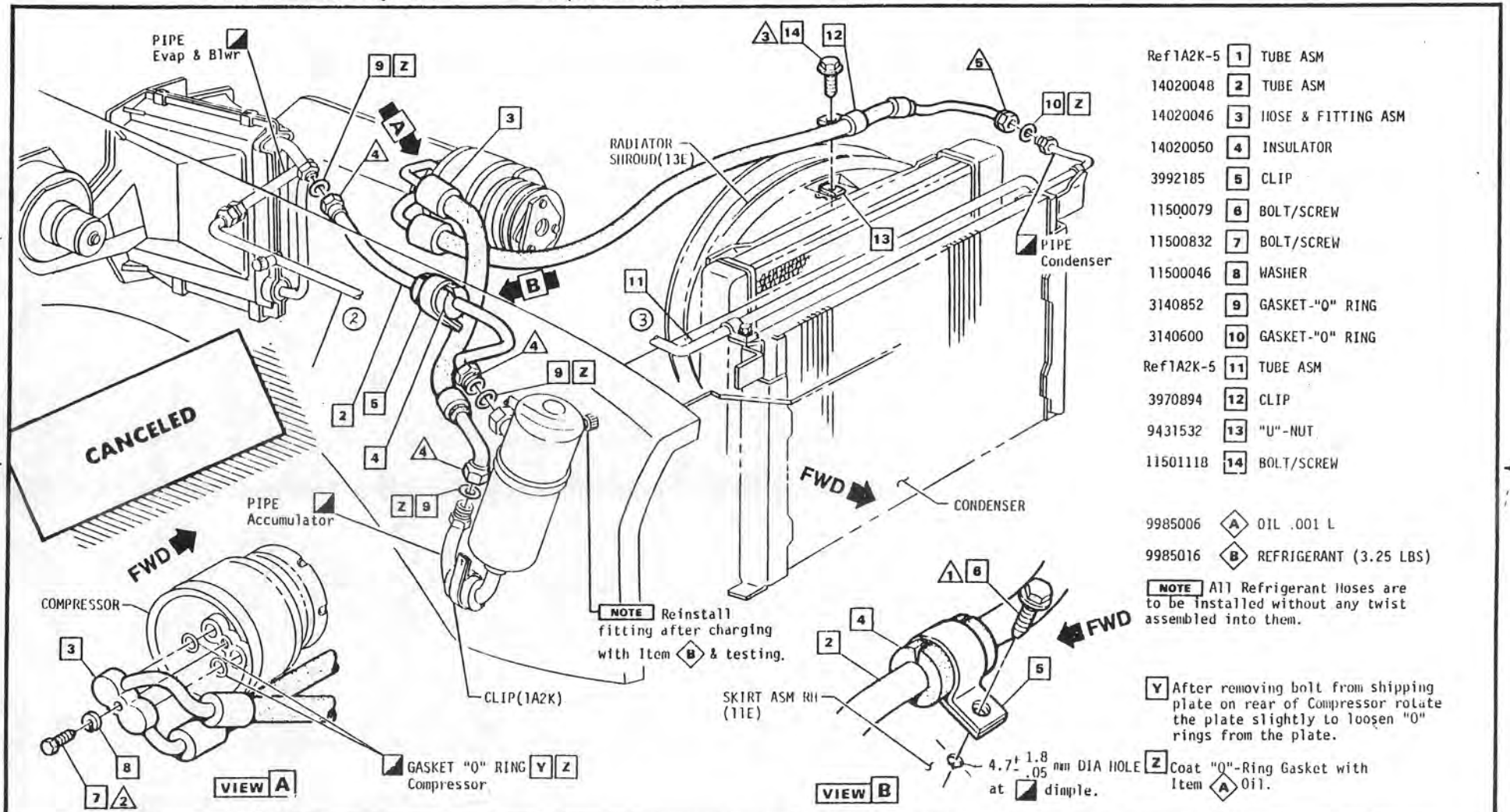
SHEET 10

PONTIAC MOTOR DIVISION

General Motors Corporation Pontiac, Michigan

PRODUCT DESCRIPTION MANUAL

☐ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF



Ref 1A2K-5	1	TUBE ASM
14020048	2	TUBE ASM
14020046	3	HOSE & FITTING ASM
14020050	4	INSULATOR
3992185	5	CLIP
11500079	6	BOLT/SCREW
11500832	7	BOLT/SCREW
11500046	8	WASHER
3140852	9	GASKET-"O" RING
3140600	10	GASKET-"O" RING
Ref 1A2K-5	11	TUBE ASM
3970894	12	CLIP
9431532	13	"U"-NUT
11501118	14	BOLT/SCREW

9985006	(A)	OIL .001 L
9985016	(B)	REFRIGERANT (3.25 LBS)

NOTE All Refrigerant Hoses are to be installed without any twist assembled into them.

Y After removing bolt from shipping plate on rear of Compressor rotate the plate slightly to loosen "O" rings from the plate.

Z Coat "O"-Ring Gasket with Item (A) Oil.

DYNAMIC (Install) N.m	HAND (Insp.) - N.m
1	1.6 - 2.2
2	26 - 40
3	4.5 - 7.0
4	38 - 46
5	20 - 27
6	15 - 18

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
16JAN80		ISSUED	96498	RH	MP	
24 APR 80	1	REDRAWN & REDESIGNED	97611	ACA	RJS	C
09 JUL 80	2	ITEM I REV				C
	3	ITEM II REV	91394	CU	RJS	C
07 NOV 80	4	SHEET CANCELED	91227	CU	EF	

DATE 1-FE-78
DR DEFILIPPI
CK KP
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE TUBE ASM & HOSE & FITTING ASM F&00 &LU8 &C60

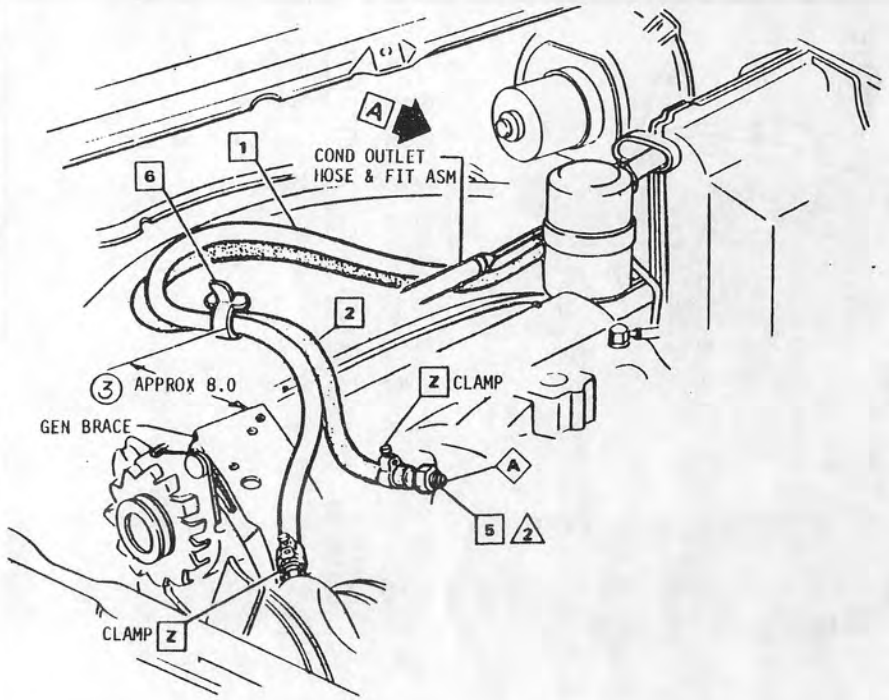
REF ECR 86448 C/O 11JAN80 1A2K-11

L 2L-88572
L 1L-22157

UPC 1A2K

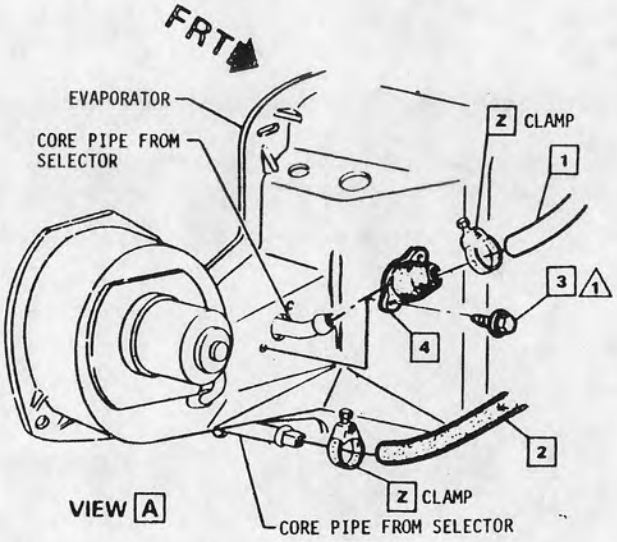
SHEET 11

Ck X | I | O | P | Co



482415	1	HOSE
482431	2	HOSE
+ 9428882	3	BOLT/SCREW
+ 3963723	4	SEAL (1)
331967	5	NIPPLE INL
335225	6	STRAP (2)
9985000	A	SEALER .0012 GAL.

Z See Sheet 1.



VIEW A

DYNAMIC (Install) N·m	HAND (Insp.) N·m
1 1.6 - 2.2	
2 20 - 34	
3	
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
18JL80	1	WAS GROMMET ASM	86816	ACA	24	
12FE81	2	"ELG4/LM1/L39" REM				
	3	DIM. "8.0" WAS "4.0"	95344	CU	RC	C

DATE 16JA80
DR E.LUTH
CK W.J Buick HB
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
HEATER HOSES
FA00 &L39/LC3/LG4/LM1 &C60

REF ECR 86448
C/O 28DE79
1A2L-2

L-08500 (S)
L-
L-
L-

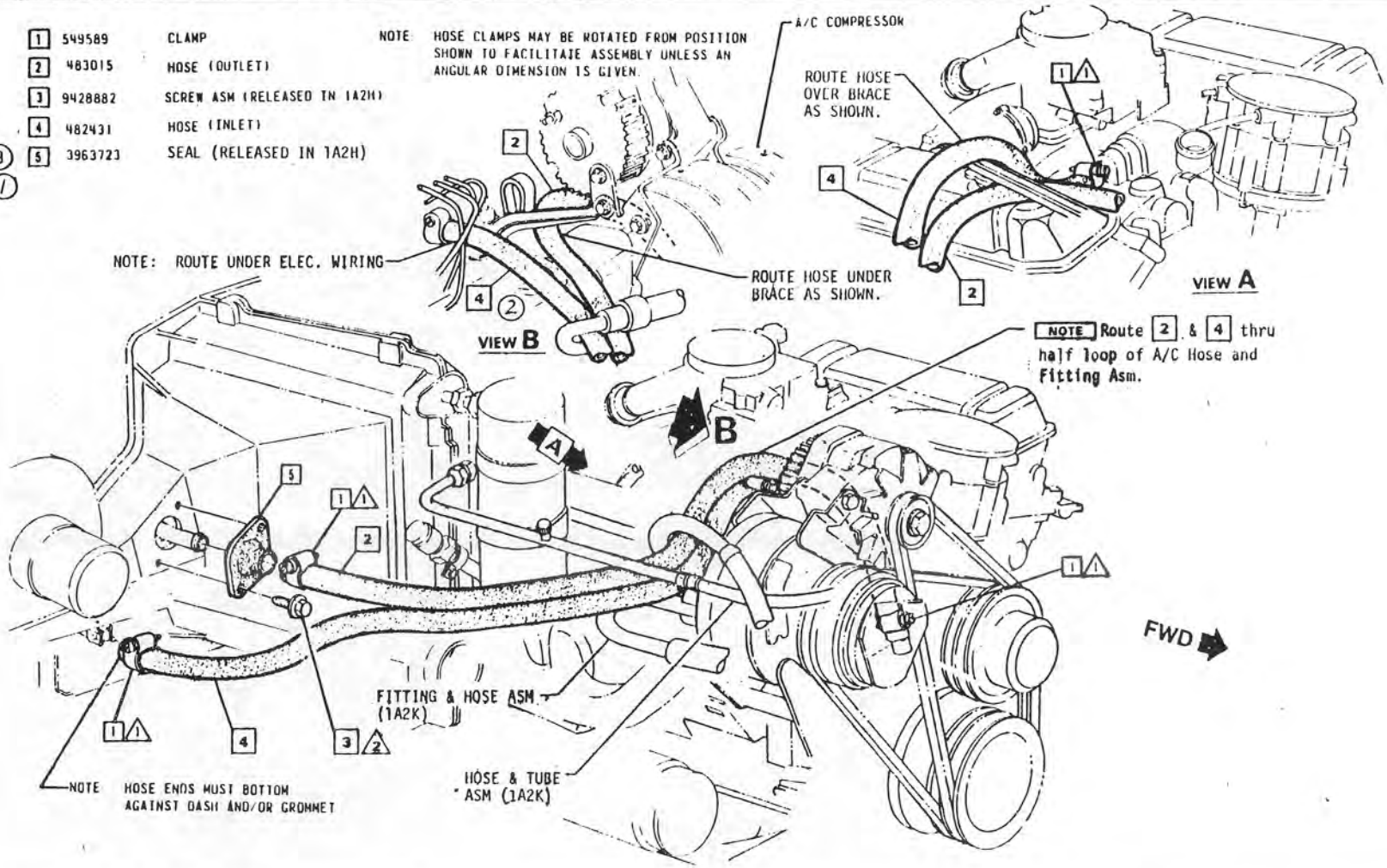
UPC 1A2L

SHEET 2

Ch X B O P X Ca

1	549589	CLAMP	
2	483015	HOSE (OUTLET)	
3	9428882	SCREW ASM (RELEASED IN 1A2H)	
4	482431	HOSE (INLET)	
3 1	5 3963723	SEAL (RELEASED IN 1A2H)	

NOTE: HOSE CLAMPS MAY BE ROTATED FROM POSITION SHOWN TO FACILITATE ASSEMBLY UNLESS AN ANGULAR DIMENSION IS GIVEN.



DYNAMIC (Instal) N.m	HAND (Insp) N.m
1	1.4 - 2.0
2	1.6 - 2.2
3	
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
6JAN80		ISSUED	86448	RH	WB	
13FEB80	1	336225 STRAP REMOVED				
	2	VIEW B REVISED	89012	ACA	AS	
20JUN80	3	WAS GROMMET ASM	86916	ACA	WB	

133

DATE	20/NOV/78
DR	DB/TLP
CK	R.A.
APPR	S
APPR	
APPR	
APPR	

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE HEATER HOSES FA00 &LD5 &C60

REF ECR 86448 C/O 11JA80 1A2L-8

DIV 1A2L

SHEET 8

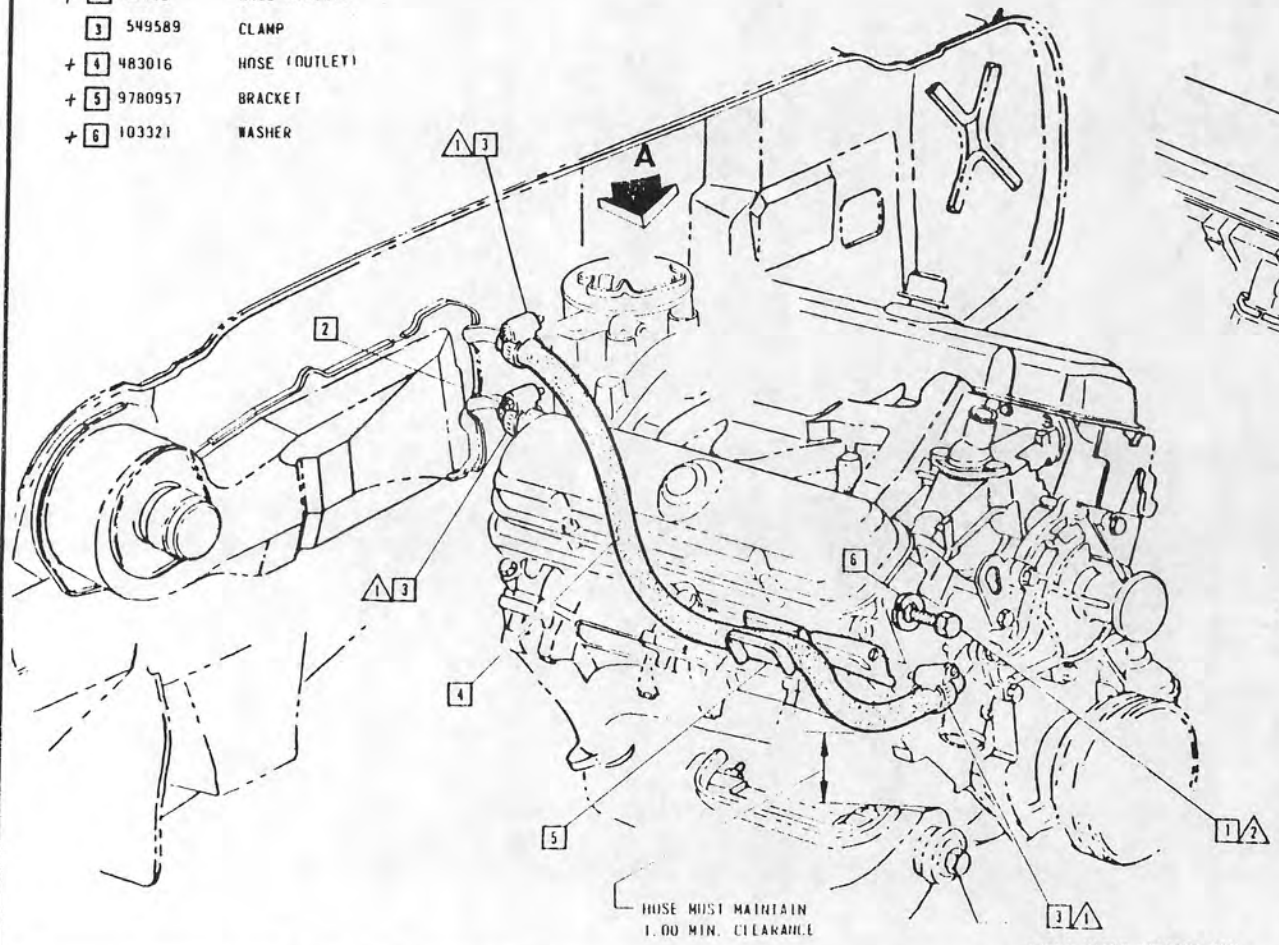
PONTIAC MOTOR DIVISION

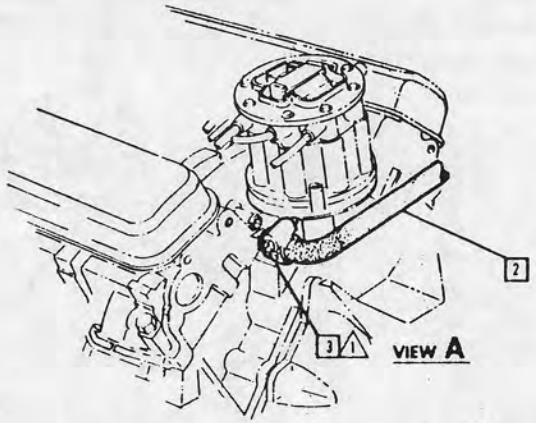
General Motors Corporation Pontiac, Michigan

PRODUCT DESCRIPTION MANUAL

☐ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF

+	1	9428638	BOLT
+	2	549339	HOSE (INLET)
	3	549589	CLAMP
+	4	483016	HOSE (OUTLET)
+	5	9780957	BRACKET
+	6	103321	WASHER





NOTE: HOSE CLAMPS MAY BE ROTATED FROM POSITION SHOWN TO FACILITATE ASSEMBLY UNLESS AN ANGULAR DIMENSION IS GIVEN.

CANCELED

DYNAMIC (Install) N m	HAND (Insp.) N m
1	1.4 - 2.0
2	26 - 48
3	
4	
5	

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
16JA80		ISSUED	86448	RH	RB	
19 FEB 80	1	SHEET CANCELED	86448	ACA	RA	

174

DATE	20 NOV 78
DR	DP/TLP
CK	R.A.
APPR	S
APPR	
APPR	
APPR	

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE HEATER HOSES F&DD &LDB

REF ECR 86448 C/O 11JA80 1A2L-10

WPC 1A2L

SHEET 10

Ck X B O P Co

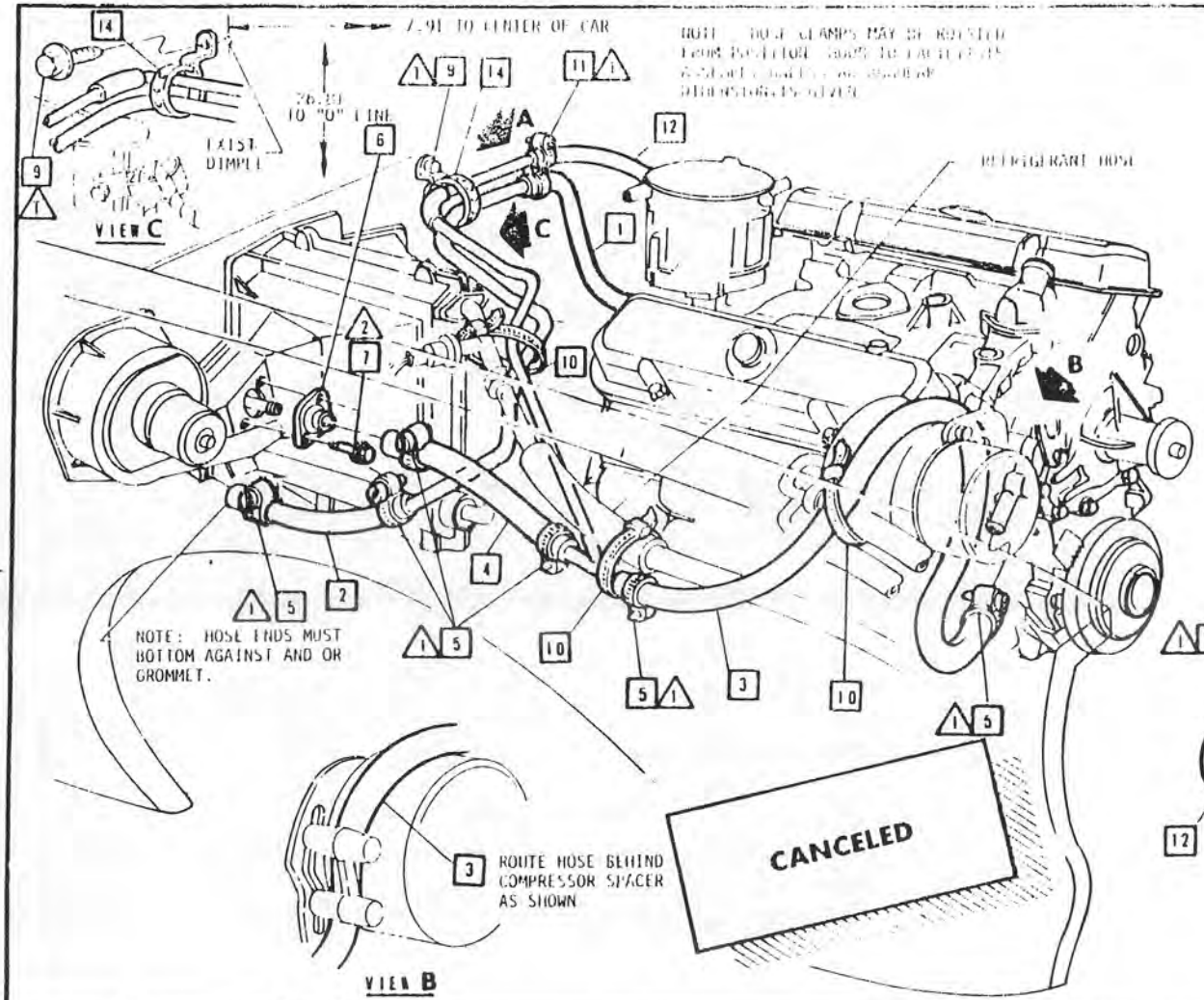
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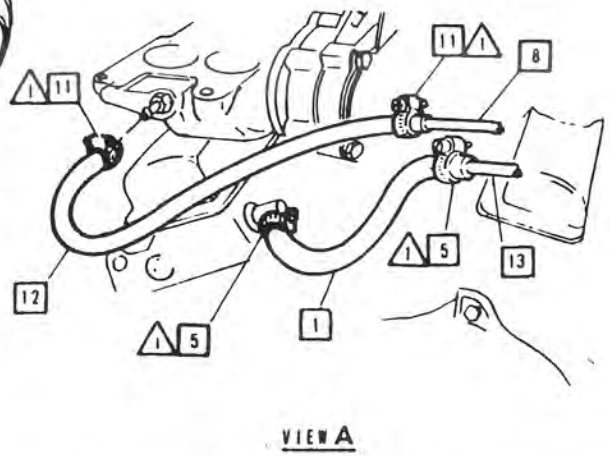
PONTIAC MOTOR DIVISION

General Motors Corporation Pontiac, Michigan

PRODUCT DESCRIPTION MANUAL

☐ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ▨ EXISTING AS PART OF





10014332	1	HOSE INLET (TO PIPE)
10014333	2	HOSE (INLET PIPE TO HEATER)
10014335	3	HOSE (COUPLING TO WATER PUMP)
10014334	4	HOSE OUTLET (TO COUPLING)
549589	5	CLAMP
(1) 3963723	6	SEAL — 1A2H
948882	7	SCREW — 1A2H
10014368	8	FITTING
11502864	9	BOLT/SCREW
11501907	10	STRAP
1478678	11	CLAMP
10014336	12	HOSE
10014367	13	PIPE (HEATER INLET)
10010498	14	CLIP

DYNAMIC (Install) N·m	HAND (Insp.) N·m
△1	1.4-2.0
△2	1.6-2.2
△3	
△4	
△5	

△1 FULLY DRIVEN SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
11APR80		ISSUED				
20NOV80	1	WAS GROMMET ASM				
07NOV80	2	SHEET CANCELED				

DATE 3 MAR 80
DR
CK
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE HEATER HOSES TURBO FA00 LU8 &C60

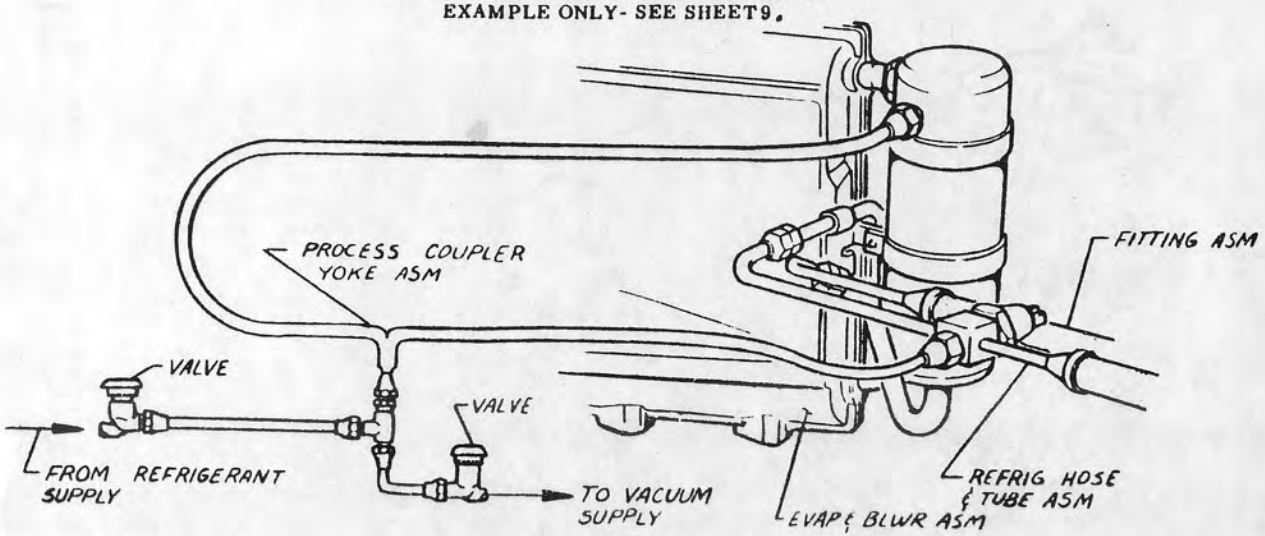
REF ECR 86448 NEW 28MR80

UPC 1A2L

SHEET 11

CK B O P Co

EVACUATING AND CHARGING EQUIPMENT
EXAMPLE ONLY- SEE SHEET9.



TEST PROCEDURE OUTLINE:

IN ORDER TO ASSURE PROPER OPERATION OF THE UNIT. THE FOLLOWING STEPS SHOULD BE TAKEN:

A. AFTER THE SYSTEM HAS BEEN INSTALLED, A LEAK TEST SHOULD BE MADE.

B. A FUNCTIONAL TEST OF COMPLETED ASSEMBLY MUST NOW BE MADE. SEE SHEET9.

C. THE HEATING SYSTEM CAN BE CHECKED BY MOVING THE "TEMP" LEVER TO EXTREME RIGHT (HOT) POSITION. WITH THE "SELECTOR" LEVER IN "HEATER" POSITION, WARM AIR WILL COME OUT OF HEATER OUTLETS. WITH THE "SELECTOR" LEVER IN THE "A/C" POSITION, WARM AIR WILL COME OUT OF THE AIR CONDITIONING OUTLETS.

DYNAMIC (Install) N·m	HAND (Insp.) N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG

DATE 16JA80
DR R. HEROMINSKI/ACA
CK NA Buck HB
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE TEST PROCEDURE FA00 &C60

REF ECR 86448 C/O 14DE79 1A2Z-1

UPC 1A2Z

SHEET 1

⚠ FULLY DRIVEN SEATED & NOT STRIPPED

Evacuating and Charging the System

1. Remove cap from V.I.R. and valve and gage fitting on V.I.R. inlet line.
2. Attach Process Coupler Yoke Assembly to process valves uncapped in Step 1.
3. Attach quick-connect fitting from vacuum system to Process Coupler and open valves slowly to evacuate Air Conditioning System.
4. Air Conditioning System must be evacuated to a minimum of 25 mm Hg. absolute system pressure (1). After a 15-second hold time (2), the system pressure must not exceed 28 mm Hg. absolute pressure.
   (1) System Pressure-the level of evacuation of the vehicle's A/C system once the vacuum source has been removed.
   (2) Hold Time-elapsed time which occurs between vacuum disconnect and charge connect.
   For those plants which have a longer than 15-second hold time, the system pressure may be allowed to rise to the values shown below in Table #1

TABLE #1

Elapsed Time Between Evacuation and Charge	Acceptable Evacuation Level (mm Hg) per Evacuation and Charge Spec.
15-30 seconds	28 mm Hg
31-60 seconds	30 mm Hg
61-90 seconds	35 mm Hg
91 seconds and over	40 mm Hg

NOTE The System must be charged through the high pressure fitting to prevent damage to the compressor.

5. Disconnect quick-connect fitting from vacuum system to Process Coupler and attach quick-connect fitting from Refrigerant Charging Board to Process Coupler.
6. Charge Air Conditioning System with specified amount of Refrigerant.
7. Close valves on Process Coupler, disconnect quick-connect fitting from Charging Board to Process Coupler, disconnect Process Coupler from V.I.R and inlet Line Fitting & replace caps.
8. Leak Test System.
9. Conduct Functional Test.

System Leak Test Limits

1. Except as noted in (2) below, all lines, connectors and system components shall be free of leakage with a detector sensitivity calibration of 1 lb. in 40 years.
2. The compressor seal, sight glass, P.O.A.S.T., and Expansion Valves shall show no leakage with a detector sensitivity calibration of 1 lb. in 5 yrs.

Functional Test

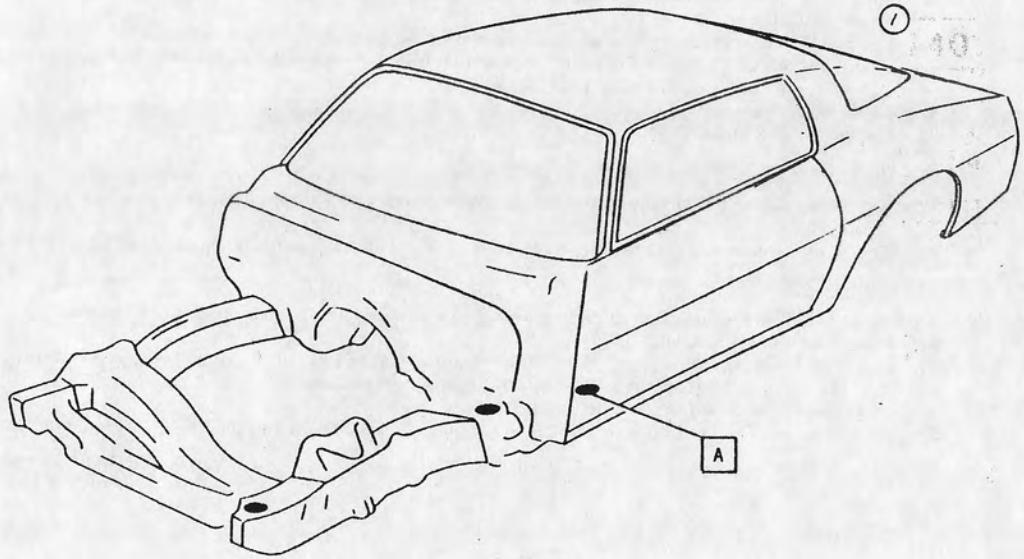
A standard test of the function of the system is to be conducted in the following manner:

1. Doors or windows open.
2. Selector lever at "A/C". "COLD-HOT" Knob at 1st detent to rt. of max cold position.
3. Temperature Indicators at condenser inlet and center outlet.
4. Start engine and run at 2000 R.P.M.
5. After one minute the minimum drop in temperature of the air from the center outlet should be as follows:

CONDENSER INLET TEMP.	70 F	80 F	90 - 110
CENTER OUTLET TEMP. DROP (MIN)	20 F	25 F	30 F

1B1 BODY MOUNTING

			DIV RESP
	1B-1	CONTENTS	D
A	1B-2	CUSHIONS	C



DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
5MAR80	1	DRAWING REVISED	86448	JD	JJ	

DATE 18JA80
DR J.D'ANGELO
CK JJBuck HB
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
CONTENTS-BODY MOUNTING
FA00 ALL

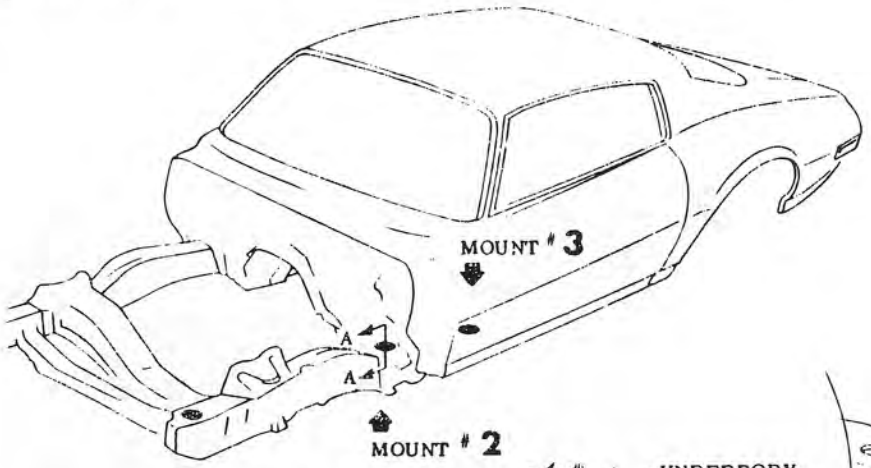
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NEW 10SE79

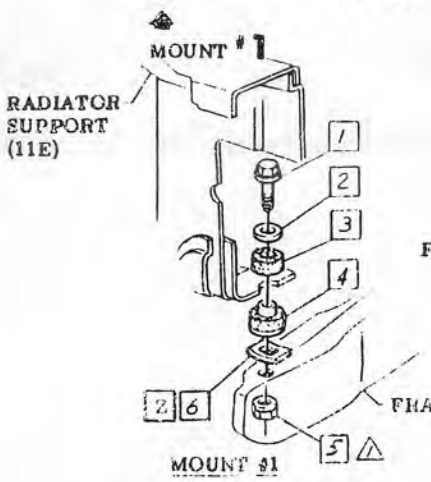
UPC 1B

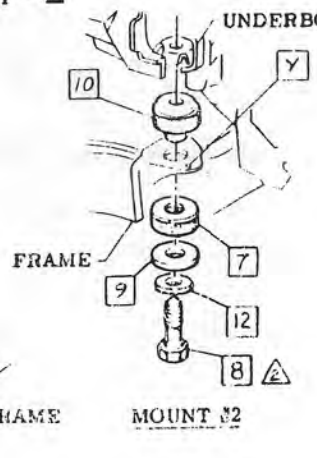
SHEET 1

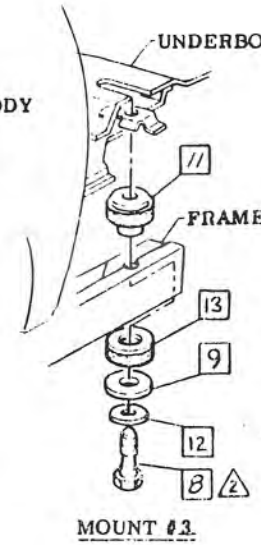
★ Instructions Carryover
● Waiting Info.

Ch X B D P Ca

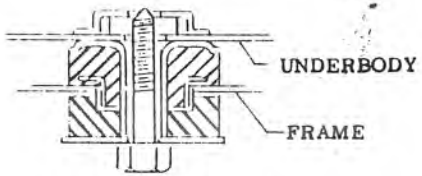








	6264033	1	BOLT/SCREW
	3914814	2	WASHER
	3893159	3	CUSHION
	14008366	4	CUSHION ASM
	9432140	5	NUT ASM
	9425568	6	NUT-PUSH ON (AS REQ'D)
(1)	332654	7	CUSHION ASM (WHITE)
	368142	8	BOLT/SCREW
	3901365	9	WASHER
	332608	10	CUSHION ASM
	332609	11	CUSHION ASM (YELLOW)
	9419279	12	WASHER
(1)	3962720	13	CUSHION ASM (WHITE)



SECTION A-A TYPICAL

[Y] At body drop use .610+.000/-.002 dia pins at locations shown on L. & R.H. side. Pins must not be removed until #2 and #3 body mount attachments are tightened to specified torque.

[Z] Retains [1] [2] [3] & [4] to radiator support prior to assembly to frame.

△ 30 ft lb
△ 100 - 130
△
△
△
△ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE | SYM | DIVISION

CHEVROLET

1981 CHEV. "F" 14020867

TITLE: BODY MOUNTING CUSHIONS
FAO ALL

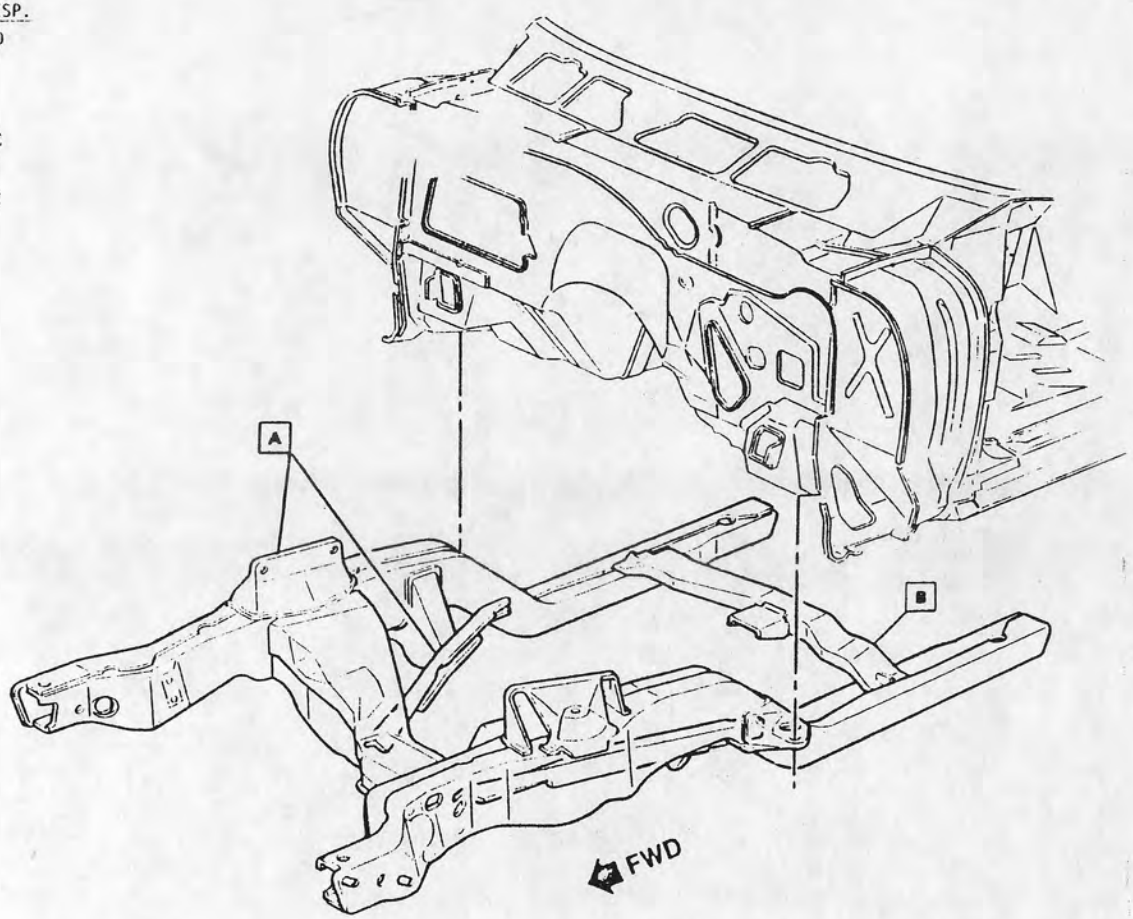
REF: ECR 86448
C/O 21DE79
1B-2

LOT069-S
19781-S

SPEC: 1B

SHEET: 2

			DIV. RESP.
2 FRAME			
	2-1	CONTENTS-2B	D
2B FRAME			
A	2B-1	FRAME ASM & FRT BRACES TO FRT CROSSMEMBER	C
B	2B-2	TRANS SUPPORT RE-INSTALLATION	C



★ Instructions Carryover
● Waiting Info.

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
		148				

DATE 10/24/80
DR S HONKISAN/EJH
CK
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE CONTENTS-FRAME
FA00 ALL

REF ECR 86448
NEW 190C79

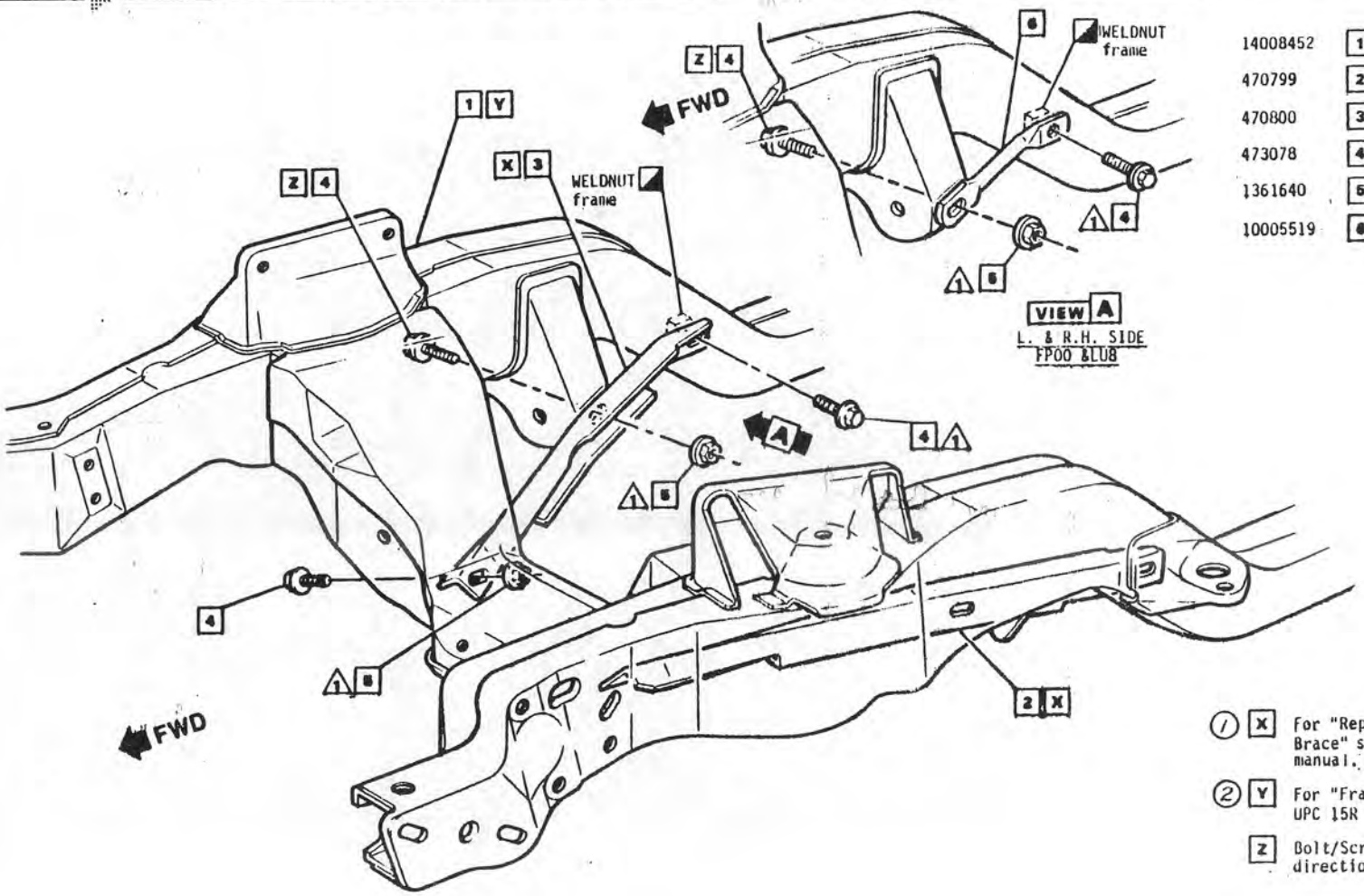
UPC 2

SHEET 1

General Motors Corporation
CHEVROLET MOTOR DIVISION

PRODUCT DESCRIPTION MANUAL

□ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF



14008452	1	FRAME ASM
470799	2	BRACE-FRT FRM L.H. exc LU8
470800	3	BRACE-FRT FRM R.H. exc LU8
473078	4	BOLT /SCREW
1361640	5	NUT
10005519	6	BRACE-FRT FRM &LU8

(1) X For "Repair Procedure-Front Crossmember Brace" see UPC 15R REPAIRS in this manual.

(2) Y For "Frame Repair Procedure", see UPC 15R REPAIRS in this manual.

Z Bolt/Screw must be installed in direction shown.

DYNAMIC (Install) N·m	HAND (Insp.) - N·m
1 2 3 4 5	28 - 40

6. FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
22MY80	1	NOTE "X" REVISED	86448	SM	RC	
12JN80	2	NOTE "Y" REVISED (GR 1003)	88165	SM	RC	

DATE 10.1A50
DR MORRISON/E.J.M
CK
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE FRAME ASM & FRT BRACES TO FRT CROSSMEMBER FA00 ALL

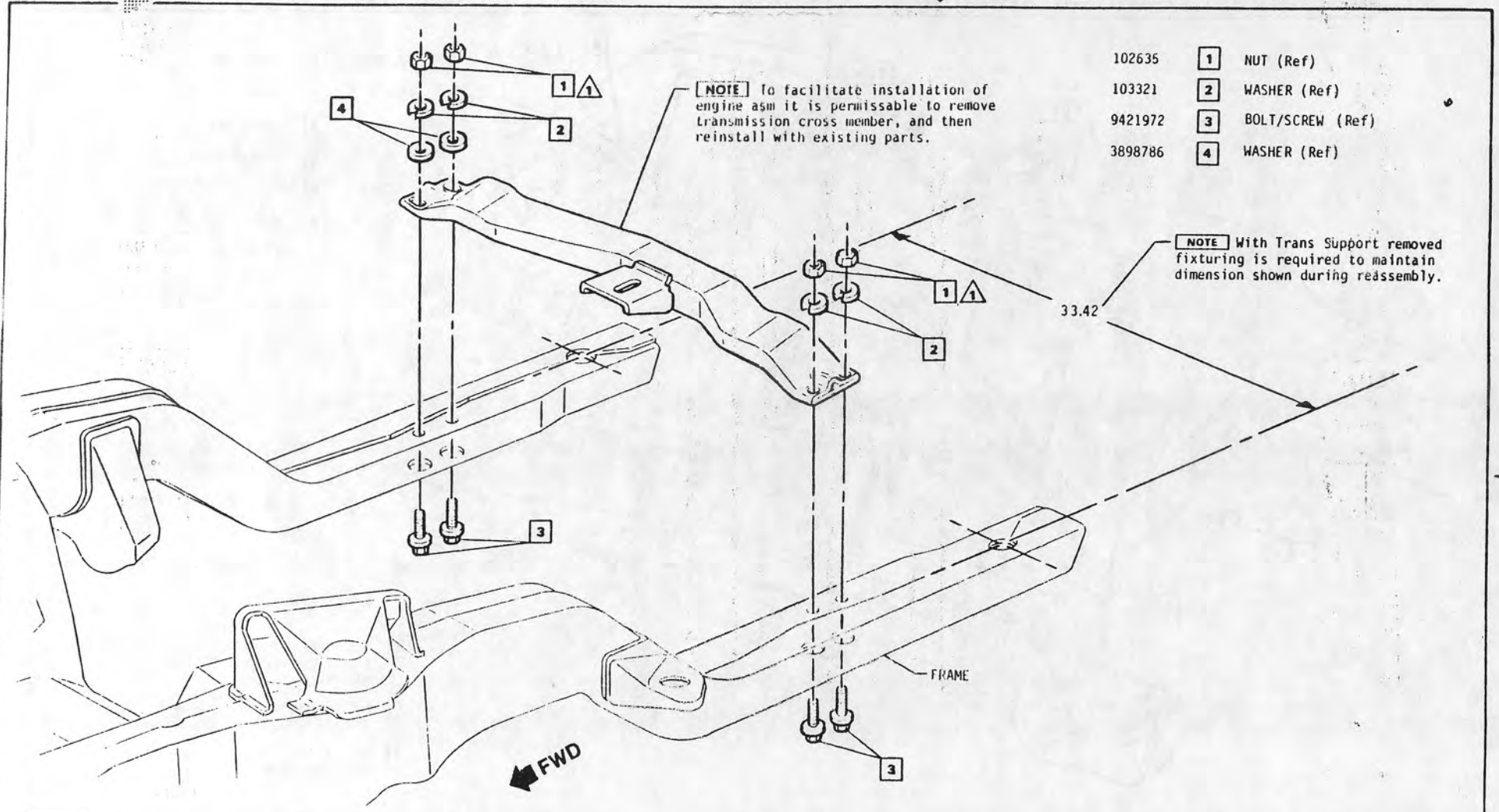
REF ECR 86448 C/O 21N079 2B-1

L-17912-S L-BRACES L-19520-S L-FRAME

UPC 2B

SHEET 1

[ ] [X] 3 [ ] 0 [ ] P [X] Ca [ ]



102635	1	NUT (Ref)
103321	2	WASHER (Ref)
9421972	3	BOLT/SCREW (Ref)
3898786	4	WASHER (Ref)

NOTE To facilitate installation of engine asm it is permissable to remove transmission cross member, and then reinstall with existing parts.

NOTE With Trans Support removed fixturing is required to maintain dimension shown during reassembly.

DYNAMIC (Install) N·m	HAND (Insp.) N·m
1	34-48
2	
3	
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
		142				

DATE 10/8/80
DR MORRISON/EJM
CK
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE TRANS SUPPORT RE-INSTALLATION
FA00 ALL

REF ECR 86448
C/O 21H079
2B-2

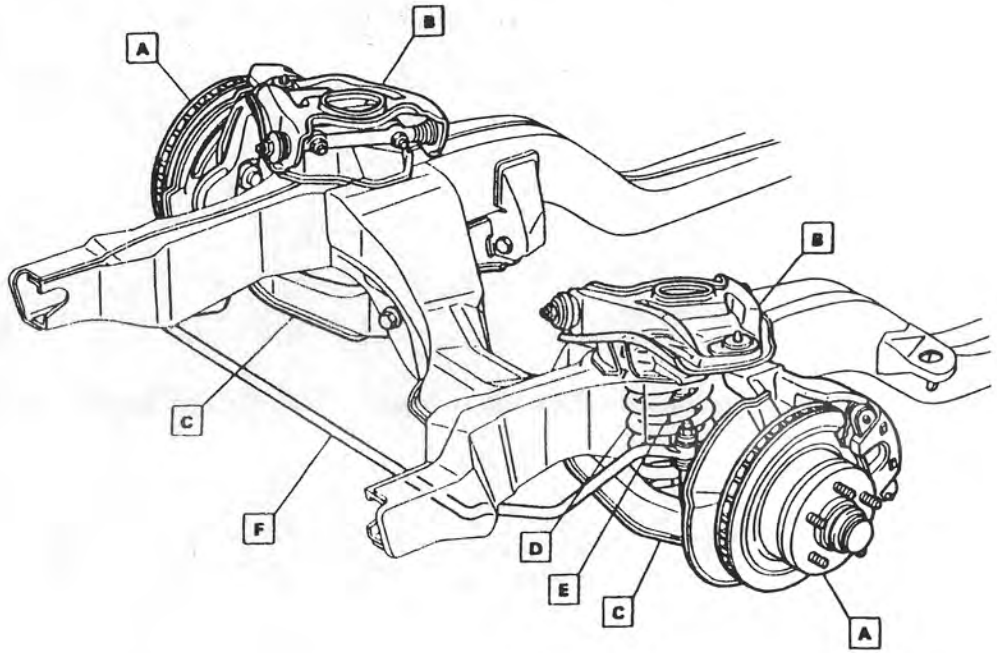
L-19520-S
L-
L-
L-

UPC 2B

SHEET 2

Ch | B | D | P | Co

			DIV. RESP.
3 FRONT SUSPENSION			
	3-1	CONTENTS 3 THRU 3Z	D
A	3-2	STEERING KNU & FRT WHL HUB ASM	C
3A FRONT SUSPENSION ASSEMBLY			
B	3A-1	UPPER CONTROL ARM & BUMPER	C
C	3A-2	LOWER CONTROL ARM & BUMPER	C
3C FRONT SPRINGS			
D	3C-1	FRONT SPRINGS	C
3F SHOCK ABSORBERS			
E	3F-1	FRONT SHOCK ABSORBERS	C
3G FRONT STABILIZER			
F	3G-1	FRONT STABILIZER	C
3Z MISCELLANEOUS INFORMATION			
	3Z-1	FRONT SUSPENSION ALIGNMENT CHART	C



★ Instructions Carryover
● Waiting Info.

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
		143				

DATE 10/15/80
DR S. HOKKISON/EJN
CK [illegible]
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

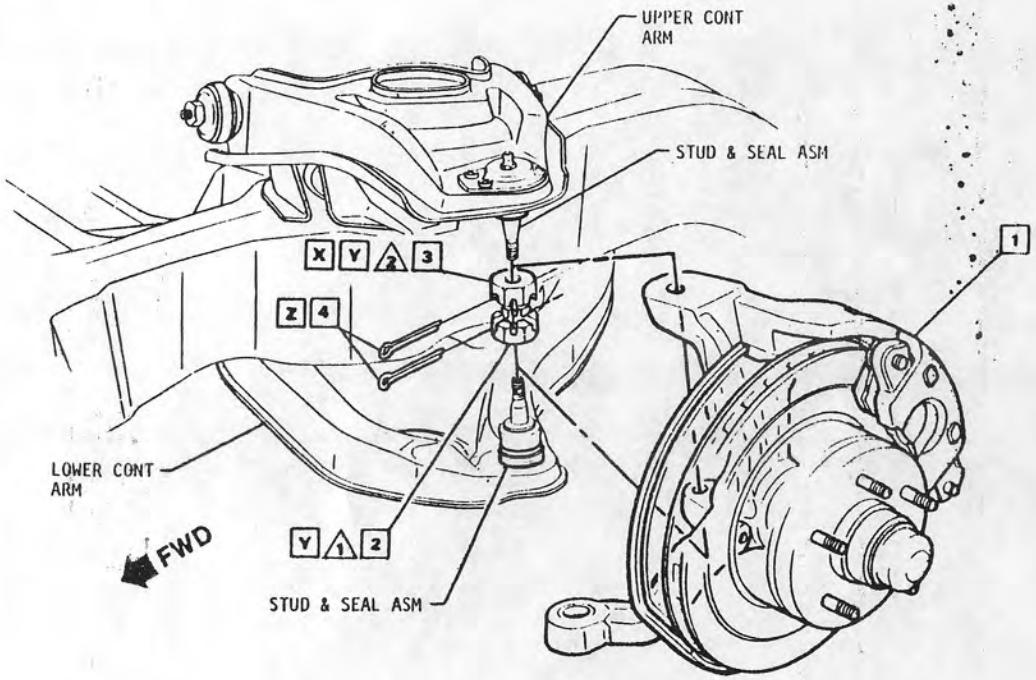
TITLE
CONTENTS-FRONT SUSPENSION
FA00 ALL

DET ECR 86448 NEW 190C79

UPC 3

SHEET 1

Ck X B O P Co



14021097-8	1	KNU & HUB ASM L & RH FA00 exc JE1
14035627-8	1	FA00 &JE1
3983037	2	NUT (Lower end)
3983036	3	NUT (Upper end)
9431604	4	COTTER PIN

⑧ X Torques must coincide with ball joint stud & thread protector colored blue.

⑨ Y Maximum Hand Torque
△1 170 N.m
△2 135 N.m
Permissible to align cotter pin slot (1/6 turn max). Do not back off nut for cotter pin insertion.

Z For cotter pin installation see UPC 0A-12.

DYNAMIC (Install) N·m	HAND (Insp.) · N·m
95 - 120 △1	95 - 130
70 - 95 ⑩ △2	70 - 95
△3	
△4	
△5	

△1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
10JA81	8	NOTE "X" REVISED				
	9	TORQUE 135 N·m WAS 120 N·m				
	10	TORQUE 70-95 N·m ADDED	13532	SM	RC	

DATE 10JA80
DR MORRISON/EJM
CK
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE STRG KNUCKLE & FRONT WHEEL HUB ASM FA00 ALL

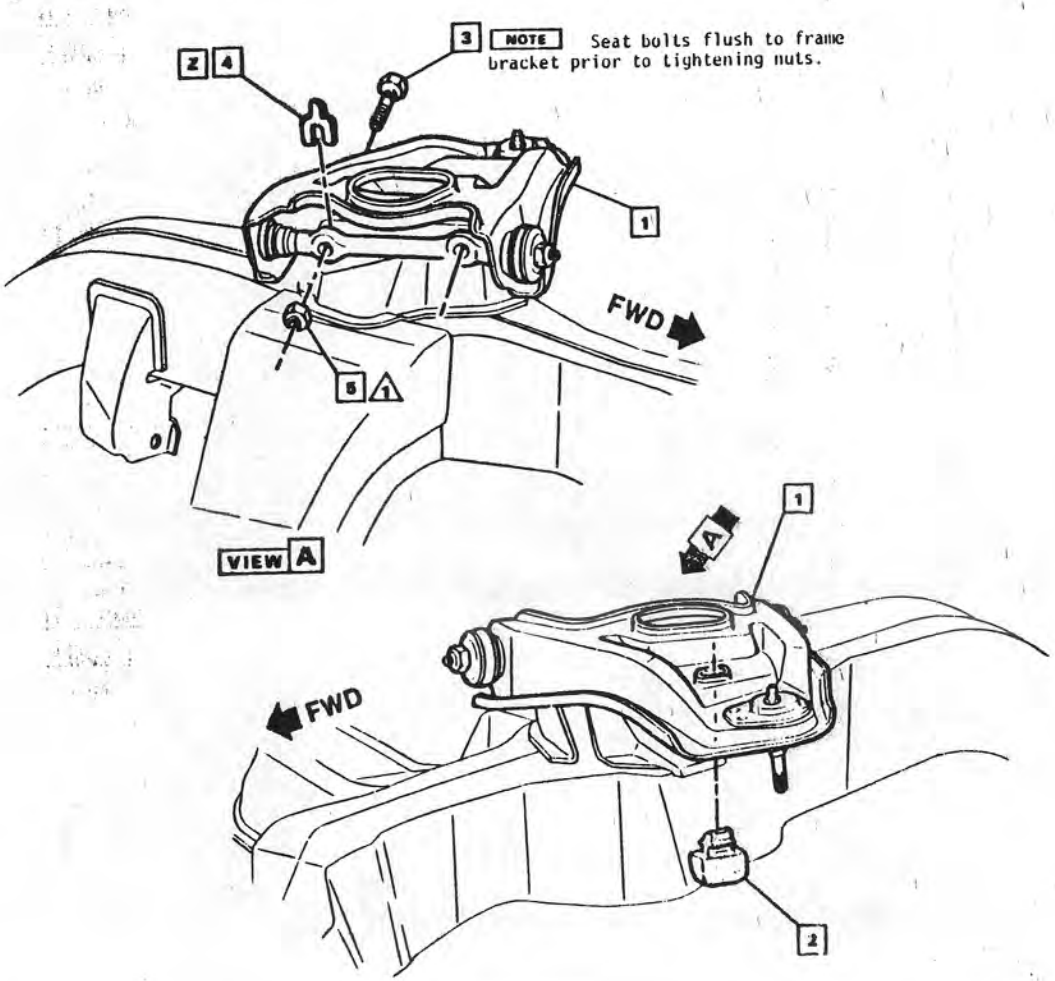
REF ECR 86A48 C/O 21N079 3A-3

L- 02899-S
L- 20315
L-
L-

UPC 3

SHEET 2

Ch ☒ D O P ☒ Ce



(1) 14031593-4	1	ARM ASM-UPPER L. & R.H.
1362014	2	BUMPER
3964832	3	BOLT /SCREW
6270717	4	SHIM (.030) AS REQ'D
6270718	4	(.060) AS REQ'D
6270719	4	(.100) AS REQ'D
9422301	5	NUT

Z MANDATORY SYSTEM REQUIREMENT:

Shim as required to make caster & camber adustment (approx 4 per job). A maximum of one each of two thinner shims (.030 or .060 in.) may be used per bolt/screw.
NOTE Shims must be clean & free of foreign substance. No foreign substance may be added to aid assembly. OPTION: Shims may be installed with open end up.

A. Maintain a minimum of .10 in. thread length beyond nut after assembly (not including chamfer).
B. Difference between front and rear shim pack must not exceed .40 in.

If these requirements cannot be met, it indicates a quality deficiency in a component part that must be corrected.

DYNAMIC (Install) N·m	HAND (Insp.) N·m
88 - 102 △1	85 - 110
△2	
△3	
△4	
△5	

△ ONLY DRIVEN, SEATED & NOT STRIPPED

DATE	STM	REVISION	AUTH	DR	CK	ASM LVL
20JN80	1	WAS 14011215-6-ARM ASM	90961	EJM		

DATE 10.A.80
DR MORRISON/EJM
CK
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE UPPER CONTROL ARM & BUMPER FA00 ALL

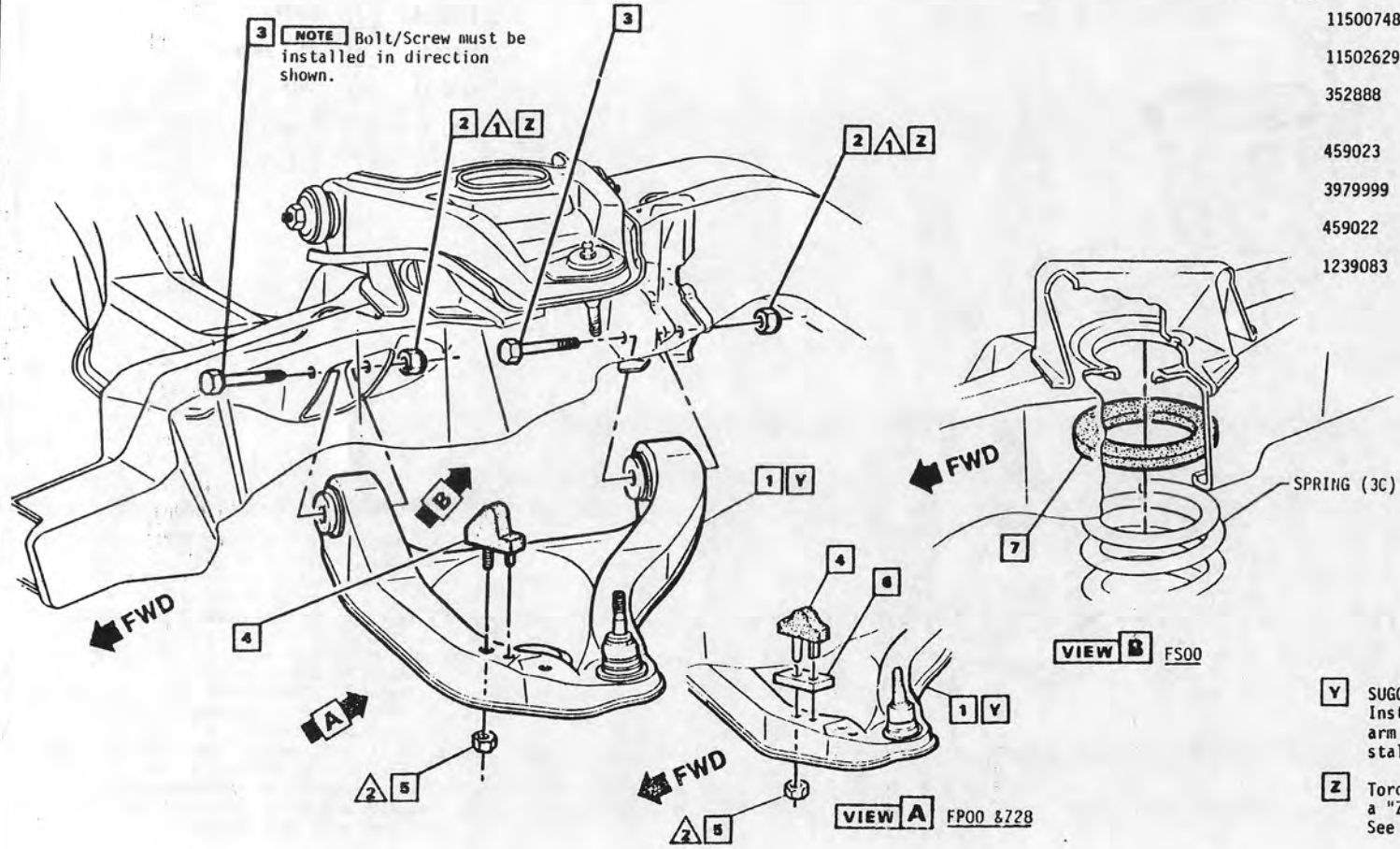
REF ECR 86448 C/O 21N079 3A-1

L- 02899-S
L- 95093-S
L-
L-

UPC 3A

SHEET 1

Ch X B D P X Co



14031591-2	1	ARM ASM-LOWER L. & R.H.
11500748	2	NUT
11502629	3	BOLT/SCREW
352888	4	BUMPER ASM FP00 exc Z28; FS00
459023	4	FP00 &Z28
3979999	5	NUT
459022	6	SPACER FP00 &Z28
1239083	7	INSULATOR FS00

Y SUGGESTED ASSEMBLY SEQUENCE: Install the front leg of the lower control arm into the crossmember prior to installing the rear leg in the frame bracket.

Z Torque with lower control arm at a "Z" height of 1.72 in. ±.25 in. See UPC "0" Trim Heights.

DYNAMIC (Instal) N.m	HAND (Insp.) - N.m
115-135	1 110-140
	2 20-34
	3
	4
	5

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
20JN80	1	WAS 14008445 6-ARM ASM	FDAG	CDM	NB	

DATE 12JAN80
DR MORRISON/EJM
CK
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE LOWER CONTROL ARM & BUMPER FA00 ALL

REF ECR 86448 C/O 21N079 3A-2

L- 02899-S
L- 95093-S
L-
L-

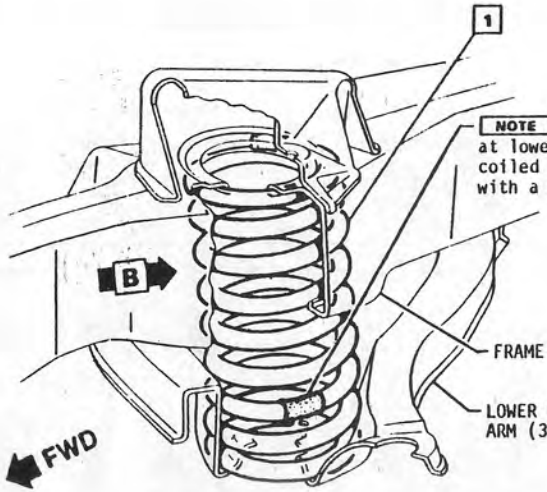
UPC 3A

SHEET 2

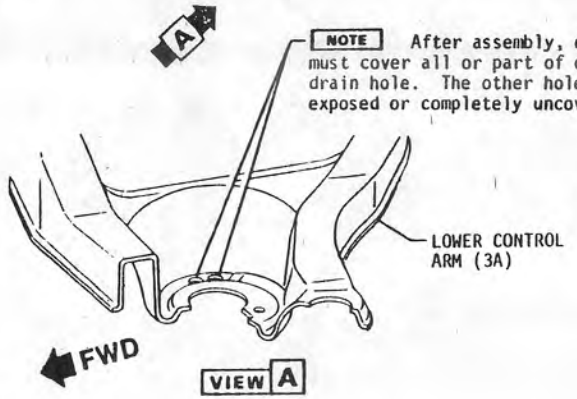
Ch X B O P X Ca

145

14029303 [1] CHART-SPRING USAGE (UPC 0)

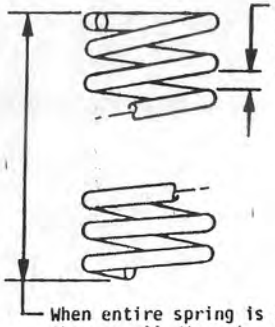


NOTE Spring to be installed with tape at lowest position. Bottom of spring is coiled helical, and the top is coiled flat with a gripper notch near end of wire.



NOTE After assembly, end of spring coil must cover all or part of one inspection drain hole. The other hole must be partly exposed or completely uncovered.

VIEW A



When a portion of coils are compressed the coil to coil gap must never be less than .60 inches.

When entire spring is compressed the overall dimension must never be less than 9.56 inches.

VIEW B

DYNAMIC (Instal) N·m	HAND (Insp.) N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG

DATE 10-14-80
DR MORRISON/EJM
CK
APPR
APPR
APPR
APPR

1 FULLY DRIVEN, SEATED & NOT STRIPPED

147

Ch X B O P X Ca

DIV CHEVROLET

1981 CHEV. "F" 14020867

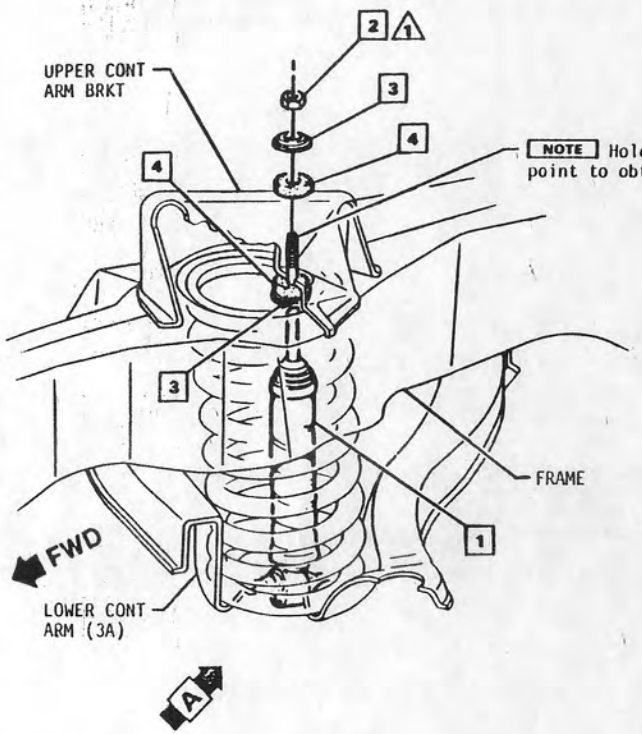
TITLE FRONT SPRINGS FA00 ALL

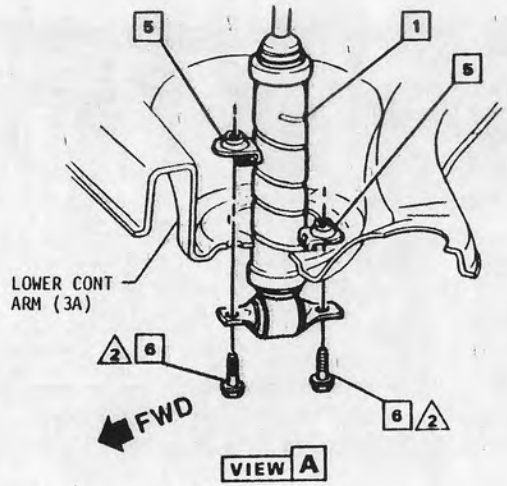
REF ECR 86448 C/O 21N079 3C-1

L-95093-S L- L- L-

UPC 3C

SHEET 1





VIEW A

22012192	1	SHOCK ABS ASM FP00 exc F41
22012621	1	FS00
22012493	1	FP00 &F41 exc Z28;
22012623	1	FP00 &Z28
1365067	2	NUT
5544049	3	RETAINER
6264018	4	INSULATOR
339715	5	NUT
3968521	6	BOLT/SCREW

DYNAMIC (Install) N·m	HAND (Insp.) · N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
	1 7 - 14							
	2 20 - 34							
	3							
	4							
	5							

1 FULLY DRIVEN SEATED & NOT STRIPPED

148

DATE 10.19.80
DR MORRISON/LJM
CK
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE FRONT SHOCK ABSORBER FA00 ALL

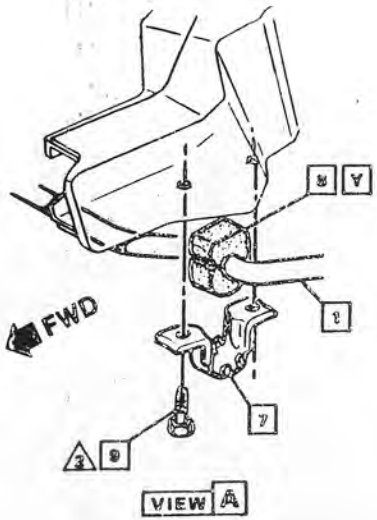
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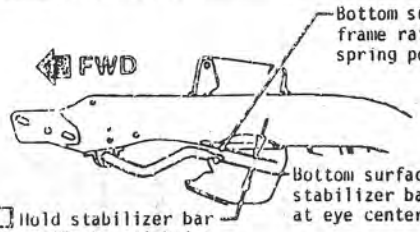
L- 95093-S
L-
L-
L-

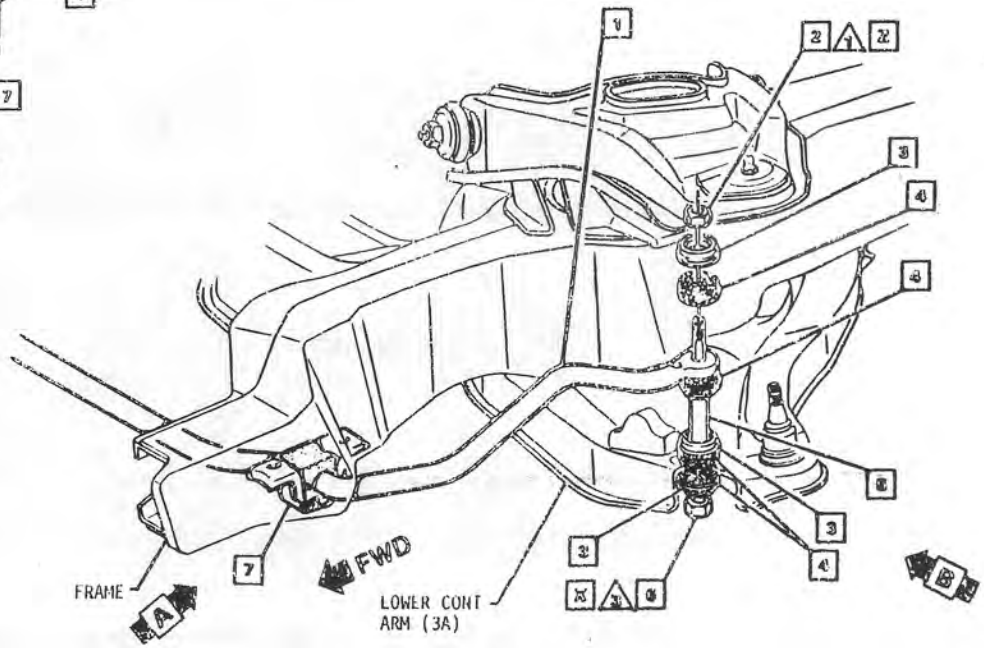
UPC 3F

SHEET 1

Ch X B O P X Ca







356533	1	SHAFT-FRT STAB (.938 Dia.) FP00 exc F41
356530	1	(1.00 Dia.) FP00 &F41 exc Z28
356529	1	(1.125 Dia.) FP00 &Z28
1365065	2	NUT
5544049	3	RETAINER FP00 exc Z28
3993729	3	FP00 &Z28
6264018	4	INSULATOR FP00 exc Z28
6270752	4	FP00 &Z28
3790333	5	SPACER FP00 exc Z28
3993730	5	FP00 &Z28
3983096	6	BOLT/SCREW FP00 exc Z28
335868	6	FP00 &Z28
406887	7	CLAMP FP00 exc Z28
3994334	7	FP00 &Z28
388294	8	INSULATOR FP00 exc Z28
371773	8	FP00 &Z28
(1) 14032586	9	BOLT/SCREW

X Bolt/Screw must be installed in direction shown.

Y Install stabilizer bar insulator with slit toward front of vehicle as shown.

Z Torque obtained by running nut to unthreaded portion of bolt.

DYNAMIC (Instel) N.m	HAND (Insp.) N.m	DATE	SYM	REVISION	AUTH	DR	CK	ASG ENG
△1 14 - 20		05MR81	1	WAS 14020259 BOLT/SCREW	01536	SM	HH	
△2 26 - 38								
△3 17 - 23								
△4								
△5								

△ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE 10/1/80
DR MORRISON/EJM
CK Harold Hayworth
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE FRONT STABILIZER FA00 ALL

REF ECR 86448 C/O 21N079 3G-1

L- 95093-S

UPC 3G

SHEET 1

Ch X B O P X Co

FRONT SUSPENSION ALIGNMENT

TO ALIGN	(A) AS SHIPPED		(A) CURB (Ref Only)	
	FACTORY TARGET	FACTORY AUDIT	SERVICE CHECKING	SERVICE SETTING
CASTER	+.6° (C)	+.6°±1° (B)	+1° ±1° (B)	+1°±.5° (C)
CAMBER	+1°	+1°±.8°	+1°±.8°	+1° ±.5°
TOE-IN (DEGREES-PER WHEEL)	+.15°	+.15°±.10°	+.15°±.10°	+.15°±.05°

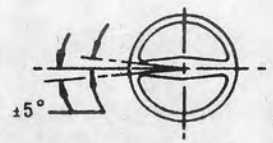
NOTE Vehicle must be jounced 3 times before checking alignment to eliminate false geometry readings.

(A) Front Suspension (Z) dimension and Rear Suspension (D) dimension are held as indicated in "Trim Heights" chart. See UPC 0. Wheel alignment specifications to be as indicated on this chart.

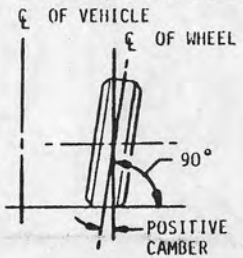
(B) Left and right side to be equal within 1°.

(C) Left and right side to be equal within .5°.

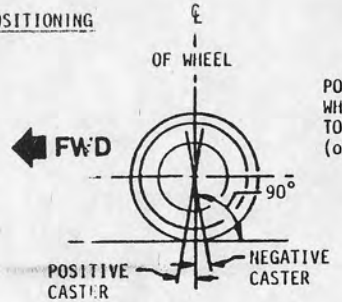
(D) Steering wheel must be held in straight ahead position ±5° while front wheel toe is being adjusted.



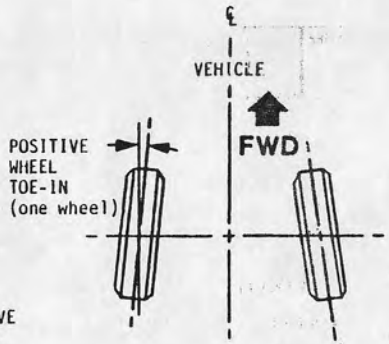
STEERING WHEEL POSITIONING



CAMBER ANGLE
Front view



CASTER ANGLE
Side view



WHEEL TOE-IN
Plan view

DYNAMIC (Instal) N.m	HAND (Insp.) N.m	DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG

DATE 11/13/80
DR MORRISON/EJM
CK [illegible] 11/14
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE FRONT SUSPENSION ALIGNMENT CHART FA00 ALL

REF ECR 86448 C/O C1N079 3Z-1

UPC 3Z

SHEET 1

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

Ch | D | O | P | Ca

4 REAR AXLE & REAR SUSPENSION

			DIV RESP
	4-1	CONTENTS-4A THRU 4F	D
	NOTE	Rear Axle Asm (See 4A)	

4A REAR AXLE ASSEM & PROP SHAFT

A	4A-1	AXLE & PROP SHAFT	C

4B REAR SPRINGS

B	4B-1	REAR SPRINGS	P

4D SPRING INSTALLATION PARTS

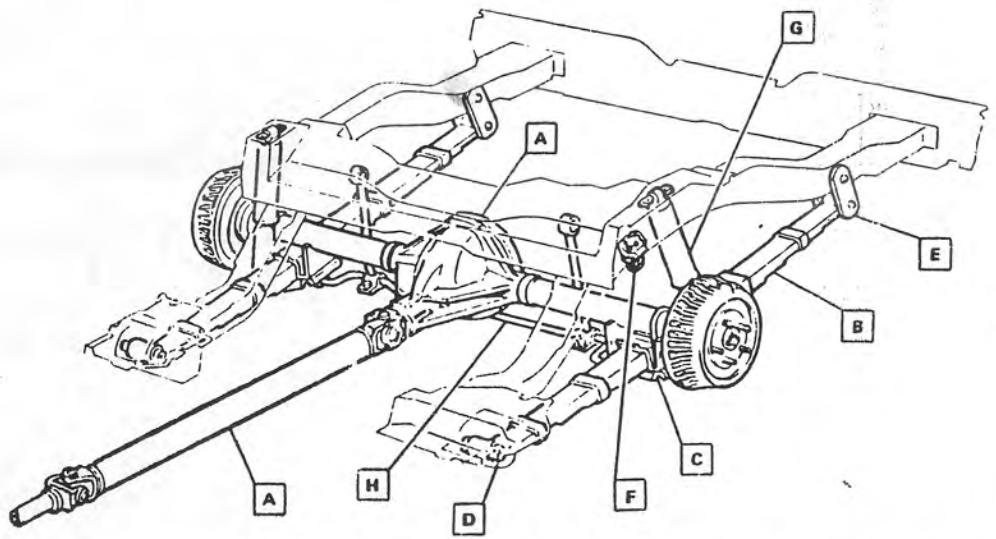
C	4D-1	REAR SPRING TO AXLE	P
D	4D-2	REAR SPRING TO FRONT BRACKET	P
E	4D-3	REAR SPRING SHACKLES	P
F	4D-4	REAR SPRING & AXLE BUMPERS	P

4E SHOCK ABSORBERS

G	4E-1	REAR SHOCK ABSORBER ASM	P

4F REAR STABILIZER

H	4F-1	REAR STABILIZER SHAFT FP00 &F41	P



DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG

DATE 15 JAN 80
DRS MORRISON/EJM
CK
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE CONTENTS-REAR SUSPENSION
FA00 ALL

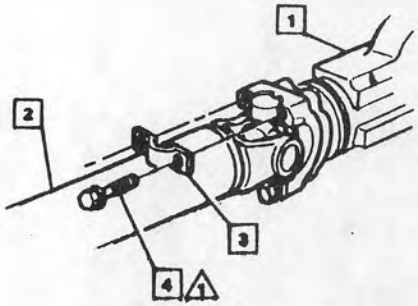
REF ECR 86448
NEW 190C79

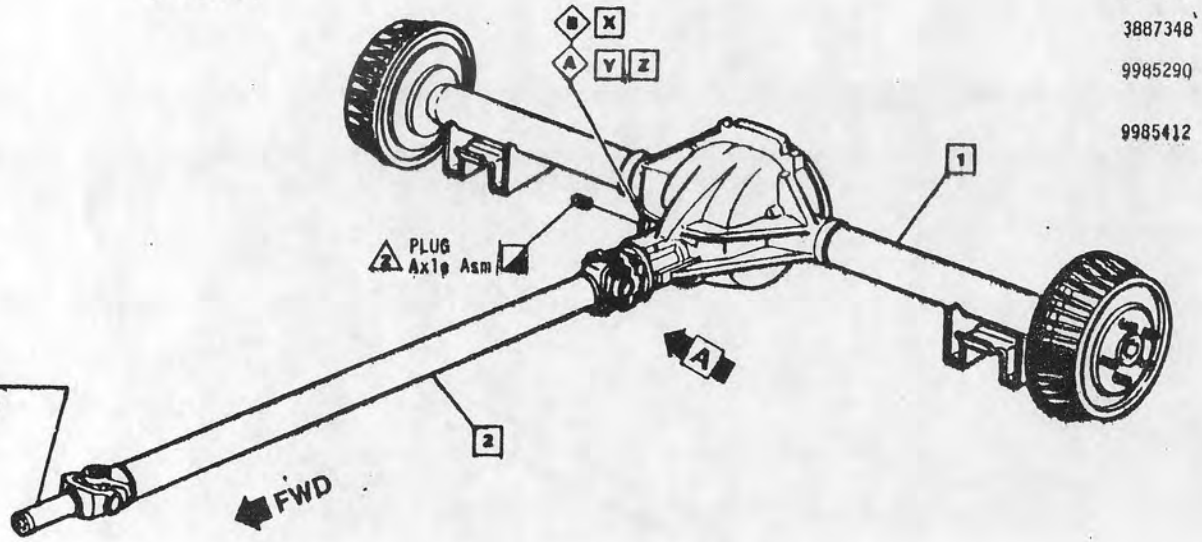
UPC 4

SHEET 1

★ Instructions Carryover
● Waiting Info.

Ch X B O P Co





NOTE This area of shaft must be entirely free of paint.

③① 1254282	1	RR AXLE ASM (UPC4) (SHOWN) For specific releasing & additional part numbers, see Parts List.
② 7819344	2	PROP SHAFT ASM FP00 &LC3/LU8/L39# &LG4 &MV4/M33# &LM1 &MX3/M38. FS00 &LC3/L39# &LG4 &MV4/M33.
② 7819345	2	FP00 &LG4/LM1 &M24 FS00 &LG4 &M24
② 7827081	2	FA00 &LD5 &MX2
7810416	3	RETAINER
3887348	4	BOLT /SCREW
9985290	A	LUB-HYPOID 3.9 LBS (4.25 pints metered fill)
9985412	B	LUB-FRICTION MODIFIER (BLUE) Approx .0312 Gal per job. FA00 &G80

X	Add B prior to A
Y	Thru hole in case. Lub level flush to 3/8" below threads.
Z	Axle may be filled at either "OFF-LINE" or "ON-LINE" fill station.

DYNAMIC (Install) N·m	HAND (Insp.) · N·m
△1	16 - 27
△2	34 - 48
△3	
△4	
△5	

△ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
08MY80	1	WAS 1254282 AXLE	81563			
	2	MODELS & OPTIONS REV (3 PLACES)	00150	SM		
12JN80	3	WAS 14026883 AXLE	21103	SM		

152

DATE 10JA80
DR MORRISON/EJM
CK Jim Hayworth
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE AXLE & PROP SHAFT FA00 ALL

ECR 86448 C/O 21N079 4A-1

97527(S)

UPC 4A

SHEET 1

Ch ☒ B ☐ O ☐ P ☒ Co ☐

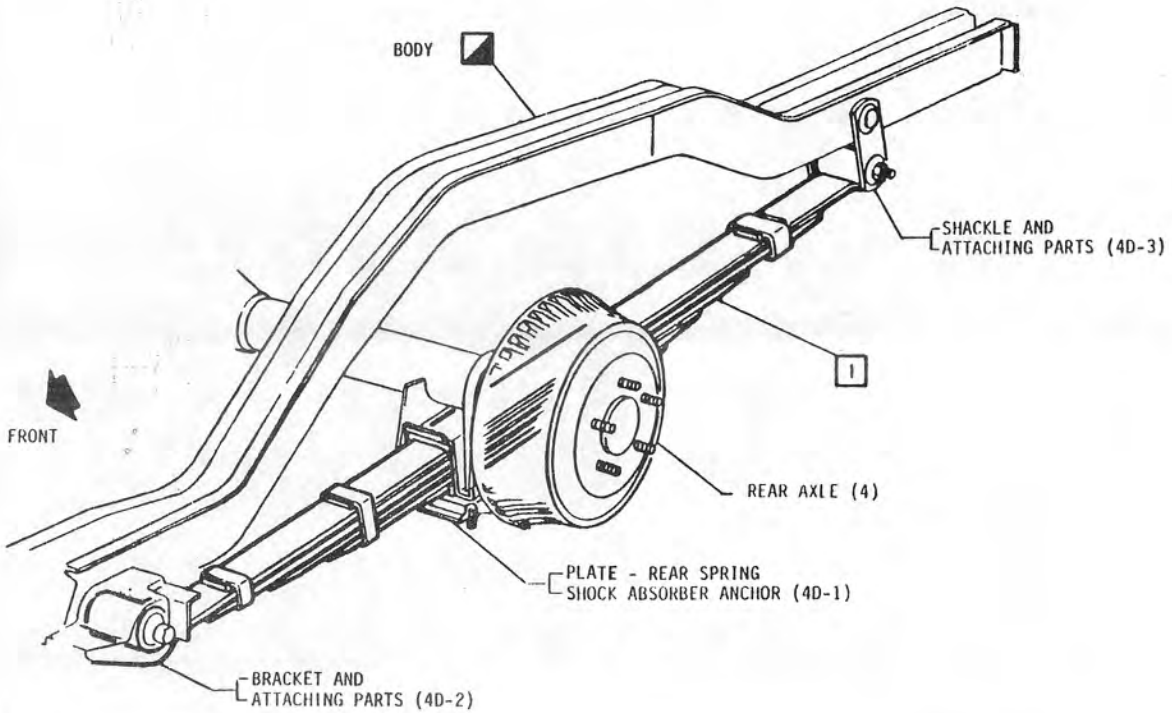
PONTIAC MOTOR DIVISION

General Motors Corporation Pontiac, Michigan

PRODUCT DESCRIPTION MANUAL

□ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF

SEE PARTS LIST FOR PART NUMBER AND USAGE [1] SPRING (CHART 480877)



DYNAMIC (Install) N m	HAND (Insp.) N m
1	
2	
3	
4	
5	

1 FULLY DRIVEN SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
12/1/80		ISSUED	86448	SM	[illegible]	

DATE	
DR P.D.S. 6... 9/0	
CK J.E.B.	
APPR S	
APPR	
APPR	
APPR	

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE REAR SPRINGS FA00 ALL

REF ECR 86448 C/O 20N079 4B-1 SAM

L- 92090 L- L-

UPC 4B

SHEET 1

Ch X B O P X Co

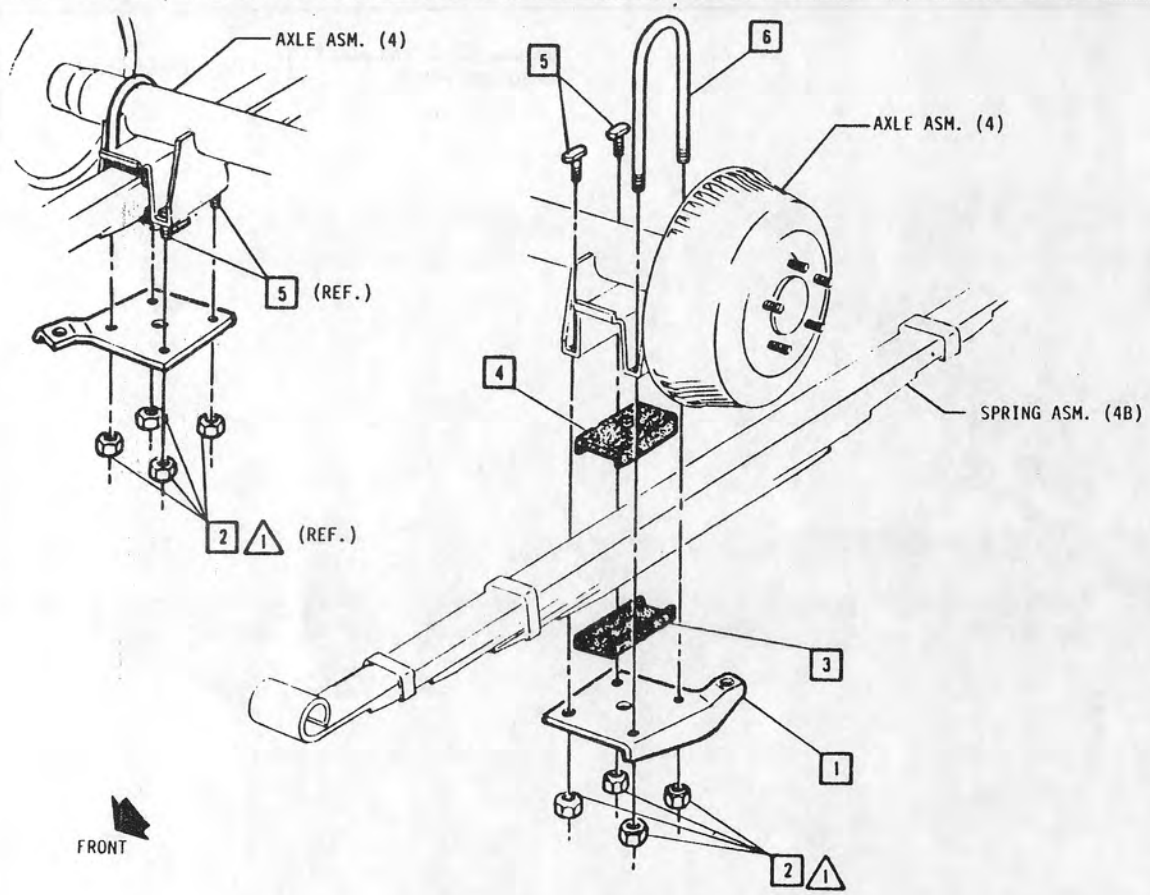
GMC M 1263 12-78 4DH+

PONTIAC MOTOR DIVISION

General Motors Corporation Pontiac, Michigan

PRODUCT DESCRIPTION MANUAL

□ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF



480909	1	PLATE
487182 3901399	2	NUT FP00 &F41 NUT FP00 exc. F41; FS00
480566	3	INSULATOR (LOWER)
477818	4	INSULATOR (UPPER)
9792949 481949	5	BOLT/SCREW FP00 exc. F41; FS00 BOLT/SCREW FP00 &F41
482970	6	U-BOLT

DYNAMIC (Install) N·m	MAND (Insp.) N·m
50-65 △1	50-70
△2	
△3	
△4	
△5	

△1 FULLY DRIVEN SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM Cog
10 JA 80		ISSUED	86448	EM	[illegible]	

154

DATE 12 NO 79
DR P.D. [illegible] C/S
CK J.E.B.
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE REAR SPRING TO AXLE
FA00 ALL

REF ECR 86448
C/O 21N079
4D-1 S.A.M

L- 73632
L-
L-
L-

UPC 4D

SHEET 1

Ch X B O P X Co

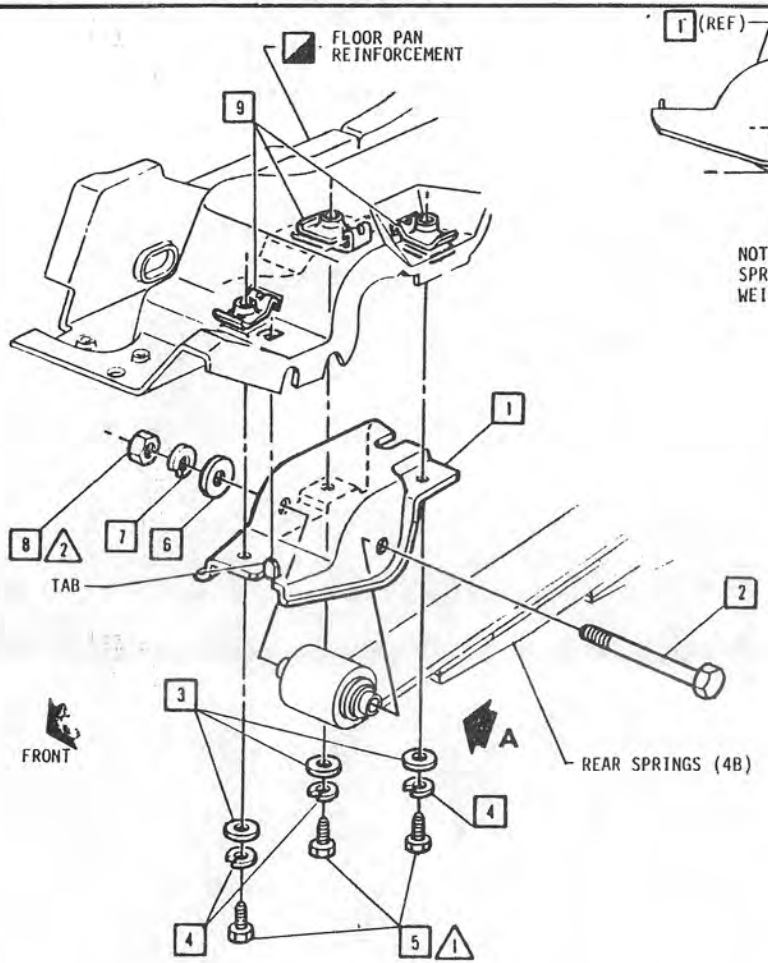
8-6E 10 1283 12-78 4044

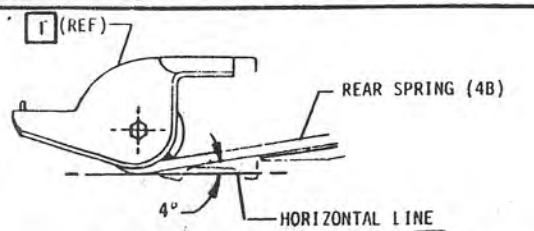
PONTIAC MOTOR DIVISION

General Motors Corporation Pontiac, Michigan

PRODUCT DESCRIPTION MANUAL

☐ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF





NOTE: INSTALL SPRING EYE BOLT [2] WITH SPRING AI APPROXIMATELY 4° OR WITH VEHICLE WEIGHT ON SPRINGS.

VIEW A

3980955 3980956	1	HANGER (L.H.) HANGER (R.H.)
3892754	2	BOLT/SCREW
3894057	3	WASHER
131099	4	WASHER
344624	5	BOLT/SCREW
415919	6	WASHER
103329	7	WASHER
9417614	8	NUT
378276	9	NUT ASM.

MANDATORY INSTALLATION SEQUENCE

1. INSTALL NUT ASM. [9] TO FLOOR PAN REINFORCEMENT.
2. LOCATE TAB ON BRACKET [1] INTO SLOT IN REINFORCEMENT AND START FORWARD BOLT [5]
3. START OTHER (2) BOLTS [5] AND DRIVE ALL THREE TO SPECIFIED TORQUE.

DYNAMIC (Install) N·m	HAND (Insp.) N·m
90-115	△1 34-48 △2 90-115 △3 △4 △5

△1 FULLY DRIVEN SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM Eng
10A80		ISSUED	86448	SM	PD	

155

DATE	12 NO 79
DR	P.D. Salmon
CK	J.E.B.
APPR	S
APPR	
APPR	
APPR	

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE: REAR SPRING TO FRONT BRACKET FA00 ALL

REF ECR 86448 C/O 21N079 4D-2 S.A.M

L- 73622

UPC 4D

SHEET 2

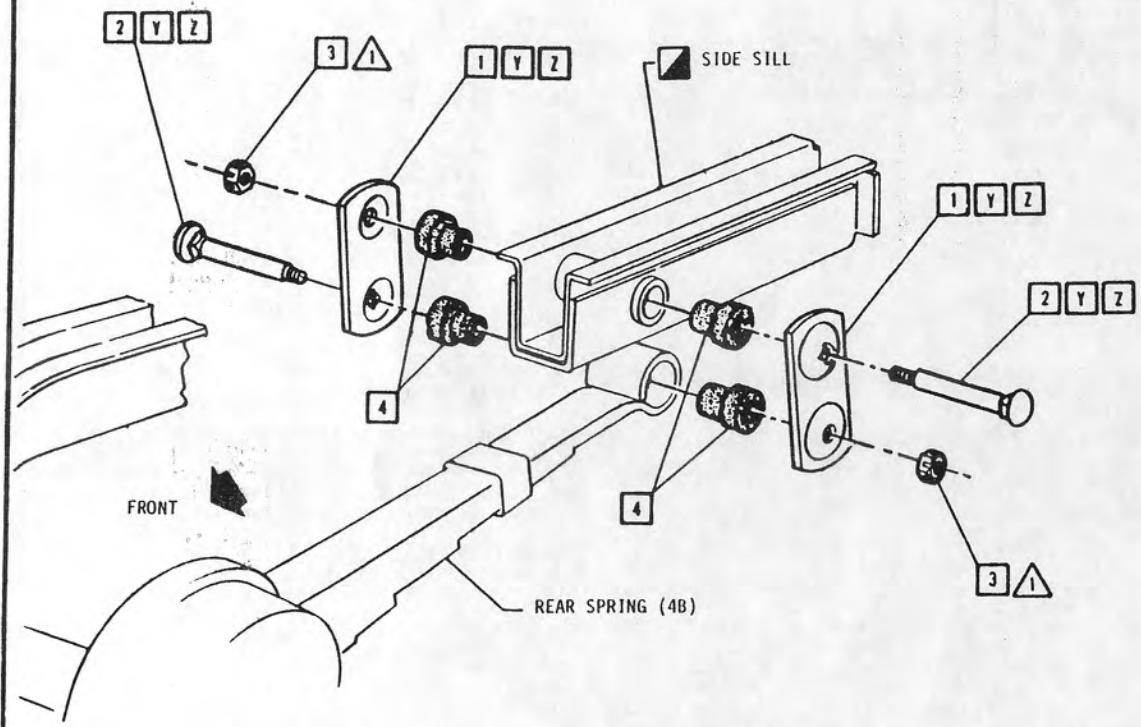
Cs ☒ B ☐ O ☐ P ☒ Co ☐

PONTIAC MOTOR DIVISION

General Motors Corporation Pontiac, Michigan

PRODUCT DESCRIPTION MANUAL

□ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF



10002468	1	SHACKLE - REAR
3973020	2	BOLT/SCREW
272876	3	NUT
480902	4	BUSHING FP00 exc Z28; FS00
499473	4	BUSHING FP00 & Z28

Y SHACKLES AND PINS TO BE ASSEMBLED IN DIRECTION SHOWN.

Z WITH SHACKLE PIN PROPERLY INSTALLED AND NUT TORQUED, A GAP OF UP TO .16 MAY EXIST BETWEEN THE BOLT HEAD AND THE SHACKLE.

