



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 built of vehicle. Refer to the Parts List for complete specifications on models, options, names, quantities and other conditions or restrictions. The word "ILL" 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 L/R and R/L 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 simple 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).

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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 & SPI ITEMS)

D-11		SIM	REVISION		02	DATE	1/7/78	DIV	CHEVROLET	1981 CHEV. "F" 14020867		
				BY: A. J. KENNY				FORD ALL				
				APR				HIDROCLER-HRHX-CORPUS				
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PRODUCT DESCRIPTION MANUAL
 PROCESS MATERIAL TORQUE EXISTING AS PART OF

General Motors Corporation
CHEVROLET MOTOR DIVISION

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 left 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.

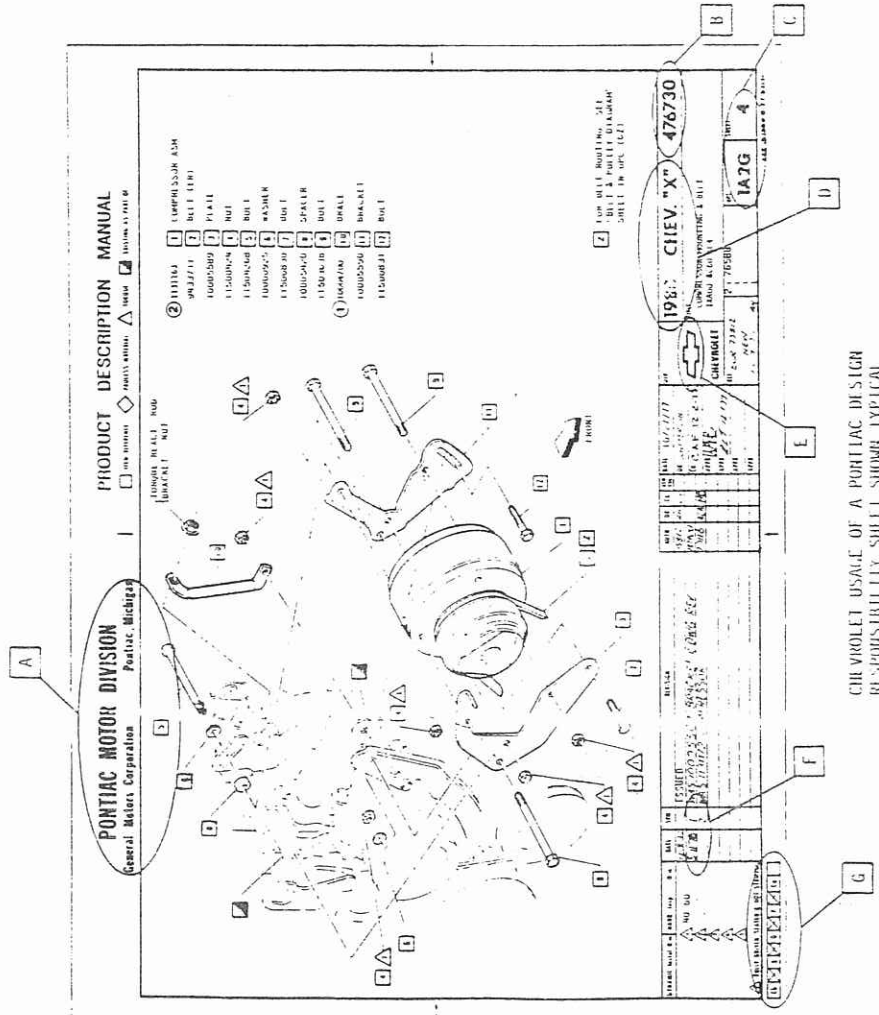
C Numeric/alpha filing system based on the Uniform Parts Classification (UPC) and similar to the Production Part List.

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.



DATE	BY	REVISION	SYM	DATE	BY	REVISION	SYM
03/27/80	L. MORENCY						

DATE	BY	REVISION	SYM	DATE	BY	REVISION	SYM
03/27/80	L. MORENCY						

DATE	BY	REVISION	SYM	DATE	BY	REVISION	SYM
03/27/80	L. MORENCY						

DATE	BY	REVISION	SYM	DATE	BY	REVISION	SYM
03/27/80	L. MORENCY						



General Motors Corporation
CHEVROLET MOTOR DIVISION

PRODUCT DESCRIPTION MANUAL

ITEM REFERENCE PROCESS MATERIAL TORQUE EXISTING AS PART OF

O CHARTS, INSTRUCTION DRAWINGS & GENERAL INFORMATION

1 BODY

- 1A1 PASS CAR BODIES / AS PURCH
- 1A2 FLOOR & STILL
- 1A2B I/P PARTS
- 1A2C BODY VERT & DEFROSTING
- 1A2D WSW & WASHER
- 1A2E MISCELLANEOUS PARTS
- 1A2F EXT BODY ORNAMENTATION
- 1A2G A/C COMPRESSOR
- 1A2H HEATER & A/C AIR SYSTEM
- 1A2J HEATER & A/C COIL/ROLS
- 1A2K A/C REFRIGERANT SYSTEM
- 1A2L HEATER WATER SYSTEM
- 1B BODY MOUNTING
- 1Z MISCELLANEOUS INFORMATION