DYNAMIC (Install) N·m	HAND (Insp.) N·m
△1 △2 △3 △4 △5	55 - 80

△ FULLY DRIVEN SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
14 NO 79		ISSUED	86448	SM	SB	

156

DATE 14 NO 79
DR P.D.S. Cm %
CK J.E.B.
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE REAR SPRING SHACKLES FA00 ALL

REF ECR 86448 C/O 21N079 4D-3 S.A.M

L· 73632 L· L· L·

UPC 4D

SHEET 3

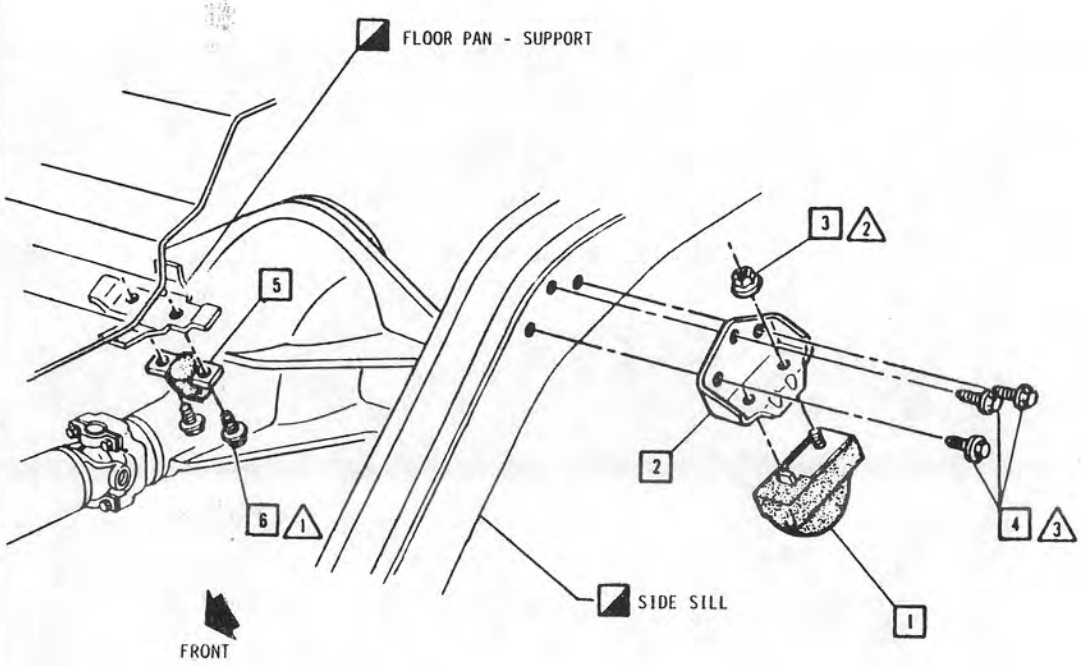
Ch X B O P X Co

PONTIAC MOTOR DIVISION

General Motors Corporation Pontiac, Michigan

PRODUCT DESCRIPTION MANUAL

☐ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF



483746	1	BUMPER ASM. - REAR AXLE
340324	2	BRACKET
1378333	3	NUT
9431970	4	BOLT/SCREW
525419	5	BUMPER ASM. - PINION
11500086	6	BOLT/SCREW

DYNAMIC (Install) N m	HAND (Insp.) N m
1	8 - 14
2	20 - 27
3	26 - 38
4	
5	

1 FULLY DRIVEN SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
JAN 80		ISSUED	86448	SM	[illegible]	

DATE 12 NO 79
DR P.D.S. (L. S.
CK J.E.B.
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE REAR SPRING AND AXLE BUMPERS
FA00 ALL

REF ECR 86448
C/O 21N079
4D-4 S.A.M

t- 73632
t-
t-
t-

UPC 4D

SHEET 4

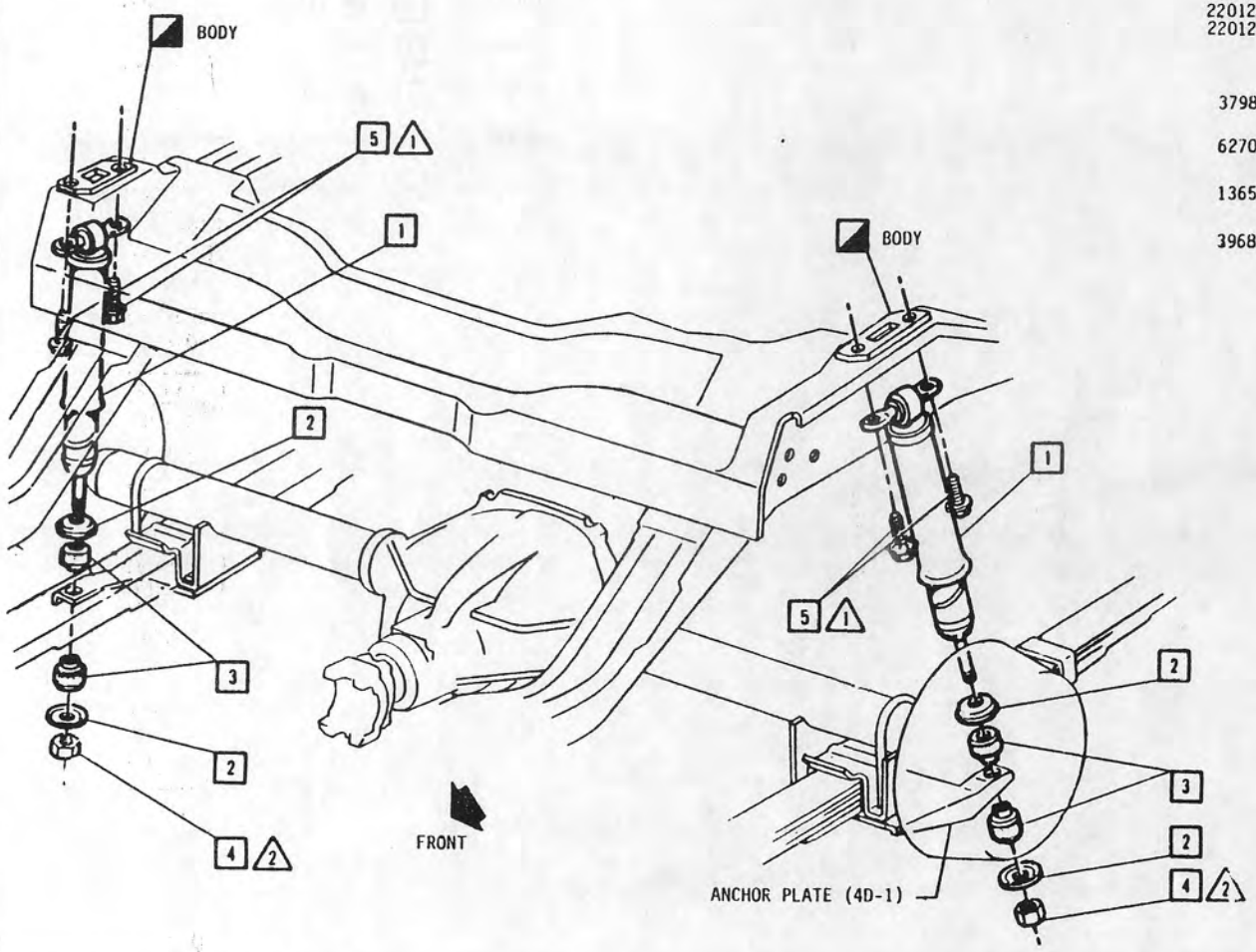
Cb ☒ B ☐ O ☐ P ☒ Cu ☐

PONTIAC MOTOR DIVISION

General Motors Corporation Pontiac, Michigan

PRODUCT DESCRIPTION MANUAL

☐ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF



22012492 22012494 22012624 22012622	1	SHOCK ABSORBER ASM. FP00 exc F41 SHOCK ABSORBER ASM. FP00 & F41 exc Z28 SHOCK ABSORBER ASM. FP00 & Z28 SHOCK ABSORBER ASM FS00
3798007	2	RETAINER
6270704	3	INSULATOR
1365067	4	NUT
3968521	5	BOLT/SCREW

DYNAMIC (Instal) N.m	HAND (Insp.) N.m
△1	20 - 34
△2	7 - 14
△3	
△4	
△5	

△ FULLY DRIVEN SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
12NO80		ISSUED	86448	SM	SM	

158

DATE 12 NO 79
DR P.D. Schuss
CK J.E.B.
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
REAR SHOCK ABSORBER ASSEMBLY
FA00 ALL

REF ECR 86448
C/O 21N079
4E-1 S.A.M

L- 73632
L-
L-
L-

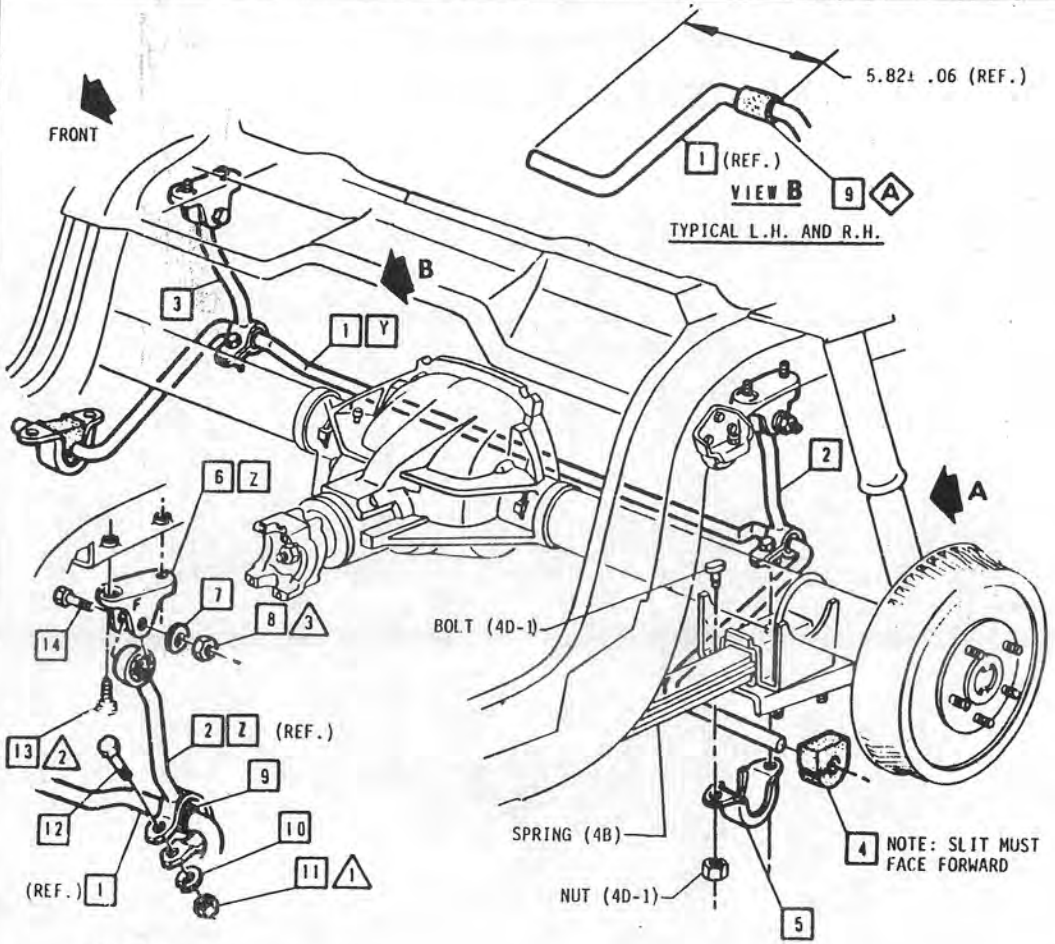
UPC 4E

SHEET 1

Ck | B | O | P | Ca

PONTIAC MOTOR DIVISION
General Motors Corporation Pontiac, Michigan

PRODUCT DESCRIPTION MANUAL
☐ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF



VIEW A

TYPICAL L.H. AND R.H.

481471 3983084	1	STABILIZER SHAFT exc Z28 STABILIZER SHAFT &Z28
486051	2	ROD ASM. L.H.
486050	3	ROD ASM. R.H.
481432 480913	4	INSULATOR - SHAFT exc Z28 INSULATOR - SHAFT & Z28
3982300	5	CLAMP
485336	6	BRACKET
382588	7	WASHER
9422297	8	NUT
498581 486960	9	INSULATOR exc Z28 INSULATOR &Z28
11500191	10	WASHER
9417954	11	NUT
1252920	12	BOLT/SCREW
9431970	13	BOLT/SCREW
9424821	14	BOLT/SCREW
9985257	A	LUBRICANT Approx. .003 Gal.

Y THE CENTER "U" SHAPED SECTION OF STABILIZER BAR MUST BE REARWARD AND DOWN WHEN IN THE INSTALLED POSITION.

Z INSTALL WITH DEPRESSED AREA AND LETTER "F" FORWARD.

DYNAMIC (Instal) N m	NANO (Insp.) N m
1	19 - 27
2	26 - 48
3	34 - 38
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
10 NOV 80		ISSUED	86448	SM	[illegible]	
		150				

DATE	12 NO 79
DR	P. D. Salvo 9c
CK	J.E.B.
APPR	S
APPR	
APPR	
APPR	

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE REAR STABILIZER SHAFT FP00 &F41

REF ECR 86448 C/O 21N079 4F-1 S.A.M

73906

UPC 4F

SHEET 1

Ck ☒ B ☐ O ☐ P ☒ Ca ☐

5 BRAKES

			DIV. RESP.
	5-1	CONTENTS 5A THRU 5Z	D

5C BRAKE PEDAL & MASTER CYLINDER CONNECTIONS

			DIV. RESP.
A	5C-1	BRAKE PEDAL BRACKET	C
	5C-2	BRAKE PEDAL	C
	5C-3	BRAKE PEDAL PUSH ROD & STRIKER	C

5D PARKING BRAKE

			DIV. RESP.
B	5D-1	PARKING BRAKE PEDAL & LEVER	C
	5D-2	PARKING BRAKE FRONT CABLE	C
C	5D-3	PARKING BRAKE REAR CABLE	C
	5D-4	PARKING BRAKE ADJUSTMENT PROCEDURE	C

5E HYDRAULIC MASTER CYLINDER

			DIV. RESP.
D	5E-1	BRAKE MAIN CYLINDER	C

5F BRAKE LINES

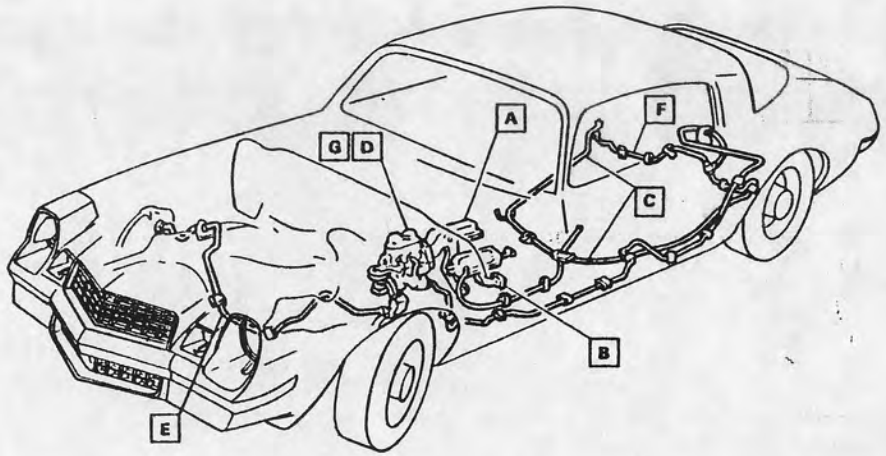
			DIV. RESP.
E	5F-1	FRONT BRAKE PIPES, DISTRIBUTOR & SWITCH ASM	C
	5F-2	FRONT BRAKE PIPES	C
(1)	5F-3	CANCELED	
F	5F-4	REAR BRAKE FRONT PIPE	C
	5F-5	REAR BRAKE REAR PIPES	C
	5F-6	BRAKE PIPE CLEARANCE DIMENSIONS	C

5G POWER BRAKE

				DIV. RESP.
G	5G-1	VACUUM POWER BRAKE HEAD ASM		C
	5G-2	VACUUM POWER BRAKE HOSES PIPE & FILTER	....LC3 &J50	C
(2)	5G-3	CANCELED		
	5G-4	VACUUM POWER BRAKE HOSE PIPE & FILTER	....LG4/LM1/L39	C
	5G-5	VACUUM POWER BRAKE HOSE	....LD8	B

5Z MISCELLANEOUS INFORMATION

			DIV. RESP.
	5Z-1	BRAKE SYSTEM TORQUE & CLEARANCE INSTRUCTIONS	C
	5Z-2	BRAKE SYSTEM BLEED CHECK	C



DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
04SE80	1	SHT 5F-3 BRAKE PIPE HT SHLD LUB CANCELED				
	2	SHT 5G-3 BRAKE HOSE LUB CANCELED	91222	EXM	RC	
		160				

★ Instructions Carryover
● Waiting Info.

DATE 18JA80
DR B. PIKE / GMP
CK Tom Hayes TH
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

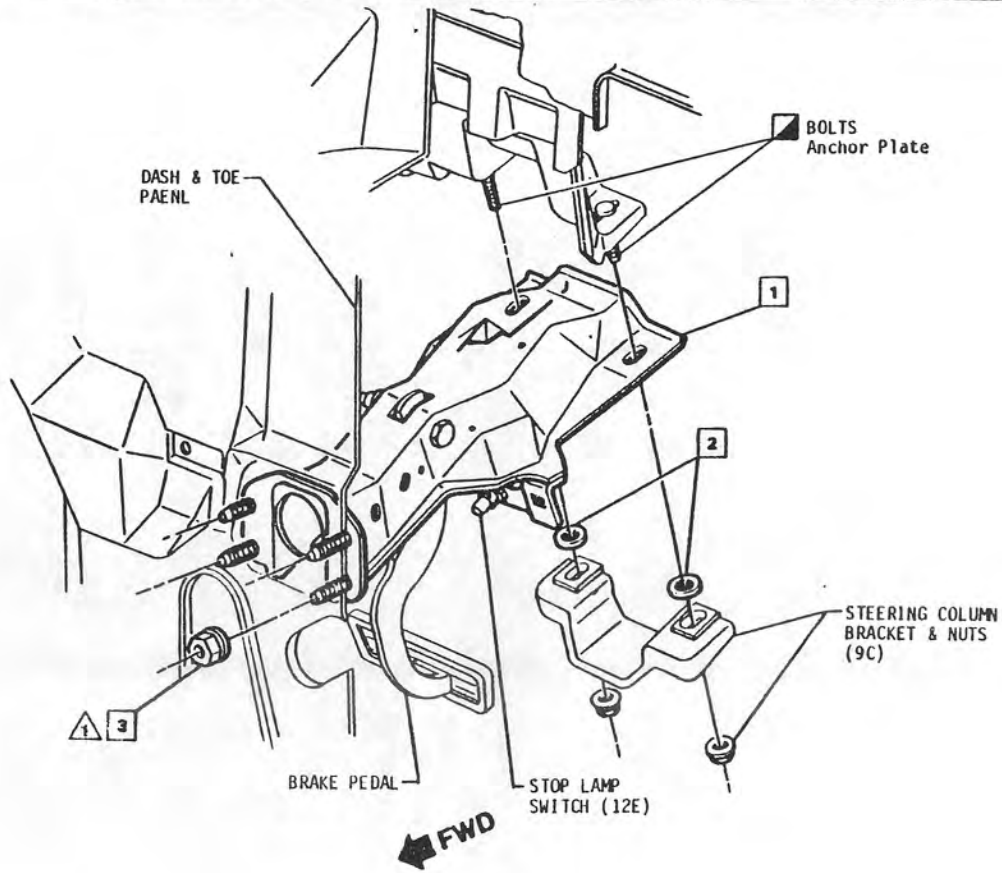
TITLE CONTENTS-BRAKES FA00 ALL

REF ECR 86448 NEW 100C79

UPC 5

SHEET 1

Ch X 8 0 P Co



14003631	1	BRACKET ASM
11501849	2	RETAINER
14000393	3	NUT

DYNAMIC (Install) N·m	HAND (Insp.) - N·m
20 - 34	20 - 34

1 2 3 4 5

1 FULLY DRIVEN, SEATED & NOT STRIPPED

Ch X B O P X Ca

DATE	SYM	REVISION	AUTH	DR	CK	ASM Chg

DATE 11.14.80
DR R G FIELDING
CK
APPR
APPR
APPR
APPR

161

DIV CHEVROLET

1981 CHEV. "F" 14020867

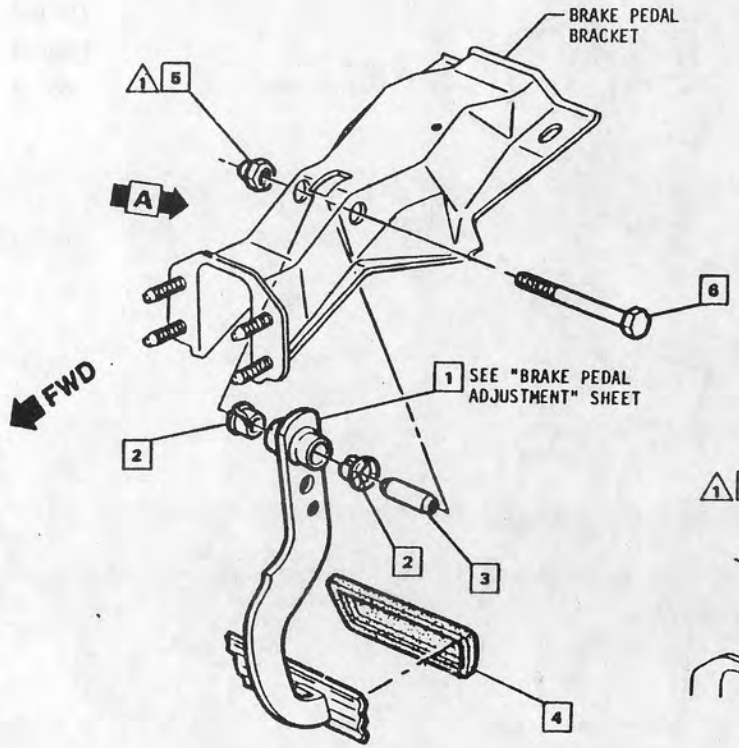
TITLE BRAKE PEDAL BRACKET
FA00 ALL

REF ECR 86448
NEW 10DE79

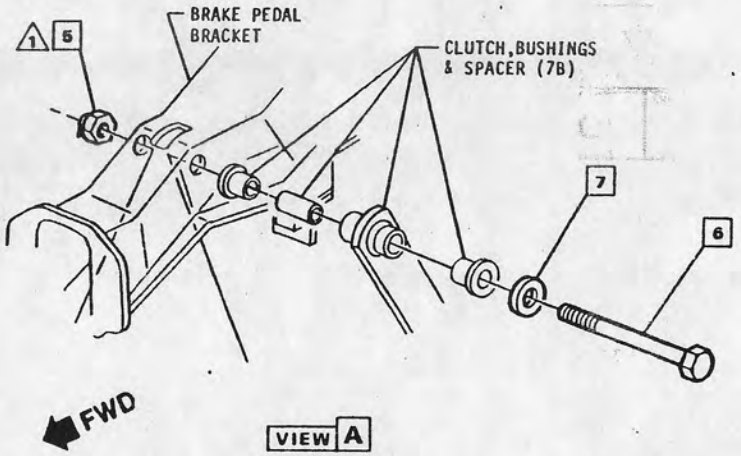
I- 91235 S
I- 18840 S
I-

UPC 5C

SHEET 1



368063	1	PEDAL ASM &M24 or M64
368064	1	exc M24 or M64
1247439	2	BUSHING
9794262	3	SPACER
3921648	4	COVER &M24 or M64
3888682	4	exc M24 or M64
9422299	5	NUT
9419194	6	BOLT /SCREW & M24 or M64
9419085	6	exc M24 or M64
9419276	7	WASHER &M24 or M64



VIEW A
&M24 or M64

DYNAMIC (Install) N·m	MAND (Insp.) · N·m
1	26-48
2	
3	
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CAG
		162				

DATE 11JA80
DR R.G. FIELDING/E.J.
CK Jim Hayeth
APPR SV
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
BRAKE PEDAL
FA00 ALL

REF ECR 86448
C/O 10DE79
5C-2

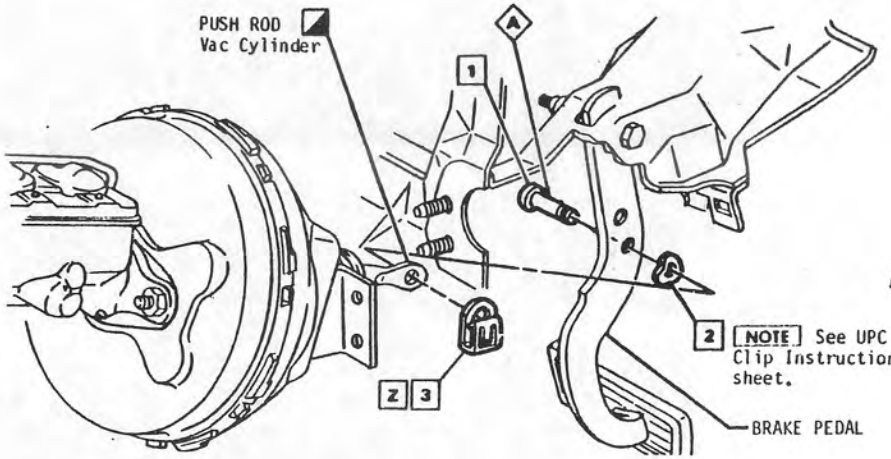
L-05346 S
L-08183 S
L-18840 S

UPC 5C

SHEET 2

Ck | B | D | P | Ca

3975544	1	PIN
410230	2	WASHER
3817880	3	RETAINER
9985164	A	GREASE-Approx .013 LBS on O.D. of Pin per job.



Z Retainer 3 MUST scribe a legible line on end of clevis pin 1 during assembly. Avoid any expanding tool which nullifies this intent.

DYNAMIC (Install) N·m	HAND (Insp.) - N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
	1 14 - 20							
	2							
	3							
	4							
	5							
	FULLY DRIVEN, SEATED & NOT STRIPPED							

DATE 11JAS1
DR RG FIELDING/EJM
CK Tom Haggerty TH
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE BRAKE PEDAL PUSH ROD
FA00 ALL

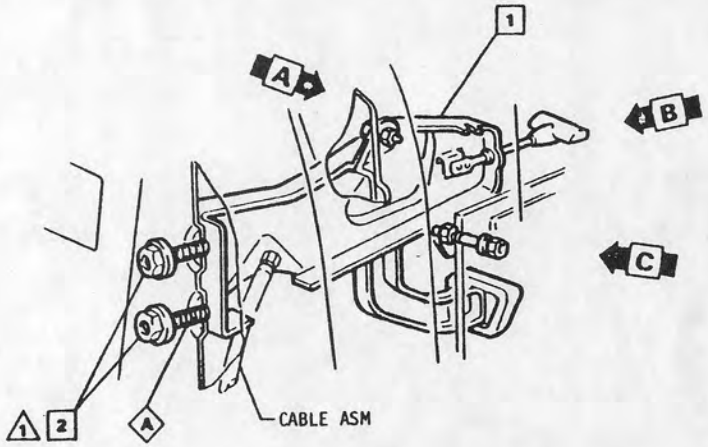
REF ECR 86448
NEW 12DE79

L-	05346	S
L-	08183	S
L-	18840	S
L-	19262	S

UPC 5C

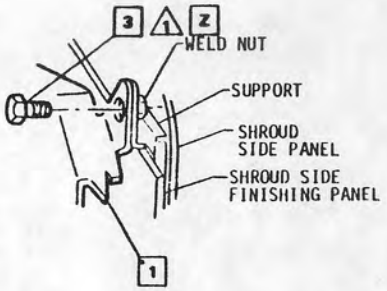
SHEET 3

B D P Ca

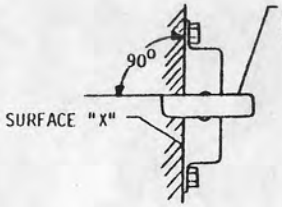


344625	1	PEDAL & LEVER ASM
1359887	2	NUT
3886787	3	BOLT/SCREW
3982308	4	STUD
9980664	A	ADHESIVE- Approx. .10 OZ per job.

2 If this Bolt/Screw is tightened first, Parking Brake Asm must be held in forward most position during tightening.

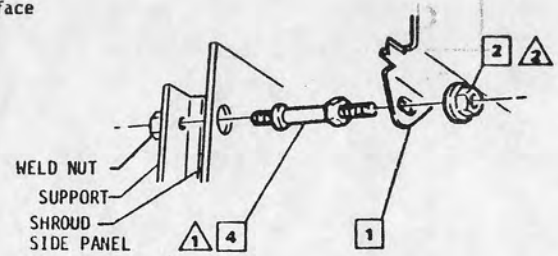


VIEW A



NOTE Maintain handle perpendicular to surface "X" within ± 1°.

VIEW B



VIEW C

DYNAMIC (Insted) N·m	HAND (Insp.) · N·m
1	9 - 14
2	14 - 20
3	
4	
5	

1 FULLY DRIVEN SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG

DATE 11JA80
DR RG FIELDING/EJM
CK Jim Hayes TH
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE PARKING BRAKE PEDAL & LEVER FA00 ALL

ECR 86448
C/O 100E79
5D-1

L- 08353 S
L- 89731 S
L- 16962 S

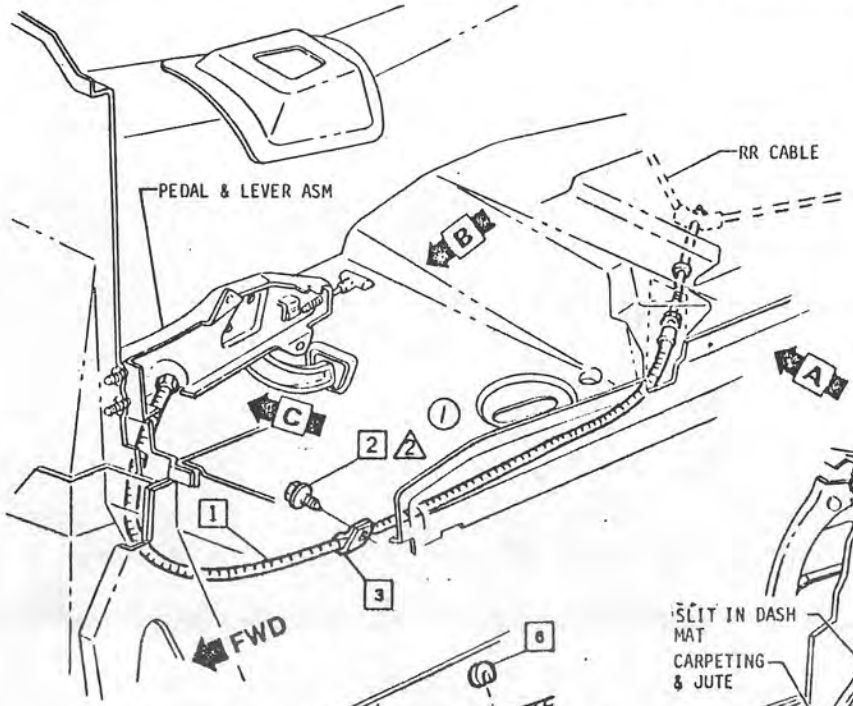
UPC 5D

SHEET 1

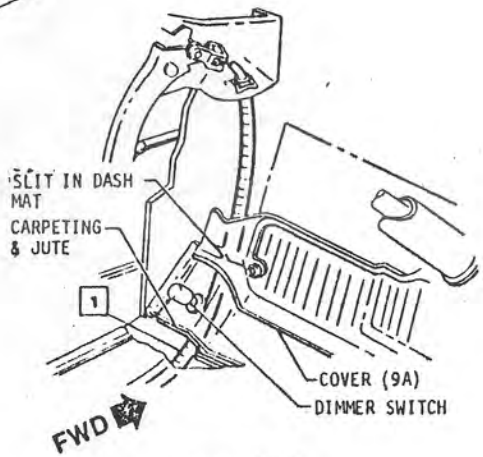
Ch | B | O | P | Cu

PRODUCT DESCRIPTION MANUAL

☐ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF



VIEW A



VIEW B



VIEW C

344682	1	CABLE ASM
11500086	2	BOLT/SCREW
340394	3	CLIP
103330	4	WASHER
103029	5	NUT
1385078	6	RETAINER
516213	7	RETAINER
1261218	7	OPT

DYNAMIC (Install) N·m	HAND (Insp.) - N·m
△1	34 - 48
△2	9 - 13
△3	
△4	
△5	

△1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM Eng
26SEP80	1	ITEMS 2&3 REMOVED & DRAWING REVISED	91803	JM	921	

DATE 11-14-80
DR R G FIELDING/EJM
CK Jan Hayworth
APPR SD
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE PARKING BRAKE
FRONT CABLE
FA00 ALL

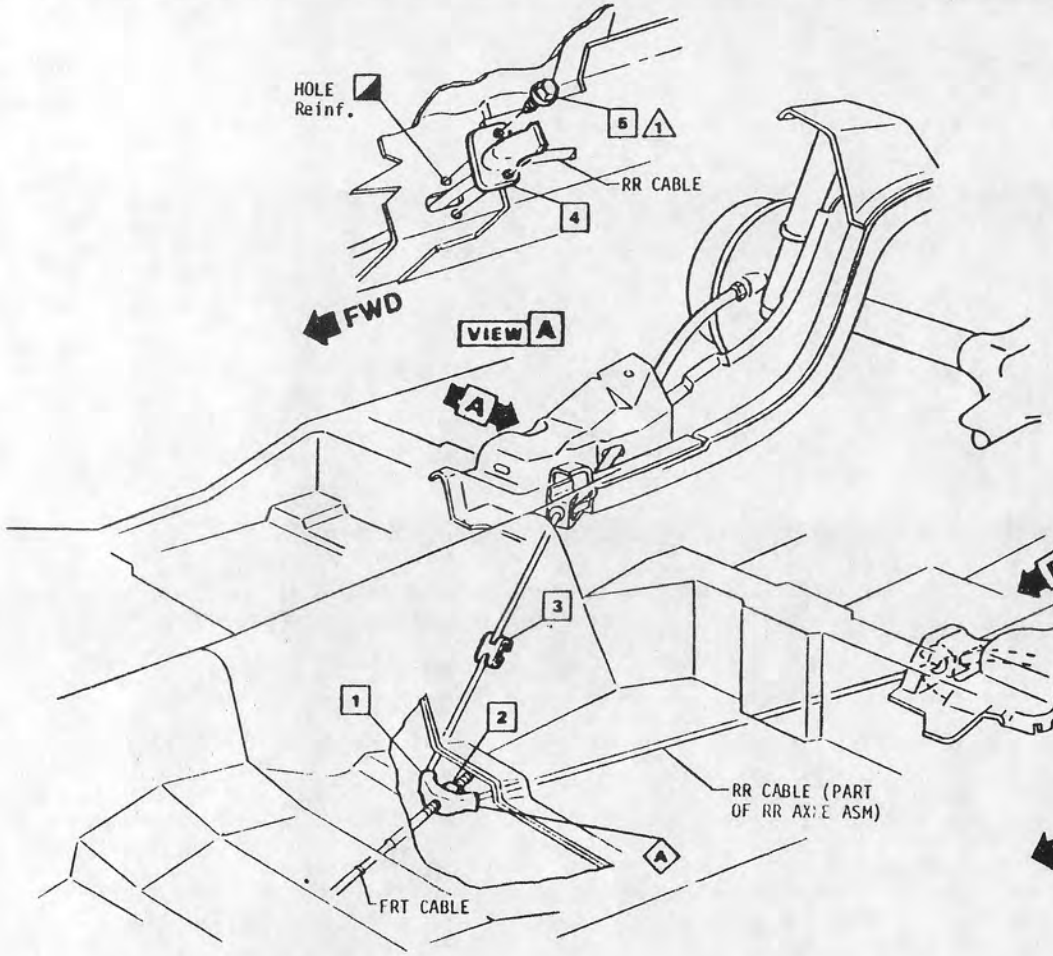
REF ECR 86448
C/O 10DE79
5D-2

L- 08353 S
L- 16962 S
L-
L-

UPC 5D

SHEET 2

Ch X B O P X Ca



1497525	1	EQUALIZER
1240837	2	NUT
537485	3	CONNECTOR
3983021-2	4	BRKT RR CABLE L & RH
11500086	5	BOLT/SCREW
516213	6	RETAINER
1261218	6	OPT
9985164	A	LUBRICANT-GREASE Approx .003 kg per job. Brush lubricant well into the inside of Equalizer 1

DYNAMIC (Instal) N·m	MANU (Insp.) - N·m
1	9 - 13
2	
3	
4	
5	

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
		500				

DATE 11JAN80
DR RG FIELDING/EJM
CK Tom Hamm
APPR SF
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE PARKING BRAKE REAR CABLE
FA00 ALL

REF ECR 86448
C/O 10DE79
5D-3

L- 08353 S
L- 06097 S
L- 16962 S

UPC 5D

SHEET 3

Ch X B O P X Ca

I. PRESTRETCH REQUIREMENT

PRIOR TO ADJUSTMENT AND WITH SYSTEM ASSEMBLED, THE ENTIRE CENTER CABLE MUST BE SUBJECTED TO A TENSILE FORCE OF AT LEAST 1334 NEWTONS CABLE TENSION BUT NOT MORE THAN 1779 NEWTONS FOR THREE (3) APPLICATIONS. THE CABLE MUST BE LOADED IN SUCH A MANNER AS NOT TO CAUSE ANY KINKS OR SET POINTS OTHER THAN AT THE EQUALIZER.

II. ADJUSTMENT PROCEDURE

ADJUST THE SYSTEM TO SPECIFICATIONS SUCH THAT A TORQUE OF 100 NEWTON METERS AT THE PARK BRAKE PEDAL WILL DEPRESS THE PEDAL AT LEAST SEVEN (7) CLICKS BUT NOT MORE THAN ELEVEN (11) CLICKS.

NOTE FOR PRODUCTION CONVENIENCE, THE ABOVE SPECIFICATION RELATES TO 1557-1779 NEWTONS OF STRAND TENSION IN THE CENTER CABLE AS MEASURED WITH A BURROUGHS CABLE TENSION GAGE B1-33-72CCA-150-400. THIS REFERENCE STRAND TENSION IS ONLY A PRODUCTION AID AND SHOULD NOT BE MISCONSTRUED TO BE AN ALTERNATE SPECIFICATION.

DYNAMIC (Instal) N·m	HAND (Insp.) N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
		1/APR80	1	REDRAWN & REDESIGNED (EC 5-0498)	28765	FJM	[illegible]	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE 1/APR80
DR [illegible]
CK [illegible]
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE PARKING BRAKE ADJUSTMENT PROCEDURE FA00 ALL

REF ECR 86448 C/O 10DE79 5D-4

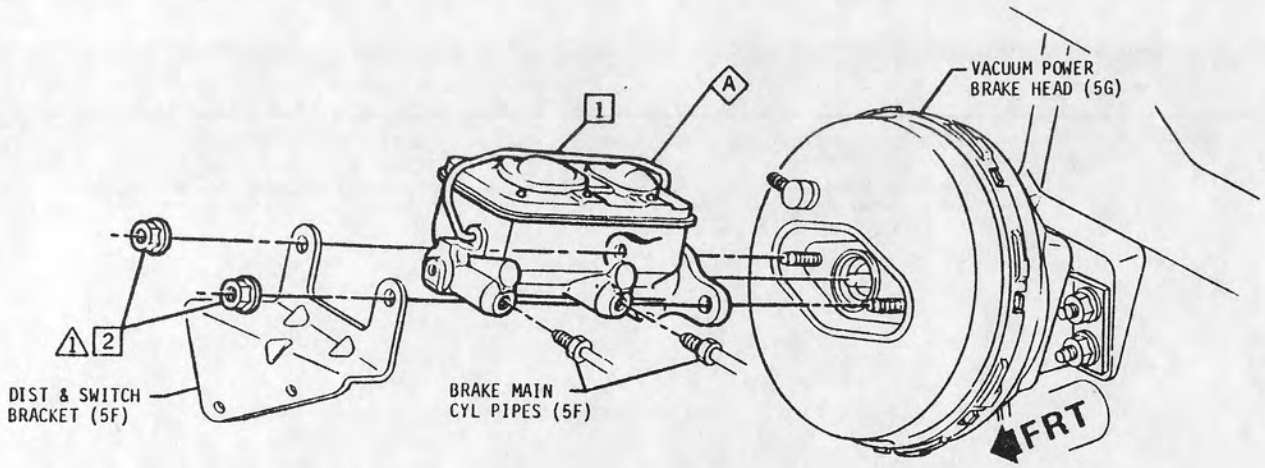
L-16962 S

UFC 5D

SHEET 4

Ch B D F Co

18008058	1	CYLINDER ASM
14000393	2	NUT
9985013	A	FLUID-HYD Approx .850 Liter (2)(3)



DYNAMIC (Instal) N·m	HAND (Insp.) - N·m
20 - 34	20 - 34

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
04SEP80	1	P/N RAWN & RE-DESIGNED 91222	91210	EJM	RC	
25FEB81	2	QTY I WAS .164 GAL	94794	EJM	RB	
09APR81	3	QTY WAS .225 GAL	94794	EJM	RB	

138

DATE	11.14.80
DR	R.G. FIELDING/EJM
CK	Tom Hayes-TH
APPR	S
APPR	
APPR	
APPR	

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE BRAKE MAIN CYLINDER
FA00 ALL

REF ECR 86448
NEW 10DE79

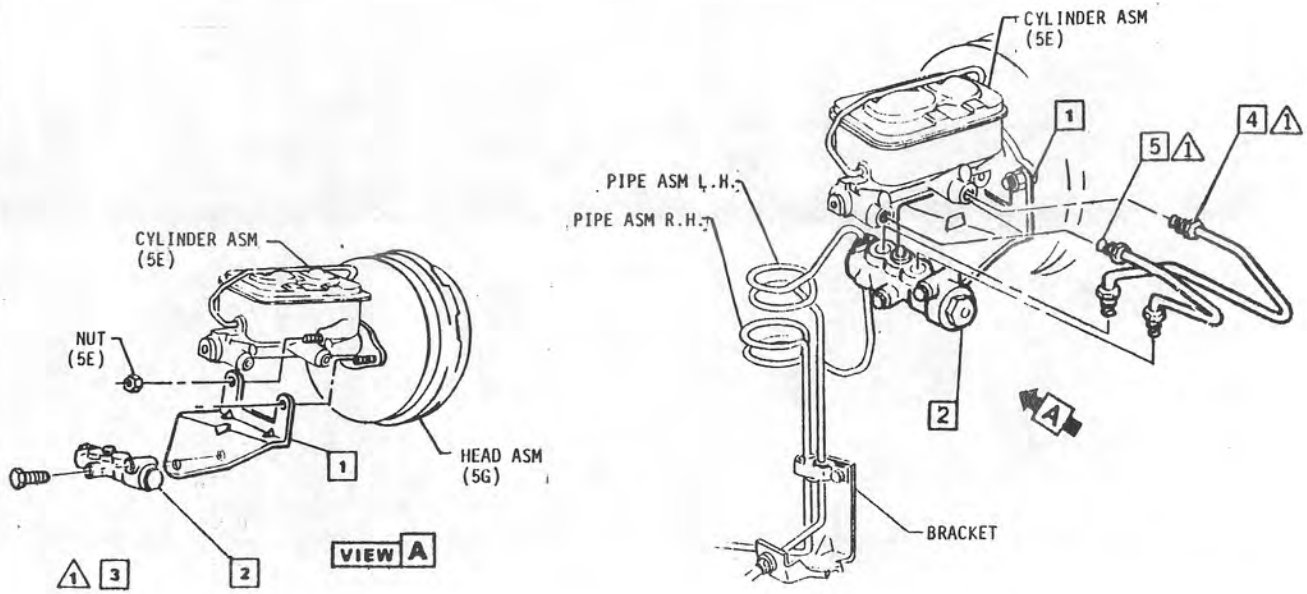
L-05346 S
L-08183 S
L-91235 S
L-18840 S

UPC 5E

SHEET 1

Ch X B O P X Ca

14025071	1	BRACKET
18008084	2	VALVE ASM
25509418	2	OPT
9432544	3	BOLT/SCREW
14031575	4	PIPE ASM-FRONT
(9) 14031576	5	PIPE ASM-REAR &LC3/LD5; &LG4/LM1/L39 &J50
(10) 10018543	5	&LG4/LM1/L39 &JE1



DYNAMIC (Instal.) N·m	HAND (Insp.) N·m
1	20-27
2	
3	
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

Ch ☒ B ☐ O ☐ P ☒ Co ☐

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
26MAR81	9	OPTIONS ADDED				
	10	10018543 PIPE ADDED	93379	EJM	RG	

DATE 15FEB80
DR RG FIELDING/EJM
CK
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

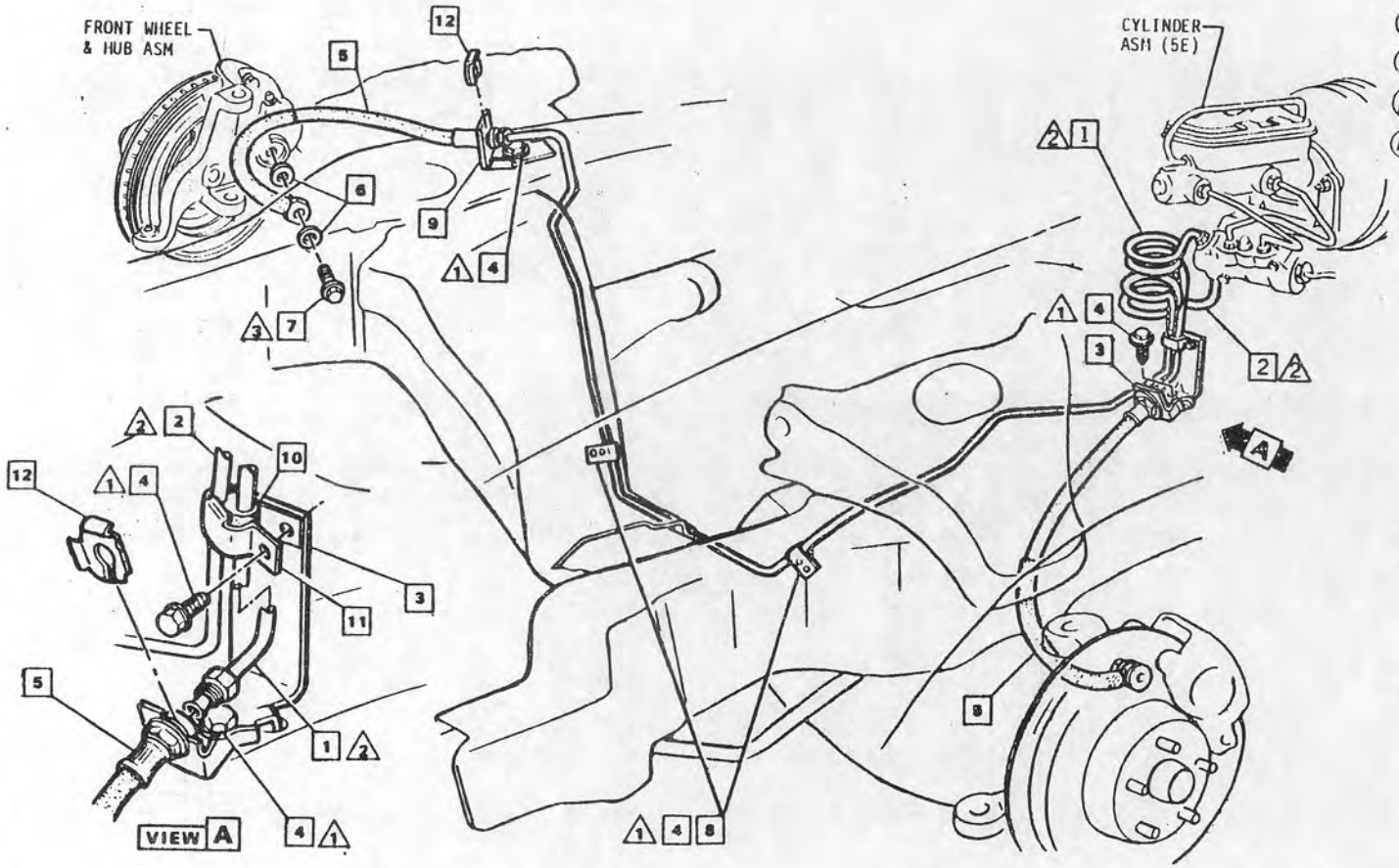
TITLE FRONT BRAKE PIPES, VALVE ASM FA00 ALL

REF ECR 86448 NEW 17JA80 5F-1

L- 95892-S
L- 96279-S
L- 25526-S
L-

UPC 5F

SHEET 1



(9) 14031569	1	PIPE ASM LH V6; V8 &J50
(10) 10012673	1	V8 &JE1
(11) 14031570	2	PIPE ASM RH V6; V8 &J50
(12) 10010002	2	V8 &JE1
(13) 6264041	3	BRACKET LH V6; V8 &J50
(14) 10012968	3	V8 &JE1
11500086	4	BOLT/SCREW
9762808	5	HOSE ASM
14005646	5	OPT
14000172	6	WASHER
14000404	7	BOLT/SCREW
343464	8	CLIP exc LD5
484527	8	&LD5
6264042	9	BRACKET RH
3983038	10	INSULATOR
3982380	11	CLIP
334961	12	RETAINER

DYNAMIC (Instal.) N·m | HAND (Insp.) - N·m

△1 8-14
△2 20-27
△3 34-54
△4
△5

△1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
9MAR81	9	OPTIONS ADDED				
	10	10012673 PIPE ADDED				
	11	OPTIONS ADDED				
	12	10010002 PIPE ADDED				
	13	OPTIONS ADDED				
	14	10012968 BRACKET ADDED	93379	EJM		

Ch X B O P X Co

DATE 13FEB0
DR RGHILLDING/LJM
CK
APPR S
APPR
APPR
APPR

DIV CHEVROLET

REF ECR 86448
NEW 10JA80

1981 CHEV. "F" 14020867

TITLE
FRONT BRAKE PIPES
FA00 ALL

L-95892-S
L-96279-S
L-23800-S
L-25526-S

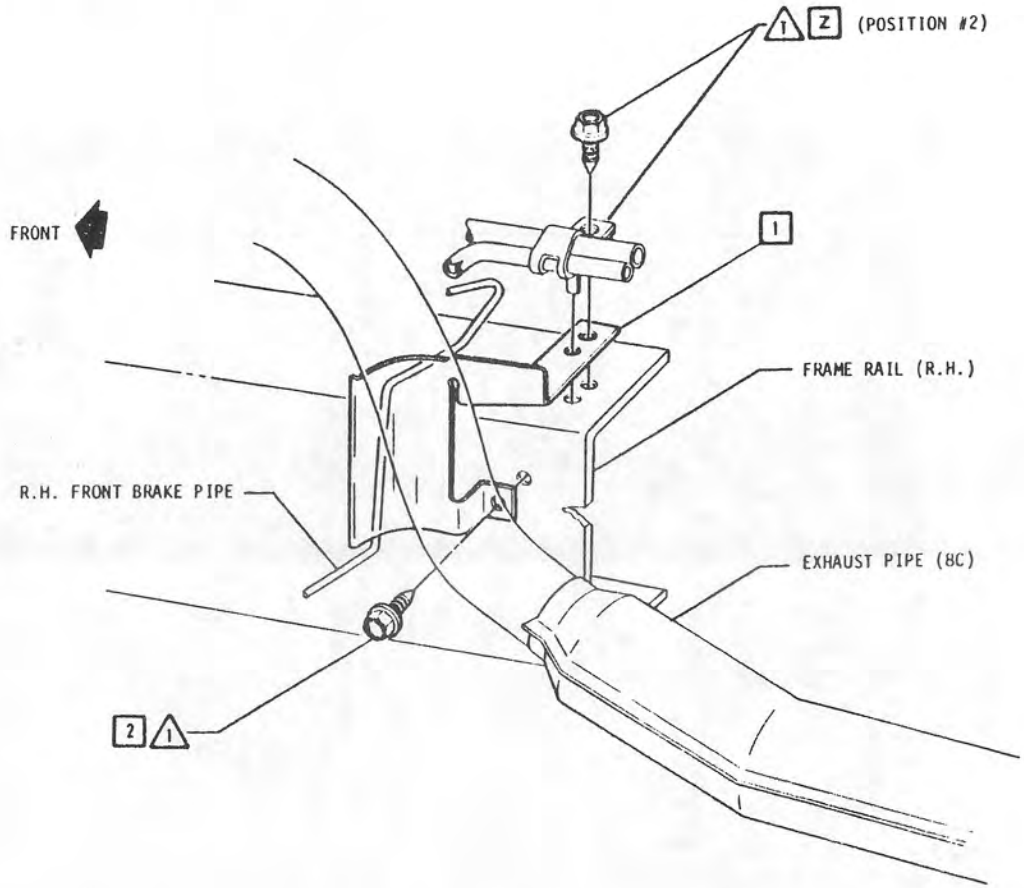
UPC 5F

SHEET 2

PONTIAC MOTOR DIVISION
General Motors Corporation Pontiac, Michigan

PRODUCT DESCRIPTION MANUAL
☐ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF

10013604 [1] SHIELD
11500086 [2] BOLT/SCREW



CANCELED

2 SEE UPC 8B SHEET-1 FOR PART NUMBERS.

DYNAMIC (Instal) N·m	HAND (Insp) N·m
1 2 3 4 5	8-14

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
11/A80		ISSUED	P6448	RF	SM	
23AUG80	1	SHEET CANCELED	91222	SM	MB	

DATE 14 NOV 79
DR P Dalmo S/O
CK JEB
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE R.H. BRAKE PIPE HEAT SHIELD FA00 & LU8

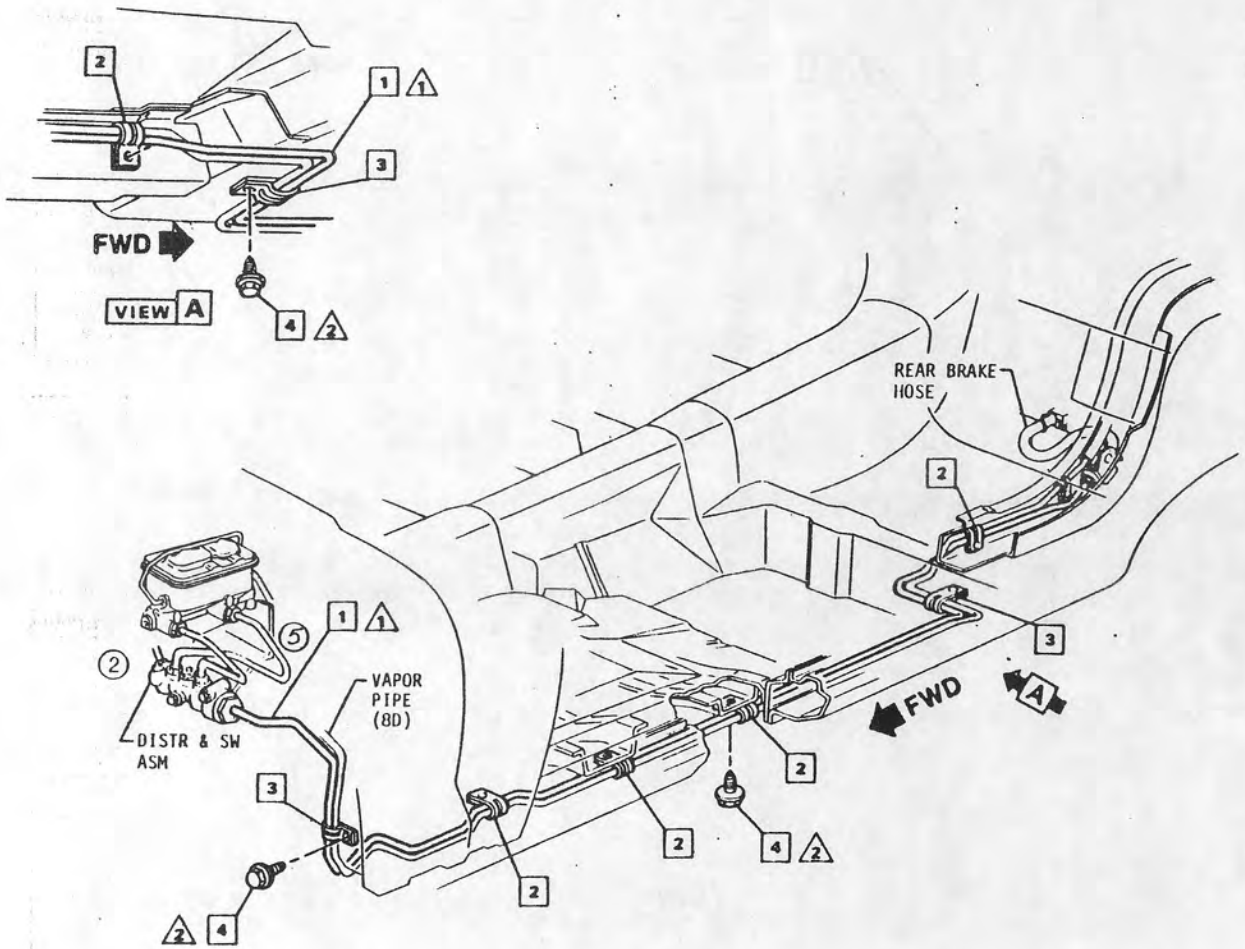
REF ECR 86448 C/O 10DE79 5F-2.1

UPC 51

SHEET 3

Ch B D P Ca

171



(3) 14031577	1	PIPE ASM-RR BRK FRT V6; V8 &J5(	
(4) 10005282	1	V8 &JE1	
340393	2	CLIP	
340392	3	CLIP	
11500086	4	BOLT/SCREW	

DYNAMIC (Instal) N·m | HAND (Insp.) · N·m

1 20-27
2 8-14
3
4
5
1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
20JN80	1	WAS 14022405 PIPE				
	2	DISTR REVISED	9076	EJM	HB	
19MR81	3	OPTIONS ADDED				
	4	10005282 PIPE ADDED				
	5	DRAWING REVISED	93379	EJM		

172

DATE 11JA80
DR RG. FIELDING/EJM
CK Tom Hayes-TH
APPR S.H
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
REAR BRAKE-FRONT PIPE
FA00 ALL

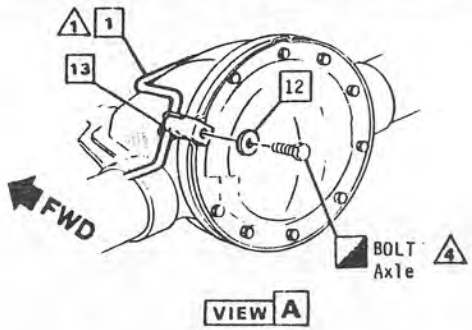
REF ECR 86448
C/O 10DE79
5F-3

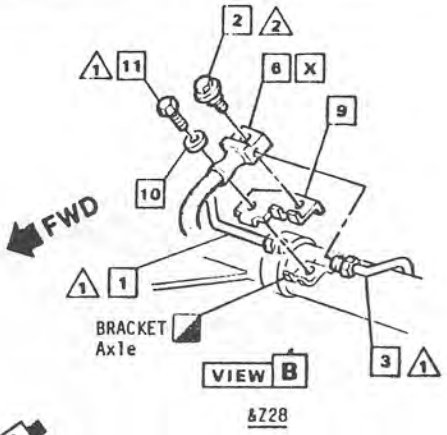
L-96279-S
L-11368-S
L-25526-S
L-

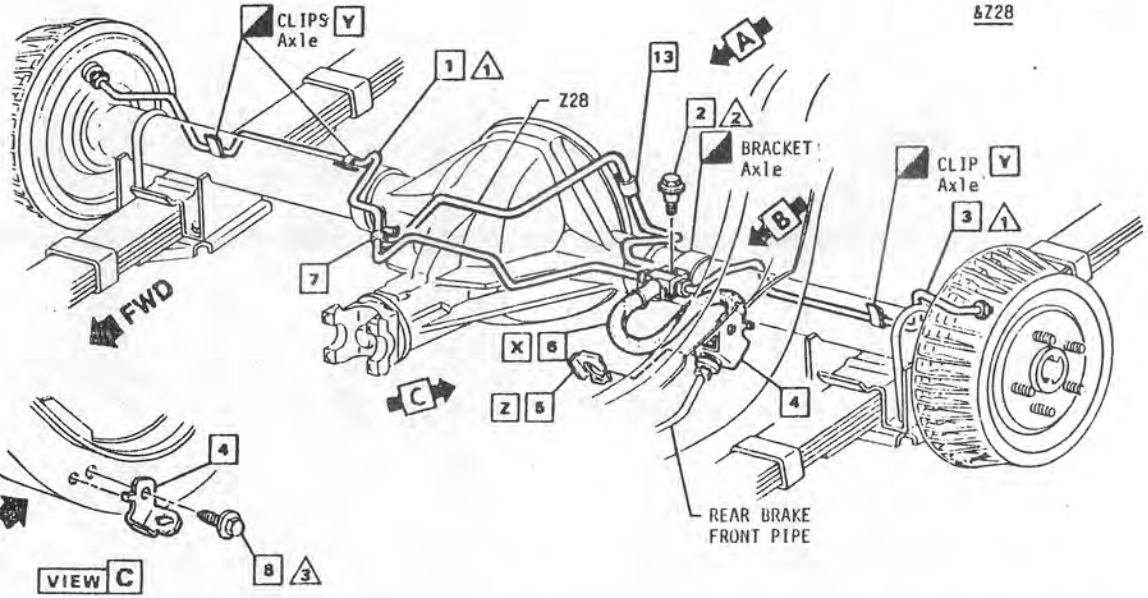
UPC 5F

SHEET 4

Ch X B D P X Co







(7)	14031572	1 PIPE ASM-RH exc Z28
(5)	14031574	1 &Z28
	1239146	2 BOLT/SCREW
(6)	14031571	3 PIPE ASM-LH exc Z28
(7)	14031573	3 &Z28
(8)	368119	4 BRACKET
	334961	5 RETAINER
	1251295	6 HOSE ASM exc Z28
(9)	9757655	6 OPT exc Z28
(10)	9761891	6 &Z28
	368115	7 CLIP
	11500086	8 BOLT/SCREW
	459072	9 BRACKET
	11500191	10 WASHER
	9419030	11 BOLT/SCREW
	9419234	12 WASHER
	470798	13 CLIP

[X] Hose Installed Position has an approx 60° Twist.

[Y] Form clip to securely retain pipes.

[Z] See UPC "0" General Information - Clip Instructions.

DYNAMIC (Install) N·m	HAND (Insp.) N·m
1	20-27
2	11-16
3	8-14
4	20-34
5	

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
20JN80	4	WAS 14020294 PIPE				
	5	14031574 WAS 14020296				
	6	WAS 14020293 PIPE				
	7	14031573 WAS 14020295				
	8	WAS 14025038 BRACKET				
	9	9757655 WAS 9764545				
	10	9761891 WAS 9764544 173	91076	EJM	HB	

DATE 16JAN80
DR R G FILLWING/EJM
CK Jim Hauge-TH
APPR 9
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE REAR BRAKE-REAR PIPES FA00 ALL

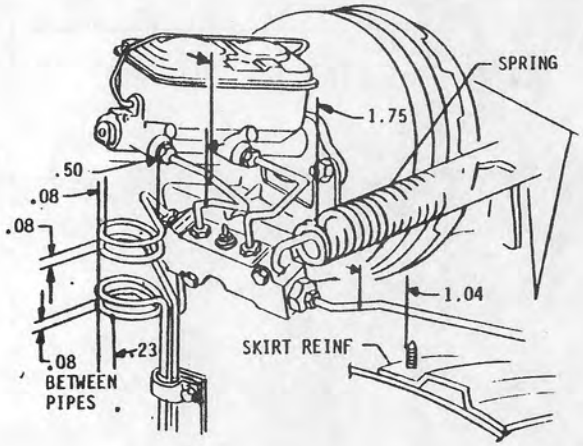
REF ECR 86448 C/O 10DE79 5F-4

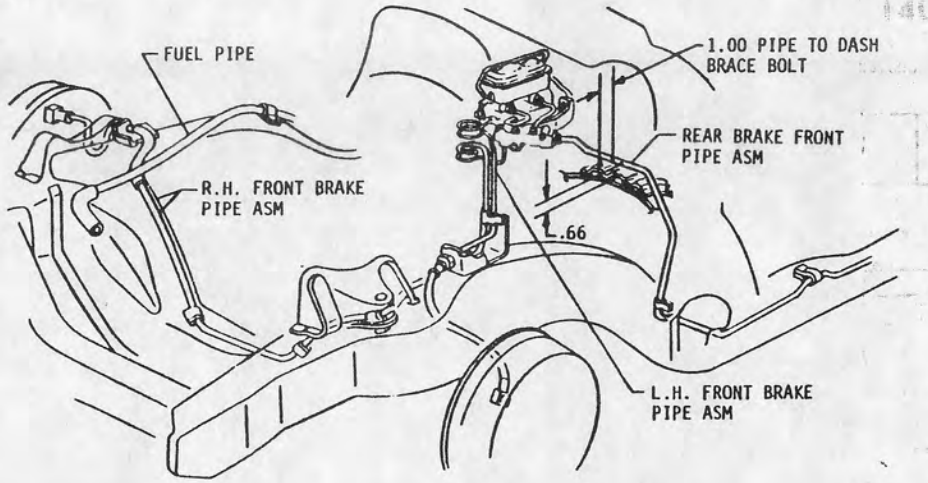
L-11714-S
L-13714-S
L-
L-

UPC 5F

SHEET 5

Ch X B O P X Ca





NOTE All dimensions shown are minimum checking dimensions as installed.

DYNAMIC (Instal) N·m	HAND (Insp.) · N·m
1	
2	
3	
4	
5	
⚠ FULLY DRIVEN, SEATED & NOT STRIPPED	

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
		174				

DATE 1/JA80
DR R.G FIELDING/EJM
CK
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE BRAKE PIPE CLEARANCE DIMENSIONS
·FA00 ALL

REF ECR 86448
C/O 10DE79
5F-5

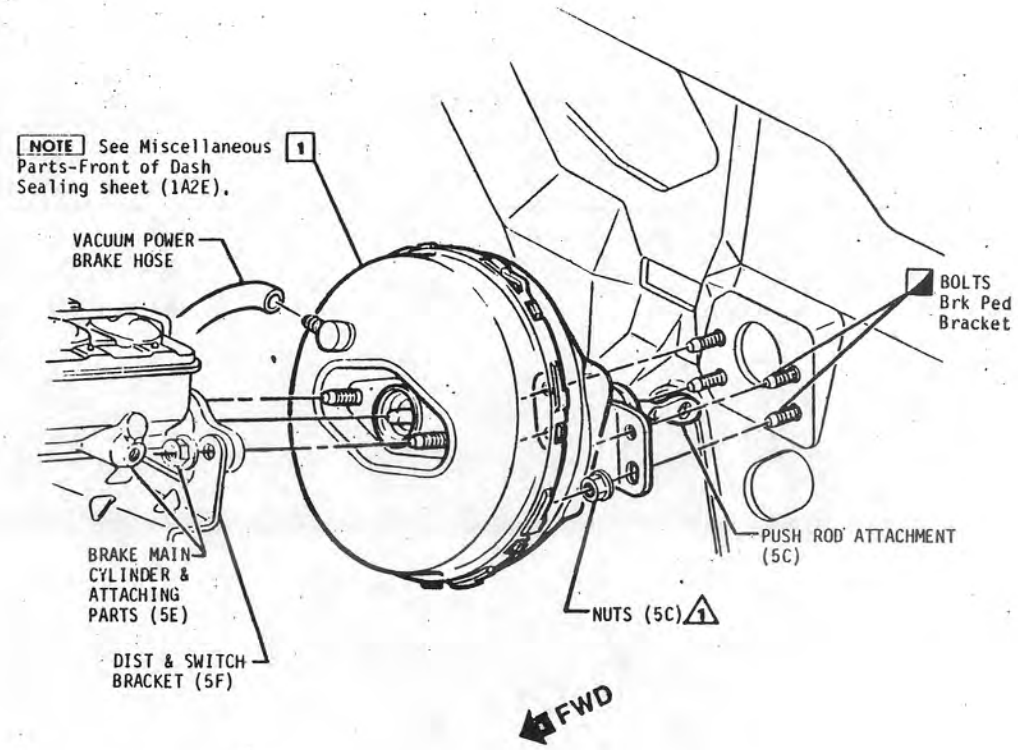
L- 91235-S
L- 92854-S
L-
L-

UPC 5F

SHEET 6

Ch X B O P X Ca

	18007257	1	BOOSTER ASM
(2) (1)	18006557	1	&JE1



DYNAMIC (Install) N·m	HAND (Insp.) · N·m
20 - 34	20 - 34

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
23AU80	1	18006322 BOOSTER REMOVED	91222	EJM	MB	
07NO80	2	18006557 & JE1 ADDED	92563	CMP	E7	

DATE 11 JAN 80
DR R G FIELDING/EJM
CK
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE VACUUM POWER BRAKE BOOSTER ASM FA00 ALL

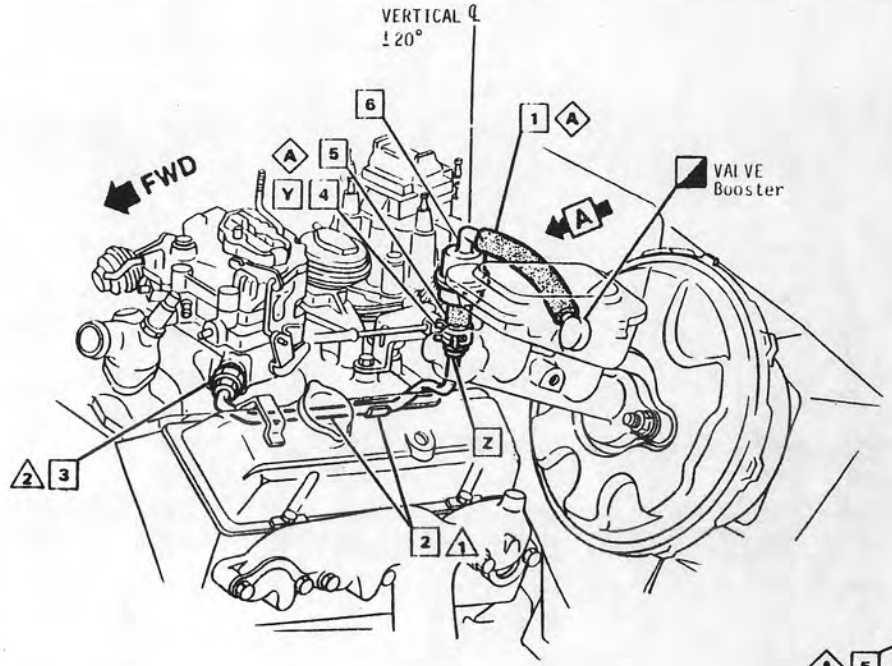
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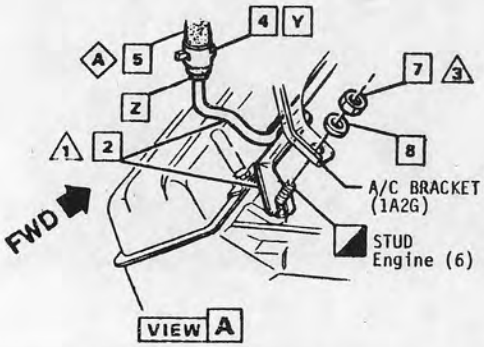
L- 08183 S
L- 91235 S
L- 18842 S

UPC 5G

SHEET 1

Ch X B O P X Ca





9437601	1	HOSE
14004844	2	PIPE ASM
145476	3	FITTING
3829058	4	CLAMP
9437903	5	HOSE
(5) 17070814	6	FILTER ASM
120377	7	NUT exc C60
3825452	8	WASHER exc C60
(1) 9985406	A	LUB-RUBBER Approx. 0.004L per hose (both ends). (6)

Y See UPC "0" General Information Hose Clamping Instructions.

Z Install hose to bead stop on pipe.

DYNAMIC (Install) N·m	HAND (Insp.) · N·m
(2) 1	8 - 11
(3) 2	11 - 14
(4) 3	26 - 40
4	
5	

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASB CHG
18AM81	1	WAS 9985234 LUB	88456	EJM		
USSE80	2	TORQUE 8-11 WAS 8.5-11.3				
	3	TORQUE 11-14 WAS 11.3-14.1				
	4	TORQUE 26-40 WAS 27-40	86045			
	5	WAS 17056236 FILTER ASM	91558			
	6	QUANTITY WAS .0038L 178	90937	EJM	RC	

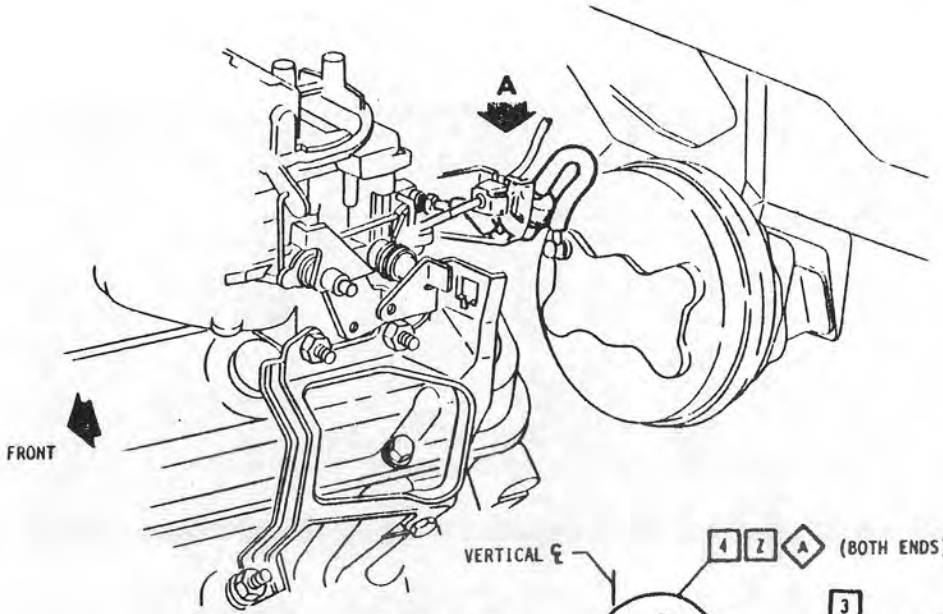
DATE	11-18-80
DR	R G FIELDING EJM
CK	
APPR	
APPR	
APPR	
APPR	

DIV CHEVROLET

1981 CHEV. "F" 14020867

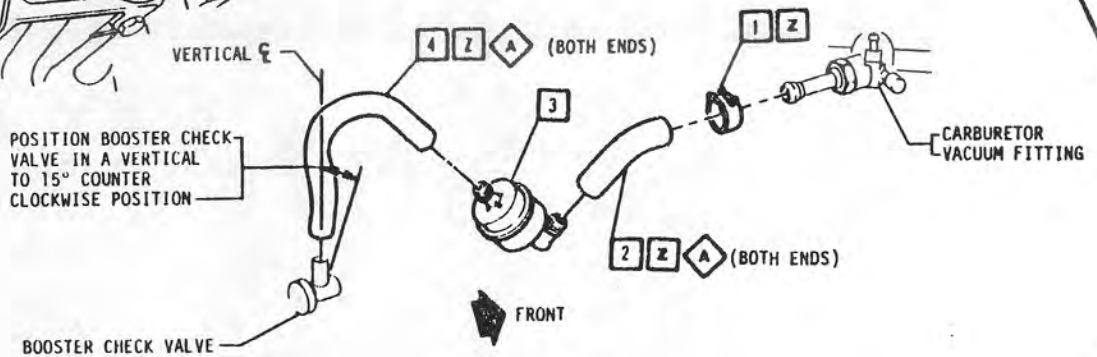
TITLE: VACUUM POWER BRAKE HOSES, PIPE & FILTER FA00 &LC3

REF			UPC	SHEET
ECR 86448 C/O 10DE79 5G-2	L-22344 L- L- L-		5G	2



3829058	1	CLAMP
10014406	2	HOSE
(2) 17070814	3	FILTER
9437601	4	HOSE
(1) 9985406	A	LUBRICANT

CANCELED



Z SEE FASTENER GENERAL INSTRUCTIONS FOR PROPER INSTALLATION (GROUP 0A)

VIEW A

DYNAMIC (Instal) N.m	HAND (Insp.) N.m	DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
	1 8-11	11JA80		ISSUED	86448	RF	GL	
	2	28MAR80	1	WAS 9985234 LUB	86456	RF	GL	
	3	25JUL80	2	WAS 17056236 FILTER	91558	CD	HK	
	4	23AUG80	3	SHEET CANCELED	91222	EJM	WB	
	5							

1 FULLY DRIVEN SEATED & NOT STRIPPED

DATE 14 NOV 79
DR P. D. Salmon
CK JEB
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

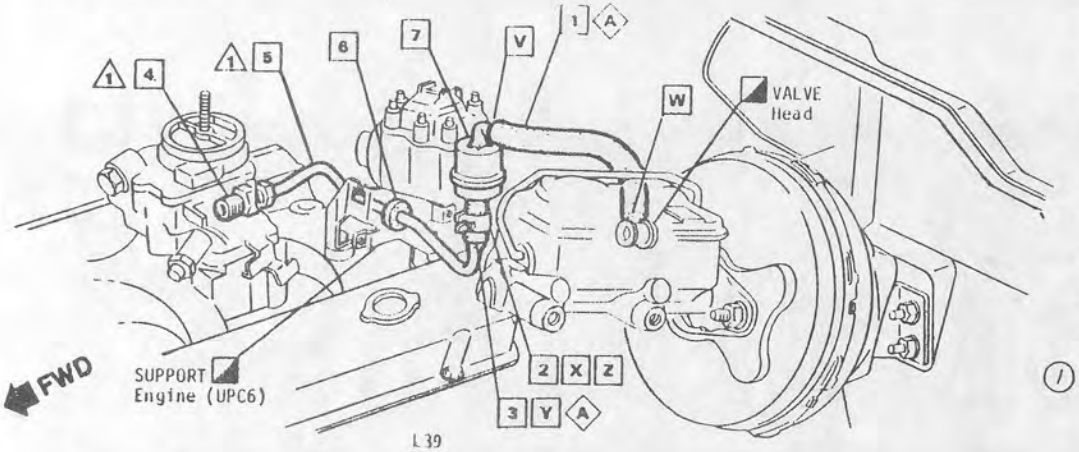
TITLE VACUUM POWER BRAKE HOSE FA0G & LU8

REF ECR 86448 C/O 10DE79 5G-3

UPC 5G

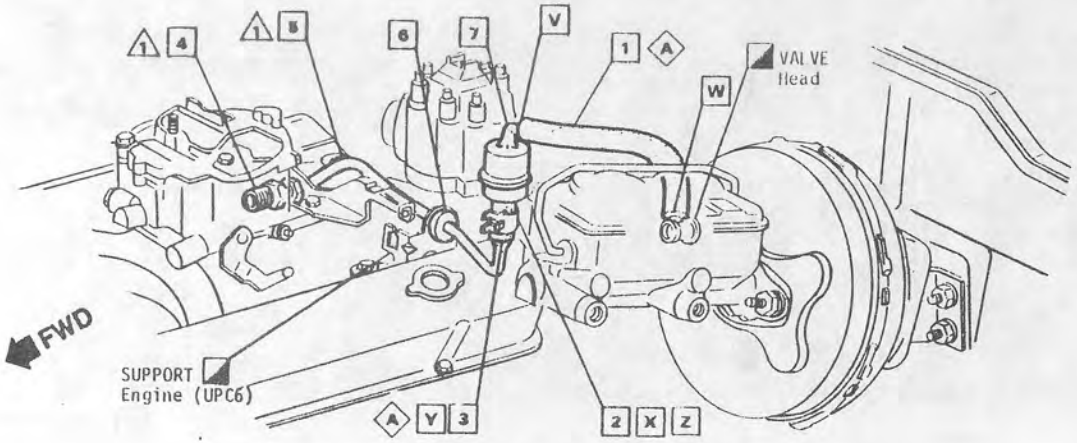
SHEET 3

A B Q P Co



L39

9437911	1	HOSE	
3829058	2	CLAMP	
9437898	3	HOSE	
273899	4	FITTING &L39	
145476	4	&LG4 or LM1	
14004857	5	TUBE ASM	
468263	6	GROMMET	
17056236	7	FILTER ASM	
(/) 9985406	A	LUB - RUBBER Approx. .004 L per hose (both ends).	



LG4 or LM1

V See Hose Installation instructions UPC 0A, Method K.

W See Hose Installation instructions. UPC 0A, Method H.

X Install Clamp 2 so that the tangs of the Clamp are pointing away from the engine oil filler cap.

Y See Hose Clamping instructions UPC 0A, Method E.

Z See Hose Installation instructions UPC 0A, Method L.

DYNAMIC (Install) N·m	HAND (Insp.) - N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM Chk
1	11 - 14	17APR80	1	WAS 9985234 LUB	88456	FJM		
2								
3								
4								
5								

1 FULLY DRIVEN, SEATED & NOT STRIPPED

178

DATE 11-A-80
DR AG FIELDING/FJM
CK
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE VAC POWER BRAKE HOSES, PIPE & FILTER FA00 & LG4/LM1/L39

REF ECR 86448 C/O 10DE79 5G-4

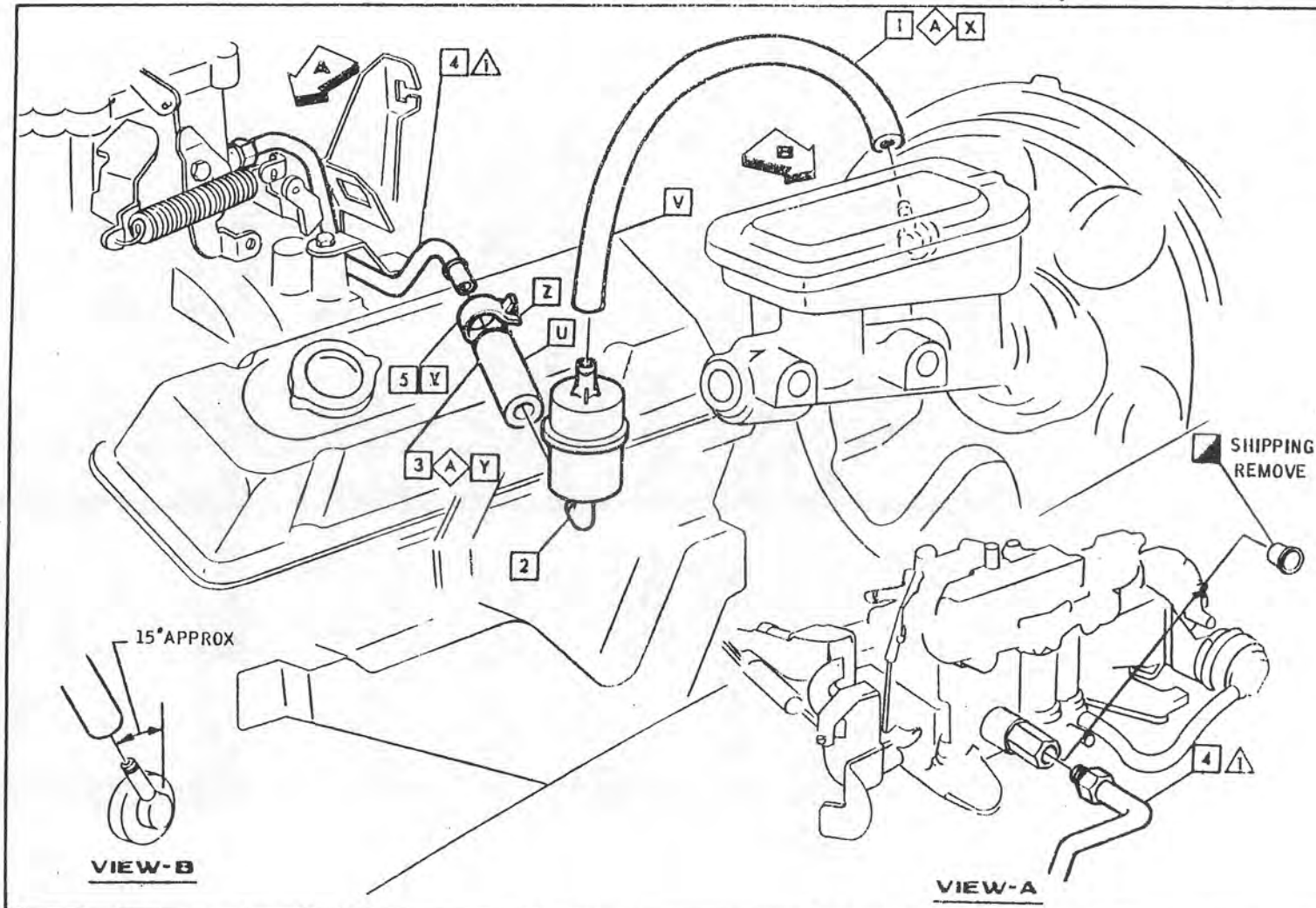
L- 18920 S
L-
L-
L-

UPC 5G

SHEET 4

Ch X B O P X Co

□ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF



9437601	1	HOSE
17056236	2	FILTER
9437898	3	HOSE
1264488	4	TUBE ASM
3829058	5	CLAMP

9985406 Ⓐ LUBRICANT(MAY BE USED TO ASSIST ASM OF TUBE)

U SEE HOSE INSTALLATION INSTRUCTIONS UPC 0A, METHOD K.

V SEE HOSE INSTALLATION INSTRUCTIONS UPC 0A, METHOD L.

W

X SEE HOSE INSTALLATION INSTRUCTIONS UPC 0A, METHOD H.

Y SEE HOSE INSTALLATION INSTRUCTIONS UPC 0A, METHOD D.

Z LOCATE CLAMP TANGS HORIZONTALLY.

DYNAMIC (Instal) N.m	HAND (Insp.) N.m	DATE	SYM	REVISION	AUTH	DR	CK	ASM CHK
	11-16	11APR80		ISSUED	86448	RF	[illegible]	

1 2 3 4 5

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE 08NOV79
DR BRIERLEY
CK K. Shier
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE VACUUM POWER BRAKE HOSE F&00 &LD5

REF ECR 86448
NEW 28MR80

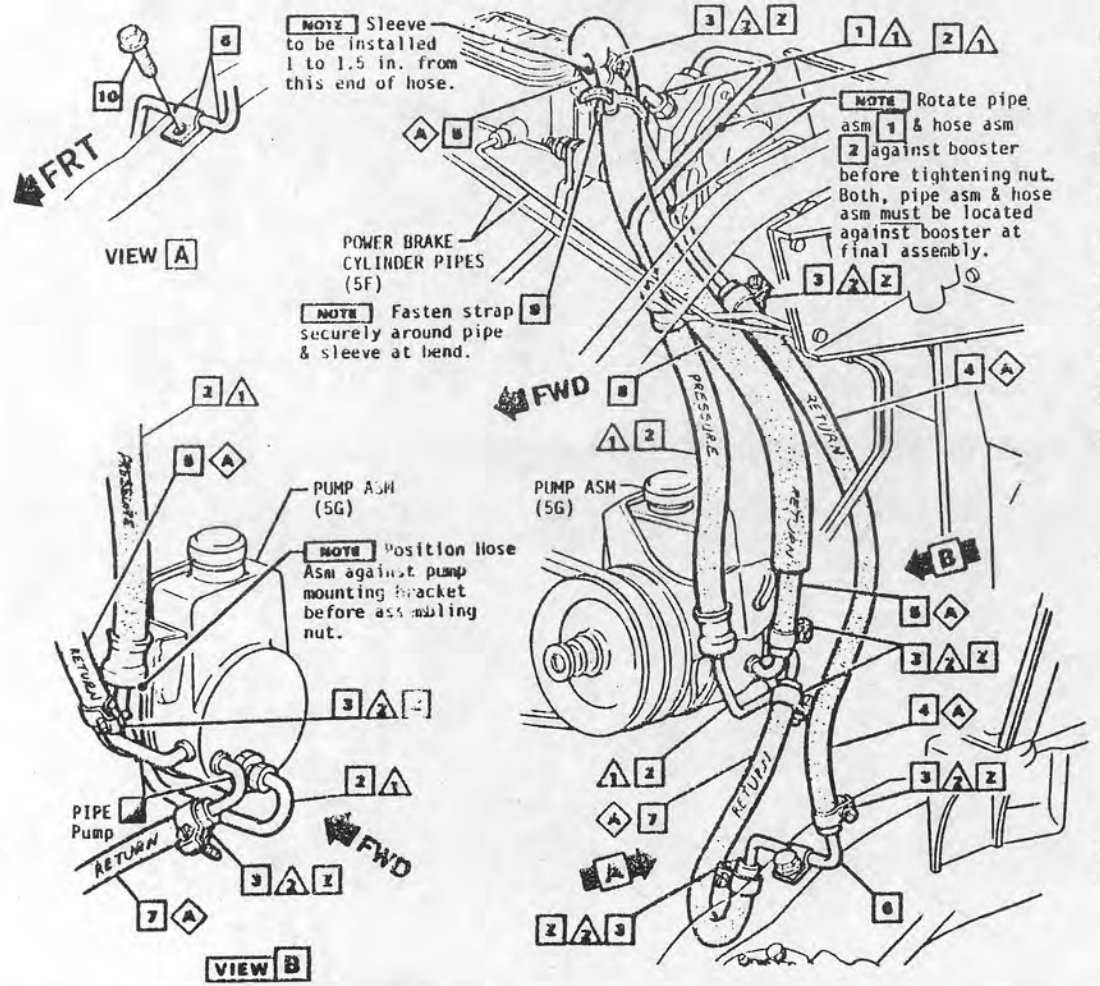
UPC 5G

SHEET 5

Ch B O P Co

PRODUCT DESCRIPTION MANUAL

□ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF



14010113	1	PIPE ASM- BOOS OUTLET RR	(1)
7833384	2	HOSE ASM- BOOS INLET	(1)
9420534	3	CLAMP ASM	
9424894	3	OPT	
7808887	4	HOSE-BOOS OUTLET	(1)
1483566	5	HOSE-BOOS OUTLET	(1)
367736	6	PIPE ASM-BOOS OUTLET FRT	
6271673	7	HOSE-BOOS OUTLET	(1)
367743	8	SLEEVE	
4778650	9	STRAP	
3958062	10	BOLT/SCREW	
9985406	A	LUB-RUBBER Approx. .004 L per hose (all ends).	(2)

CANCELED

Z See UPG "0A" General Information-Hose Clamping Instructions.

△ FULLY DRIVEN, SEATED & NOT STRIPPED

DYNAMIC (Install) N·m	HAND (Insp.) · N·m
△1	26-40
△2	1.4-2.0
△3	14-20
△4	
△5	

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
31APR80	1	PART NAME REVISED - 5 PLACES	86447	WJS	RC	
14AUG80	2	QUANTITY WAS .001 GAL. (both ends)	90937	WJS	MB	
7MAY81	3	SHEET CANCELED	91382	GMP	[illegible]	

130

DATE 16APR80
DR W.J. SMITH/GMP
CK [signature]
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "P" 14020864

TITLE HYDRA-BOOSTER PIPES & HOSES P300 (42) &LT9 &JB8 or JF9 exc N40

REF ECR 86447 C/O 27MR80 5G-11

L-18929 S
L-20723 S
L-
L-

UPC **5G**

SHEET **11**

CA [X] B [ ] D [ ] F [ ] Ca [ ]

TORQUE SPECIFICATIONS

All brake hydraulic system inverted flare type connections have a specified torque range of 20-27 N·m. It is permissible to torque fittings to a maximum of 27 N·m to repair system leaks. Fittings torqued above this limit shall require replacement of the mating components involved.

CLEARANCE INSTRUCTIONS

Brake lines and hoses must not be kinked, flattened, or bent out of designed position. In particular, unless covered by drawing specifications, lines must have at least 19.04mm clearance to any moving component (i.e. steering shaft, shift levers, etc.) and 12.7mm clearance to any vibrating part (i.e., underbody, power brake booster, etc.) unless it is specifically clipped to these components. There must be no evidence of hose twist.

DYNAMIC (Install) N·m	HAND (Insp.) · N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
1								
2								
3								
4								
5								
⚠ FULLY DRIVEN, SEATED & NOT STRIPPED				131				

DATE 11JA80
DR R.G FIELDING/EDM
CK Jim Haycath
APPR S J
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE BRAKE SYSTEM TORQUE & CLEARANCE INSTRUCTIONS FA00 ALL

REF ECR 86448 C/O 10DE79 5Z-1

UPC 5Z

SHEET 1

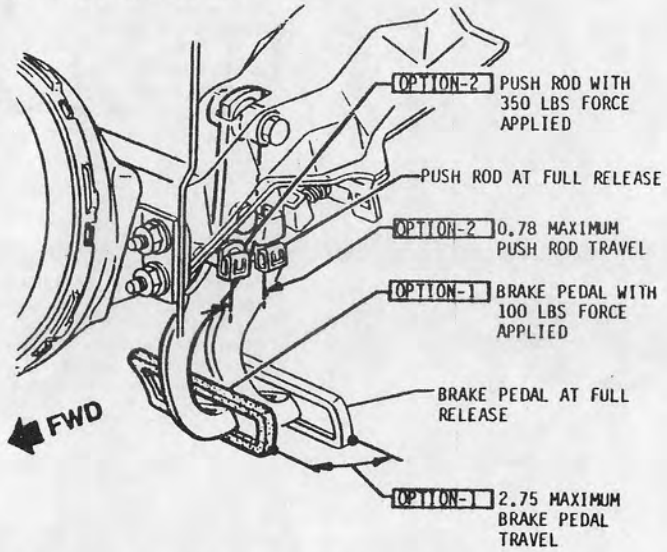
Ch X B | O | P X Ca

BRAKE SYSTEM BLEED CHECK

OPTION-1 Brake Pedal Travel must not exceed 2.75 when a 100 LB force, is applied to the Brake Pedal Pad.

OPTION-2 Push Rod Travel must not exceed 0.78 when a 350 LB force, is applied to the Push Rod.

NOTE Engine must be off and all vacuum exhausted from the booster on Power Brake vehicles before checks.



INDIVIDUAL WHEEL BRAKING EFFORT TEST-COMPLY WITH GM QUALITY/RELIABILITY STANDARD 1QS-5-102

All cars to be checked on this equipment with a maximum deceleration of 15 ft/sec^2 from a maximum speed of 10 M.P.H. (recommended speed of 4 M.P.H.) mak a permanent single punch record to show that the vehicle has passed the test.

NOTE This is a hard stop which would be considerably short of wheel slide on dry pavement, harder stops or fast apply rates may give indications of problems which do not really exist.

DYNAMIC (Install) N·m	HAND (Insp.) N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM CAG
1								
2								
3								
4								
5								
⚠ FULLY DRIVEN, SEATED & NOT STRIPPED				132				

DATE 11 APR 80
DR R.G. HILDAG/EUM
CK Tom Hayes JA
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE BRAKE SYSTEM BLEED CHECK
FA00 ALL

REF ECR 86448
NEW 10DE79

UPC 5Z

SHEET 2

Ch X B O P X Co

			DIV RESP
6-1	CONTENTS		D
6-1.1	CONTENTS		D

6 ENGINE

6-2	ENGINE ASM & V.I.N. LOCATION	....LC3/L39/LG4/LM1	C
6-3	ENGINE IDENT NO. LOCATION	....LD5	B
(3) 6-4	CANCELED		

6A ENGINE ASSEMBLY

(4) 6A-1	CANCELED		

6B ENGINE LABELS

(SHOWN IN UPC "0")

6C CRANKSHAFT, BALANCER, AND FLYWHEEL

6C-1	TORSIONAL DAMPER BOLT	....LC3/L39/LG4/LM1	C

6G ENGINE LUBRICATION

6G-1	OIL FILLER	....LC3/L39/LG4/LM1	C
6G-2	OIL LEVEL INDICATOR	....LD5	B
6G-3	OIL LEVEL INDICATOR	....LC3	C
6G-4	OIL LEVEL INDICATOR	....L39/LG4/LM1	C
6G-5	ENG OIL FILL	....ALL	P

6H ENGINE VENTILATION

6H-1	CRANKCASE VENTILATION	....L39/LG4/LM1	C
6H-2	CRANKCASE VENTILATION	....LC3	C
6H-3	CRANKCASE VENTILATION	....LD5	B
6H-4	OPEN		

6K ENGINE COOLING

			DIV RESP
(2) 6K-1	FAN, BELT, PULLEY & BELT	....LC3 or L39 & C41; & LG4 & GM8 & C41	C
6K-2	FAN, BELT, PULLEY & CLUTCH	..LC3/L39/LG4/LM1 & K81	C
6K-3	FAN & CLUTCH	....LD5	B
(5) 6K-4	CANCELED		
6K-5	PULLEY & BELTS	....LD5	B
(6) 6K-6	CANCELED		
6K-7	CRANKSHAFT PULLEY	....L39/LC3/LG4/LM1	C
6K-8	RAD HOSES & ANTI-FREEZE	....LC3	C
6K-9	RAD HOSES	....LD5	B
6K-10	RAD HOSES & ANTI-FREEZE	....L39/LG4/LM1	C
(7) 6K-11	CANCELED		
6K-12	COOLING SYSTEM FILL	....LD5	B

ENGINE DESCRIPTION

LC3 - V6, 3.8 LITER, 229 C.I.D.	C
LD5 - V6, 3.8 LITER, 231 C.I.D.	B
L39 - V8, 4.3 LITER, 267 C.I.D.	C
(8)	
LG4 - V8, 5.0 LITER, 305 C.I.D.	C
LM1 - V8, 5.7 LITER, 350 C.I.D.	C

NOTE FOR ENGINE ASSEMBLY INSTRUCTION
SEE + V6 ENGINE
+ V8 ENGINE

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
05JN80	1	RESPAWN & REDESIGNED	86448	CU	[illegible]	
27JN80	2	SHT 6K-1 OPTS REV	89761	CU	[illegible]	
07NOR0	3	SHT 6-4 ENG IDENT NO LOCATION CANC				
	4	SHT 6A1 CYL BLK DRAIN PLUG CANC				
	5	SHT 6K-4 FAN PUL & CLU CANC				
	6	SHT 6K-6 CSHAFT PUL CANC				
	7	SHT 6K-11 RAD HOSES CANC 133				
	8	"LU8" REMOVED	91222	CU	EF	

DATE 18JA80 APPR
DR R. TAYLOR APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
CONTENTS-ENGINE
FA00 ALL (6 Thru 6K)

REF ECR 86448
NEW 06N079

UPC 6

SHEET 1

C X B O P Ca

6L ENGINE HEAT CONTROL AND MANIFOLDS

				DIV RESP
6L-1		VACUUM FITTINGS	....LG4 or LM1 & M38	C
6L-2		VACUUM FITTINGS	....L39 & M38	C
6L-3		VACUUM FITTINGS	....LC3 (2)	C
6L-4		VACUUM FITTINGS ....LC3 & M15; & LG4 & M20; & LM1 & M21		C
6L-5	★	VACUUM FITTINGS	....LD5	B
(3) 6L-6		OPEN		
6L-7		INLET MANIFOLD PLUG	....LC3	C
6L-8		E.F.E. VALVE & PIPE	....L39/LG4/LM1	C
6L-9		E.F.E. VALVE & PIPE	....LC3	C
6L-10		E.F.E. VALVE & PIPE	....LD5	B
6L-11		E.F.E. VALVE SWITCH ASM	....LC3	C
6L-12		SOLENOID -EGR CONT VALVE RELAY ....LG4 or LM1 & M38/M33/MX3 (exc NM5)		C
6L-13		SOLENOID-EGR CONT VALVE RELAY ....LG4 or LM1 & M24 (exc NM5)		C
6L-14		SOLENOID-EGR CONT VALVE RELAY	....L39 (exc NM5)	C
6L-15		EGR VACUUM HARN ASM	....LC3 &M31 &NB1 (1) (2)	C
6L-16		EGR VACUUM HARN ASM	....LC3 &M64 &NB1 (1)	C

★ Instructions Carryover
● Waiting Info.

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
053580	1	OPT NB1 ADDED (2) PLACES	89795	CU	RC	
030CB0	2	"MV9" REM (2) PLACES	91615	CU	RT	
270CB0	3	SHT 6L-6 VACUUM FITTING REM	91222	CU	RB	

DATE 05JN80
DR R TAYLOR
CK
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE CONTENTS-ENGINE
FA00 ALL (6L)

REF ECR 86448
NEW 22MY80

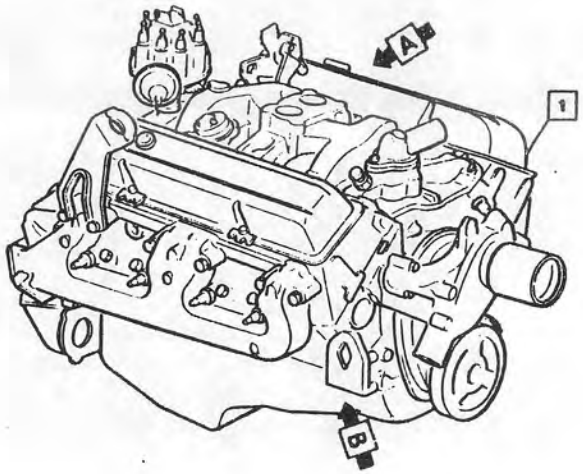
UPC 6

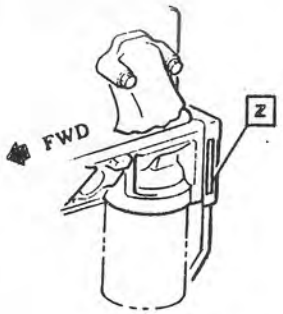
SHEET 1.1

C X B O P Ca

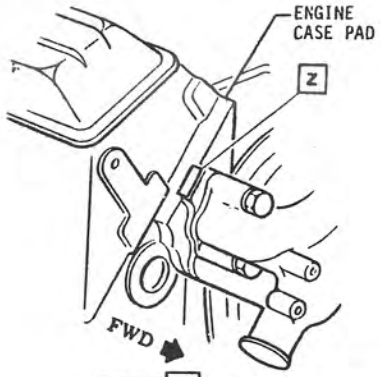
(1)	14031065	[1]	ENGINE ASM (AS SHIPPED) & L39 (SHOWN) For specific releasing & additional part numbers, see Parts List.
(2)	14023166	[1]	& LC3 &M64
(3)	14023167	[1]	& LC3 &M3i

[Z] V.I.N. locations (See 14F for V.I.N. specs).





VIEW A OPTIONAL V8



VIEW B & LC3/LG4/L39/LM1

DYNAMIC (Instal) N·m	HAND (Insp.) · N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
		030CB0	1	14031065 WAS 14017804	90150			
			2	14023166 WAS14017815 & OPT REV	86195			
			3	14623167 WAS14021833 & OPT REV	91615	CU	RCT	

△ FULLY DRIVEN, SEATED & HOT STRIPPED

135

DATE	1JA80
DR	J. PARK
CK	
APPR	(S)
APPR	
APPR	
APPR	

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE ENGINE ASM & V.I.N. LOCATION FA00 & ALL V8 ENG or LC3

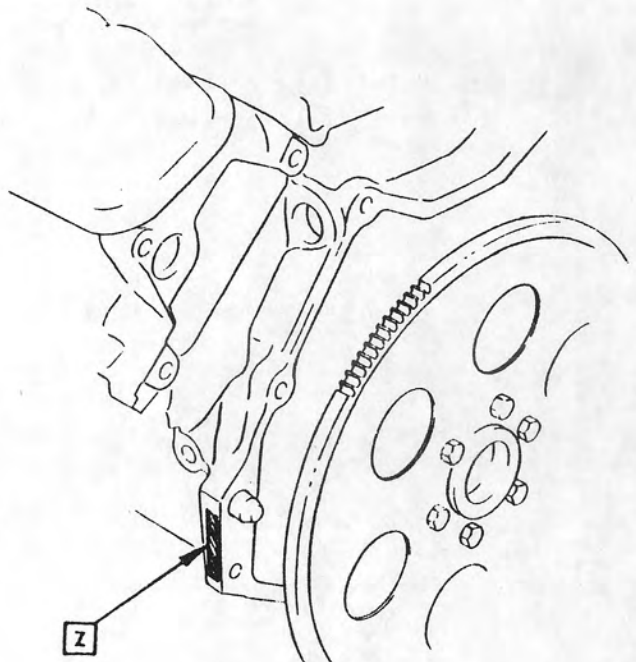
REF ECR 86447 C/O 14JA79 6-2

L-99927 (S) L-01024 (S) L-01619 (S)

UPC 6

SHEET 2

Ch | 8 | 0 | P | Ca



Z LOCATION TO BE STAMPED WITH VEHICLE IDENTIFICATION NUMBER. SEE UPC 142 FOR NUMBER STAMPING PROCEDURE.

DYNAMIC (Install) N.m	HAND (Insp.) - N.m
1	
2	
3	
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION
MAR 80		ISSUED

AUTH	DR	CK	ASM ENG
86446	JP	RL	

DATE
DR B. RAYMOND
CK
APPR S
APPR S
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

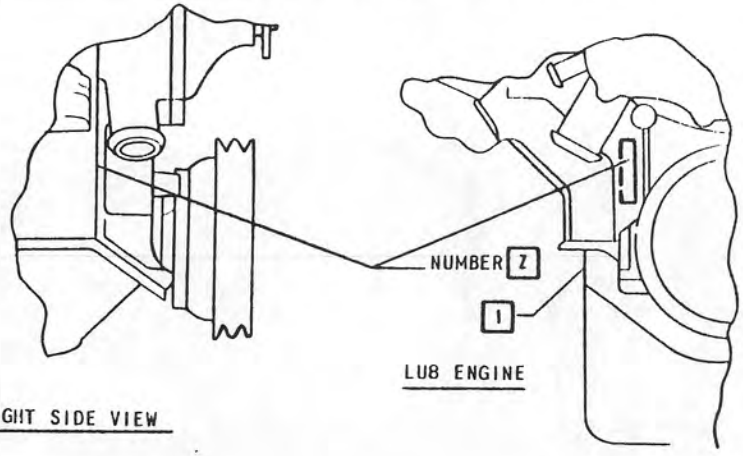
TITLE
ENGINE ASM V.I.N. LOCATION
FA00 & LD5

REF ECR 86448
C/O 03AP80
6-3 JP

UPC 6

SHEET 3

136



RIGHT SIDE VIEW

LU8 ENGINE

FRONT VIEW

[1] CHART - ENGINE USAGE

CANCELED

[2] SEE SHEET 14Z FOR NUMBER STAMPING PROCEDURE

DYNAMIC (Install) N.m	HAND (Insp.) - N.m
⚠1	
⚠2	
⚠3	
⚠4	
⚠5	

⚠ FULLY DRIVEN SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
17JA80		ISSUED	86448	CU	AS	
17NOV80	1	SHEET CANCELED	7222	CU	EA	

137

DATE	18 OC 79
DR	LC/EDB
CK	FHA
APPR	S
APPR	
APPR	
APPR	

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE ENGINE V.I.N. LOCATION FA00 & LU8

REF ECR 86448 C/O 14DE79 6-2 JP

UPC 6

SHEET 4

Ck B O P Co

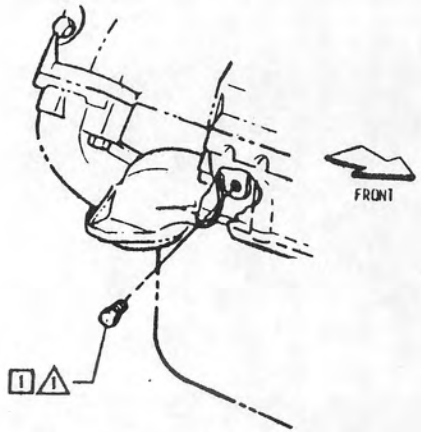
PONTIAC MOTOR DIVISION

General Motors Corporation Pontiac. Michigan

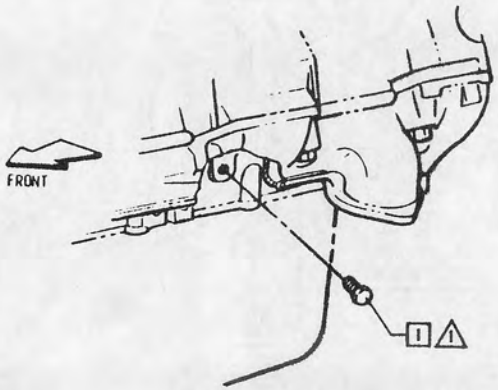
PRODUCT DESCRIPTION MANUAL

☐ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF

444613 [1] PLUG



R.H. SIDE OF ENGINE



L.H. SIDE OF ENGINE

CANCELED

DYNAMIC (Install) N.m	HAND (Insp.) - N.m
1 20-34	
2	
3	
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM Chg
12/19/80		ISSUED	86448	CLI	AB	
07/08/80	1	SHEET CANCELED	91222	CLI	EJ	

DATE	17 OC 79
DR	GMV/EDB
CK	RRG
APPR	S
APPR	
APPR	
APPR	

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE ENGINE BLOCK DRAIN PLUG FA00 & LU8

REF ECR 86448 C/O 14DE79 6A-1 JP

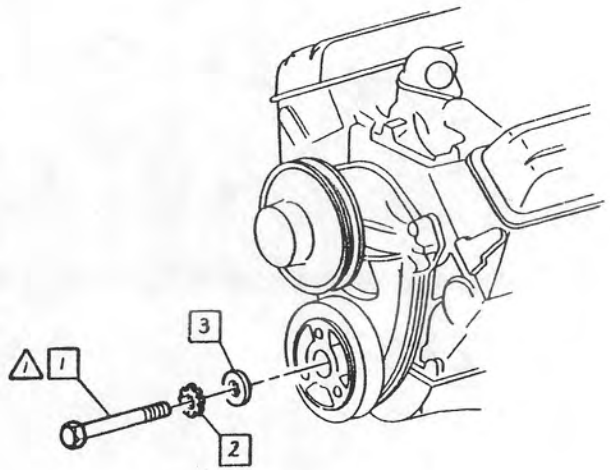
UPC 6A

SHEET 1

Ch B O P Co

133

9428643	1	BOLT/SCREW
138494	2	WASHER
3739422	3	WASHER



DYNAMIC (Install) N·m	HAND (Insp) N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
	△1 80-110							
	△2							
	△3							
	△4							
	△5							
△1 FULLY DRIVEN, SEATED & NOT STRIPPED				139				

DATE 17 JA 80
DR J. PARK
CK [signature]
APPR (S)
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
TORSIONAL DAMPER BOLT
FA00 & ALL V8 ENG & LC3

REF ECP 86448
C/O 14JA79
6C-1

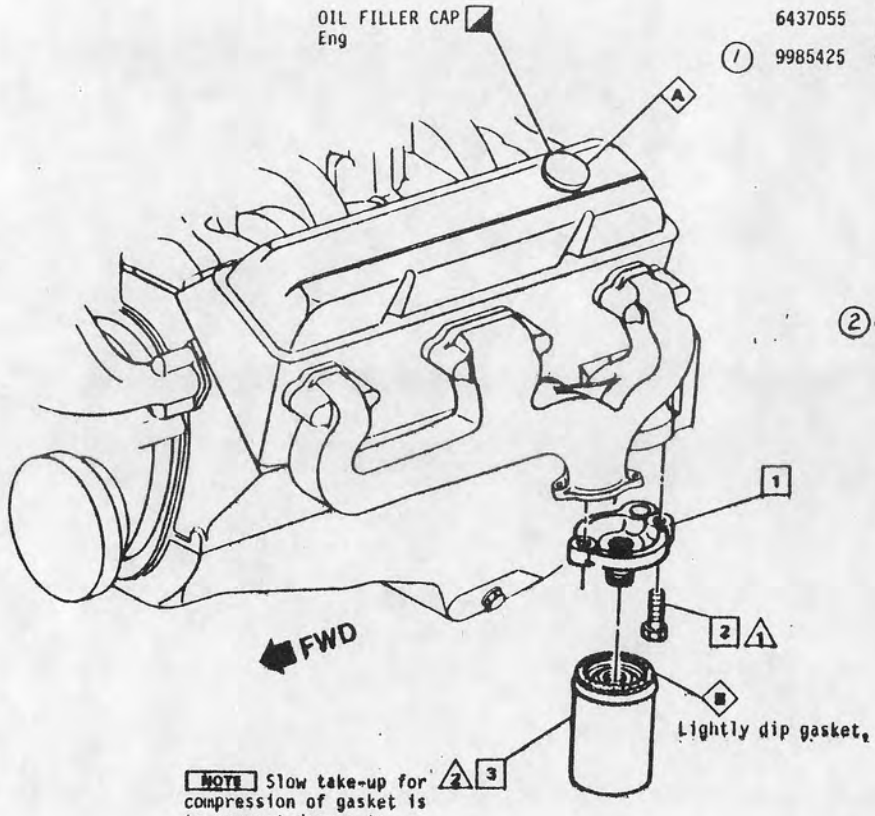
96436 (S)
98121 (S)

UPC 6C

SHEET 1

Ch X B O P X Co

3952301	1	ADAPTER ASM	
3951644	2	BOLT/SCREW	
6437055	3	FILTER ASM	
(1) 9985425	◇A	OIL-ENG If engine oil level is not above "ADD" mark on oil level gage, add 0.95 Liters. The readings are based upon "as shipped" vehicle condition so the assembly plant will have to allow for factors that affect dipstick readings taken in process.	
(2)	◇B	0.004 L	



NOTE Slow take-up for compression of gasket is to prevent damage to gasket.

DYNAMIC (Instal) N·m	HAND (Insp.) - N·m
1	19-30
2	26-34
3	
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
05JN80	1	WAS 9985183 OIL				
	2	QTY. 0.004 L WAS 0.00378 LITERS	81350	CU		

100

DATE 01FEB0
DR S. BOROWICZ
CK Richard Clinton
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
OIL FILTER
FA00 & LC3/L39/LG4/LM1.

REF ECR 86448
C/O 17JA80
6G-1

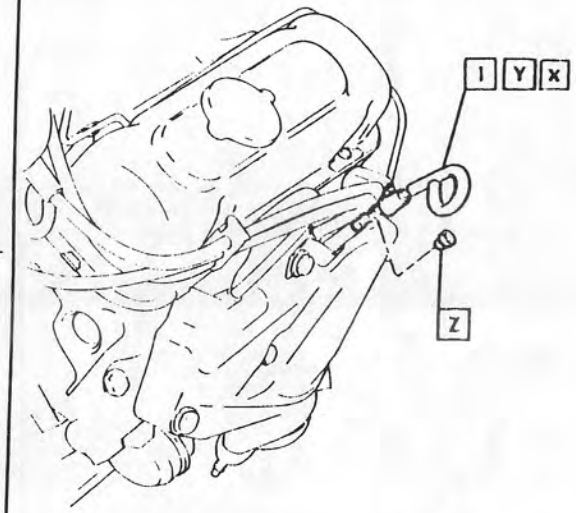
L-83821 (S)
L-
L-
L-

UPC 6G

SHEET 1

CK | X | B | | O | | P | X | Co |

(1) 25508906 [1] INDICATOR ASM - OIL LEVEL



[X] OIL LEVEL TO BE FROM FULL TO 1/4" BELOW FULL MARK ON [1], AFTER ENGINE IS RUN.

[Y] INSERT INDICATOR ASM WITH LETTERING TOWARD THE ENGINE.

[Z] REMOVE SHIPPING PLUG & DISCARD

DYNAMIC (Install) N.m	HAND (Insp) N.m
1	
2	
3	
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
7/1/80		ISSUED	[illegible]	[illegible]	[illegible]	
12/JA/79	1	ADD RECOGNITION INDICATOR	[illegible]	[illegible]	[illegible]	B

DATE 12/JA/79
DR M. MITCHELL
CK
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
OIL LEVEL INDICATOR
FA00 &LD5

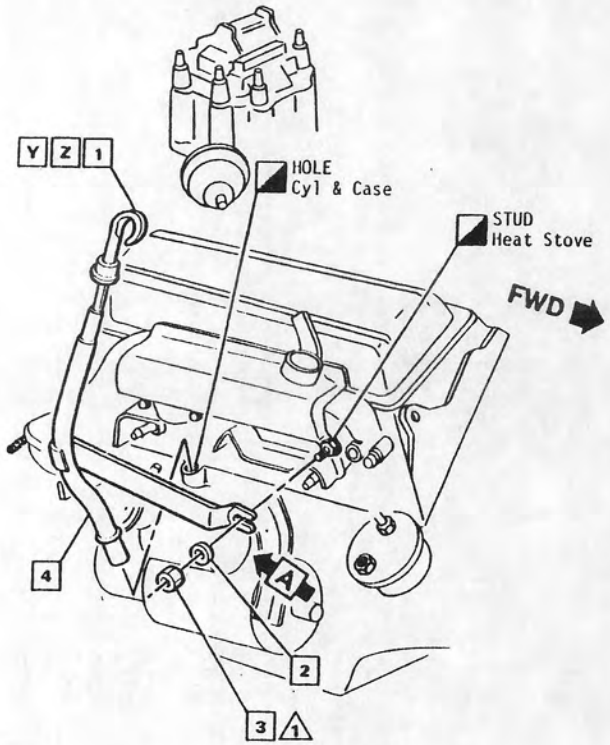
REF ECR 86448
C/O 17JA80
6G-1 SB

UPC 6G

SHEET 2

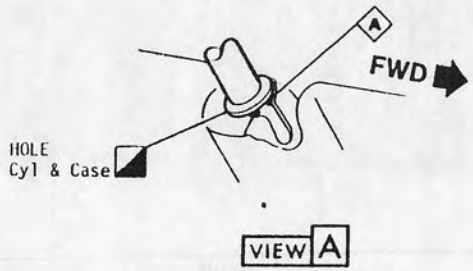
Ch X B X O X P X Ca

14026137	1	INDICATOR ASM-OIL LEVEL
3825452	2	WASHER
120377	3	NUT
14017708	4	TUBE ASM
9985345	A	SEALER .00076 Liters



Y Oil level to be from full to 1/4" below full mark on 1, after engine is run.

Z Handle loop must face forward.



VIEW A

DYNAMIC (Instal) N·m	HAND (Insp.) - N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
1	2.2 - 3.4							
2								
3								
4								
5				192				

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE OIFE50
DR S. BOROWICZ
CK Richard Lim Rc
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
OIL LEVEL INDICATOR
FA00 & LC3

REF ECR 86448
C/O 17JA80
6G-3

I- 16075 (S)
I-
I-
I-

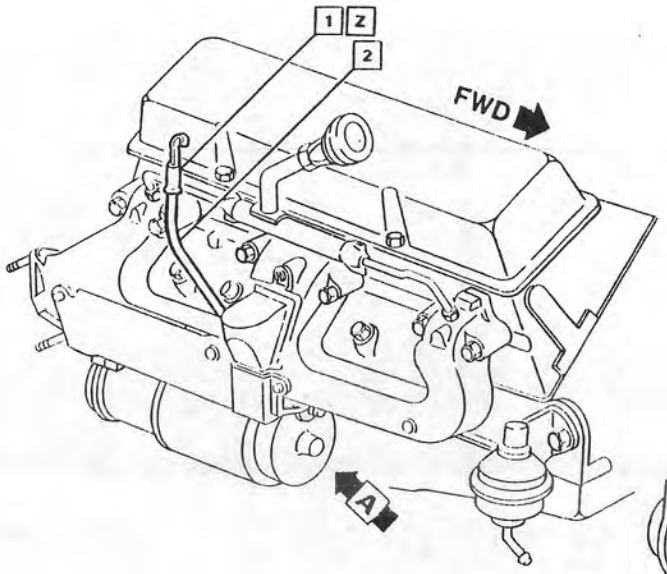
UPC 6G

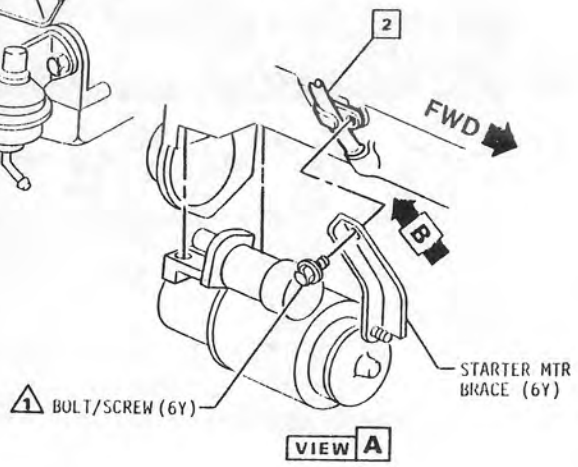
SHEET 3

A | B | D | P | Co

14026164	1	INDICATOR ASM
14010290	2	TUBE ASM
9985345	A	SEALER-.000076 Liters

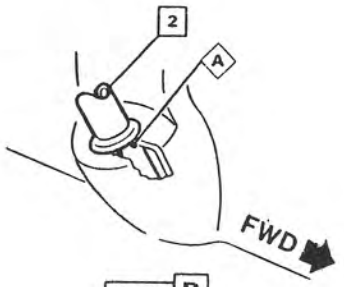
Z OIL LEVEL TO BE FROM FULL TO 1/4" BELOW FULL MARK ON 1, AFTER ENGINE IS RUN.





VIEW A

WAITING LAYOUT APPROVAL



VIEW B

DYNAMIC (Install) N·m	HAND (Insp.) N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
	1 20-27							
	2							
	3							
	4							
	5							
1 FULLY DRIVEN, SEATED & NOT STRIPPED				133				

DATE DEC 8 1 | DR S. BOROVICZ | CK Jim Haigh | APPR NS | APPR | APPR | APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE OIL LEVEL INDICATOR FA00 & L39/LG4/LM1

REF ECR 86448 C/O 17JA80 6G-4

L- 20471 (NS) L- L-

UPC 6G

SHEET 4

C | B | O | P | Ca

PONTIAC MOTOR DIVISION

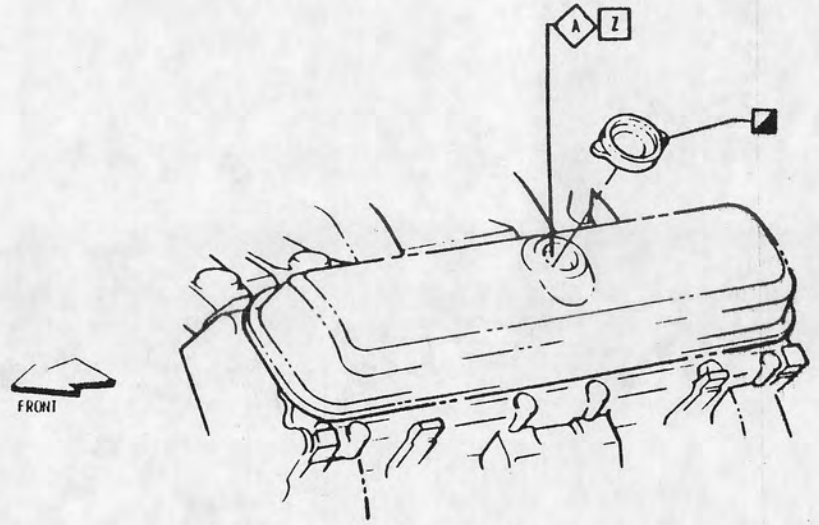
General Motors Corporation Pontiac, Michigan

PRODUCT DESCRIPTION MANUAL

☐ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF

(1) 9985425 (A) OIL

(2)



Z AS REQUIRED TO BRING OIL LEVEL ON DIP STICK TO FULL MARK (ALL ENGINES) PONTIAC ENGINE SHOWN

DYNAMIC (Install) N.m	MANO (Insp.) - N.m
1	
2	
3	
4	
5	

1 FULLY DRIVEN SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
12NOV80		ISSUED	86448	CU	AS	
05JNB0	1	WAS 9935183 OIL	89350	CU	RH	
07NOV80	2	"LUB" VIEW REMOVED	91222	CU	EG	

194

DATE 17 OC 79
DR GMV/EDB
CK CAR
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE ENGINE OIL-(TOP OFF) FA00 ALL

REF ECR 86448 C/O 14DE79 6G-6 SB

UPC 6G

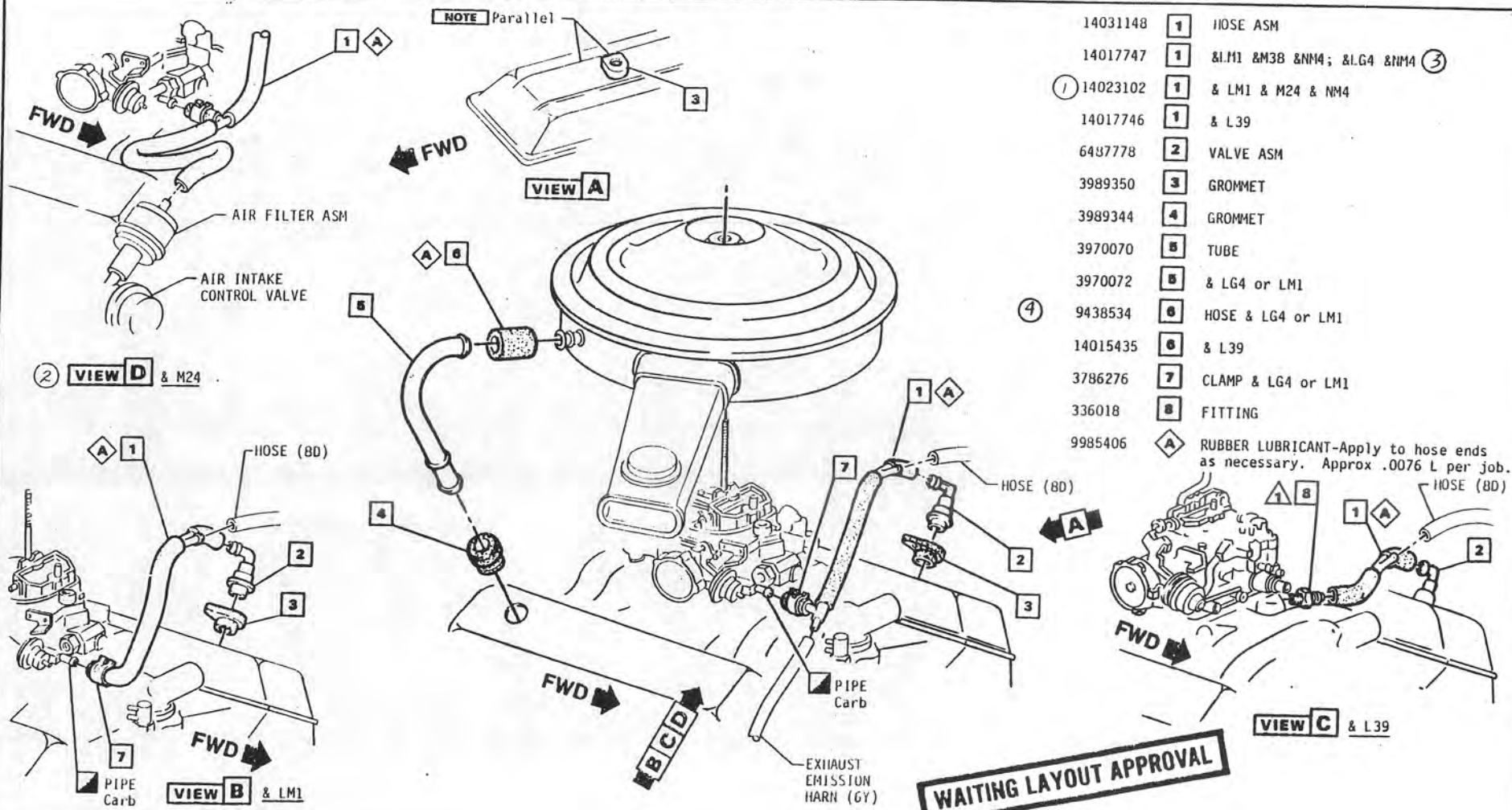
SHEET 5

Ch B O P Co

EAE 10 1283 12-78 4M4

PRODUCT DESCRIPTION MANUAL

☐ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF



14031148	1	HOSE ASM	
14017747	1	&LM1 &M38 &NM4; &LG4 &NM4	(3)
(1) 14023102	1	& LM1 & M24 & NM4	
14017746	1	& L39	
6487778	2	VALVE ASM	
3989350	3	GROMMET	
3989344	4	GROMMET	
3970070	5	TUBE	
3970072	5	& LG4 or LM1	
(4) 9438534	6	HOSE & LG4 or LM1	
14015435	6	& L39	
3786276	7	CLAMP & LG4 or LM1	
336018	8	FITTING	
9985406	A	RUBBER LUBRICANT-Apply to hose ends as necessary. Approx .0076 L per job.	

DYNAMIC (Install) N·m	HAND (Insp.) N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG	
		11APR80	1	14023102 HOSE ADDED					DATE 07FEB80
			2	VIEW "D" ADDED	57994	CU	RC	C	DR R TAYLOR
		10OCT80	3	OPTS REVISED	92328				CK Richard Clark
			4	9438534 WAS 14020614	90775	CU	AS		APPR NS
									APPR
									APPR
									APPR

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

Ch X B O P X Co

DIV CHEVROLET

REF ECR 86448 NEW 29JA80

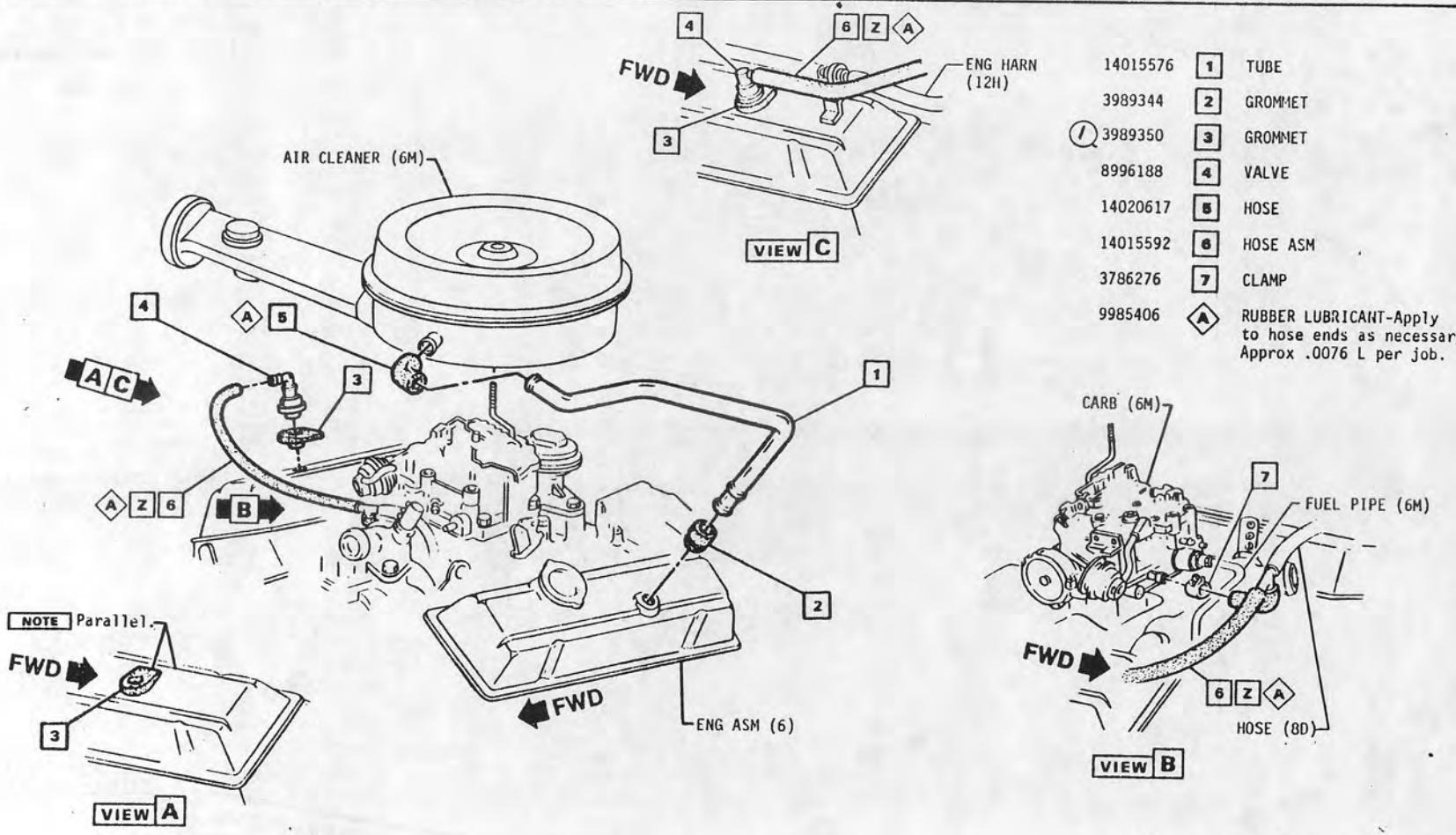
1981 CHEV. "F" 14020867

TITLE
CRANKCASE VENTILATION
FA00 & LG4/LM1/L39

L-(NS)

UPC 6H

SHEET 1



14015576	1	TUBE
3989344	2	GROMMET
1 3989350	3	GROMMET
8996188	4	VALVE
14020617	5	HOSE
14015592	6	HOSE ASM
3786276	7	CLAMP
9985406	A	RUBBER LUBRICANT-Apply to hose ends as necessary. Approx .0076 L per job.

Z Route item 6 forward of engine electrical harness clips on the R.H. Rocker Cover.

DYNAMIC (Instal) N·m	HAND (Insp.) - N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
1 2 3 4 5		27JN80	1	WAS 3994239 GROMMET	89016	CU	RJ	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	14FE80
DR	R. TAYLOR
CK	Richard Claire RC
APPR	S
APPR	
APPR	
APPR	

DIV CHEVROLET

1981 CHEV. "F" 14020867

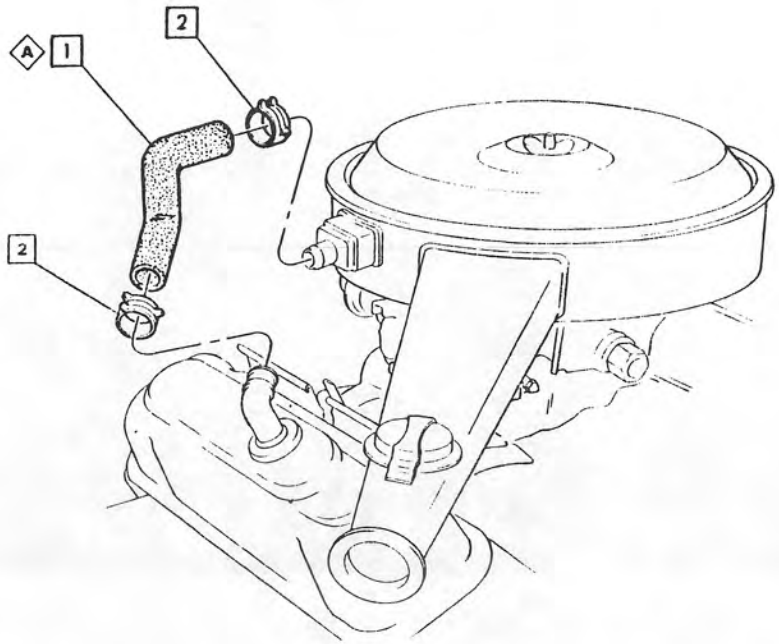
TITLE
CRANKCASE VENTILATION
FA00 & LC3

RF ECR 86448
C/O 25JA80
6H-2

UPC 6H

SHEET 2

Ch X 8 0 P Co



25505469	1	TUBE
1374023	2	CLAMP (2)
9985406	A	RUBBER LUBRICANT- Apply to hose ends as necessary. Approx .0076 L per job.

DYNAMIC (Install) N.m	HAND (Insp.) N.m	DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
		DEC 80		ISSUED	86448	CU	[illegible]	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

197

DATE	11DE79
DR	B. RAYMOND
CK	R. Ahrens
APPR	W. Stark
APPR	H. Ahrens
APPR	M. J. Stevens
APPR	

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
CRANKCASE VENTILATION
FA00 & LD5

REF ECR 86448
C/O 30JA80
6H-1 RT

UPC 6H

SHEET 3

BUICK FORM 7160

PONTIAC MOTOR DIVISION

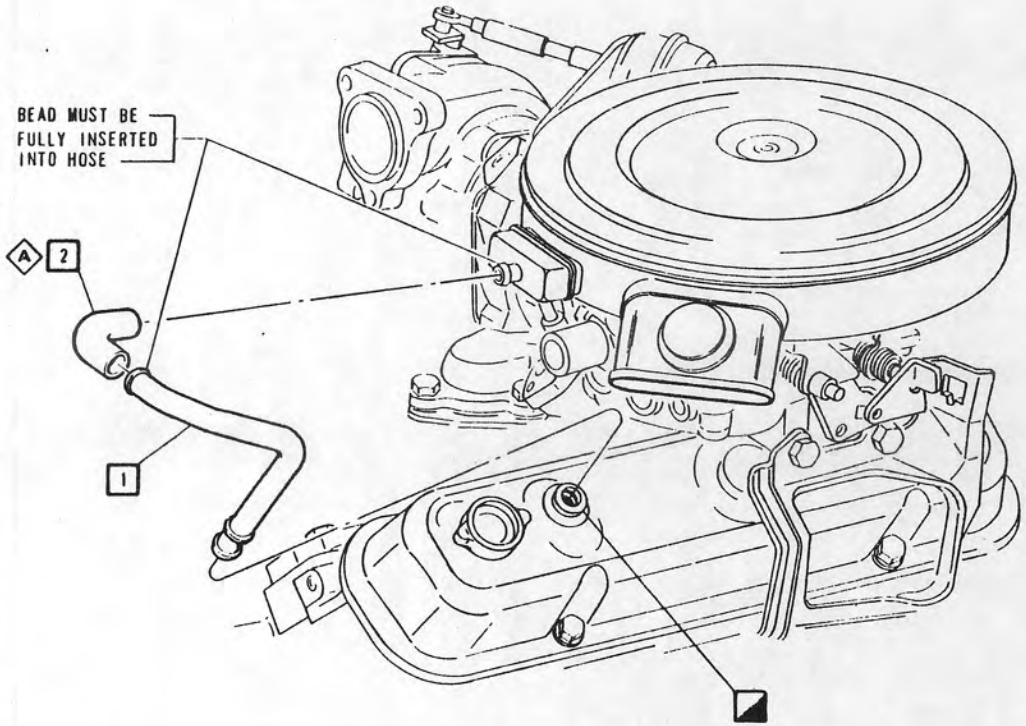
General Motors Corporation Pontiac, Michigan

PRODUCT DESCRIPTION MANUAL

□ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF

10012234	1	PIPE
10013730	2	HOSE

9985406	A	RUBBER LUBRICANT Apply to hose ends as necessary. Approx. .0076 L per job.



CANCELED

DYNAMIC (Install) N m	HAND (Insp.) N m	DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
		23MAR		ISSUED	86448	CH	AS	
		01NOV	1	SHEET CANCELED	01222	CH	CT	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE 19/JA/79
DR G. M. VERSTRAETE
CK JEB
APPR WHE
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE CRANKCASE VENTILATION FA00 & LU8

REF ECR 86448 C/O 05MY80 6H-3 RT

2 L-77338 L- L- L-

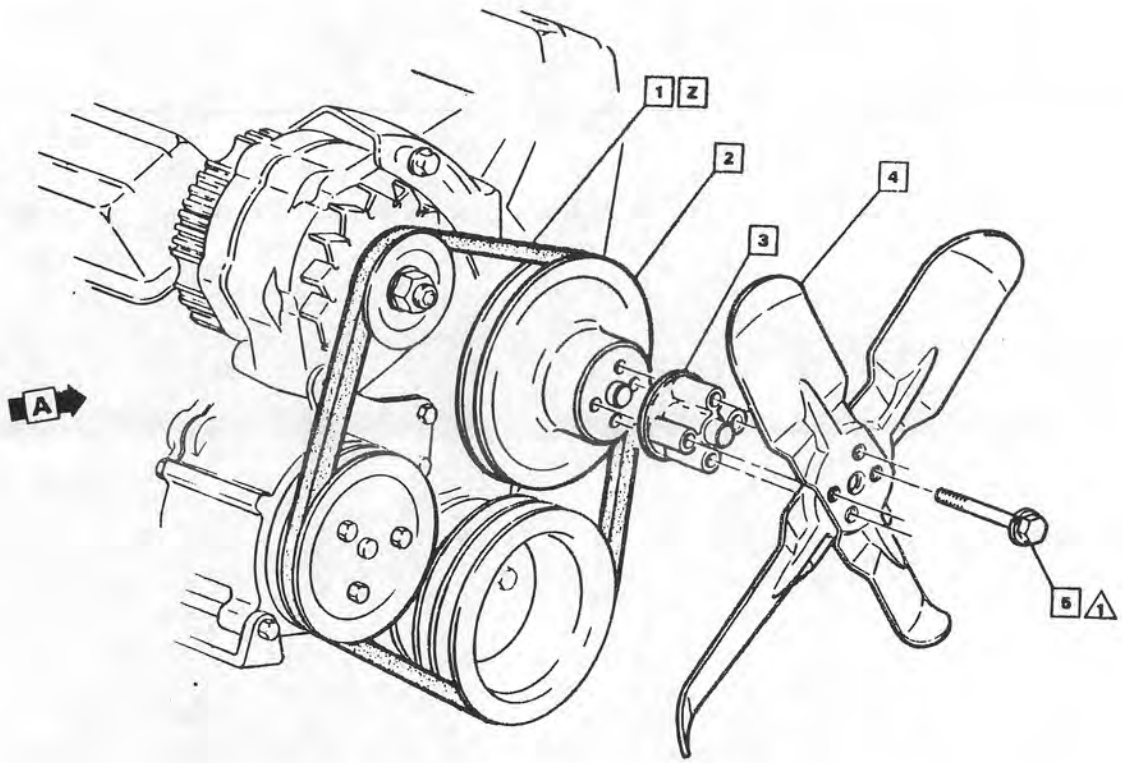
UPC 6H

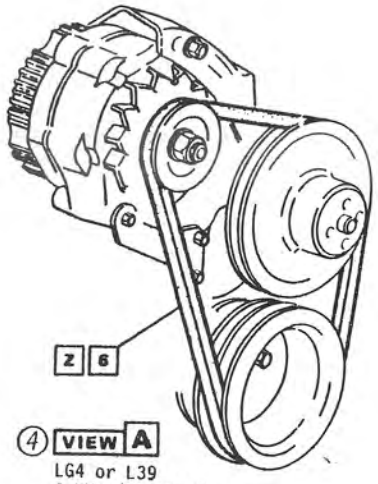
SHEET 4

CL X B O P X Co

4AE 18 1283 8-77 3313

	9433644	1	BELT & K19 (2)
(1)	14023154	2	PULLEY
	3947132	3	SPACER
	14001915	3	OPT
	342748	4	BLADE ASM
	9420515	5	BOLT/SCREW
(3)	9433639	6	BELT





(4) VIEW A
LG4 or L39
& NM4 (exc K73)

Z For belt tensioning see UPC 6Z.

DYNAMIC (Install) N·m	HAND (Insp.) N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
△1 20-27		21NOV80	1	WAS 330556 PULLEY	8589C			
△2			2	"& K19" ADDED				
△3			3	ITEM 6 ADDED				C
△4			4	VIEW "A" ADDED				C
△5			5	OPTS REV	89761	CU	RC	
△ FULLY DRIVEN, SEATED & NOT STRIPPED								

199

DATE 07FEB0
DR R. LINDNER
CK Jim Hyde TH
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE (5) FAN PULLEY & BELTS
FA00 & LC3 or L39 & C41;
& LG4 & GM8 & C41

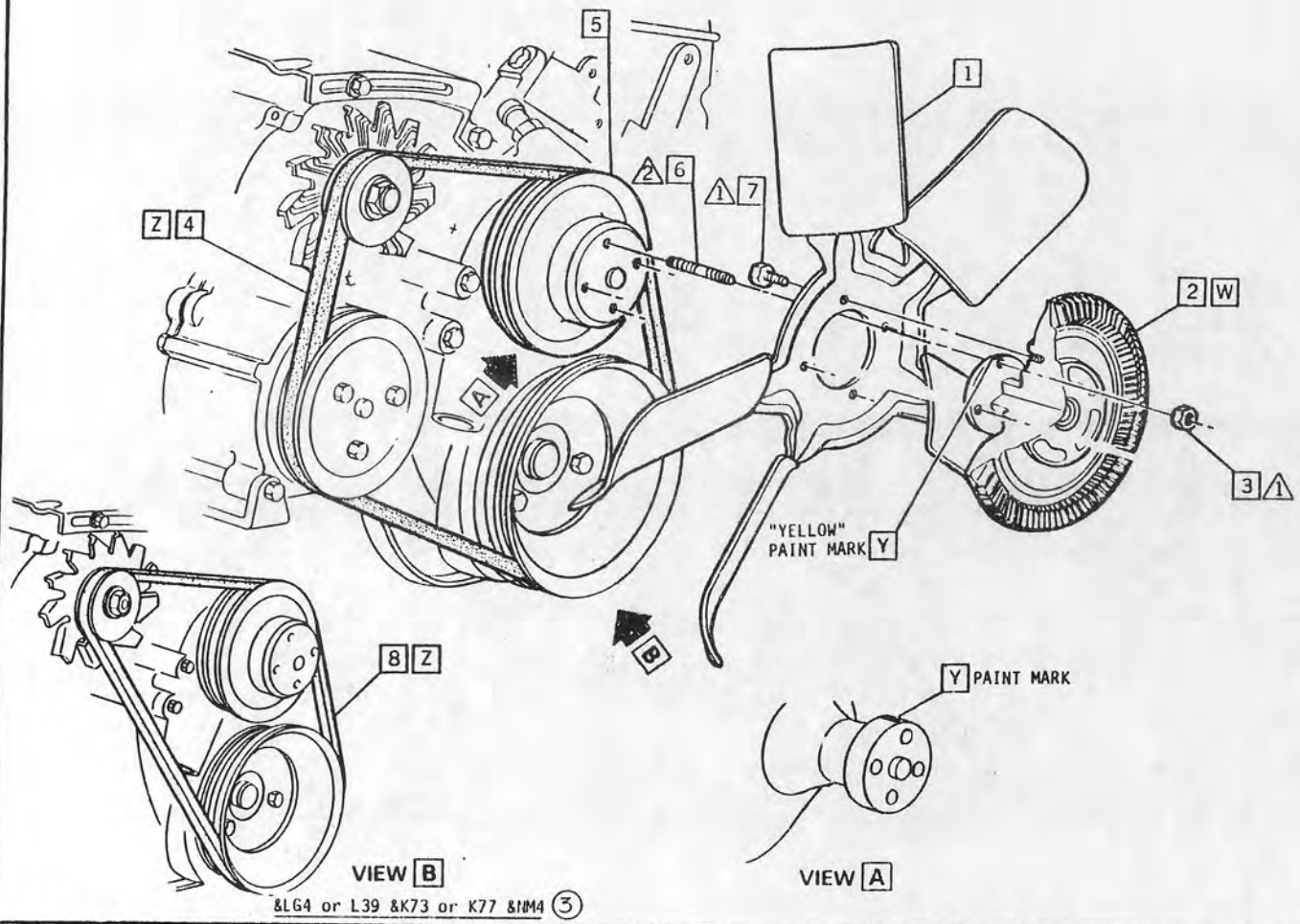
REF ECR 86448
C/O 16JA80
6K-1

l-04966 (S)
l-11532 (S)
l-
l-

UPC 6K

SHEET 1

Ck X I O P X Cu



14026143	1	BLADE ASM	
14026144	1	OPT	
(2) 14030071	1	&LM1 &C60	
343719	2	CLUTCH ASM (SHOWN)	X (5)
9417954	3	NUT	
9433646	4	BELT &C60 &K19 &K77	(3)
9433647	4	&K19 &K73	(3)
9433644	4	&C41 &K19	(3)
14023155	5	PULLEY &C60	
14023154	5	&C41	(3)
1364760	6	STUD	
9419683	7	BOLT/SCREW	
9433640	8	BELT	(4)

&LG4 or L39 &K73 or K77 &NM4 (3)

W Do not allow clutch asm 2 to rest on front face as loss of lubricant fluid may occur.

X For specific releasing & additional part numbers, see parts list.

Y The fan clutch "Yellow" paint mark is to be matched with paint mark on O.D. & backside of water pump hub at assembly.

Z For belt tensioning see UPC 6Z.

DYNAMIC (Install) N·m | HAND (Insp.) - N·m

1 20 - 27
2 5 - 11
3
4
5

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
27JAN80	1	REDRAWN / REDESIGNED 85896 87761	87761	CU	[illegible]	C
19SEP80	2	14030071 BLADE ADDED	911832			
	3	OPTS REV (5) PLOS				
	4	OPTS REM 85896	87761	CU	[illegible]	
20OCT80	5	NOTE "X" ADDED	85896	CU	[illegible]	C
		200				

DATE 07FEB80
DR R. LINDNER
CK [illegible]
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE FAN, CLUTCH & BELTS
FA00 & LC3/LG4/LM1/L39 & C60; & LM1; & LG4 & GU4 & C41

REF ECR 86448
C/O 16JA80
6K-2

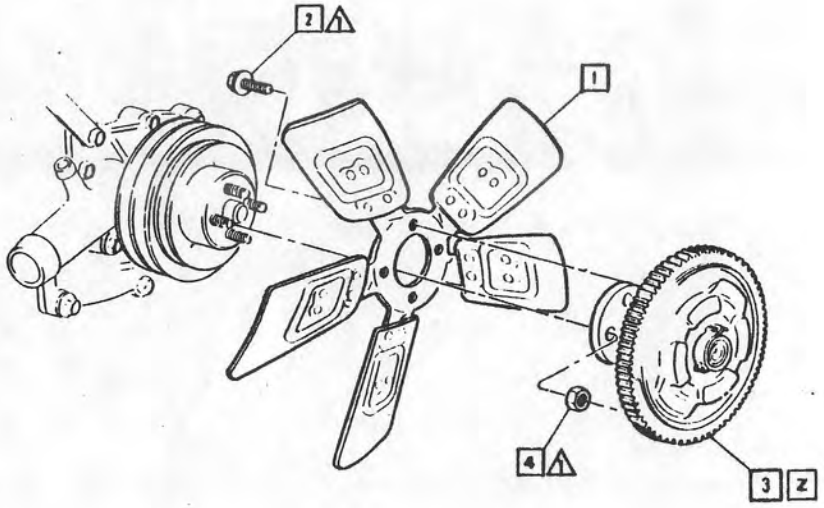
04966 (S)
11532 (S)

UPC 6K

SHEET 2

Ch X B O P X Ca

14026143	1	BLADE
14026144	1	OPT
9419683	2	BOLT
22008490	3	CLUTCH ASM (SHOWN) For specific releasing & additional part numbers, see Parts List.
9417954	4	NUT



Z Do not allow clutch asm 3 to rest on front face as loss of lubricant fluid may occur.

DYNAMIC (Install) N.m	HAND (Insp.) - N.m
⚠1 ⚠2 ⚠3 ⚠4 ⚠5	20-27

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
20JN80		ISSUED	86448	RL	HB	

201

DATE	23-FE-79
DR	RPB/GMV
CK	RRG
APPR	S
APPR	
APPR	
APPR	

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE FAN & FAN CLUTCH FA00 &LD5

REF ECR 86448 C/O 10JN80 6K-12 RL

GPC 6K

SHEET 3

Ch X 8 0 P Co

K&E 10 1263 8-77 3313

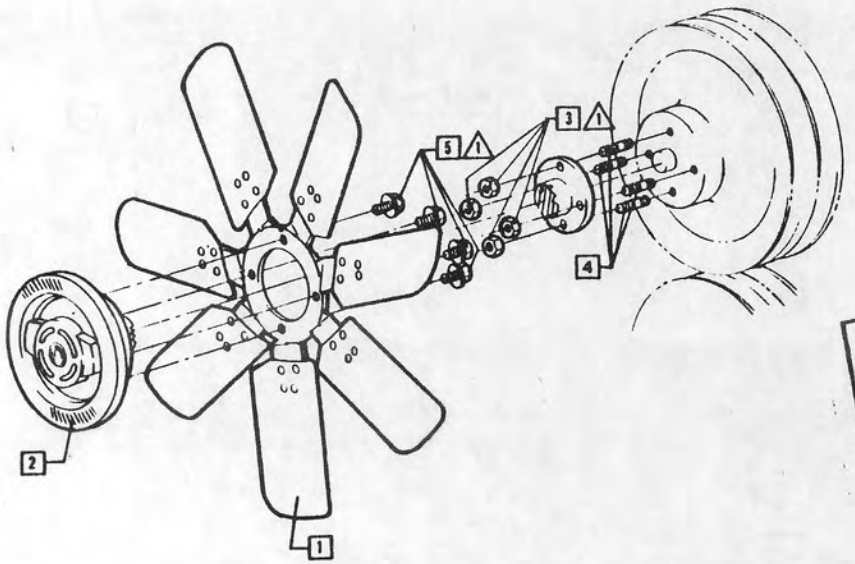
PONTIAC MOTOR DIVISION

General Motors Corporation Pontiac, Michigan

PRODUCT DESCRIPTION MANUAL

□ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF

14030071	1	BLADE ASM-FAN
22008502	2	CLUTCH ASM.
9417954	3	NUT
480168	4	STUD
+ 9419683	5	BOLT



CANCELED

FRONT

DYNAMIC (Install) N·m	HAND (Insp.) - N·m
△1 △2 △3 △4 △5	21-27
△1 FULLY DRIVEN, SEATED & NOT STRIPPED	

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
22FEB0		ISSUED	86448	CU	RC	
07NOV80	1	SHEET CANCELED	91222	CU	EJ	

202

DATE 17 OC 79
DR GMV/EDB
CK CAR 5
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE FAN & CLUTCH ASM FA00 & LU8

REF ECR 86448 NEW 09FE80

UPC 6K

SHEET 4

Ch B O P Co

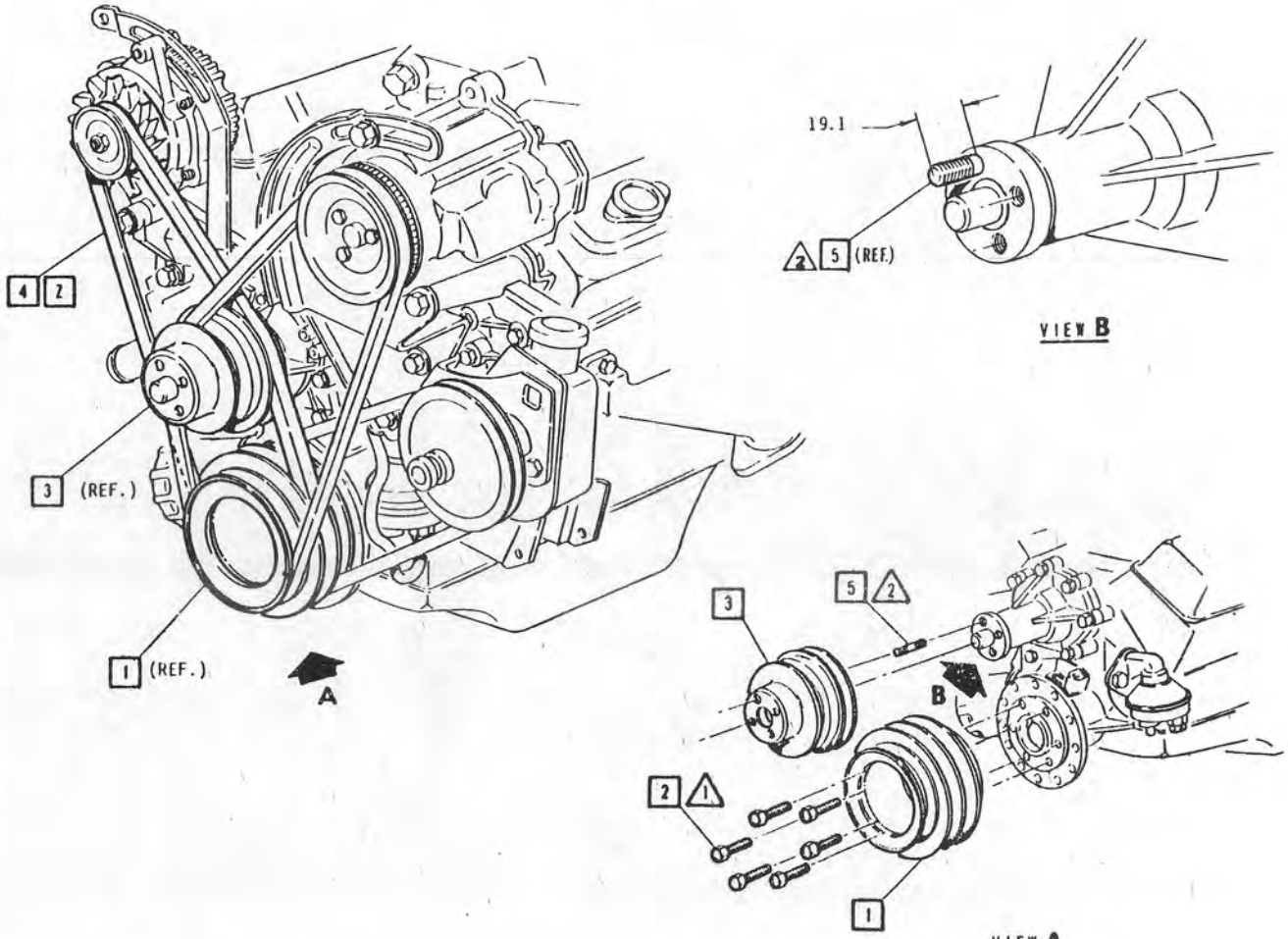
E-6E 10 1253 12-78 4044

PONTIAC MOTOR DIVISION

General Motors Corporation Pontiac, Michigan

PRODUCT DESCRIPTION MANUAL

☐ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF



546924	1	PULLEY ASM. (ZR)
9417950	2	BOLT
1249741	3	PULLEY ASM.
9433639 9433642	4	BELT (BR) W/C41 BELT (BV) W/C60
1364760	5	STUD

Z FOR BELT ROUTING SEE 'PULLEY & BELT DIAGRAM' - UPC 6Z.

DYNAMIC (Instal) N.m	HAND (Insp.) N.m
1	20 - 34
1	5 - 11
1	
4	
5	

1 FULLY DRIVEN SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
10JN80		ISSUED	86448	RL	WB	

203

DATE 05 MY 80
DR R.P. BIERI
CK RAB
APPR RAB
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE PULLEYS & BELTS
FA00 &LD5

REF ECR 86448
NEW 10JN80
6K-2.1 RL

UPC 6K

SHEET 5

Ch X B O P X Ca

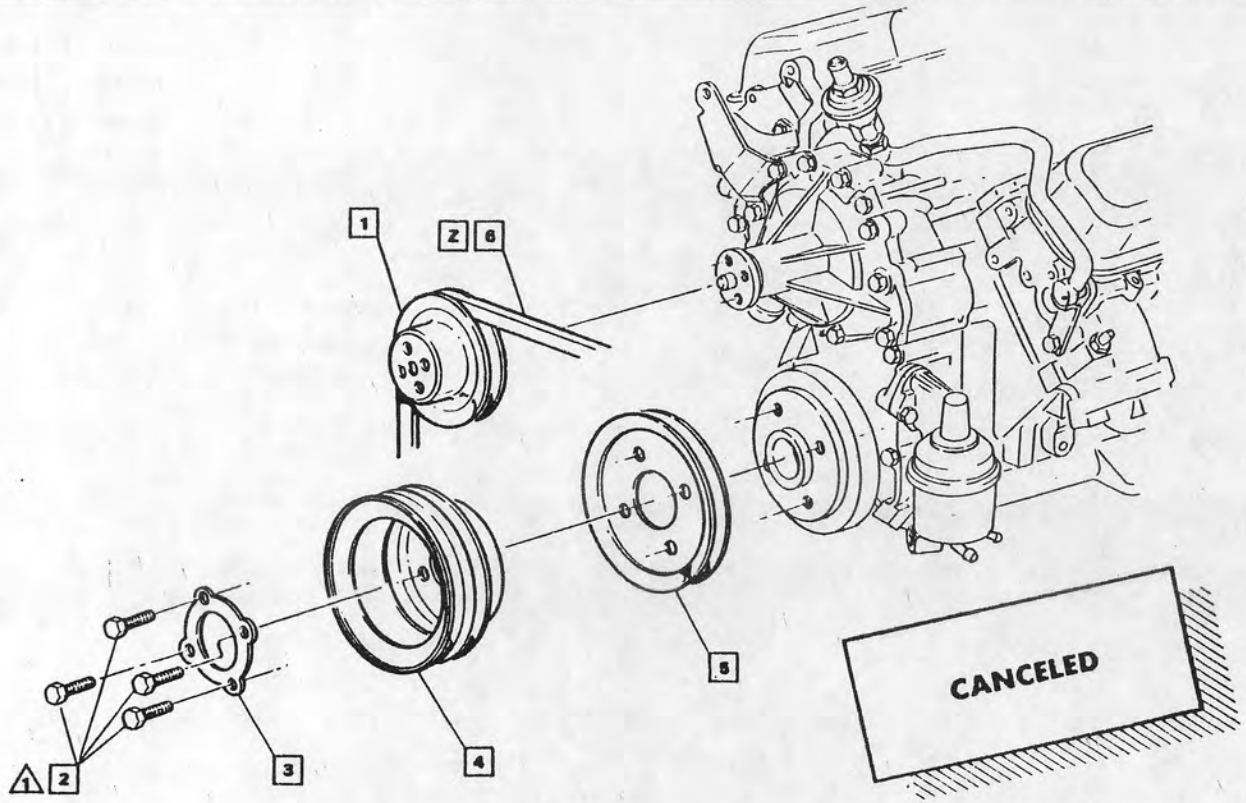
K&E 10 1263 8-77 3313

PONTIAC MOTOR DIVISION

General Motors Corporation Pontiac, Michigan

PRODUCT DESCRIPTION MANUAL

□ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF



10014014	1	PULLEY (WU)
9420960	2	BOLT
10003735	3	REINFORCEMENT PLATE
10014013	4	PULLEY
10001528	5	PULLEY (ZU)
	6	BELT

Z For belt routing see "Pulley & Belt Diagram"-UPC 6Z.

DYNAMIC (Instal) N.m	HAND (Insp.) N.m
1	24-34
2	
3	
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM EFF
4MK80		ISSUED	86448	CU	CU	
07NO80	1	SHEET CANCELED	91222	CU	EJ	

201

DATE 11JA80
DR K P BIERI
CK JEB
APPR RLJ
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE CRANKSHAFT & WATER PUMP PULLEY AND BELT FA00 & LU8

REF ECR 86448
NEW 29FE80
6K-3 RL

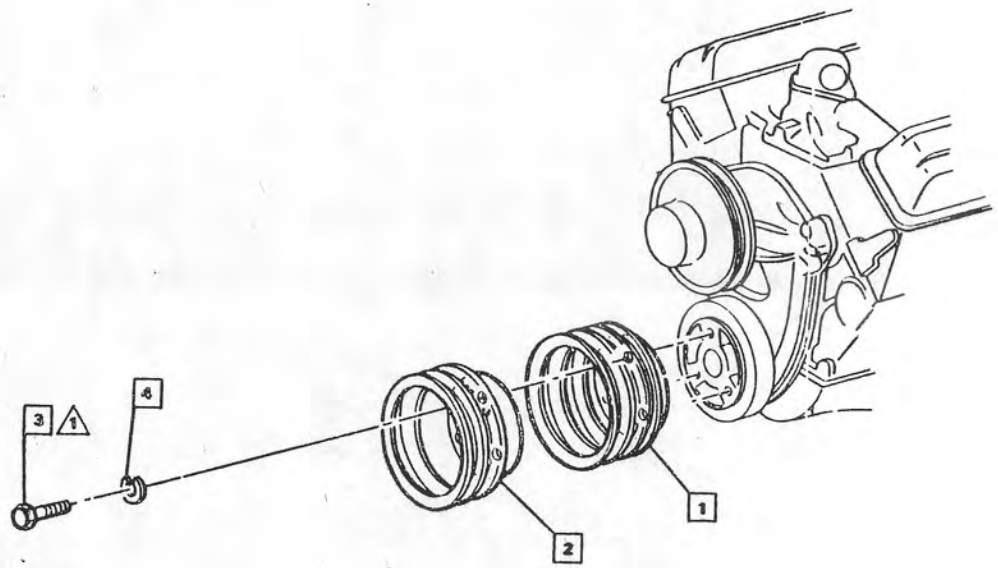
UPC 6K

SHEET 6

Ch X B X O P X Co

K&E 10 1263 8-77 3313

14023148	1	PULLEY ASM & C60
(1) 14023147	2	PULLEY ASM &C41
9423959	3	BOLT/SCREW
103321	4	WASHER



DYNAMIC (Install) N·m	HAND (Insp.) N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
△1 34 - 48		030CT80	1	WAS 3956666 PULLEY E "C41" WAS "(exc C60)"	85896	CW	MCT	
△1								
△2								
△3								
△4								
△5								

△ FULLY DRIVEN, SEATED & NOT STRIPPED

Ch ☒ B ☐ O ☐ P ☒ Ca ☐

205

DATE 07FEB:0
DR R. LINDNER
CK Jim Thayer-TH
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

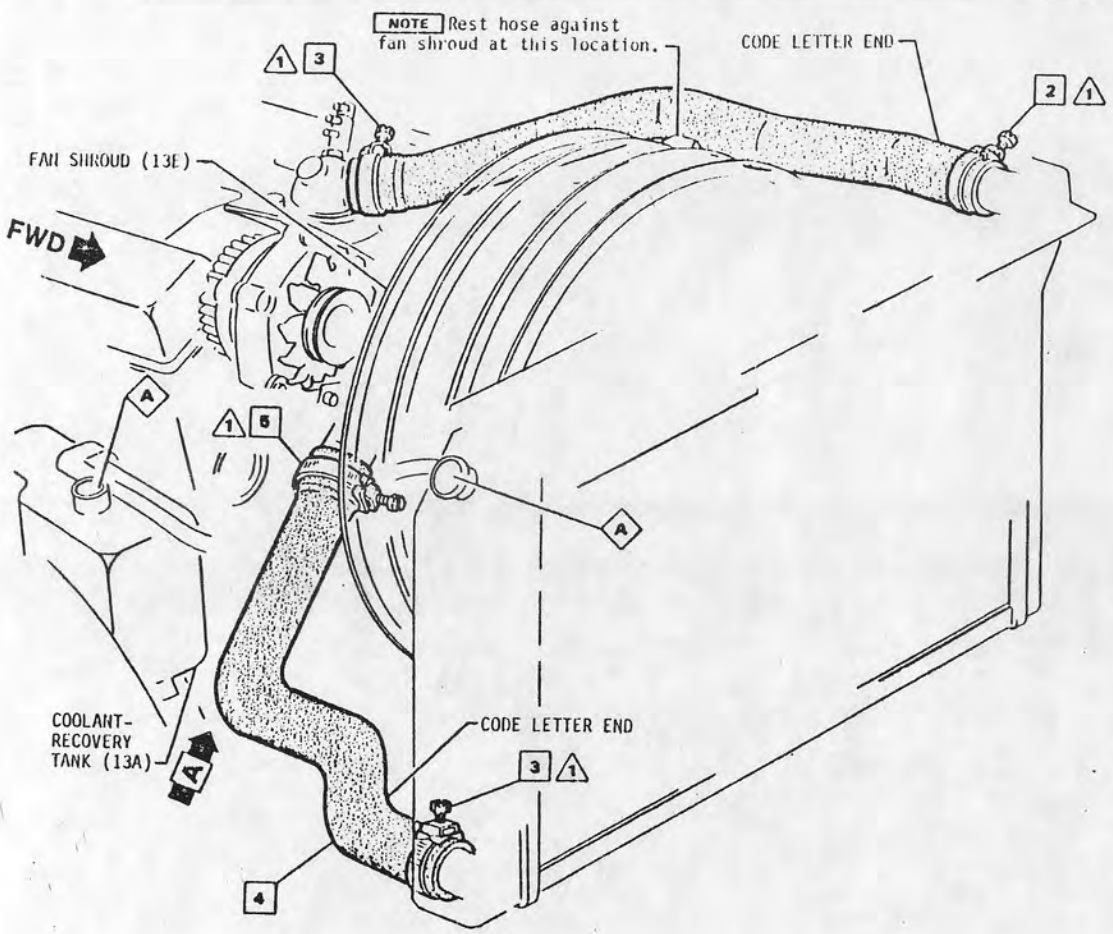
TITLE
CRANKSHAFT PULLEY
FA00 & L39/LC3/LG4/LM1

REF ECR 86448
C/O 16JA80
6K-8.1

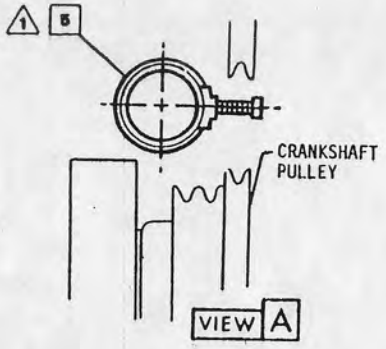
L-96436 (S)
L-98121 (S)
L-
L-

UPC 6K

SHEET 7



14031647	1	HOSE-INLET
9414932	2	CLAMP ASM
9437366	3	CLAMP ASM
14016850	4	HOSE-OUTLET
274765	5	CLAMP ASM
9985012	A	COOLANT As required to protect to -36.66° C (exc. Z49) or -34° F (-37° C) &Z49. See Engine Cooling System Capacity Chart 14023188 for proper quantity.



DYNAMIC (Install) N·m	HAND (Insp.) N·m
1 2.6-3.2 (I)	
2	
3	
4	
5	

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
16SEP80	1	TORQ (1) WAS 1.6-2.8 (PC-0074)	89725	(M)	CM	C

206

DATE 25MAR80
DR R.LINDNER
CK
APPR (S)
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE RADIATOR HOSES & COOLANT FA00 &LC3

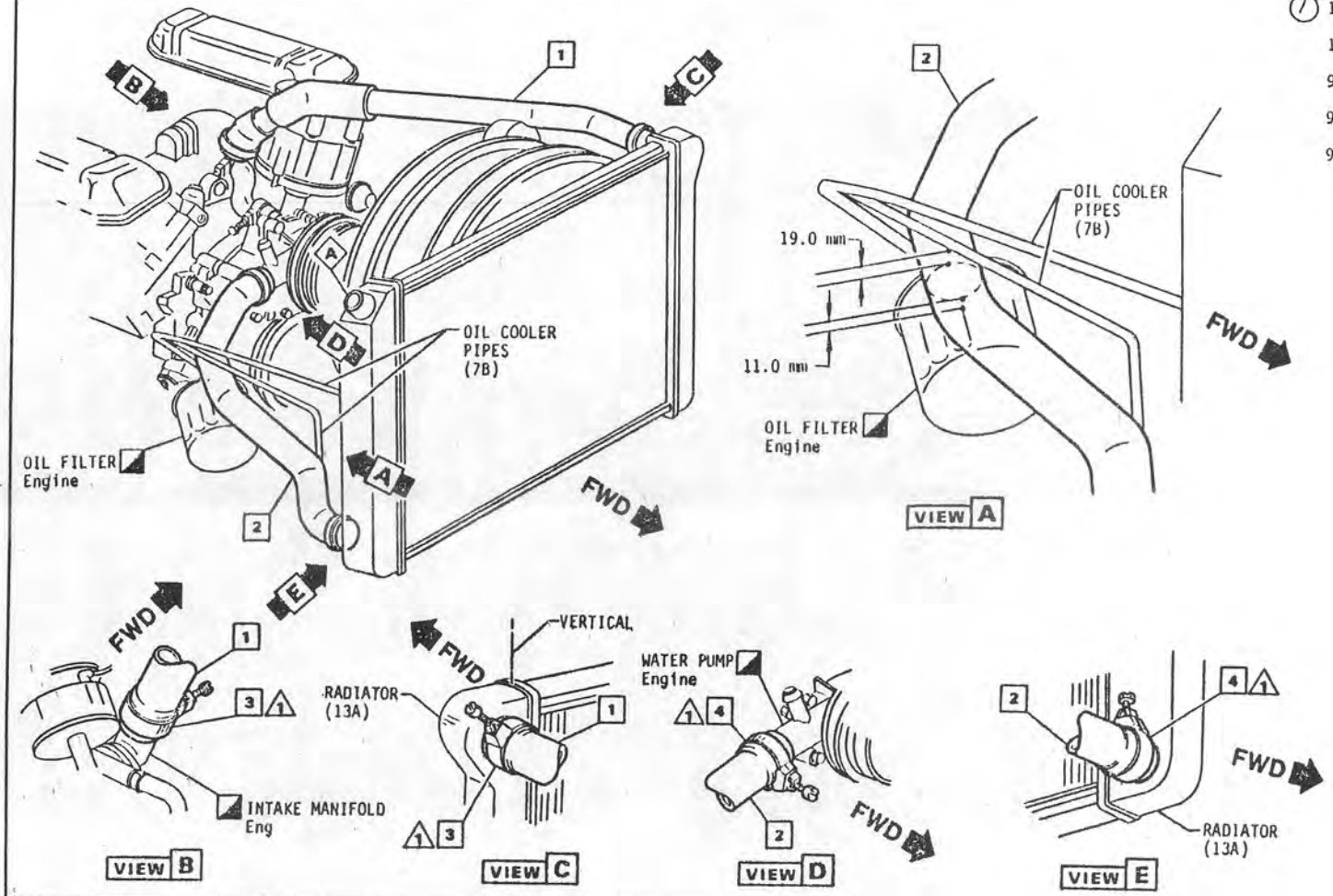
REF ECR 86448 C/O 20MR80 6K-9

l-20165 (S)
l-
l-

UPC 6K

SHEET 8

Ch X B O P Ca



14034150	1	HOSE-INLET
14013504	2	HOSE-OUTLET
9414932	3	CLAMP ASM
9437366	4	CLAMP ASM
9985012	A	COOLANT As required to protect to -36.66° C (exc Z49) or -34° F (-37° C) & Z49. See Engine Cooling System Capacity Chart 14023188 for proper quantity.

DYNAMIC (Install) N·m	HAND (Insp.) - N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
	1 2.6-3.2 (2)	05SEP80	1	WAS M032130 HOSE	85871	CU	RL	
	2	26SEP80	2	TORQ (1) WAS 1.6-2.8 (PC-0074)	85875	CU	RL	C
	3							
	4							
	5							

1 FULLY DRIVEN, SEATED & NOT STRIPPED

207

Ck X B D P Co

DATE 29JAN80
DR R. LINDNER
CK
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

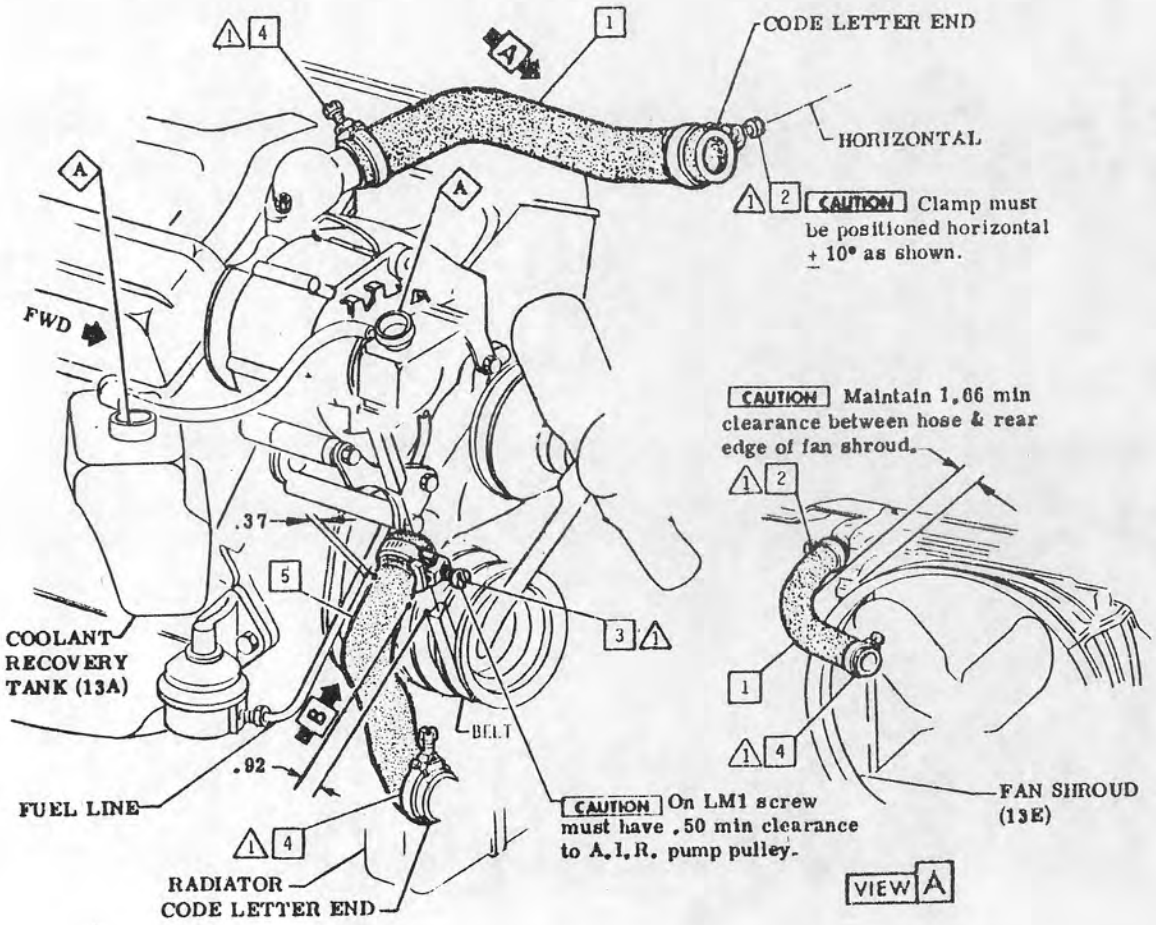
TITLE RADIATOR HOSES FA00 & LD5

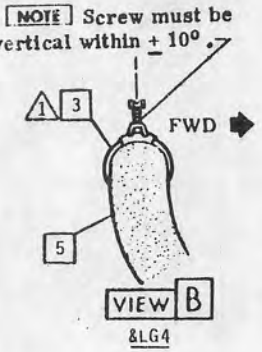
REF ECR 86448 NEW 11MR80

11-21488 (S)
1-
1-
1-

UPC 6K

SHEET 9





14013519	1	HOSE-INLET &LG4 or L39
14013520	1	&LM1; &C60 or V08
9414932	2	CLAMP ASM
274765	3	CLAMP ASM
9437366	4	CLAMP ASM
360647	5	HOSE-OUTLET
9985012	A	COOLANT As required to protect to -36.66° C (exc. Z49) or -34° F (-37° C) &Z49. See Engine Cooling System Capacity Chart 14023188 for proper quantity.

DYNAMIC (Install) N·m | HAND (Insp.) N·m | DATE | SYM | REVISION | AUTH | DR | CK | ASM CHG

△1 2.6 - 4.0
△2
△3
△4
△5

△1 FULLY DRIVEN, SEATED & NOT STRIPPED

208

DATE 2BAUG80
DR R. LINDNER
CK Tom Davis III
APPR (S)
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE RADIATOR HOSES & COOLANT FA00 & LG4/LM1/L39

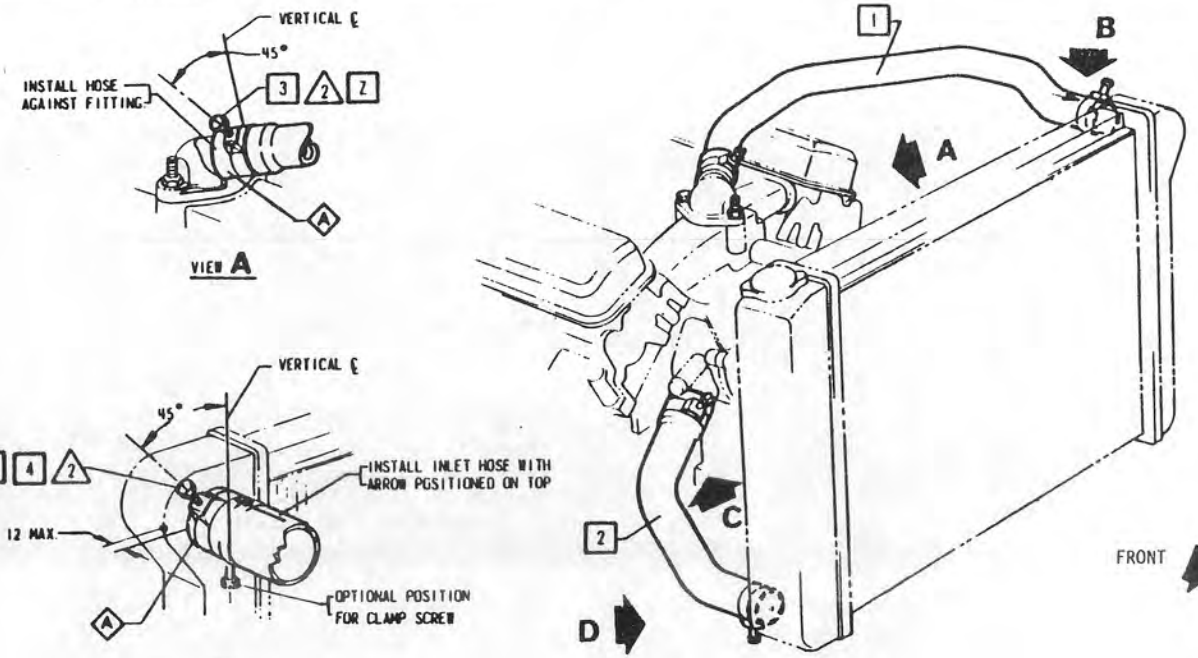
REF ECR 86448 C/O 20MR80 6K-11 | L-91826 (S) L- L- L- | UPC 6K | SHEET 10

Ch X B D P X Co

PONTIAC MOTOR DIVISION
General Motors Corporation Pontiac, Michigan

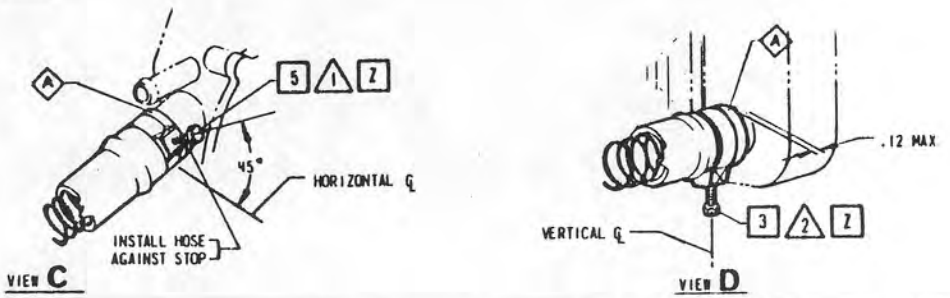
PRODUCT DESCRIPTION MANUAL

□ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF



14015196	1	HOSE-INLET (LP)
480200	2	HOSE ASM. (NT) OUTLET
9437366	3	CLAMP
9414932	4	CLAMP
274765	5	CLAMP
9985012	A	COOLANT MAY BE USED TO ASSIST RADIATOR HOSE INSTALLATION

CANCELED



Z SEE FASTENERS GENERAL INSTRUCTIONS (GROUP 0A)

DYNAMIC (Instal) N·m	HAND (Insp.) N·m
1	1.6 - 2.2
2	2.8 - 4.0
3	
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM Eng.
17JA80		ISSUED	BG446	CU		
07NOV80	1	SHEET CANCELED	21222	CU	EJ	

209

DATE 18 OC 79
DR EDB/GMV
CK F.H.A
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE RADIATOR HOSES FA00 & LU8

REF ECR 86448 C/O 11DE79 6K-4 RL

UPC 6K

SHEET 11

Ch X B O P X Ca

COOLANT VOLUMES

CODLANT REQUIRED TO GIVE 50% SOLUTION
BY VOLUME WITH FREEZE POINT OF -37 C.

(1)

ENGINES						TRANS		COOLING			QUANTITY OF SOLUTION (LITRES)	TOTAL COOLING SYSTEM CAPACITY (LITRES)
LD5						MAN	AUTO	C41	C60	V08		
X						X	X	X	X	X	6.6	13.2
						X	X	X	X		9.92	19.84
						X	X			X	10.2	20.4

THESE VOLUMES INCLUDE 0.95 LITRE IN OVERFLOW RESERVOIR AFTER AIR IS PURGED OUT OF SYSTEM.

GENERAL

FILL RADIATOR TO FILLER NECK. PUT 1.42 LITRES IN OVERFLOW RESERVOIR. CARE MUST BE TAKEN IN FILLING SYSTEM TO PREVENT DAMAGE TO CAR FINISH.

RADIATOR FILL REQUIREMENTS

ETHYLENE CLYCOL TWO YEAR COOLANT MEETING SPECIFICATION #9985012 (6K5) MANDATORY IN ALL SERIES YEAR AROUND TO PROVIDE AN INHIBITED COOLANT IN THE AMOUNTS TABULATED.

DYNAMIC (Instal) N.m | HAND (Insp.) N.m

1 2 3 4 5

⚠ FULLY DRIVEN SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
(illegible)		ISSUED	SKAAR	RL	[illegible]	
07NOV80	1	"LUB" REMOVED (2) PLACES	91222	CU	EY	

210

DATE 31 OC 79
DR G.M. VERSTRAETE
CK B.A.B
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

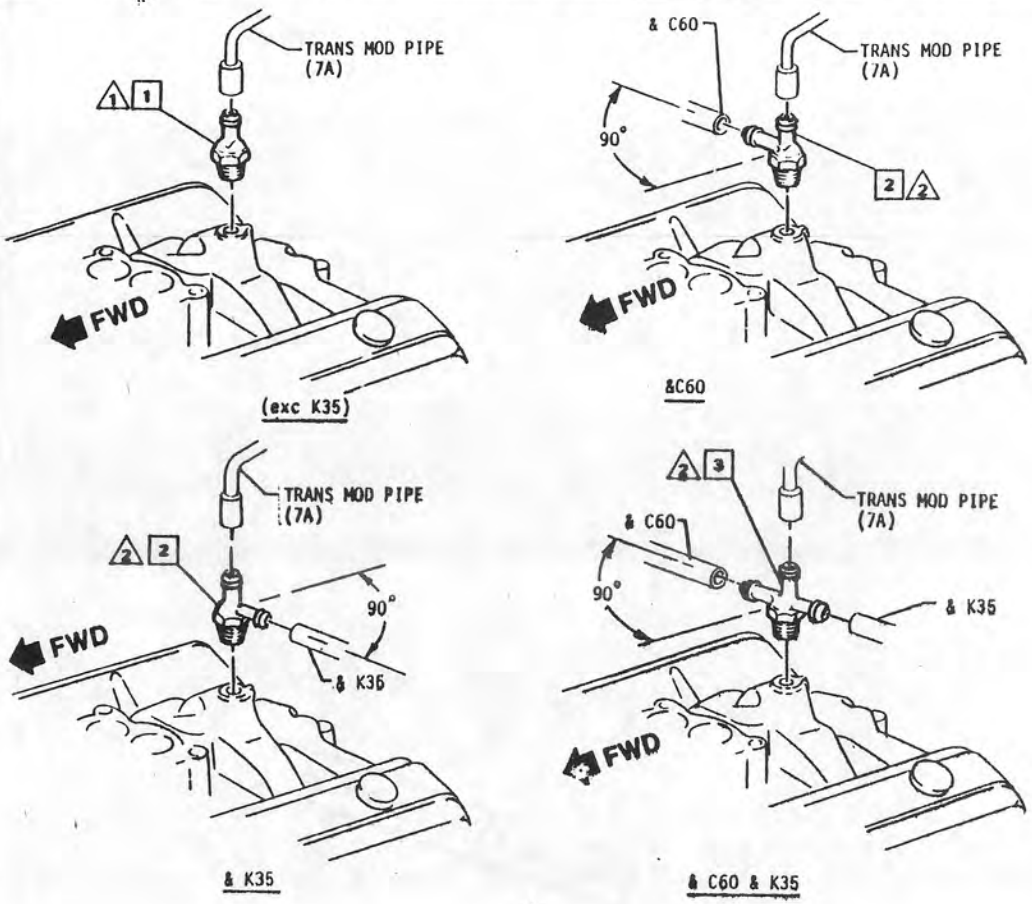
TITLE CHART-COOLING SYSTEM FILL (1)
FA00 & LD5/LG4

REF ECR 86448
C/O 26FE80
6K-15 RL

UPC 6K

SHEET 12

Ch X 0 X 0 P X Ca



14017791	1	FITTING
14017792	2	FITTING
14020680	3	FITTING

WAITING LAYOUT APPROVAL

*Plus torque required to align fitting.

DYNAMIC (Install) N·m	HAND (Insp.) · N·m
1	11 - 14
2	11 - *
3	
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ESR CNS
12JN80	1	"MX3" OPTION ADDED	8904	EL	[illegible]	

211

Ch X B X O P X Co

DATE 07FEB80
DR E.LUTH
CK [signature] TN
APPR NS
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

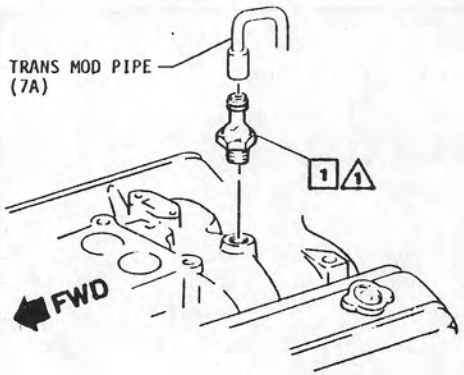
TITLE VACUUM FITTINGS FA00 & LG4 & M33; & LM1 & MX3 (1)

REF ECR 86448
C/O 25JA80
6L-1

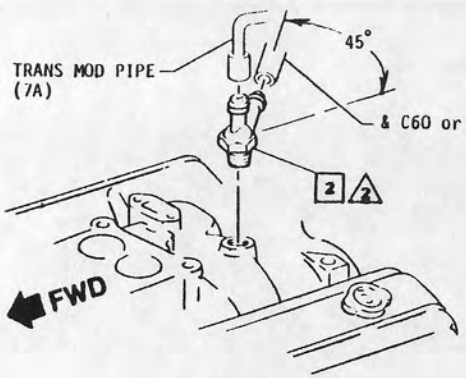
L- (NS)
L-
L-
L-

UPC 6L

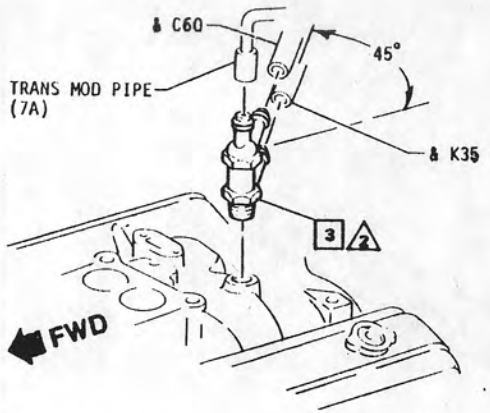
SHEET 1



(exc K35)



& C60 or K35



*Plus torque required to align fitting.

& C60 & K35

14017791	1	FITTING
14017792	2	FITTING
14017793	3	FITTING

WAITING LAYOUT APPROVAL

DYNAMIC (Instal) N·m	HAND (Insp.) N·m
△1	11 - 14
△2	11 - *
△3	
△4	
△5	

△ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
12JN80	1	OPTIONS "2" MV4 OR M33 ADDED	89074	EL	RH	

212

DATE 07FEB80
DR E. LUTH
CK
APPR NS
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE VACUUM FITTINGS FA00 & L39 & MV4 or M33 (1)

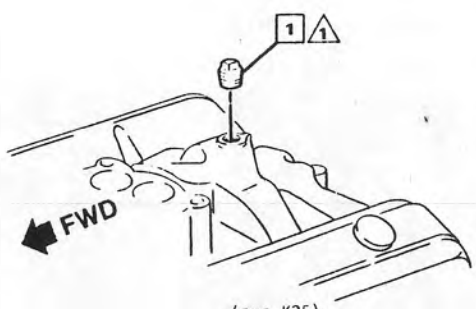
REF ECR 86448
C/O 25JA80
6L-2

L- (NS)
L-
L-
L-

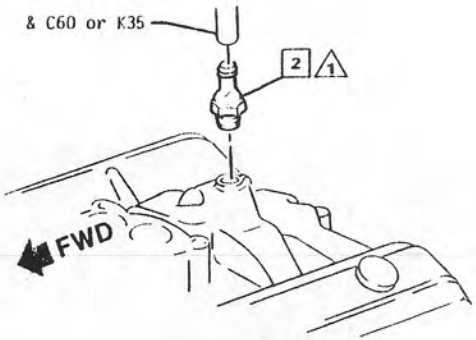
UPC 6L

SHEET 2

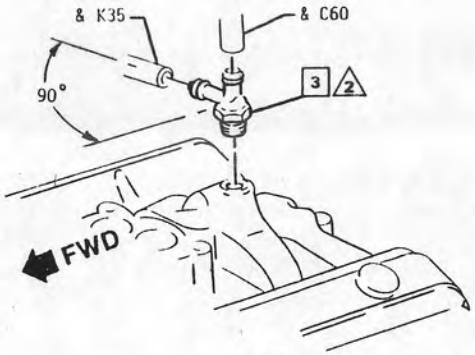
Ch X B O P X Ca



(exc K35)



& C60 or K35



& C60 & K35

445673	1	PLUG
445686	1	OPT
14017791	2	FITTING
14017792	3	FITTING

WAITING LAYOUT APPROVAL

*Plus torque required to align fitting.

DYNAMIC (Instal) N·m	HAND (Insp.) · N·m
△1	11-14
△2	11-*
△3	
△4	
△5	

△1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
		213				

DATE 07FEB80
DR E. LUTH
CK [signature]
APPR NS
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE VACUUM FITTINGS FA00 & LC3

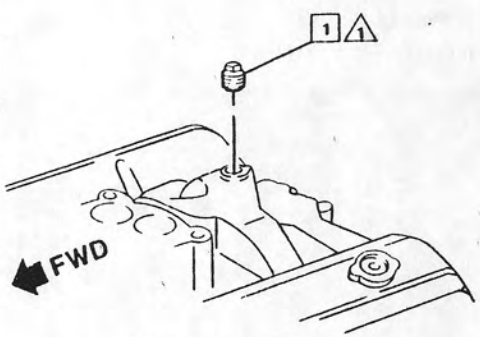
REF ECR 86448 C/O 25JA80 6L-3

L-(NS) L- L- L-

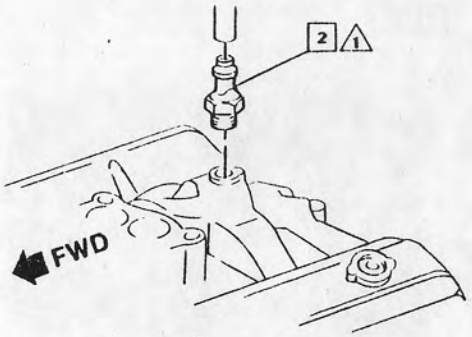
UPC 6L

SHEET 3

C D O P Co



(exc C60)



& C60

445673	1	PLUG
445686	1	OPT
14017791	2	FITTING

WAITING LAYOUT APPROVAL

DYNAMIC (Instal) N·m	HAND (Insp.) · N·m
1	11-14
2	
3	
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
		214				

DATE 07FEB0
DR E. LUTH
CK
APPR NS
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
VACUUM FITTINGS
FA00 & LC3 & M64; & LG4 & M24

REF ECR 86448
C/O 25JA80
6L-4

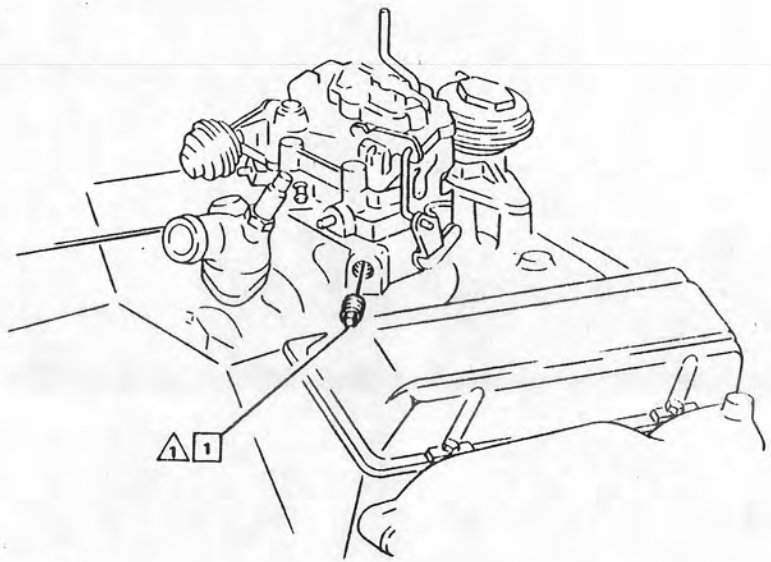
L-(NS)
L-
L-

UPC 6L

SHEET 4

C X B O P X Ca

+445673	1	PLUG
+445686	1	OPT



WAITING LAYOUT APPROVAL

DYNAMIC (Install) N·m	HAND (Insp.) N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
1	11-14							
2								
3								
4								
5				215				

1 FULLY DRIVEN, SEATED & NOT STRIPPED

Ch X B O P Co

DATE 14 FE 80
DR E. LUTH
CK R. Landschi RC
APPR NS
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
INLET MANIFOLD PLUG
FA00 & LC3

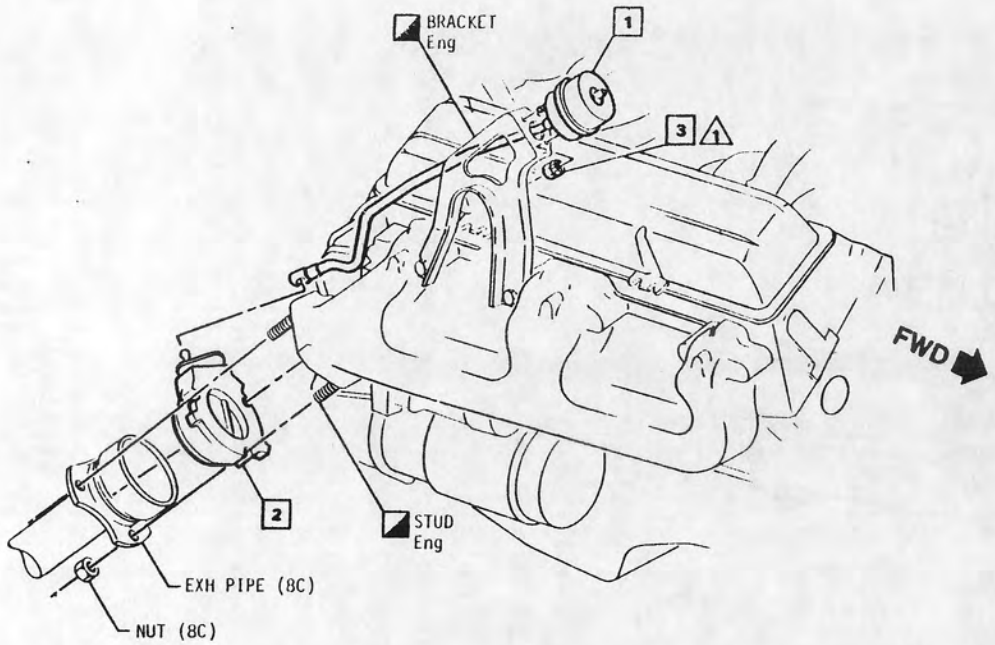
REF ECR 86448
C/O 05FE80
6L-7

L-(NS)
L-
L-
L-

UPC 6L

SHEET 7

1996636	1	ACTUATOR & ROD ASM
355915	2	VALVE ASM
11503647	3	NUT ASM



WAITING LAYOUT APPROVAL

DYNAMIC (Instal) N·m	HAND (Insp.) N·m
1	2.2-3.4
2	
3	
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
		216				

DATE 07FEB0
DR E. LUTH
CK Tom Wagner TH
APPR NS
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE EXHAUST HEAT VALVE & ACTUATOR FA00 & L39/LG4/LM1

REF ECR 86448
C/O 29JA80
6L-8

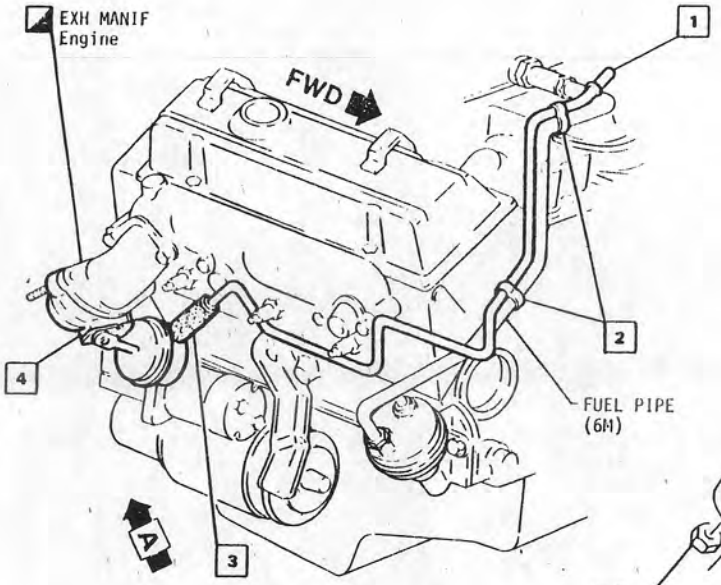
L-06063 (NS)
L-SHTS 3 & 5
L-
L-

UPC 6L

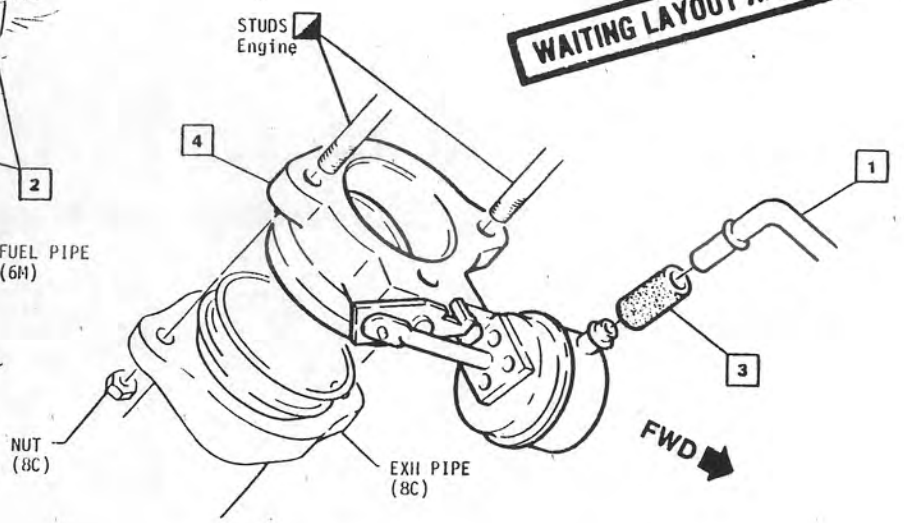
SHEET 8

Ch X B O P Ca

14023129	1	PIPE
460796	2	CLIP
326560	3	HOSE
5233475	4	VALVE & ACTUATOR ASM



WAITING LAYOUT APPROVAL



VIEW A

DYNAMIC (Instal) N·m	HAND (Insp.) · N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
1 2 3 4 5								
⚠1 FULLY DRIVEN, SEATED & NOT STRIPPED				217				

DATE	07FEB0
DR	E.LUTH
CK	Jim Daugherty
APPR	NS
APPR	
APPR	
APPR	

DIV: CHEVROLET

1981 CHEV. "F" 14020867

TITLE: E.F.E VALVE & PIPE FA00 &LC3

REF: ECR 86448 C/O 29JA80 6L-9

L- (NS) L- L-

UPC: 6L

SHEET: 9

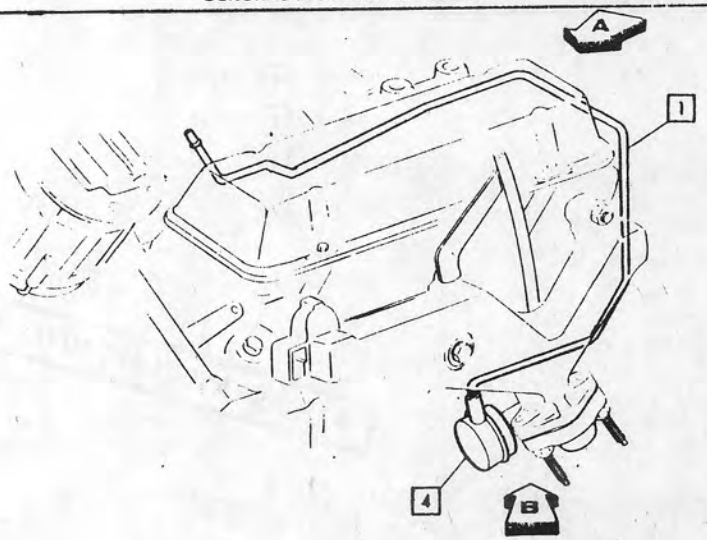
Ch | B | Q | P | Ca

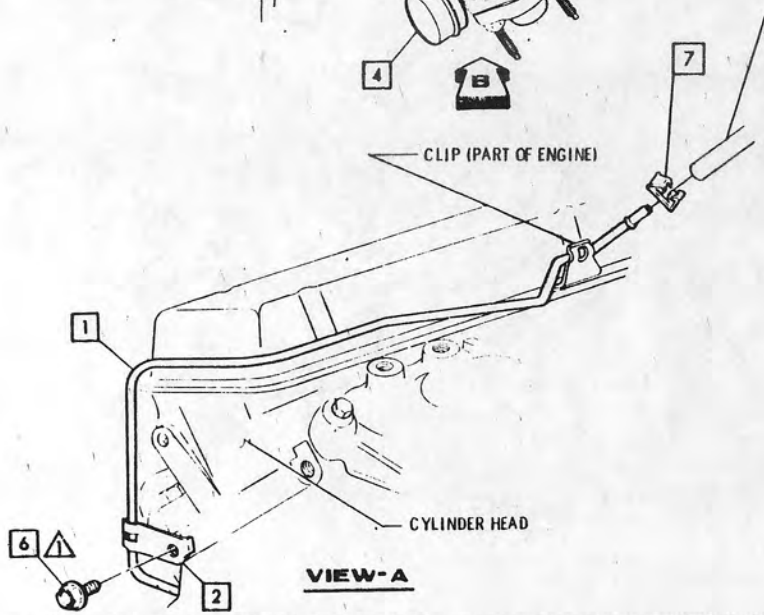
PRODUCT DESCRIPTION MANUAL

BUICK MOTOR DIVISION
GENERAL MOTORS CORPORATION FLINT, MICHIGAN

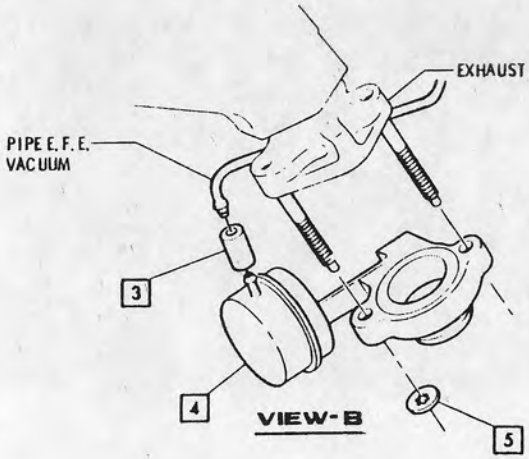
☐ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF

25504236	1	PIPE - E.F.E. VACUUM
1257393	2	CLIP
1247711	3	HOSE
5233320	4	VALVE & ACTUATOR ASM - E.F.E.
11502759	5	NUT
3987930	6	BOLT
+ 25501479	7	CLIP





VIEW-A



VIEW-B

DYNAMIC (Install) N·m	HAND (Insp.) N·m
△1	14 - 27
△2	
△3	
△4	
△5	

△1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASN CHG
07FEB		ISSUED	BLAKER	CD	DE	

218

DATE 12 JA 79
DR J. OSTERMANN DE
CK R. Thies
APPR [illegible] 10-12-78
APPR [illegible]
APPR [illegible]
APPR [illegible]

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE E.F.E. VALVE & PIPE
FA00 &LD5

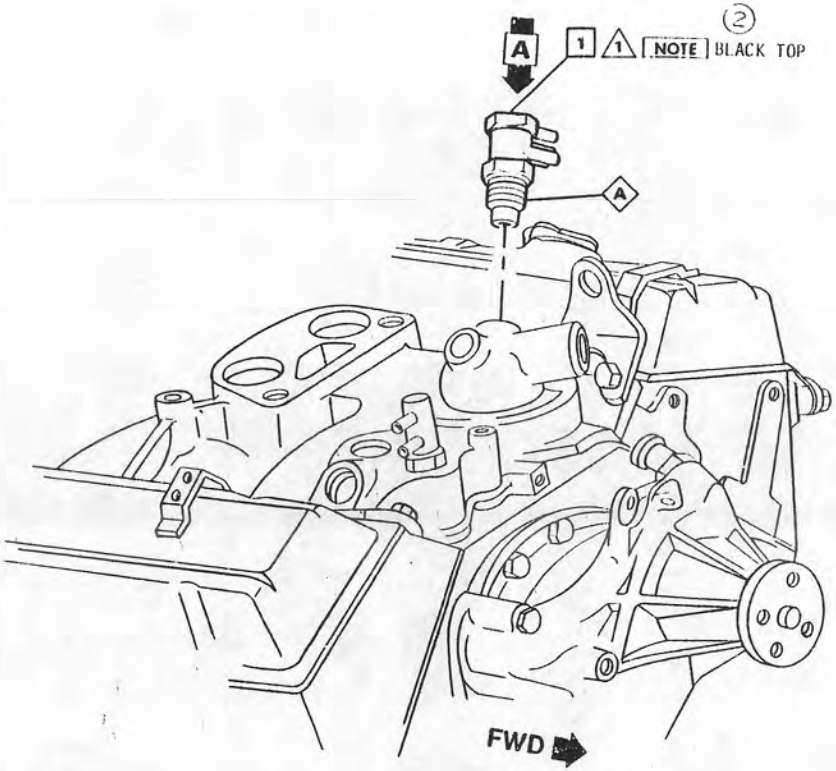
REF ECR 86448
C/O 29JA80
6L-10 EL

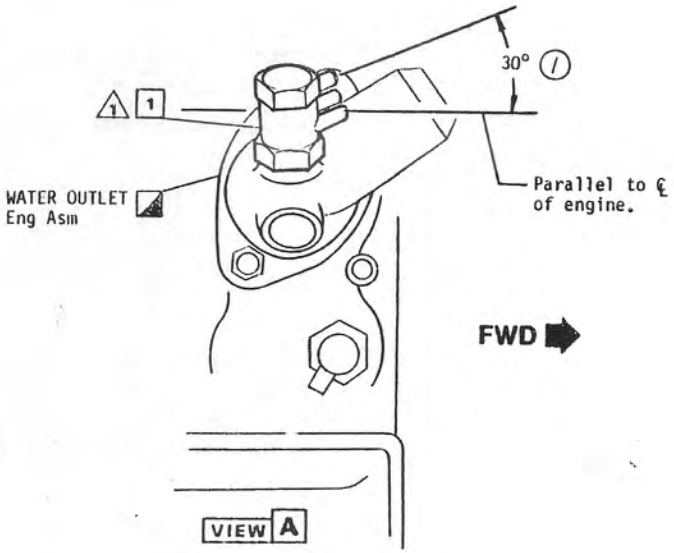
UPC 6L

SHEET 10

Ch X 8 X 0 X P X Ca

3039144	1	SWITCH ASM	
9985345	A	SEAL-.0038 L	





*Plus hand torque clockwise as required to align switch to accommodate hose harness.

DYNAMIC (Instal) N·m	HAND (Insp.) N·m
1	2.2-*
2	
3	
4	
5	
1 FULLY DRIVEN, SEATED & NOT STRIPPED	

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
12SEP80	1	"30° LEFT WAS 45° RIGHT (PC-6-53)	RSK.5	CU	R-	C
200CT80	2	"BLACK" WAS "WHITE"	89395	C.U		C

219

DATE 04FEB80
DR E. LUTH
CK Tom Hagen TH
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
E.F.E. VALVE SWITCH ASM
FA00 & LC3

REF ECR 86448
C/O 29JA80
6L-14

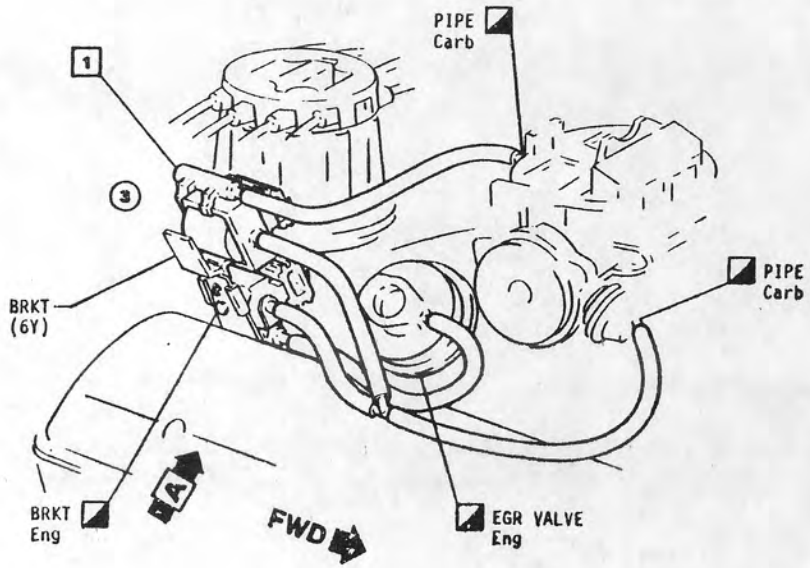
L- 13621 (S)
L-
L-
L-

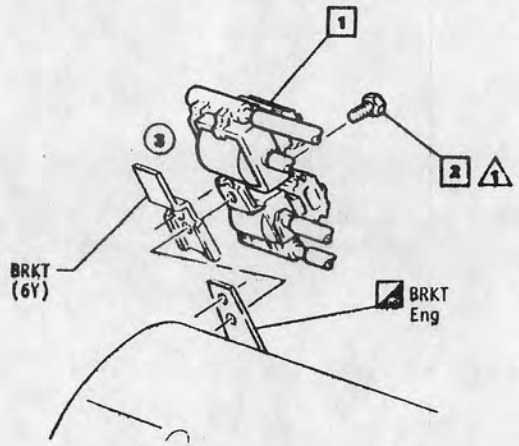
UPC 6L

SHEET 11

C ☒ B ☐ O ☐ P ☒ Ca ☐

(4)	14034060	1	HARN ASM-EGR VAC
(1)	11504067	2	BOLT/SCREW





VIEW A

WAITING LAYOUT APPROVAL

DYNAMIC (Instal) N·m	HAND (Insp.) - N·m
△1 +	
△2	
△3	
△4	
△5	

△ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM Cog
02MAY80	1	"11504067" ADDED				
	2	"(CAC NMS)" REMOVED				
	3	ITEM 1 DWG & INSTL REV - 2 PLCS	90412	RL		
23MAY80	4	WAS 1997517 SOLENOID				
	5	TITLE & OPTIONS REV	90412	RL		

220

DATE 29FEB0
DR R KOCH
CK Jim Hayes TH
APPR NS
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE (5) HARNESS ASM-EGR VAC CONT
FA00 &LG4 &MV4 &NB1, LK1 &MX3 &NB1 (2)

REF ECR 86448
NEW 22FEB0

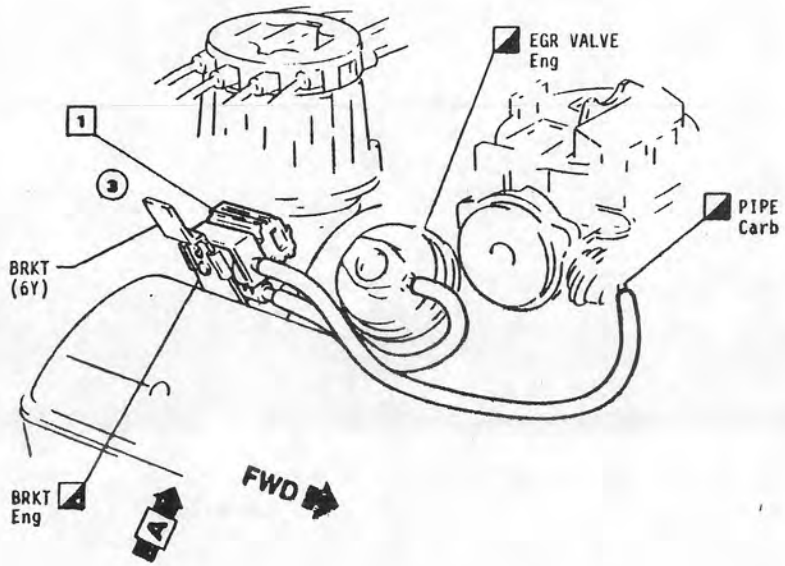
(NS)

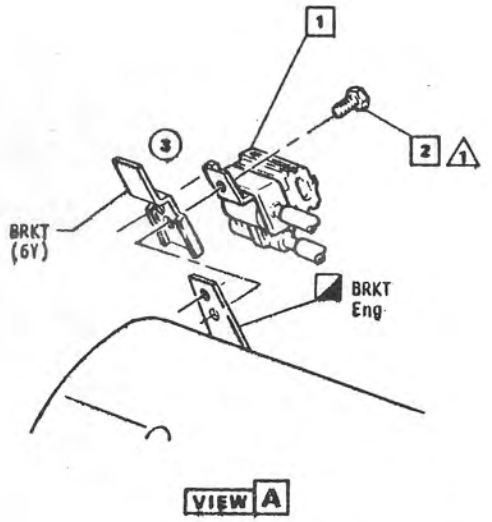
UPC 6L

SHEET 12

Ch X B O P X Co

(4)	14034059	1	HARN ASM-EGR VAC
(1)	11504067	2	BOLT/SCREW





VIEW A

WAITING LAYOUT APPROVAL

DYNAMIC (Install) N·m	HAND (Insp.) - N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
		02MY80	1	"11504067" ADDED				
			2	"(exc NM3)" REMOVED				
			3	ITEM 1 DWG & INSTL REV-2 PLCS	90412	RK	RJ	
		23MY80	4	WAS 1997518 SOLENOID				
			5	TITLE & OPTIONS REV	90912	RK	RJ	
				221				

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

CK B | O | P Ca

DATE 22FEB0
DR R KOCH
CK Richard Chin RC
APPR NS
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE HARNESS ASM-EGR VAC CONT (5)
FA00 &LG4 &M24 &NB1 (2)

REF ECR 86448
NEW 22FEB0

(NS)

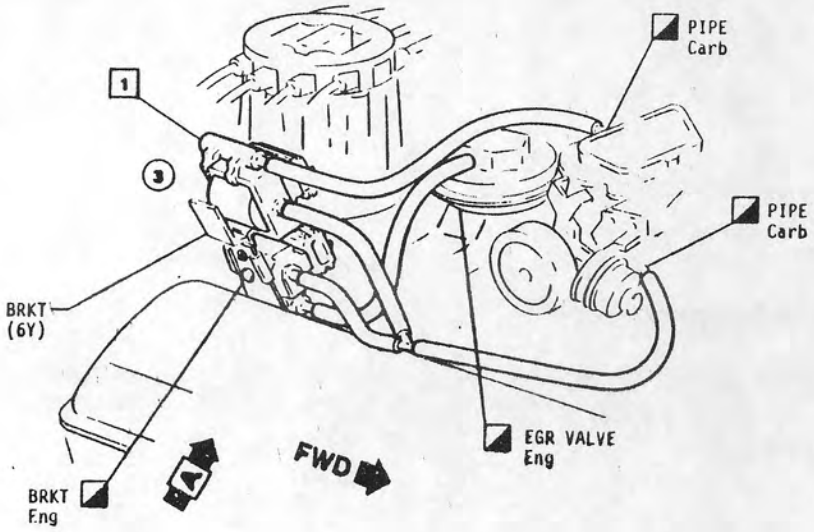
UPC 6L

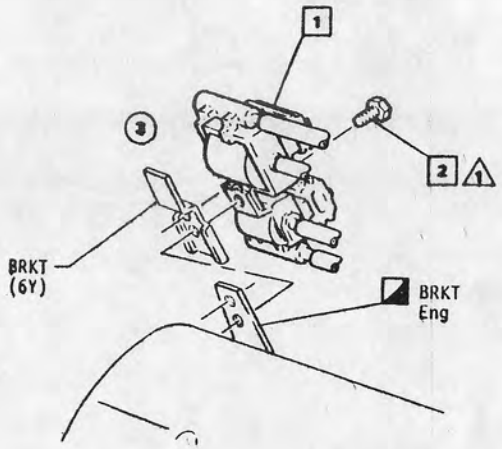
SHEET 13

PRODUCT DESCRIPTION MANUAL

□ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF

(4)	14034058	1	HARN ASM-EGR VAC
(1)	11504067	2	BOLT/SCREW





VIEW A

WAITING LAYOUT APPROVAL

DYNAMIC (instal) N·m	HAND (Insp.) - N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
		02MY80	1	"11504067" ADDED				
			2	"(exc NMS)" REM				
			3	ITEM 1 DWG & INSTL. REV-2 PLCS	90412	RK	SH	
		23MY80	4	WAS 1997517 SOLENOID				
			5	TITLE & OPTIONS REV	90912	RK	KJ	
				223				

△ FULLY DRIVEN, SEATED & NOT STRIPPED

Ch ☒ D ☐ O ☐ P ☒ Ca ☐

DATE 29FEB0
DR R KOCH
CK Jim Haynie TN
APPR NS
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE HARNESS ASM-EGR VAC CONT (5)
FA00 &L39 &NB1 (2)

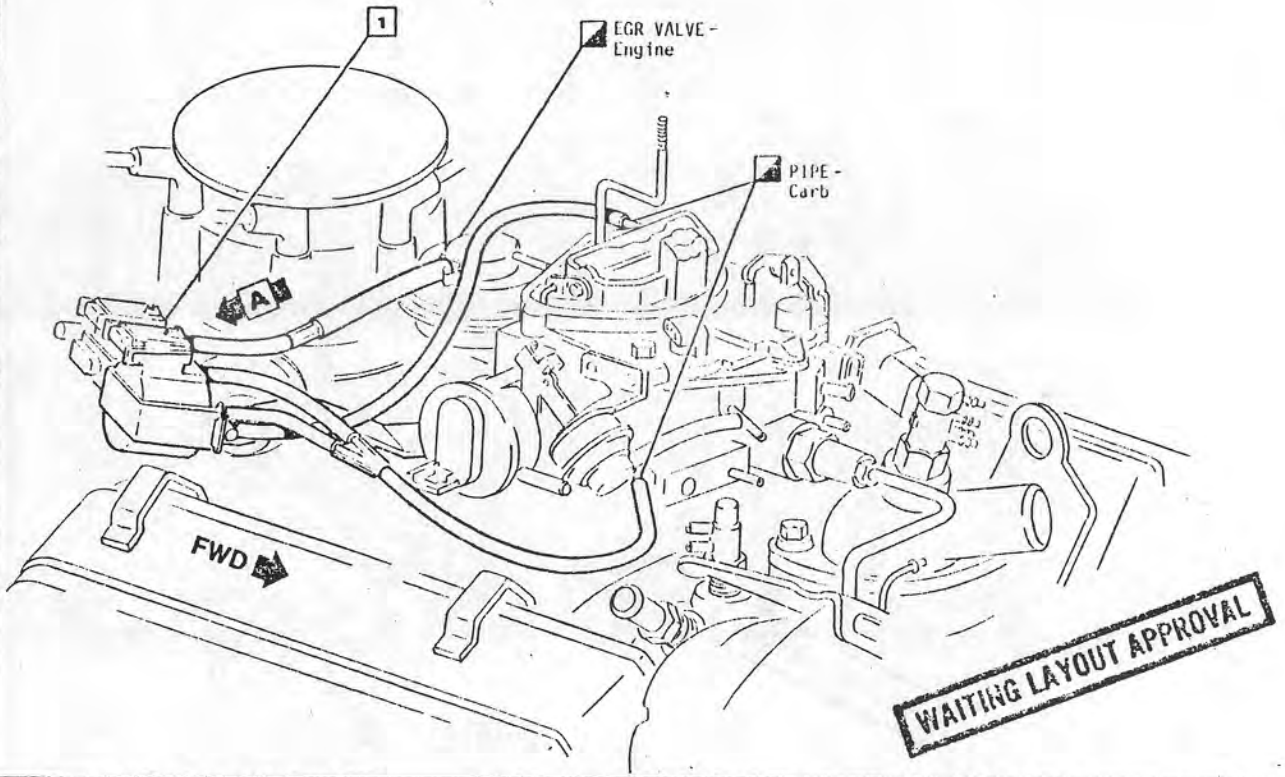
REF ECR 86448
NEW 22FEB0

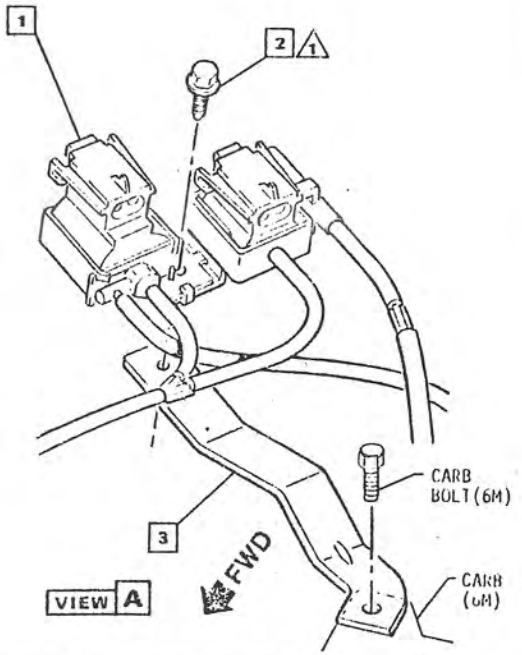
(NS)

UPC 6L

SHEET 14

1	14034057	1	EGR VAC HARN ASM
	11504067	2	BOLT/SCREW
	14029012	3	BRACKET





WAITING LAYOUT APPROVAL

DYNAMIC (Install) N·m	HAND (Insp.) - N·m
1	+
2	
3	
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
21NOV80	1	WAS "SOLENOID ASM EGR CONT VV" & PART NO." ADDED				
	2	TITLE REVISED	83795	CU	RC	
03DEC80	3	"MVD" REMOVED	91645	KLU	RCT	

223

DATE	11APR80
DR	R LINDNER
CK	Richard Linder RL
APPR	NS
APPR	
APPR	
APPR	

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE (2) EGR VACUUM HARNESS ASM FA00 &LC3 &M31 &NB1 (3)

REF ECR 86448 NEW 25MR80

UPC 6L

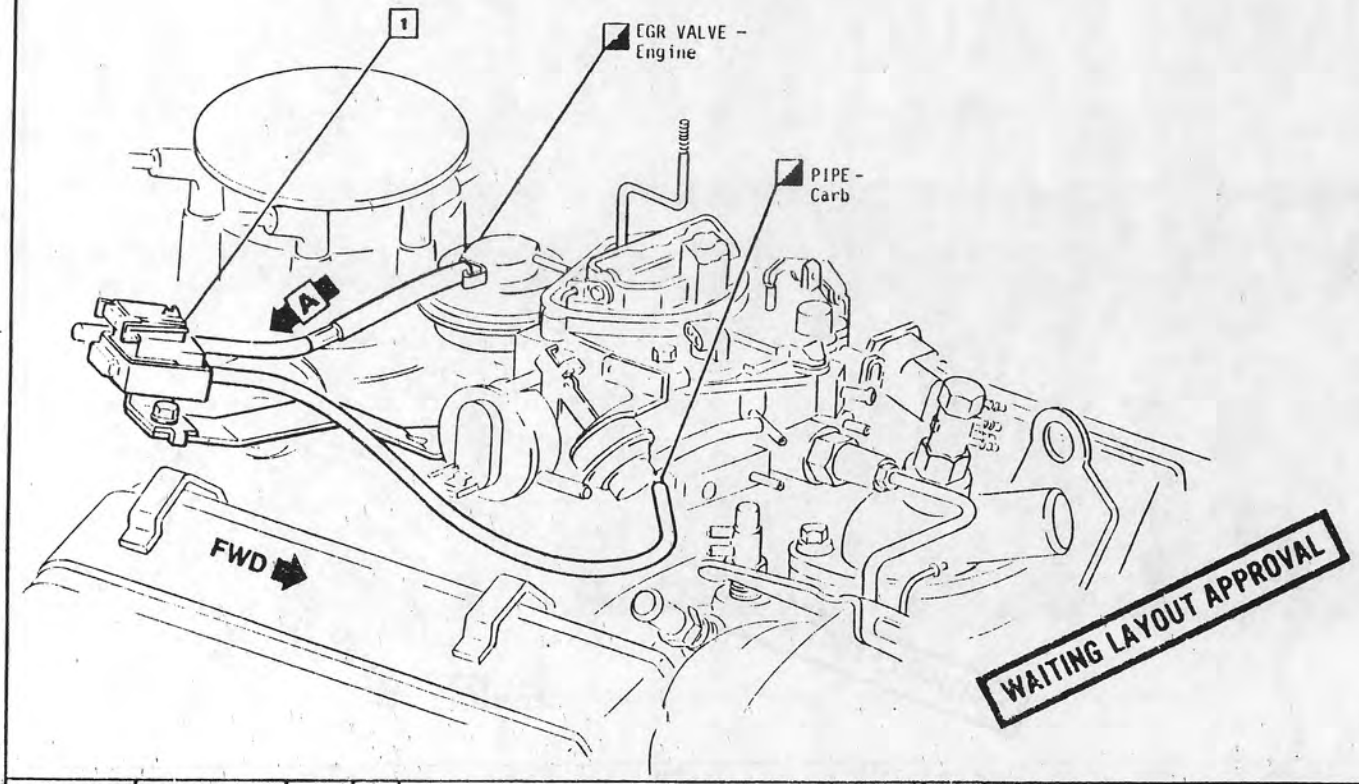
SHEET 15

C X B O P Ca

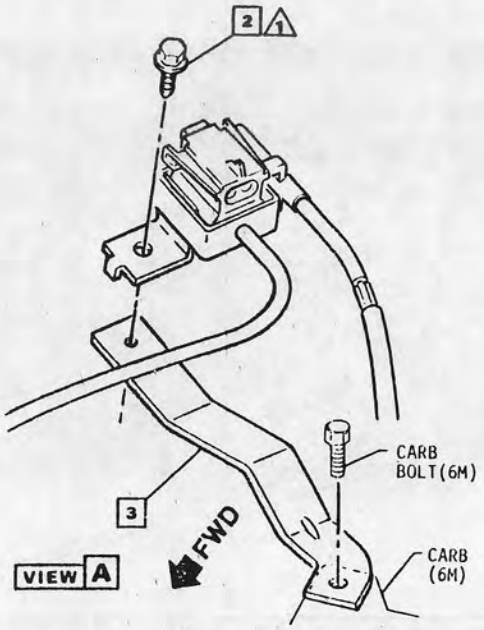
PRODUCT DESCRIPTION MANUAL

☐ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF

(1) 14034055	1	EGR VAC HARN ASM
11504067	2	BOLT/SCREW
14029012	3	BRACKET



WAITING LAYOUT APPROVAL



DYNAMIC (Instal) N·m	HAND (Insp.) N·m
△1 +	
△2	
△3	
△4	
△5	

△ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
22AUG80	1	WAS "SOLENOID ASM-EGR CONT VLV" 3"PART NO." ADDED				
	2	TITLE REVISED	89798	CU	RC	

224

DATE 11APR80
DR R. LINDNER
CK Richard Cline RC
APPR NS
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE (2) EGR VACUUM HARNESS ASM FA00 &LC3 &M64 &NB1

REF ECR 86448 NEW 28MR80

UPC 61

SHEET 16

C X B O P Ca

UPC	SHEET	NEW OR C/O	TITLE	DIV RESP
6M			**ENGINE FUEL SYSTEM**	
6M	1	N	CONTENTS (6M THRU 6Q)	C
6M	2	N	CONTENTS (6T THRU 6Z)	C
6M	C1	C	CARBURETOR....L39	C
6M	C2	N	FUEL PUMP....L39 OR LU5	C
6M	C3	N	AIR CLEANER....LC1	C
6M	C4	C	AIR CLEANER....L39	C
6M	C5	N	AIR CLEANER....LU5	C
6M	C6	N	MODULE-ELECTRONIC CONTROL....NB1	C
6M	C7	N	MANIF DIFF PRESSURE SENSOR....M18 OR M26	C
6M	C8	N	MANIF DIFF PRESSURE SENSOR....MV9	C
6M	C9	N	EXHAUST OXYGEN SENSOR....L39 OR LU5	C
6M	C10	N	EXHAUST SENSOR ASM....LC1	C
6M	P1	N	AIR CLEANER....LQ9	P
6M	P2	N	ENGINE HEAT CONTROL....LQ9	P
6M	P3	N	CARB AIR INTAKE....LQ9	P
6M	P4	N	AIR FUEL SENSOR....LQ9	P
6M	P5	N	E.C.U. MOUNTING....NB1	P
6M	P6	N	MANIFOLD VACUUM SENSOR MTG....LQ9	P
6M	P7	N	SENSOR HOSE ROUTING....LQ9	P
6N2			**THROTTLE CONTROL**	
6N2	C1	N	ACCELERATOR CONTROLS-PASS COMPT	C
6N2	C2	N	ACCELERATOR CONTROLS-ENG COMPT....LC1	C
6N2	C3	N	ACCELERATOR CONTROLS-ENG COMPT....L39	C
6N2	C4	N	ACCELERATOR CONTROLS-ENG COMPT....LU5	C
6N2	P1	N	ACCELERATOR CONTROLS-ENG COMPT....LQ9	P
6N4			**THROTTLE SPEED CONTROL**	
6N4	C1	N	SERVO UNIT BRKTS....LC1/L39/LU5	C
6N4	C2	N	SERVO UNIT....LC1/L39/LU5	C
6N4	C3	N	TRANSDUCER MOUNTING....K35	C
6N4	C4	N	TUBE ROUTING....LC1	C
6N4	C5	N	TUBE ROUTING....L39	C
6N4	C6	N	TUBE ROUTING....LU5	C
6N4	C7	N	VAC VALVE RELEASE....K35	C
6N4	P	N	CABLE ROUTING & ADJUSTMENT....LQ9	P
6N4	P1	N	VACUUM TUBE DIAGRAM....LQ9	P
6N4	P2	N	SERVO UNIT....LQ9	P
6N4	P3	N	HOSE ROUTING-ENG COMPT....LQ9	P
6Q			**ENGINE/TRAMISSION MOUNTING**	
6Q	C1	N	ENGINE MOUNTING BRKT....LC1	C
6Q	C2	N	ENGINE MOUNTING BRKT....L39 OR LU5	C
6Q	C3	N	ENGINE MOUNTING....LC1	C
6Q	C4	N	ENGINE MOUNTING....L39 OR LU5	C
6Q	C5	N	TRANS MOUNTING....LC1	C
6Q	C6	N	TRANS MOUNTING...L39 OR LU5	C
6Q	P1	N	ENG MOUNT BOLT LOCATION....LQ9	P
6Q	P2	N	ENGINE MOUNTING....LQ9	P
6Q	P3	N	TRANS MOUNTING....LQ9 & M18 OR M26	P
6Q	P4	N	TRANS MOUNTING.....LQ9 & MV9	P

DYNAMIC (Install) N·m	HAND (Insp.) - N·m
1	
2	
3	
4	
5	

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
		225				

DATE 23AU80
DR R.C. TAYLOR
CK H.J. Buck HB
APPR
APPR
APPR
APPR

DIV CHEVROLET

1982 "F" CHEV 14036164

TITLE CONTENTS-ENGINE
FA00(00) ALL (6M THRU 6Q)

REF ECR 91284
NEW 12AU80

UPC 6M

SHEET 1

C | B | O | P | Ca

6Q ENGINE/TRANSMISSION MOUNTING

				DIV RESP
6Q-1	ENGINE MOUNT BOLT LOCATION ON FRAME	....ALL		D
6Q-2	ENGINE MOUNTING	....L39/LG4/LM1		C
6Q-3	ENGINE MOUNTING BRACKET	....LC3		C
6Q-4	ENGINE MOUNTING	....LC3		C
6Q-5	ENGINE MOUNTING	....LD5		P
(1) 6Q-6	CANCELED			
6Q-7	TRANSMISSION MOUNTING	....L39/LG4/LM1/LC3		C
6Q-8	TRANSMISSION MOUNTING	....LD5 or LS5	(2)	P

6T AIR INJECTION REACTOR

			DIV RESP
6T-1	A.I.R. PUMP	....LC3/LG4/L39/LM1 & K19	C
(3) 6T-2	CANCELED		
(4) 6T-2.1	CANCELED		
6T-3	VALVE ASM-A.I.R. CONTROL SWITCHING	....LC3/LG4/LM1/L39	C
6T-3.1	A.I.R. DIVERTER VALVE	....LM1 & M38 & NM4	C
6T-3.2	AIR CONTROL VALVE & FILTER	....LM1 & M24 & NM4	C
6T-4	OPEN		
6T-5	A.I.R. PUMP & MOUNTING BRACKET	....LD5	P
6T-6	A.I.R. HOSES	....LC3	C
6T-7	A.I.R. HOSES	....LG4/LM1/L39	C
6T-7.1	A.I.R. HOSES TO AIR CLEANER	....LC3/LG4/LM1/L39	C
6T-7.2	A.I.R. HOSES	....LM1 & K19 & NM4	C
6T-8	A.I.R. HOSES	....LD5	B
(5) 6T-9	CANCELED		
(6) 6T-9.1	CANCELED		
6T-10	A.I.R. PIPES & CHECK VALVE	....LG4/LM1/L39	C
6T-10.1	A.I.R. PIPES & CHECK VALVE	....LM1 & K19 & NM4	C
6T-11	A.I.R. PIPES & CHECK VALVE	....LC3	C
6T-12	A.I.R. CATALYTIC CONVERTER PIPE	....LG4/LM1/L39	C
6T-13	A.I.R. CATALYTIC CONVERTER PIPE	....LC3	C
(7) 6T-14	CANCELED		

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
29OCT80	1	SHT 6Q-6 ENG MTG LU8 CANC				
	2	LS5 WAS LU8				
	3	SHT 6T-2 A.I.R PUMP MTG LU8 & NB1 CANC				
	4	SHT 6T-2.1 A.I.R PUMP ASM MTG LU8 & NM4 CANC				
	5	SHT 6T-9 A.I.R HOSES LU8 & NB1 CANC				
	6	SHT 6T-9.1 A.I.R. HOSES LU8 & NM4 CANC				
	7	SHT 6T-14 CONV AIR FEED PIPES LU8 & NB1 CANC	91222	CU	JB	

DATE 05.NOV80
DR R.TAYLOR
CK
APPR
APPR
APPR 226
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE CONTENTS-ENGINE
FA00 ALL (6Q Thru 6T)

REF ECR 86448
NEW 22MY80

UPC 6M

SHEET 1.1

C X B D P Ca

UPC	SHEET	NEW OR C/O	TITLE	DIV RESP
6T			**AIR INJECTION REACTOR**	
6T	C1	N	A.I.R. PUMP MOUNTING....LC1	C
6T	C2	N	A.I.R. PUMP MOUNTING....L39 OR LU5	C
6T	C3	N	VALVE ASM-A.I.R. CONT SWITCH....LC1/L39/LU5	C
6T	C4	N	A.I.R. HOSES....LC1	C
6T	C5	N	A.I.R. HOSES....L39 OR LU5	C
6T	C6	N	A.I.R. HOSES TO AIR CLEANER....LC1/L39/LU5	C
6T	C7	N	DECELERATION VALVE....LC1	C
6T	C8	N	DECEL VALVE HOSE ROUTING....LC1	C
6T	C9	N	A.I.R. PIPES & CHECK VALVE....L39 OR LU5	C
6T	C10	N	A.I.R. CAT. CONV PIPE....LC1	C
6T	C11	N	A.I.R. CAT. CONV PIPE....L39 OR LU5	C
6Y			**ENGINE ELECTRICAL SYSTEM**	
6Y	C1	N	GENERATOR MOUNTING....LC1 & C41	C
6Y	C2	N	GENERATOR MOUNTING....LC1 & C60	C
6Y	C3	N	GENERATOR MOUNTING....L39 OR LU5	C
6Y	C4	N	STARTING MOTOR....LC1	C
6Y	C5	N	STARTING MOTOR....L39 OR LU5	C
6Y	C6	N	STARTER MOTOR SHIM (REPAIR)....LC1/L39/LU5	C
6Y	C7	N	SPARK PLUG WIRE CLEARANCE RH....LC1	C
6Y	C8	N	SPARK PLUG WIRE CLEARANCE LH....LC1	C
6Y	C9	N	SPARK PLUG SHIELDS....L39 OR LU5	C
6Y	C10	N	SPARK PLUG WIRING RIGHT SIDE....L39 OR LU5	C
6Y	C11	N	SPARK PLUG WIRING LEFT SIDE....L39 OR LU5	C
6Y	C12	N	EMISSION HOSES....L39 & M18 OR M26	C
6Y	C13	N	EMISSION HOSES....L39 & MV9	C
6Y	C14	N	EMISSION HOSES....LU5 & M18 OR M26	C
6Y	C15	N	EMISSION HOSES....LU5 & MV9	C
6Y	P1	N	GENERATOR MOUNTING...LQ9 & C41	P
6Y	P2	N	GENERATOR MOUNTING....LQ9 & C60	P
6Y	P3	N	STARTER MOTOR....LQ9	P
6Y	P4	N	ENGINE GROUND STRAP....LQ9	P
6Y	P5	N	SPARK PLUG WIRING-REF....LQ9	P
6Y	P6	N	EMISSION HOSES....LQ9 & C41	P
6Y	P7	N	EMISSION HOSES....LQ9 & C60	P
6Z			**MISCELLANEOUS INFORMATION**	
6Z	C1	N	BELT TENSIONING....LC1/L39/LU5	C
6Z	C2	N	PULLEY ALIGNMENT.....LC1/L39/LU5	C
6Z	C3	N	BELT ROUTING....LC1	C
6Z	C4	N	BELT ROUTING....L39 OR LU5	C
6Z	C5	N	EMISSION HOSE ROUTING....LC1	C
6Z	C6	N	EMISSION CONTROLS....L39 & M18 OR M26	C
6Z	C7	N	EMISSION CONTROLS....L39 & MV9	C
6Z	C8	N	EMISSION CONTROLS....LU5 & M18 OR M26	C
6Z	C9	N	EMISSION CONTROLS....LU5 & MV9	C
6Z	P1	N	BELT TENSIONING SPECS....LQ9	P
6Z	P2	N	BELT & PULLEY DIAGRAM....LQ9	P
6Z	P3	N	EMISSION HOSES-REF....LQ9 & C41	P
6Z	P4	N	EMISSION HOSES-REF....LQ9 & C60	P

DYNAMIC (Install) N·m	HAND (Insp.) · N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASB ENG
1 2 3 4 5								

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

227

DATE 23AUG0
DR R.C.TAYLOR
CK H.J.Buck HB
APPR
APPR
APPR
APPR

DIV CHEVROLET

1982 "F" CHEV 14036164

TITLE CONTENTS-ENGINE
FA00(00) ALL (6T THRU 6Z)

REF ECR 91284
NEW 12AU80

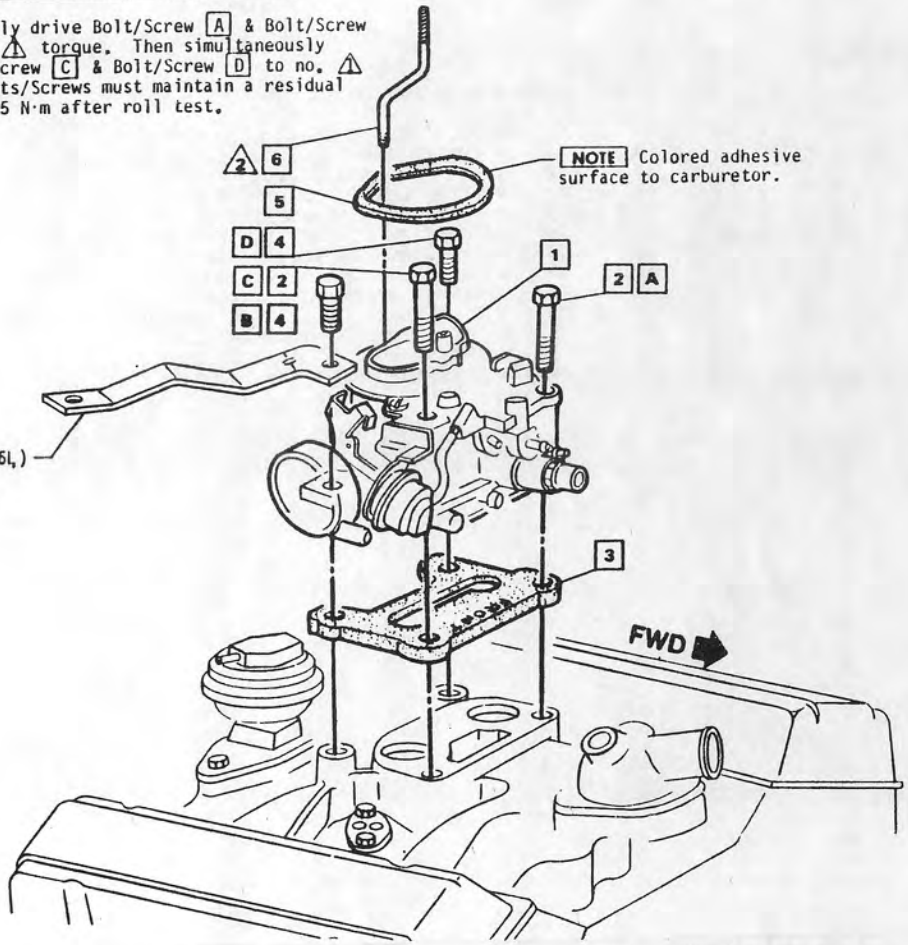
UPC 6M

SHEET 2

C | 0 | 0 | P | Co

ATTACHING BOLT/SCREW TORQUE SEQUENCE

Simultaneously drive Bolt/Screw [A] & Bolt/Screw [B] to no. △ torque. Then simultaneously drive Bolt/Screw [C] & Bolt/Screw [D] to no. △ torque. Bolts/Screws must maintain a residual torque of 8.5 N·m after roll test.



⑥17081134	1	CARB ASM (SHOWN) For specific releasing & additional part numbers, see Parts List.
9419047	2	BOLT/SCREW-CARB FRONT
④14005211	3	INSULATOR ASM (SHOWN) For specific releasing & additional part numbers, see Parts List.
⑤		
9419032	4	BOLT/SCREW-CARB REAR
①14031138	5	SEAL
②	5	
14005212	6	STUD

DYNAMIC (Instal) N·m	HAND (Insp.) - N·m
△1	14-19
△2	4.0-5.0
△3	
△4	
△5	

△ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
23JUL80	1	14031138 WAS 25502695				
	2	25505915 SEAL REMOVED				
	3	BRACKET (6L) ADDED	89016			C
	4	PART REL REF ADDED				
	5	14010231 & 14021887 INSL REM	91392	CU	HG	
ADDED	6	WAS 17081130 CARB	93680	CU	RC	

228

DATE	01FE80
DR	R. LINDNER
CK	Richard Cline RC
APPR	S
APPR	
APPR	
APPR	

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
CARBURETOR
FA00 &LC3 or L39

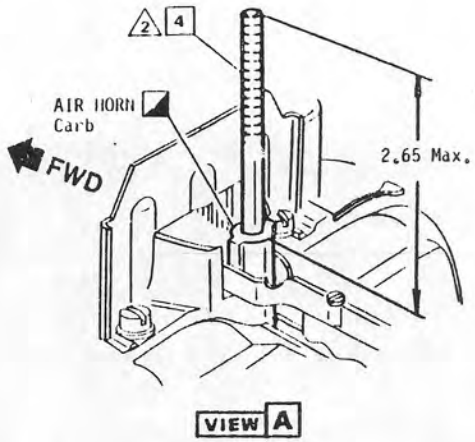
REF ECR 86448
C/O 16JA80
6M-3

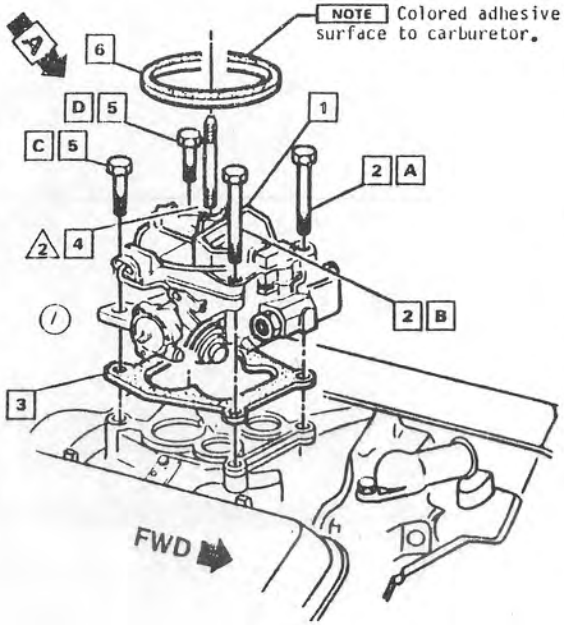
L-18343(S)
L-
L-
L-

UPC 6M

SHEET 3

CK ☒ B ☐ O ☐ P ☒ Co ☐





17081203	1	CARB ASM (SHOWN) For specific releasing & additional part numbers, see Parts List.
9419047	2	BOLT/SCREW-CARB FRT
354310	3	INSULATOR (SHOWN) For specific releasing & additional part numbers, see Parts List.
3737482	4	STUD
9419032	5	BOLT/SCREW-CARB RR
25502694	6	SEAL
25505914	6	OPT

ATTACHING BOLT/SCREW TORQUE SEQUENCE

Simultaneously drive Bolt/Screw [A] & Bolt/Screw [C] to no. △1 torque. Then simultaneously drive Bolt/Screw [B] & Bolt/Screw [D] to no. △1 torque. Bolts/Screws must maintain a residual torque of 8.5 N·m after roll test.

DYNAMIC (Install) N·m	HAND (Insp.) · N·m
△1	14-19
△2	4.0-5.0
△3	
△4	
△5	
△ FULLY DRIVEN, SEATED & NOT STRIPPED	

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
111160	1	CRKT (C.N) DWG REM	88101	CU	RE	C

229

DATE 01FE80
DR R.LINDNER
CK R. Lindner
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE CARBURETOR FA00 & LG4 or LM1

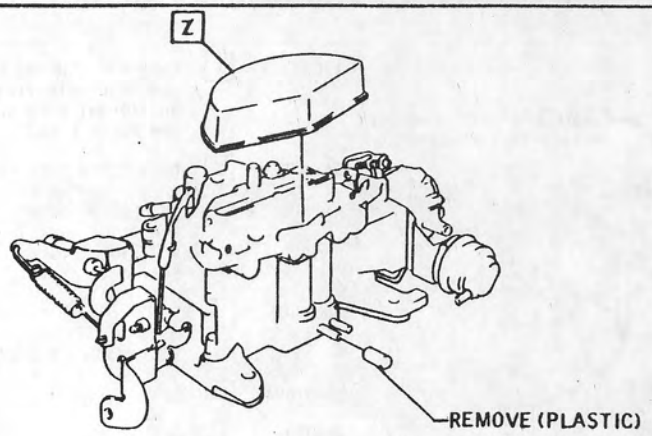
REF ECR 86448 C/O 16JA80 6M-4

L-08290 L-2 OF 3 (S) L- L-

UPC 6M

SHEET 4

Ch X B O P X Ca



LD5

Z COVER-CARBURETOR PROTECTION (REMOVE PRIOR TO INSTALLATION OF AIR CLEANER).

DYNAMIC (Instal) N.m	HAND (Insp.) N.m	DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
		20JN80		ISSUED	8L448	RL	HB	
				230				

1 2 3 4 5
⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

Ch X B X O X P X Ca X

DATE 04JA80
DR MAC DORMOTT
CK
APPR
APPR
APPR
APPR

DIV CHEVROLET

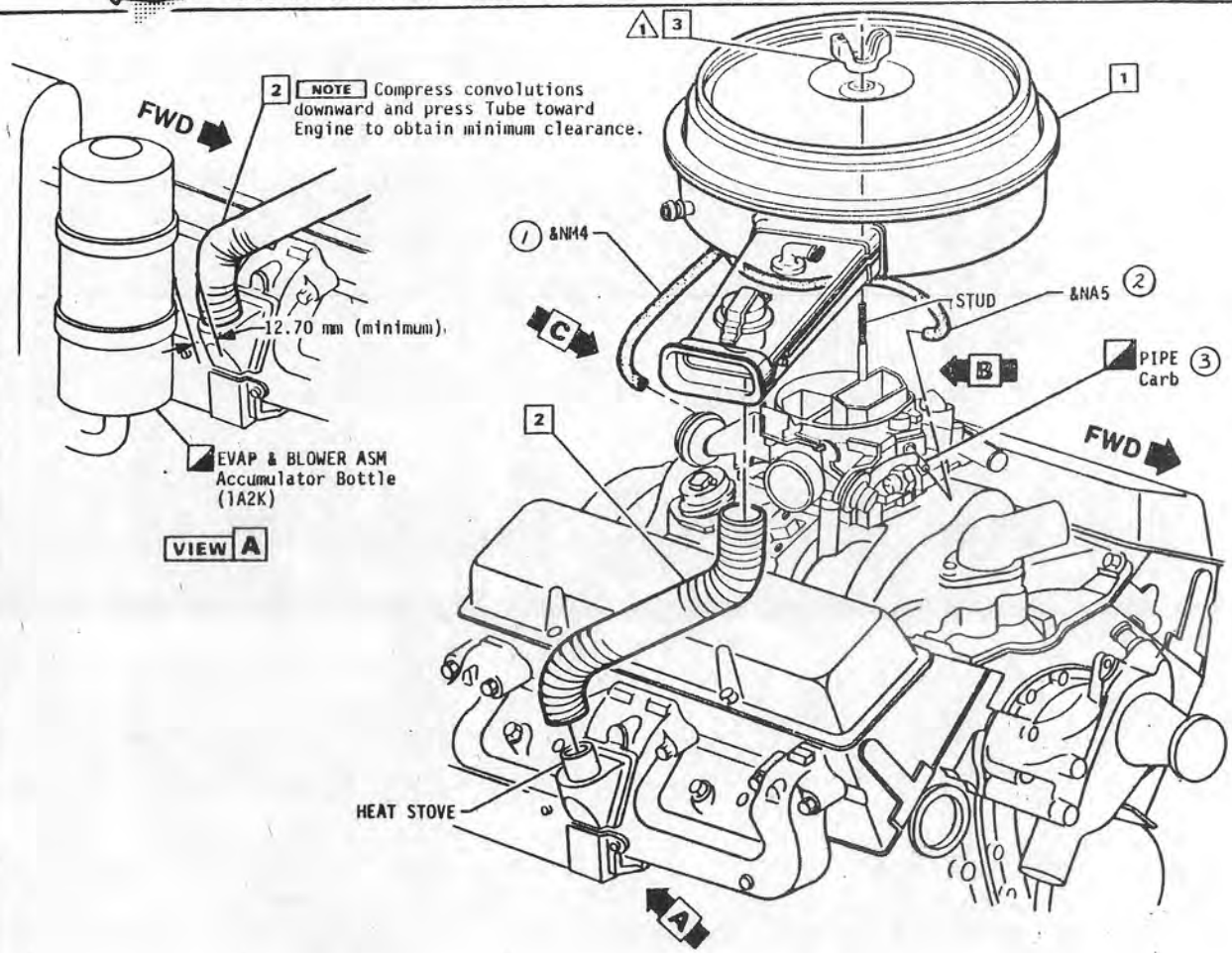
1981 CHEV. "F" 14020867

TITLE CARBURETOR COVER & VACUUM PLUG A00 &LD5

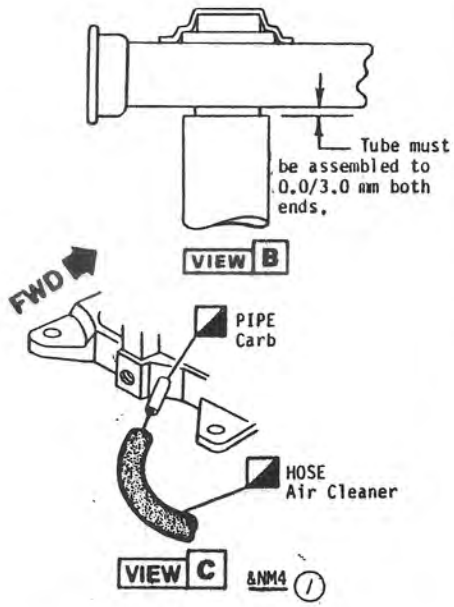
REF ECR 86448
C/O 10JN80
6M-2 RL

UPC 6M

SHEET 5



25040287	1	AIR CLEANER (SHOWN) For specific releasing & additional part numbers, see Parts List.
14020671	2	TUBE
148312	3	NUT



DYNAMIC (Install) N·m	HAND (Insp.) · N·m
1	1.6-2.8
2	
3	
4	
5	

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
08DEC80	1	"&NM4" ADDED (2) PLCS	88871			
	2	"&NA5 HOSE ADDED				C
	3	"CARB PIPE" REFADDED	91222	CLT	SH	C

23i

DATE 01MY80
DR R LINDNER
CK
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE AIR CLEANER
FA00 & LG4 or LM1

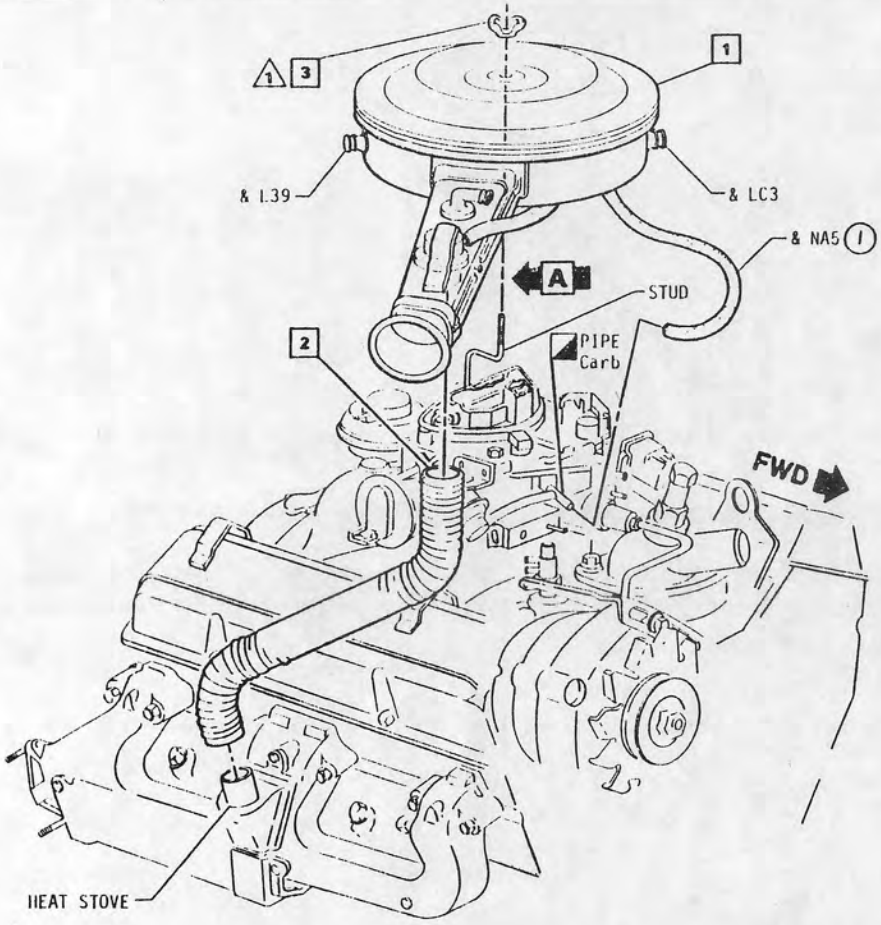
REF ECR 86448
C/O 23AP80
6M-10

L-98044 (S)
L-
L-
L-

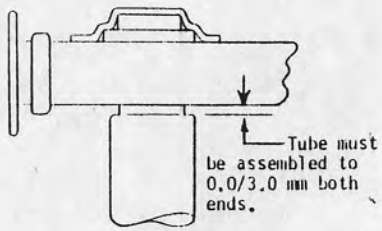
UPC 6M

SHEET 6

Cb X B O P X Ca



25040284	1	AIR CLEANER & LC3
25040286	1	& L39 & NB1
25040698	1	& L39 & NM4
14020672	2	TUBE ASM-ENG AIR HEAT STOVE & LC3
14020671	2	& L39
9418700	3	NUT



VIEW A

DYNAMIC (Install) N·m	HAND (Insp.) · N·m
1	1.6-2.8
2	
3	
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
27JN80	/	" & NA5" ADDED	88871	CU	JH	
		232				

DATE 01AUG80
DR R. LINDNER
CK
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
AIR CLEANER
FA00 & LC3 or L39

REF ECR 86448
NEW 21AP80

L-18733 (S)
L-
L-
L-

UPC 6M

SHEET 7

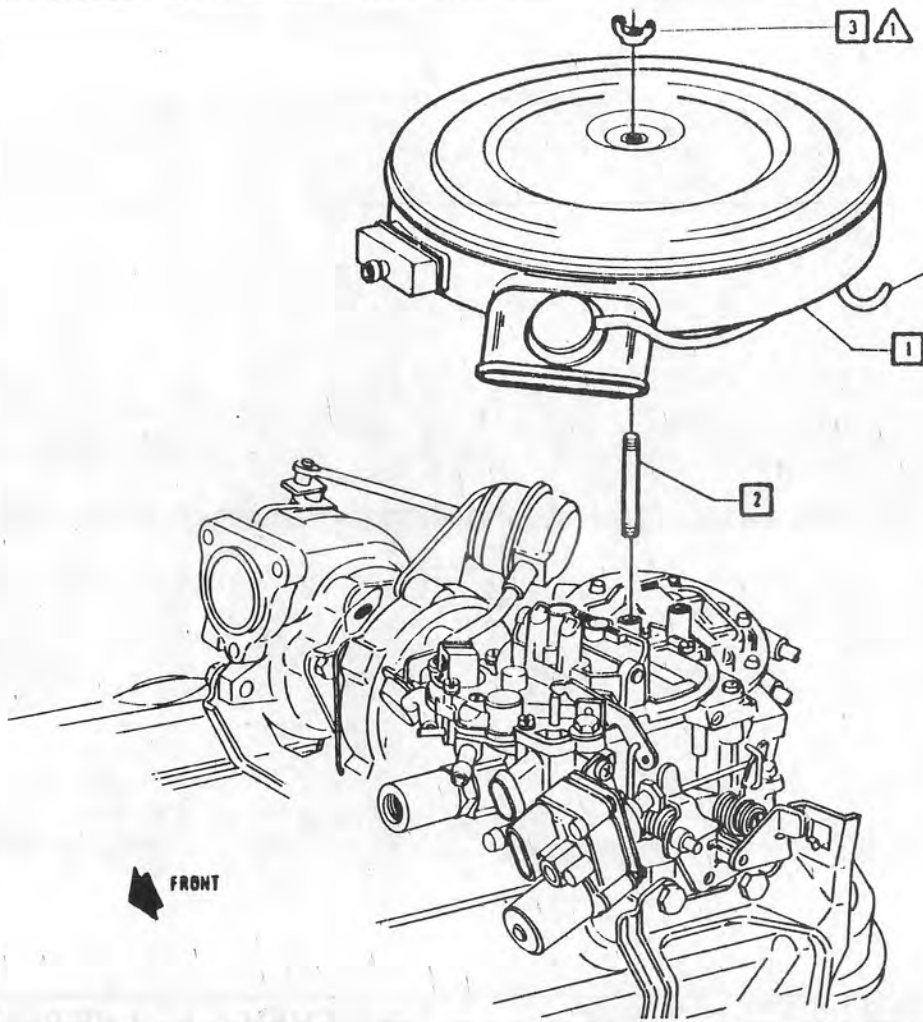
Ch ☒ B ☐ O ☐ P ☒ Ca ☐

PONTIAC MOTOR DIVISION

General Motors Corporation Pontiac, Michigan

PRODUCT DESCRIPTION MANUAL

☐ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF



25040178	1	CLEANER ASM.
546515	2	STUD
148312	3	NUT

CANCELED

DYNAMIC (Install) N·m	HAND (Insp.) N·m
1	1.4 - 2.2
2	
3	
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
12JA80		ISSUED	86448	RL	KS	
29JA80	1	SHEET CANCELED	91222	CU	KE	

233

DATE	07 NO 79
DR	G.M. VERSTRAETE
CK	JEB
APPR	S
APPR	DLM
APPR	
APPR	

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE AIR CLEANER FA00 &LU8

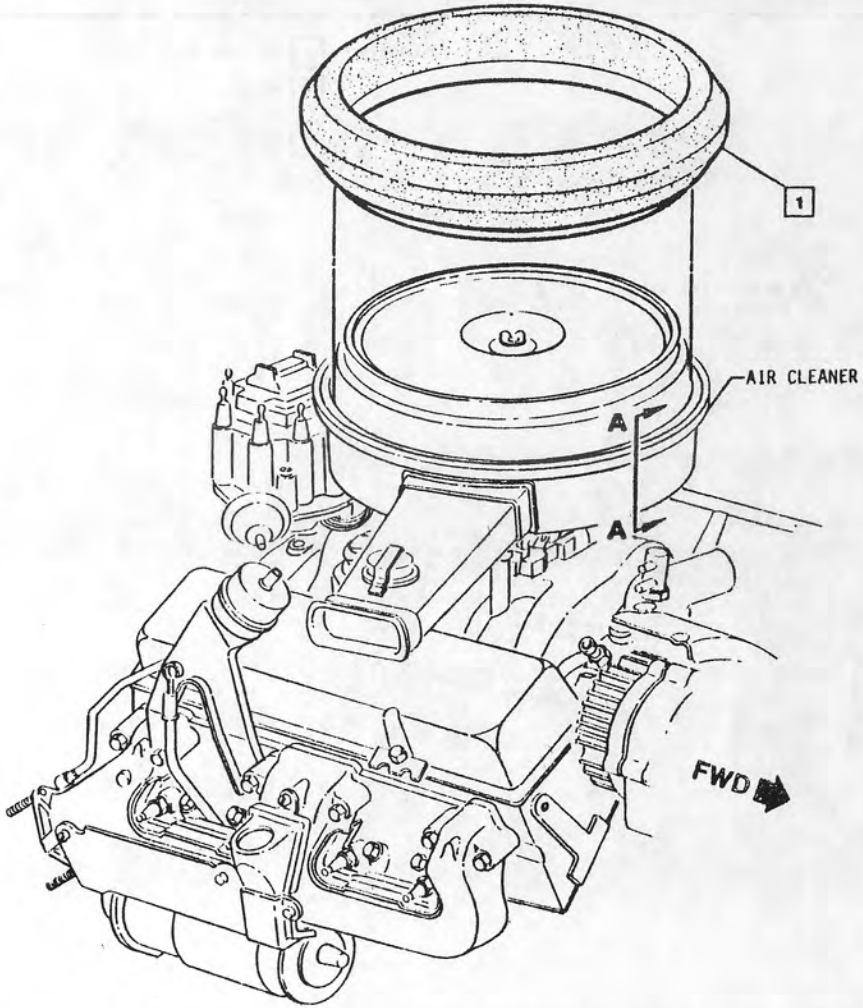
REF ECR 86448 C/O 16JA80 6M-13 RL

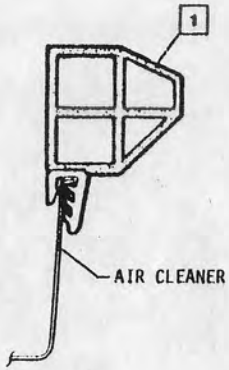
MPC 6M

SHEET 9

Ch X B O P Cu

14013425 [1] SEAL ASM





SECTION A–A–INSTALLED

DYNAMIC (Install) N·m	HAND (Insp.) · N.m	DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
1 2 3 4 5				234				

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	11AP80
DR	R. LINDNER
CK	Richard Allen RC
APPR	(S)
APPR	
APPR	
APPR	

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
AIR CLEANER SEAL
FP00 & Z28

REF ECR 86448
C/O 25MR80
6M-13.1

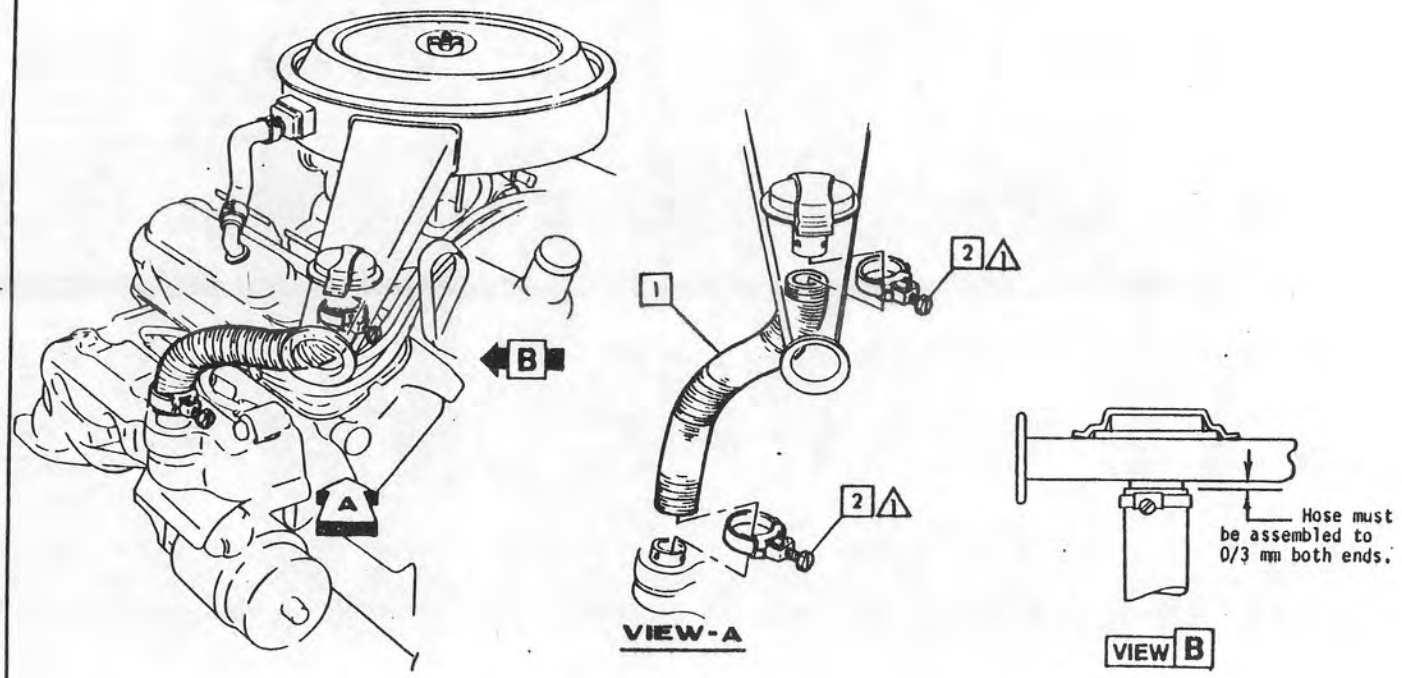
L-20092 (S)
L-
L-
L-

UPC 6M

SHEET 10

Ch X B O P Cu

1254731	1	TUBE ASM
9414931	2	CLAMP



DYNAMIC (Instal) N.m	HAND (Insp.) - N.m	DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
	△1 1.6 - 2.2	20JN80		ISSUED	RKA48	RL	HB	
	△2							
	△3							
	△4							
	△5							
	△1 FULLY DRIVEN, SEATED & NOT STRIPPED			235				

DATE 22JA79
DR MAC DORMOTT
CK
APPR
APPR
APPR
APPR

DIV CHEVROLET

REF ECR 86448
C/O 10JN80
6M-8 RL

1981 CHEV. "F" 14020867

TITLE
ENGINE HEAT CONTROL
FA00 &LD5

UPC 6M

SHEET 11

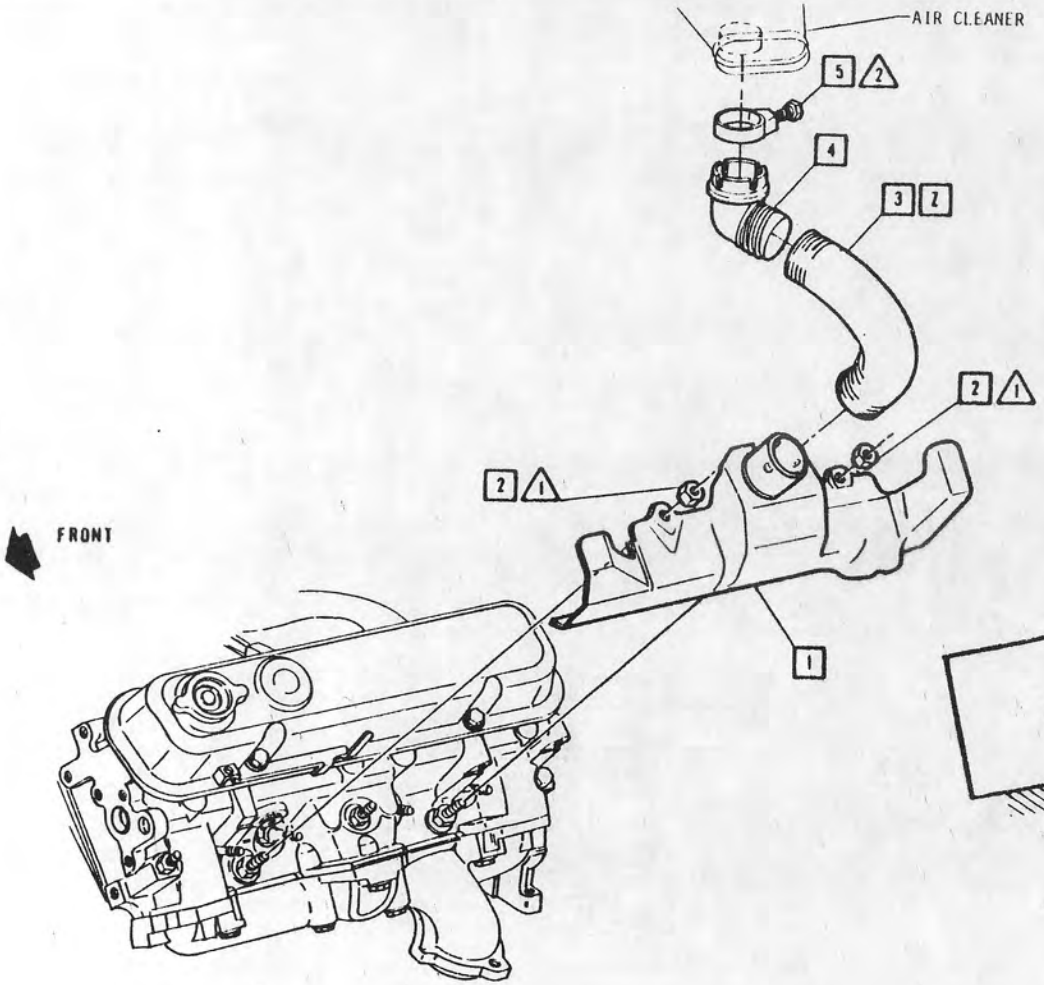
Ch X 8 X 0 X P X Ca

PONTIAC MOTOR DIVISION

General Motors Corporation Pontiac, Michigan

PRODUCT DESCRIPTION MANUAL

□ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF



10014575	1	STOVE ASM
9418931	2	NUT
10014408	3	TUBE ASM.
498539	4	ADAPTER (LU8)
274765	5	CLAMP ASM

Z TUBE MUST BE INSTALLED WITH END FIRMLY SEATED AGINST STOVE ASM. TO INSURE ADEQUATE RETENTION. PROPER INSTALLATION MAY REQUIRE SLIGHT STRECHING OF TUBE AFTER BENDING.

CANCELED

DYNAMIC (Instal) N.m	HAND (Insp.) - N.m
1	26.0 - 48.0
2	1.6 - 2.2
3	
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
14APR80		ISSUED	86448	RL		
29APR80	1	SHEET CANCELED	91222	CU		

236

DATE 18 DE 79
DR G.M. VERSTRAETE
CK JEB
APPR
APPR
APPR DLM
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE ENGINE HEAT CONTROL FA00 & LU8

REF ECR 86448
NEW 26FE80
6M-9 RL

UPC 6M

SHEET 12

Ch X B X D P X Co

PONTIAC MOTOR DIVISION
General Motors Corporation Pontiac, Michigan

PRODUCT DESCRIPTION MANUAL
☐ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF

10012353 [1] SWITCH ASM.
3043807 OPT.

497548 [2] RETAINER

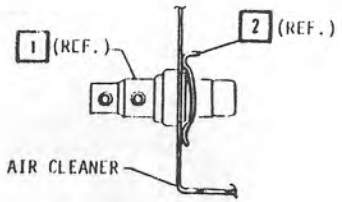
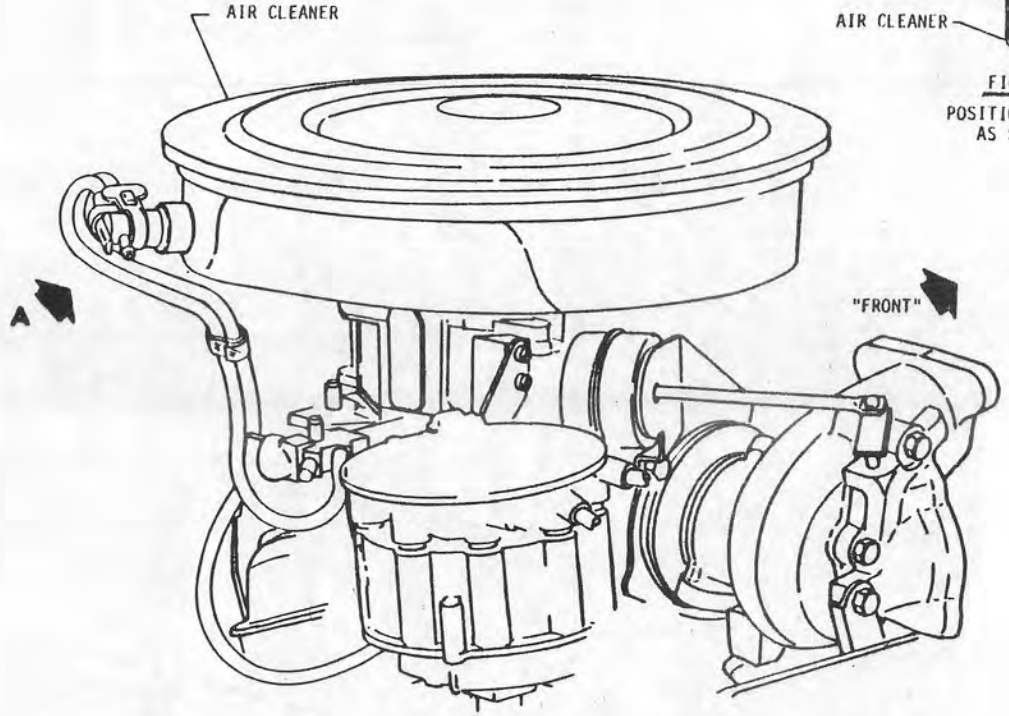
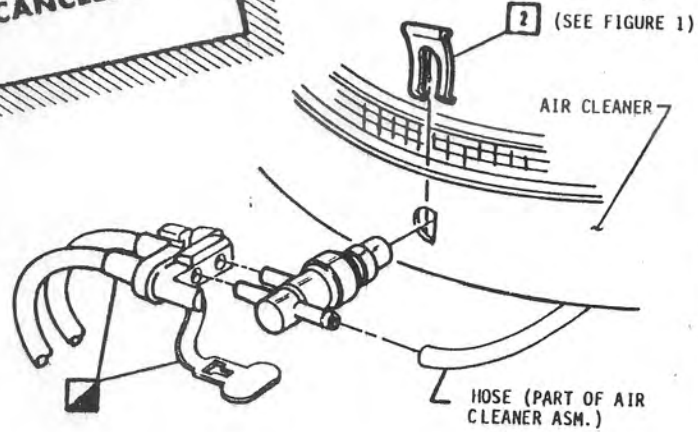


FIGURE 1
POSITION RETAINER AS SHOWN



CANCELED



VIEW A

DYNAMIC (Instal) N.m	HAND (Insp.) N.m
⚠1	
⚠2	
⚠3	
⚠4	
⚠5	

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
20MR80		ISSUED	86448	RL	RC	
30MAR80	1	SHEET CANCELED	91222	CU	RE	

237

DATE 10 JA 80
DR G.M. VERSTRAETE
CK JEB
APPR JCW
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

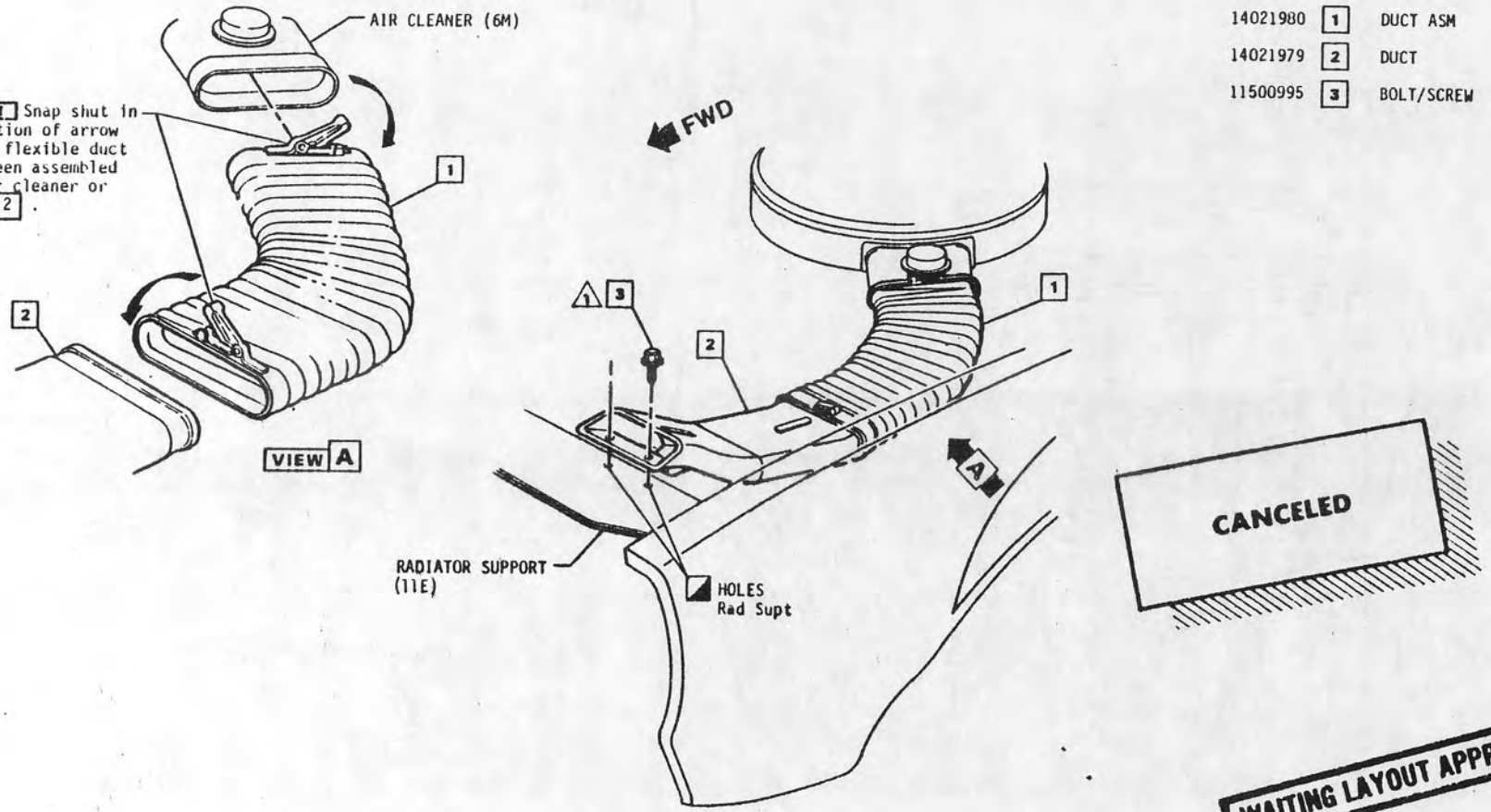
TITLE S.V.B./THERMO VACUUM VALVE F&00 &L08

REF ECR 86448
NEW 01MR80

UPC 6M

SHEET 13

Ch ✕ 0 0 P ✕ Ca



14021980	1	DUCT ASM
14021979	2	DUCT
11500995	3	BOLT/SCREW

CANCELED

WAITING LAYOUT APPROVAL

DYNAMIC (Install) N·m	HAND (Insp.) · N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
	1 4.6-7.0 .	29AU80	1	SHEET CANCELED	91222	CU		
	2							
	3							
	4							
	5							
	1 FULLY DRIVEN, SEATED & NOT STRIPPED			238				

DATE 30APR80
DR R. LINDNER
CK
APPR NS
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE CARBURETOR AIR INTAKE
FA00 & LU8

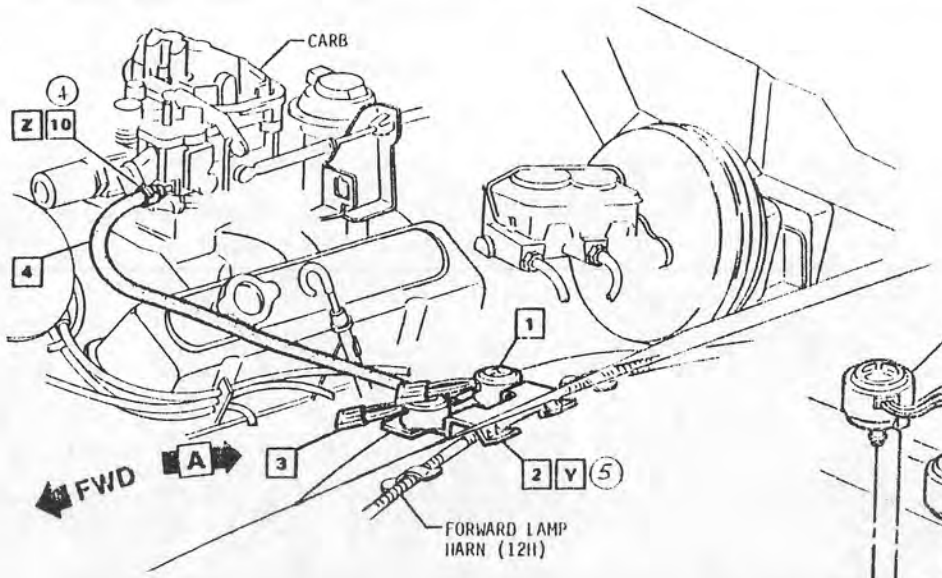
REF ECR 86448
C/O 18AP80
6M-18

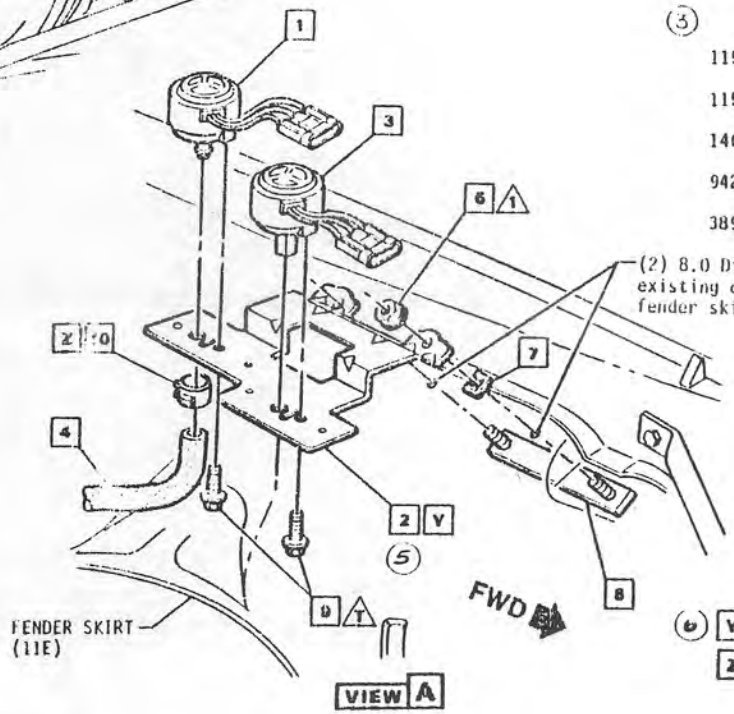
L-23648 (NS)
L-
L-
L-

UPC 6M

SHEET 14

C X B O P Ca





1620212	1	SENSOR ASM-M.A.P.	
(7) 16006835	1	OPT	
14034348	2	BRACKET ASM	
1620213	3	SENSOR ASM-BARO	
(8) 16006833	3	OPT	
(2) 9439498	4	HOSE	
(3)	5		
11503745	6	NUT	
11503736	7	RETAINER-PUSH ON	
14034346	8	PLATE ASM	
9420494	9	BOLT/SCREW	
3899723	10	CLAMP	

(2) 8.0 Dia. holes at existing dimples in L.H. fender skirt.

(6) Y See UPC 15D for paint specs.

Z See UPC "0A" for clamping instructions.

DYNAMIC (Install) N·m	HAND (Insp.) N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
△1 8.5-11		1NOV80	1	REDRAWN & REDESIGNED	90949	CU	RE	C
△2		15EP81	2	WAS 9438920 HOSE				
△3			3	NO P/N CLAMP REM				
△4			4	ITEM 10 WAS ITEM 5	P1980			
△5			5	ITEM 2 REV (2) PLACES	92409	CU	RE	C
		13OCT80	6	NOTE "Y" ADDED	92409	CU	RE	C
		13MY81	7	16006835 SENSOR ADDED				
△ FULLY DRIVEN, SEATED & NOT STRIPPED			8	16006833 SENSOR ADDED	96612	CU		

239

DATE	30 AP 80
DR	R. LINDNER/CU
CK	
APPR	S
APPR	
APPR	
APPR	

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE MANIFOLD ABSOLUTE PRESSURE AND BARO SENSOR FA00 & LD5 & NB1

REF ECR 86448 NEW 21AP80

L-22003 (S)
L-
L-
L-

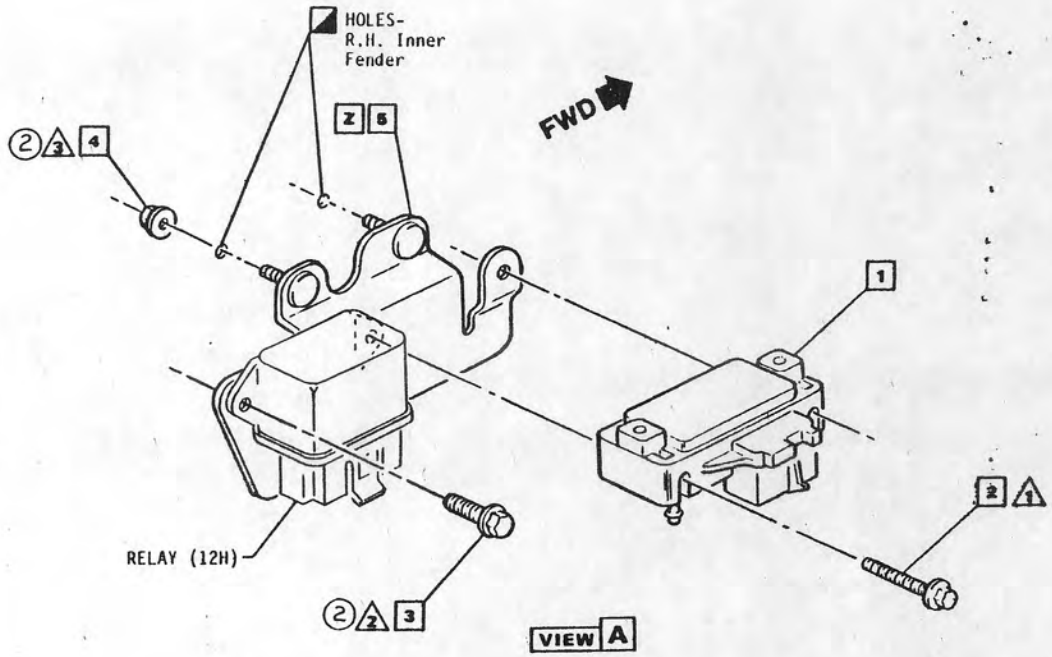
UPC 6M

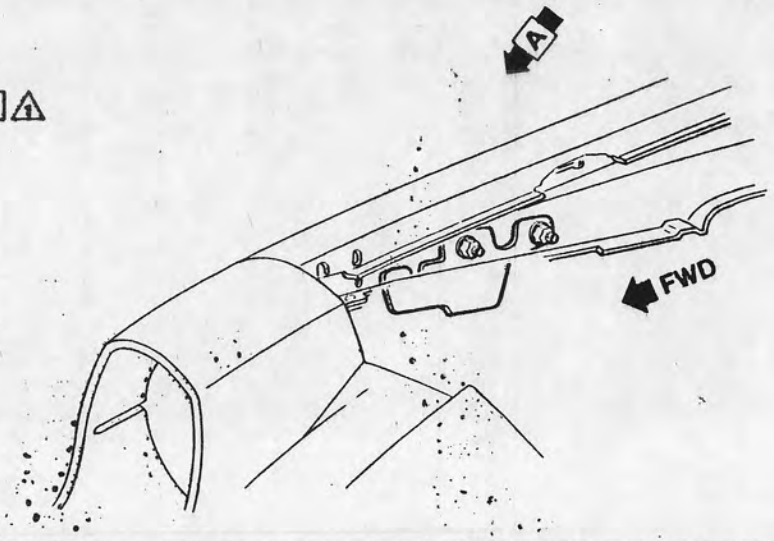
SHEET 15

C X B D P Co

16006834	1	SENSOR ASM-MANIFOLD DIFF. PRESSURE
(3) 11505831	2	BOLT/SCREW
11505439	3	BOLT/SCREW
11503745	4	NUT ASM
14032059	5	BRACKET

(1) Z See 15D for paint specs.





DYNAMIC (Install) N·m | HAND (Insp.) N·m

△1 1.5 - 2.0
△2 8-14
△3 16-22
△4
△5

△1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
12SEP80	1	"Z" NOTE ADDED	B9617	CU	RB	C
23OCT80	2	TORQS (2)&(3) ADDED	BG498	CU	RB	C
20DEC80	3	WAS 11505377 BOLT	94040	CU	RB	

240

DIV CHEVROLET

DATE 18APR80
DR R. KOCH
CK [illegible] TH
APPR S
APPR
APPR
APPR

1981 CHEV. "F" 14020867

TITLE MANIFOLD DIFF. PRESSURE SENSOR
FA00 &LG4 &M24 &NB1

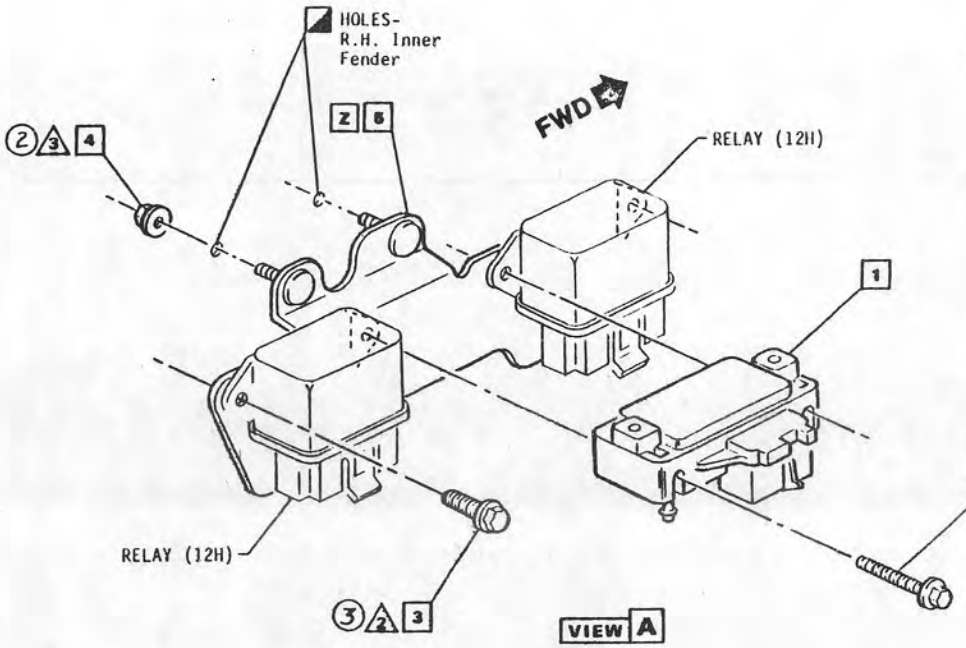
REF ECR 86448
NEW 15AP80

L-22003 (S)
L-
L-
L-

UPC 6M

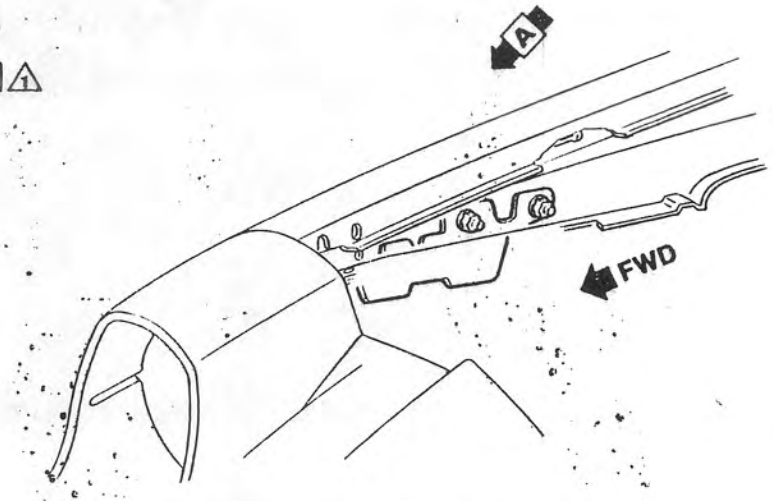
SHEET 15.1

C X B 0 P X Co



16006834	1	SENSOR ASM-MANIFOLD DIFF. PRESSURE
(4) 11505831	2	BOLT/SCREW
11505439	3	BOLT/SCREW
11503745	4	NUT ASM
14032058	5	BRACKET

(1) Z See 15D for paint specs.



MIC (Install) N·m	HAND (Insp.) · N·m
1	1.5 - 2.0
2	8-14
3	16-22
4	
5	

FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
12SEP80	1	"Z" NOTE ADDED	896.17	CU		C
23OCT80	2	TORQUE ADDED				C
	3	TORQUE WAS 1.5-2.0	8644B	CU		C
20DEC80	4	WAS 11505377 BOLT	6A040	CU		

241

DATE 18 NOV 80
DR R. KOCH
CK
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE MANIFOLD DIFF. PRESSURE SENSOR
FA00 &LG4/L39 &MV4 &NB1;
&LM1 &MX3 &NB1

REF ECR 86448
NEW 15AP80

L-22003 (S)
L-
L-
L-

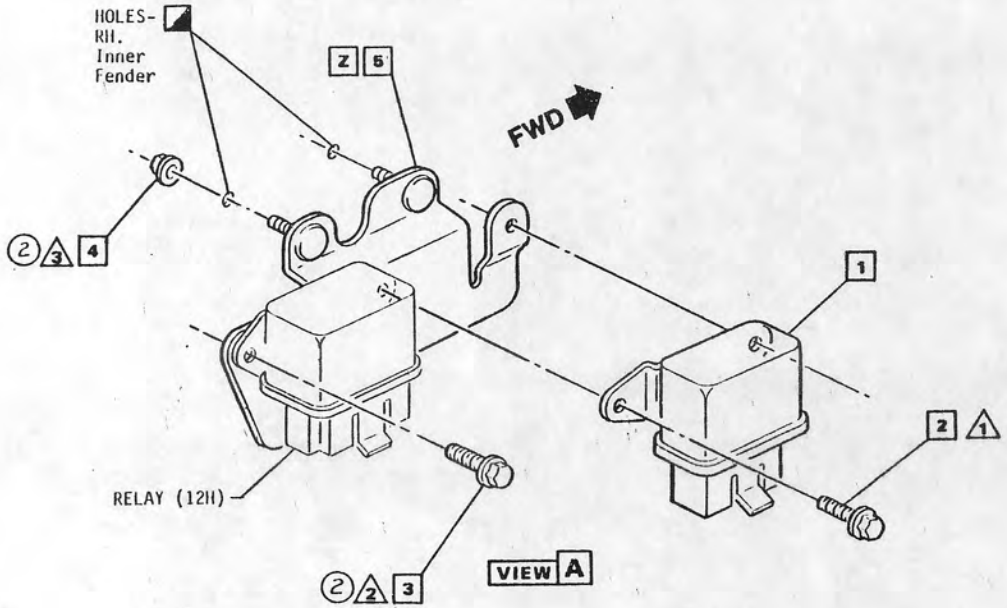
UPC 6M

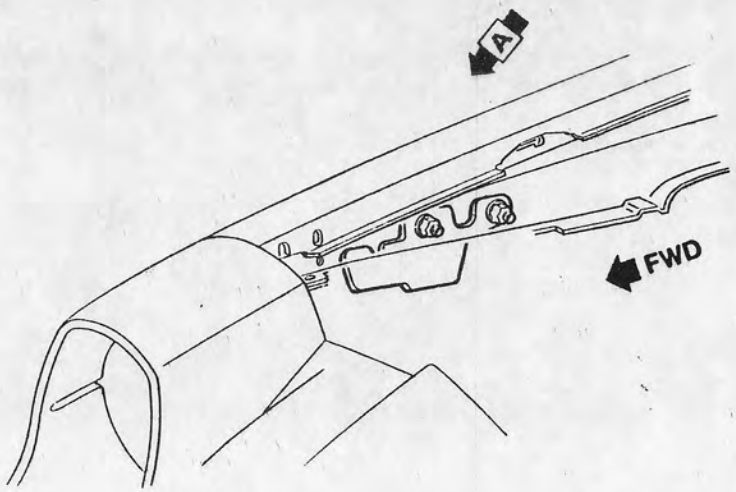
SHEET 15.2

I O P Co

14029547	1	MODULE ASM-RPM SIGNAL CONDITIONER
11503540	2	BOLT/SCREW
11505439	3	BOLT/SCREW
11503745	4	NUT ASM
14032059	5	BRACKET

(1) Z See 15D for paint specs.





DYNAMIC (Instal) N·m	HAND (Insp.) N·m
△1	1.5 - 2.0
△2	8-14
△3	16-22
△4	
△5	

△1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
12 SEP 80	1	"Z" NOTE ADDED	89617	CU	AD	C
23 OCT 80	2	TORQS (2) & (3) ADDED	86448	CU	AD	C

242

DATE 18APR80
DR R. KOCH
CK
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
R.P.M. SIGNAL CONDITIONER
FA00 &LC3 &M64 &NB1

REF ECR 86448
NEW 15AP80

1-22003 (S)

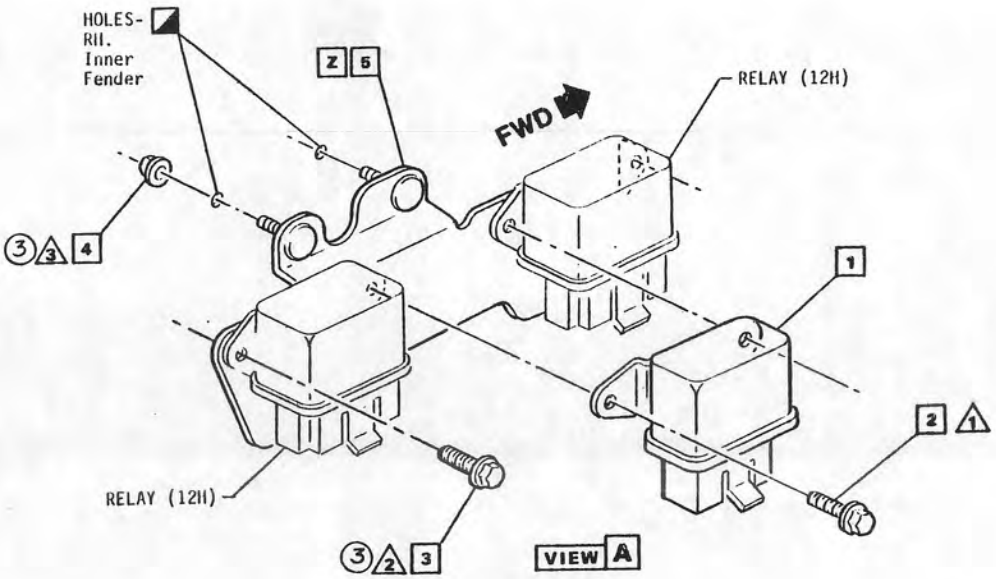
UPC 6M

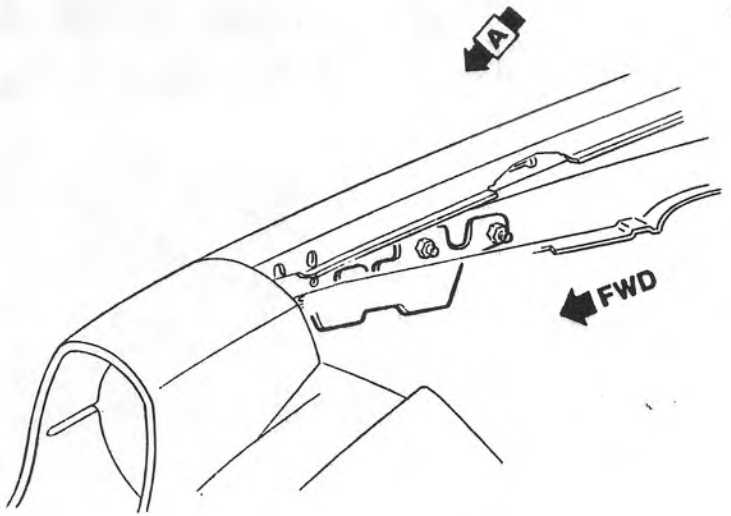
SHEET 15.3

C X B O P X Ca

14029547	1	MODULE ASM-RPM SIGNAL CONDITIONER
11503540	2	BOLT/SCREW
11505439	3	BOLT/SCREW
11503745	4	NUT ASM
14032058	5	BRACKET

(1) Z See 15D for paint specs.





DYNAMIC (Instal) N·m	HAND (Insp.) · N·m
1	1.5 - 2.0
2	8-14
3	16-22
4	
5	
⚠ FULLY DRIVEN, SEATED & NOT STRIPPED	

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
12SEP80	1	"Z" NOTE ADDED	B9617	CU	AJ	C
030CT80	2	"MV9" REMOVED	01615	CU	RCT	
230CT80	3	TORQUES (2) & (3) ADDED	86448	CU	AJ	C

243

DATE 18APR80
DR R. KOCH
CK
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE R.P.M. SIGNAL CONDITIONER FA00 &LC3 &M31 &NB1 (2)

REF ECR 86448 NEW 15AP80

L-22003 (S) L- L- L-

UPC 6M

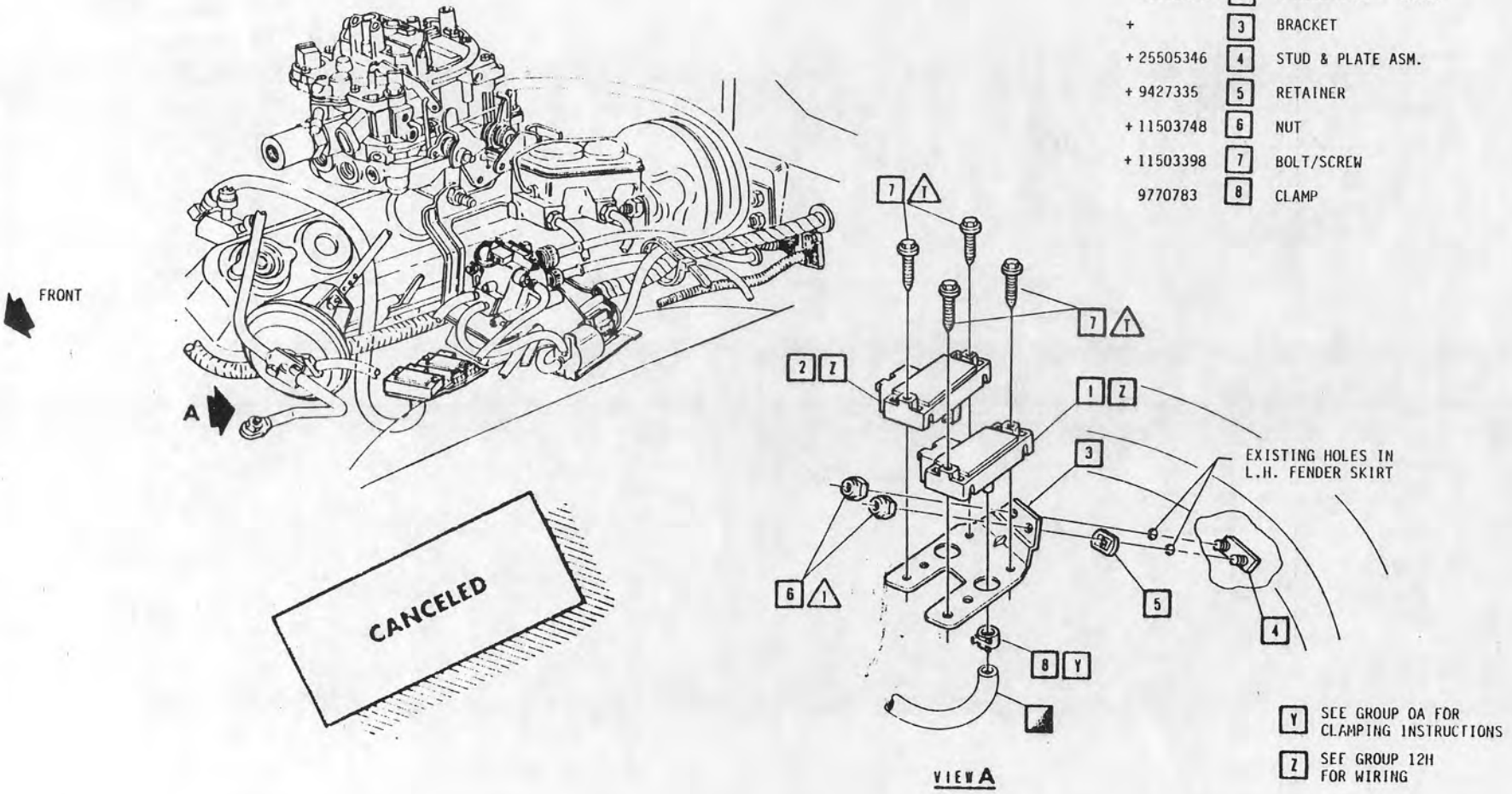
SHEET 15.4

C X B | O | P X Cu

PONTIAC MOTOR DIVISION
General Motors Corporation Pontiac, Michigan

PRODUCT DESCRIPTION MANUAL
□ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF

16009886	1	SENSOR ASM. - M.A.P.
16006833	2	SENSOR ASM. - BARO.
+	3	BRACKET
+ 25505346	4	STUD & PLATE ASM.
+ 9427335	5	RETAINER
+ 11503748	6	NUT
+ 11503398	7	BOLT/SCREW
9770783	8	CLAMP



VIEW A

Y SEE GROUP 0A FOR CLAMPING INSTRUCTIONS

Z SEE GROUP 12H FOR WIRING

DYNAMIC (Instal) N.m	HAND (Insp.) - N.m
△1 14 - 20	
△2	
△3	
△4	
△5	

△ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
01MY80		ISSUED	86448	KJ	[illegible]	
1NJL80	1	SHT CANCELED	91222	CJ	K2	

244

DATE 19 MR 80
DR G.M.VERSTRAETE
CK
APPR
APPR
APPR
APPR

DIV. CHEVROLET

1981 CHEV. "F" 14020867

TITLE MANIFOLD ABSOLUTE PRESSURE SENSOR AND BARO SENSOR FA00 & LU8 & NB1

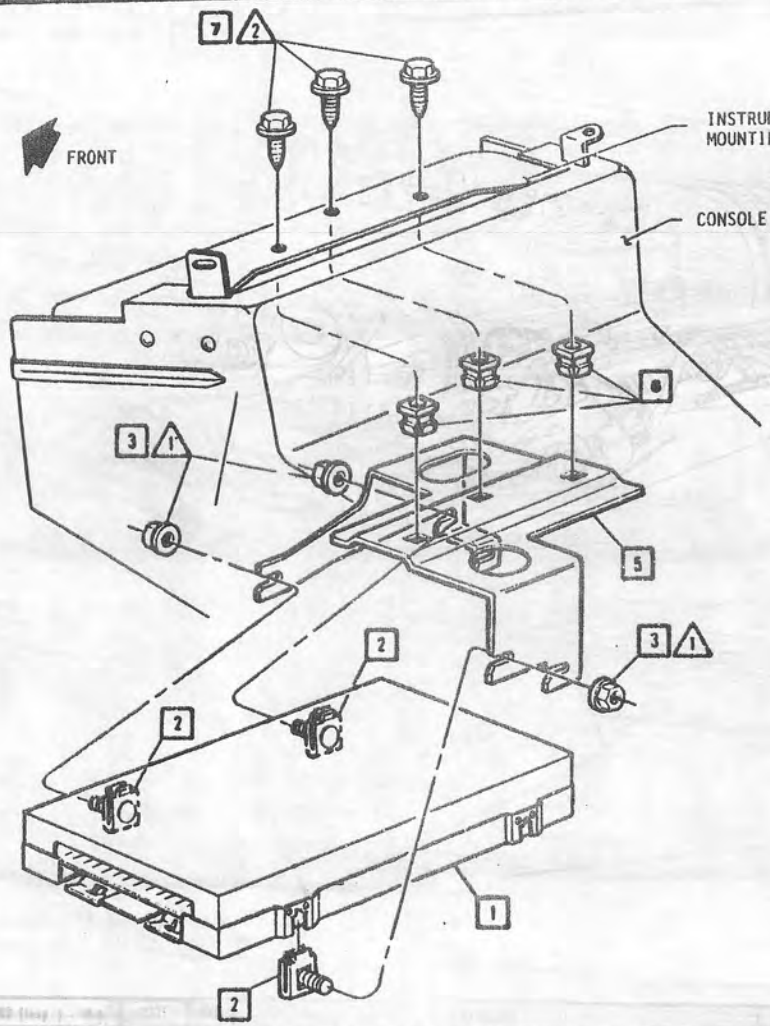
REF ECR 86448
NEW 21AP80
6M-14.1 RL

UPC 6M

SHEET 15.6

Ch X B O P X Co

Sale 4330



3 1	16011811	1	MODULE ASM-ELEC FUEL CONTROL (SHOWN) - FOR SPECIFIC RELEASING & ADDITIONAL PART NUMBERS SEE PARTS LIST.
	469088	2	BOLT - CLIP
4 2	11501814	3	NUT
		4	
	10013257	5	BRACKET
	3919773	6	NUT
	11502843	7	SCREW

DYNAMIC (Install) N.m	HAND (Insp.) - N.m
1	1.2 - 1.6
2	5.5 - 8.0
3	
4	
5	

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION
14MR80		ISSUED
18JL80	1	WAS 16012774 MODULE
29AU80	2	WAS 11501814 NUT
22AP81	3	WAS 16011741 MODULE
08JL81	4	WAS 1611402 NUT

245

	AUTH	DR	CK	ASM ENG
	86-145	RL	RL	
	91084	CU	RL	
	92616	CU	RL	
	96511	CU	NB	
	97238	CU	RA	

DATE 13 DE 79
DR G.M. VERSTRAETE
CK JEB
APPR CCA
APPR CMP
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE ELECTRONIC FUEL CONTROL MODULE FA0O &NB1

REF ECR 86448 NEW 29FE80 6M-26 RL

2 1- 88651 1- 1-

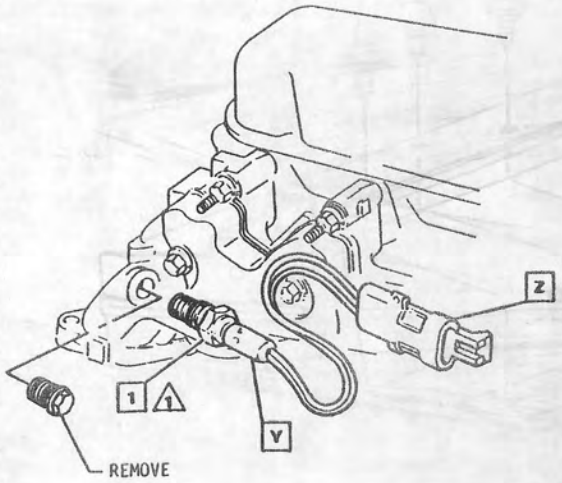
UPC 6M

SHEET 16

Ch X B Ca

FORM 4330

8990346 [1] SENSOR ASM-EXHAUST OXYGEN



[Y] CORRECT BOOT LOCATION. DO NOT PUSH BOOT OVER SENSOR. A CLEARANCE OF 11.3 ± 4.3 MUST BE MAINTAINED BETWEEN BOOT & FLANGE.

[Z] FOR CONNECTION TO HARNESS & ROUTING SEE UPC 12H.

DYNAMIC (Instal) N.m	HAND (Insp.) - N.m
1	38-46
2	
3	
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
20JN80		ISSUED	86448	RL	HB	

DATE
DR MAC DORMOTT
CK A.H. Hendrickson
APPR
APPR
APPR
APPR 24-AUG

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE EXHAUST OXYGEN SENSOR
FA00 &LD5 &NB1

REF ECR 86448
NEW 09JN80
R.L.

UPC 6M

SHEET 17

BUICK FORM 7160

246

Ch B O P Cu

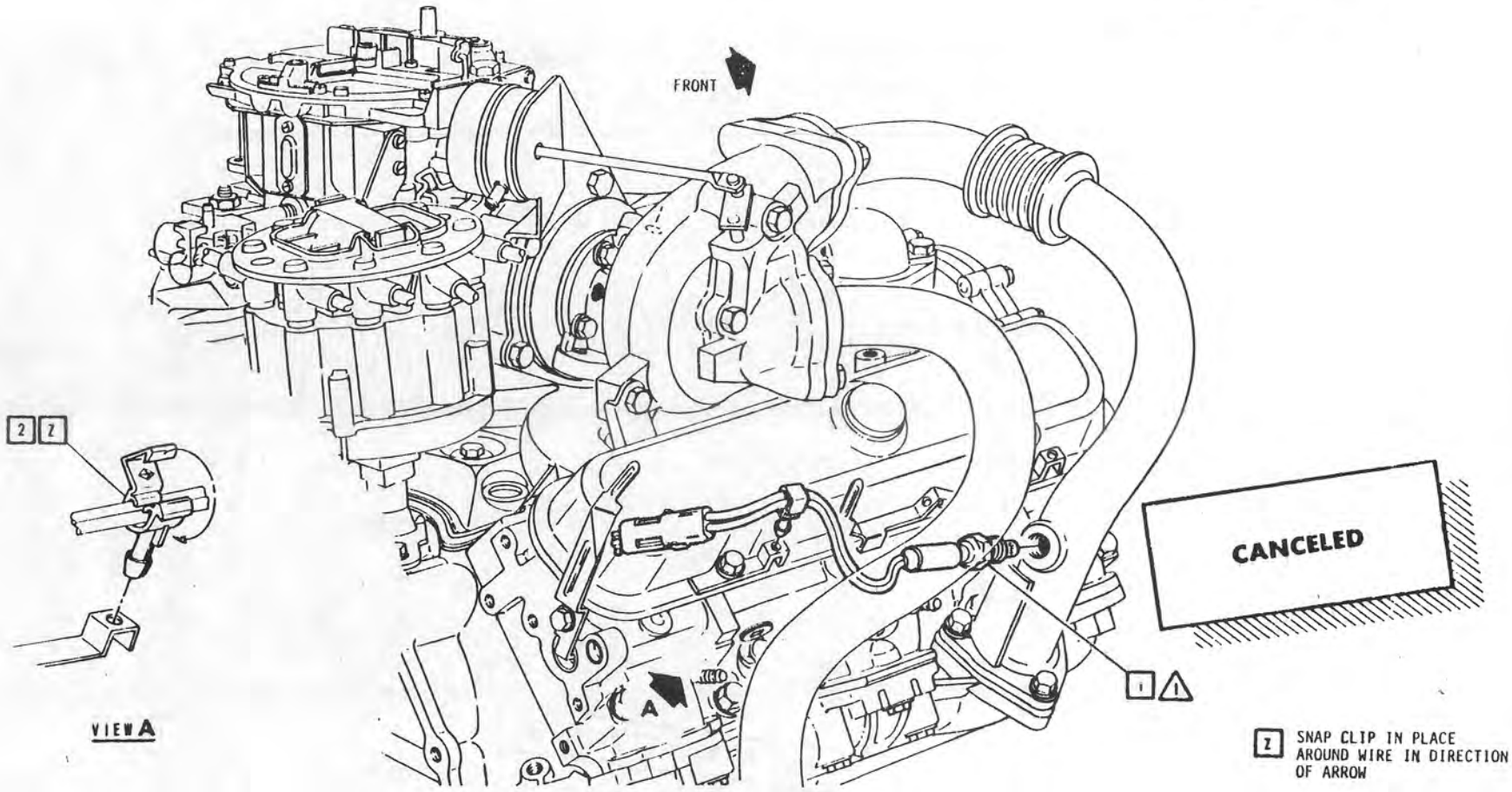
PONTIAC MOTOR DIVISION

General Motors Corporation Pontiac, Michigan

PRODUCT DESCRIPTION MANUAL

☐ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF

8990346	1	SENSOR ASM.
+8900116	2	CLIP



DYNAMIC (Instal) N.m	HAND (Insp.) - N.m
△1	
△2	
△3	
△4	
△5	

△1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
4MY80		ISSUED	86448	RL	[illegible]	
23AUG80	1	SHEET CANCELLED	91222	CU	[illegible]	

247

DATE	25 MR 80
DR	G.M. VERSTRAETE
CK	JEB
APPR	[illegible]
APPR	
APPR	
APPR	

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE EXHAUST OXYGEN SENSOR FA00 & LU8 & NB1

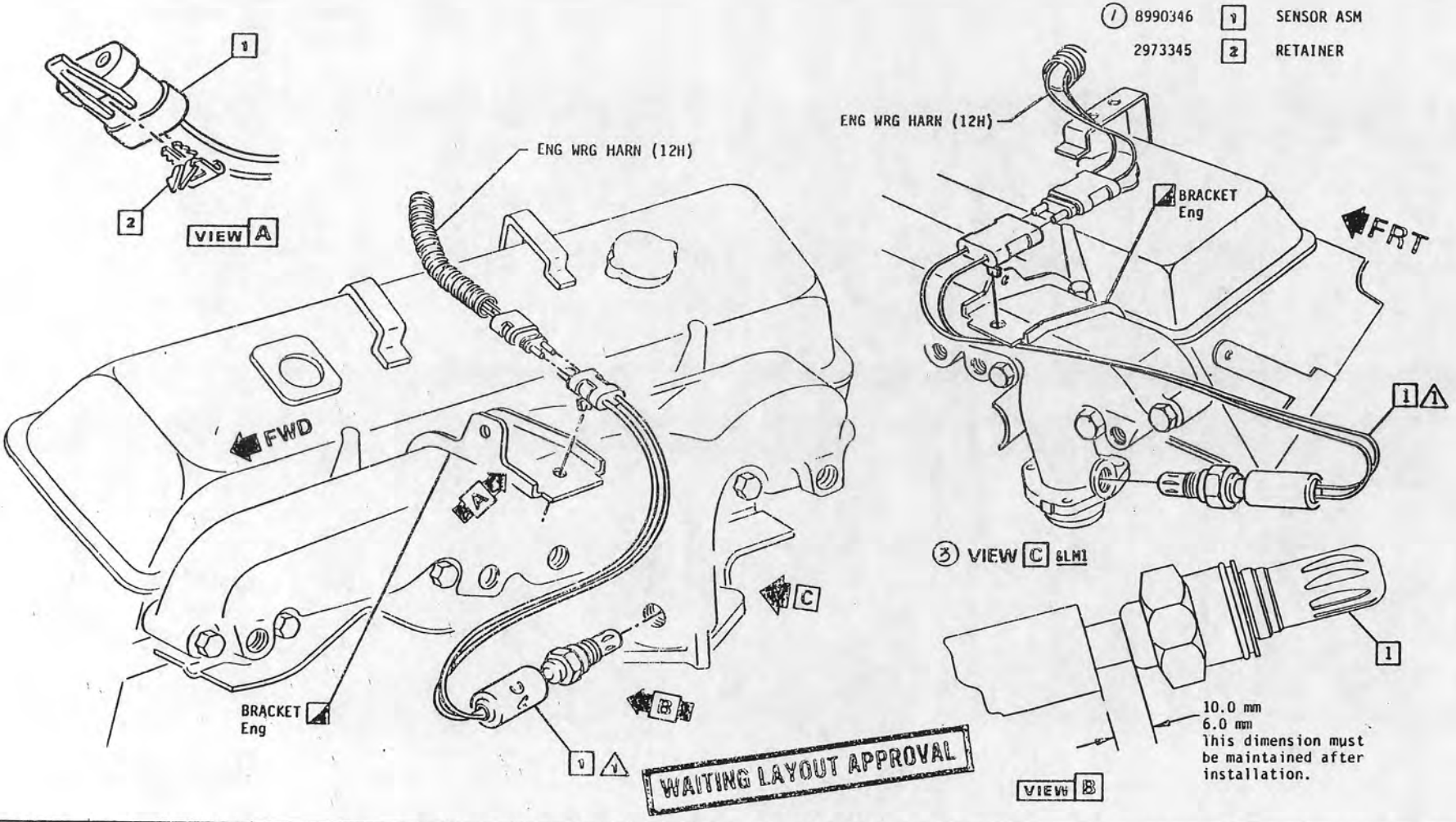
REF ECR 86448
NEW 21AP80
6M-3.1 RL

UPC 6M

SHEET 17.1

Ch X D O P X Co

Edit 4330



DYNAMIC (Install) N·m	HAND (Insp.) · N·m
1	38 - 46
2	
3	
4	
5	

1 FULLY DRIVEN, SEATED & HOT STRIPPED

DATE	SYS	REVISION	AUTH	DR	CK	ASM ENG
18JL80	1	WAS 8990298 SENSOR	90088	CU	[illegible]	
05MR81	2	VIEW "C" ADDED (PC-1251)	89945	CU	HP	C
		248				

DATE 28MR80
DR R. LINDNER
CK Jim Nagy-TN
APPR NS
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
EXHAUST OXYGEN SENSOR
FA00 &LG4/LM1/L39 &NB1

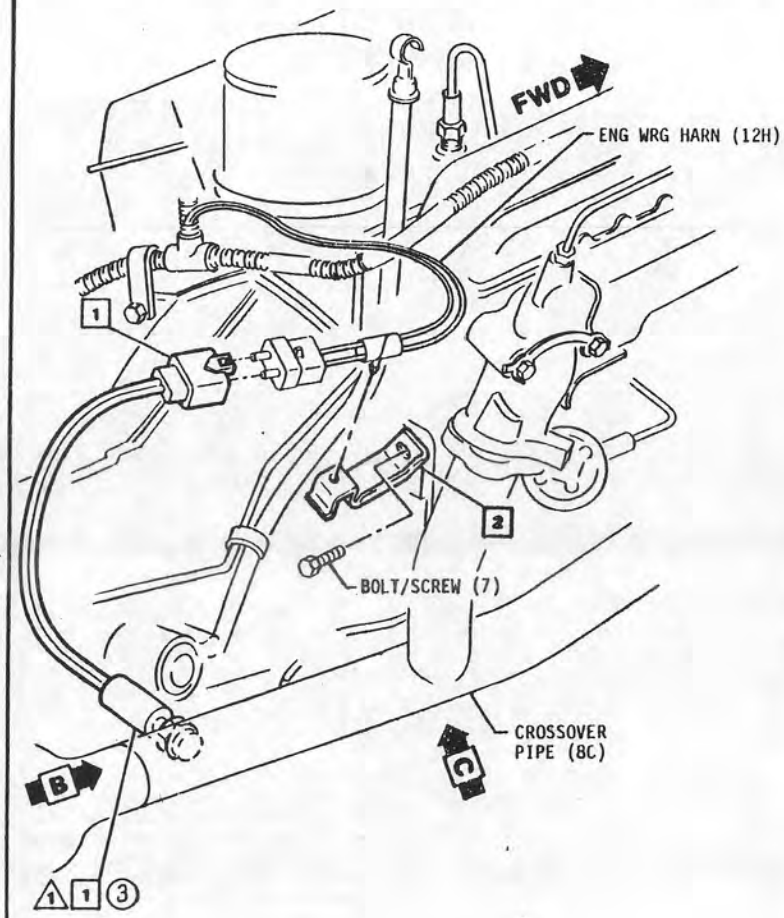
REF ECR 86448
NEW 14MR80

L- (NS)
L-
L-
L-

UPC 6M

SHEET 18

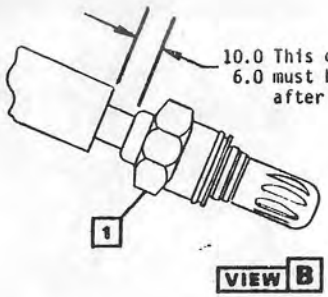
C ☒ B ☐ O ☐ P ☒ Ca ☐



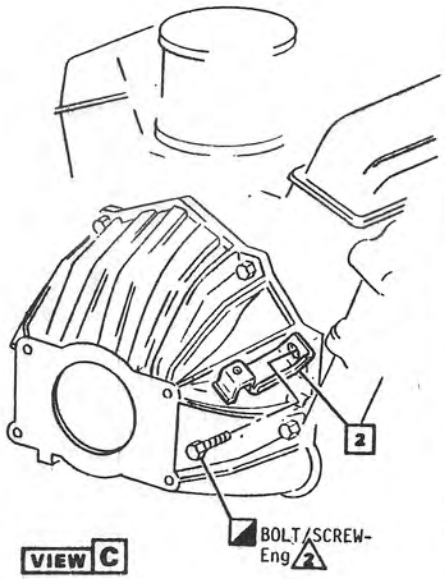
8990346 [1] SENSOR ASM-EXH. OXYGEN
14034322 [2] BRACKET

(1)

(2)



VIEW B



VIEW C
&M24 or M64

DYNAMIC (Install) N·m	HAND (Insp.) - N·m
△1	38 - 46
△2	34 - 40
△3	
△4	
△5	

△1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION*	AUTH	DR	CK	ASM CHG
080280	1	2973345 RETAINER REM				C
	2	VIEW "A" REM				C
	3	ITEM 1 DWG REV 90997	9/438	CU	RC	C

249

DATE 20MY80
DR R. KOCH
CK Richard Klein RC
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
EXHAUST OXYGEN SENSOR
FA00 &LC3

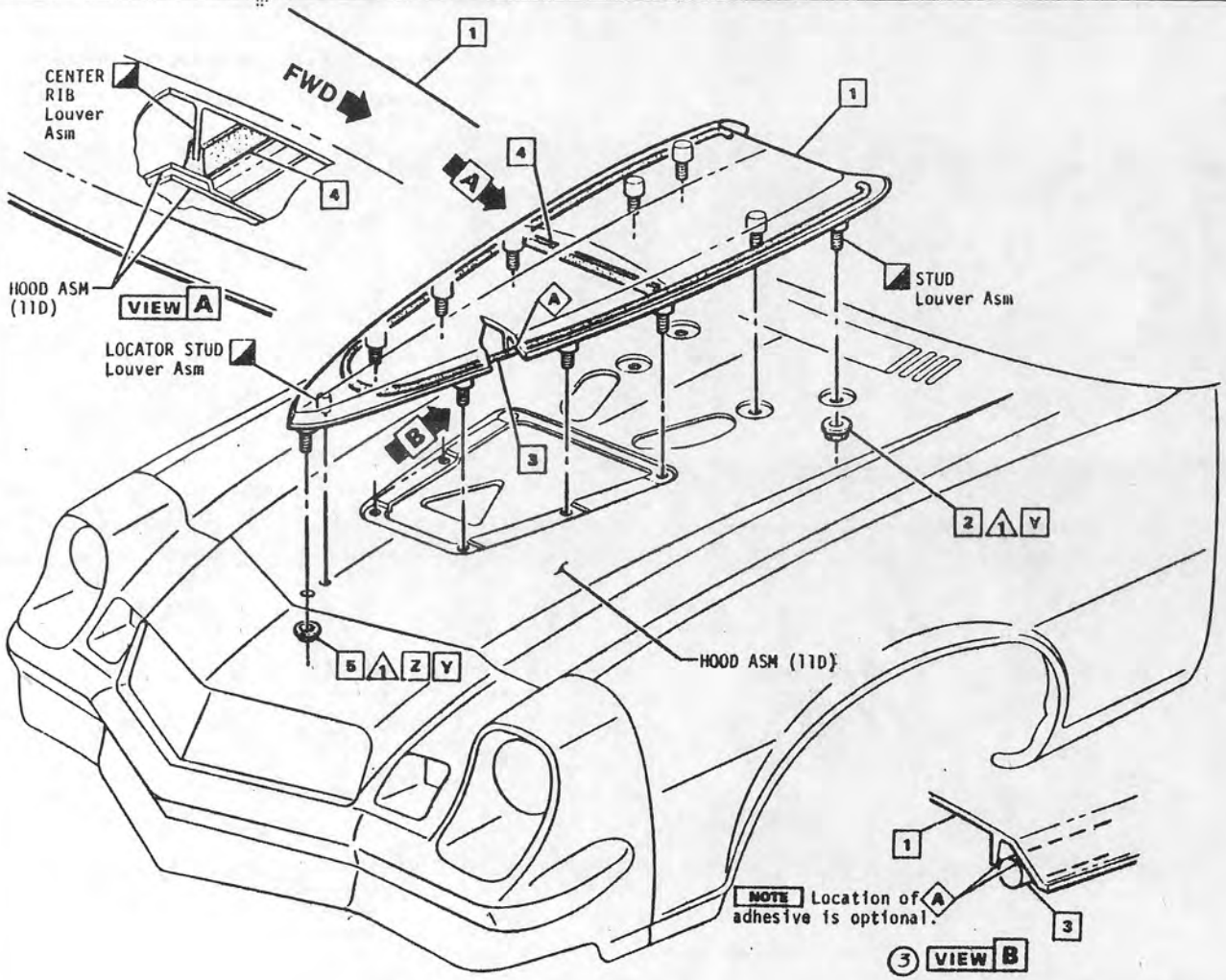
REF ECR 86448
NEW 13MY80

1-1- 25023(S)
1-
1-

UPC 6M

SHEET 18.1

C X B D P Ca



14010481	1	LOUVER ASM	
9419845	2	NUT	
14013426	3	SEAL (APPROX 90.00 IN.)	
14013427	4	SEAL (APPROX 16.00 IN.)	
9420253	5	NUT	
(2) 9981472	A	ADHESIVE Approx .01 Gal per job.	

(1) Y To avoid breakage, tighten the two rear nuts before the front nut, then tighten from front to rear. This avoids concentrating the scoop to hood mismatch in the weaker nose area.

Z Use Nut 5 at front attachment only.

DYNAMIC (Instal) N m	HAND (Insp.) · N m
△1	4.6-7.0
△2	
△3	
△4	
△5	

△1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
27JAN80	1	NOTE "Y" ADDED (PE-0059)	88765			C
	2	ADHESIVE ADDED				
	3	VIEW B ADDED	83293	CU	RL	C

250

DATE 01FEB0
DR R. LINDNER
CK Richard Cline RC
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE HOOD LOUVER ASM-AIR INTAKE FQ00 & Z28

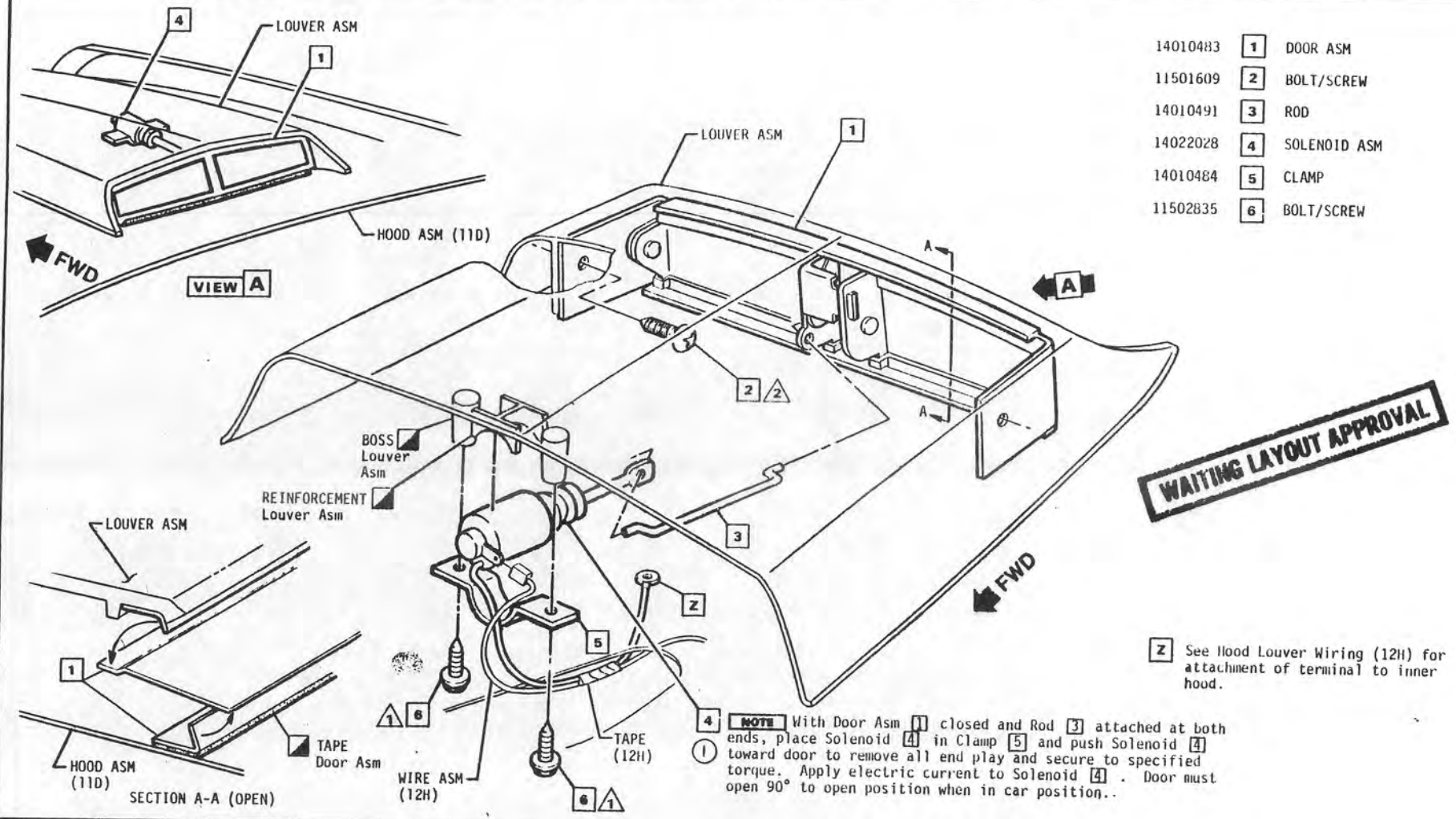
REF ECR 86448 C/O 16JA80 6M-25

L- 20092 (S)
L-
L-

UPC 6M

SHEET 19

Ch X A O P X Co



14010483	1	DOOR ASM
11501609	2	BOLT/SCREW
14010491	3	ROD
14022028	4	SOLENOID ASM
14010484	5	CLAMP
11502835	6	BOLT/SCREW

WAITING LAYOUT APPROVAL

Z See Hood Louver Wiring (12H) for attachment of terminal to inner hood.

NOTE With Door Asm 1 closed and Rod 3 attached at both ends, place Solenoid 4 in Clamp 5 and push Solenoid 4 toward door to remove all end play and secure to specified torque. Apply electric current to Solenoid 4 . Door must open 90° to open position when in car position..

DYNAMIC(Instal) N.m	HAND (Insp.) · N.m
1	1.2-1.6
2	0.6-1.4
3	
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
22APR80	1	"SOLENOID" NOTE REVISED (PC-0003)	88765	CU	[illegible]	

251

DATE 06FEB81
DR R. LINDNER
CK [illegible]
APPR NSJ
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE DOOR ASM & SOLENOID-AIR INTAKE
FP00 & Z28

REF ECR 86448
C/O 16JA80
6M-26

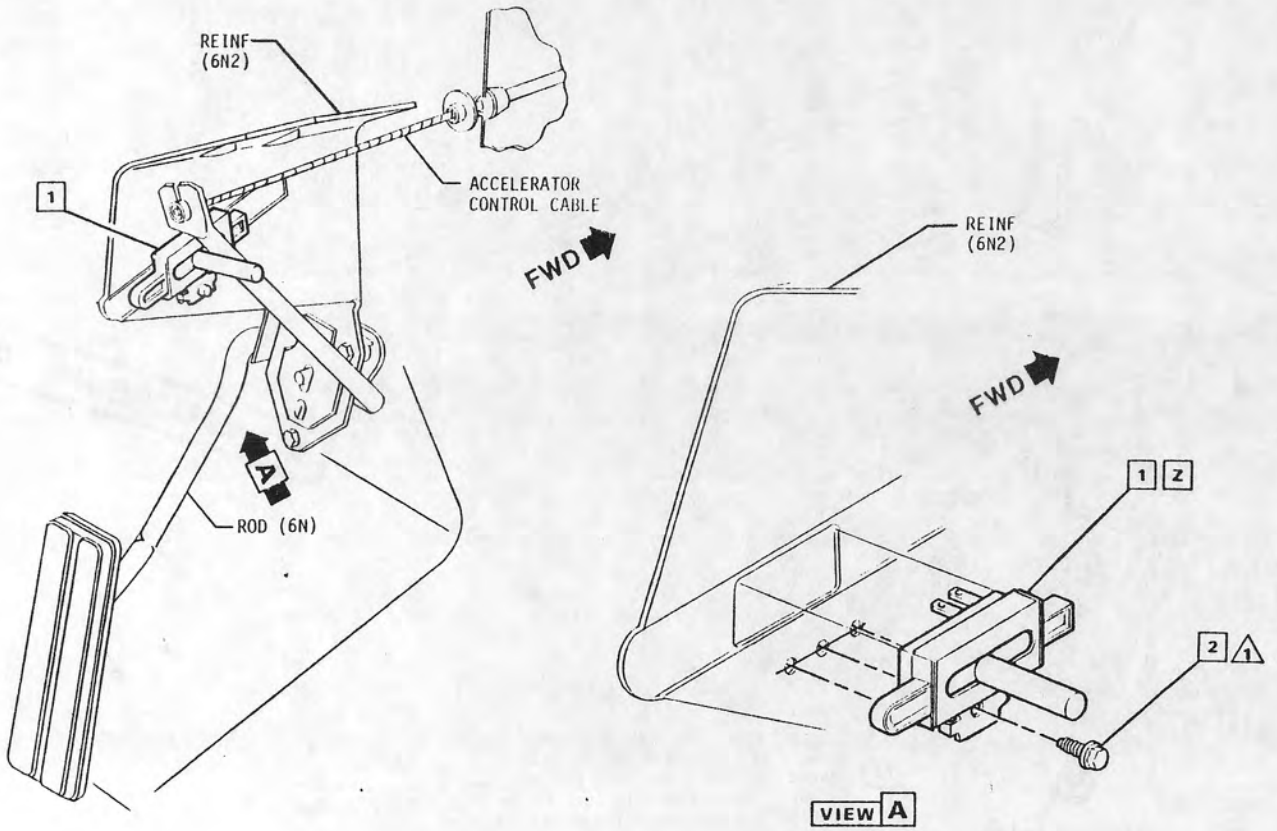
L- 20092 (S)
L- 19051 (NS)
L-
L-

UPC 6M

SHEET 20

Ch X B O P Ca

1242101	1	SWITCH ASM
11502453	2	BOLT/SCREW



Z After installing switch 1, press switch plunger as far FWD as possible. This presets switch for adjustment. Accel pedal rod will adjust switch the first time it is moved to the wide open throttle position.

DYNAMIC (Install) N.m	HAND (Insp.) - N.m
△1	4.0 - 5.5
2	
3	
4	
5	

△1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
		252				

DATE 07FEB80
DR R.LINDNER
CK
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
SWITCH ASM-HOOD AIR INTAKE LOUVER
FP00 & Z28

REFECR 86448
C/O 16JA80
6M-26.1

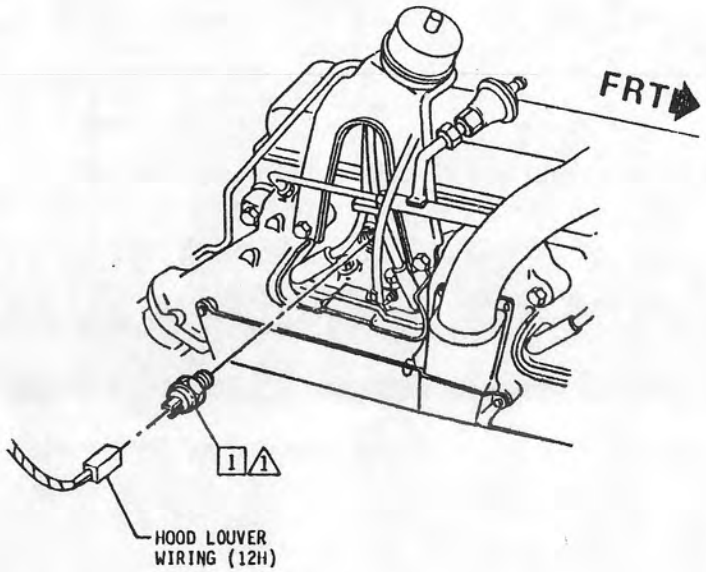
1L-20735(S)
L-
L-
L-

UPC 6M

SHEET 21

Ch X B O P X Co

25036265 [1] SWITCH ASM



DYNAMIC (Install) N·m	HAND (Insp.) · N·m
1	20-27
2	
3	
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
		253				

DATE 26SE80
DR R. LINDNER/CU
CK
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE THERMAL SWITCH ASM-AIR INTAKE SCOOP FP00 &Z28

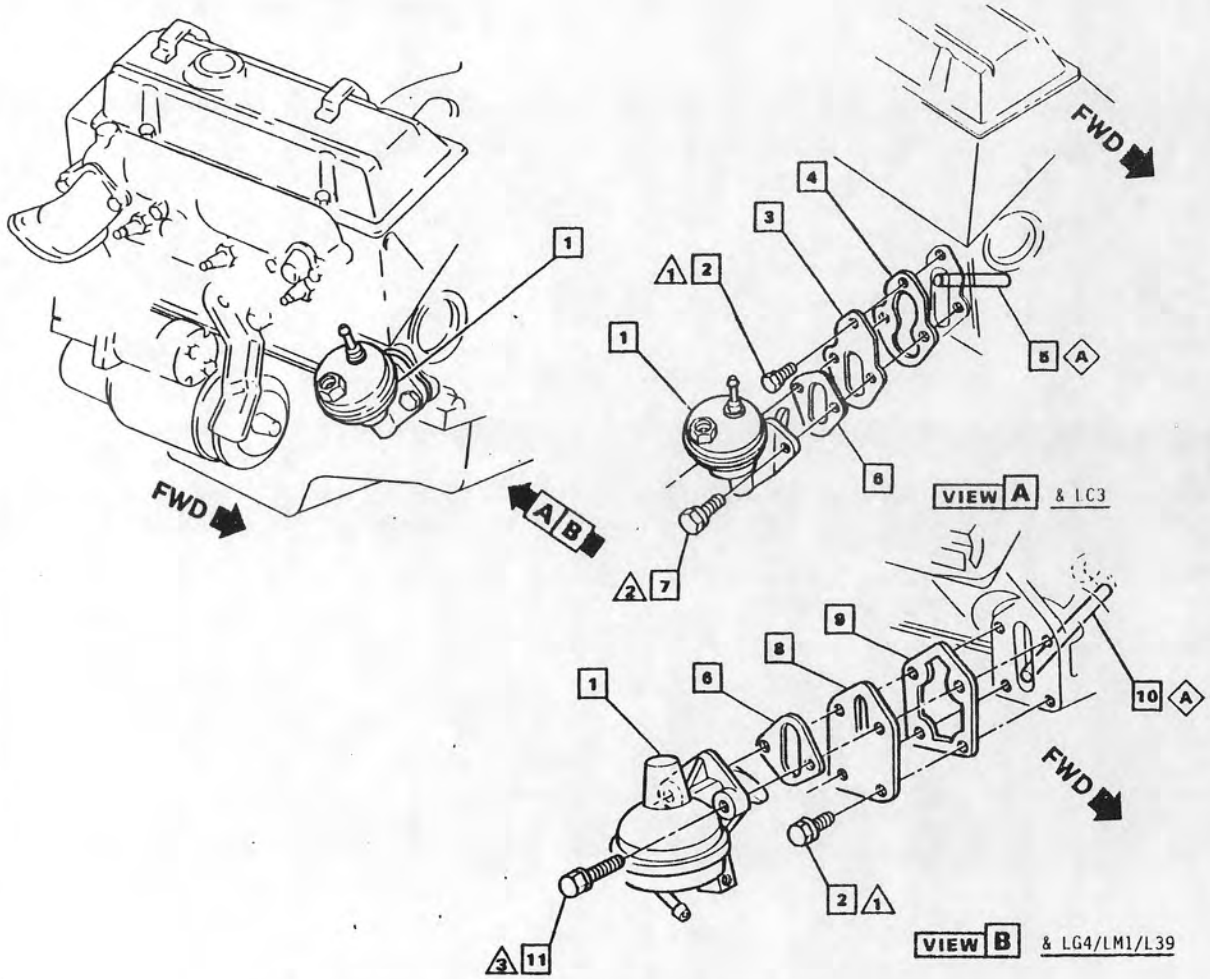
REF ECR 90397
NEW 16SE80

L-22003 (S)
L-
L-
L-

UPC 6M

SHEET 22

C X B O P Ca



6441386	1	PUMP ASM-FUEL & LC3
6440777	1	& LG4 or LM1 & Z28; & LG4 & M33 & C60
6441604	1	& LG4 & M24; & LG4 & M33 & C41; & L39
9431878	2	BOLT/SCREW
14006701	3	ADAPTER
462632	4	GASKET
464603	5	ROD-PUSH
3705042	6	GASKET
14001985	7	BOLT/SCREW
3719599	8	ADAPTER
3705044	9	GASKET
3704817	10	ROD-PUSH
3895411	11	BOLT/SCREW
9985038	A	LUBRICANT .0045 kg

DYNAMIC (Instal) N·m | HAND (Insp.) · N·m

△1 3.6-4.6
△2 19-26
△3 34-40
△4
△5

△1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG

DATE 08FEB0
DR R.LINDNER
CK
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
FUEL PUMP
FA00 & LC3/LG4/LM1/L39

REF ECR 86448
C/O 22JA80
6M-7 & 8

I-13621 (S)
I-
I-
I-

UPC 6M

SHEET 24

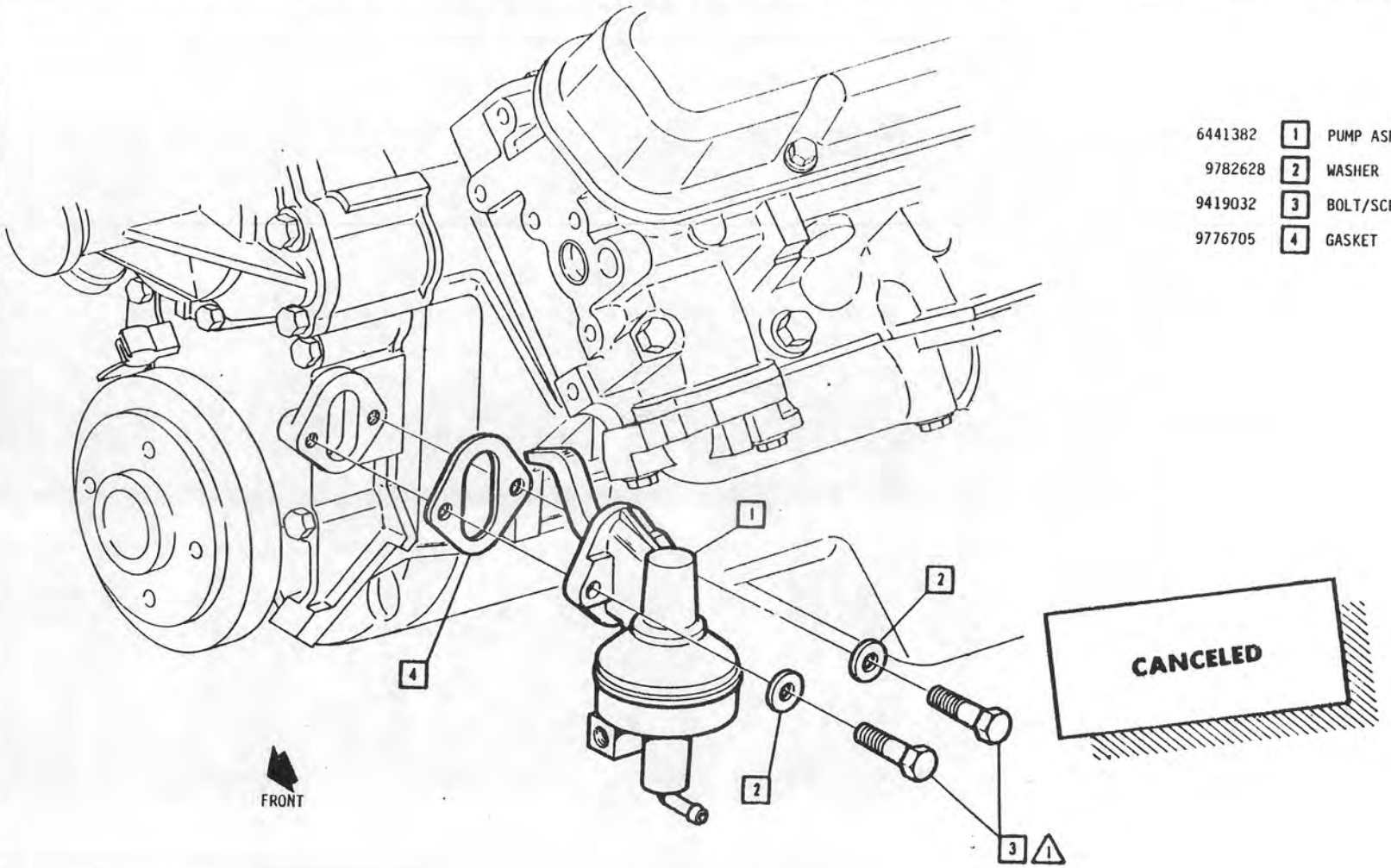
C | P | O | P | Ca

PONTIAC MOTOR DIVISION

General Motors Corporation Pontiac, Michigan

PRODUCT DESCRIPTION MANUAL

☐ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF



6441382	1	PUMP ASM.
9782628	2	WASHER
9419032	3	BOLT/SCREW
9776705	4	GASKET

CANCELED

DYNAMIC (Instal) N.m	HAND (Insp.) - N.m	DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
△1	16 - 24	12AUG0		ISSUED	86448	CU		
2		29AUG0	1	SHEET CANCELED	91222	CU		
3								
4								
5								

△ FULLY DRIVEN, SEATED & NOT STRIPPED

255

Ch X B X D X P X Ca

DATE 01 NO 79
DR E.D.BOTHWELL
CK M.B
APPR S
APPR
APPR
APPR

DIV CHEVROLET

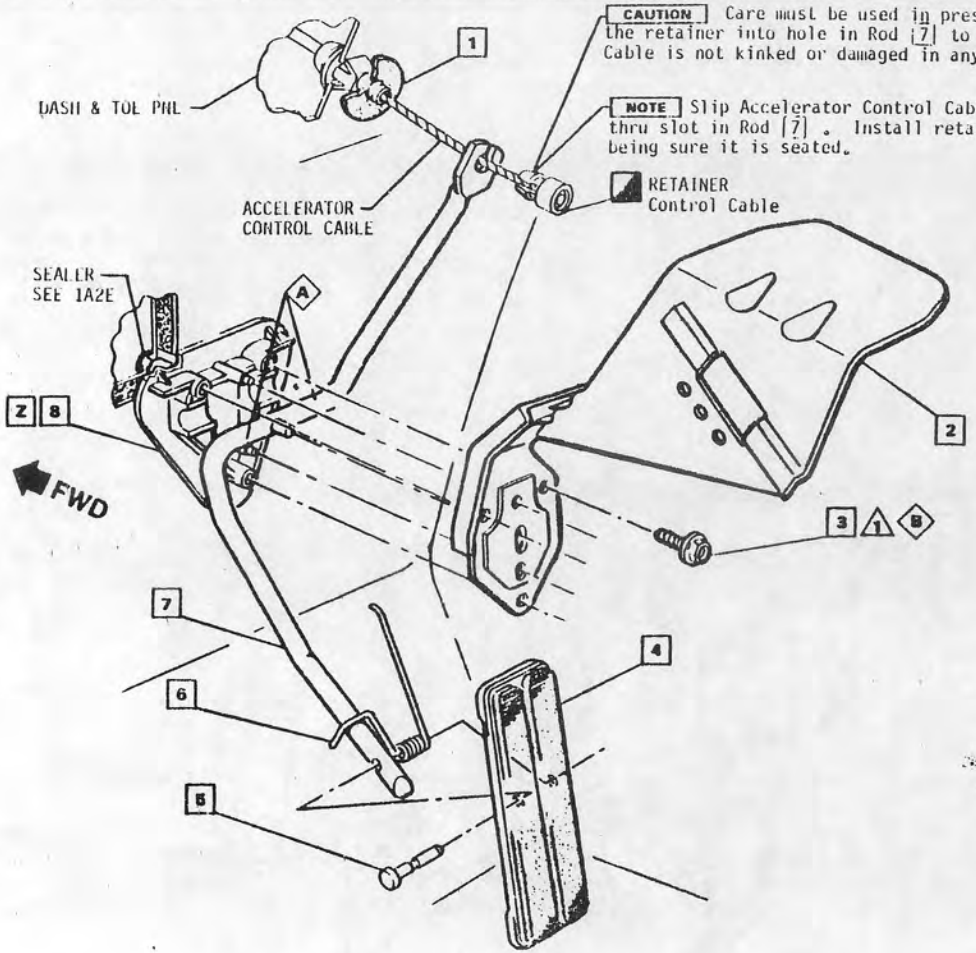
1981 CHEV. "F" 14020867

TITLE FUEL PUMP FA00 & LU8

REF ECR 86448 C/O 14DE79 6M-22 RL

UPC 6M

SHEET 26



1233539	1	RETAINER
352229	2	REINFORCEMENT
11500083	3	BOLT/SCREW
3920296	4	PEDAL
368078	5	PIN
368077	6	SPRING
6264915	7	ROD
3993087	8	SUPPORT
9985276	A	LUB-GREASE .01 LBS per job.
(1) 9985377	A	OPT
(2) 9980664	B	SEALER Approx .006 LBS per job.

Z Mounting surface between support and dash panel must be free of insulation.

CAUTION Having secured all components of the accelerator linkage as specified, linkage must operate freely without bind between full closed throttle and full wide open throttle.

DYNAMIC (Install) N·m	HAND (Insp.) · N·m
1 2.2-4.0	
2	
3	
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
JUN 80	1	9985377 LUB ADDED	89136	CU		
JUL 80	2	9980664 WAS 9980669	83293	CU	AS	

256

DATE 07FE80
DR R. TAYLOR
CK
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE ACCELERATOR CONTROLS-PASS. COMPT
FA00 ALL

REF ECR 86448
C/O 16JA80
6N2-1

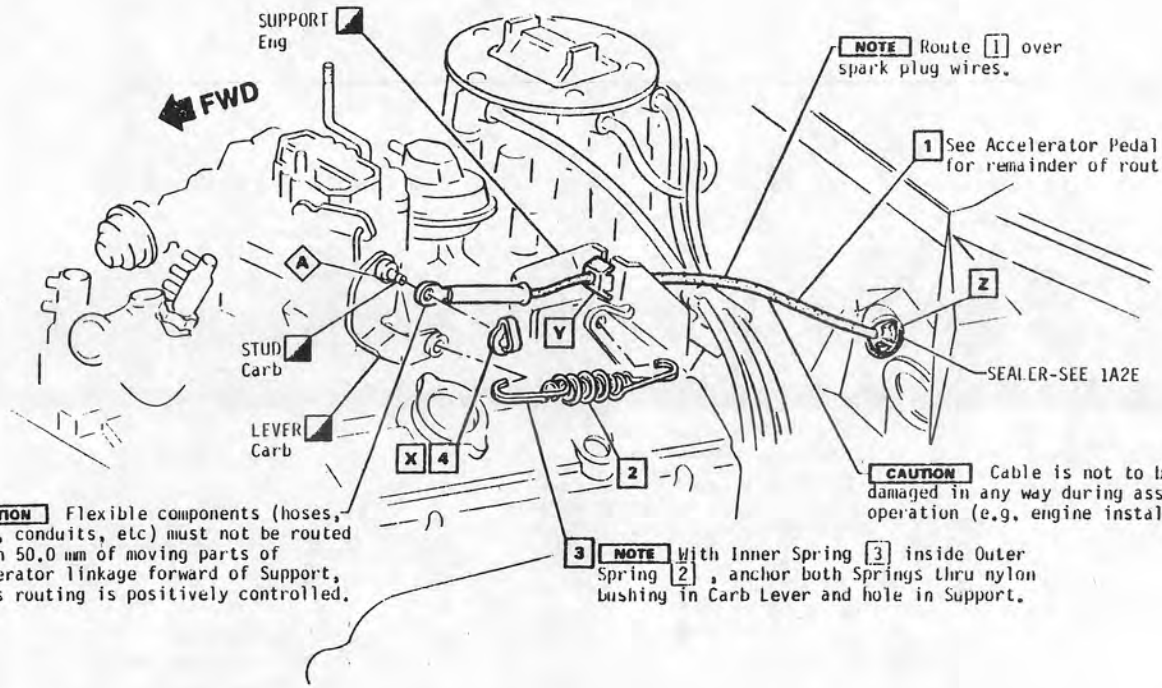
L-22344 (S)
L-
L-
L-

UPC 6N2

SHEET 1

Ch X B O P X Ca

(1)	25508907	1	CABLE ASM
	340637	2	SPRING-OUTER
	340638	3	SPRING-INNER
	1247872	4	RETAINER
	9985276	A	LUB-GREASE 0.5 g
(2)	9985377	A	OPT



NOTE Route [1] over spark plug wires.

[1] See Accelerator Pedal Sheet for remainder of routing.

CAUTION Cable is not to be kinked or damaged in any way during assembly operation (e.g. engine installation).

CAUTION Flexible components (hoses, wires, conduits, etc) must not be routed within 50.0 mm of moving parts of accelerator linkage forward of Support, unless routing is positively controlled.

[3] NOTE With Inner Spring [3] inside Outer Spring [2], anchor both Springs thru nylon bushing in Carb Lever and hole in Support.

[X] See UPC "O" - "Retainer Instructions".

[Y] Conduit fitting at both ends must have locking tangs expanded & locked in attaching hole.

[Z] The braided portion of the accelerator cable asm must not come in contact with the front of dash sealer during assembly, repair or replacement of the assembly.

DYNAMIC (Instal) N·m	HAND (Insp.) N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
		11APR80	1	WAS 1248081 CABLE	89729	CU	RC	
		11JL80	2	9985377 LUB ADDED	89136	CU	RC	

1 2 3 4 5 FULLY DRIVEN, SEATED & NOT STRIPPED

257

Ch B O P Co

DATE 29FEB0
DR R. TAYLOR
CK
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
ACCELERATOR CONTROLS
FA00 &LC3

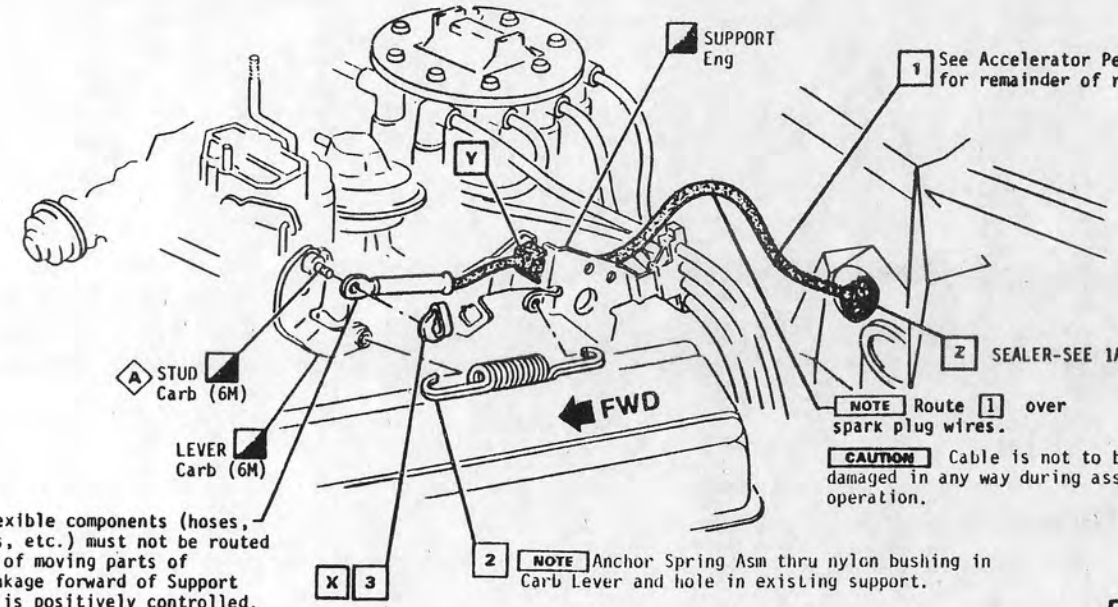
REFECR 86448
C/O 19FE80
6N2-2

L-22344 (S)
L-
L-
L-

UPC 6N2

SHEET 2

1248086	1	CABLE ASM
14024945	2	SPRING ASM
1247872	3	RETAINER
9985276	◇A	LUB-GREASE 0.5 g-Stud Shaft
(I) 9985377	◇A	OPT



X See UPC "0"-"RETAINER INSTRUCTIONS"

Y Conduit fitting at both ends must have locking tangs expanded & locked in attaching hole.

Z The braided portion of the accelerator cable asm must not come in contact with the front of dash sealer during assembly, repair or replacement of the assembly.

DYNAMIC (Install) N·m	HAND (Insp.) N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASH CHG
1 2 3 4 5		JUL80	1	9985377 LUB ADDED	89136	CW	RC	

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE 20MR80
DR R.C. TAYLOR
CK Richard Line RC
APPR (S)
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE ACCELERATOR CONTROLS FA00 &L39

REF ECR 86448 NEW 11MR80

L-22344 (S)

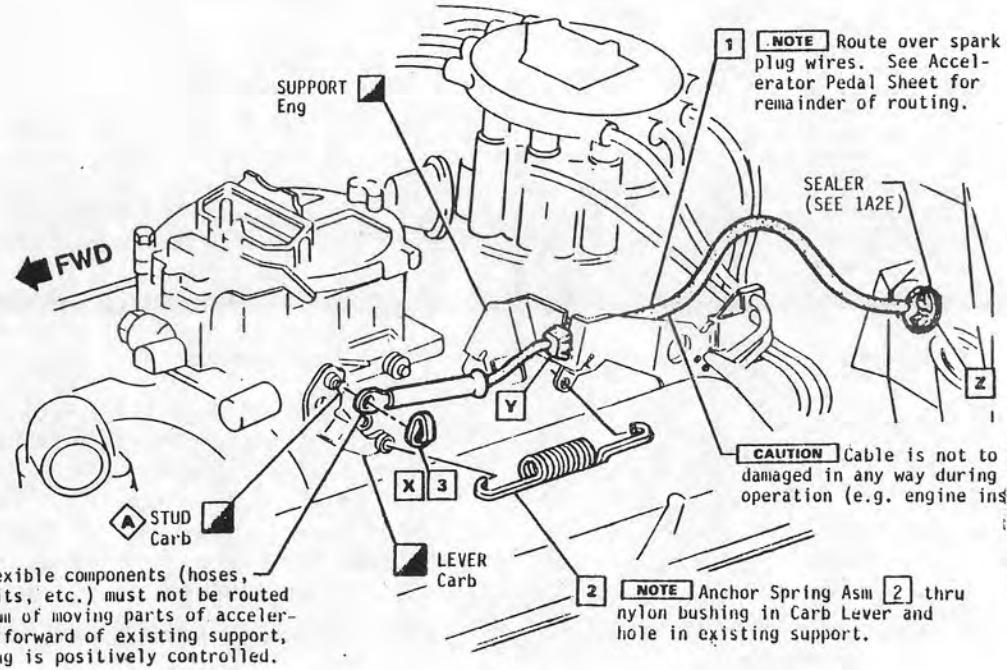
UPC 6N2

SHEET 3

258

CK X B O P X Co

1248086	1	CABLE ASM	
14024945	2	SPRING ASM	
1247872	3	RETAINER	
9985276	A	LUB-GREASE 0.5 g	
(1) 9985377	A	OPT	



X See UPC "0" "Retainer Instructions"

Y Conduit fitting at both ends must have locking tangs expanded & locked in attaching hole.

Z The braided portion of the accelerator cable asm must not come in contact with the front of dash sealer during assembly, repair or replacement of the assembly.

DYNAMIC (Instal) N·m	HAND (Insp.) N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM Cag
		INLBO	1	9985377 LUB ADDED	89136	CU	LE	

DATE 29FEB0
DR R.C. TAYLOR
CK Jim Johnson TH
APPR (S)
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE ACCELERATOR CONTROLS FA00 &LG4 or LM1

REF ECR 86448 NEW 19FE80

L-22344 (S)

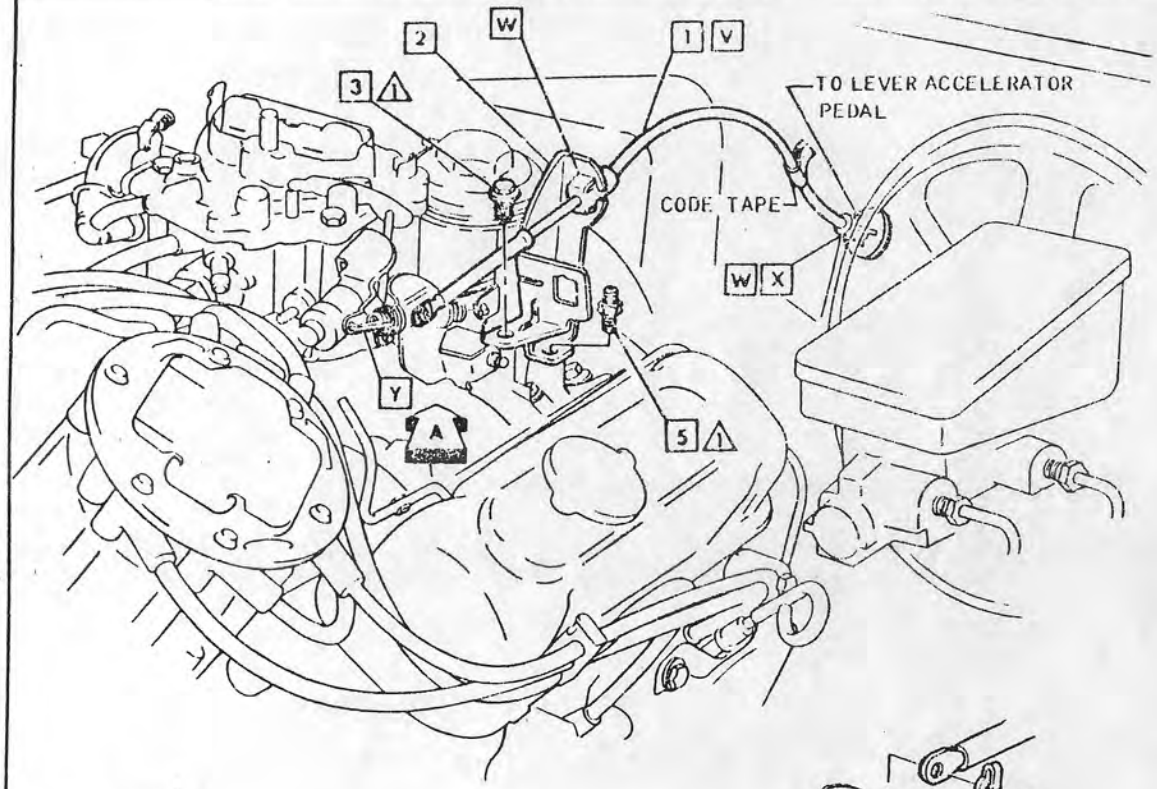
UPC 6N2

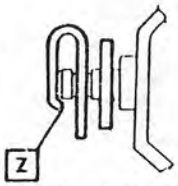
SHEET 4

△1 FULLY DRIVEN, SEATED & NOT STRIPPED

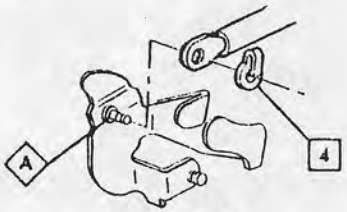
259

Ch X B O P Co





VIEW OF FASTENER



VIEW-A

1254176	1	CABLE ASM - ACCEL CONT (CODE ON)
25505161	2	BRACKET
(1) 9439483	3	BOLT/SCREW
1247872	4	FASTENER
(2) 25509838	5	STUD
9985276	A	GREASE
9985377	A	OPT.

V 1. ACCELERATOR CABLE MUST BE INSTALLED IN THE BODY PRIOR TO ASSEMBLY TO THE ENGINE.
2. ACCELERATOR CABLE MUST NOT BE SUBJECTED TO SHARP BENDS DURING INSTALLATION.
3. ACCELERATOR CABLE MUST BE ROUTED SMOOTHLY & FREELY OF WIRES, HOSES, OR OTHER OBSTRUCTIONS BETWEEN CONDUIT FITTINGS.

W CONDUIT FITTING AT BOTH ENDS MUST HAVE LOCKING TANGS EXPANDED & LOCKED IN ATTACHING HOLES.

X THE BRAIDED PORTION OF THE ACCELERATOR CABLE ASM MUST NOT COME IN CONTACT WITH THE FRONT OF DASH SEALER DURING ASSEMBLY, REPAIR, OR REPLACEMENT OF ASM.

Y INSTALLED IN ENGINE PLANT.

Z FASTENER MUST BE INSTALLED WITH TANG SECURED OVER HEAD OF STUD.

DYNAMIC (Instal) N·m	HAND (Insp.) · N·m
1 20-34	
2	
3	
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
OCT 80		ISSUED	S6448	CU	MC	
03 OCT 80	1	WAS 9437766 BOLT	P2016			
	2	WAS 3998589 STUD	P2354	CU	MC	

260

DATE 04JA80
DR MAC DORMOTT
CK
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE ACCELERATOR CONTROLS-ENGINE COMPARTMENT
FA00 & LD5

REF ECR 86448
C/O 25JA80
6N2-1 RT

UPC 6N2

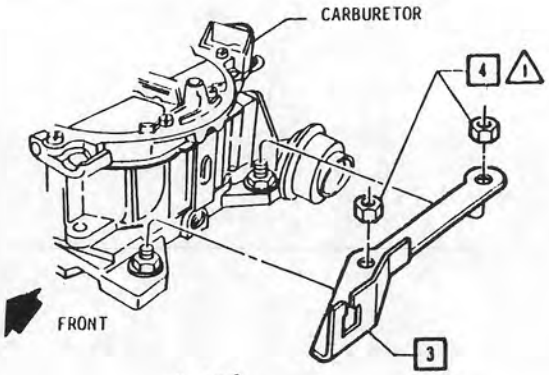
SHEET 5

CB X B X O X P X Ca

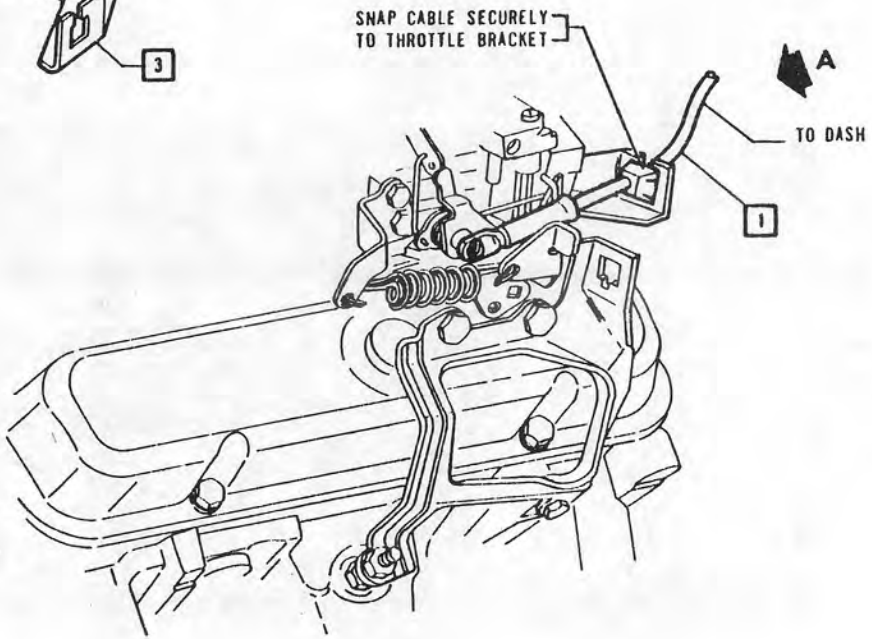
PONTIAC MOTOR DIVISION
General Motors Corporation Pontiac, Michigan

PRODUCT DESCRIPTION MANUAL
□ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF

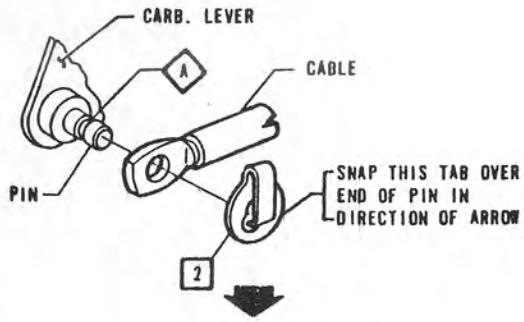
1254896	1	CABLE ASM.
1247872	2	FASTENER
10012929	3	BRACKET
9418892	4	NUT
9985276	A	GREASE
(1) 9985377	A	OPT



VIEW A



CANCELED



CABLE TO CARB. LEVER

DYNAMIC (Install) N·m	HAND (Insp.) N·m
1	14-19
2	
3	
4	
5	

⚠ FULLY DRIVEN SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
12JAN80		ISSUED	86448	CU	RS	
11JUL80	1	9985377 LUB ADDED	89136	CU	RE	
07NOV80	2	SHEET CANCELED	91222	CU	EF	

261

DATE 18 OC 79
DR G.M. VERSTRAETE
CK J.E.B.
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE ACCELERATOR CONTROLS-ENG COMPARTMENT FA00 &LU8

REF ECR 86448 C/O 11DE79 6N2-3 RT

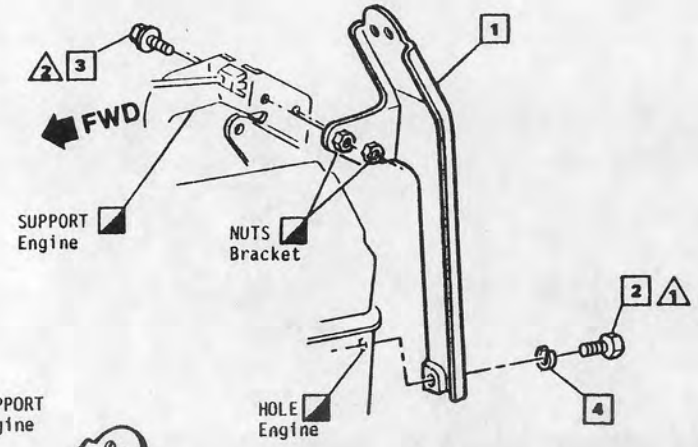
2 L-77200 L- L- L-

UPC 6N2

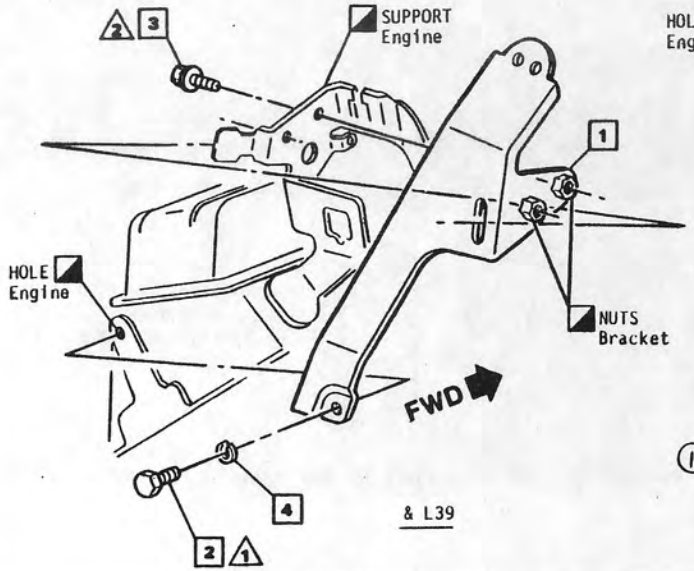
SHEET 6

Ch X I O P X Co

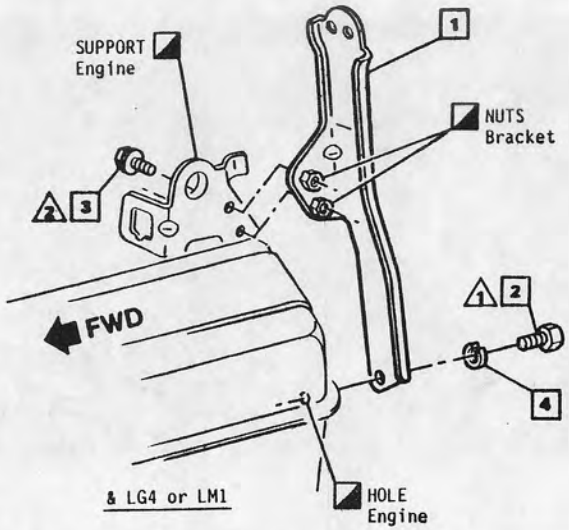
14009117	1	BRACKET ASM
14009123	1	& LC3
14009118	1	&L39
9428638	2	BOLT/SCREW
9433256	3	BOLT/SCREW
103321	4	WASHER



& LC3



& L39



& LG4 or LM1

(1) NOTE Assemble [3] loosely. Assemble [2] & [4] and tighten to specified torque. Tighten [3] to specified torque.

DYNAMIC (Install) N·m	HAND (Insp.) · N·m
△1	26-40
△2	7.0-10.0 (2)
△3	
△4	
△5	

△1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
28APR80	1	TORQUE NOTE ADDED	89137	CJ	[illegible]	C
01MAY80	2	TORQUE (2) WAS 7.0-9.0	89137	CJ	[illegible]	C

262

DATE 08FEB80
DR R.C. TAYLOR
CK [signature]
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE CRUISE CONTROL SERVO UNIT BRACKETS FA00 & LC3/L39/LG4/LM1&K35

REF ECR 86448 C/O 16JA80 6N4-1

L- 21192 (S)
L- 22283 (S)
L-
L-

UPC 6N4

SHEET 1

Ck X B O P X Ca

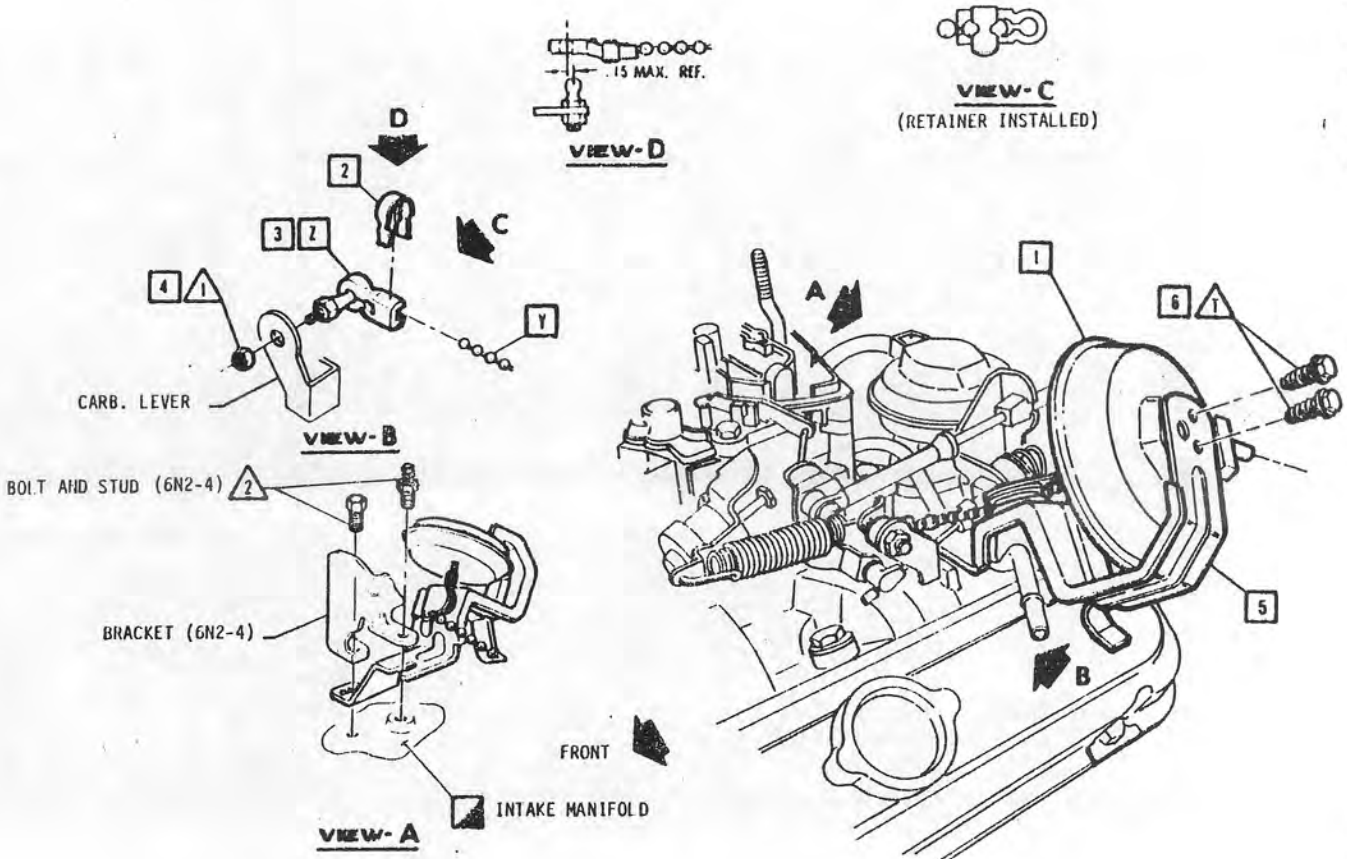
PONTIAC MOTOR DIVISION

General Motors Corporation Pontiac, Michigan

PRODUCT DESCRIPTION MANUAL

☐ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF

25031056	1	SERVO ASM.
1241089	2	RETAINER
1243807	3	SWIVEL ASM.
9420418	4	NUT
10014856	5	BRACKET & PULLY ASM.
11504874	6	BOLT/SCREW



Y ASSEMBLE CHAIN TO BE TAUT WITH CARB IN THE HOT IDLE POSITION & WITH THE IDLE CONTROL SOLENOID DE-ENERGIZED. PLACE CHAIN INTO SWIVEL CAVITIES WHICH PERMIT CHAIN TO HAVE SLIGHT SLACK. PLACE RETAINER OVER SWIVEL & CHAIN ASM. RETAINER MUST BE POSITIONED TO REST BETWEEN BALLS: VIEW-C CUT OFF CHAIN FLUSH WITH SIDE OF SWIVEL TO REMOVE EXCESS LENGTH. CHAIN SLACK NOT TO EXCEED ONE HALF DIAMETER OF BALL STUD (.15) WHEN MEASURED AT HOT IDLE POSITION, WITH THE IDLE CONTROL SOLENOID DE-ENERGIZED & SWIVEL DISCONNECTED FROM BALL STUD, REFERENCE VIEW-D.

Z BALL SWIVEL MUST BE INSTALLED ON THE INBOARD SIDE OF LEVER.

DYNAMIC (Instal) N m	HAND (Insp.) N m
1	3.4 - 4.6
1	20 - 34
1	
1	
1	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
11APR80		ISSUED	86448	RCT	RE	
		263				

DATE 29 JA 80
DR G.M. VERSTRAETE
CK Jeb
APPR HF
APPR REL
APPR
APPR RDH

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE CRUISE CONTROL-SERVO UNIT FA00 & LD5 & K35

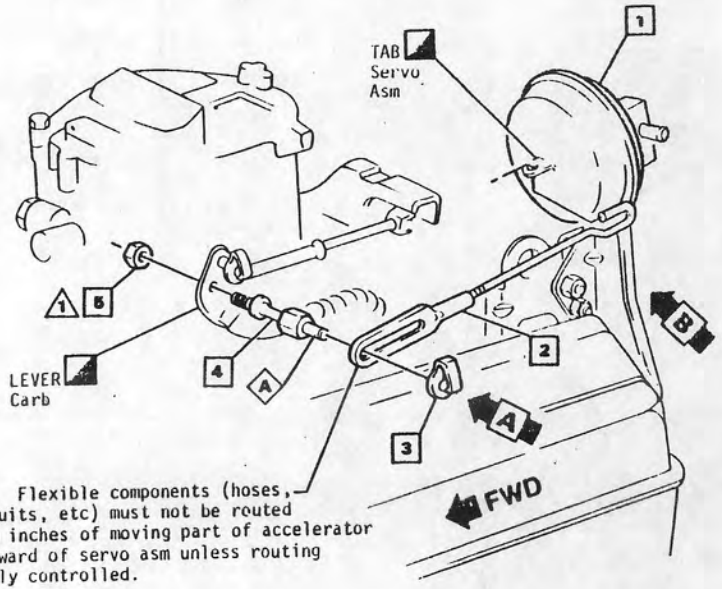
REF ECR 86448 NEW 24MR80 6N4-5 RT

21-78341

BPC 6N4

SHEET 2

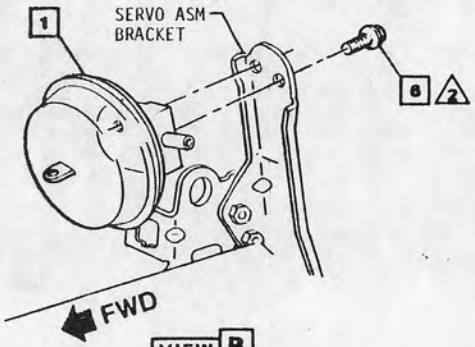
Ch X B O P X Ca



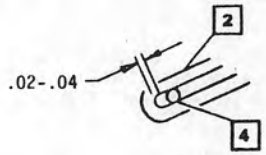
25030595	1	SERVO ASM
14009158	2	ROD ASM
14009159	2	& LG4 or LM1
1247872	3	RETAINER
376231	4	STUD
9417954	5	NUT
11504874	6	BOLT/SCREW
9985276	A	LUB-GREASE .0005 kg Stud-Shaft
9985377	A	OPT

CAUTION Flexible components (hoses, wires, conduits, etc) must not be routed within 2.00 inches of moving part of accelerator linkage forward of servo asm unless routing is positively controlled.

&LM1 SHOWN
&LC3/L39/LG4 TYPICAL



VIEW B



VIEW A

SERVO ASM TO CARBURETOR ADJUSTMENT

With ignition off and fast idle cam off and throttle completely closed, hook [2] through tab on servo asm . Adjust length so that [2] assembles over end of [4] as shown (See View A). Install [3] .

DYNAMIC(Instal) N·m	HAND (Insp.) - N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
1	12-17							
2	1.2 - 2.0							
3								
4								
5								

1 FULLY DRIVEN, SEATED & NOT STRIPPED

264

DATE 15FEB0
DR R.C. TAYLOR
CK
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE CRUISE CONTROL-
SERVO ASM
FA00 &LC3/L39/LG4/LM1 &K35

REF ECR 86448
C/O 16JA80
6N4-3

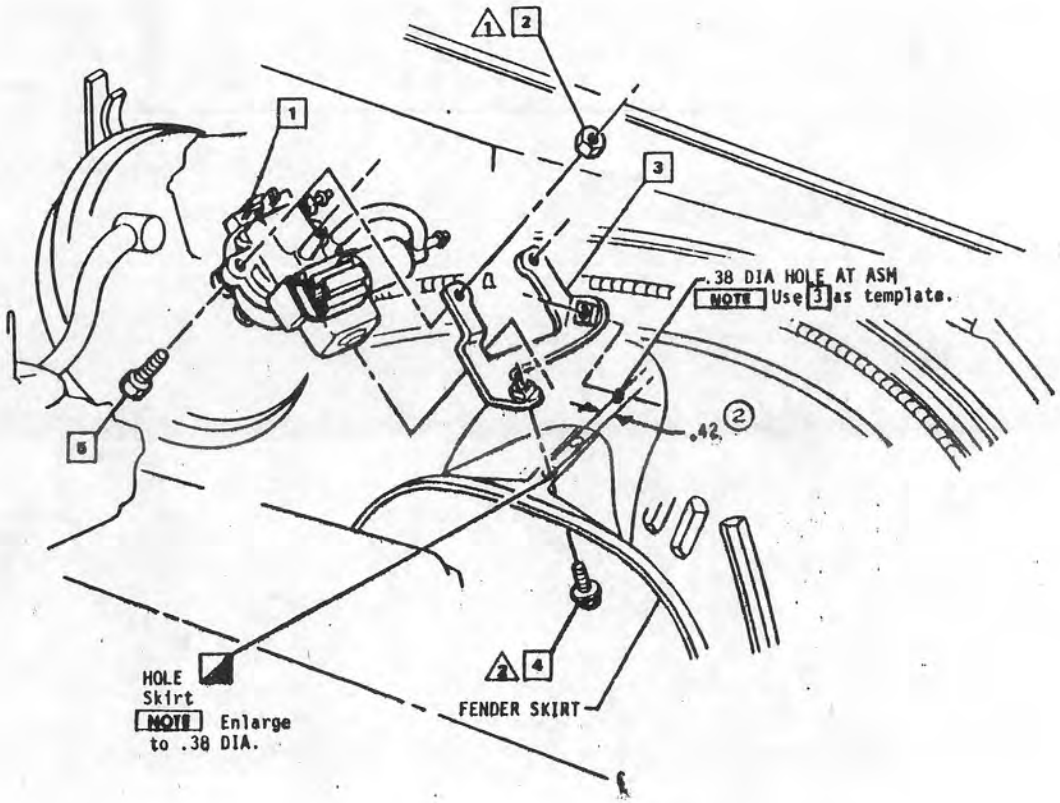
11-21192(S)
l-
l-
l-

UPC 6N4

SHEET 3

Ch | B | O | P | Co

25030560	1	TRANSDUCER ASM
9422273	2	NUT
14024950	3	BRACKET ASM
3846201	4	BOLT/SCREW
(1) 180022	5	BOLT/SCREW



DYNAMIC (Install) N·m	HAND (Insp.) · N·m
1 7.0-10.0	
2 20-27	
3	
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
23NV80	1	WAS 9419004 BOLT/SCREW	86448	CU	RC	
12JN80	2	.42 DIM. ADDED	88765	CU	RC	C

265

CK X B D P Co

DATE 21FE80
DR R. TAYLOR
CK Richard Chin RC
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE CRUISE CONTROL-TRANSDUCER MOUNTING FA00 & K35

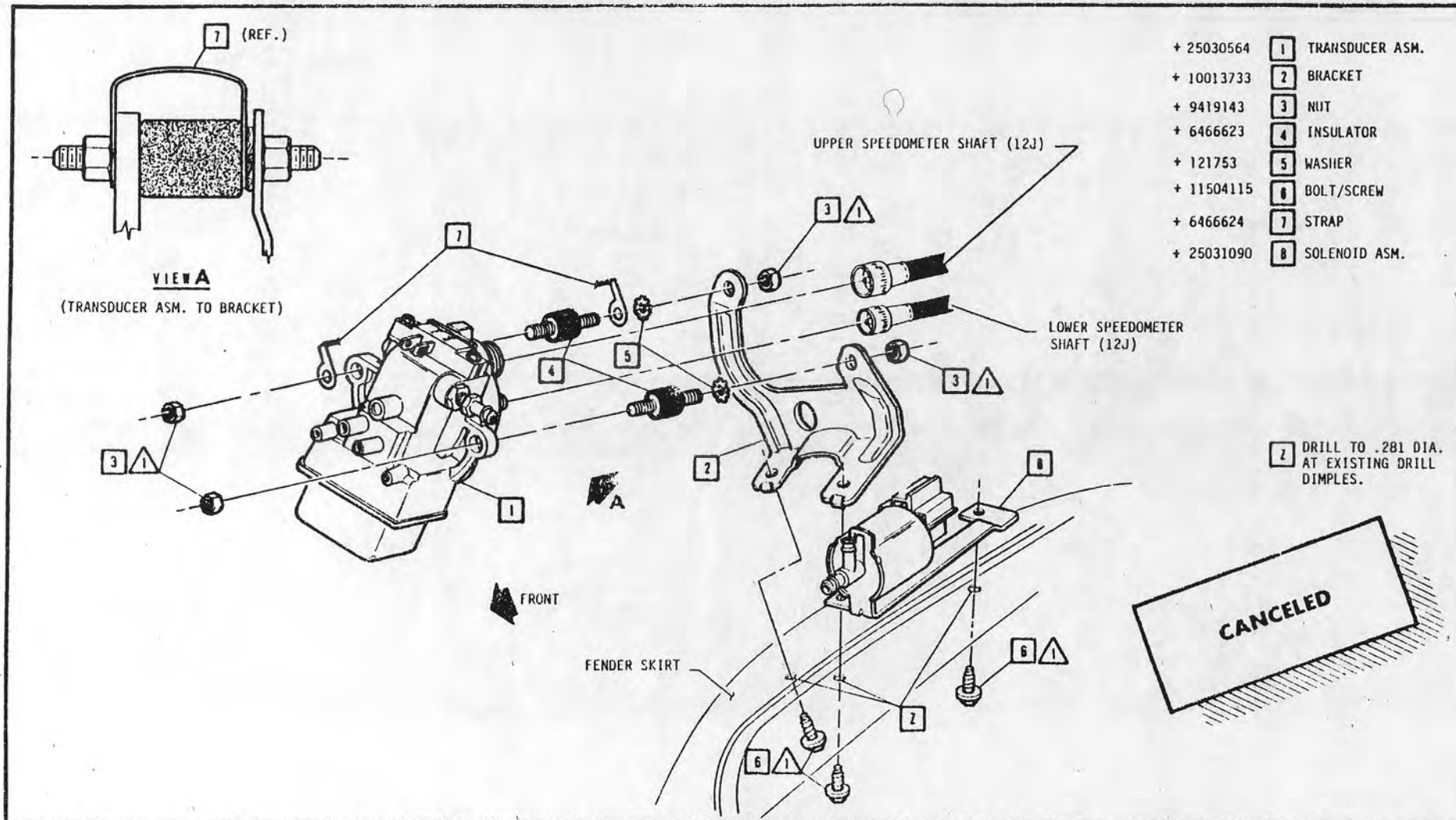
REF ECR 86448 NEW 05FE80 | 11-22283 (S) | UPC 6N4 | SHEET 4

PONTIAC MOTOR DIVISION

General Motors Corporation Pontiac, Michigan

PRODUCT DESCRIPTION MANUAL

□ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF



+ 25030564	1 TRANSDUCER ASM.
+ 10013733	2 BRACKET
+ 9419143	3 NUT
+ 6466623	4 INSULATOR
+ 121753	5 WASHER
+ 11504115	6 BOLT/SCREW
+ 6466624	7 STRAP
+ 25031090	8 SOLENOID ASM.

DYNAMIC (Instal) N·m | MAND (Insp.) N·m

△ 7-10

△ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
06MR80		ISSUED	86448	KCT	LJB	
11AP80	1	SHEET CANCELED	88900	CU	KC	

266

DATE 14 JA 80
DR G.M. VERSTRAETE
CK JEB
APPR HF
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE TRANSDUCER AND SOLENOID ASM MOUNTING FA00 & LU8 & K35

REF ECR 86448 NEW 26FE80 RT

21-78296 L- L- L-

UPC 6N4

SHEET 4.1

Ch | B | O | P | Co

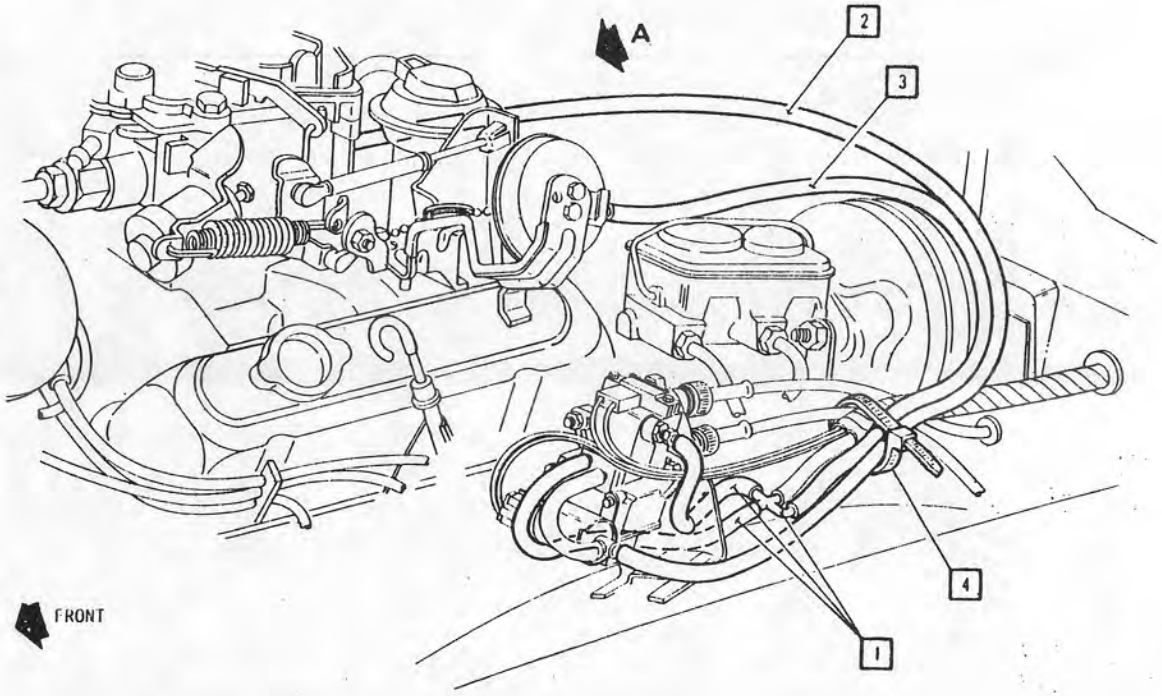
PONTIAC MOTOR DIVISION

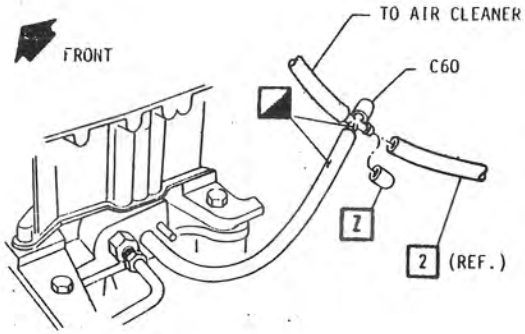
General Motors Corporation Pontiac, Michigan

PRODUCT DESCRIPTION MANUAL

☐ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF

10006780	1	HARNESS ASM.
9438988	2	HOSE
* 6467953	3	HOSE
11501906	4	STRAP





VIEW A
(VACUUM SOURCE)

Z REMOVE AND DISCARD CAP PRIOR TO INSTALLATION

DYNAMIC (Instal) N·m	HAND (Insp.) N·m
1	
2	
3	
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
29APR80		ISSUED	86448	CU	ZA	

267

DATE 29 JA 80
DR G.M. VERSTRAETE
CK JEB
APPR
APPR
APPR
APPR RDH

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
CRUISE CONTROL TUBE ROUTING
FA00 & LD5 & K35

REF ECR 86448
NEW 02AP80
RT

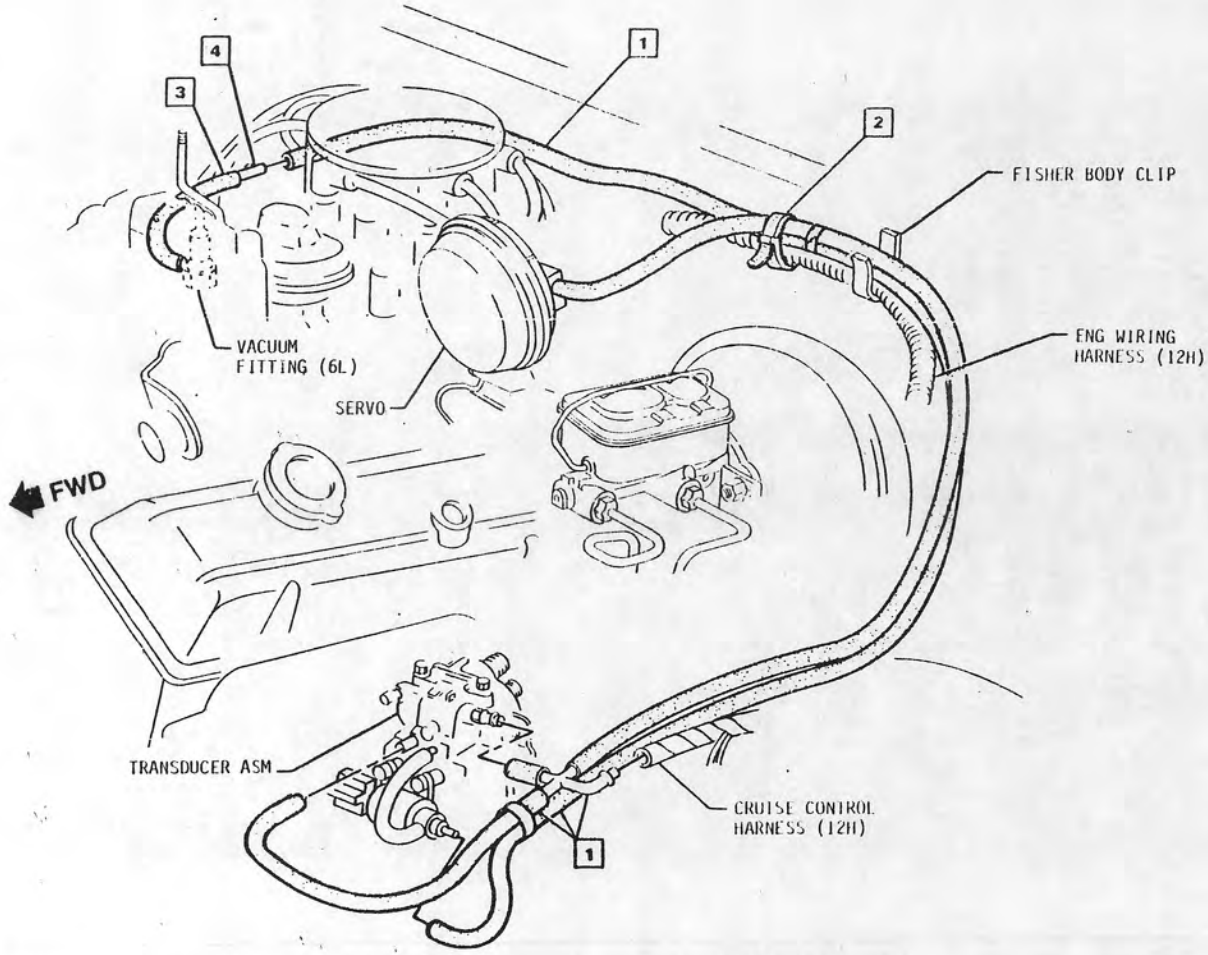
UPC 6N4

SHEET 5

Ch X B O P X Co

SAE* 4338

14024926	1	HARNESS ASM
9422033	2	STRAP
468288	3	TUBE
14004876	4	CONNECTOR



DYNAMIC (Instal) N·m	HAND (Insp.) · N·m
1	
2	
3	
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
		268				

DATE 08FE90
DR R.C. TAYLOR
CK
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE CRUISE CONTROL VACUUM TUBE ROUTING FA00 & LC3 & K35

REF ECR 86448 NEW 05FE80

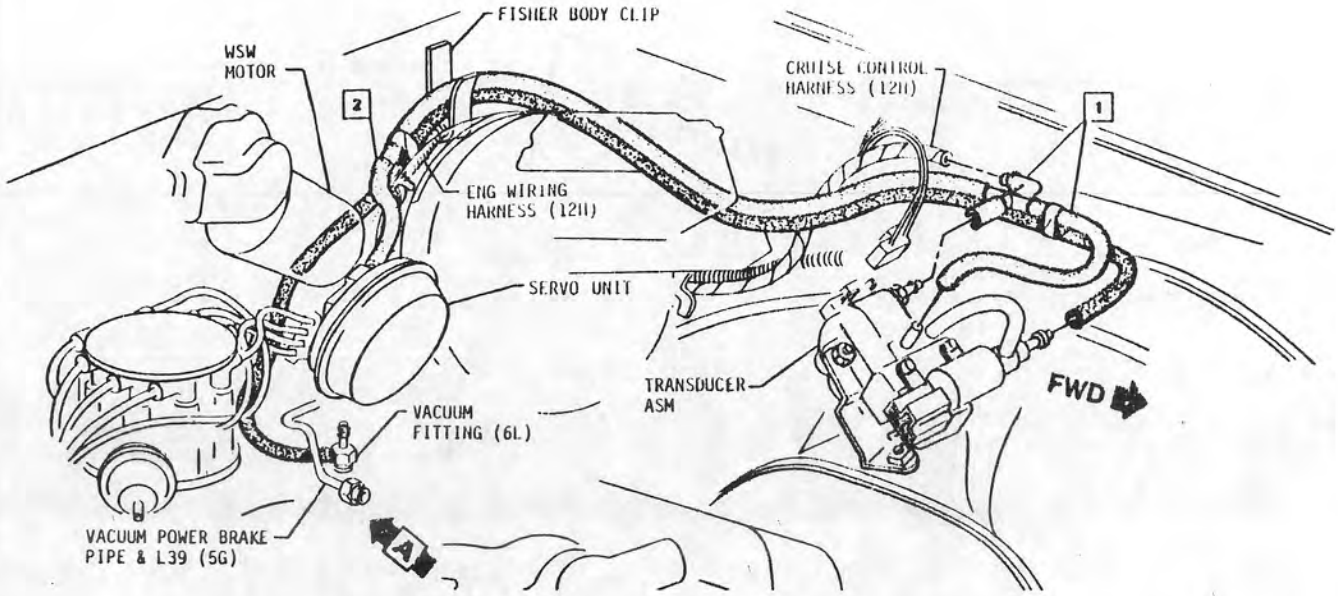
11-22283 (S)

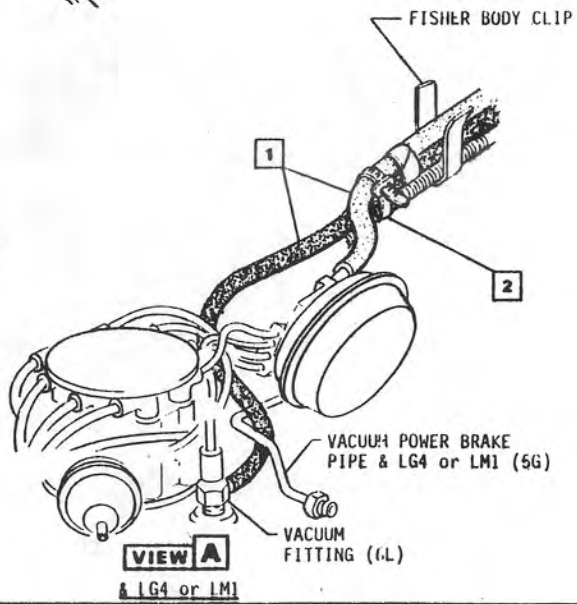
UPC 6N4

SHEET 6

C	X	B		O		P		Ca

14024926	1	HARNESS ASM
9422033	2	STRAP





DYNAMIC(Instal) N·m	HAND (Insp.) - N·m
1	
2	
3	
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
		269				

DATE 14FE80
DP R.C. TAYLOR
CK
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE CRUISE CONTROL-VACUUM TUBE ROUTING FA00 & L39/LG4/LM1 & K35

REF ECR 86448 NEW 05FE80

11- 22283 (S)
1-
1-
1-

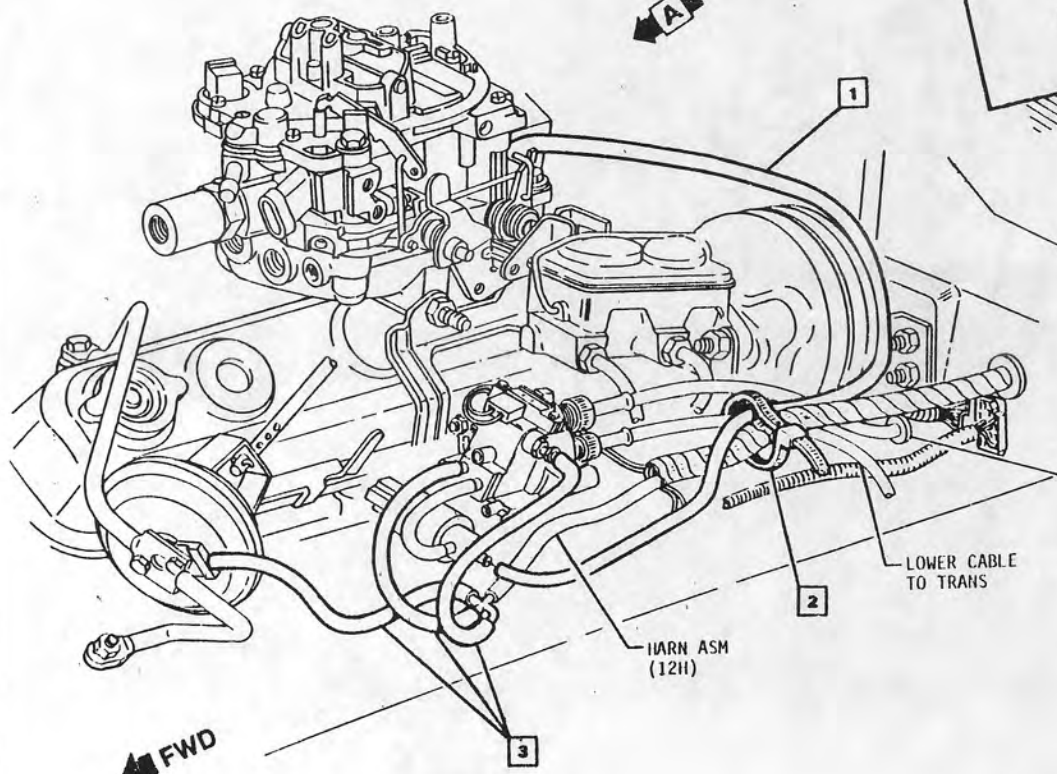
UPC 6N4

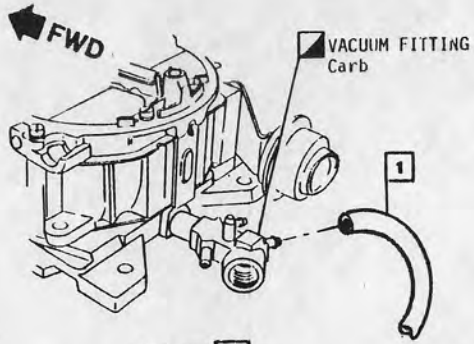
SHEET 7

Ch ☒ B ☐ O ☐ P ☒ Co ☐

9436856	1	HOSE
11501906	2	STRAP
10010684	3	HARNESS ASM

CANCELED





WAITING LAYOUT APPROVAL

DYNAMIC (Instal) N·m	HAND (Insp.) · N·m
1 2 3 4 5	⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CNG
07NOV80	1	SHEET CANCELED	91222	TU	EF	
		270				

DATE 11APR80
DR R.TAYLOR
CK Jim Hayes TH
APPR NS
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

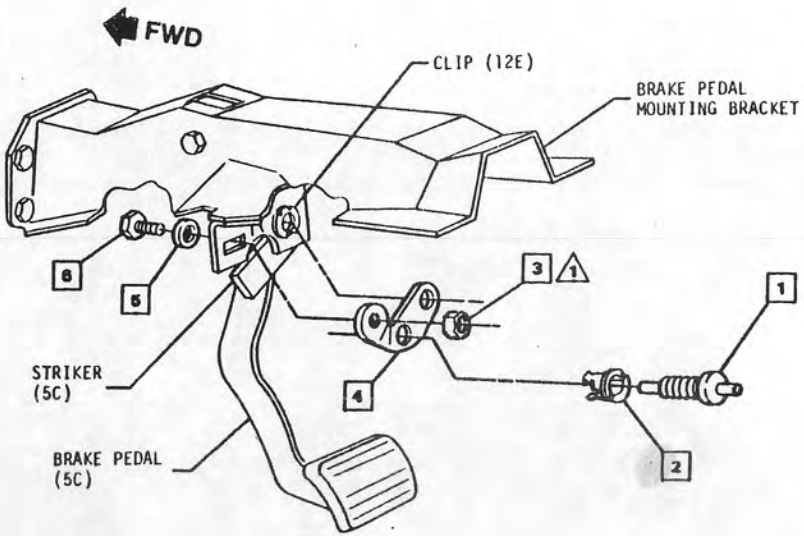
TITLE CRUISE CONTROL-TUBE ROUTING FA00 & LU8 & K35

REF ECR 86448 NEW 25MR80

UFC 6N4

SHEET 7.1

Ch X B O P Co



407437	1	VALVE ASM-VAC RELEASE
9796744	2	RETAINER
9417954	3	NUT
10007040	4	BRACKET
120393	5	WASHER
9419030	6	BOLT/SCREW

INSTALLATION OF SELF-ADJUSTING VACUUM RELEASE VALVE

1. Install retainer [2]
2. With brake pedal depressed, insert valve [1] into tubular retainer until valve seats on retainer. Note that audible "clicks" can be heard as threaded portion of valve is pushed through the retainer toward the brake pedal.
3. Pull brake pedal fully rearward against pedal stop, until audible "click" sounds can no longer be heard. Valve will be moved in tubular retainer providing adjustment.
4. Release brake pedal, and then repeat step #3, to assure that no audible "click" sounds remain.

DYNAMIC (Install) N·m	HAND (Insp.) - N·m
1	14-20
2	
3	
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
		271				

Ch X B O P X Co

DATE 16 FEB 0
DR R.C. TAYLOR
CK Jim Hayes TH
APPR 5
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE CRUISE CONTROL VACUUM RELEASE VALVE FA00 & K35

REF ECR 86448 C/O 16JA80 6N4-7

T L-21192 (S) L- L- L-

UPC 6N4

SHEET 8

PONTIAC MOTOR DIVISION
General Motors Corporation Pontiac, Michigan

PRODUCT DESCRIPTION MANUAL
□ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF

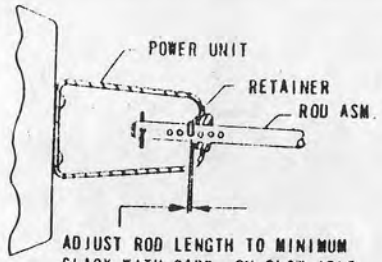
MANDATORY ASSEMBLY SEQUENCE

A. BOLT BRACKET [6] TO INTAKE MANIFOLD (SERVO MAY BE SUB-ASSEMBLED TO BRACKET OR ASSEMBLED NEXT)

B. ASSEMBLE SERVO ROD ACTUATOR [3] TO CARB LEVER. THEN ASSEMBLE ROD TO SERVO

C. ADJUST PER FIGURE 1 AND INSTALL RETAINER

D. CHECK FOR FREE OPERATION TO WIDE OPEN THROTTLE AND RETURN



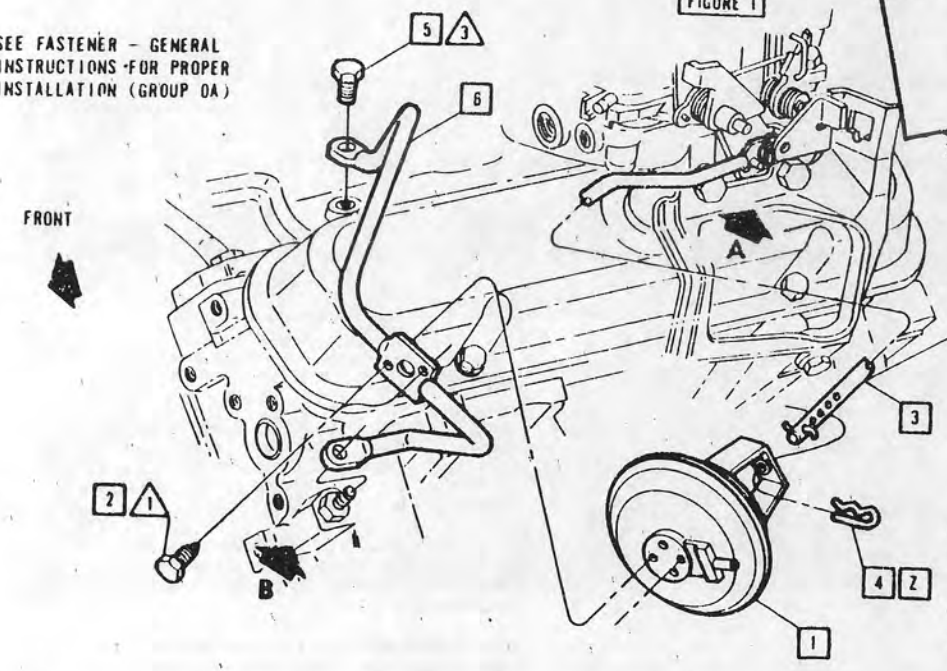
ADJUST ROD LENGTH TO MINIMUM SLACK WITH CARB. ON SLOW IDLE CAM AND ENGINE NOT RUNNING

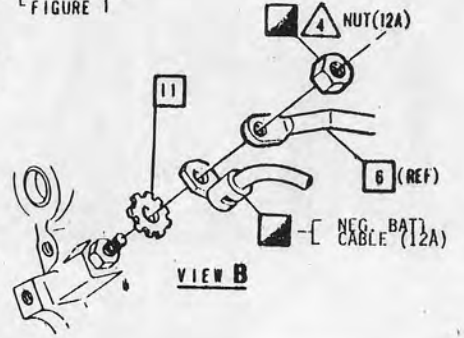
FIGURE 1

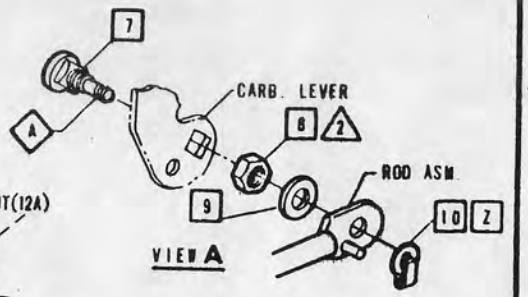
25030578	1	SERVO - CRUISE CONTROL
11504874	2	SCREW
+ 10016225	3	ROD ASM. - ACTUATOR
1351769	4	RETAINER
+ 11501939	5	BOLT/SCREW
10010191	6	BRACKET
10010190	7	PIN
124824	8	NUT
9419274	9	WASHER
1247872	10	RETAINER
11500417	11	WASHER

CANCELED

[Z] SEE FASTENER - GENERAL INSTRUCTIONS FOR PROPER INSTALLATION (GROUP 0A)







◇ 9985276 - Grease
◇ 9985377 - Grease
OPT.

DYNAMIC (Install) N.m	HAND (Insp.) N.m
△1	1.2 - 1.6
△2	5.5 - 8.0
△3	20 - 34
△4	26 - 48
△5	

△ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
18APR80		ISSUED	86448	GU	JEB	
07NOV80	1	SHEET CANCELED	91223	CU	EF	

272

DATE 08 JA 80
DR G.M. VERSTRAETE
CK JEB
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
SERVO UNIT MOUNTING
FP87 & LU8 & K35

REF ECR 86448
C/O 09AP80
6N4-11 RT

2 [illegible] 77200

UPC 6N4

SHEET 9

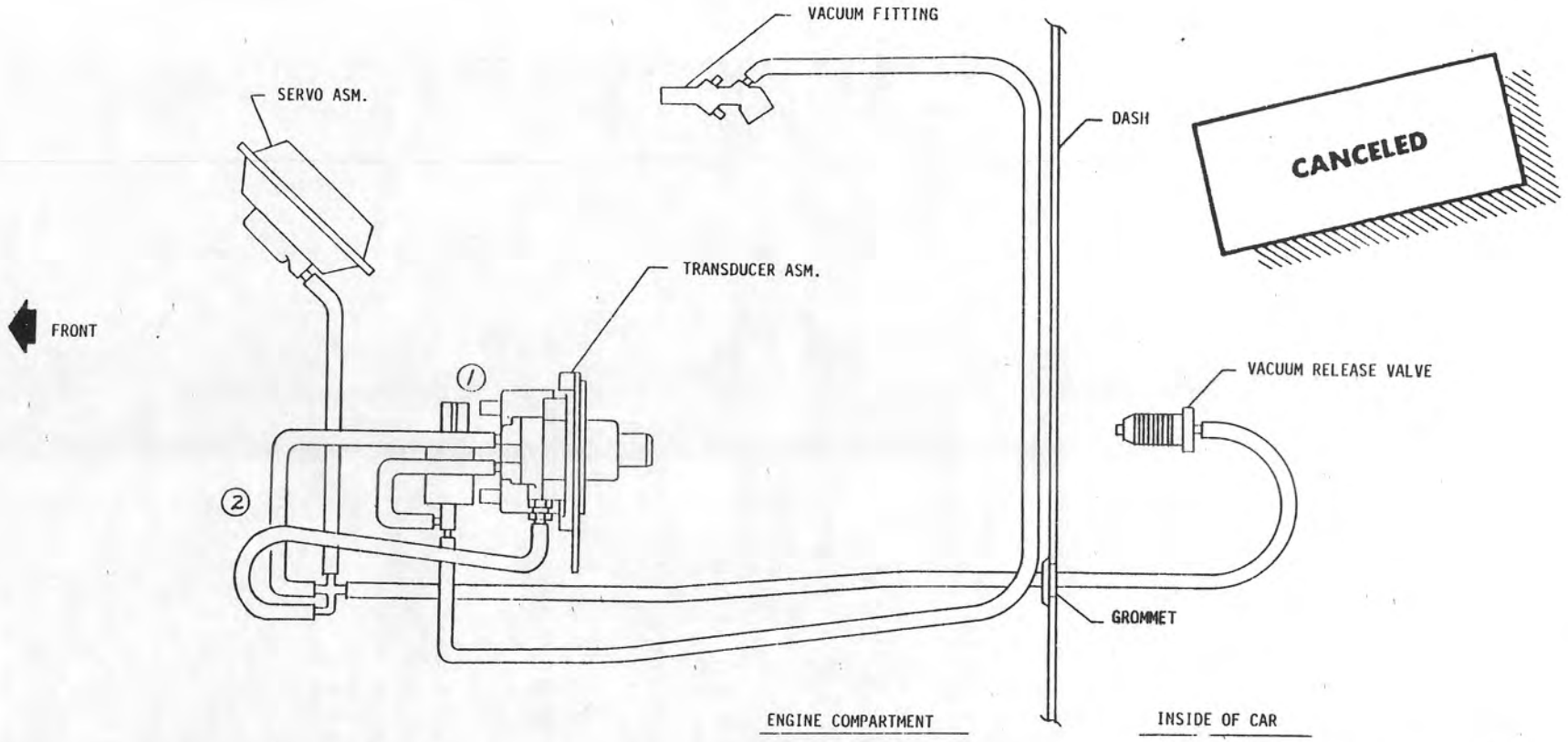
Ch X D O P X Co

PONTIAC MOTOR DIVISION

General Motors Corporation Pontiac, Michigan

PRODUCT DESCRIPTION MANUAL

□ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF



THIS DRAWING IS FOR REFERENCE PURPOSES ONLY

DYNAMIC (Instal) N·m	HAND (Insp.) - N·m
1	
2	
3	
4	
5	

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
4JAN80		ISSUED	86448	RT	RH	
13APR80	1	TRANSDUCER DWG REVISED	88900			C
	2	HOSES REROUTED	AUDIT	CU	RH	
01NOV80	3	SHEET CANCELED	91222	CU	EF	

273

DATE	07 JA 80
DR	G.M. VERSTRAETE
CK	BAB
APPR	HH
APPR	
APPR	
APPR	

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE SCHEMATIC VACUUM TUBE DIAGRAM FA00 & LU8 & K35

REF ECR 86448
NEW 26FE80
6N4-1.3 RT

UPC **6N4**

SHEET **10**

Ch B O P Ca

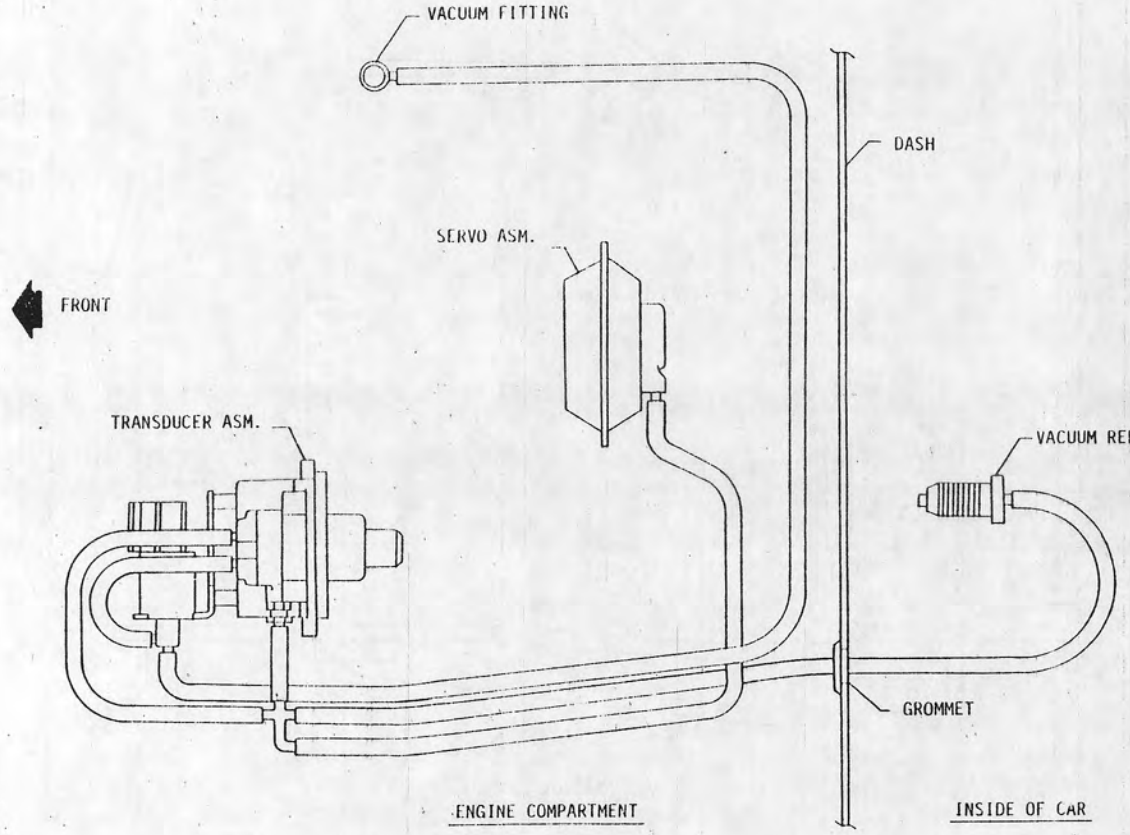
KdE• 4330

PONTIAC MOTOR DIVISION

General Motors Corporation Pontiac, Michigan

PRODUCT DESCRIPTION MANUAL

□ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF



THIS DRAWING IS FOR REFERENCE PURPOSES ONLY.

DYNAMIC (Instal) N.m	HAND (Insp.) - N.m

△1 △2 △3 △4 △5

△1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
07FEB0		ISSUED	BCHB	CU	RC	
		271				

DATE 07 JA 80
DR G.M. VERSTRAETE
CK BAG
APPR HH
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE SCHEMATIC VACUUM TUBE DIAGRAM FA00 & LD5

REF ECR 86448 NEW 30JA80 6N4-1.1 RT

UPC 6N4

SHEET 11

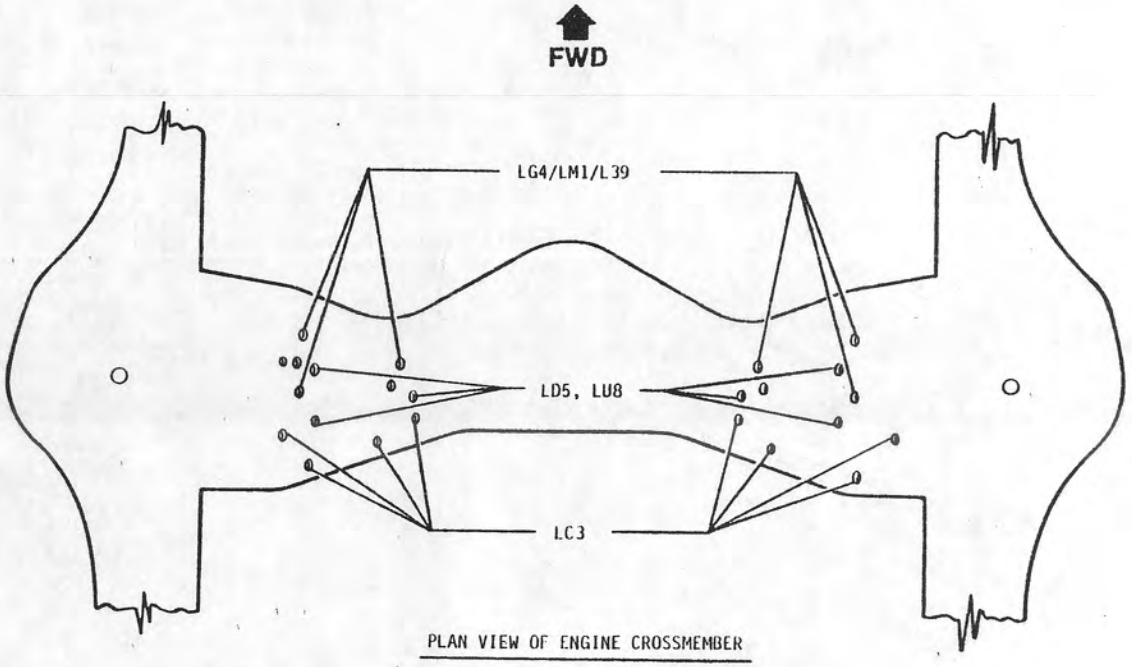
CK X B O P X Ca

SAE 4330

General Motors Corporation
CHEVROLET MOTOR DIVISION

PRODUCT DESCRIPTION MANUAL

□ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF



PLAN VIEW OF ENGINE CROSSMEMBER

DYNAMIC (Install) N·m	HAND (Insp.) N·m
1	
2	
3	
4	
5	

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
		275				

DATE 17JA80
DR J. PARK
CK
APPR (S)
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE ENGINE MOUNT BOLT LOCATION ON FRAME
FA00 ALL

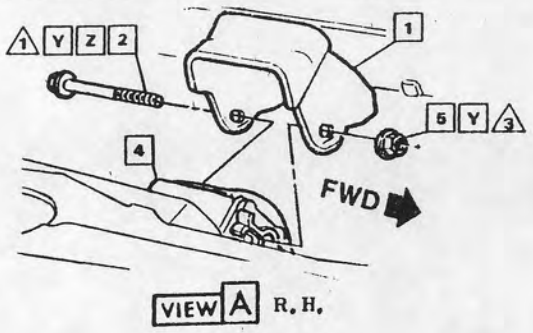
REF FCR 86448
C/O 14JA79
6Q-1

1-1- 19208(S)
2-1- 75254(S)
2-1- 75309(S)
1-

UPC 6Q

SHEET 1

C | B | O | P | Ca

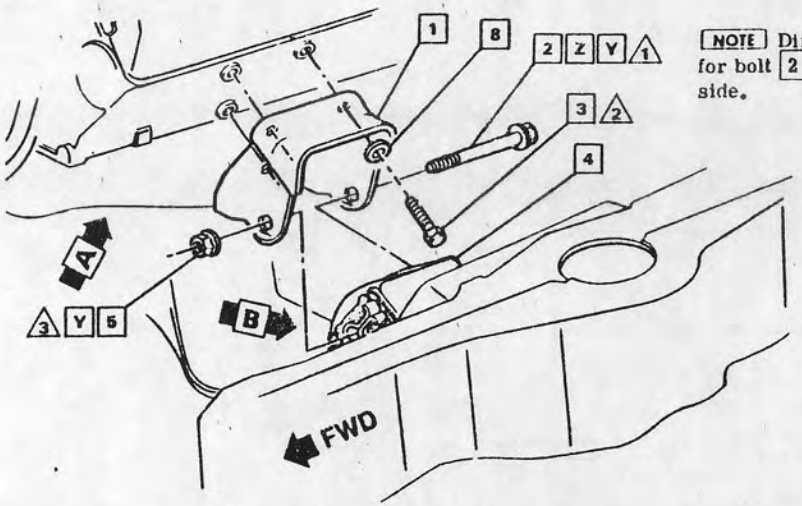


VIEW A R.H.

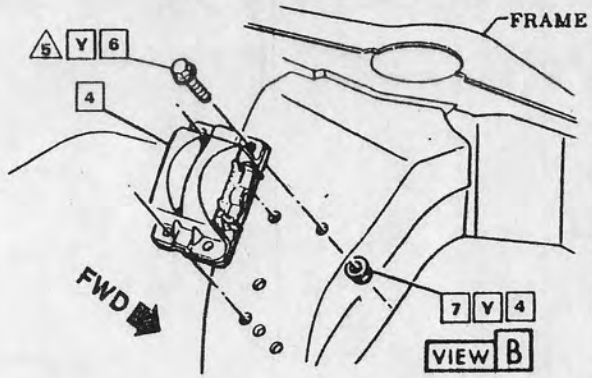
332648	1	BRACKET
6262211	2	BOLT/SCREW
9420942	3	BOLT/SCREW
470780	4	MOUNTING ASM
6262212	5	NUT
11502788	6	BOLT/SCREW
11502812	7	NUT
103321	8	WASHER

Y Bolt or nut may be torqued optionally.

Z Align L.H. engine mounting to frame bracket hole & assemble L.H. "Thru" bolt, then assemble R.H. "Thru" bolt.



NOTE Direction of installation for bolt 2 is optional on L.H. side.



DYNAMIC (Install) N·m	HAND (Insp.) N·m
△1	80-110
△2	40 - 54
△3	60 - 75
△4	34 - 48
△5	38 - 52

△ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
		276				

DATE 7/24/80
DR J. PARK
CK
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE ENGINE MOUNTING
FA00 &LG4/LM1/L39

REF ECR 86448
C/O 12DE79
6Q-2

1-1-98052(S)
L-
L-
L-

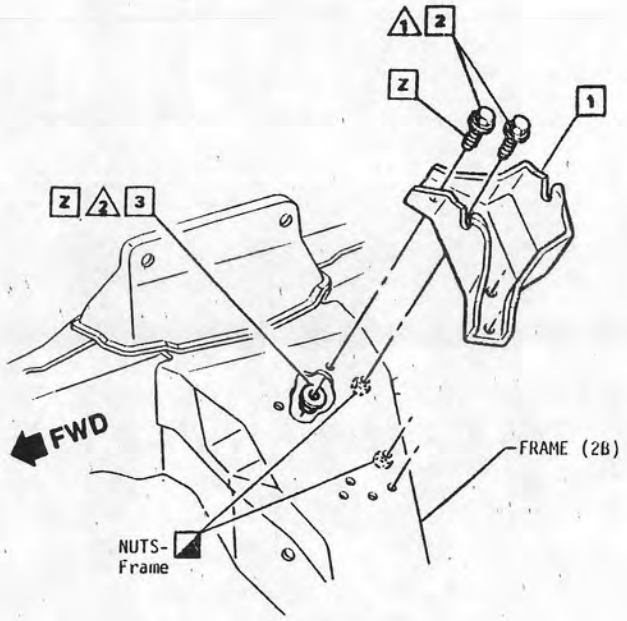
UPC 6Q

SHEET 2

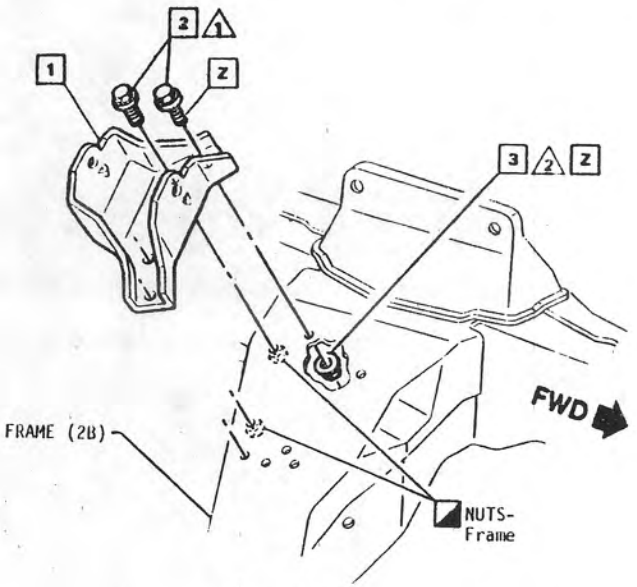
Ch | I | O | P | Co

14022435-6	1	BRACKET ASM L & RH
11502788	2	BOLT/SCREW
11502812	3	NUT

Z Bolt or nut may be torqued optionally.



RIGHT SIDE



LEFT SIDE

DYNAMIC (Install) N·m	HAND (Insp.) N·m
1	34-46
2	28-38
3	
4	
5	

2 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CKG
		277				

DATE 11JA80
DR J PARK
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE ENGINE MOUNTING BRACKET
FA00 &LC3

REF ECR 86448
C/O 12DE79
6Q-3

I- 19208 (S)
I-
I-
I-

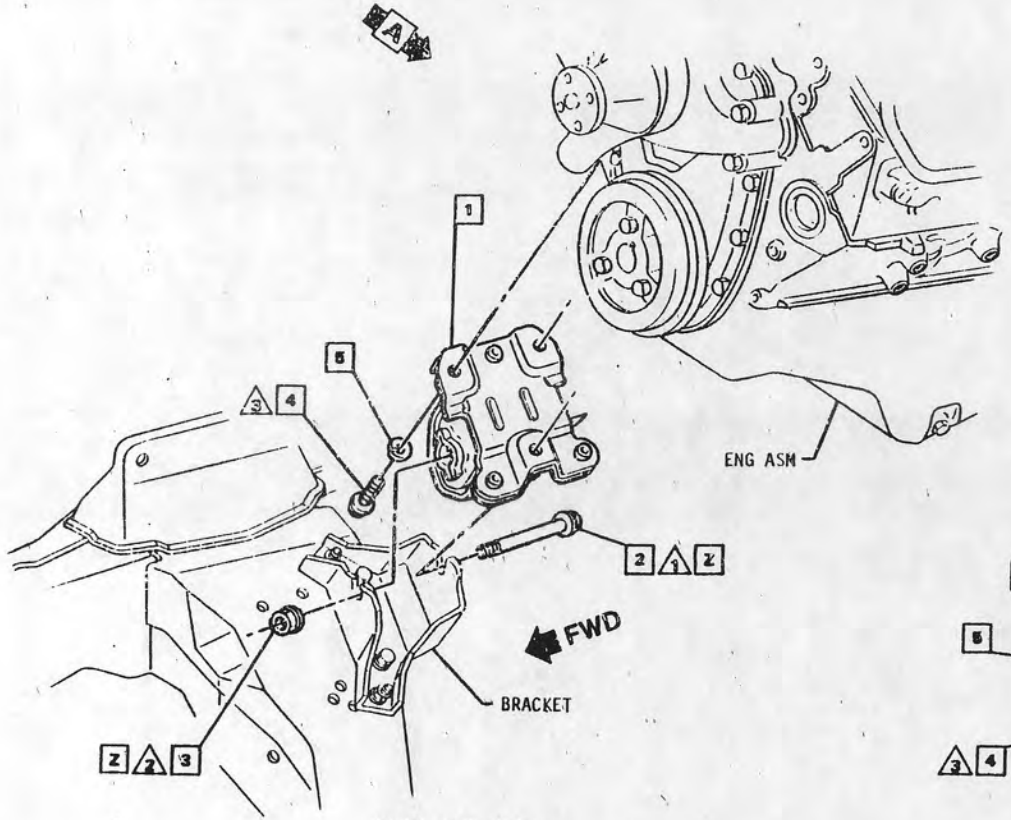
UPC 6Q

SHEET 3

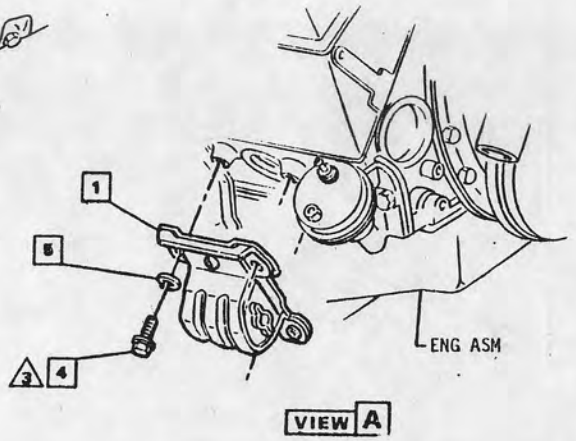
Cb X B 0 P X Co

467427-8	1	MOUNTING ASM L & RH
363453	2	BOLT/SCREW
	2	
6262212	3	NUT
9420942	4	BOLT/SCREW
103321	5	WASHER

Z Bolt or nut may be torqued optionally.



RIGHT SIDE SHOWN-
LEFT SIDE TYPICAL



VIEW A

DYNAMIC (Instal) N.m	HAND (Insp.) · N.m
1	1 80 - 110
	2 60 - 75
	3 40 - 54
	4
	5
	⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
19MAR81	1	TORQ WAS 90-110	96239	CU	Rd	C

DATE 11.14.80
DR J. PARK
CK
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE ENGINE MOUNTING
FA00 &LC3

REF ECR 86448
C/O 12DE79
6Q-4

L-19208 (S)
L-
L-
L-

UPC 6Q

SHEET 4

278

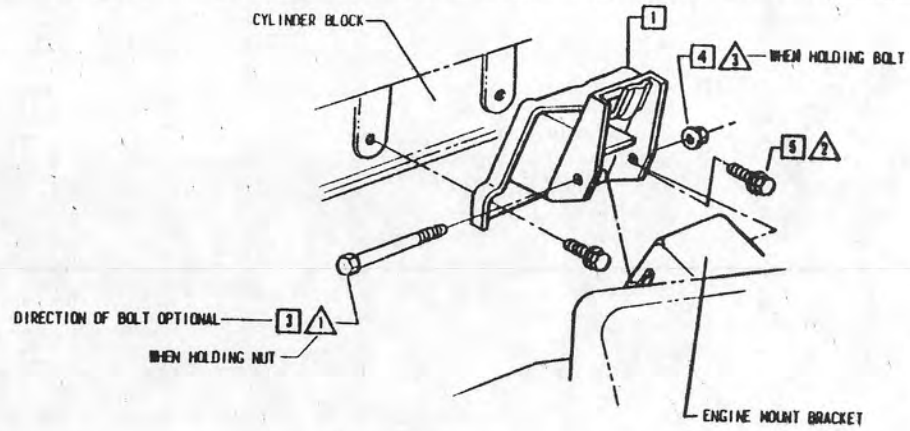
Ch X B O P Co

PONTIAC MOTOR DIVISION

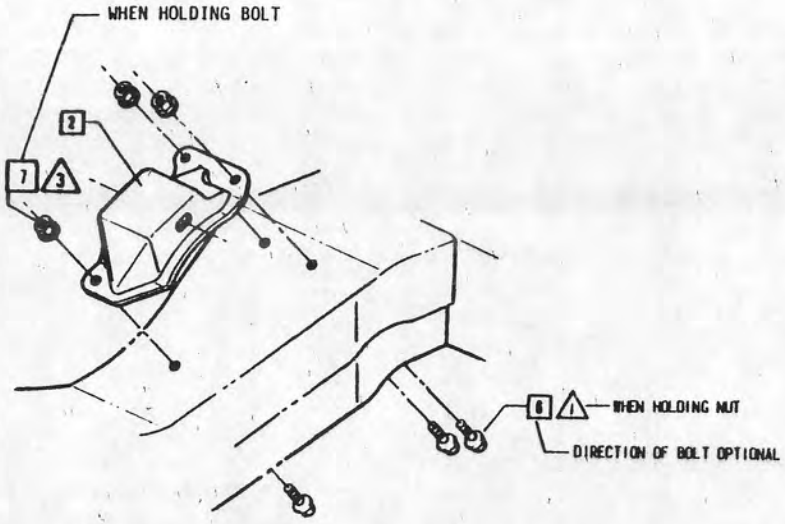
General Motors Corporation Pontiac, Michigan

PRODUCT DESCRIPTION MANUAL

□ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF



L.H. SIDE SHOWN
R.H. SIDE OPPOSITE



R.H. SIDE SHOWN
L.H. SIDE OPPOSITE

1258718	1 MOUNT ASM. - R.H. (CODE WHITE)
25504645	MOUNT ASM. - L.H. (CODE RED)
10014337	2 BRACKET ASM. - R.H.
10014338	BRACKET ASM. - L.H.
9419713	3 BOLT
6262212	4 NUT
1244786	5 BOLT
11502788	6 BOLT
11502812	7 NUT

DYNAMIC (Tested) N·m	HAND (Insp.) N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
1	55-75	17JAN80		ISSUED	86448	CU	AJ	
2	70-90							
3	34-48							
4								
5								

1 FULLY DRIVEN SEATED & NOT STRIPPED

279

Ch X 8 | 0 | P X Ca

DATE 19 OC 79
DR G.M. VERSTRAETE
CK C.A.R
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE ENGINE MOUNTING FA00 & LD5

REF ECR 86448 C/O 11DE79 6Q-3 JP

UPC 6Q

SHEET 5

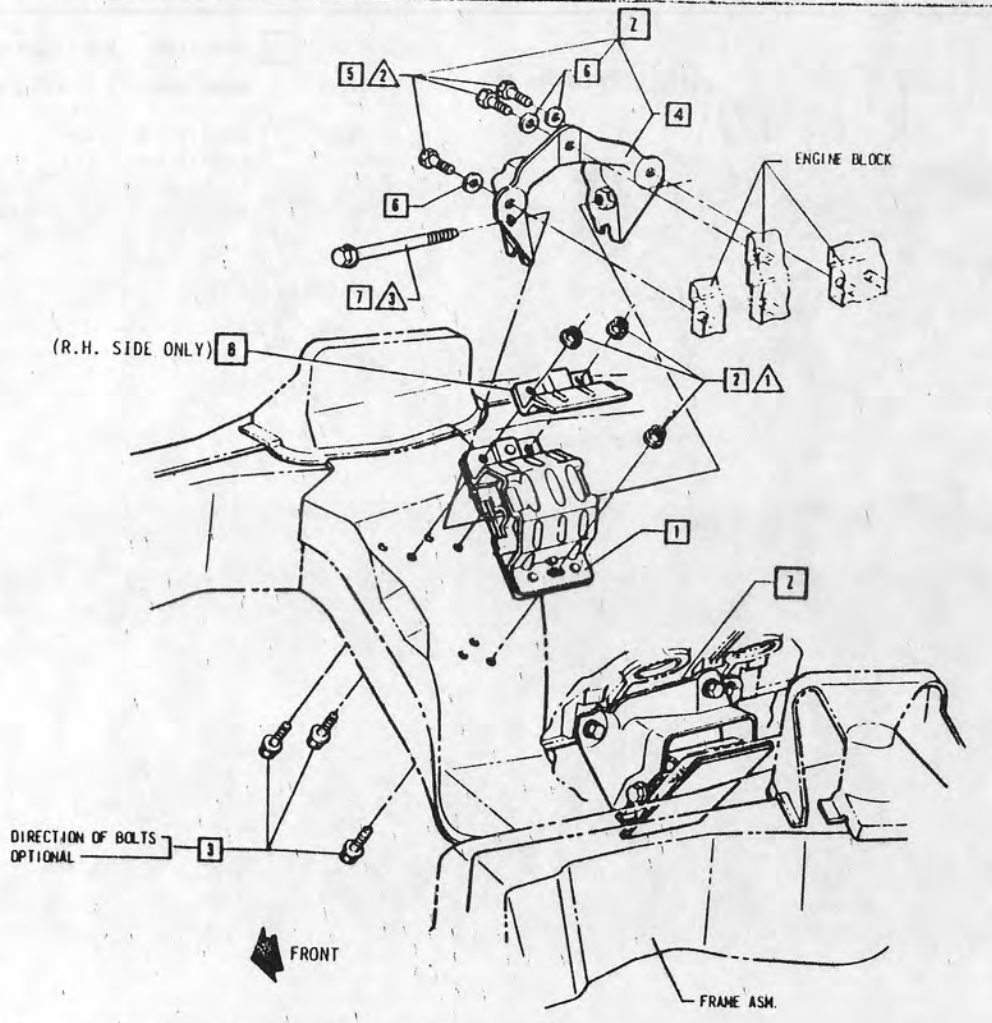
E-OE 10 1283 12-78 4014

PONTIAC MOTOR DIVISION

General Motors Corporation Pontiac, Michigan

PRODUCT DESCRIPTION MANUAL

□ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF



10014252 10001090	1	INSULATOR ASM. - R.H. INSULATOR ASM. - L.H.
11502812	2	NUT (6)
11502788	3	BOLT (6)
496892 496893	4	BRACKET ASM. - R.H. BRACKET ASM. - L.H.
454932	5	BOLT
103328	6	WASHER
334972	7	BOLT
1009607	8	SHIELD

CANCELED

2 EXISTING PARTS (UPL) INSTALLED BY ENGINE PLANT

DYNAMIC (Instal) N·m	HAND (Insp.) N·m
1	34-48
2	70-90
3	55-75
4	
5	

⚠ FULLY DRIVEN SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CAS
11ASO		ISSUED	86448	CU		
01NOBO	1	SHEET CANCELED	91222	CU	EJ	

280

DATE 31 OC 79
DR G.M. VERSTRAETE
CK C.A.R.
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE ENGINE MOUNTING FA00 & LU8

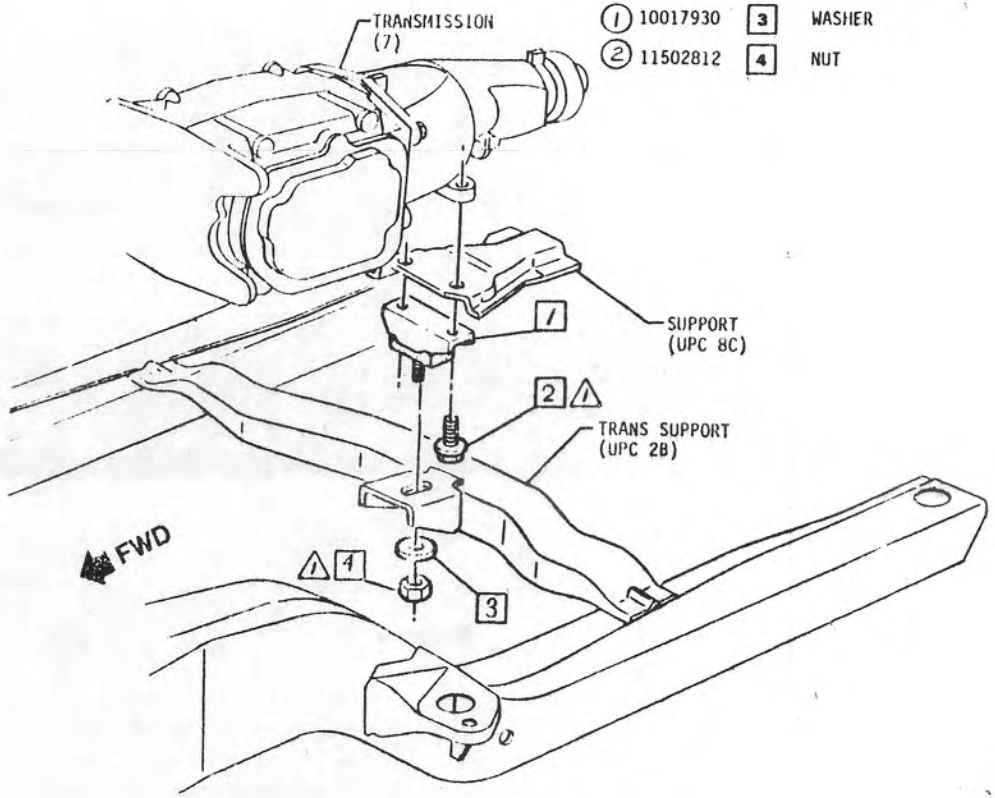
REF ECR 86448 C/O 11DE79 6Q-2 JP

UPC 6Q

SHEET 6

Ch | B | O | P | Co

459008	1	MOUNTING ASM
11502599	2	BOLT/SCREW
(1) 10017930	3	WASHER
(2) 11502812	4	NUT



DYNAMIC (Instal) N·m	HAND (Insp.) - N·m
△1	40 - 54
△2	
△3	
△4	
△5	

△ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
22AU80	1	WAS 11502474 WASHER				
	2	WAS 11501033 NUT	91898	CU	RC	

281

DATE 17JA80
DR J. PARK
CK
APPR (S)
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
TRANSMISSION MOUNTING
FA00 &LC3/LG4/LM1/L39

REF			UPC	SHEET
ECR 86447 C/O 14JA79 6Q-	1-1- 79860(S) 1- 1-		6Q	7

A B O P Co

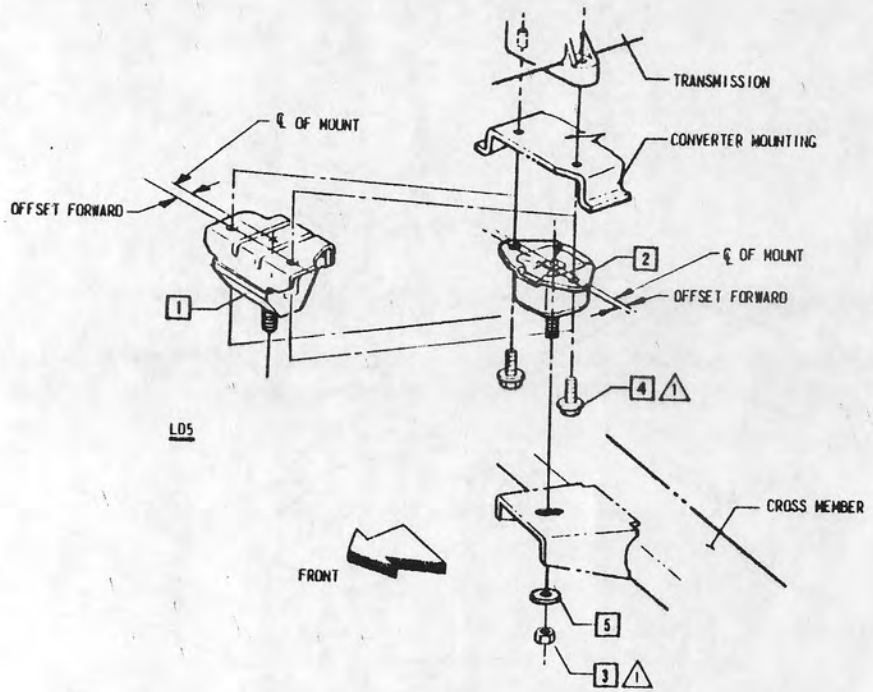
PONTIAC MOTOR DIVISION

General Motors Corporation Pontiac, Michigan

PRODUCT DESCRIPTION MANUAL

☐ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF

1258670	1	MOUNT ASM. - LD5 (.60 OFFSET)
(3) 10001751	2	MOUNT ASM. - LS5 (.20 OFFSET)
(1) 11502812	3	NUT
11502588	4	BOLT/SCREW
(2) 10017930	5	WASHER



DYNAMIC (Install) N.m	HAND (Insp.) N.m
△1 40-54	
△2	
△3	
△4	
△5	

△1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
11AP80		ISSUED	86998	JP	DD	
22AU80	1	WAS 11501033 NUT				
	2	WAS 11502474 WASHER	91898			
	3	"LU8" REM (2) PLCS	91222	CU	R	

282

DATE	190C79
DR	G.M. VERSTRAETE
CK	C.A.R.
APPR	S
APPR	
APPR	
APPR	

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE (3) FA00 &LD5 or LS5 TRANSMISSION MOUNTING

REF ECR 86448 C/O 08AP80 6Q-9 JP

L-75597 L-75622 L-75623

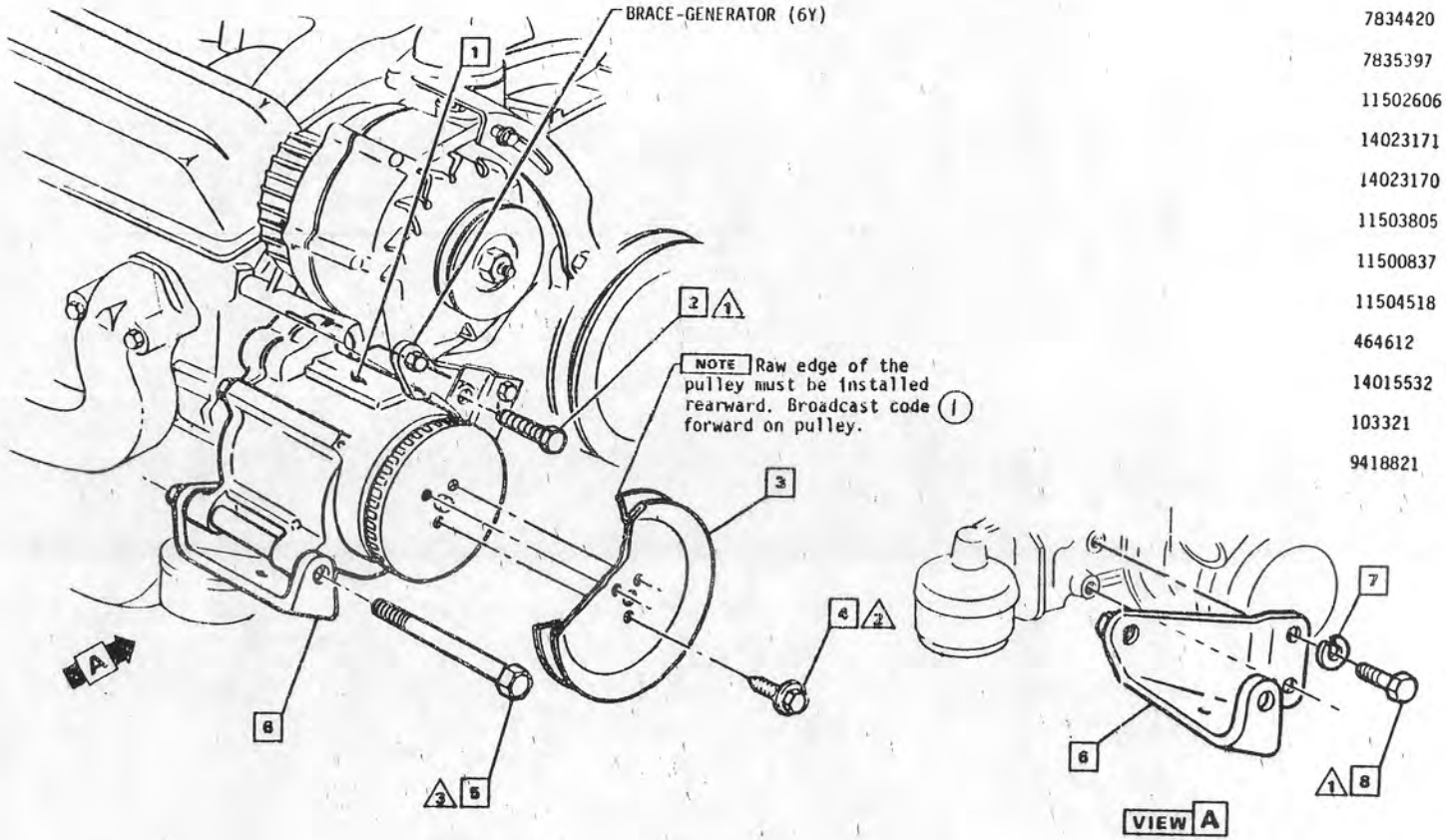
UPC 6Q

SHEET 8

Cb X 0 0 P X Ca

PRODUCT DESCRIPTION MANUAL

☐ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF



7834420	1	PUMP ASM & LC3
7835397	1	& L39/LG4/LM1
11502606	2	BOLT/SCREW
14023171	3	PULLEY & C41
14023170	3	& C60
11503805	4	BOLT/SCREW
11500837	5	BOLT/SCREW & LC3
11504518	5	& L39/LG4/LM1
464612	6	BRACKET & LC3
14015532	6	& L39/LG4/LM1
103321	7	WASHER
9418821	8	BOLT/SCREW

DYNAMIC (Instal) N·m	HAND (Insp.) - N·m
1	26-36
2	8-11
3	20-27
4	
5	

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
030C80	1	"PULLEY" NOTE REV	86448	CU	RCT	C

283

DATE 07FE80
DR R. KOCH
CK
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
A.I.R. PUMP
FA00 & LC3/LG4/L39/LM1 & K19

REF ECR 86448
C/O 17JA80
6T-1

11-86342 (S)

UPC 6T

SHEET 1

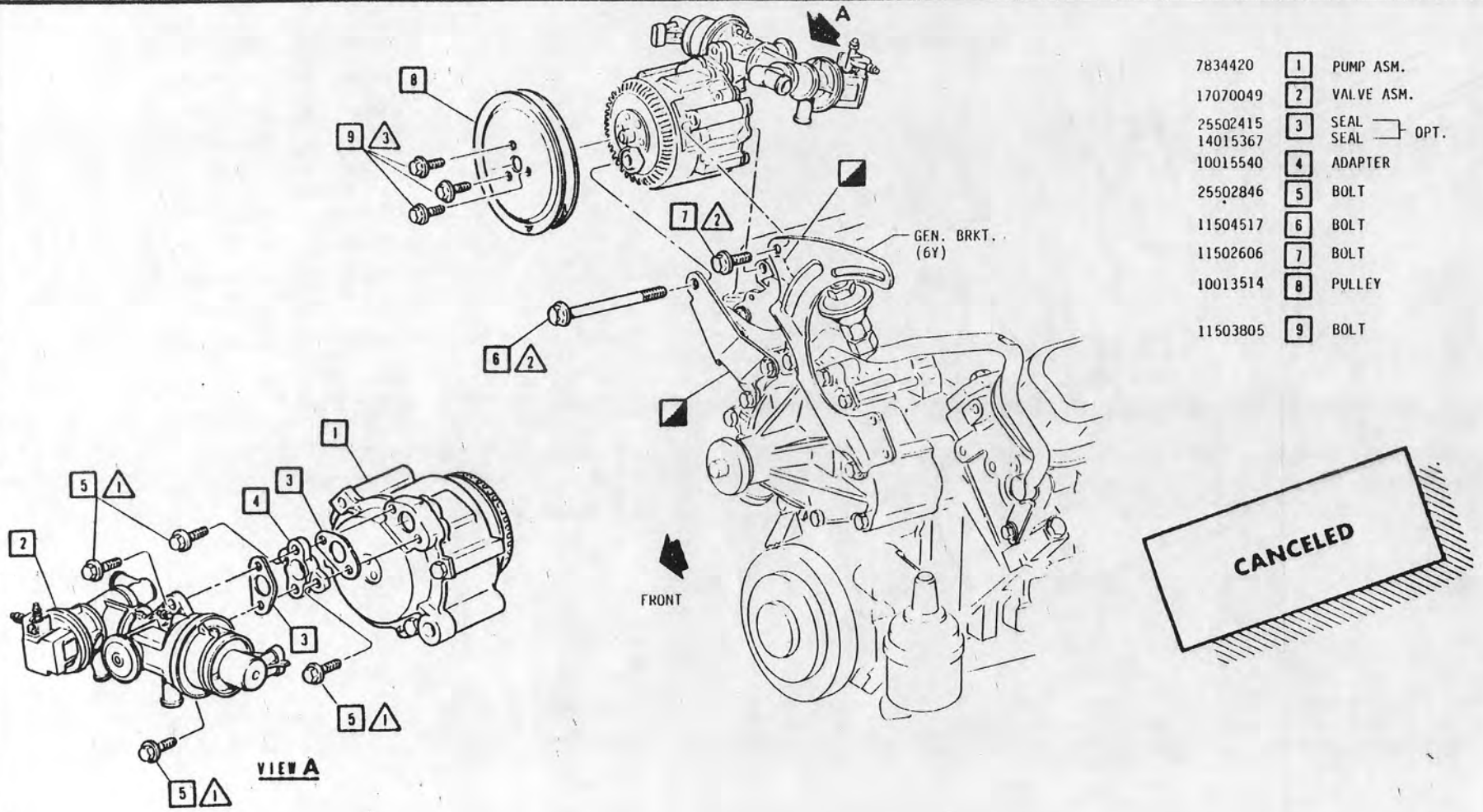
Ch | B | O | P | Ca

PONTIAC MOTOR DIVISION

General Motors Corporation Pontiac, Michigan

PRODUCT DESCRIPTION MANUAL

□ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF



7834420	1	PUMP ASM.
17070049	2	VALVE ASM.
25502415 14015367	3	SEAL SEAL — OPT.
10015540	4	ADAPTER
25502846	5	BOLT
11504517	6	BOLT
11502606	7	BOLT
10013514	8	PULLEY
11503805	9	BOLT

CANCELED

DYNAMIC (Instal) N·m	HAND (Insp.) N·m
1	12-16
2	40-60
3	8-12
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
REMADE OTMOBO	1	ISSUED	86448	CLI	[illegible]	
		SHEET CANCELED	11222	CLI	87	

284

DATE 12 FEB 80
DR R.P. BIERI
CK JEB
APPR [illegible] 12FEB80
APPR [illegible]
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE A.I.R. PUMP MOUNTING FA00 & LU8 & NB1

REF ECR 86448 NEW 11MR80

2 L-78313 L- L-

UPC 6T

SHEET 2

Ch X B O P X Ca

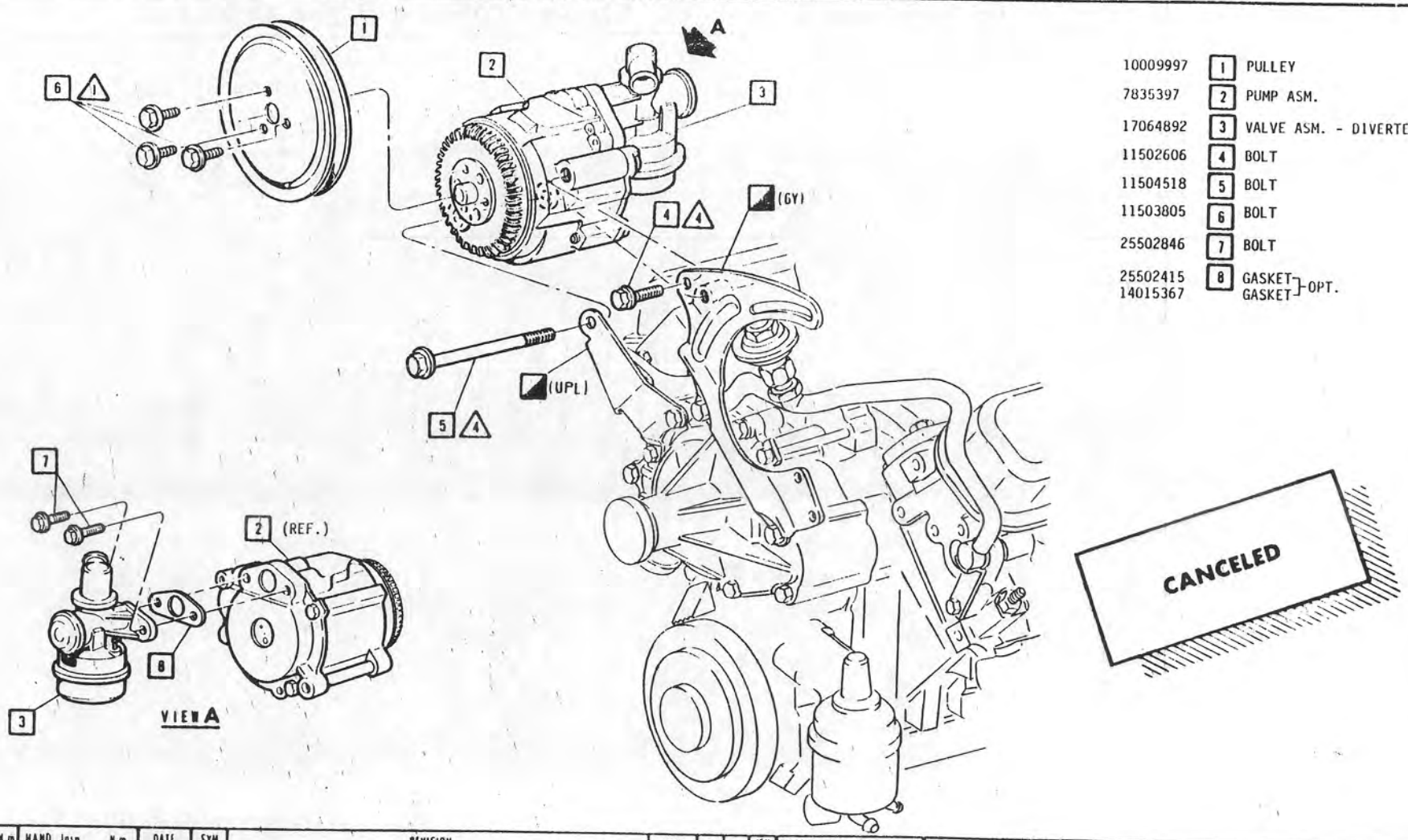
Rel. 4339

PONTIAC MOTOR DIVISION

General Motors Corporation Pontiac, Michigan

PRODUCT DESCRIPTION MANUAL

☐ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF



10009997	1	PULLEY
7835397	2	PUMP ASM.
17064892	3	VALVE ASM. - DIVERTER
11502606	4	BOLT
11504518	5	BOLT
11503805	6	BOLT
25502846	7	BOLT
25502415 14015367	8	GASKET GASKET } OPT.

DYNAMIC Instal: N.m	HAND Insp N.m
1	8-12
2	12-16
3	
4	40-60
5	

1 FULLY DRIVEN SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
15MY80		ISSUED	86448	CU	RE	
07NOV80	1	SHEET CANCELED	91222	CU	EB	

285

Ch X B O P X Ca

DATE 13 FE 79
DR R.P BIERI / KM
CK BAB
APPR WME 18APR80
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE A.I.R. PUMP ASM MOUNTING FA00 & LU8 & NM4

REF ECR 86448
NEW 05MY80
6T-3.2 RK

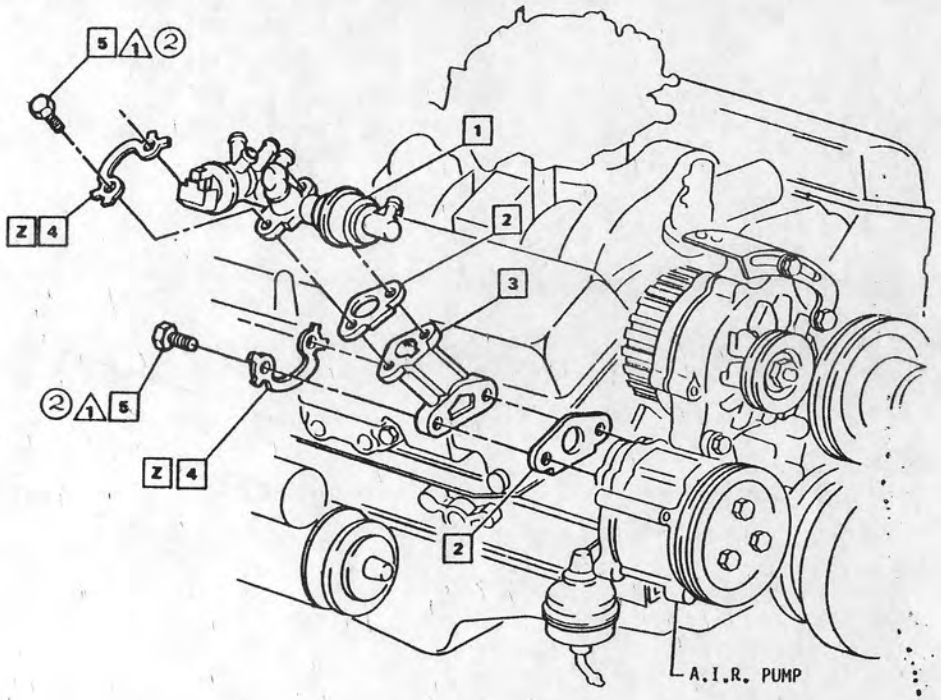
2 | 77652
2 | 77317
2 | 77538

UPC 6T

SHEET 2.1

K&E 18 1253 6-77 3313-

(3)	17071548	1	VALVE ASM
	14023103	2	GASKET
	14026181	3	ELBOW
	14015366	4	LOCK
(1)	14015365	5	BOLT/SCREW



Z Tab nearest to hex flat shall be folded against the bolt/screw heads.

DYNAMIC(Install) N·m	HAND (Insp.) · N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
△1 △2 △3 △4 △1	9-12	270CT80	1	WAS 14031110 BOLT/SCREW	85985			
			2	TORQUE 9-12 ADDED (2) PLACES	86448	CU	RC	C
		10JAN81	3	WAS 17064721 VALVE	94295	CU	RC	

△1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE 4MAR80
DR R KOCH
CK
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE VALVE ASM-A.I.R. CONTROL SWITCHING FA00 & LC3/LG4/LM1/L39

REF ECR 86448 NEW 21FE80

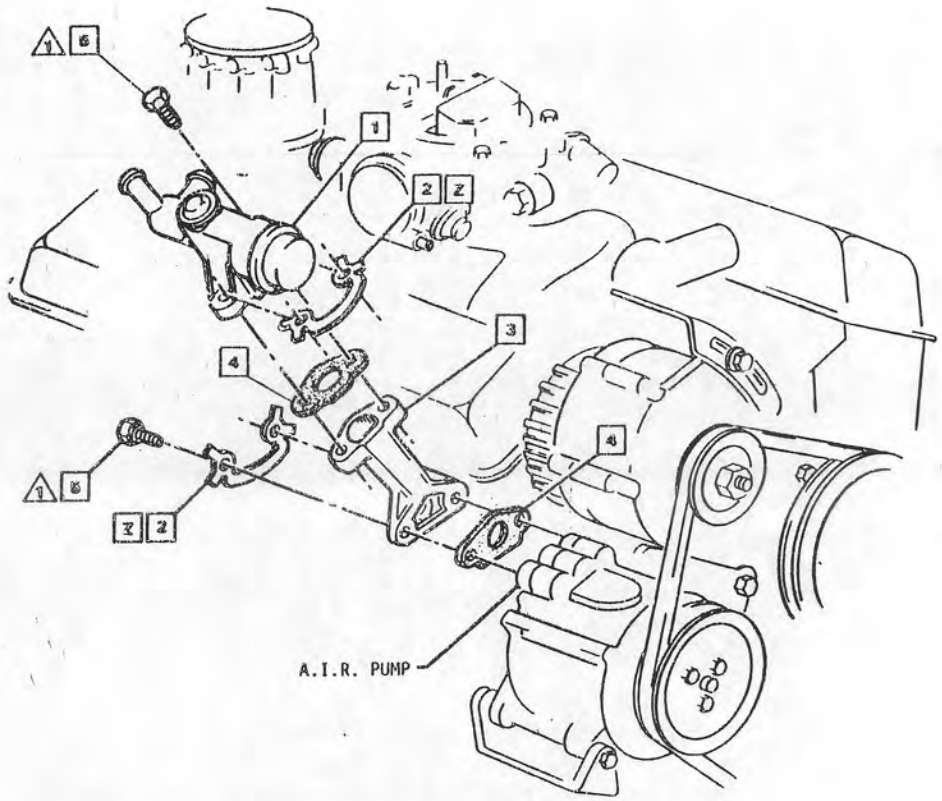
L- 22738 (S)
L-
L-
L-

UPC 6T

SHEET 3

C ☒ D ☐ Q ☐ P ☒ Co ☐

286



17063050	1	VALVE ASM-DVTR
14015366	2	LOCK
14015562	3	ELBOW
14015367	4	GASKET
14015365	5	BOLT/SCREW

Z Tab nearest to hex flat shall be folded against the bolt heads.

DYNAMIC (Install) N·m	HAND (Insp.) - N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
1 2 3 4 5	9 - 12							
				287				

1 ±1.17 DRIVEN, SEATED & NOT STRIPPED

DATE 27MR80
DR R. KOCH
CK Richard Cline Ri
APPR NS
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE A.I.R. DIVERTER VALVE FA00 &LM1 &M38 &NM4

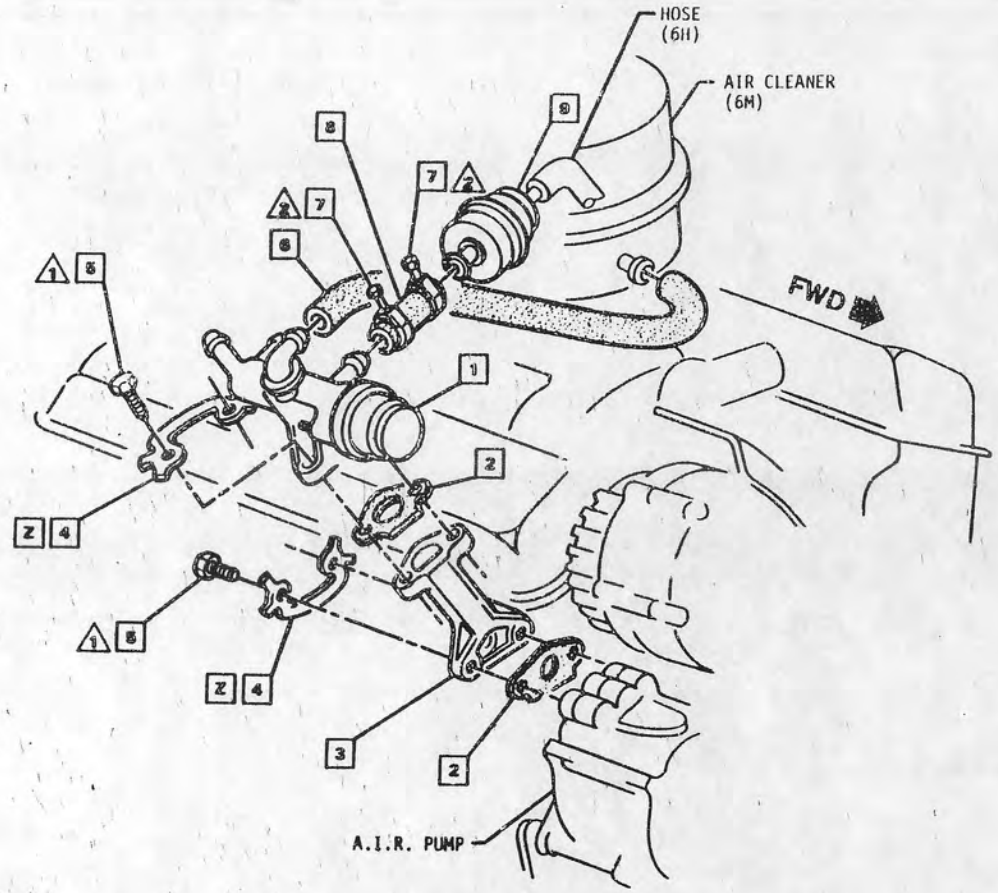
REF ECR 86448 NEW 13MR80

L- (NS) L- L- L-

UPC 6T

SHEET 3.1

Ca | q | D | P | Ca



17064300	1	AIR INTAKE CONTROL VALVE
14023103	2	GASKET
14015555	3	ELBOW
14015366	4	LOCK
14015365	5	BOLT
14023127	6	HOSE
9423574	7	CLAMP
14023107	8	HOSE
25040196	9	AIR FILTER A/C SPARK PLUG

Z Tab nearest to hex flat shall be folded against the bolt heads.

DYNAMIC (Instal) N·m | HAND (Insp.) · N·m

△1 9 - 12
△1 +
△3
△4
△5

△1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
		283				

DATE 27MR80
DR R.KOCH
CK Richard Koch
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
AIR CONTROL VALVE & FILTER
FA00 &LM1 &M24 &NM4

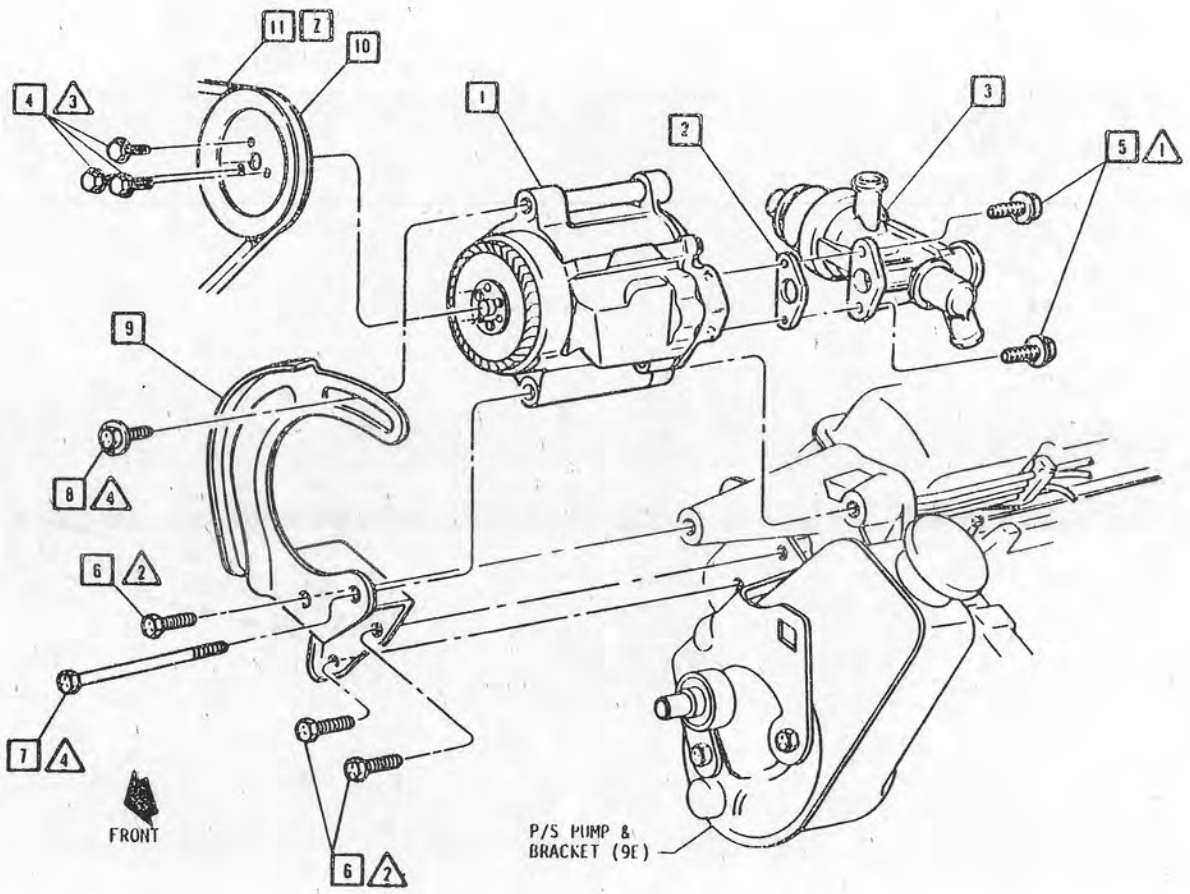
REF ECR 86448
NEW 13MR80

L- 23175 (S)
L-
L-
L-

UPC 6T

SHEET 3.2

C | N | O | P | Ca



7835396	1	PUMP ASM
7832871	1	OPT
25502415	2	SEAL
17062994	3	VALVE ASM.
11503805	4	BOLT
25502846	5	BOLT
9418822	6	BOLT
11504518	7	BOLT
11502606	8	BOLT
10010233	9	BRACKET
547227	10	PULLEY (ZS)
9433756	11	BELT (GN)

Z FOR BELT ROUTING, SEE BELT & PULLEY DIAGRAM - GROUP 6Z

DYNAMIC (Install) N·m	HAND (Insp.) N·m
1	12-16
2	26-48
3	8-11
4	40-60

1 BOLT MUST BE SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
4 FEB 80		ISSUED	SAE (4)	74		

289

DATE 26 FE 80
DR R.P. BIEBER/JMV
CK JEB
APPR WME 16AP80
APPR RJB 17AP80
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE A.I.R. PUMP & MOUNTING BRACKET FA00 &LD5 &K19

REF. ECR 86448
NEW 16SE80
6T-6 RL

UPC 6T

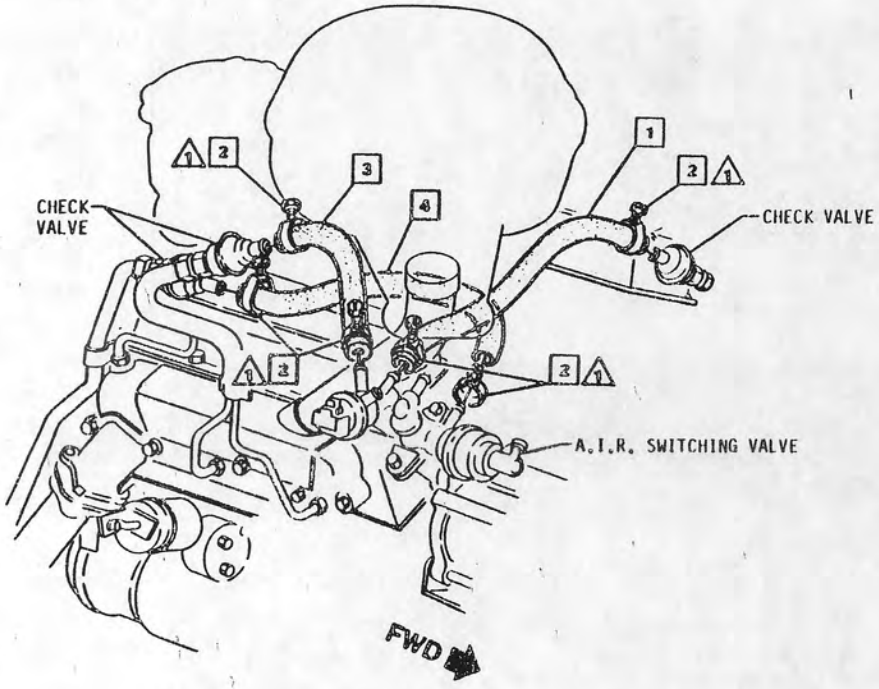
SHEET 5

Ch ☒ B ☐ D ☐ P ☒ Co ☐

PRODUCT DESCRIPTION MANUAL

☐ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF

342713	1	HOSE
9423574	2	CLAMP
3951355	3	HOSE
14031152	4	HOSE



WAITING LAYOUT APPROVAL

NOTE Do not use lubricant other than water when installing hoses.

DYNAMIC (Install) N·m	HAND (Insp.) N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
△1 +								
△2								
△3								
△4								
△5				290				

△ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE 29FEB0
DR R. KOCH
CK
APPR NSF
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE A.I.R. HOSES FA00 & LC3

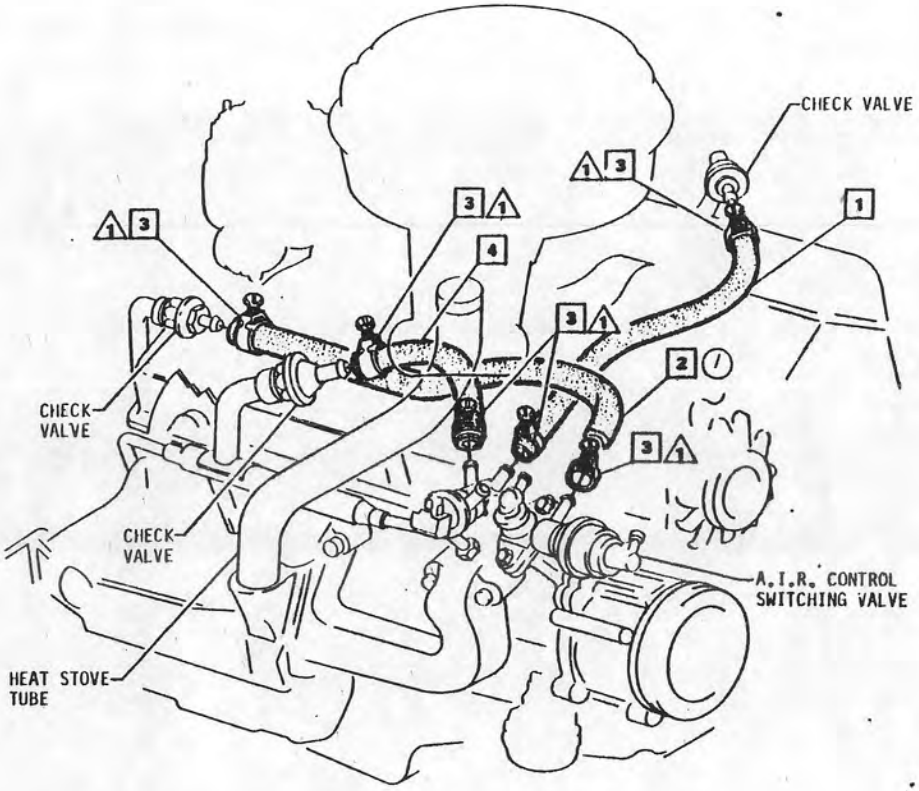
REF ECR 86448 NEW 20FE80

L-
L-
L-
L-

UPC 6T

SHEET 6

C | B | D | P | G



14006709	1	HOSE
14031155	2	HOSE
9423574	3	CLAMP
3943007	4	HOSE

NOTE Do not use lubricant other than water when installing hoses.

DYNAMIC (Install) N·m	HAND (Insp.) - N·m
⚠1	
⚠2	
⚠3	
⚠4	
⚠5	

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
14JL80	1	ITEM 2 REROUTED (PC-0020)	88765	CU	RK	C
		291				

DATE 22FE80
DR R KOCH/CU
CK Richard Cain RC
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE A.I.R. HOSES FA00 &LG4/LM1/L39

REF ECR 86448 NEW 19FE80

L-22738 (S)
L-
L-
L-

UPC 6T

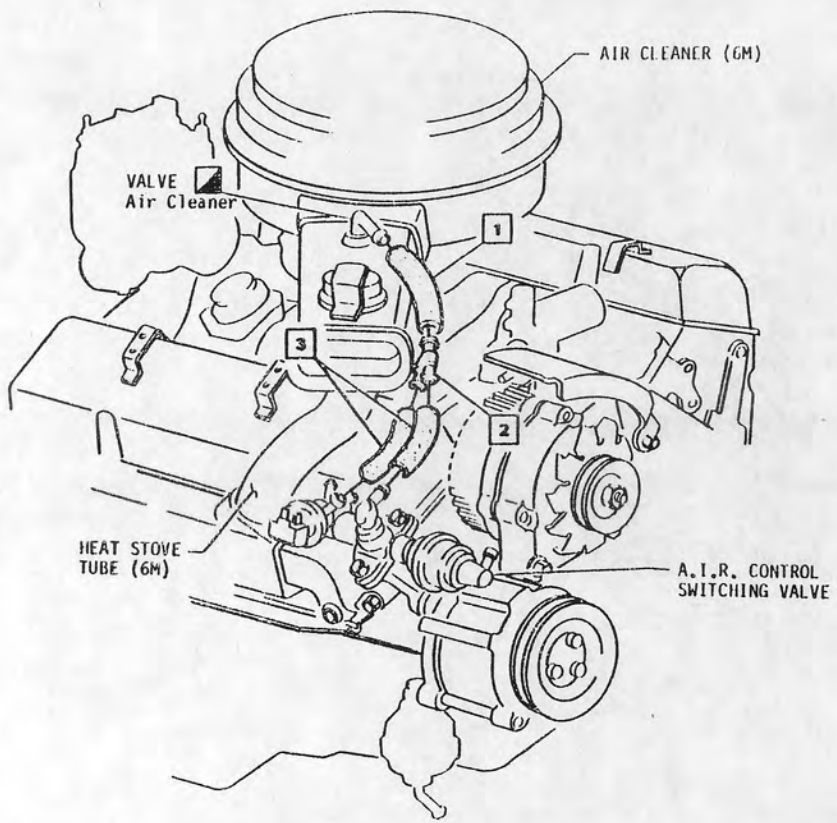
SHEET 7

C ☒ B ☐ O ☐ P ☒ Co ☐

PRODUCT DESCRIPTION MANUAL

□ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF

3940940	1	TUBE
14031110	2	CONNECTOR
14031111	3	TUBE



DYNAMIC (Install) N·m	HAND (Insp.) N·m
1	
2	
3	
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
		292				

DATE 2SEP81
DR R. KOCH /CU
CK
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
A.I.R. HOSES TO AIR CLEANER
FA00 & LC3/LG4/LM1/L39

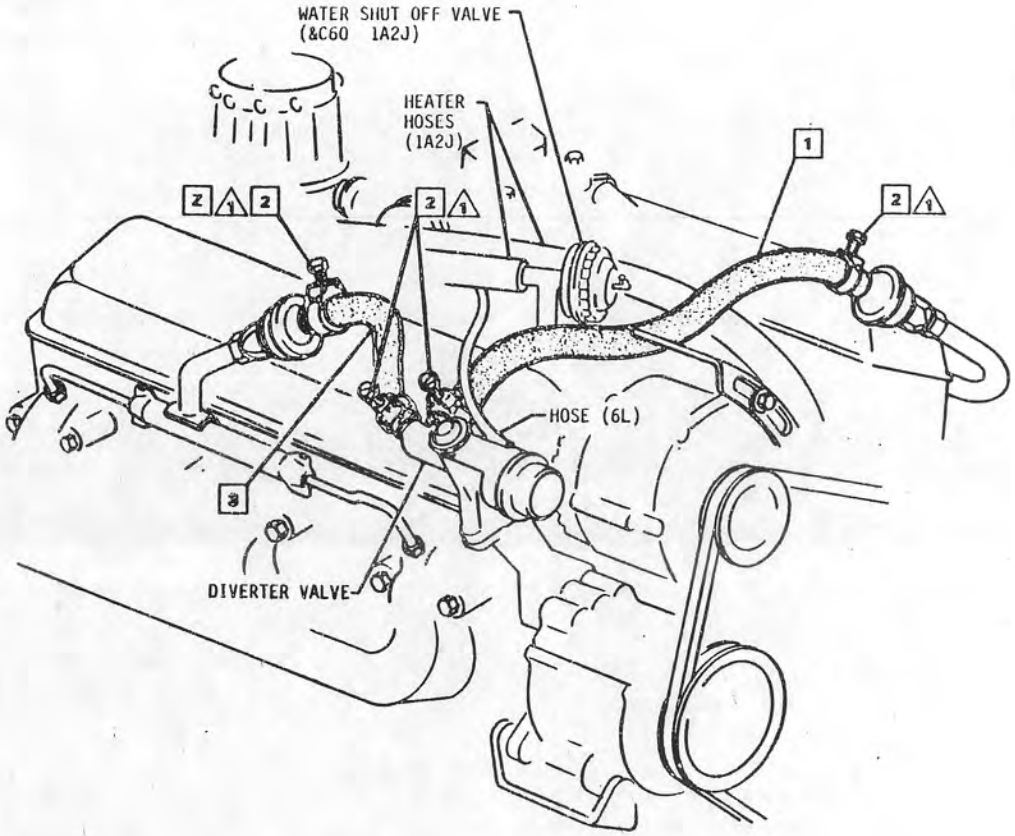
REF ECR 86448
NEW 21FE80

L-22738 (S)
L-
L-
L-

UPC 6T

SHEET 7.1

C ☒ G ☐ O ☐ P ☒ Co ☐



472804	1	HOSE LH
9423574	2	CLAMP
330554	3	HOSE RH

Z Installation of this clamp to be in a vertical position at this location.

DYNAMIC(Instal) N·m	HAND (Insp.) · N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
1	1.4 - 2.0							
2								
3								
4								
5								
⚠ FULLY DRIVEN, SEATED & HOT STRIPPED				293				

DATE 27MR80
DR R KOCH
CK Richard Koch RC
APPR NS
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE A.I.R. HOSES
FA00 &LM1 &K19 &NM4

REF ECR 86448
NEW 14MR80

L- (NS)
L-
L-
L-

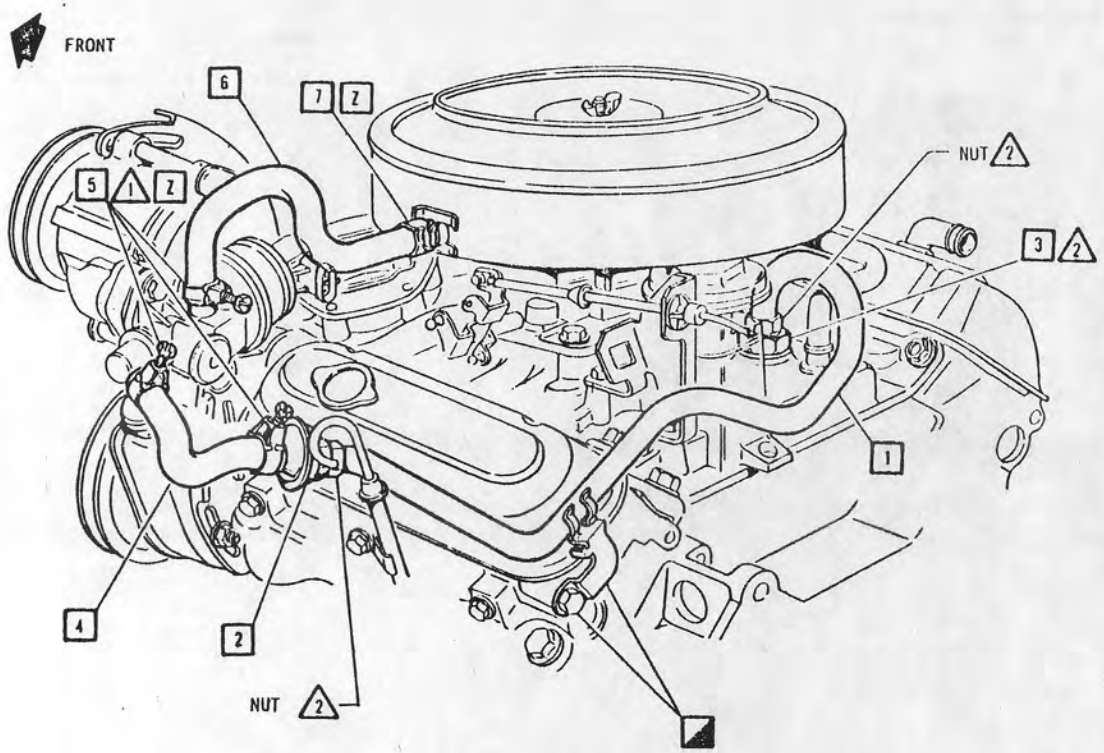
UPC 6T

SHEET 7.2

Ch X B | O | P X Co

PONTIAC MOTOR DIVISION
General Motors Corporation Pontiac, Michigan

PRODUCT DESCRIPTION MANUAL
□ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF



10018829	1	PIPE ASM.
22034707	2	VALVE ASM.
442367	3	CONNECTOR
10018175	4	HOSE
9423576	5	CLAMP
10018176	6	HOSE
1374023	7	CLAMP

Z SEE FASTENER GENERAL INSTRUCTIONS UPC 0A.

DYNAMIC (Instal) N.m	HAND (Insp.) - N.m
1	1.4 - 2.8
2	20 - 34
3	
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CAL
20JN80		ISSUED	86448	CU	VIS	
26SEP	1	REDRAWN & REDESIGNED	1-2100	CU	RV	

DATE 08AP80
DR R.P. BIERI
CK JEB
APPR W.H.E.
APPR
APPR
APPR

294

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE A.I.R. HOSES FA00 &LD5 &K19

REF ECR 86448 NEW 06JN80 6T-6 RK

2 L-78711
4 L-21778
L-
L-

UPC 6T

SHEET 8

Ch X B O P X Co

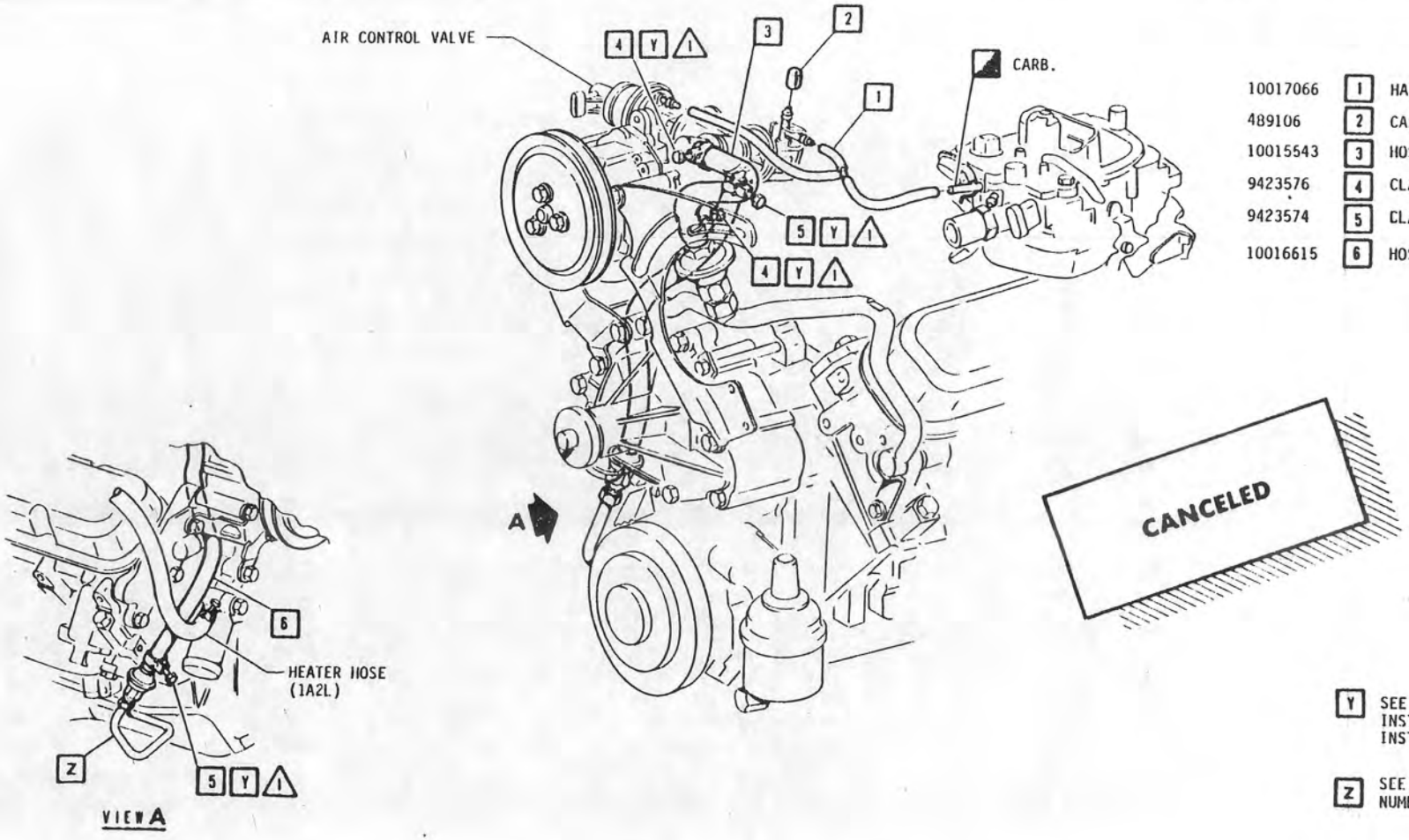
Kalb 10 1263 12-78 4084

PONTIAC MOTOR DIVISION

General Motors Corporation Pontiac, Michigan

PRODUCT DESCRIPTION MANUAL

☐ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF



10017066	1	HARNESS ASM.
489106	2	CAP
10015543	3	HOSE
9423576	4	CLAMP
9423574	5	CLAMP
10016615	6	HOSE

CANCELED

Y SEE FASTENERS GENERAL INSTRUCTIONS FOR PROPER INSTALLATION (0A.)

Z SEE UPC 6T-4 FOR PART NUMBERS & INSTALLATION

DYNAMIC (Instal) N.m	HAND (Insp.) - N.m	DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
	1.8 - 2.8	20MR80		ISSUED	96449	RK	RC	
		07NR80	1	SHEET CANCELED	91222	CU	EJ	

△1 FULLY DRIVEN, SEATED & NOT STRIPPED

295

DATE 15FE80
DR R. P. BIERI
CK JEB
APPR WMC 22FEB80
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE A.I.R. HOSES FA00 & LU8 & NB1

REF ECR 86448 NEW 11MR80

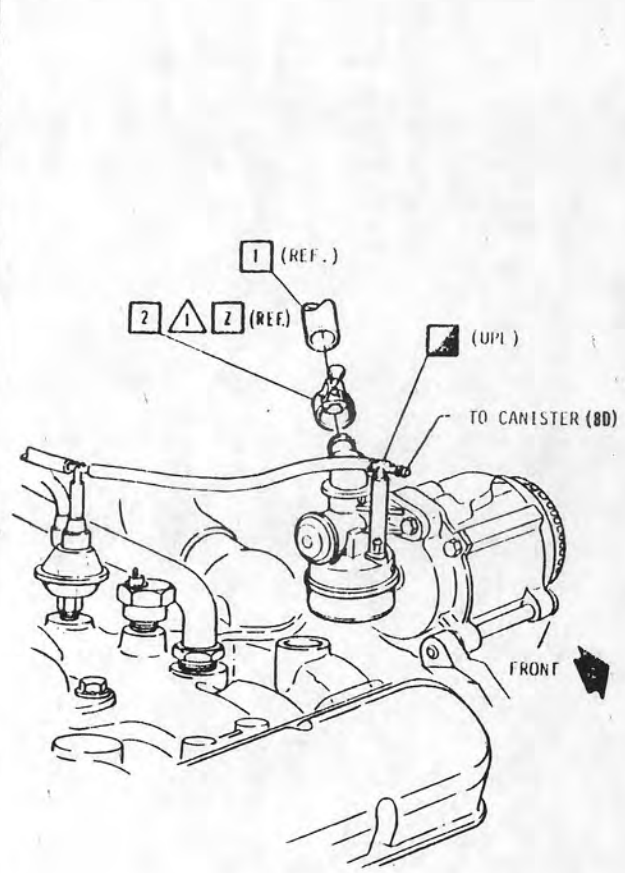
21-78313

UPC 6T

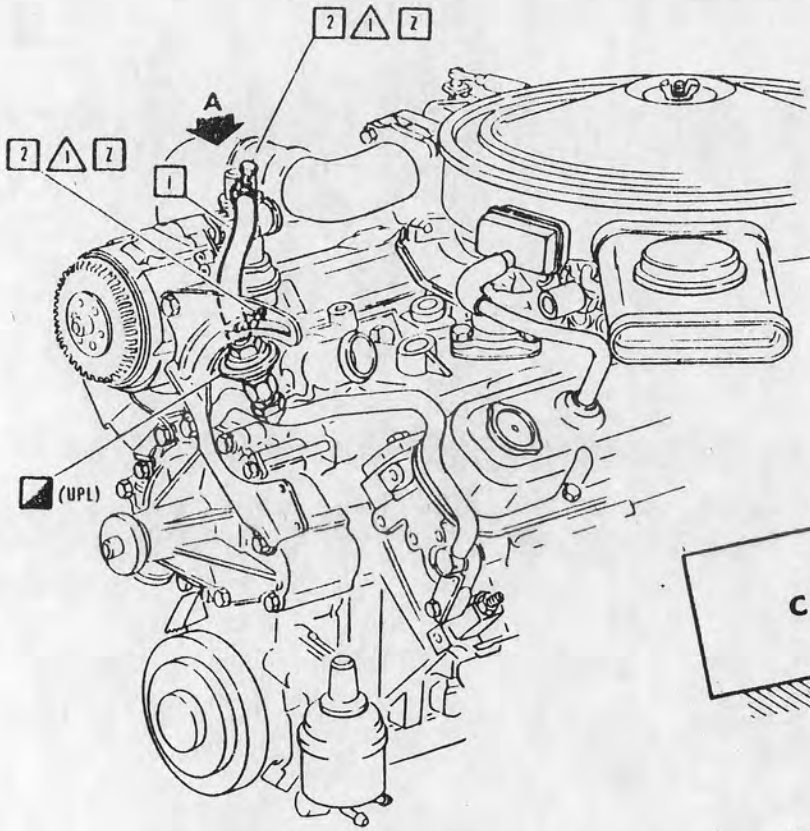
SHEET 9

Ch X B O P X Ca

Form 4338



VIEW A



10010567	1 HOSE
9423576	2 CLAMP

CANCELED

Z SEE FASTENERS GENERAL INSTRUCTIONS (GROUP 0A)

DYNAMIC (Install) N·m	HAND (Insp.) N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
△1	1.8 - 2.8	22NOV79		ISSUED	81148	CU	RC	
△2		07NOV80	1	SHEET CANCELED	91222	CU	EZ	
△3								
△4								
△5								
△ FULLY DRIVEN SEATED & NOT STRIPPED								

DATE 17APR80
DR PPB/KM
CK PHS
APPR UWE 18APR80
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE A.I.R. HOSES FA00 & LU8 & NM4

REF ECR 86448
NEW 05MY80
6T-3.3 RK

UPC 6T

SHEET 9.1

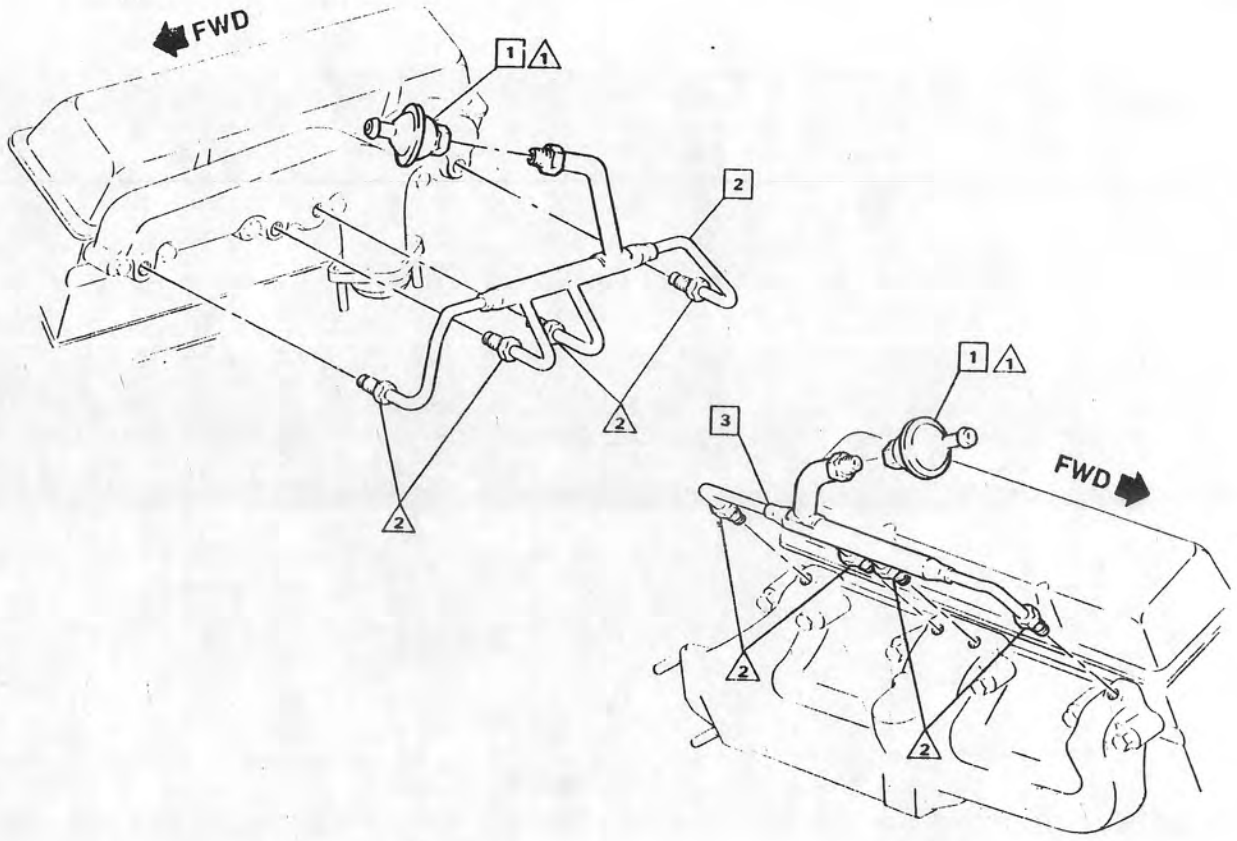
Ch X B O P X Co

KoE 10 1253 12-78 40M44

PRODUCT DESCRIPTION MANUAL

□ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF

(1)	22034703	1	CHECK VALVE
	14020665	2	PIPE ASM-LH
	14018785	3	PIPE ASM-RH



DYNAMIC(Instal) N·m	HAND (Insp.) · N·m
1	19 - 27
2	16 - 23
3	
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
05SEP80	1	WAS 22016902 VALVE	41207	CV		RC

297

DATE	07FEB80
DR	R. KOCH
CK	Tom Hayworth
APPR	S
APPR	
APPR	
APPR	

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE A.I.R. PIPES & CHECK VALVE FA00 & LG4/LM1/L39

REF ECR 86448 C/O 08JA80 6T-11

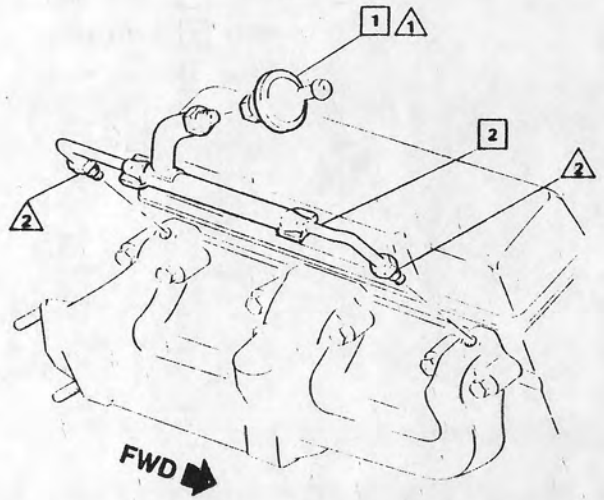
1 1-22738 (S) 1- 1- 1-

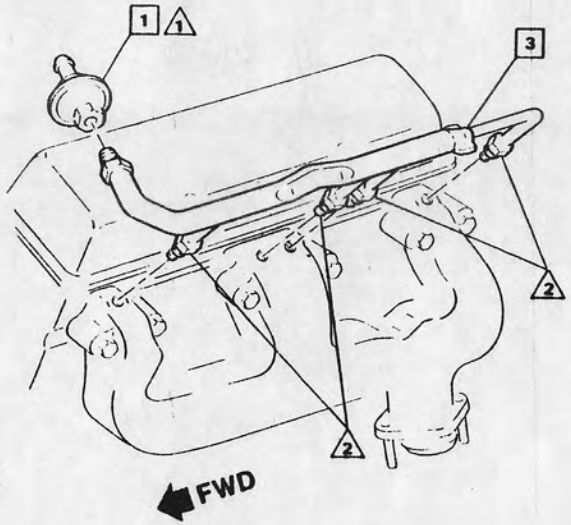
UPC 6T

SHEET 10

C | B | O | P | Ca

(1)	22034703	1	CHECK VALVE
	471542	2	PIPE ASM RH
	343763	3	PIPE ASM LH





DYNAMIC (Instal) N·m	HAND (Insp.) N·m
△1	19 - 27
△2	16 - 23
△3	
△4	
△5	

△1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
03SEP80	1	WAS 22016902 VALVE	91207	CU	RC	
		298				

DATE 20MAR80
DR R KUCH
CK Richard Cline RC
APPR NS
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE A.I.R. PIPES & CHECK VALVE LM1 &K19 &NM4

REF ECR 86448 NEW 13MAR80

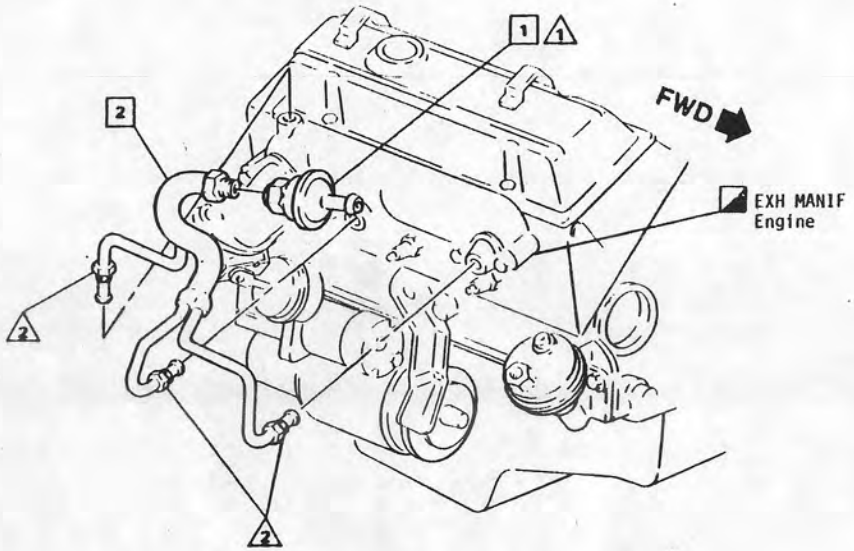
L- (NS) L- L- L-

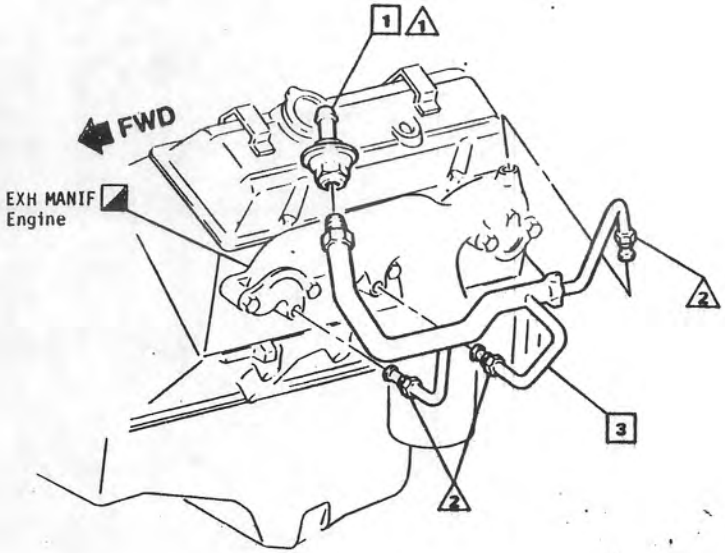
UPC 6T

SHEET 10.1

Ch | B | O | P | Ca

(2)	22034703	1	CHECK VALVE
	14015580	2	PIPE ASM-RH
(3)(1)	14026183	3	PIPE ASM-LH





DYNAMIC (Instal) N·m	HAND (Insp.) - N·m
+ △1	19-27
+ △2	16-23
△3	
△4	
△5	

△ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASH CHG
025E11	1	WAS 14026183 PIPE	91994			
	2	WAS 22016902 VALVE	91207	CU	RC	
19A1R8	3	WAS 14037669 PIPE	95160	CU	[illegible]	

299

C ☒ B ☐ D ☐ P ☒ Ca ☐

DATE 08FE80
DR R KOCH
CK [signature]
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE A.I.R. PIPES & CHECK VALVE FA00 & LC3

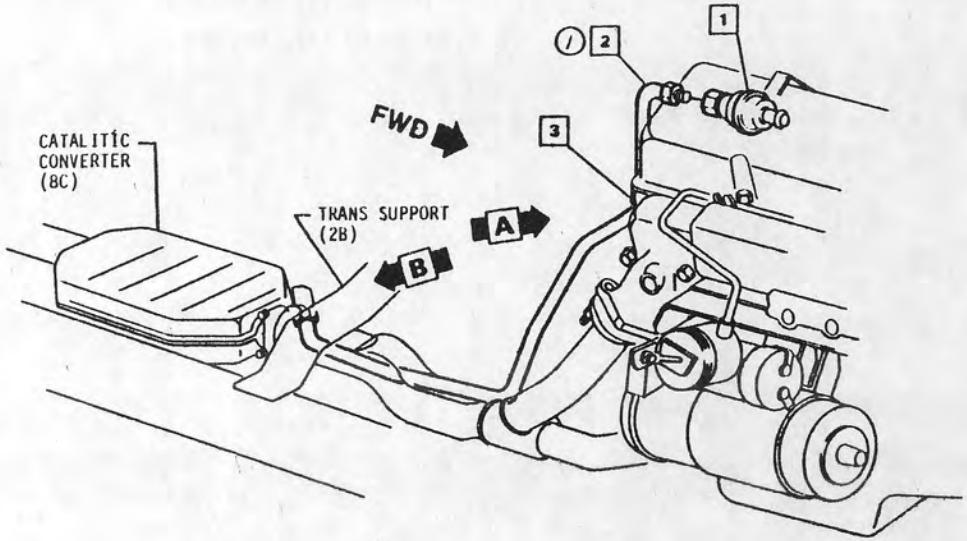
REF ECR 86448
C/O 11JA80
6T-12

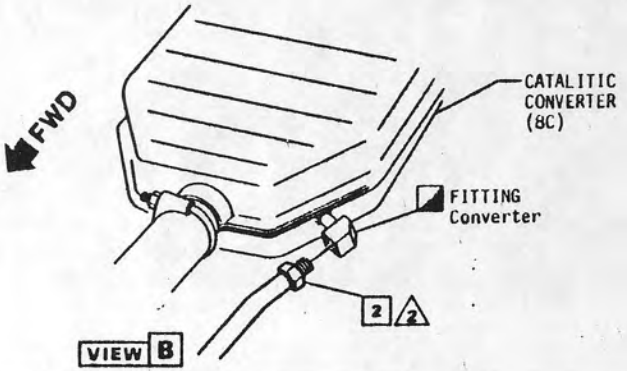
I- 22738 (S)
I-
I-
I-

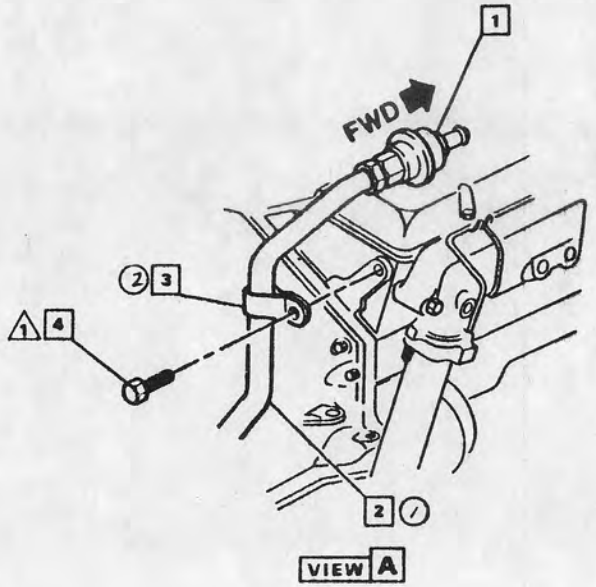
UPC 6T

SHEET 11

22017478	1	VALVE ASM
14029495	2	PIPE
14029497	3	BRACKET
9419885	4	BOLT/SCREW







DYNAMIC (Install) N·m	HAND (Insp.) - N·m
	1 10-15
	2 4.6-6.0
	3
	4
	5

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
27JN80	1	ITEM 2 REROUTED (2) PLACES				C
	2	ITEM 3 RELOCATED (PC-0061)	88765	CU	JH	C

300

DATE 29FE80
DR R. KOCH
CK
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE A.I.R.-CATALITIC CONVERTER PIPE FA00 & LG4/LM1/L39

REF ECR 86448 NEW 14FE80

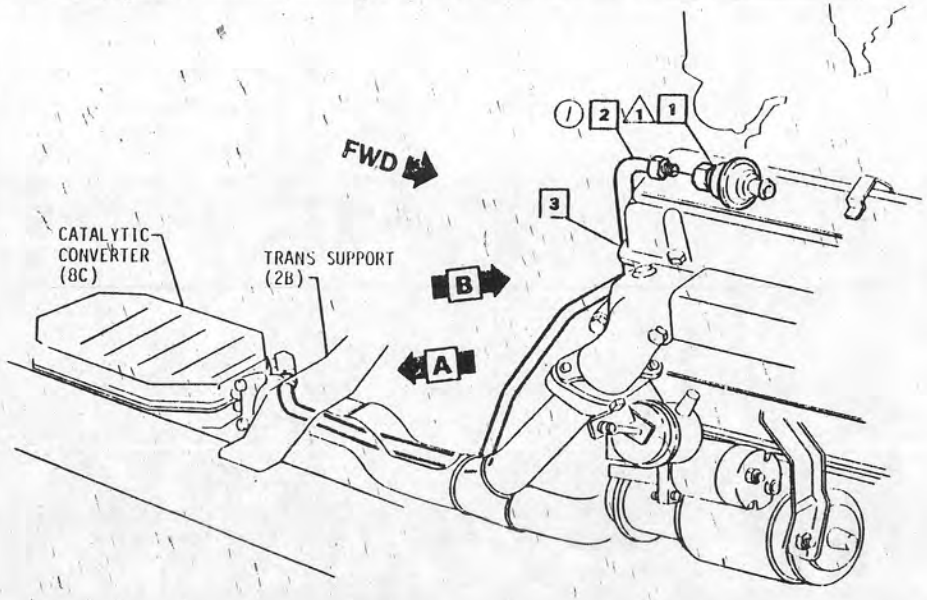
1 L-22808 (S)
L-
L-
L-

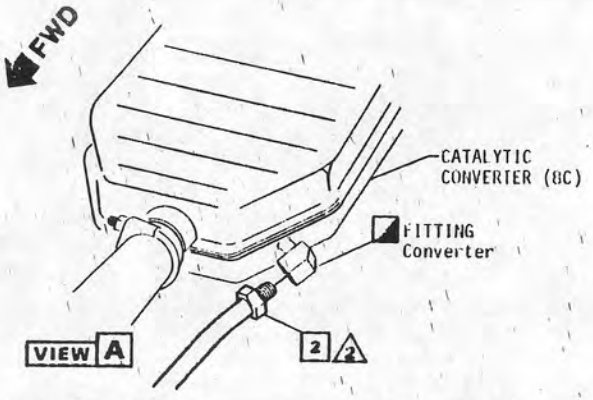
UPC 6T

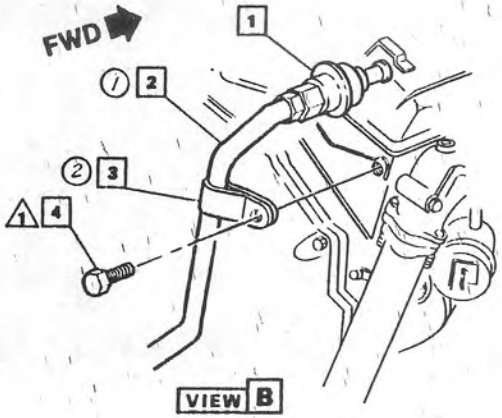
SHEET 12

C ☒ B ☐ O ☐ P ☒ Co ☐

22017478	1	VALVE ASM
14029495	2	PIPE
14029497	3	BRACKET
9419885	4	BOLT/SCREW







DYNAMIC (Instal) N·m	HAND (Insp.) N·m
1	19-27
2	4.5-6.0
3	
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
1NL80	1	ITEM 2 REROUTED (2) PLACES				C
	2	ITEM 3 RELOCATED	89166	CU		C

301

C | B | D | P | Co

DATE 27FE80
DR R J LINDNER
CK Jim Haugath
APPR SJ
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
A.I.R. CATALYTIC CONVERTER PIPE
FA00 & LC3

REF ECR 86448
NEW 21FE80

L- 22808 (S)
L-
L-
L-

UPC 6T

SHEET 13

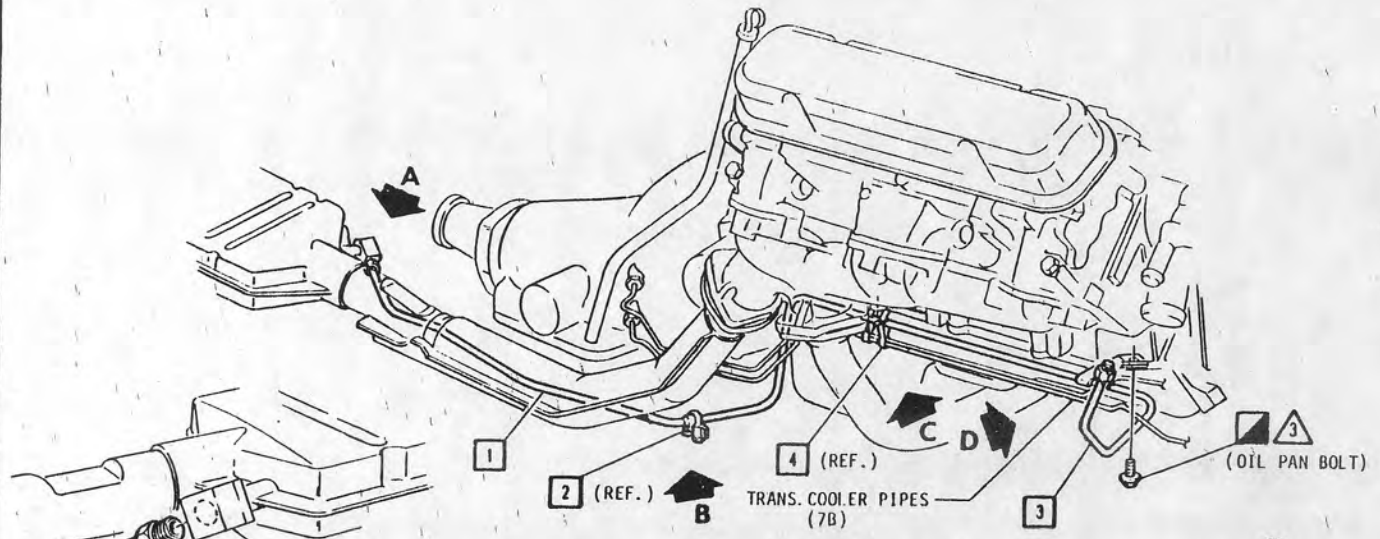
PONTIAC MOTOR DIVISION

General Motors Corporation Pontiac, Michigan

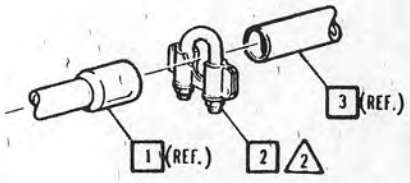
PRODUCT DESCRIPTION MANUAL

□ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF

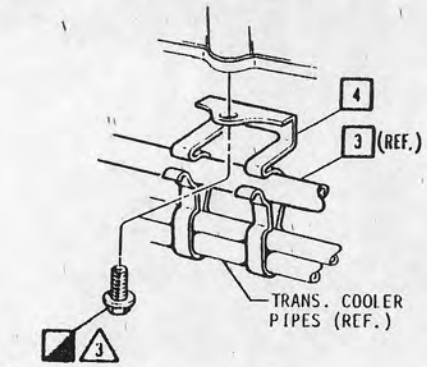
+	1	PIPE ASM.
25505116	2	CLAMP ASM.
+	3	PIPE ASM.
10016681	4	CLIP
22016902	5	VALVE ASM.



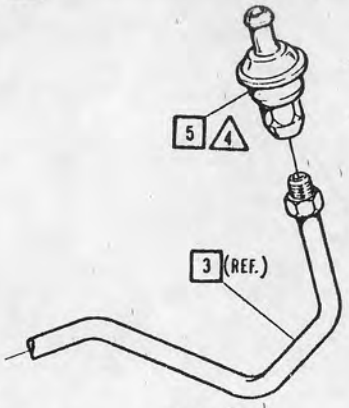
VIEW A



VIEW B



VIEW C



VIEW D

CANCELED

DYNAMIC (Instal) N·m	HAND (Insp.) - N·m
△1	20 - 34
△2	11 - 14
△3	11 - 20
△4	19 - 27
△5	

△1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
20MR80		ISSUED	86448	RK	RC	
04NO80	1	SHEET CANCELED	91222	CU	EF	

302

DATE	11FEB0
DR	R. P. BIERI
CK	JEB
APPR	WHC 14FEB0
APPR	
APPR	
APPR	

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE CONVERTER AIR FEED PIPES FA00 & LU8 & NB1

REF ECR 86448 NEW 11MR80 RK

21-78357 1- 1- 1-

UPC 6T

SHEET 14

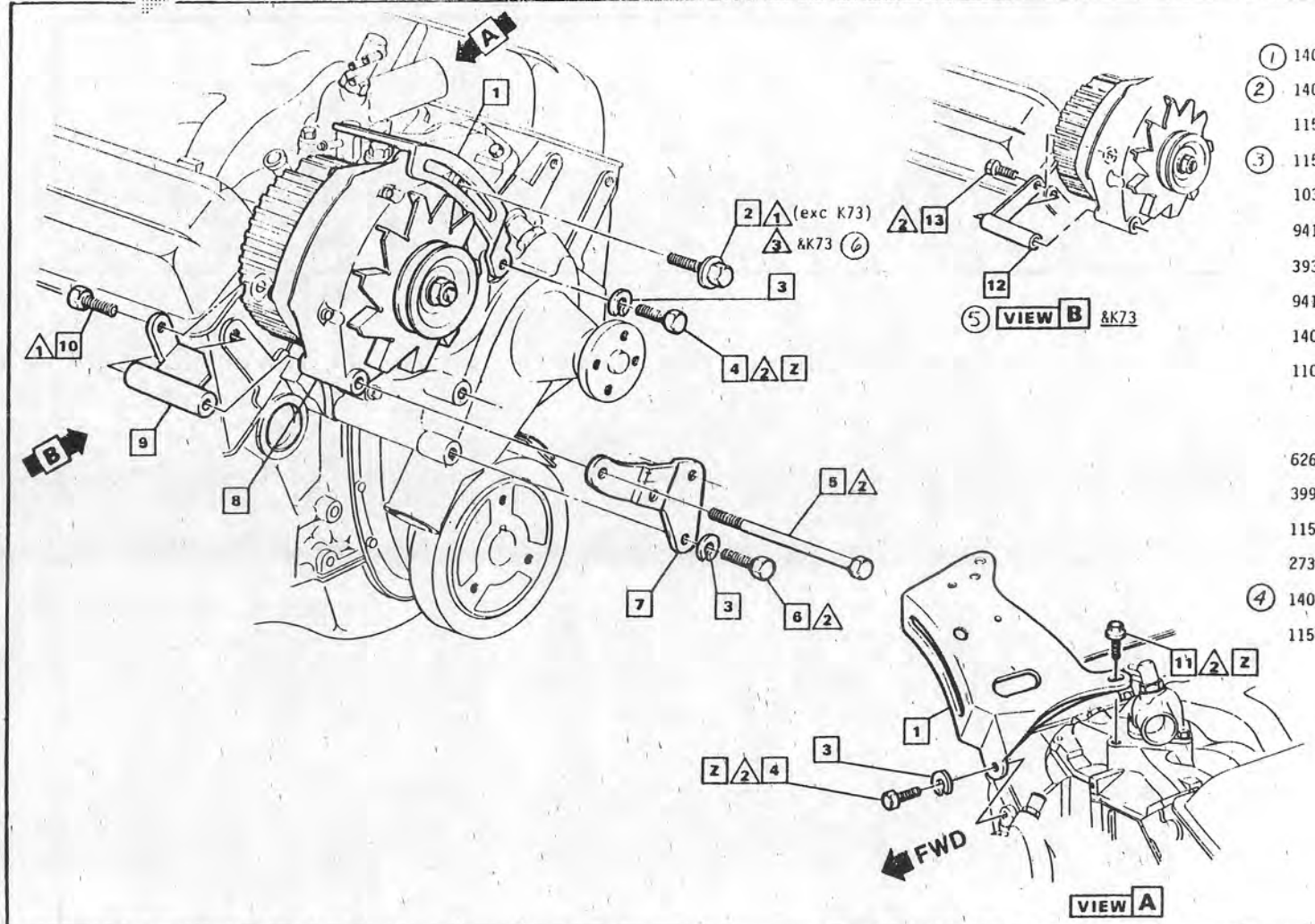
Ch X B O P X Co

Edit 4338

General Motors Corporation
CHEVROLET MOTOR DIVISION

PRODUCT DESCRIPTION MANUAL

□ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ▨ EXISTING AS PART OF



(1)	14034010	1	BRACKET-FRONT
(2)	14017794	1	&K73
	11502605	2	BOLT/SCREW
(3)	11502606	2	&K73
	103321	3	WASHER
	9418967	4	BOLT/SCREW
	3932414	5	BOLT/SCREW
	9418822	6	BOLT/SCREW
	14015533	7	BRACKET
	1103161	8	GENERATOR ASM (SHOWN) For specific releasing & additional part numbers, see Parts List.
	6262934	9	SPACER-REAR
	3993312	9	&LC3
	11504270	10	BOLT/SCREW
	273773	11	BOLT/SCREW
(4)	14017795	12	SPACER &K73
	11504512	13	BOLT/SCREW &K73

Z Bolt/screw [4] to be driven prior to bolt/screw [11] & bolt/screw [11] not to be driven until after belt tensioning & adjusting bolt/screw [2] is driven.

DYNAMIC (Install) N·m | HAND (Insp.)] · N·m

△1 20-30
△2 16-40
△3 36-50
△4
△5

△ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
27JUL80	1	14034010 WAS 469579	90190	CU	RC	
22AUG80	2	14017794 BRACKET ADDED				
	3	11502606 BOLT/SCREW ADDED				
	4	ITEMS 12, 13 ADDED				C
	5	VIEW "B" ADDED				C
	6	TORQUE (3) ADDED	89761	CU	RC	C
07NOV80	7	"LUB" REMOVED	91222	CU	EJ	

308

DATE 21FEB80
DR R. TAYLOR
CK Richard Allen
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
GENERATOR MOUNTING
FA00 ALL ENGINES exc LD5 (7)

REF ECR 86448
C/O 29JA80
6Y-1

L- 05972 (S)
L- 08290 (S)
L-
L-

UPC 6Y

SHEET 1

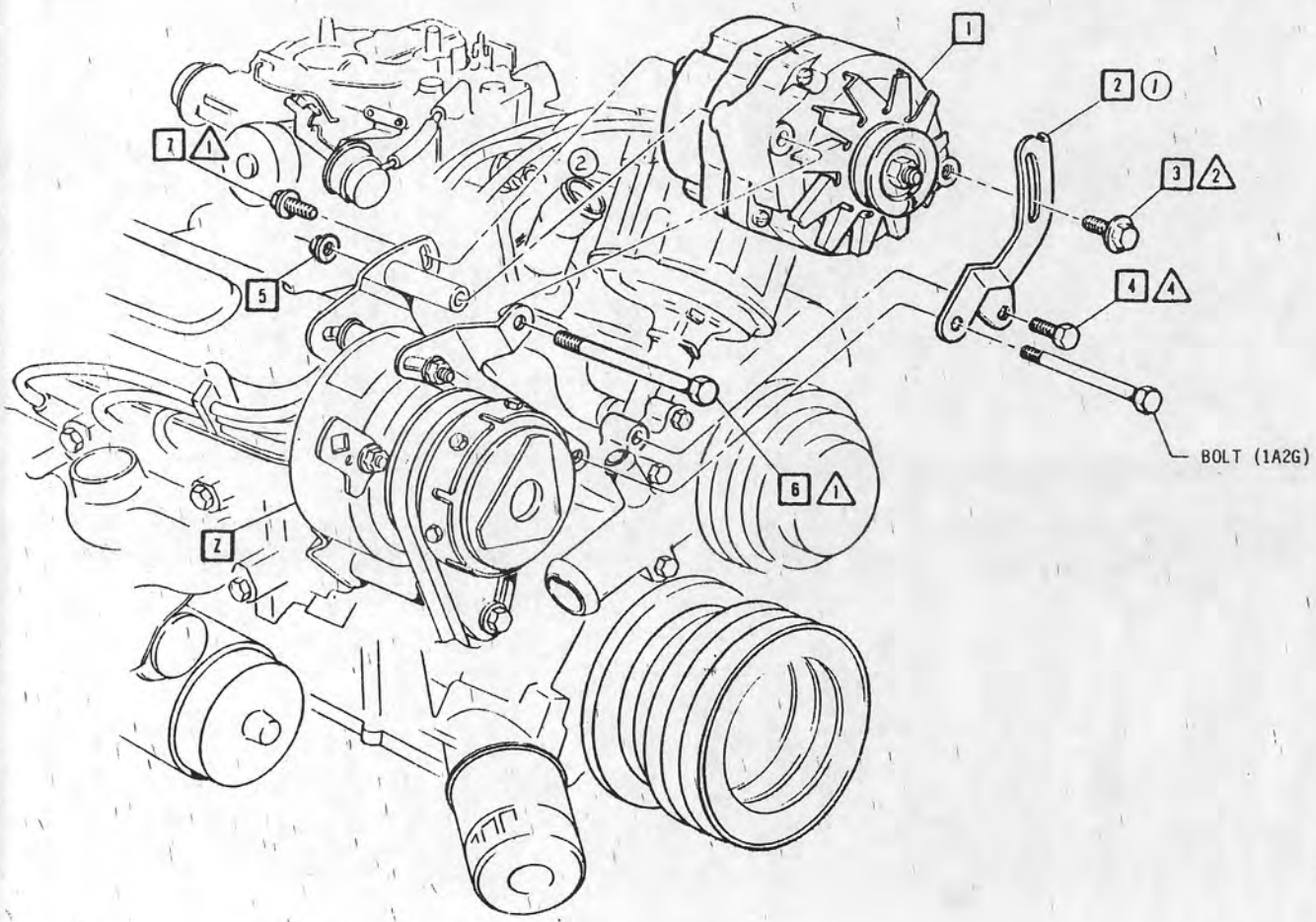
Ch X B O P X Cu

PONTIAC MOTOR DIVISION

General Motors Corporation Pontiac, Michigan

PRODUCT DESCRIPTION MANUAL

☐ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF



1101071	1	GENERATOR ASM.
10013948	2	BRACKET
10008894	3	BOLT/SCREW
9419785	4	BOLT/SCREW
11501850	5	NUT
11505007	6	BOLT/SCREW
11502685	7	BOLT/SCREW

7 SEE UPC 1A2G – FOR COMPRESSOR AND BRACKETS PART NUMBERS AND INSTALLATION.

DYNAMIC (Instal) N·m | MAND (Insp.) - N·m

1 40-60
2 26-48
3 26-40
4 20-34
5

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
05JN80		ISSUED	86448	CU	[illegible]	
22AU80	1	ITEM 2 DWG REV				P
	2	WATER OTLT DWG REV	1-2017	CU	RC	P

304

DATE 30AP80
DR R.P.BIERI
CK [illegible]
APPR RJS
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE GENERATOR MOUNTING FA00 & LD5 & K73

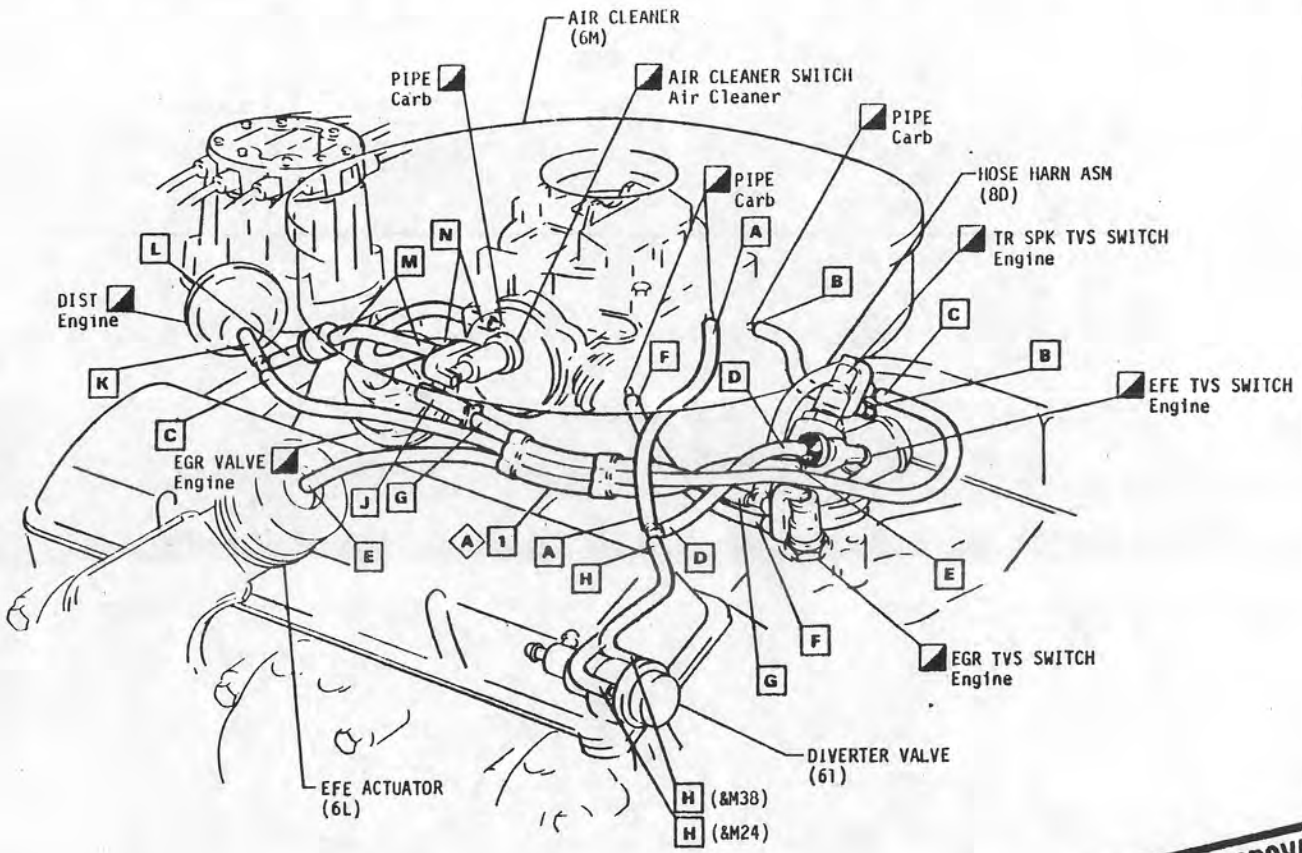
REF ECR 86448 NEW 23MY80 6Y-6 RCT

2 1-78593
1-
1-
1-

UPC 6Y

SHEET 2.1

CB X 0 0 P X Ca



14023189	1	HARNESS ASM &M38
14023109	1	&M24
9985406	A	RUBBER LUBRICANT Approx. .015L per job.

A THRU N Letters used to indicate color code and opposite ends of each tube in Tube Asm for proper routing.

TUBE	COLOR CODE
A	Yellow Solid Stripe
B	Lt. Brown Dashed Stripe
C	Lt. Green Solid Stripe
D	Yellow Solid Stripe
E	White Solid Stripe
F	Purple Solid Stripe
G	Orange Solid Stripe
H	Pink Dashed Stripe
J	None
K	None
L	None
M	Red Solid Stripe
N	None

WAITING LAYOUT APPROVAL

DYNAMIC (instal) N·m	HAND (insp.) N·m
1	
2	
3	
4	
5	

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
		305				

DATE 27JN80
DR R. KOCH
CK
APPR NS
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE EMISSION HOSES FA00 &LM1 &NM4

REF ECR 86448 NEW 18JN80

L- (NS)
L-
L-
L-

UPC 6Y

SHEET 13.1

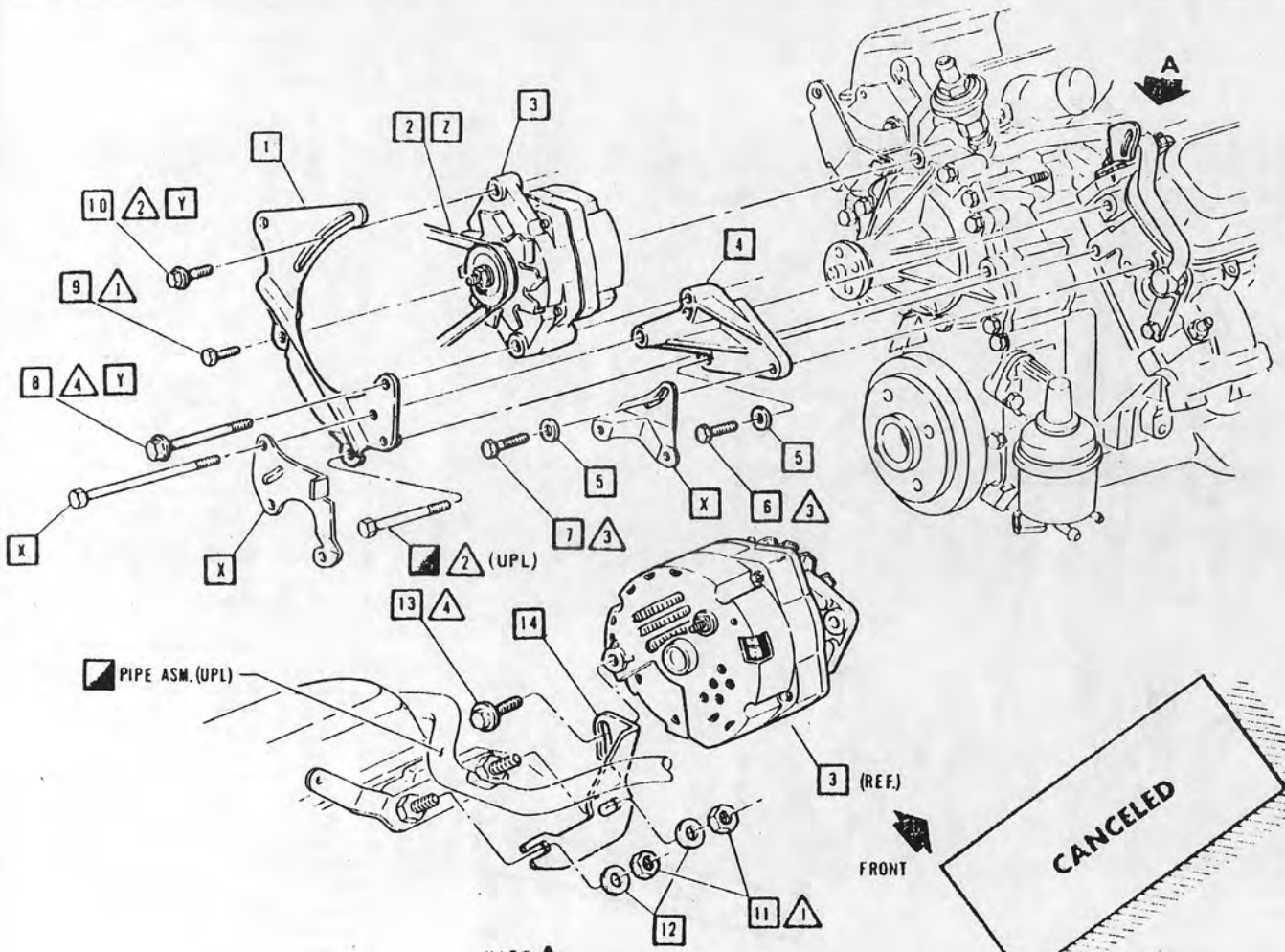
Ch | B | O | P | Ca

PONTIAC MOTOR DIVISION

General Motors Corporation Pontiac, Michigan

PRODUCT DESCRIPTION MANUAL

□ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF



+ 10014890	1	BRACKET ASM.
+ 9433664	2	BELT
+ 1101080	3	GENERATOR ASM
+ 10010137	4	SUPPORT
+ 502306	5	WASHER
+ 9418824	6	BOLT
+ 9419053	7	BOLT
+ 11504745	8	BOLT
+ 180083	9	BOLT
+ 10008894	10	BOLT
+ 9417954	11	NUT
+ 537209	12	WASHER
+ 11502685	13	BOLT
+ 10010136	14	BRACKET

X PARTS RELEASED & SHOWN IN UPC 9E.

Y TIGHTEN BOLT 10 BEFORE BOLT 8 WHILE BELT TENSIONING DEVICE IS IN POSITION.

Z FOR BELT ROUTING SEE 'PULLEY & BELT DIAGRAM' - UPC 6Z.

CANCELED

DYNAMIC (Install) N·m | HAND (Insp.) · N·m

1 20-34
2 26-40
3 26-48
4 40-60
5

1 FULLY DRIVEN SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
10 DEC 79		ISSUED	SKW	AVT	NB	
10 DEC 79	1	SHEET CANCELED	91222	JP		

306

DATE 10 DEC 79
DR R.P. BIERI
CK JEB
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE GENERATOR MOUNTING FA00 & LU8

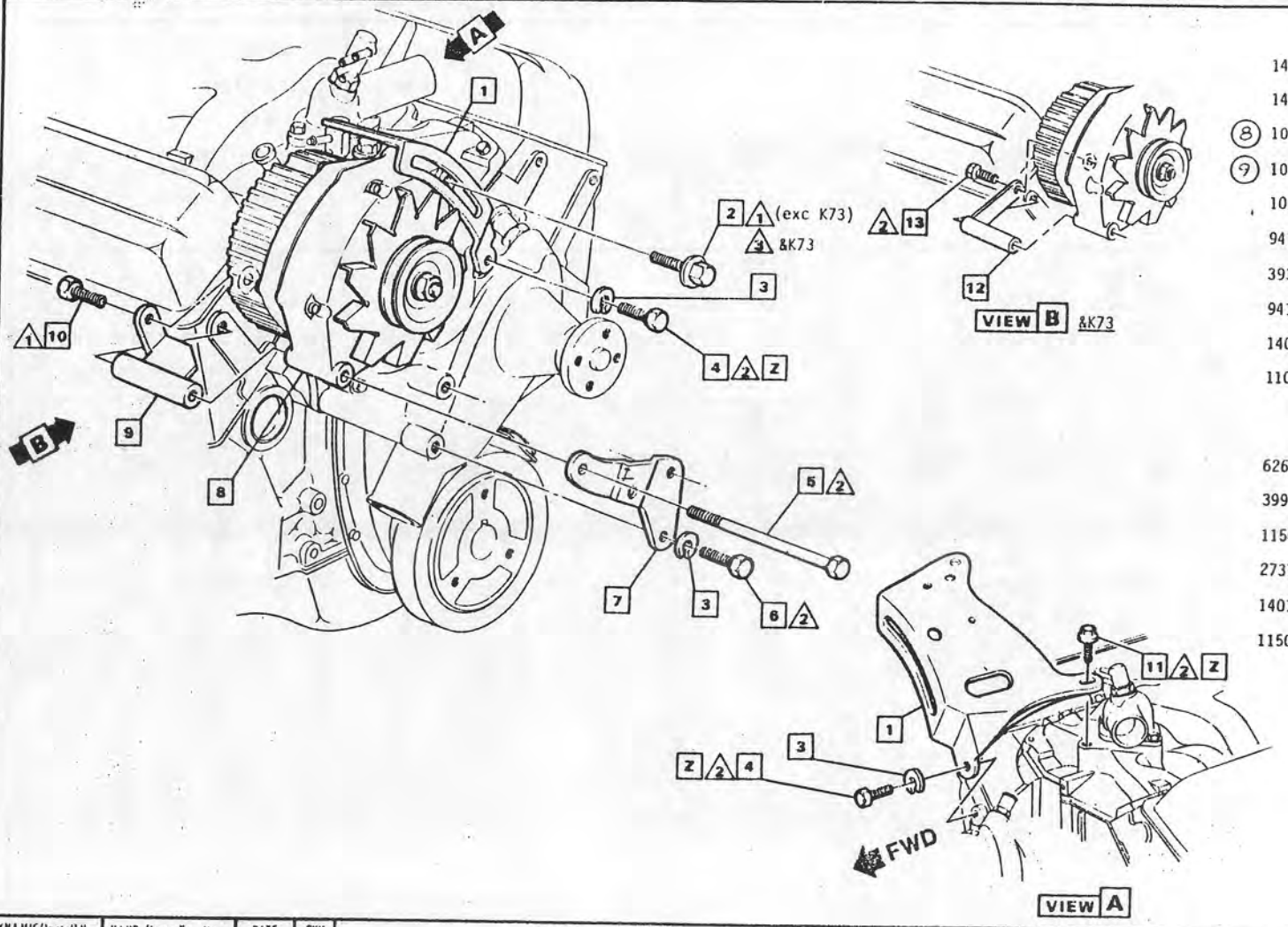
REF ECR 86448 NEW 26FE80 6Y-2 RT

UPC 6Y

SHEET 3

Ch | B X O | P X Co

Form 30 1263 12-78 4064



14034010	1	BRACKET-FRONT	
14017794	1	&K73	
(8) 10018897	2	BOLT/SCREW	
(9) 10018894	2	&K73	
103321	3	WASHER	
9418967	4	BOLT/SCREW	
3932414	5	BOLT/SCREW	
9418822	6	BOLT/SCREW	
14015533	7	BRACKET	
1103161	8	GENERATOR ASM (SHOWN) For specific releasing & additional part numbers, see Parts List.	
6262934	9	SPACER-REAR	
3993312	9	&LC3	
11504270	10	BOLT/SCREW	
273773	11	BOLT/SCREW	
14017795	12	SPACER &K73	
11504512	13	BOLT/SCREW &K73	

Z Bolt/screw [4] to be driven prior to bolt/screw [11] & bolt/screw [11] not to be driven until after belt tensioning & adjusting bolt/screw [2] is driven.

DYNAMIC (Install) N·m	HAND (Insp.) N·m
1	20-30
2	16-40
3	36-50
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
04JAN81	8	10018897 WAS 11502605				
	9	10018894 WAS 11502606	73959	CU	HB	

307

DATE 21FEB80
DR R. TAYLOR
CK Richard Cline JC
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
GENERATOR MOUNTING
FA00 ALL ENGINES exc LD5 (7)

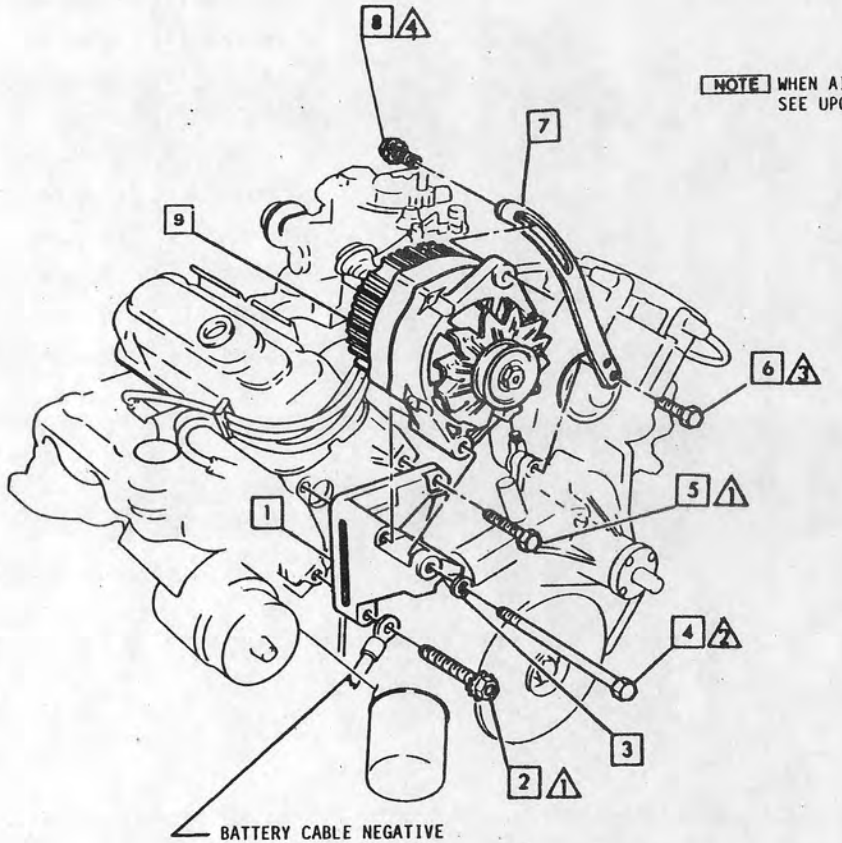
REF ECR 86448
C/O 29JA80
6Y-1

L- 05972 (S)
L- 08290 (S)
L-
L-

UPC 6Y

SHEET 1

Ch X D O P X Co



NOTE WHEN AIR CONDITIONING IS SPECIFIED SEE UPC GROUP 1A2G.

1250786	1	BRACKET - GENERATOR MTG
9424933	2	SCREW ASM
502306	3	WASHER
3932414	4	BOLT
9418821	5	BOLT
9419785	6	BOLT
1375049	7	BRACE
10008893	8	BOLT
1100110	9	GENERATOR ASM (SHOWN) For specific releasing & additional part numbers, see Parts List.

DYNAMIC (Instal) N.m	HAND (Insp.) - N.m
1	40-60
2	50-70
3	20-34
4	20-30
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
11 MAY 80		ISSUED	86448	CUR		

DATE 22JA79
DR MAC DORMOTT
CK
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE GENERATOR MOUNTING FA00 & LD5 (exc C60)

REF ECR 86448 C/O 05MY80 6Y-1 RT

UPC 6Y

SHEET 2

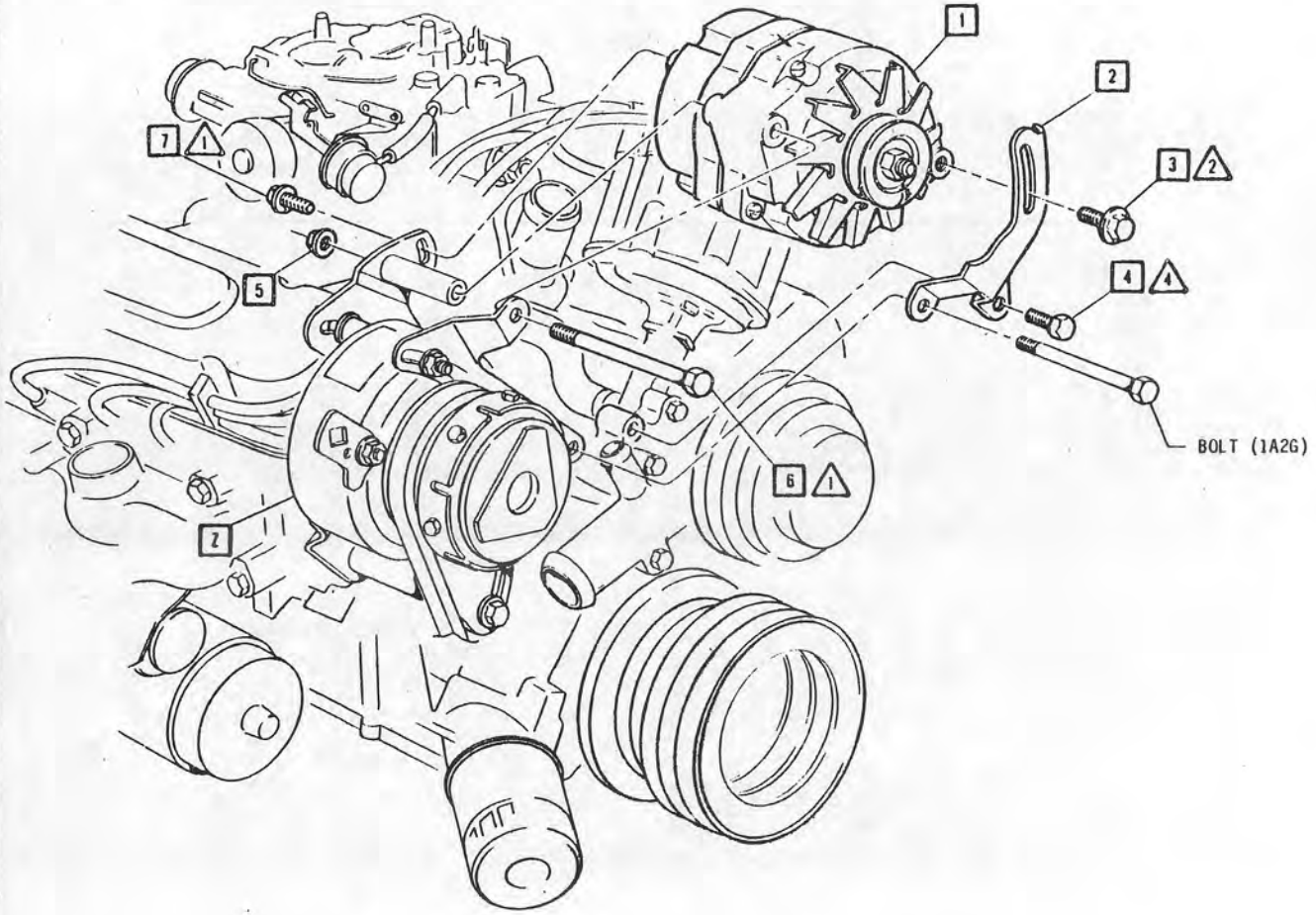
Ch X 0 X 0 X P X Co

PONTIAC MOTOR DIVISION

General Motors Corporation Pontiac, Michigan

PRODUCT DESCRIPTION MANUAL

☐ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF



1101071	1	GENERATOR ASM.
+ 10013948	2	BRACKET
10008894	3	BOLT/SCREW
9419785	4	BOLT/SCREW
. 11501850	5	NUT
+ 11505007	6	BOLT/SCREW
11502685	7	BOLT/SCREW

Z SEE UPC 1A2G – FOR COMPRESSOR AND BRACKETS PART NUMBERS AND INSTALLATION.

DYNAMIC (Instal) N·m	MANO (Insp.) - N·m
1	40-60
2	26-48
3	26-40
4	20-34
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
15.NOV80		ISSUED	BG418	C.O		

309

DATE 30 AP 80
DR R. P. BIERI
CK AAB
APPR RJS
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE GENERATOR MOUNTING FA00 & LD5 & K73

REF ECR 86448 NEW 23MY80 6Y-6 RCT

2 L-78593 L- L-

UPC 6Y

SHEET 2.1

E&E• 0338

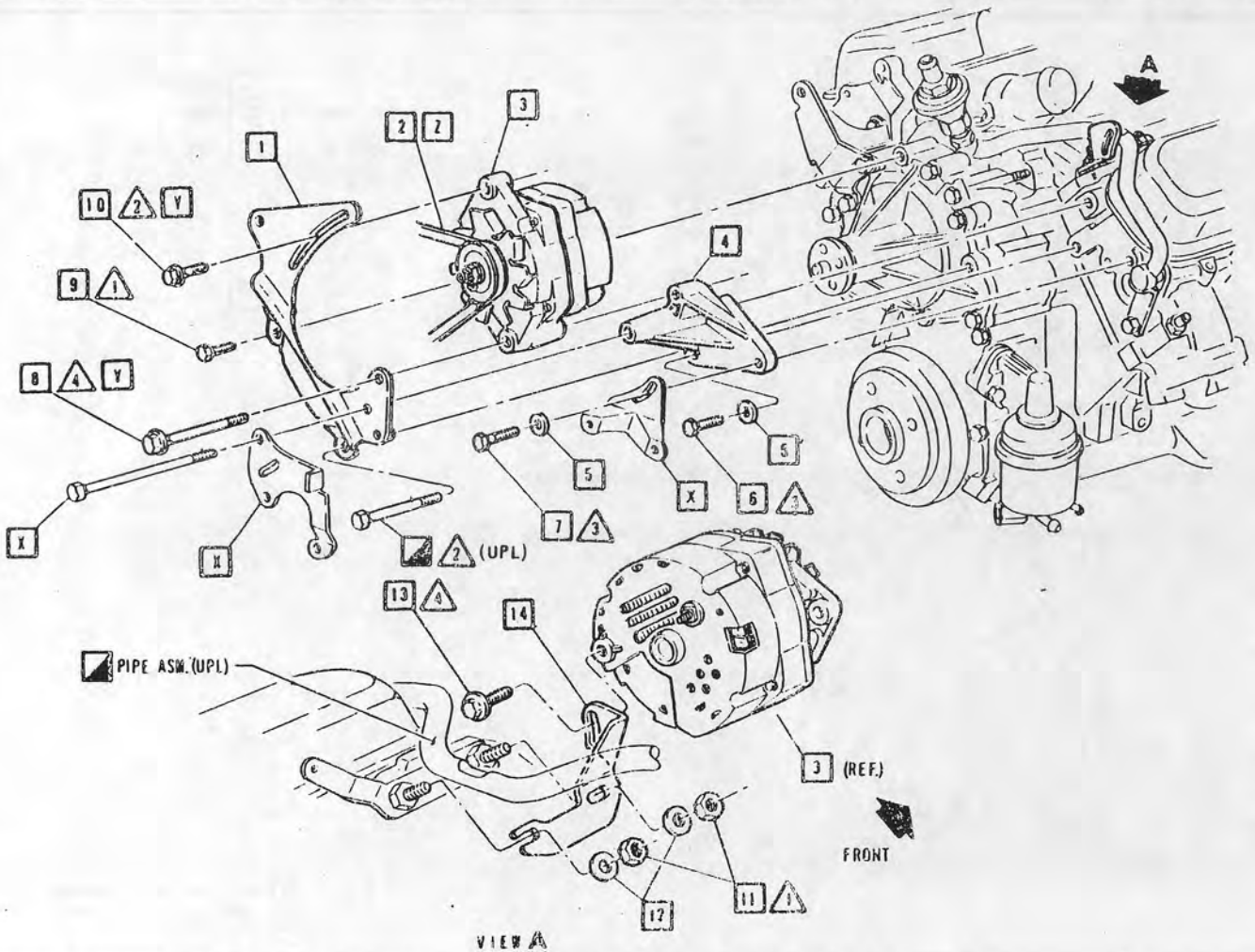
Cb X D 0 ? X Co

PONTIAC MOTOR DIVISION

General Motors Corporation Pontiac, Michigan

PRODUCT DESCRIPTION MANUAL

☐ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF



+ 10014890	1	BRACKET ASM.
+ 9433664	2	BELT
+ 1101080	3	GENERATOR ASM
+ 10010137	4	SUPPORT
+ 502306	5	WASHER
+ 9418824	6	BOLT
+ 9419053	7	BOLT
+ 11504745	8	BOLT
+ 180083	9	BOLT
+ 10008894	10	BOLT
+ 9417954	11	NUT
+ 537209	12	WASHER
+ 11502685	13	BOLT
+ 10010136	14	BRACKET

[X] PARTS RELEASED & SHOWN IN UPC 9E.

[Y] TIGHTEN BOLT [10] BEFORE BOLT [8] WHILE BELT TENSIONING DEVICE IS IN POSITION.

[Z] FOR BELT ROUTING SEE 'PULLEY & BELT DIAGRAM' - UPC 6Z.

DYNAMIC (Install) N·m | HAND (Insp.) · lb·in

1. 26–34
2. 26–40
3. 26–48
4. 40–60
5.

1. FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASS ENG
4MC30		ISSUED	8448	407	HB	

310

DATE 10 DE 79
DR R.P. BIERI
CK JEB
APPD
APPR
APPR
APPR

DIV CHEVROLET

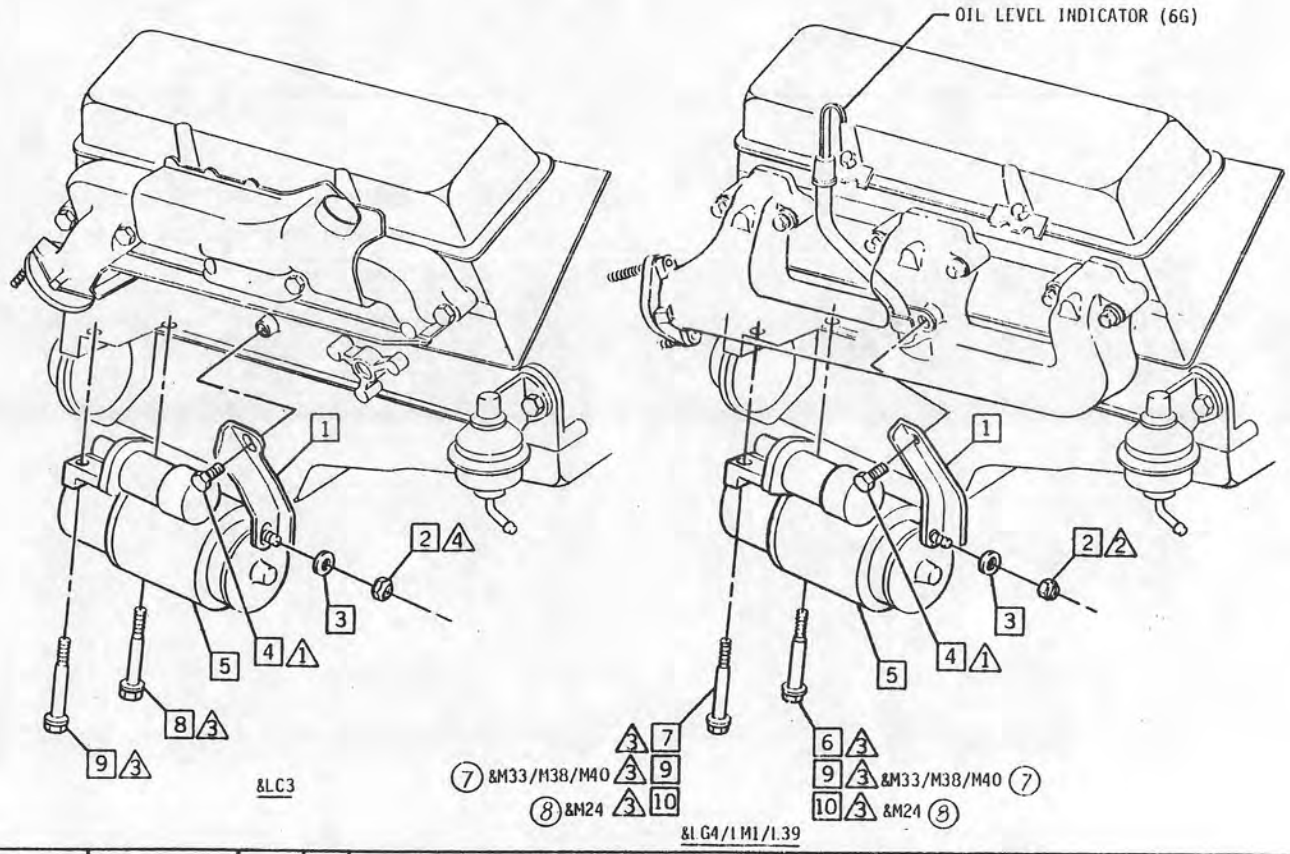
1981 CHEV. "F" 14020867

TITLE
GENERATOR MOUNTING
FA00 & LU8

REF ECR 86448
NEW 26FE80
6Y-2 RT

UPC 6Y

SHEET 3



3965589	1	BRACKET
461340	1	&L39 or LG4 &MV4 ⑦
14037620	1	&LC3 -
9422273	2	NUT
190254	2	&L39 or LG4 &MV4 ⑦
9419274	3	WASHER
9421080	3	&L39 or LG4 &MV4 ⑦
14020698	4	BOLT/SCREW
1109062	5	STARTER MOTOR (SHOWN) For specific releasing & additional part numbers, see Parts List.
1258672	6	BOLT/SCREW &L39 or LG4 &MV4 ⑦
1258673	7	BOLT/SCREW &L39 or LG4 &MV4 ⑦
1366042	8	BOLT/SCREW
1366043	9	BOLT/SCREW
3733289	10	BOLT/SCREW

DYNAMIC (Install) N·m	HAND (Insp.) N·m
△1	20-27
△2	2.8-3.4
△3	34-40
△4	7.0-10.0
△5	

△1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
19SEP80	6	REDRAWN & REDESIGNED	90540	CO	[illegible]	C
23DEC80	7	OPTS REV (7) PLCS				
	8	"EM24" ADDED (2) PLCS	93052			
	9	"&LU8" REM	91222	CU		

311

DATE 23DEC80
DR R TAYLOR
CK [illegible]
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
STARTER MOTOR
FA00 & ALL ENGINE exc LD5 ⑦

REF ECR 86448
C/O 16JA80
6Y-4

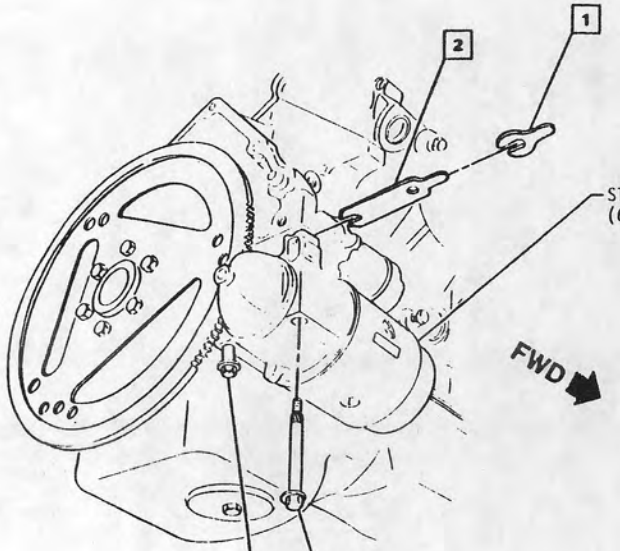
L-95951 (S)
L-
L-
L-

UPC 6Y

SHEET 4

C X B O P X Co

1246249 [1] SHIM
9785608 [2] SHIM



NOTE Loosen this bolt/screw when installing [2] shim. Tighten bolt/screw to ⚠1.

NOTE Remove this bolt/screw to install [2] shim, then re-install bolt/screw and tighten to ⚠1.

NOTE Loosen both bolts/screws when installing [1] shim. Tighten both bolts/screws to ⚠1.

STARTER NOISE REPAIR PROCEDURE

Noise during cranking.....use shim [1] on outboard pad only. Use no more than four shims.

Noise after engine fires.....use shim [2] apply shims one at a time until noise is corrected. Use no more than four shims.

For combinations of the above...use no more than four shims totally.

DYNAMIC (Instal) N·m	HAND (Insp.) N·m
⚠1	34-48
⚠2	
⚠3	
⚠4	
⚠5	

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
07NOV80	1	(EXC LUB) REMOVED	41222	CU	EJ	

312

DATE 14FEB80
DR R. TAYLOR
CK
APPR NS
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE STARTER MOTOR SHIM (REPAIR ONLY) FA00 ALL ENGINE (1)

REF ECR 86448 C/O 16JA80 6Y-5

L- (NS)
L-
L-
L-

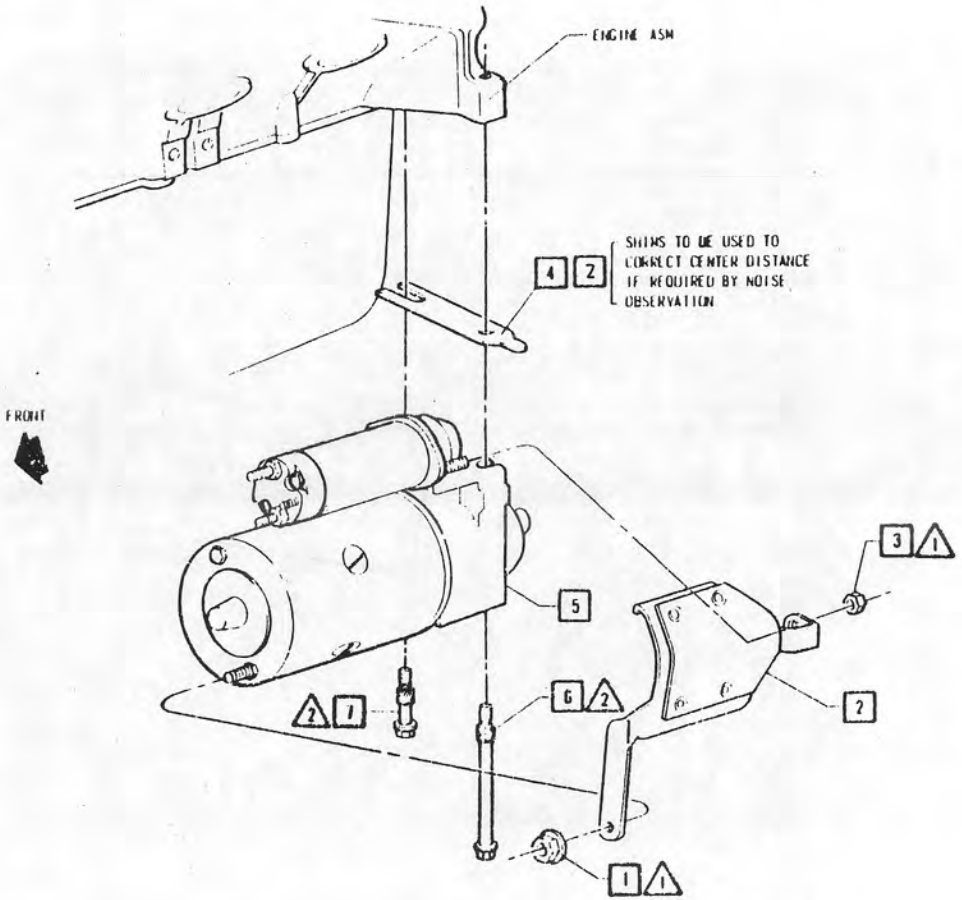
UPC 6Y

SHEET 5

Ch X B O P Ca

PONTIAC MOTOR DIVISION
General Motors Corporation Pontiac, Michigan

PRODUCT DESCRIPTION MANUAL
☐ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF



566314	1	NUT	
10001644	2	SHIELD	
9419143	3	NUT	
	3		
9785608	4	SHIM (.015)	USE AS REQ'D.
9785609	4	SHIM (.045)	
1109523	5	MOTOR ASM.	
1258674	6	BOLT	
1258675	7	BOLT	

CANCELED

2 NOMINAL DESIGN SHIM REQUIREMENT =.090 (USE 2 (TWO) .045 SHIMS)

DYNAMIC (Install) N.m | HAND (Insp.) - N.m
1 2.2-4.0
1 34-48
2
4
3
1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
01FEB0		ISSUED				
07AUG0	1	SHEET CANCELED				

313

DATE 24 OC 79
DR GMV/EDB
CK FHA
APPR S
APPR
APPR
APPR

DIV. CHEVROLET

1981 CHEV. "F" 14020867

TITLE STARTER MOTOR FA00 & LU8

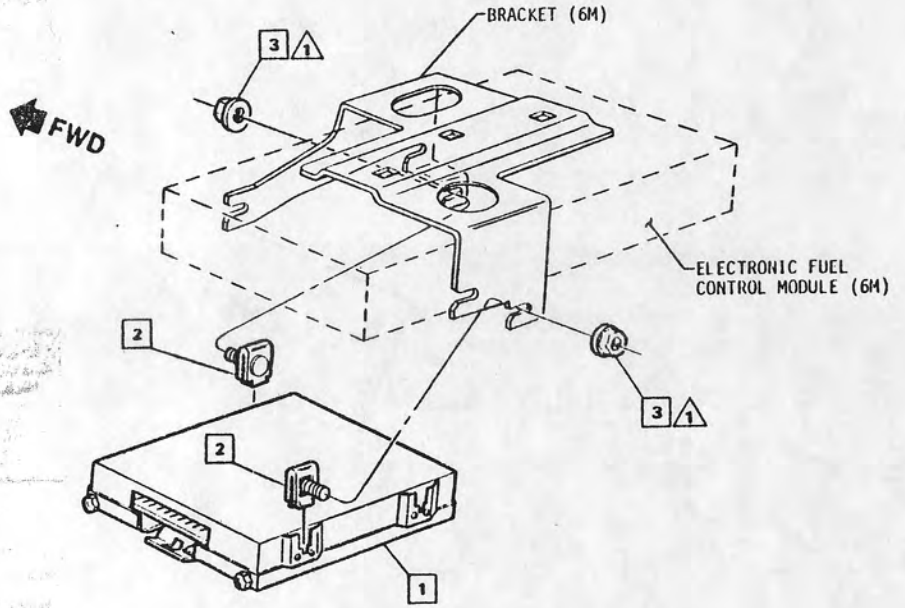
REF ECR 86448 NEW 24JA80 6Y-14 RT

GPC 6Y

SHEET 6

Ch B D F Co

16013312	1	CONTROLLER-IGN SPARK
469088	2	BOLT/SCREW
11501814	3	NUT



CANCELED

DYNAMIC (Install) N·m	HAND (Insp.) · N·m
△1	1.2-1.6
2	
3	
4	
5	

△1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
01NOV	1	SHEET CANCELED	91222	CU	EF	

314

DATE 06MR80
DR R. LINDNER
CK N.J Buck HB
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
IGNITION SPARK CONTROLLER
FA00 & LU8 & NB1

REF ECR 86448
NEW 27FE80

21-88651
L-
L-
L-

UPC 6Y

SHEET 9

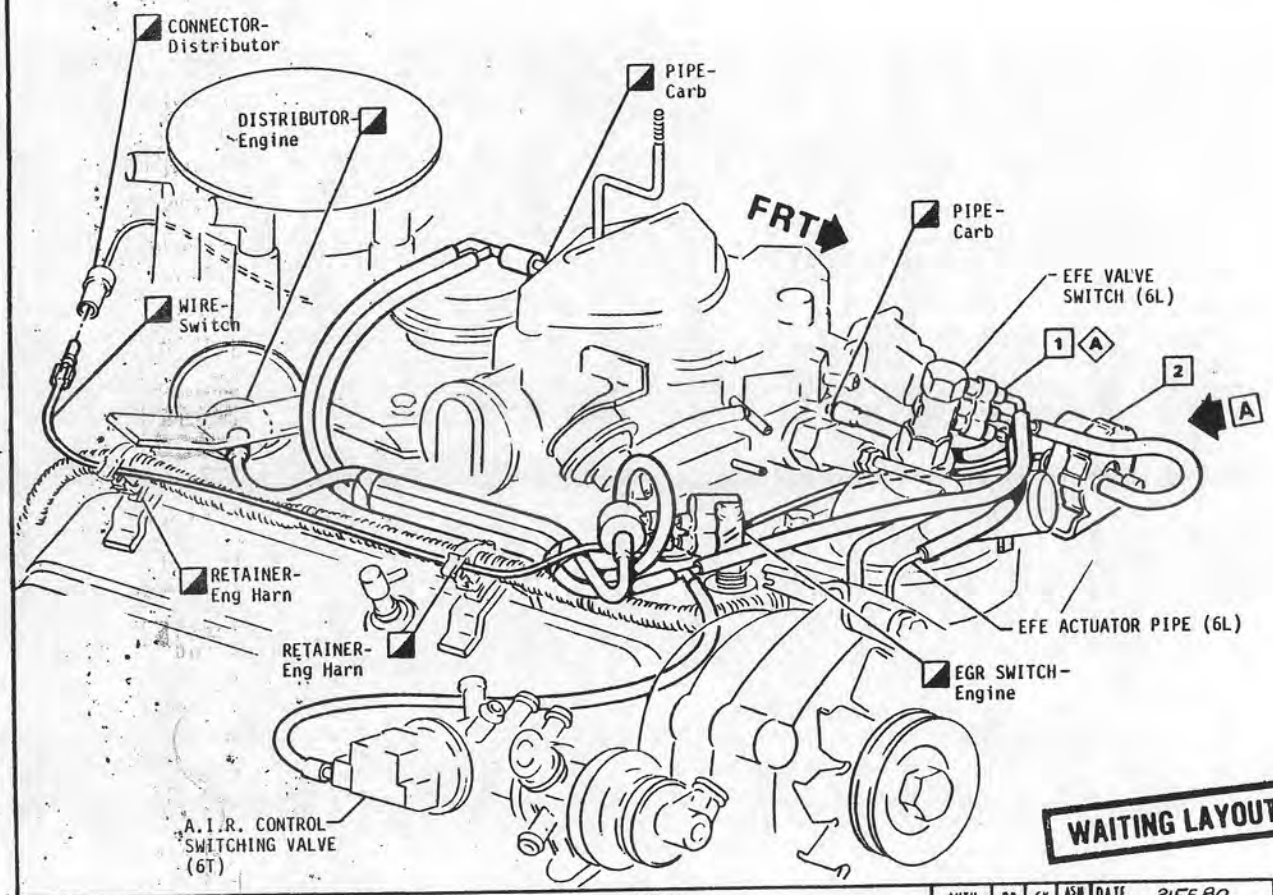
CA ☒ B ☐ O ☐ P ☒ Ca ☐

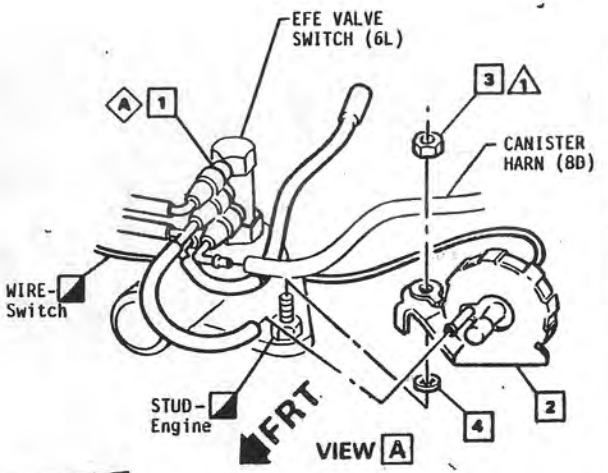
General Motors Corporation
CHEVROLET MOTOR DIVISION

PRODUCT DESCRIPTION MANUAL

☐ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF

14031141	1	HARNESS ASM
14032057	2	SWITCH ASM-SPARK RETARD
(3) 120377	3	NUT ASM
(4) 138542	4	WASHER
9985406	A	LUBRICANT Approx 0.015 L per job.





WAITING LAYOUT APPROVAL

DYNAMIC (Install) N·m	HAND (Insp.) N·m
1	26-40 (2)
2	
3	
4	
5	

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
14JUL80	1	REDRAWN & REDESIGNED	90528	RL	RE	C
030CT80	2	TORQUE 26-40 ADDED				C
	3	WAS 9418931 NUT	91344	CU	RCT	
14NOV80	4	ITEM 4 ADDED	91344	CU	RC	C

315

DATE 21FEB80
DR R. LINDNER
CK Richard C. Lindner RC
APPR NS
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE HARNESS ASM-EXHAUST EMISSION CONTROL FA00 &LC3 &NB1

REF ECR 86448 NEW 14FE80

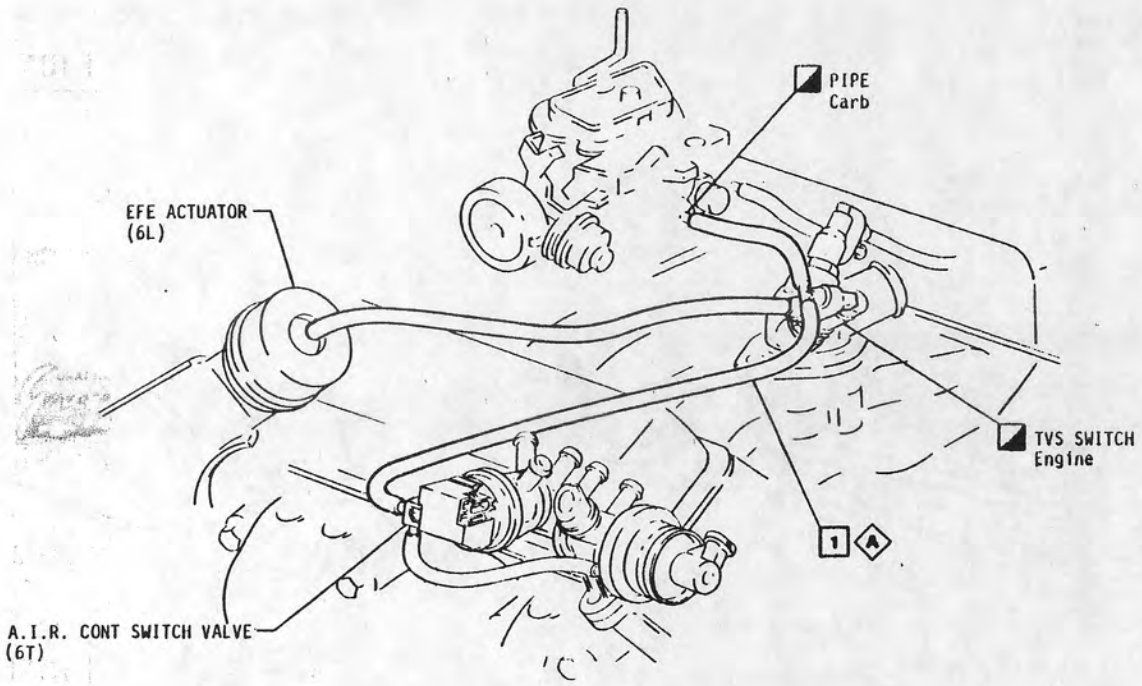
1-L-24776(NS) L- L- L-

UPC 6Y

SHEET 10

C ☒ B | O | P | Co |

14031142	1	HOSE ASM
9985406	A	RUBBER LUBRICANT Approx .015 L per job



WAITING LAYOUT APPROVAL

DYNAMIC (Install) N·m	HAND (Insp.) · N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
1 2 3 4 5				31C				

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE 22FEB0
DR R KOCH
CK Richard Koch RC
APPR NS
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
EMISSION HOSES
FA00 &L39 (exc NM5)

REF ECR 86448
NEW 15FE80

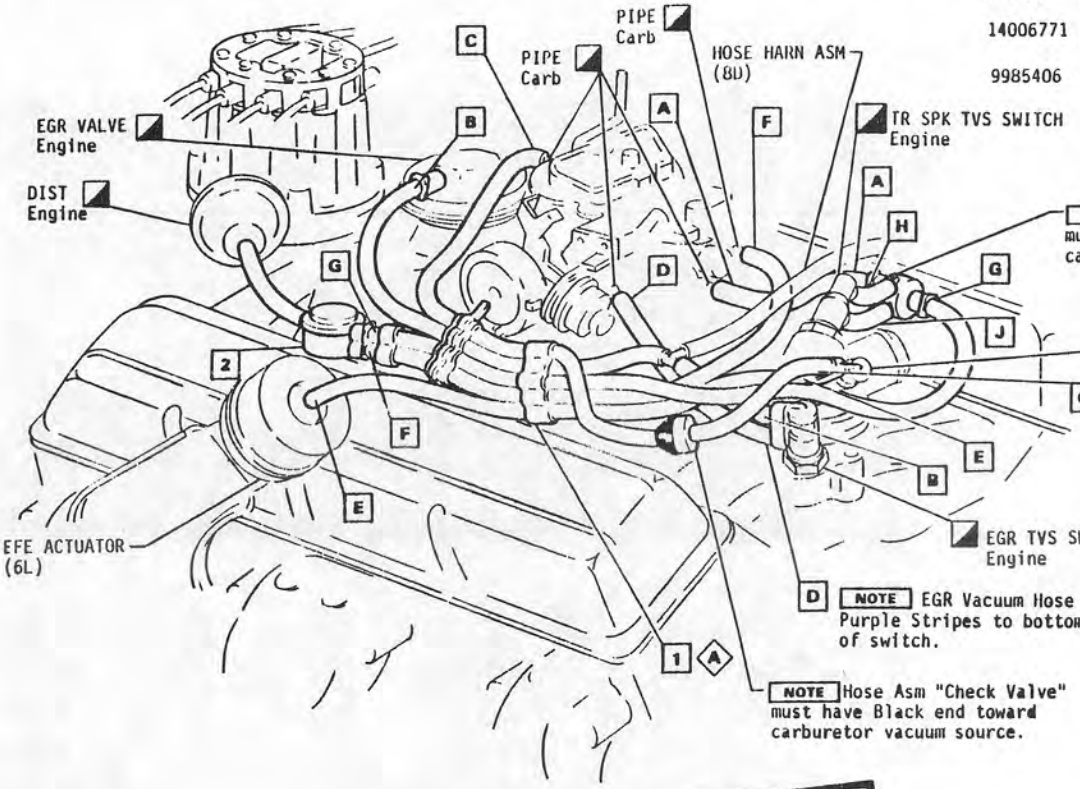
L- (NS)
L-
L-
L-

UPC 6Y

SHEET 11

Ch | B | O | P | Ca

745477	1	HOSE ASM
14006771	2	VAC. REG. VLV. & HOSE ASM
9985406	A	RUBBER LUBRICANT Approx .015L per job.



◪ EFE TVS SWITCH Engine

NOTE Hose Asm "Delay Valve" must have Black end toward carburetor vacuum source.

NOTE EFE Vacuum Hose with Yellow Stripes to top port of switch.

NOTE EGR Vacuum Hose with Purple Stripes to bottom port of switch.

NOTE Hose Asm "Check Valve" must have Black end toward carburetor vacuum source.

HOSE	COLOR
A	Lt. Blue Solid Stripe
B	Orange Solid Stripe
C	Yellow Solid Stripe
D	Purple Solid Stripe
E	White Solid Stripe
F	Lt. Blue Dashed Stripe
G	Lt. Green Solid Stripe
H	Lt. Brown Dashed Stripe
J	Red Solid Stripe

WAITING LAYOUT APPROVAL

A THRU J Letters used to indicate color code and opposite ends of each tube in Hose Asm for proper routing.

DYNAMIC (Install) N·m	HAND (Insp.) - N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
		18APR80	1	"NM6" WAS "NM5"	89395	RL	RL	

1 2 3 4 5 ⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

317

DATE 14FEB80
DR R KOCH
CK Richard Lin RL
APPR NS

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE EMISSION HOSES FA00 &L39 &NM6 (1)

REF ECR 86448 C/O 04FE80 6Y-15.1

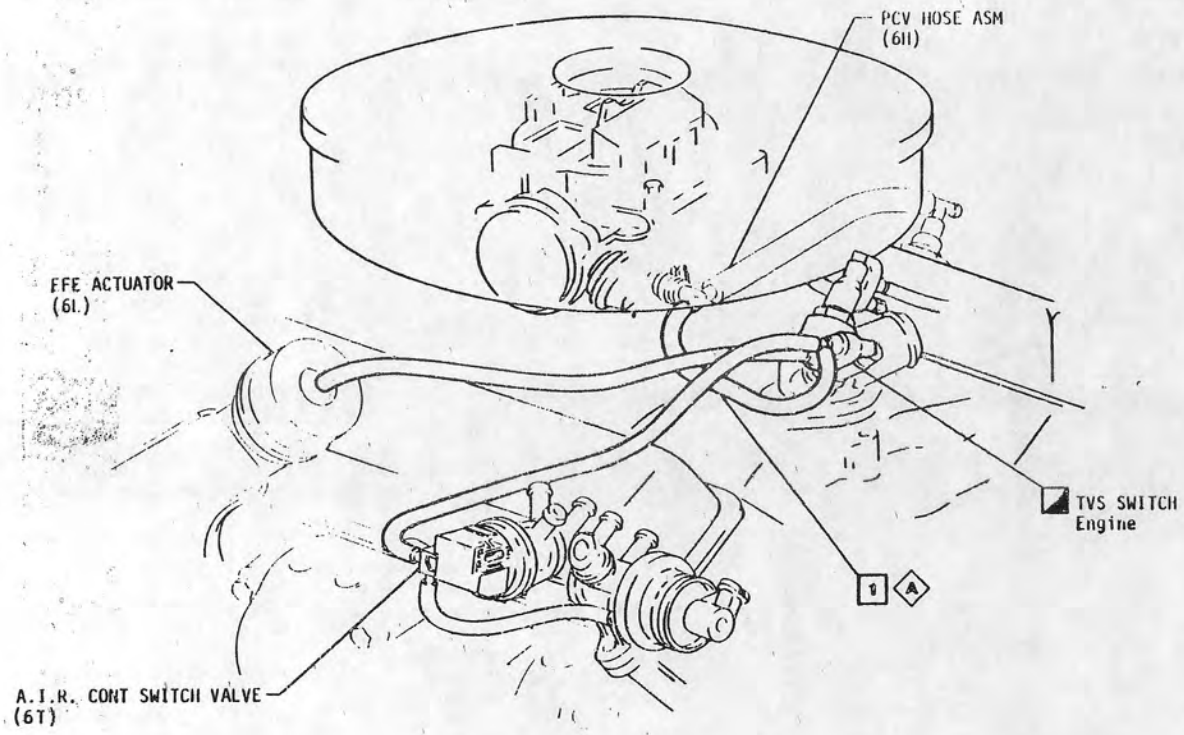
L- (NS)
L-
L-
L-

UPC 6Y

SHEET 11.1

Ch ☒ B ☒ O ☒ P ☒ Co ☐

14031143	1	HOSE ASM
9985406	A	RUBBER LUBRICANT Approx .015 L per job



WAITING LAYOUT APPROVAL

DYNAMIC (Install) N·m	HAND (Insp.)	DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
	1 2 3 4 5			31E				

⚠ FULLY DRIVEN SEATED IS NOT STRIPPED

CK ☒ U ☐ O ☐ P ☐ CW ☐

DATE 07MR80
DR R KOCH
CK H/J Buick HB
APPR NS
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE EMISSION HOSES FA00 &LG4 or LM1 exc NM5

REF ECR 86448 NEW 15FE80

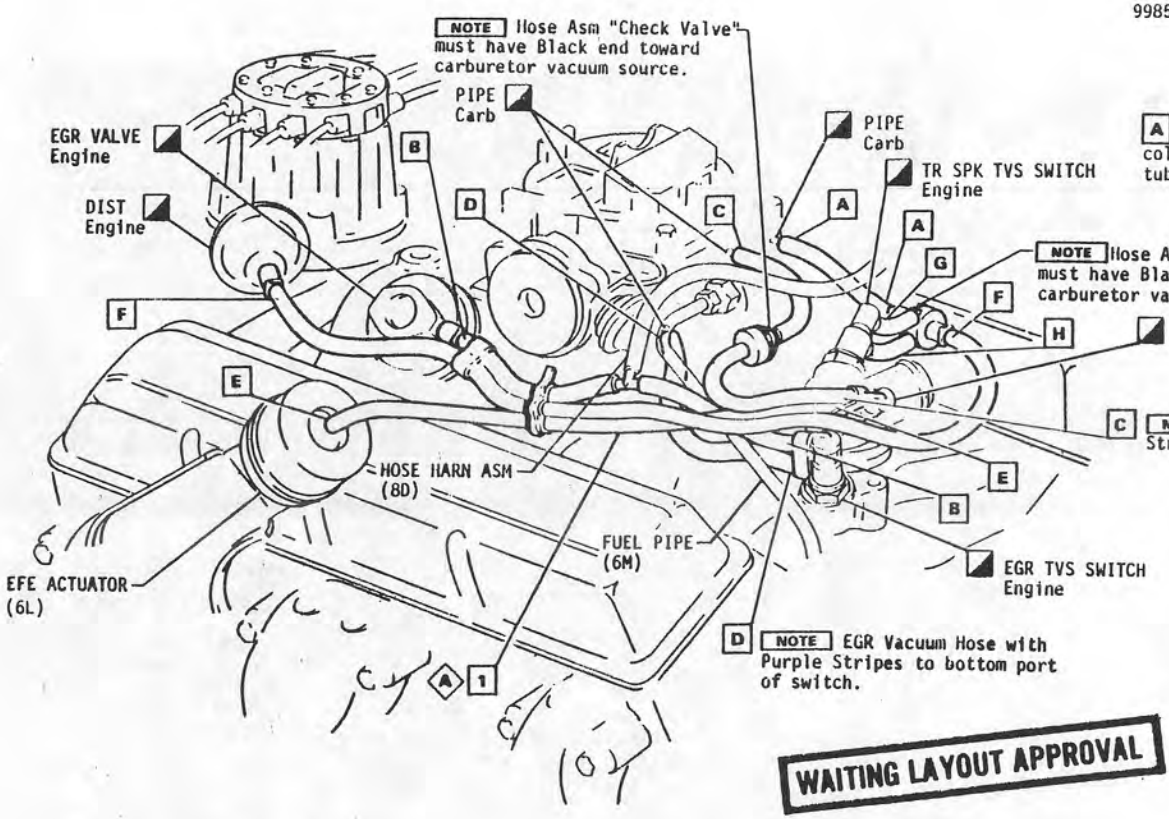
L- (NS) L- L- L-

UPC 6Y

SHEET 12

745476 [1] HOSE ASM

9985406 [A] RUBBER LUBRICANT
Approx .015L per job.



A THRU H Letters used to indicate color code and opposite ends of each tube in Hose Asm for proper routing.

HOSE	COLOR
A	Lt. Blue Solid Stripe
B	Orange Solid Stripe
C	Yellow Solid Stripe
D	Purple Solid Stripe
E	White Solid Stripe
F	Lt. Green Solid Stripe
G	Lt. Brown Dashed Stripe
H	Red Solid Stripe

WAITING LAYOUT APPROVAL

DYNAMIC (Install) N·m	HAND (Insp.) · N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
		18APR80	1	"NM6" WAS "NM5"	89395	RL	[illegible]	

DATE 14FEB80
DR R KOCH
CK Richard Cline RC
APPR NS
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE EMISSION HOSES FA00 &LG4 &NM6 (1)

REF ECR 86448 C/O 04FE80 6Y-17

L- (NS) L- L- L-

UPC 6Y

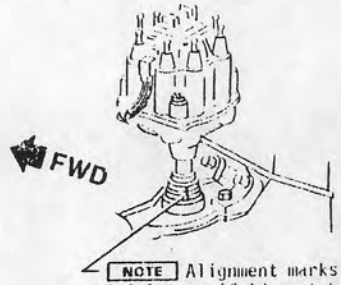
SHEET 13

319

1 FULLY DRIVEN, SEATED & NOT STRIPPED

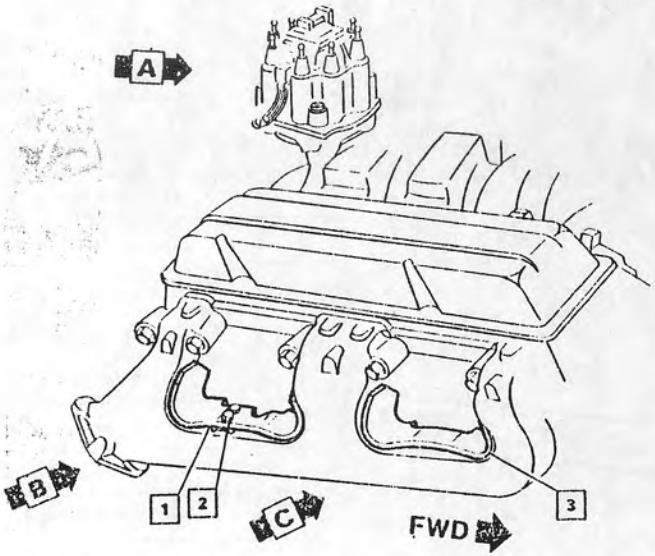
Ch B D P Co

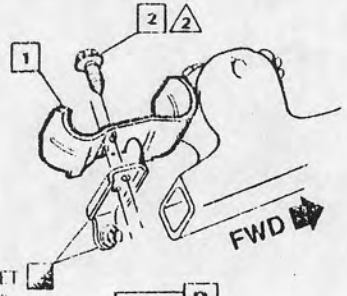
	14017879	1	SHIELD
(2)	11502833	2	BOLT/SCREW
	458628	3	SHIELD
	9431878	4	BOLT/SCREW



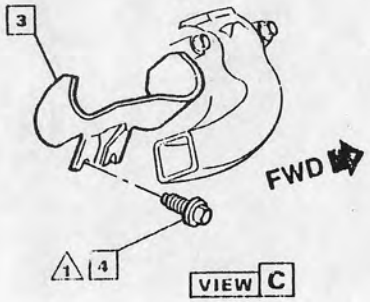
NOTE Alignment marks on distributor & inlet manifold must be checked. If misaligned or missing, distributor must be adjusted using a timing light to provide correct initial timing within ± 1°.

VIEW A





VIEW B



VIEW C

DYNAMIC (Install) N·m	HAND (Insp.) - N·m
△1	4.0-5.5
△2	1.6-2.2
1	
4	
3	

△1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
01NOV80	1	(EXC LUB) REMOVED	91222			
	2	WAS 11503644 BOLT - SCREW	93198	CO	EF	

320

DIV CHEVROLET

DATE 23MAR80
DR N. TAYLOR
CK
APPR S
APPR
APPR
APPR

1981 CHEV. "F" 14020867

TITLE SPARK PLUG SHIELDS RIGHT SIDE FA00 ALL V8 ENGINE (1)

REF ECR 86448
C/O 17AP80
6Y-19

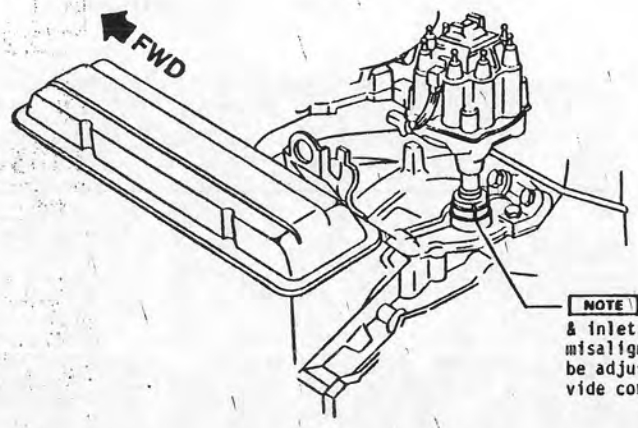
L-00190 (S)
L-
L-
L-

UPC 6Y

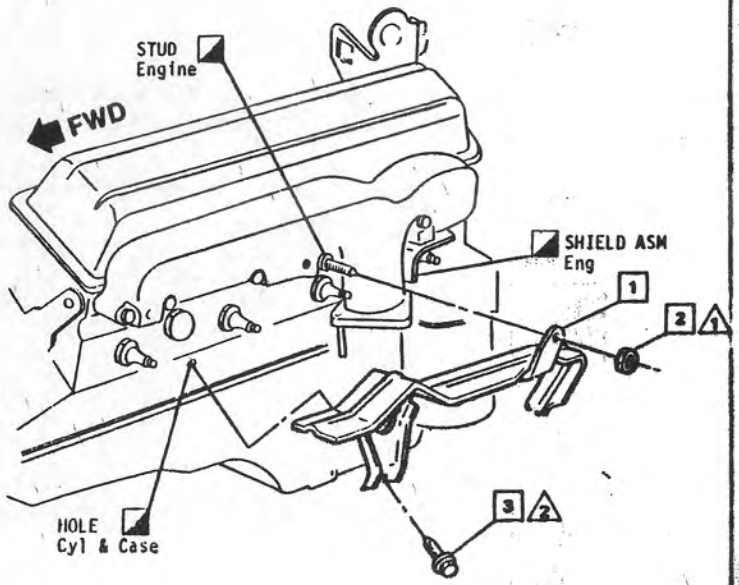
SHEET 14

Ch ☒ B ☐ D ☐ P ☒ Co ☐

14017722	1	SHIELD ASM
9418931	2	NUT
9431878	3	BOLT/SCREW



NOTE Alignment marks on distributor & inlet manifold must be checked. If misaligned or missing, distributor must be adjusted using a timing light to provide correct initial timing within ± 1°.



DYNAMIC (Instal) N·m	HAND (Insp.) · N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
	1 2.2-3.4 2 4.0-5.5 3 4 5							
	6 FULLY DRIVEN, SEATED & NOT STRIPPED			321				

DATE 23FE80
DR R. TAYLOR
CK NJ Buck HB
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE SPARK PLUG SHIELDS LEFT SIDE
FA00 ALL V8 ENGINE

BL ECR 86448
NEW 14FE80

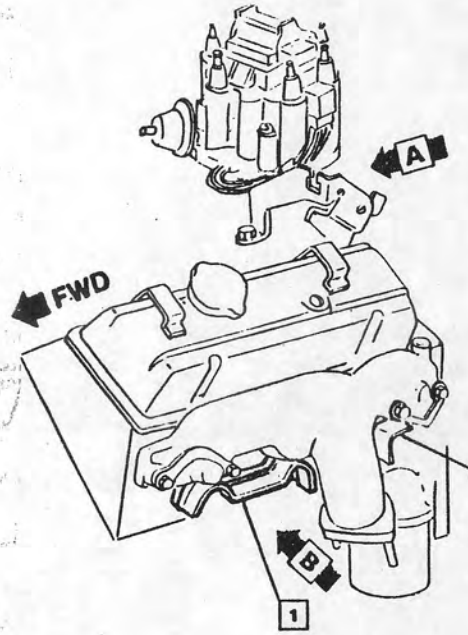
MC 15440 (S)
00190 (S)

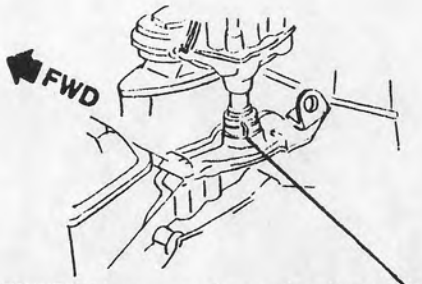
UPC 6Y

SHEET 15

L X D O P X Co

462683	1	SHIELD
9431878	2	BOLT/SCREW

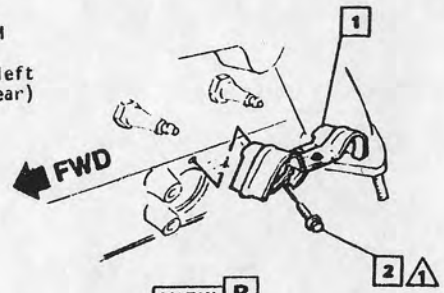




NOTE Alignment marks on distributor & inlet manifold must be checked. If misaligned or missing, distributor must be adjusted using a timing light to provide correct initial timing with ± 1° .

VIEW A

◪ SHIELD ASM Engine (Typical left & right rear)



VIEW B

TYPICAL LEFT & RIGHT FRT

WAITING LAYOUT APPROVAL

DYNAMIC (Install) N·m	HAND (Insp.) N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
△1	4.0-5.5							
△2								
△3								
△4								
△5								
△ FULLY DRIVEN, SEATED & NOT STRIPPED				322				

DATE 14 FEB 80
DR R. TAYLOR
CK Richard Cline Rc
APPR NS
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE SPARK PLUG SHIELDS FA00 & LC3

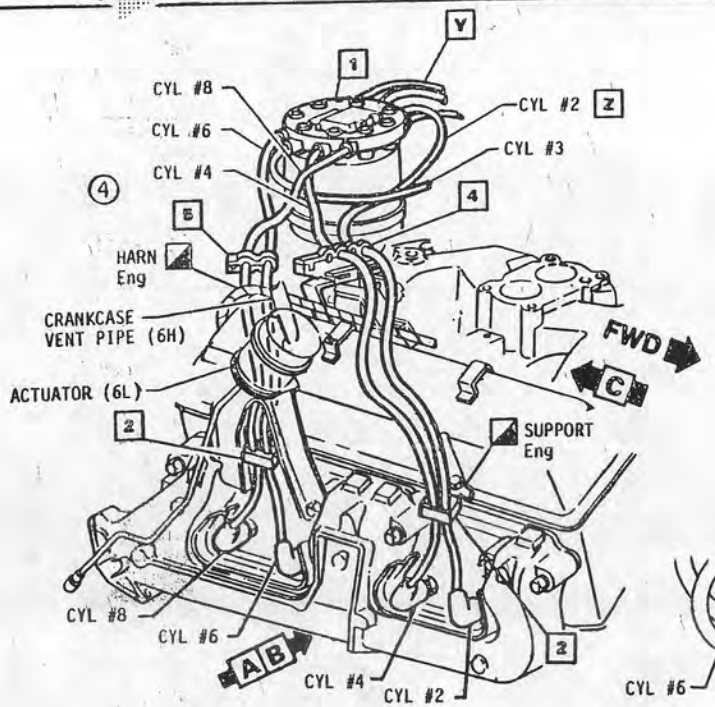
REF ECR 86448 C/O 16JA80 6Y-20

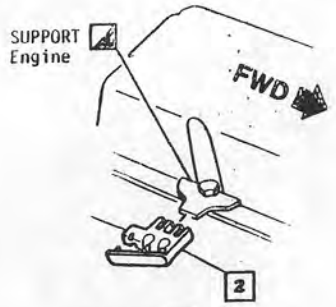
L- (NS) L- L-

UPC 6Y

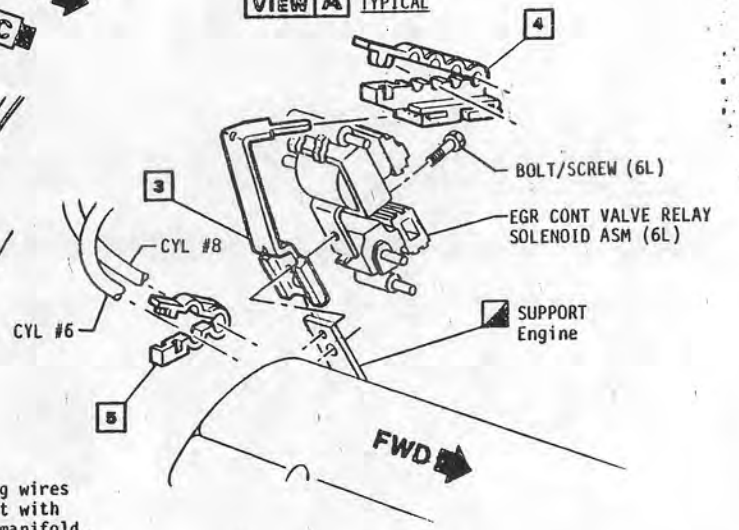
SHEET 16

Ch ☒ B ☐ O ☐ P ☐ Co ☐

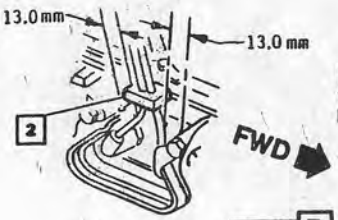




VIEW A TYPICAL



③ VIEW C TYPICAL
AUTO TRANS SHOWN



VIEW B TYPICAL

NOTE Rotate spark plug wires inward to prevent contact with heat shield and exhaust manifold.

12016203	1	HARNESS ASM
372539	2	RETAINER
⑥ 14044601	3	SUPPORT
① 500014	4	RETAINER
② 499457	5	RETAINER

NOTE Position spark plug wire nipples #1 & #8 to provide 6.35 min clearance to Air Cleaner.

WAITING LAYOUT APPROVAL

Y For remainder of routing to left side see SPARK PLUG WIRE ROUTING LEFT SIDE (6Y).

Z Take slack out of #2 wire at Retainer #2 to make wire nest against front of distributor.

DYNAMIC (Instal) N·m	HAND (Insp.) · N·m
1	
2	
3	
4	
5	

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
27JN80	1	WAS 372540 RETAINER	89798			
	2	ITEM 5 ADDED				C
	3	VIEW "C" REV.				C
	4	"SPARK PLUG" DRAWING REV.	91745	CU		C
05SE80	5	"8 NB1" ADDED	89798	CU		
17JA81	6	WAS 14033061 SUPPORT	94531	CU		

323

DATE	29 AUG 80
DR	R TAYLOR
CK	
APPR	NS
APPR	
APPR	
APPR	

DIV CHEVROLET

1981 CHEV. "F" 14020867

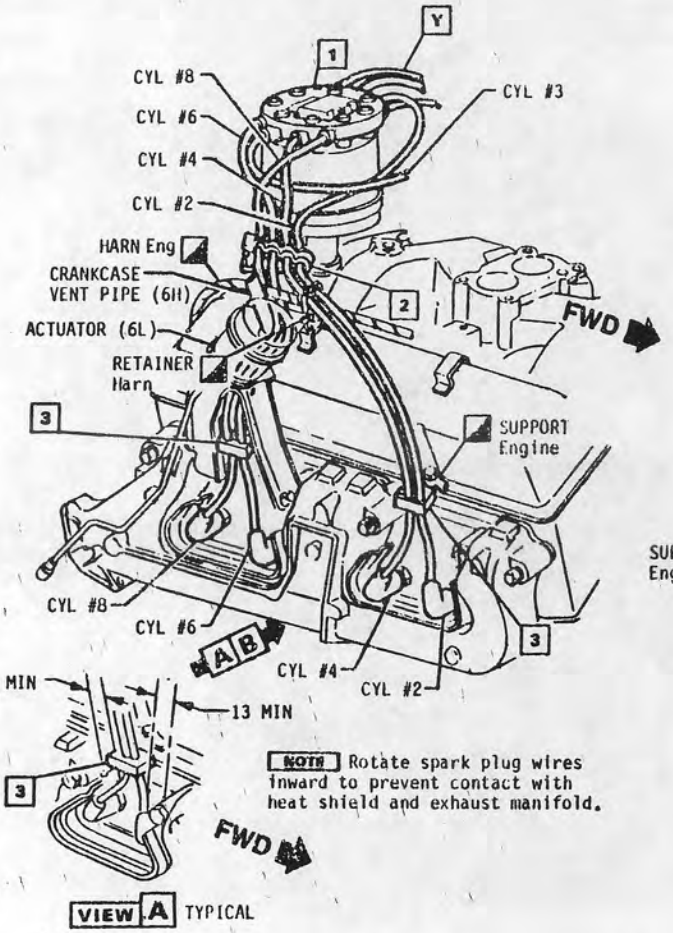
TITLE SPARK PLUG WIRE ROUTING RIGHT SIDE F&O0 &ALL V8 ENGINE &NB1 ⑤

REF ECR 86448 NEW 21MR80

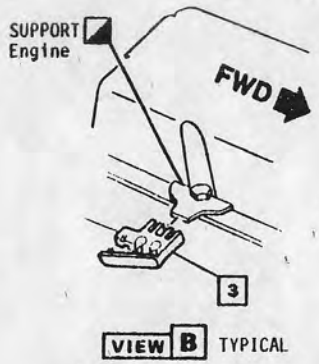
UPC 6Y

SHEET 17

Ch X B O P X Co



NOTE Rotate spark plug wires inward to prevent contact with heat shield and exhaust manifold.



12005623 [1]	HARNESS ASM & LM1
12005624 [1]	& LG4 or L39
367111 [2]	RETAINER
372539 [3]	RETAINER & LG4 or L39
372540 [3]	& LM1

NOTE Position spark plug wire nipples #1 & #8 to provide 6.35 min clearance to Air Cleaner.

WAITING LAYOUT APPROVAL

Y For remainder of routing to left side see SPARK PLUG WIRE ROUTING LEFT SIDE (6Y).

Z Take slack out of #2 wire at Retainer #2 to make wire nest against front of distributor.

DYNAMIC (Install) N·m	HAND (Insp.) · N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
1 2 3 4 5								
⚠ FULLY DRIVEN, SEATED & NOT STRIPPED				324				

DATE 29MAR80
DR R. TAYLOR/CU
CK Jim Hayes-TH
APPR NS
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

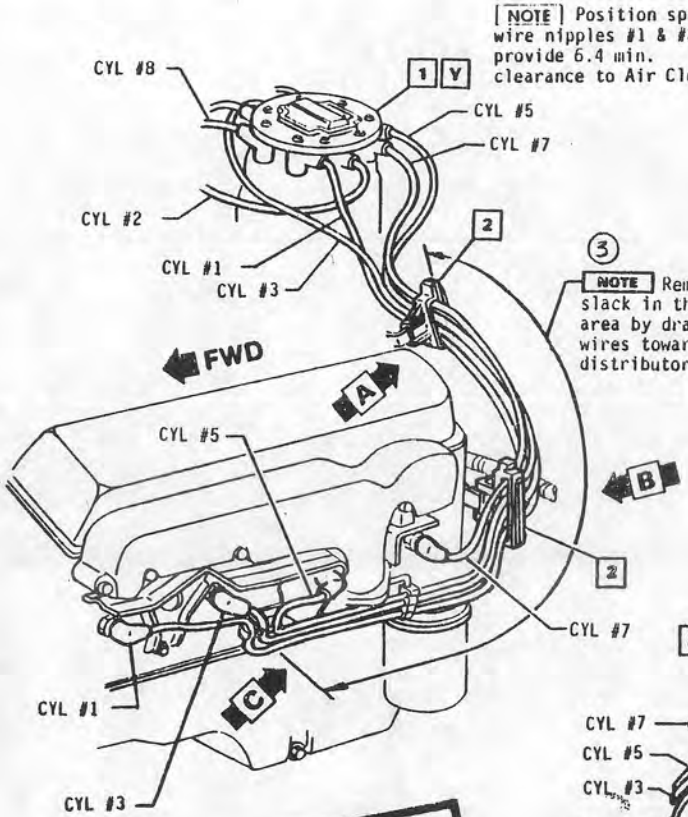
TITLE SPARK PLUG WIRE ROUTING RIGHT SIDE FA00 & ALL V8 ENGINE & NM4

REF ECR 86448 C/O 20MR80 6Y-21

UPC 6Y

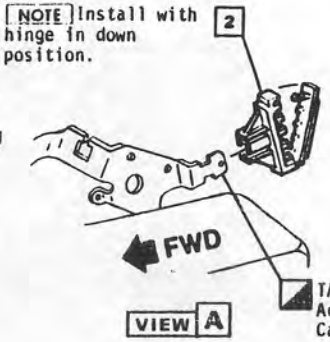
SHEET 17.1

Ck ☒ D ☐ O ☐ P ☒ Co ☐



[NOTE] Position spark plug wire nipples #1 & #8 to provide 6.4 min. clearance to Air Cleaner.

③ [NOTE] Remove slack in this area by drawing wires toward distributor.

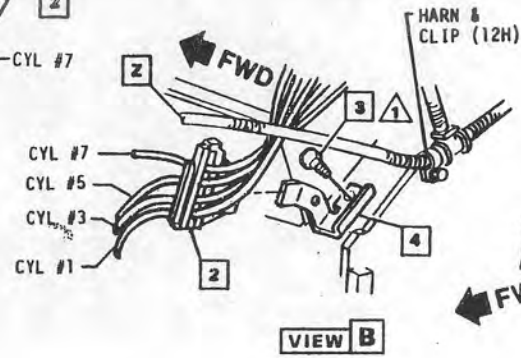


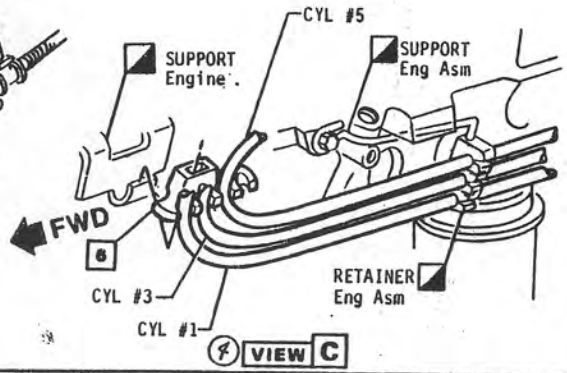
[NOTE] Install with hinge in down position.

①	12016203	1	HARNESS ASM
	372540	2	RETAINER
	274430	3	BOLT/SCREW
	14007361	4	SUPPORT
②		5	
	357125	6	RETAINER
	8917420	6	OPT

Y For remainder of routing to right side, see "Spark Plug Wire Routing, Right Side" Sheet.

Z Route Spark Plug Wires in front of Eng Wire Harn; as shown.





WAITING LAYOUT APPROVAL

DYNAMIC (Install) N·m	HAND (Insp.) N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
① 4.0-5.5		05SEP80	1	WAS 12005624 HARN				
②			2	8911554 RETAINER REM				
③			3	"WIRE" NOTE REVISED				C
④			4	VIEW "C" REVISED				C
⑤			5	WAS "JLG4 & NB2"	89770	CU	RC	
⑥								
⑦								
⚠ FULLY DRIVEN, SEATED & NOT STRIPPED								

325

DATE	14 FEB 80
DR	R. TAYLOR
CK	Richard Cline RC
APPR	NS
APPR	
APPR	
APPR	

DIV CHEVROLET

1981 CHEV. "F" 14020867

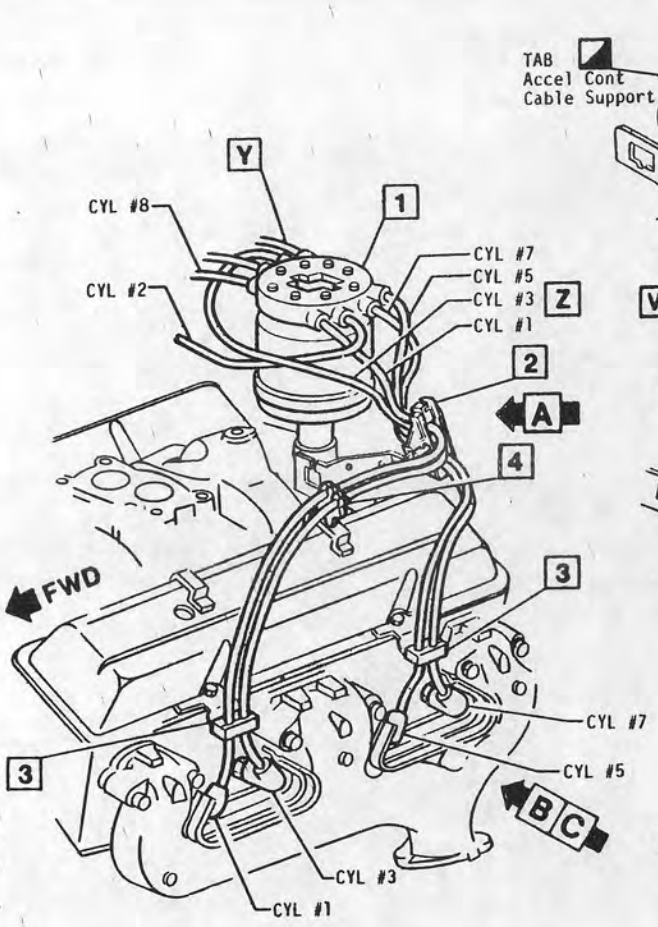
TITLE SPARK PLUG WIRE ROUTING LEFT SIDE FA00 &ALL V8 ENGINE &NB1 ⑤

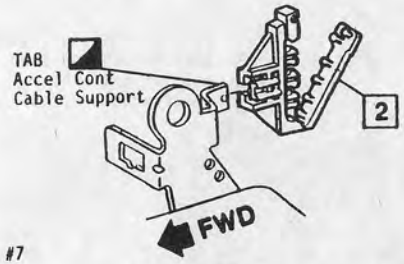
REF	UPC	SHEET
ECR 86448 C/O 16JA80 6Y-22	6Y	18

(NS)

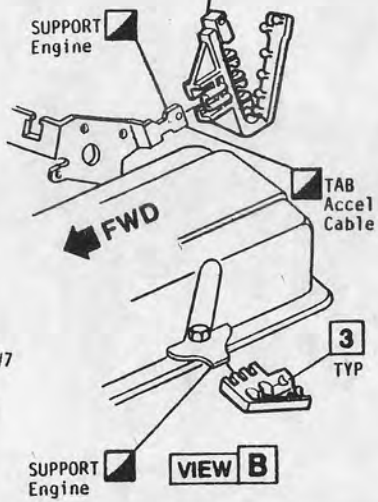
Ck ☒ B ☐ O ☐ P ☒ Co ☐

1	12005623	1	HARNESS ASM
4 2		1	
	372540	2	RETAINER
	372539	3	RETAINER
	8911952	4	RETAINER
	8911953	4	OPT





VIEW A & LM1



VIEW B

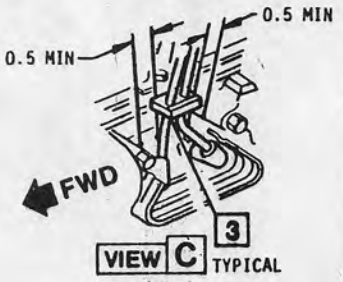
NOTE Install with hinge in down position.

NOTE Position spark plug wire nipples #1 and #8 to provide 6.35 mm min clearance to air cleaner.

Y For remainder of routing to RT side see SPARK PLUG WIRE ROUTING RIGHT SIDE (6Y).

Z Take slack out of #3 wire at Retainer #2 to make wire nest against front of distributor.

NOTE Rotate spark plug wires inward to prevent contact with heat shield and exhaust manifold.



VIEW C TYPICAL

DYNAMIC (Install) N·m	HAND (Insp.) · N·m
1	
2	
3	
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
05SEP80	1	12005623 WAS 12016203				
	2	12005624 HARN ADDED				
	3	WAS "V8 ENG (exc N82)"	89798	CU	RC	
14NOV80	4	12005624 HARN REM				
	5	"&LM1" WAS ALL V8 ENG	89944	CU	RC	

326

DATE 23MY80
DR R C TAYLOR
CK
APPR 5
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE SPARK PLUG WIRE ROUTING LEFT SIDE FA00 &LM1 &NM4 (3)(5)

REF ECR 86448 C/O 14MY80 6Y-23

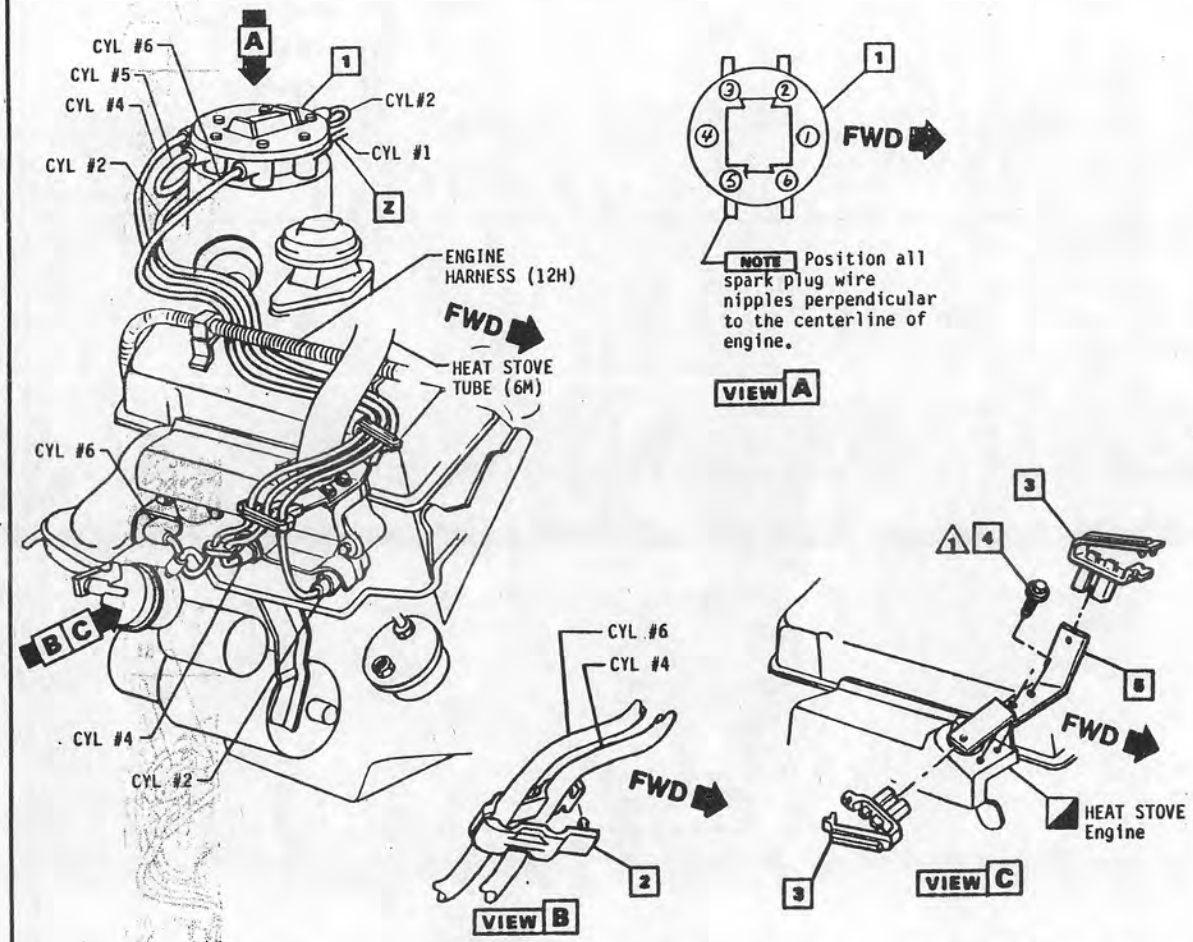
L- 05907 (S)
L-
L-
L-

UPC 6Y

SHEET 19

Ch 7/21 B O P Co

12005790	1	HARNESS ASM	
499457	2	RETAINER	
469513	3	RETAINER	
(2)(1) 11502833	4	BOLT/SCREW	
14017741	5	SUPPORT	



NOTE Position all spark plug wire nipples perpendicular to the centerline of engine.

VIEW A

Z For remainder of routing to left side, see "Spark Plug Wire Routing, Left Side" sheet.

DYNAMIC (Instal) N·m	HAND (Insp.) - N·m
1	1.6-2.2
2	
3	
4	
5	

1 FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
2/10/80	1	WAS 11503644 BOLT/SCREW	93198	CU	RB	
2/14/80	2	WAS 1502833 BOLT/SCREW	93198	CU	RL	

327

Ch X B O P Ca

DATE 14FE80
DR R. TAYLOR
CK Richard Lewis RL
APPR NS
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE SPARK PLUG WIRE ROUTING RIGHT SIDE FA00 & LC3

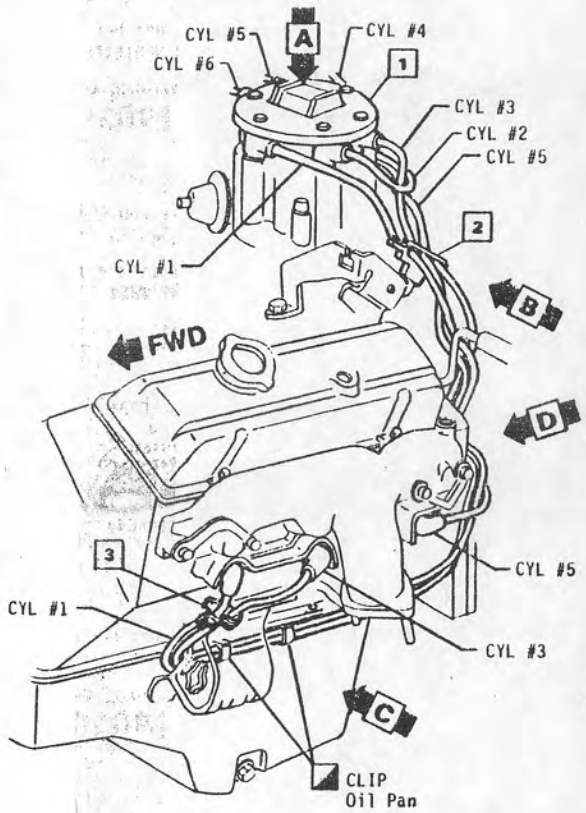
REF ECR 86448 C/O 16JA80 6Y-24

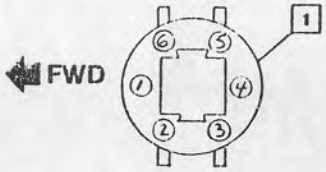
L-(NS) L- L- L-

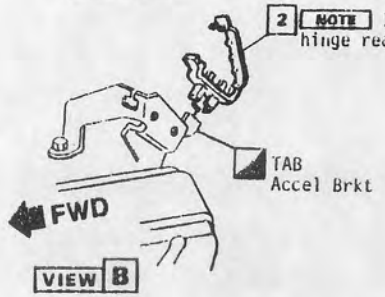
UPC 6Y

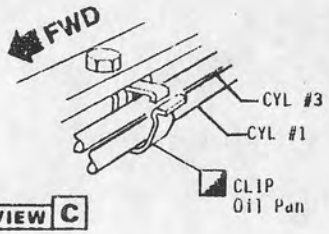
SHEET 20

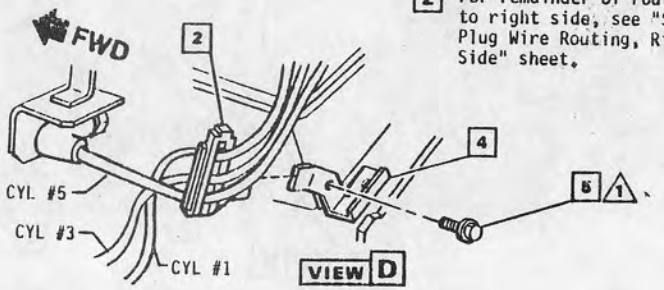
12005790	1	HARNESS ASM
469513	2	RETAINER
499457	3	RETAINER
14007361	4	SUPPORT
9419051	5	BOLT/SCREW











Z For remainder of routing to right side, see "Spark Plug Wire Routing, Right Side" sheet.

DYNAMIC (Install) N·m	HAND (Insp.) - N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
1 27-40								
2								
3								
4								
5								
⚠ FULLY DRIVEN, SEATED & NOT STRIPPED				328				

DATE 14FEB0
DR R. TAYLOR
CK Richard Clinton
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE SPARK PLUG WIRE ROUTING LEFT SIDE FA00 & LC3

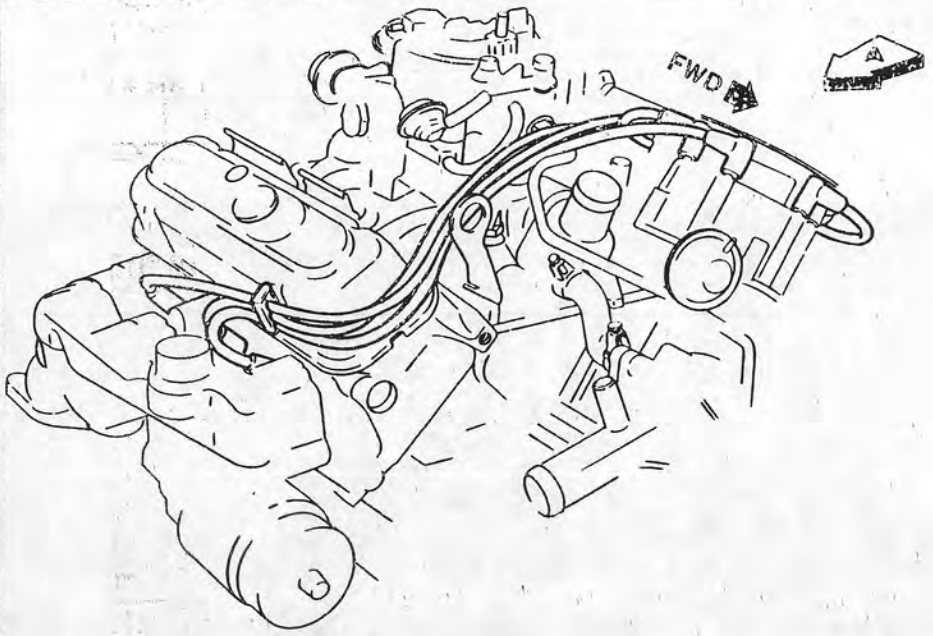
REF ECR 86448 C/O 16JA80 6Y-25

L-16034 (S)
L-
L-
L-

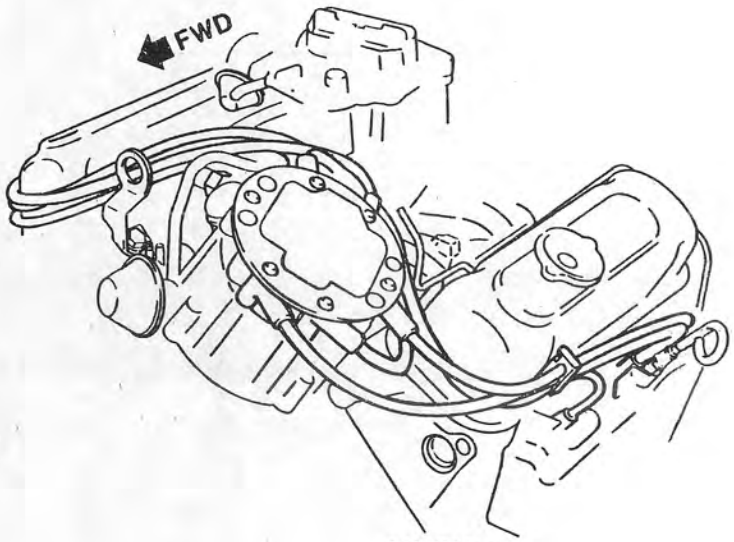
UPC 6Y

SHEET 21

Ck | I | O | P | Co



RIGHT IGNITION WIRING



VIEW-A

LEFT IGNITION WIRING

DYNAMIC (Instal) N·m HARD (Insp.) N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASG ENG
	22JA80		ISSUED	86448	CU	AS	
			329				

1 2 3 4 5

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

Ch B O P Cn

DATE 22JA79
DR MAC DORMOTT
CK
APPR
APPR
APPR
APPR

DIV CHEVROLET

DEF ECR 86448
C/O 12MY80
6Y-13 RT

1981 CHEV. "F" 14020867

TITLE
SPARK PLUG WIRING
FA00 & LD5

UPC 6Y

SHEET 22

PONTIAC MOTOR DIVISION

General Motors Corporation Pontiac, Michigan

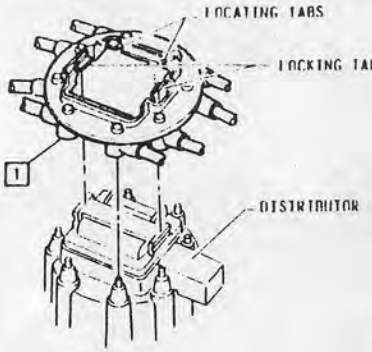
PRODUCT DESCRIPTION MANUAL

□ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF

1 6Y4 HARNESS ASM.
2 6Y4 RETAINER
3 6Y4 RETAINER
4 6Y4 BRACKET
5 6Y4 BOLT
— UPL

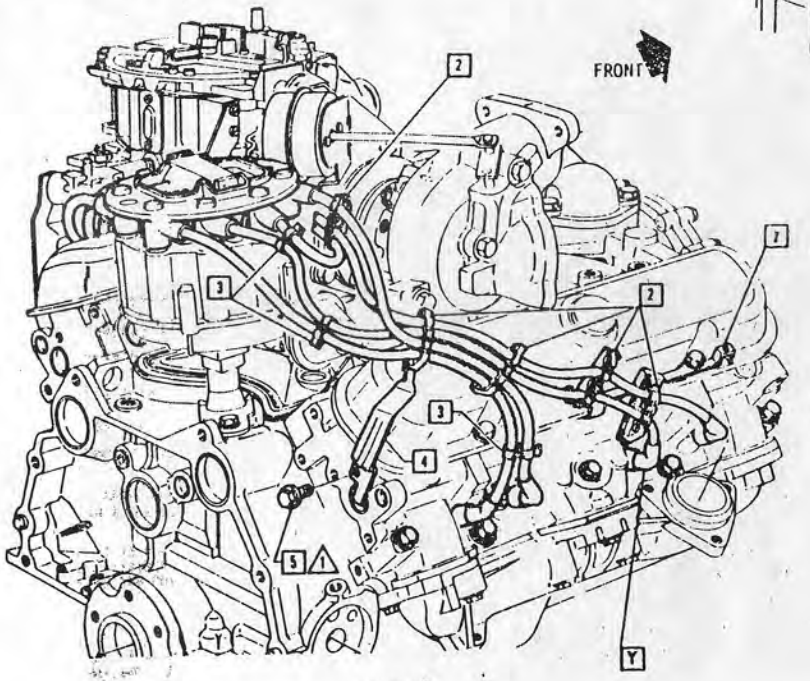
Y INSTALL SPARK PLUG WIRES ON SPARK PLUGS IN A VERTICAL POSITION

Z SEE SHEET 15 FOR SPARK PLUG WIRE LOCKING RETAINER MOUNTING BRACKETS TO ROCKER ARM COVERS — UPL

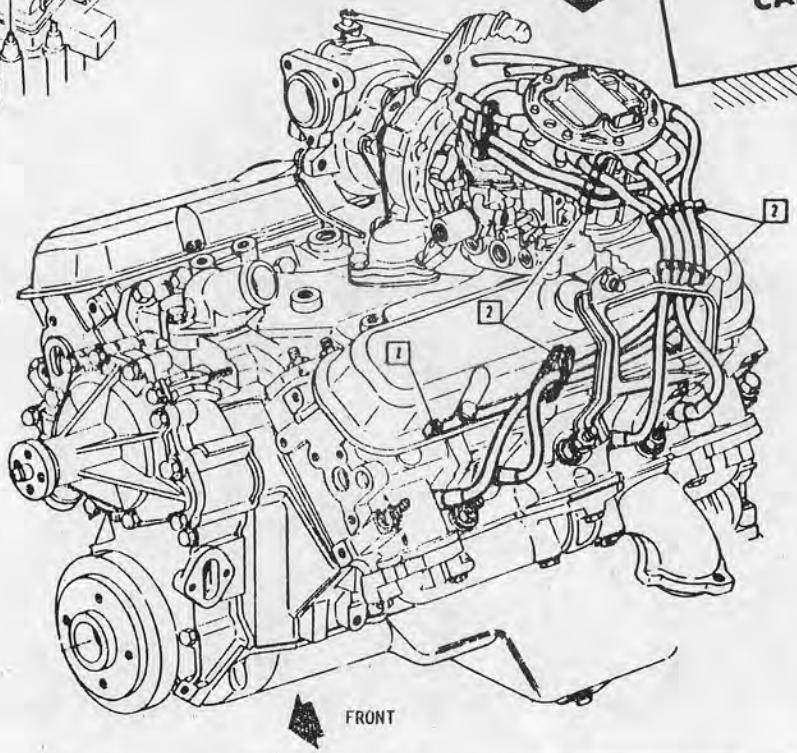


CAUTION SPARK PLUG WIRE TO BE ROUTED TO AVOID CONTACT OR RUB AGAINST EACH OTHER OR SOME OBJECT WHEREVER POSSIBLE.

CANCELED



VIEW A



DYNAMIC (Install) N.m | HAND (Insp.) N.m

△1 △1 △1 △1 △1

△ FULLY DRIVEN SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
7JAN80		ISSUED	RG448	CU	[illegible]	
07NOV80	1	SHEET CANCELED	71222	CU	EJ	

330

DATE 25 OC 79
DR G.M. VERSTRAETE
CK J.E.B.
APPR S
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE SPARK PLUG WIRE ROUTING FA00 & LU8

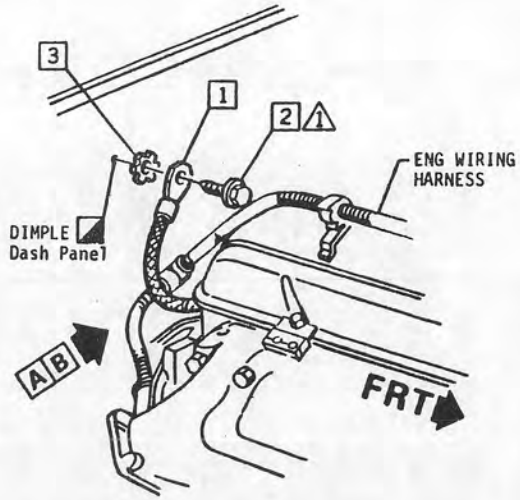
REF ECR 86448 C/O 11DE79 6Y-22 RT

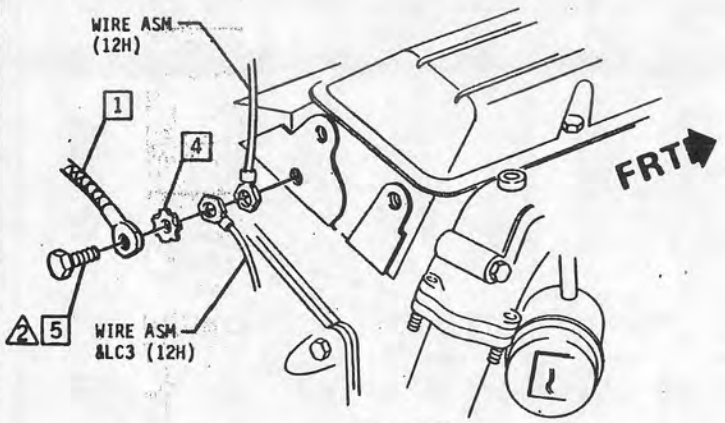
UPC 6Y

SHEET 23

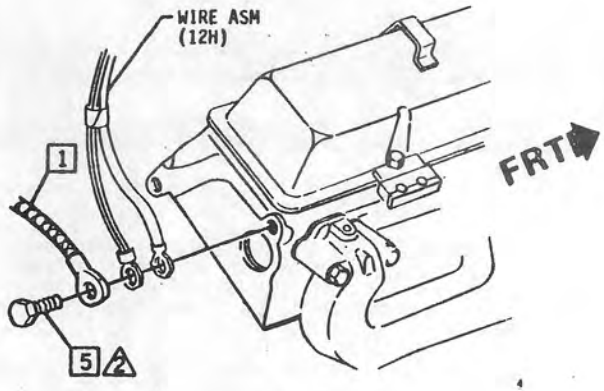
Ch X 3 0 P X Co

8916578	1	STRAP ASM
11503408	2	BOLT/SCREW
11501045	3	WASHER
11500417	4	WASHER (CANADA ONLY)
③ + 9428638	5	BOLT/SCREW





VIEW A



④ VIEW B &LD5

DYNAMIC (Instal) N.m	HAND (Insp.) - N.m	DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG	
	1 1.2-1.6	14SEB0	2	REDRAWN & REDESIGNED (PC-0035)	88765	CU	SM	C	DATE 14FEB0
	2 26-40	08DEB0	3	WAS 180116 BOLT/SCREW				C	DR R. TAYLOR
	3		4	VIEW "B" REV	91438	CU	SM	C	CK Richard Lee RC
	4								APPR S
	5								APPR
	⚠ FULLY DRIVEN, SEATED & NOT STRIPPED								APPR
				331					APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE ENGINE GROUND STRAP FA00 & ALL ENGINE

REF ECR 86448 C/O 29JA80 6Y-27

L-14560 (S)

UPC 6Y

SHEET 24

Ch ☒ B ☐ O ☐ P ☒ Cu ☐

BELT TENSION (NEWTONS)

ENGINE	TENSIONING	GENERATOR	POWER STEERING	AIR COND.	A.I.R. PUMP
(1)					
LD5	MAXIMUM INITIAL INSTALLATION	650	750	750	350
	MINIMUM AFTER CHASSIS ROLLS*	300	400	400	200
LC3	MAXIMUM INITIAL INSTALLATION	650	650	750	+
	MINIMUM AFTER CHASSIS ROLLS*	300	300	400	+
L39	MAXIMUM INITIAL INSTALLATION	650	650	750	+
	MINIMUM AFTER CHASSIS ROLLS*	300	300	400	+
LG4	MAXIMUM INITIAL INSTALLATION	650	650	750	+
	MINIMUM AFTER CHASSIS ROLLS*	300	300	400	+
LM1	MAXIMUM INITIAL INSTALLATION	650	650	750	+
	MINIMUM AFTER CHASSIS ROLLS*	300	300	400	+

*Tension to be checked within 15 minutes after vehicle has completed chassis rolls test.

For belts driving more than one adjustable accessory, use highest tension specified.

CAUTION Any tensioning of replacement belts, or re-tensioning of previously installed but unrun belts, must adhere to the above specifications (maximums prior to engine operation and minimums after engine operation). Any re-tensioning of previously run belts must be set to the "after chassis rolls" specifications - 0 +50 newtons.

Belt tensions are to be measured with a Borroughs Gage BT-33-95 ACBN.

At no time should belt exceed maximum initial installation tension.

WAITING LAYOUT APPROVAL

DYNAMIC (Instal) N·m	HAND (Insp.) N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
		01NOV80	1	"LUB" REMOVED	91222	CU	[illegible]	

(1) (2) (3) (4) (5)

⚠ FULLY DRIVEN, SEATED & HOT STRIPPED

332

DATE 07FEB80
DR R.I INDNER
CK [signature]
APPR N.S.
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

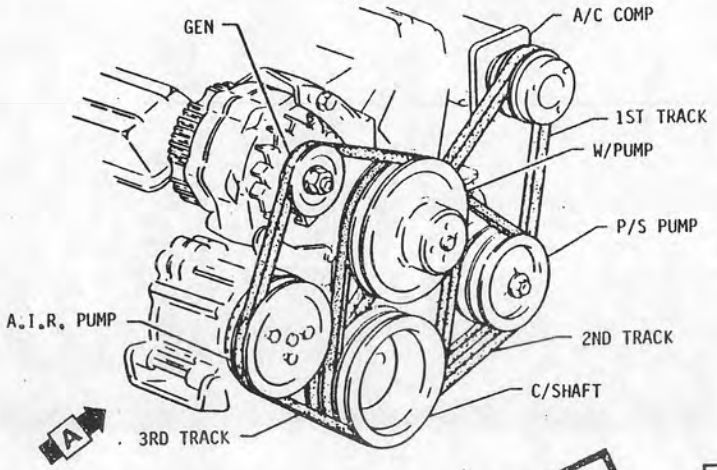
TITLE BELT TENSIONING FA00 ALL

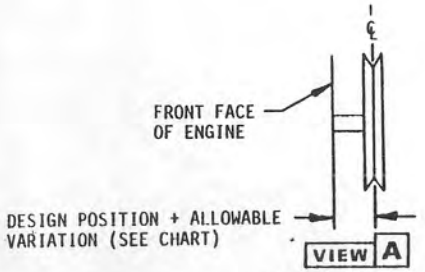
REF ECR 86448 C/O 18JA80 6Z-1

UPC 6Z

SHEET 1

Ch ☒ B ☐ D ☐ P ☒ Co ☐





TYPICAL BELT TRACK ℄ TO FRONT OF CASE

	Allowable variation Belt Track Centerline to Front of Case V6 or V8
Crankshaft Pulley	.05
Water Pump Pulley	.03
Generator Pulley	.06
Power Steering Pump Pulley	.13
A/C Compressor Pulley	.04
A.I.R. Pump Pulley	.07

Allowable variation, pulley to pulley, is determined by adding above tolerances together. For example: allowable variation of water pump to generator pulley on V8 engine is .03 + .06 or + .09. Tolerances are intended as a general indication of component part quality.

WAITING LAYOUT APPROVAL

DYNAMIC (Instal) N·m	HAND (Insp.) · N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
1								
2								
3								
4								
5				333				
⚠ FULLY DRIVEN, SEATED & NOT STRIPPED								

DATE 07FEB0
DR R. LINDNER
CK [signature]
APPR N.S
APPR
APPR
APPR

DIV CHEVROLET

REF ECR 86448
C/O 18JA80
6Z-2

1981 CHEV. "F" 14020867

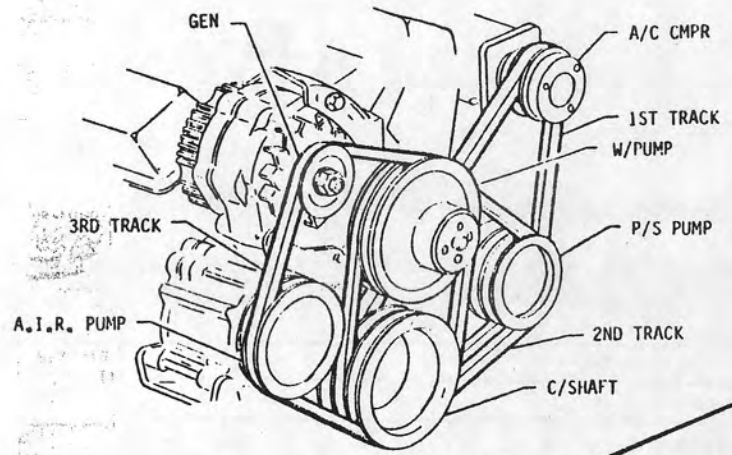
TITLE PULLEY ALIGNMENT
FA00 ALL

L (NS)

UPC 6Z

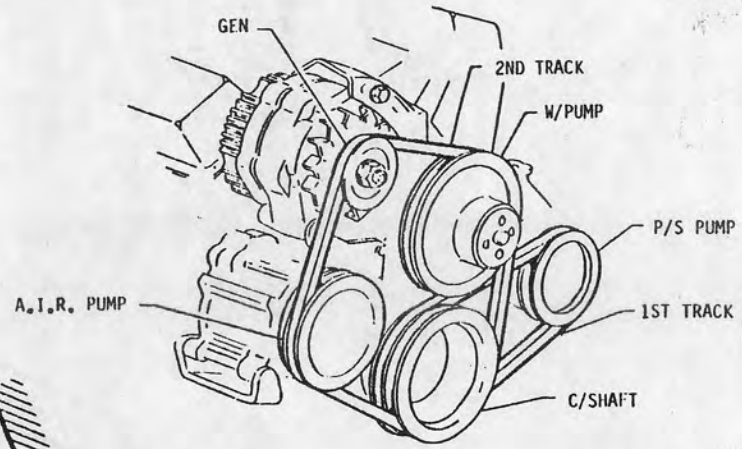
SHEET 2

Ch ☒ B ☐ O ☐ P ☒ Ca ☐



& C60

CANCELED



WAITING LAYOUT APPROVAL

DYNAMIC (Instal) N·m	HAND (Insp) N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
		030CT80	1	SHT CANCELED	86448	CU	RET	C

DATE 07FEB80
DR R. LINDNER
CK
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE PULLEY BELT ROUTING FA00 &LC3

REF ECR 86448 C/O 18JA80 6Z-3

UPC 6Z

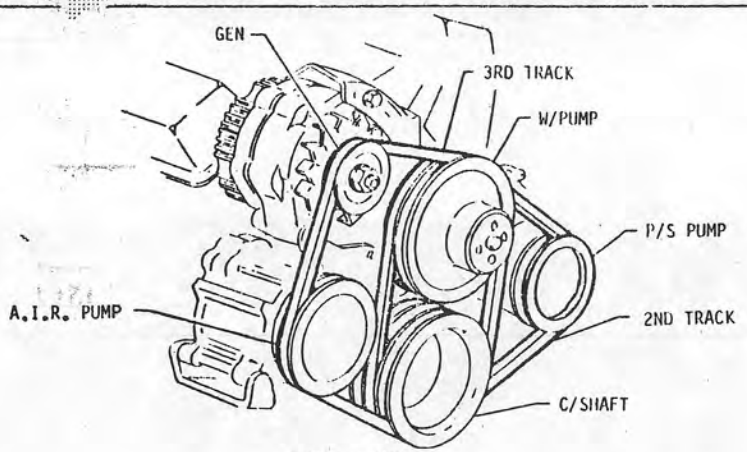
SHEET 3

334

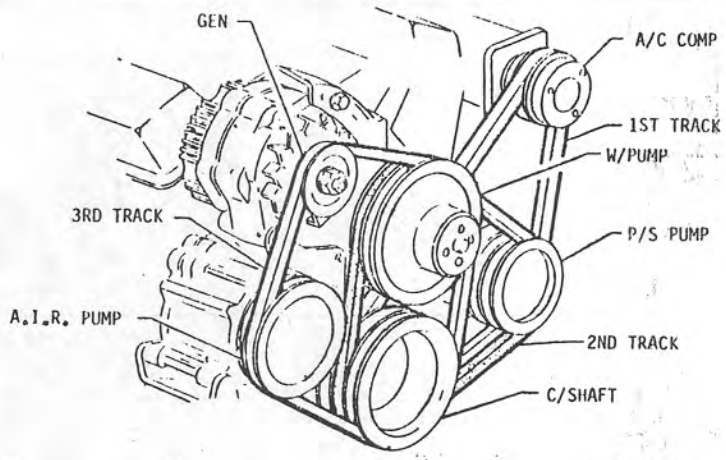
1 2 3 4 5

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

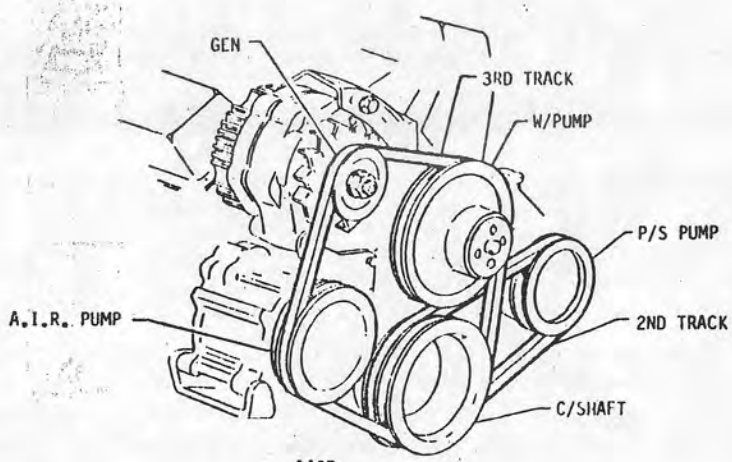
Ch X B O P Cg



& K73 or K81



& C60



BASE

WAITING LAYOUT APPROVAL

DYNAMIC (Instal) N·m	HAND (Insp.) - N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
		030CB0	1	"LC3" ADDED	86448	CU	RCT	
				335				

1 2 3 4 5
⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE 07FEB0
DR R. LINDNER
CK
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

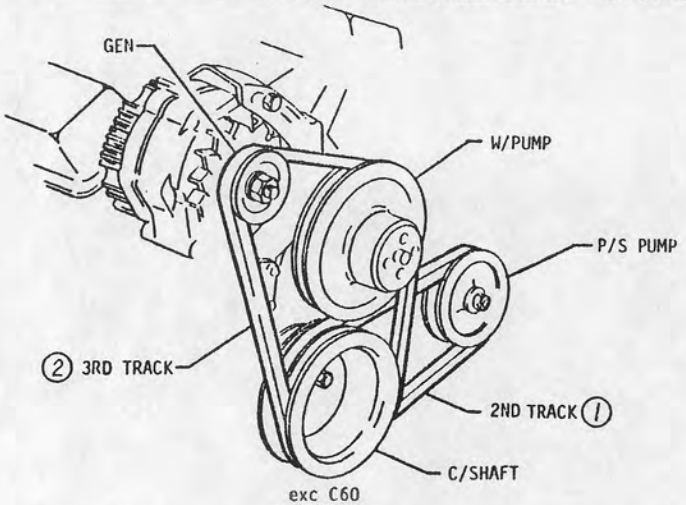
TITLE PULLEY & BELT ROUTING
FA00 &LG4/LM1/L39/LC3 (1)

REF ECR 86448
C/O 18JA80
6Z-4

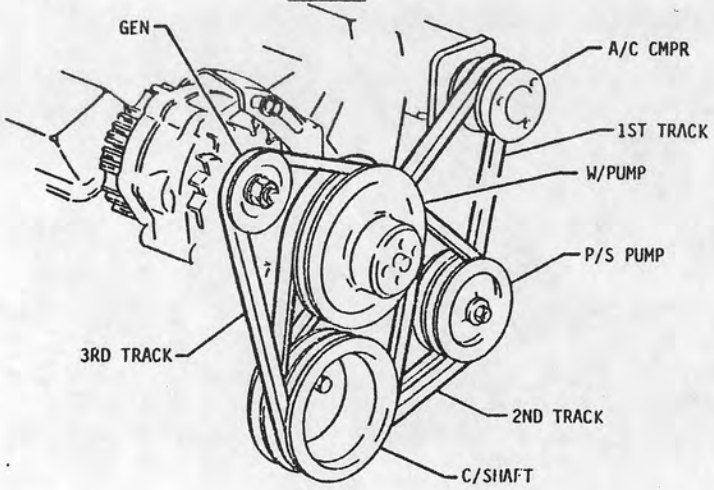
UPC 6Z

SHEET 4

Ch ☒ B ☐ J ☐ P ☒ Ca ☐



exc C60



& C60

DYNAMIC (Instal) N·m	HAND (Insp.) - N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
		030C.80	1	"2ND" WAS "1ST"				
			2	"3RD" WAS "2ND"	86448	CJJ	RET	

△1 △2 △3 △4 △5 △ FULLY DRIVEN, SEATED & NOT STRIPPED

336

DATE 07MR80
DR R. LINDNER
CK W.J. Buck H.B. S
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE BELT ROUTING
FA00 &LG4 or L39 &NH4

REF ECR 86448
NEW 29FE80

L-11532 (S)
L-
L-
L-

UFC 6Z

SHEET 4.1

C ☒ B ☐ O ☐ P ☐ Co ☐

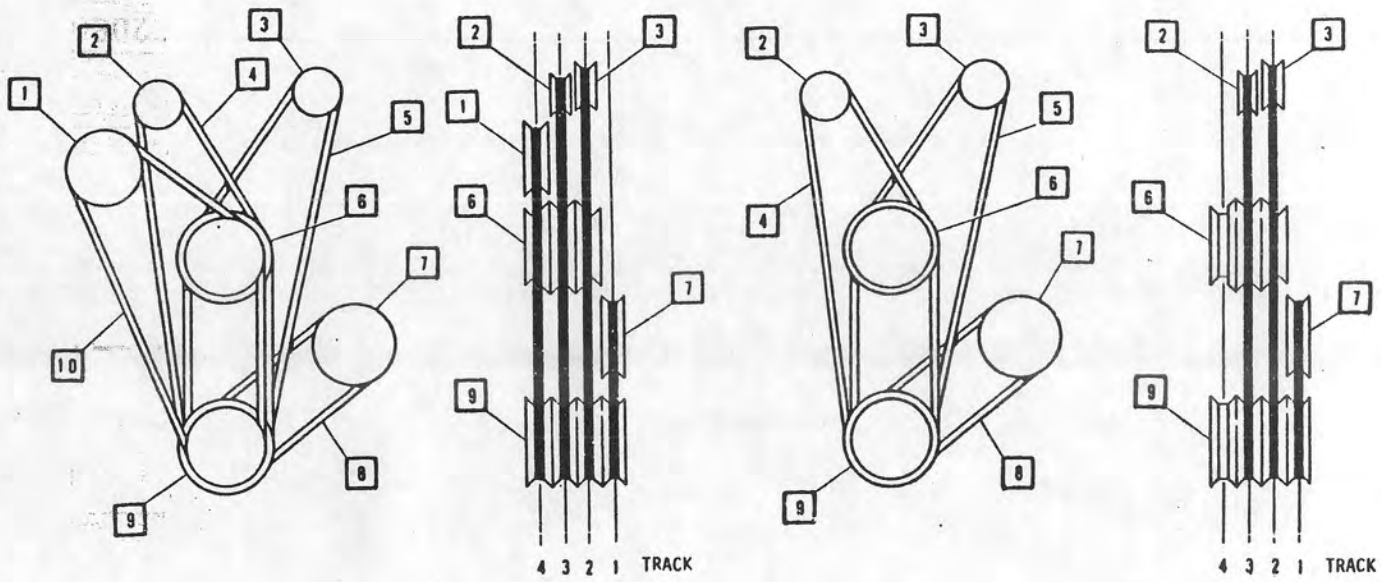
PONTIAC MOTOR DIVISION

General Motors Corporation Pontiac, Michigan

PRODUCT DESCRIPTION MANUAL

□ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF

1. A/C COMPRESSOR ASM. - 1A2G
2. GENERATOR ASM. - 6Y
3. A.I.R. PUMP PULLEY - 6T
4. BELT - 6K1
5. BELT - 6T
6. WATER PUMP PULLEY - 6K1
7. P/S PUMP PULLEY - 9E
8. BELT - 9E
9. CRANKSHAFT PULLEY - UPL
10. BELT - 1A2G



WITH C60 EXC. C60

DYNAMIC (Instal) N.m	HAND (Insp.) - N.m
1	
2	
3	
4	
5	

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
20JN80		ISSUED	86448	RL	MB	

337

DATE 07 MY 80
DR R.P. BIERI
CK AAB
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE PULLEY AND BELT DIAGRAM FA00 &LD5

REF ECR 86448 NEW 09JN80 R.L.

UPC 6Z

SHEET 5

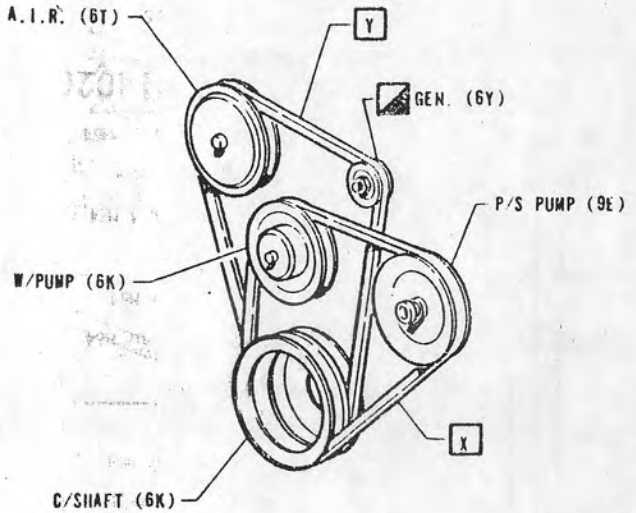
Ch X 8 0 P X Ca

PONTIAC MOTOR DIVISION

General Motors Corporation Pontiac, Michigan

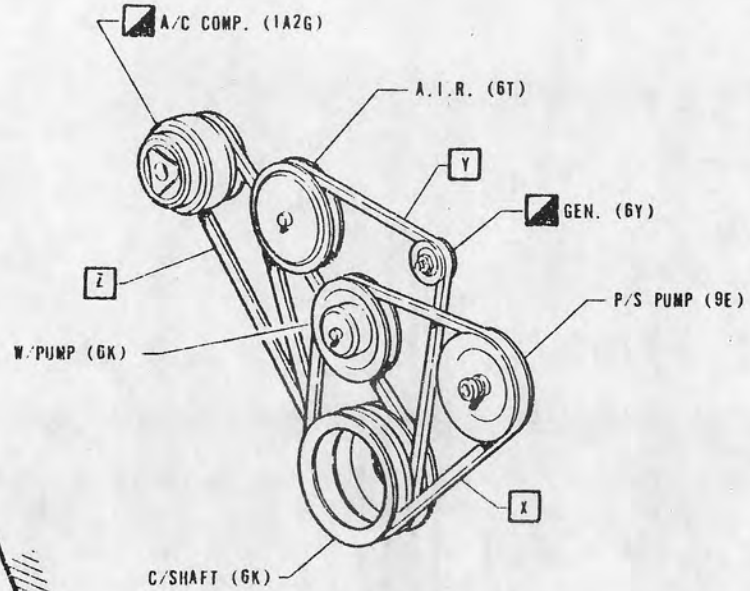
PRODUCT DESCRIPTION MANUAL

☐ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF



WITH C41 & N41

CANCELED



WITH C60 & N41

X 3RD TRACK
Y 2ND TRACK
Z 1ST TRACK

DYNAMIC (Instal) N·m	HAND (Insp.) - N·m

1 2 3 4 5

⚠ FULLY DRIVEN SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
7JAN80		ISSUED	86448	CO	[illegible]	
07NOV80	1	SHEET CANCELED	[illegible]	[illegible]	EF	

338

DATE 25 OC 79
DR GMV/EDB
CK JEB
APPR S
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE PULLEY & BELT ROUTING FA00 & LU8

REF ECR 86448 C/O 14DE79 6Z-2 RL

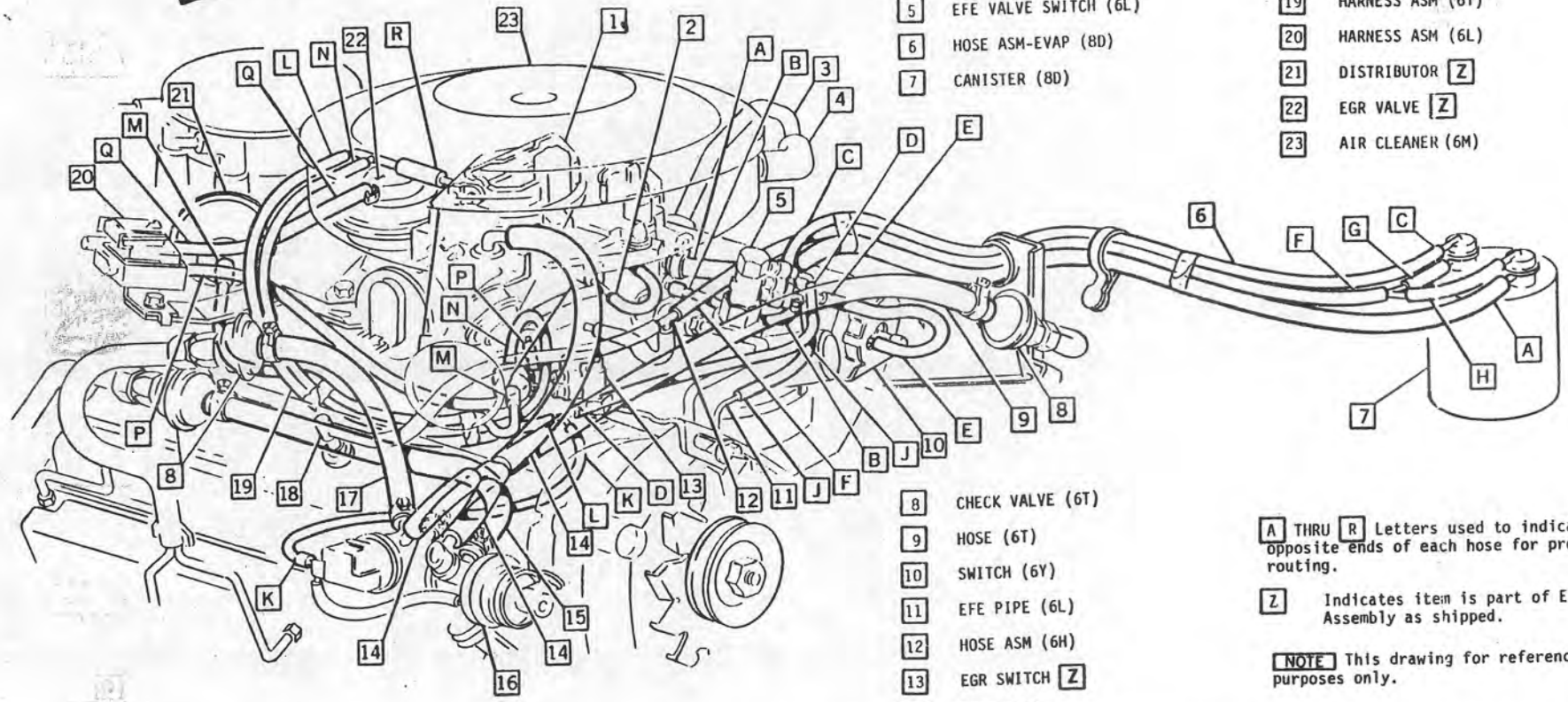
2 1-77562 1- 1- 1-

UPC 6Z

SHEET 6

Ch B O P Co

WAITING LAYOUT APPROVAL



1 CARBURETOR (6M)
2 AIR CLEANER HOSE (6M)
3 PIPE (6H)
4 HOSE (6H)
5 EFE VALVE SWITCH (6L)
6 HOSE ASM-EVAP (8D)
7 CANISTER (8D)
8 CHECK VALVE (6T)
9 HOSE (6T)
10 SWITCH (6Y)
11 EFE PIPE (6L)
12 HOSE ASM (6H)
13 EGR SWITCH Z
14 TUBE (6T)
15 HOSE (6T)
16 A.I.R. CONTROL VALVE (6T)
17 HOSE (6T)
18 PCV VALVE (6M)
19 HARNESS ASM (6Y)
20 HARNESS ASM (6L)
21 DISTRIBUTOR Z
22 EGR VALVE Z
23 AIR CLEANER (6M)

A THRU R Letters used to indicate opposite ends of each hose for proper routing.

Z Indicates item is part of Engine Assembly as shipped.

NOTE This drawing for reference purposes only.

DYNAMIC (Instal) N·m	HAND (Insp.) : N·m
1	
2	
3	
4	
5	

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASH CHG
		339				

DATE 22AU80
DR R. LINDNER
CK Richard Cline RC
APPR NS
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE EMISSION CONTROLS
FA00 &LC3 &M64 &C41

REF ECR 86448
NEW 14AU80

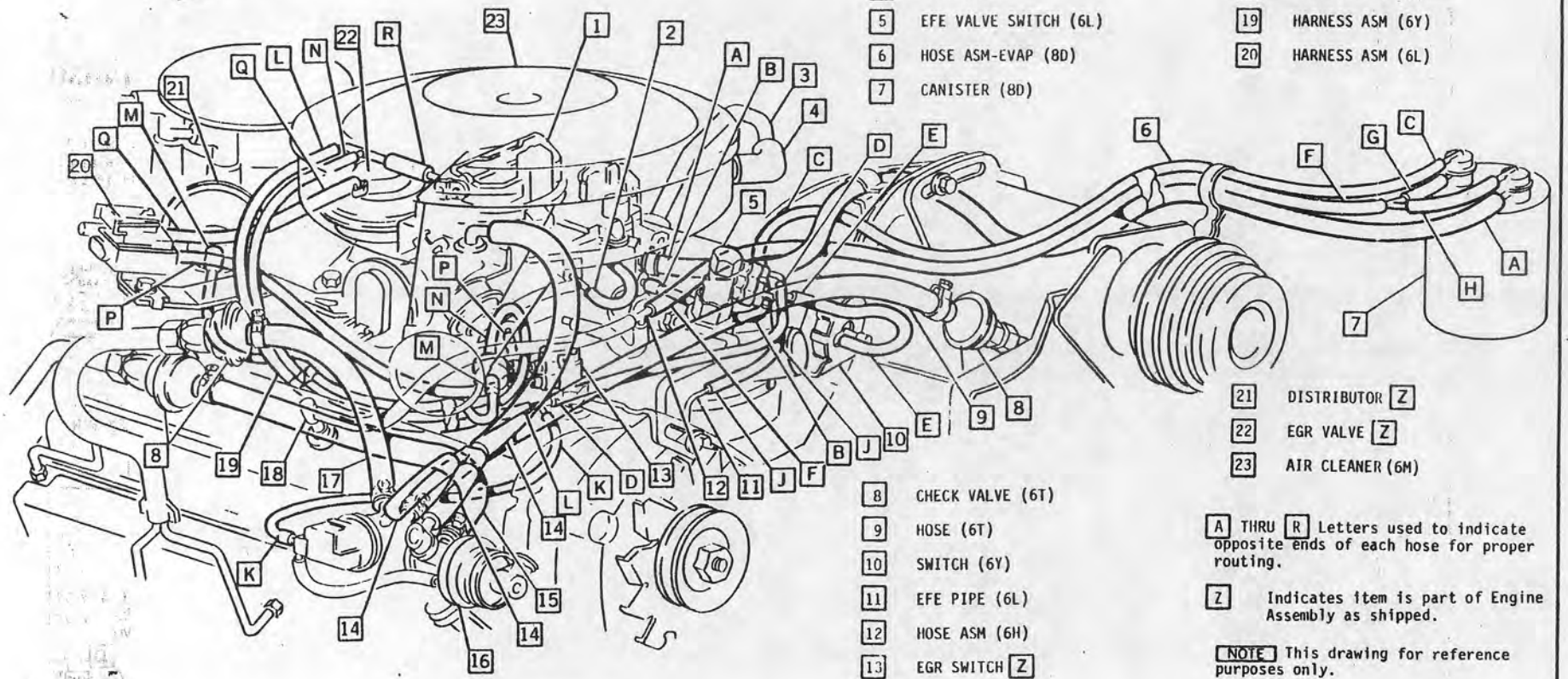
L- (NS)
L-
L-
L-

UPC 67

SHEET 7

K X B O P Co

WAITING LAYOUT APPROVAL



1 CARBURETOR (6M)
2 AIR CLEANER HOSE (6M)
3 PIPE (6H)
4 HOSE (6H)
5 EFE VALVE SWITCH (6L)
6 HOSE ASM-EVAP (8D)
7 CANISTER (8D)
8 CHECK VALVE (6T)
9 HOSE (6T)
10 SWITCH (6Y)
11 EFE PIPE (6L)
12 HOSE ASM (6H)
13 EGR SWITCH Z
14 TUBE (6T)
15 HOSE (6T)
16 A.I.R. CONTROL VALVE (6T)
17 HOSE (6T)
18 PCV VALVE (6H)
19 HARNESS ASM (6Y)
20 HARNESS ASM (6L)
21 DISTRIBUTOR Z
22 EGR VALVE Z
23 AIR CLEANER (6M)

A THRU R Letters used to indicate opposite ends of each hose for proper routing.

Z Indicates item is part of Engine Assembly as shipped.

NOTE This drawing for reference purposes only.

DYNAMIC (Install) N·m	HAND (Insp.) · N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASH CRG
1 2 3 4 5 ⚠ FULLY DRIVEN, SEATED & NOT STRIPPED				340				

DATE 22AU80 | DR R. LINDNER | CK Richard Lee RC | APPR NS | APPR | APPR | APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE EMISSION CONTROLS FA00 &LC3 &M64 &C60

REF ECR 86448 NEW 14AU80

L- (NS) L- L- L-

UPC 6Z

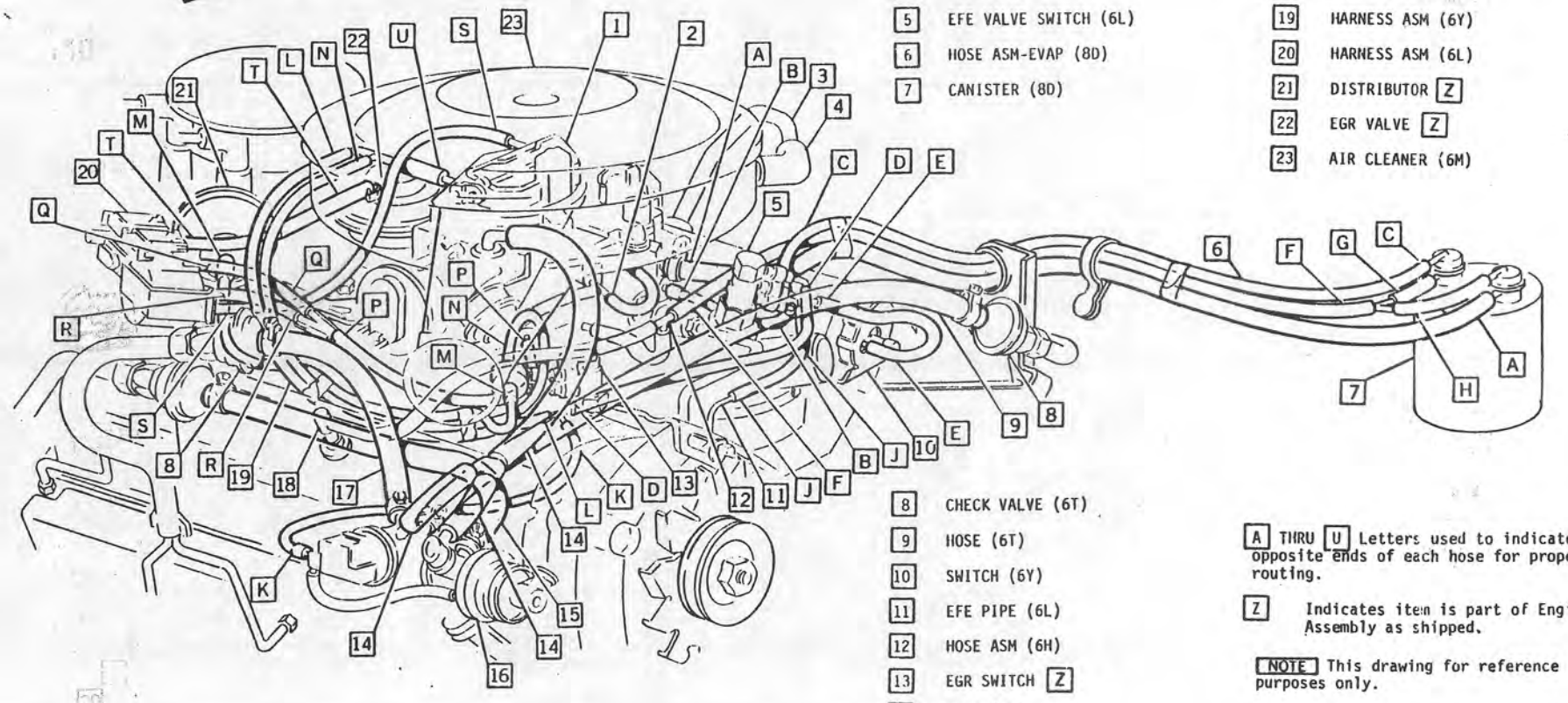
SHEET 8

E ☒ B O P Co

PRODUCT DESCRIPTION MANUAL

☐ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF

WAITING LAYOUT APPROVAL



1 CARBURETOR (6M)
2 AIR CLEANER HOSE (6M)
3 PIPE (6H)
4 HOSE (6H)
5 EFE VALVE SWITCH (6L)
6 HOSE ASM-EVAP (8D)
7 CANISTER (8D)
8 CHECK VALVE (6T)
9 HOSE (6T)
10 SWITCH (6Y)
11 EFE PIPE (6L)
12 HOSE ASM (6H)
13 EGR SWITCH Z
14 TUBE (6T)
15 HOSE (6T)
16 A.I.R. CONTROL VALVE (6T)
17 HOSE (6T)
18 PCV VALVE (6H)
19 HARNESS ASM (6Y)
20 HARNESS ASM (6L)
21 DISTRIBUTOR Z
22 EGR VALVE Z
23 AIR CLEANER (6M)

A THRU U Letters used to indicate opposite ends of each hose for proper routing.

Z Indicates item is part of Engine Assembly as shipped.

NOTE This drawing for reference purposes only.

DYNAMIC (Instal) N·m	HAND (Insp.) - N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
1 2 3 4 5	⚠ FULLY DRIVEN, SEATED & NOT STRIPPED							

DATE 22AU80
DR R. LINDNER
CK Richard Lindner
APPR NS
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
EMISSION CONTROLS
FA00 &LC3 &MV9 or M31 &C41

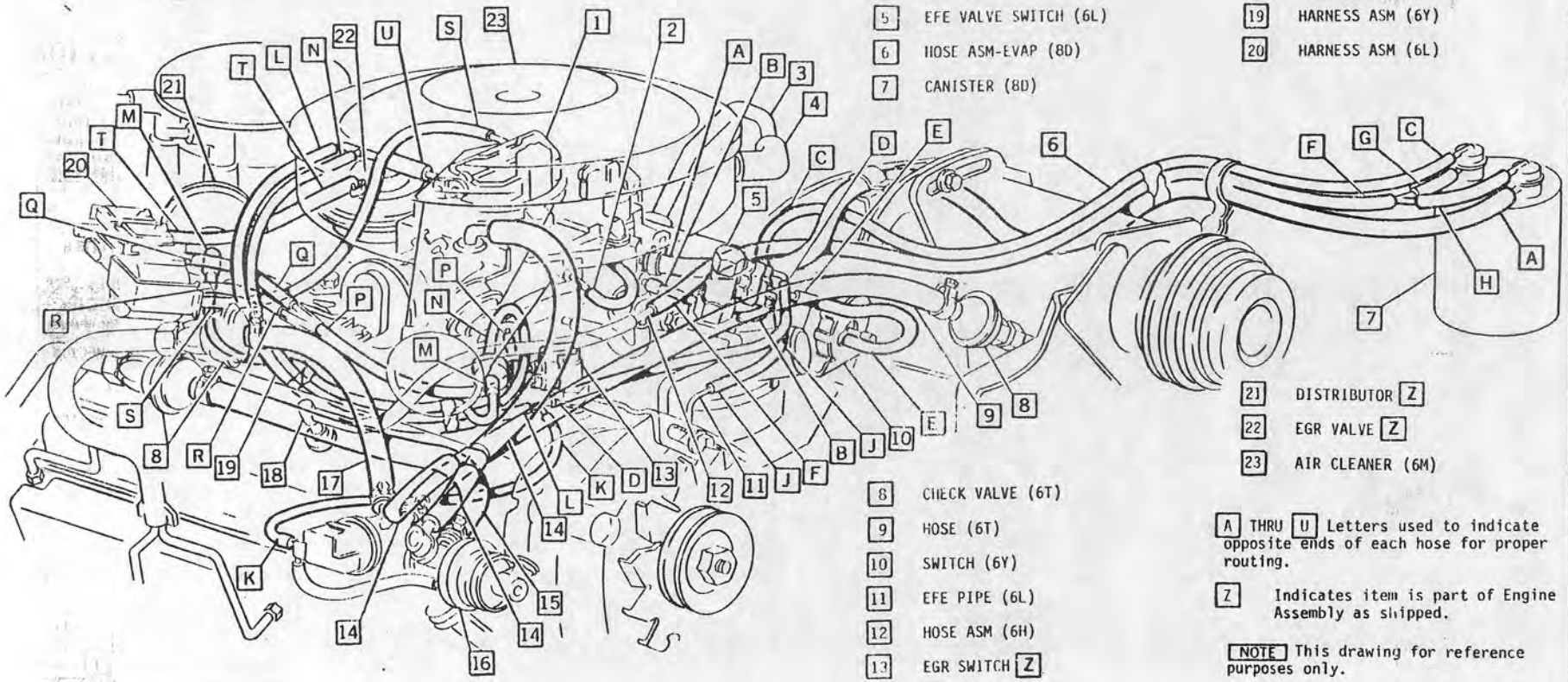
REF ECR 86448
NEW 13AU80

(NS)

UPC 6Z

SHEET 9

WAITING LAYOUT APPROVAL



1 CARBURETOR (6M)
2 AIR CLEANER HOSE (6M)
3 PIPE (6H)
4 HOSE (6H)
5 EFE VALVE SWITCH (6L)
6 HOSE ASM-EVAP (8D)
7 CANISTER (8D)
8 CHECK VALVE (6T)
9 HOSE (6T)
10 SWITCH (6Y)
11 EFE PIPE (6L)
12 HOSE ASM (6H)
13 EGR SWITCH Z
14 TUBE (6T)
15 HOSE (6T)
16 A.I.R. CONTROL VALVE (6T)
17 HOSE (6T)
18 PCV VALVE (6H)
19 HARNESS ASM (6Y)
20 HARNESS ASM (6L)
21 DISTRIBUTOR Z
22 EGR VALVE Z
23 AIR CLEANER (6M)

A THRU U Letters used to indicate opposite ends of each hose for proper routing.

Z Indicates item is part of Engine Assembly as shipped.

NOTE This drawing for reference purposes only.

DYNAMIC (Instal) N·m	HAND (Insp.) N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
1 2 3 4 5				342				

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	22AUG0
DR	R. LINDNER
CK	Richard Lee Jr
APPR	NS
APPR	
APPR	
APPR	

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE
EMISSION CONTROLS
FA00 &LC3 &MV9 or M31 &C60

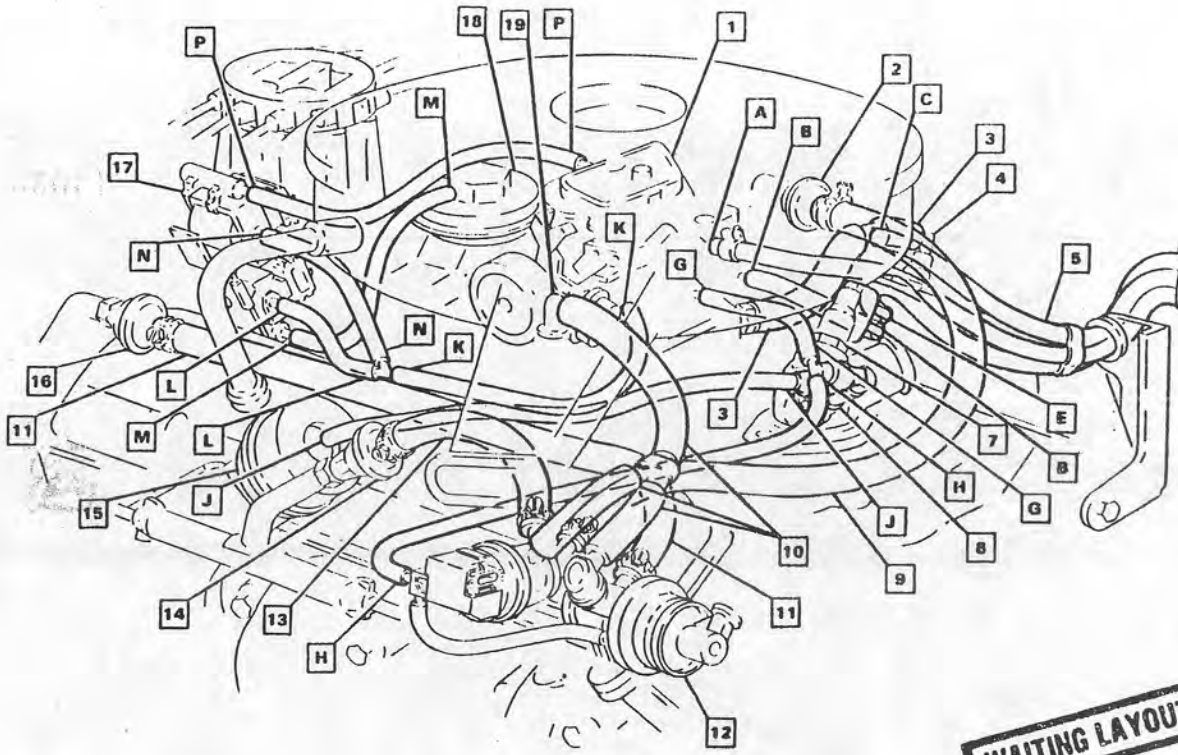
REF ECR 86448
NEW 13AU80

L- (NS)
L-
L-
L-

UPC 67

SHEET 10

E X B O P Ca



WAITING LAYOUT APPROVAL

1 CARB (6M)
2 CHECK VALVE (6T)
3 HOSE (6H)
4 PCV VALVE (6H)
5 HOSE ASM-EVAP (8D)
6 CANISTER (8D)
7 SWITCH Z
8 SWITCH Z
9 HOSE LH (6T)
10 TUBE (6T)
11 HOSE (6T)
12 A.I.R. CONT SWITCH VALVE (6T)
13 HOSE RH (6T)
14 CHECK VALVE (6T)
15 EFE ACTUATOR (6L)
16 CHECK VALVE (6T)
17 HARN ASM (6L)
18 EGR VALVE Z
19 AIR CLEANER (6M)

A THRU P Letters used to indicate opposite ends of each hose for proper routing.

Z Indicates item is part of Engine Assembly as shipped.

NOTE This drawing for reference purposes only.

DYNAMIC (Instal) N·m | HAND (Insp.) · N·m

1 2 3 4 5

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
		343				

DATE 25JL80
DR P KOCH
CK H.J. Bunch HB
APPR NC
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE EMISSION CONTROLS FA00 &L39 &MV4 &NB1

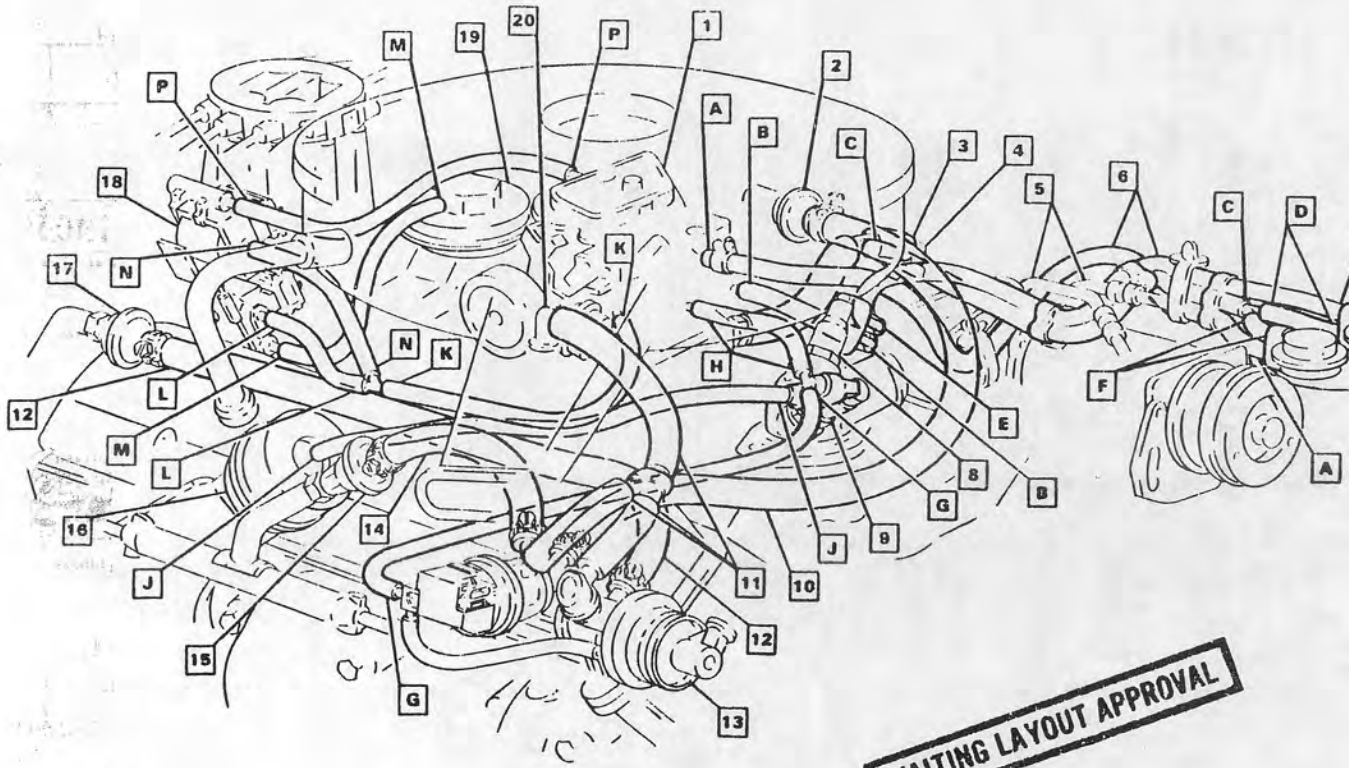
REF ECR 86448 NEW 10JL80

L-(NS) L- L- L-

UPC 6Z

SHEET 11

C ☒ I ☐ O ☐ P ☒ Ca ☐



1 CARB (6M)
2 CHECK VALVE (6T)
3 HOSE (6H)
4 PCV VALVE (6H)
5 FITTING ASM (1A2K)
6 HOSE ASM-EVAP (8D)
7 CANISTER (8D)
8 SWITCH Z
9 SWITCH Z
10 HOSE LH (6T)
11 TUBE ASM (6T)
12 HOSE (6T)
13 A.I.R. CONT SWITCH VALVE (6T)
14 HOSE RH (6T)
15 CHECK VALVE (6T)
16 EFE ACTUATOR (6L)
17 CHECK VALVE (6T)
18 HARN ASM (6L)
19 EGR VALVE Z
20 AIR CLEANER (6M)

WAITING LAYOUT APPROVAL

A THRU P Letters used to indicate opposite ends of each hose for proper routing.

Z Indicates item is part of Engine Assembly as shipped.

NOTE This drawing for reference purposes only.

DYNAMIC (Install) N·m	HAND (Insp.) - N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASR CHG
1 2 3 4 5 FULLY DRIVEN, SEATED & NOT STRIPPED				344				

DATE 08AUG0
DR R. KOCH/CU
CK
APPR NS
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE EMISSION CONTROLS FA00 &L39 &MV4 &NB1 &C60

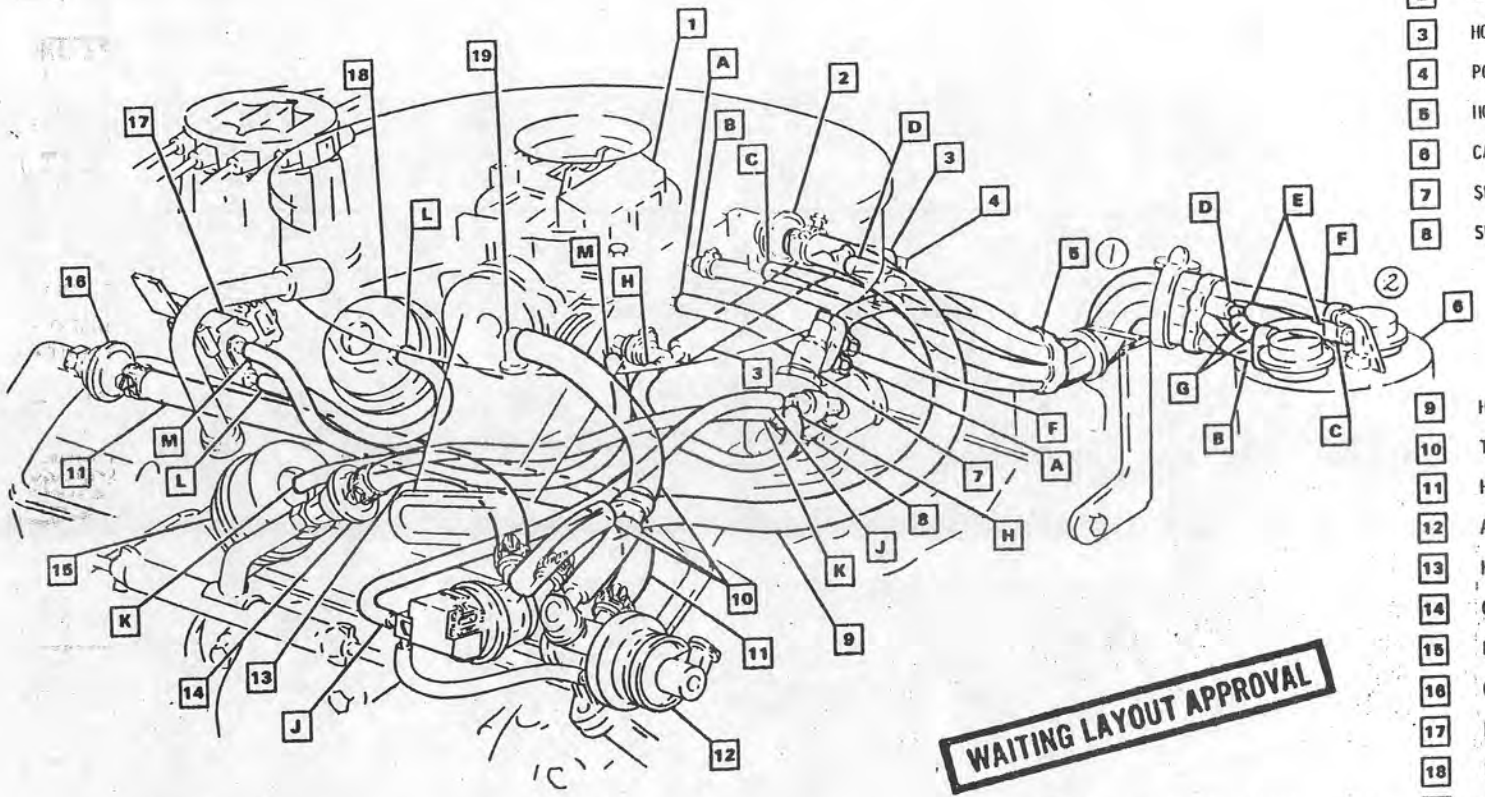
REF ECR 86448 NEW 22JL80

L- (NS)
L-
L-
L-

UPC 6Z

SHEET 12

C ☒ B D P ☒ Ca



1 CARB (6M)
2 CHECK VALVE (6T)
3 HOSE (6H)
4 PCV VALVE (6H)
5 HOSE ASM-EVAP (8D)
6 CANISTER (8D)
7 SWITCH Z
8 SWITCH Z
9 HOSE LH (6T)
10 TUBE (6T)
11 HOSE (6T)
12 A.I.R. CONT SWITCH VALVE (6T)
13 HOSE RH (6T)
14 CHECK VALVE (6T)
15 EFE ACTUATOR (6L)
16 CHECK VALVE (6T)
17 HARN ASM (6L)
18 EGR VALVE Z
19 AIR CLEANER (6M)

WAITING LAYOUT APPROVAL

A THRU M Letters used to indicate opposite ends of each hose for proper routing.

Z Indicates item is part of Engine Assembly as shipped.

NOTE This drawing for reference purposes only.

DYNAMIC (Install) N·m	HAND (Insp.) · N·m
1	
2	
3	
4	
5	

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
26SEP80	1	"80 HOSE ASM" ROUTING REVISED	86448	RK	SH	
	2	"80 CANISTER" DWG REVISED				

345

DATE 25JL80
DR R KOCH
CK HJ Buch 11B
APPR NS
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE EMISSION CONTROLS FA00 &LG4 &M24 &NB1

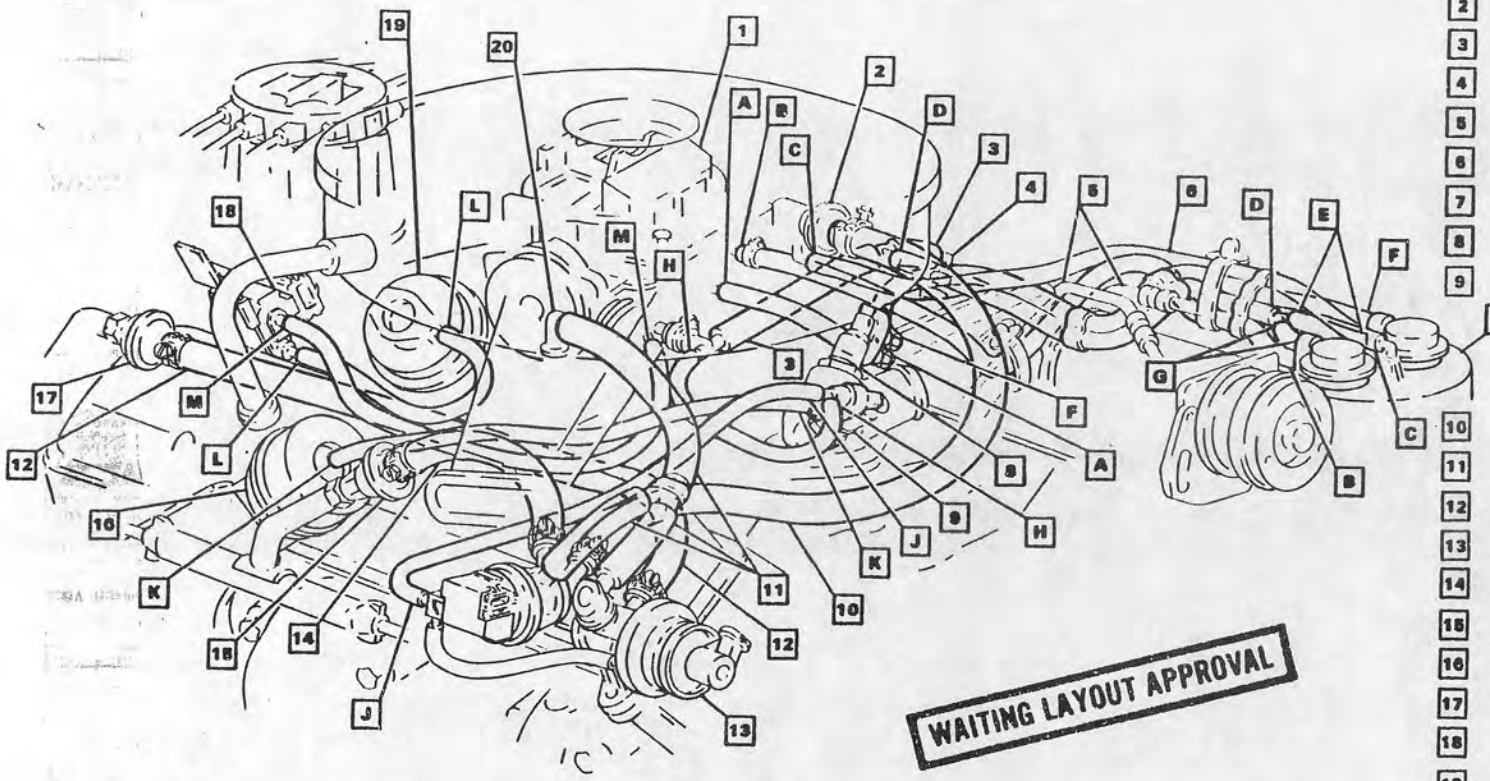
REF ECR 86448 NEW 10JL80

L- (NS)
L-
L-
L-

UPC 6Z

SHEET 13

Ch X B 0 P X Co



1 CARB (6M)
2 CHECK VALVE (6T)
3 HOSE (6H)
4 PCV VALVE (6H)
5 FITTING ASM (1A2K)
6 HOSE ASM-EVAP (8D)
7 CANISTER (8D)
8 SWITCH Z
9 SWITCH Z
10 HOSE LH (6T)
11 TUBE ASM (6T)
12 HOSE (6T)
13 A.I.R. CONT SWITCH VALVE (6T)
14 HOSE RH (6T)
15 CHECK VALVE (6T)
16 EFE ACTUATOR (6L)
17 CHECK VALVE (6T)
18 HARN ASM (6L)
19 EGR VALVE Z
20 AIR CLEANER (6M)

A THRU M Letters used to indicate opposite ends of each hose for proper routing.

Z Indicates item is part of Engine Assembly as shipped.

NOTE This drawing for reference purposes only.

DYNAMIC (Install) N·m	HAND (Insp.) N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
				346				

1 2 3 4 5
⚠ FULLY DRIVEN, SEATED & HOT STRIPPED

Ch X B D F X Ca

DATE 08AUG0
DR R. KOCH/CU
CK
APPR NS
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

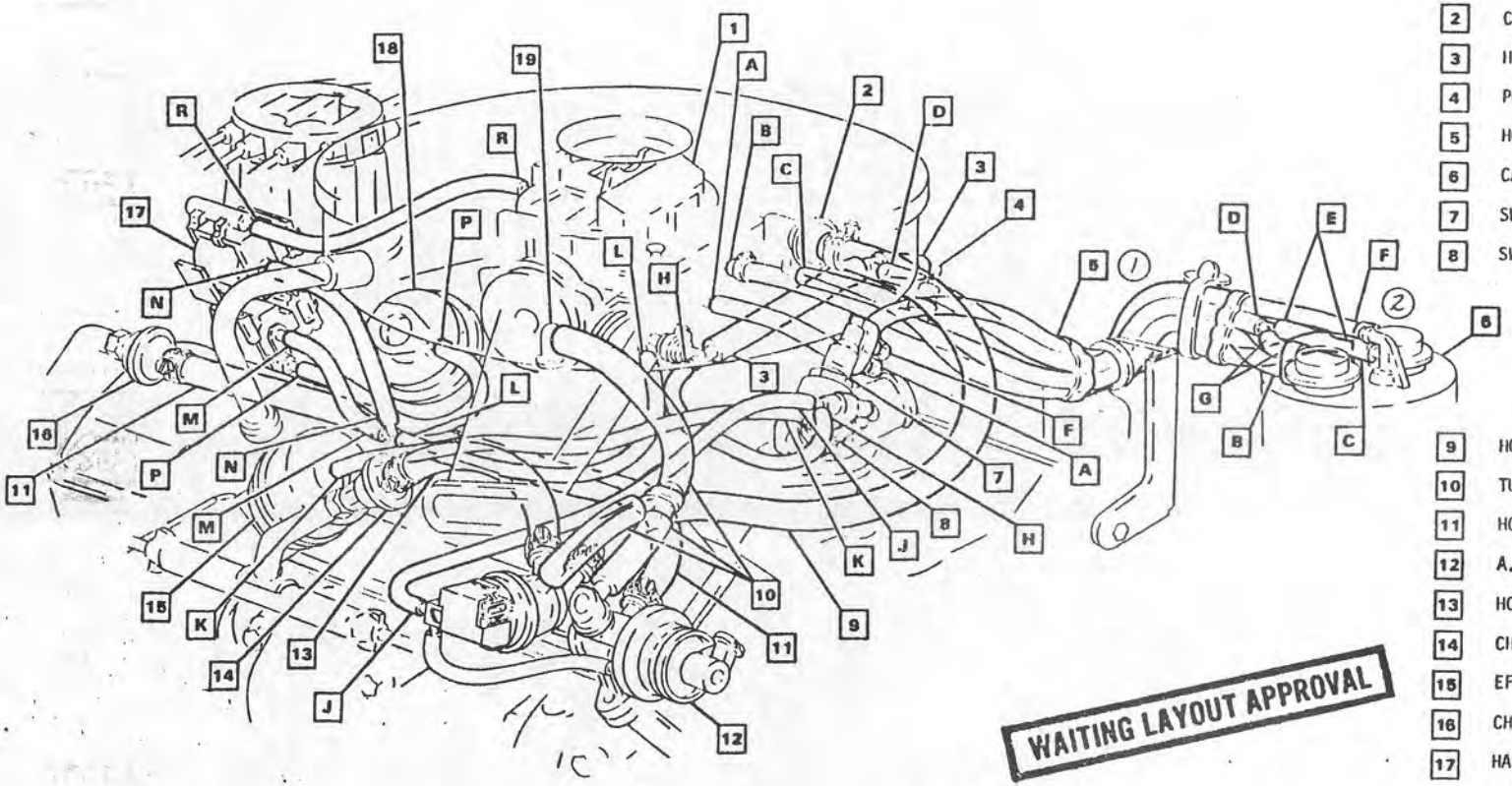
TITLE EMISSION CONTROLS
FA00 &LG4 &M24 &NB1 &C30

REF ECR 86448
NEW 22JL80

L- (NS)
L-
L-
L-

UPC 6Z

SHEET 14



1 CARB (6M)
2 CHECK VALVE (6T)
3 HOSE (6H)
4 PCV VALVE (6H)
5 HOSE ASM-EVAP (8D)
6 CANISTER (8D)
7 SWITCH Z
8 SWITCH Z
9 HOSE LH (6T)
10 TUBE (6T)
11 HOSE (6T)
12 A.I.R. CONT SWITCH VALVE (6T)
13 HOSE RH (6T)
14 CHECK VALVE (6T)
15 EFE ACTUATOR (6L)
16 CHECK VALVE (6T)
17 HARN ASM (6L)
18 EGR VALVE Z
19 AIR CLEANER (6M)

WAITING LAYOUT APPROVAL

A THRU R Letters used to indicate opposite ends of each hose for proper routing.

Z Indicates item is part of Engine Assembly as shipped.

NOTE This drawing for reference purposes only.

DYNAMIC (Install) N·m	HAND (Insp.) - N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
		26SEP80	1	"80 HOSE ASM" ROUTING REVISED				
			2	"80 CANISTER" ONG REVISED	B5948	Ex	SDA	

1 2 3 4 5 ⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

347

DATE 25JL80
DR R KOCH
CK NJBuck HR
APPR NS
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020067

TITLE EMISSION CONTROLS FA00 &LG4 &MV4 &NB1

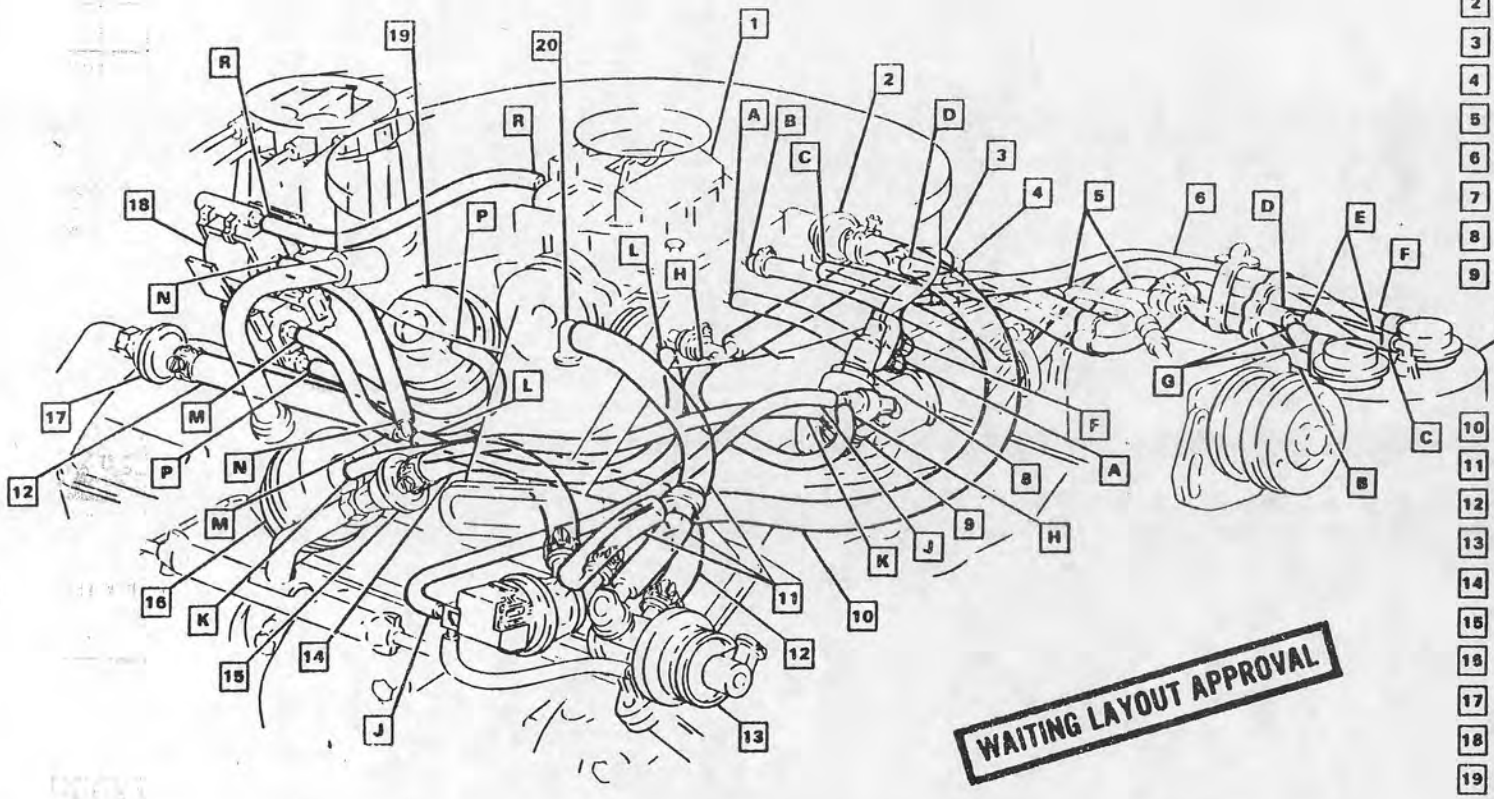
REF ECR 86448 NEW 10JL80

L- (NS) L- L- L-

UPC 6Z

SHEET 15

Ch X 8 0 ? X Ca



1 CARB (6M)
2 CHECK VALVE (6T)
3 HOSE (6H)
4 PCV VALVE (6H)
5 FITTING ASM (1A2K)
6 HOSE ASM-EVAP. (8D)
7 CANISTER (ED)
8 SWITCH Z
9 SWITCH Z
10 HOSE LH (6T)
11 TUBE ASM (6T)
12 HOSE (6T)
13 A.I.R. CONT SWITCH VALVE (6T)
14 HOSE RH (6T)
15 CHECK VALVE (6T)
16 EFE ACTUATOR (6L)
17 CHECK VALVE (6T)
18 HARN ASM (6L)
19 EGR VALVE Z
20 AIR CLEANER (6M)

A THRU R Letters used to indicate opposite ends of each hose for proper routing.

Z Indicates item is part of Engine Assembly as shipped.

NOTE This drawing for reference purposes only.

DYNAMIC (Instal) N·m	HAND (Insp.) - N·m	DATE	SYM	REVISION	AUTH	DR	CK	ASM CHG
1 2 3 4 5								
⚠ FULLY DRIVEN, SEATED & NOT STRIPPED				348				

DATE 08AUG0
DR R. KOCH/CU
CK
APPR NS
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE EMISSION CONTROLS
FA00 &LG4 &MV4 &NB1 &C60

REF ECR 86448
NEW 23JL80

(NS)

UPC 6Z

SHEET 16

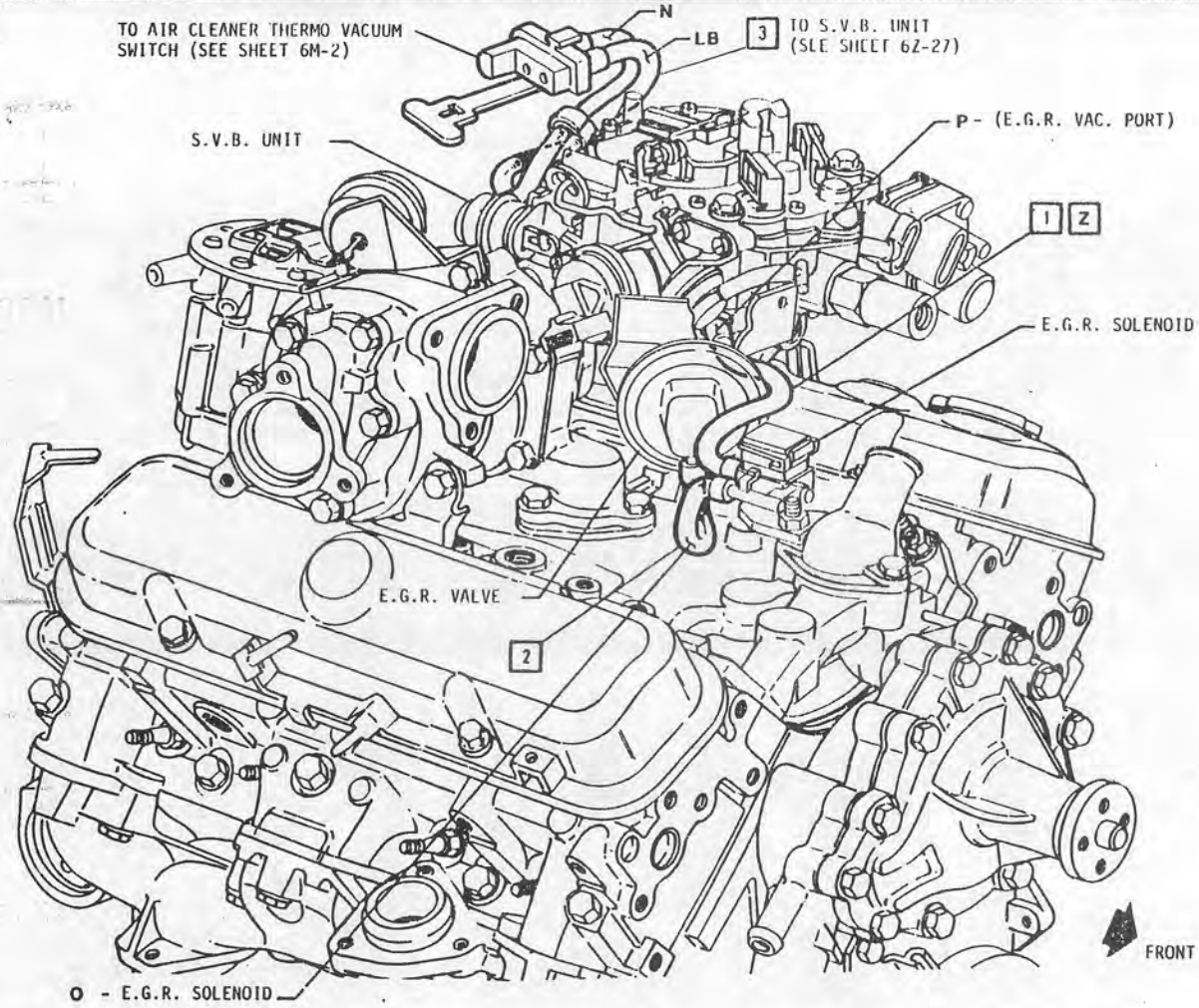
Ck | B | D | P | Ca

PONTIAC MOTOR DIVISION

General Motors Corporation Pontiac, Michigan

PRODUCT DESCRIPTION MANUAL

□ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF



1 6L3 - HOSE
2 6L3 - HOSE — (E.G.R.)
3 6L3 - HARNESS (S.V.B.) — UPL

HOSE STRIPE IDENTIFICATION

N - NONE
LB - LIGHT BROWN
O - ORANGE
P - PURPLE

Z ROUTE HOSE UNDER CHOKE SHIELD TO E.G.R. VAC. PORT ON CARB.

CANCELED

CAUTION - THIS SHEET IS FOR REFERENCE ONLY

DYNAMIC (Instal) N.m	HAND (Insp.) - N.m
1	
2	
3	
4	
5	

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
11AP80		ISSUED	86448	CU	RC	
07NO80	1	SHEET CANCELED	91222	CU	EJ	

349

DATE 05 MR 80
DR E.D.BOTIWELL
CK JEB
APPR JZW
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE EMISSION HOSES (FRONT VIEW) FA00 & LU8

REF ECR 86448 NEW 21MR80 6Z-26 RK

UPC 6Z

SHEET 17

Ch X B O P X Ca

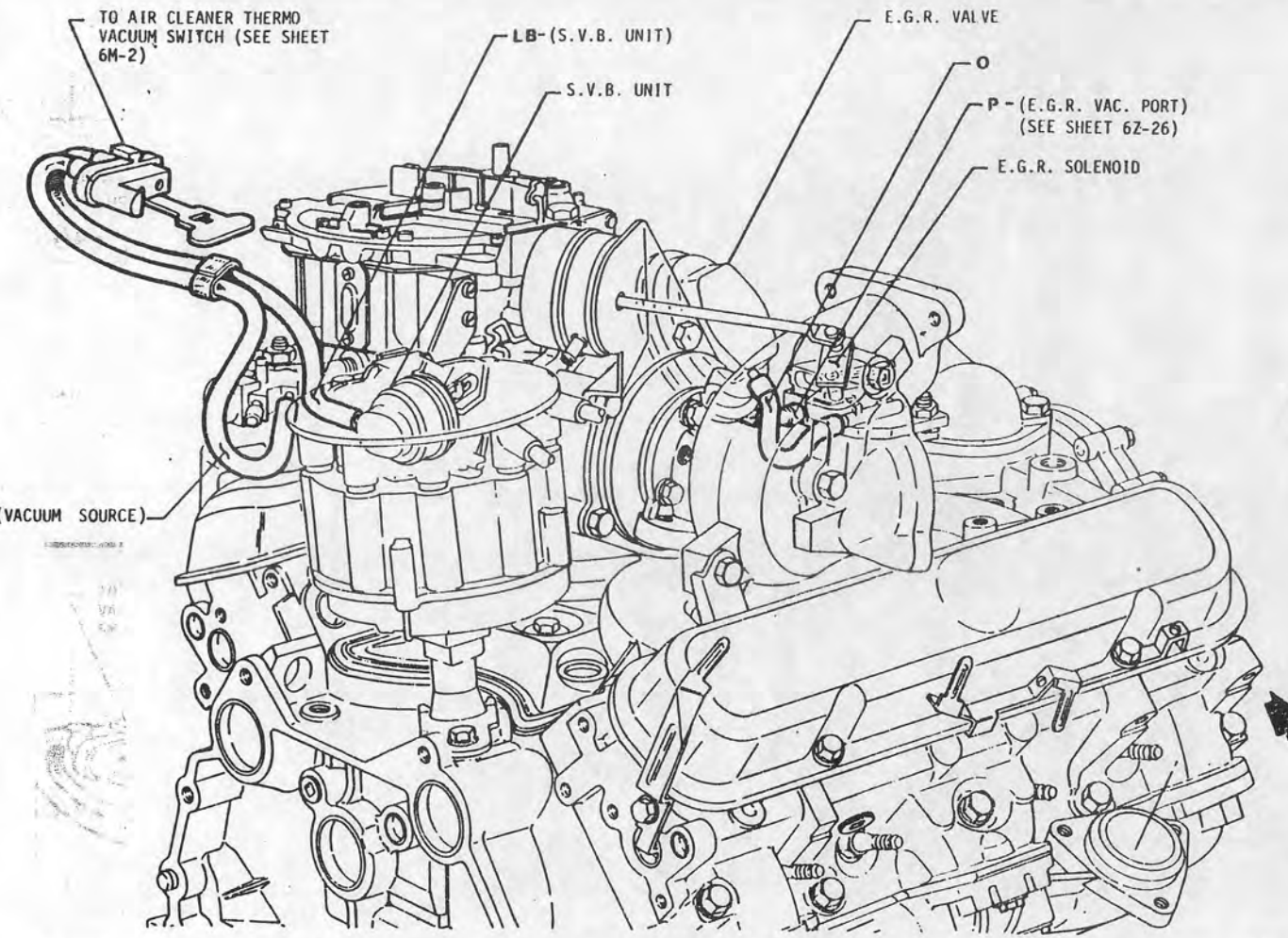
EaE- 4330

PONTIAC MOTOR DIVISION

General Motors Corporation Pontiac, Michigan

PRODUCT DESCRIPTION MANUAL

□ ITEM REFERENCE ◇ PROCESS MATERIAL △ TORQUE ◪ EXISTING AS PART OF



HOSE STRIPE IDENTIFICATION

N - NONE
LB - LIGHT BROWN
O - ORANGE
P - PURPLE

CANCELED

CAUTION THIS SHEET IS FOR REFERENCE ONLY

DYNAMIC (Install) N.m	HAND (Insp.) - N.m
①	
②	
③	
④	
⑤	

⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
11APR80		ISSUED	86448	CU	RC	
11MAR80	1	SHEET CANCELED	9222	CU	EF	

DATE 05 MR 80
DR E.D. BOTHWELL
CK JEB
APPR JZW
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE EMISSION HOSES (REAR VIEW) FA00 & LU8

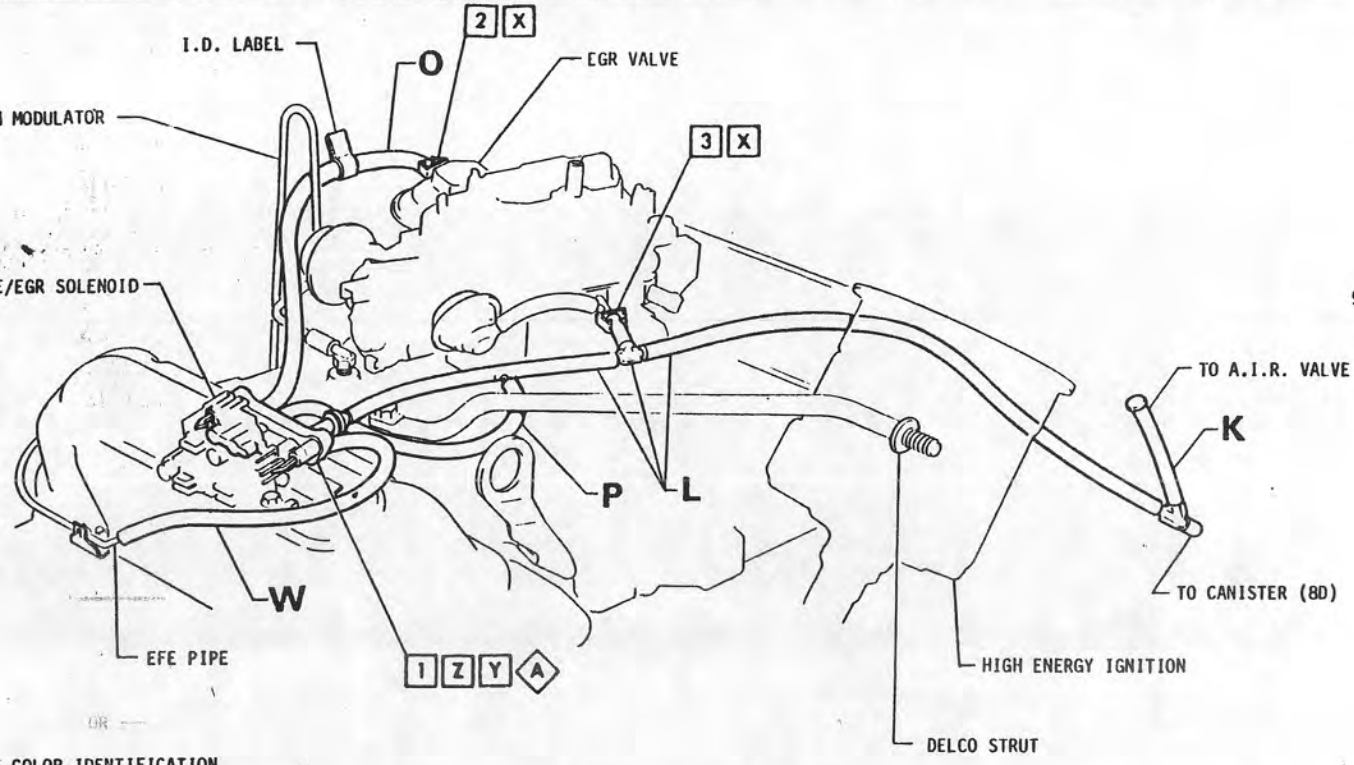
REF ECR 86448 NEW 21MR80 6Z-27 RK

GR 6Z

SHEET 18

Cs X B O P X Ca

350



UPL 1 HARNESS ASM - EFE/EGR (WHITE)

UPL 2 CLIP

UPL 3 CLIP

9985406 ◇A LUBRICANT - APPLY TO HARNESS ENDS AS NECESSARY.

HOSE COLOR IDENTIFICATION

O - ORANGE STRIPE
P - PURPLE STRIPE
L - YELLOW STRIPE
W - WHITE STRIPE
K - PINK STRIPE

X HOSE TO CLIP INSTALLATION MUST NOT EXCEED 5.0 FROM FULL ENGAGEMENT.

Y REMOVE & DISCARD SHIPPING PLUGS PRIOR TO INSTALLATION.

Z MOLDED CONNECTOR SHOULD BE FULLY SEATED WITH RETENTION CLIPS ENGAGED IN SOLENOID.

NOTE: ALL PARTS SHOWN ON THIS SHEET ARE INSTALLED IN THE ENGINE PLANT.

DYNAMIC(Instal)N.m	HAND (Insp.) - N.m	DATE	SYM	REVISION	AUTH	DR	CK	ASM ENG
		07NOV80		ISSUED	86448	CW	EF	

1 2 3 4 5 ⚠ FULLY DRIVEN, SEATED & NOT STRIPPED

351

DATE 25JL80 CA
DR B. RAYMOND
CK
APPR
APPR
APPR
APPR

DIV CHEVROLET

1981 CHEV. "F" 14020867

TITLE EMISSION HOSES F/A00 &LD5 &NB1

REF ECR 86448
NEW 300C80
6Z-10.2 RL

UFC 6Z

SHEET 19

Ch V O P Co

BUICK FORM 7160