2 FRAME

- 2B FRAME
- 2C DYNAMIC DAMPENER
- 2Z MISCELLANEOUS INFORMATION

3 FRONT SUSPENSION

- 3A FRONT SUSP ASM
- 3C FRONT SPRINGS
- 3F FRONT SHOCK ASSEMBLERS
- 3G FRONT STABILIZER
- 3Z MISCELLANEOUS INFORMATION

4 REAR AXLE & REAR SUSPENSION

- 4A REAR AXLE & SUSP ASM
- 4B RR AXLE ASH & PRIP SHIP
- 4D REAR SPRINGS
- 4E SPRING INSTL PARTS
- 4F SHOCK ASSEMBLERS
- 4Z REAR STABILIZER
- 4Z MISCELLANEOUS INFORMATION

5 BRAKES

- 5A FRONT BRAKES
- 5C BRK PEDAL & MASTER CYL CORR
- 5D PARKING BRAKE
- 5E HYD MASTER CYL INDR
- 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 COR & MANIF
- 6M ENGINE FUEL SYSTEM
- 6N THROTTLE CONTROL
- 6O 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 REACTION CONT SYS
- 8Z MISCELLANEOUS INFORMATION

9 STEERING MECHANISM

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

10 WHEELS & TIRES

- 10B WHEELS & TIRES
- 10L 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 HO. & IDENT PLATES
- 14G SHIPG PROTECTIVE ITEMS
- 14Z MISCELLANEOUS INFORMATION

15 MISC PAINT & WATER TEST

- 15D MISCELLANEOUS PAINT
- 15F WATER TEST

DATE	SYN	REVISION	AUTH	DE	REV	DATE	BY	INDEX	TITLE	
1981 CHEVROLET "A" 14020865*						03	CHEVROLET	1981 ALL PASS* (exc "Y")		
1981 CHEVROLET "B" 14020866										
1981 CHEVROLET "F" 14020867										
1981 CHEVROLET "H" 14020868										
1981 CHEVROLET "I" 14020869										
1981 CHEVROLET "X" 14020871										
DIV CHEVROLET ALL FCR 36448 C/O 198079 INDEX-2 UICR 36448 C/O 198079 INDEX-2							UNIFORM PARTS CLASSIFICATION ALL PASSING (exc "Y") (0 Thru 15)			
							UPC	1100 X	SHEET	3

14020865



General Motors Corporation
CHEVROLET MOTOR DIVISION

PRODUCT DESCRIPTION MANUAL
 ITEM REFERENCE PROCESS MATERIAL TORQUE EXISTING AS PART OF

1 BODY

AN6 EQUIPMENT-Seat Back Adjustable	<input type="checkbox"/> Y <input type="checkbox"/> Z
AU3 LOCK-Side Door (Electric)	<input type="checkbox"/> Y <input type="checkbox"/> Z
AV9 SEAT REQUIREMENTS-Export	<input type="checkbox"/> Y <input type="checkbox"/> Z
A01 GLASS-Body-Tinted	<input type="checkbox"/> Y <input type="checkbox"/> Z
A02 GLASS-Windshield-Tinted	<input type="checkbox"/> Y <input type="checkbox"/> Z
A31 WINDOW-Electrical	<input type="checkbox"/> Y <input type="checkbox"/> Z
A51 SEAT-Special Contour-Bucket	<input type="checkbox"/> Y <input type="checkbox"/> Z

B51 BODY INSULATION	<input type="checkbox"/> Y <input type="checkbox"/> Z
B18 ORNAMENTATION-Interior-Deluxe	<input type="checkbox"/> Y <input type="checkbox"/> Z
B37 MATS-Floor (Front & Rear)	<input type="checkbox"/> Y <input type="checkbox"/> Z
B77 ORNAMENTATION-Reveal Holding	<input type="checkbox"/> Y <input type="checkbox"/> Z
B80 MOLDING-Roof Drip	<input type="checkbox"/> Y <input type="checkbox"/> Z
B81 ORNAMENTATION-Body Side (Letete)	<input type="checkbox"/> Y <input type="checkbox"/> Z
B84 MOLDING-Body Side	<input type="checkbox"/> Y <input type="checkbox"/> Z
B85 MOLDING-Belt Reveal	<input type="checkbox"/> Y <input type="checkbox"/> Z
B89 ORNAMENTATION-Reveal Holding	<input type="checkbox"/> Y <input type="checkbox"/> Z
B93 GUARDS-Door Edge	<input type="checkbox"/> Y <input type="checkbox"/> Z
B94 ORNAMENTATION-Body Emblem	<input type="checkbox"/> Y <input type="checkbox"/> Z
B97 ORNAMENTATION-Spoiler	<input type="checkbox"/> Y <input type="checkbox"/> Z

CC1 ROOF-Removable Hatch	<input type="checkbox"/> Z
CD4 WASHER & WIPER-Pulse Windshield	<input type="checkbox"/> Z
C41 HEATER-Standard	<input type="checkbox"/> Z
C49 DEFOGGER-Rear Window-Electric	<input type="checkbox"/> Y <input type="checkbox"/> Z
C60 AIR CONDITIONING-All Weather	<input type="checkbox"/> Y <input type="checkbox"/> Z
D28 MIRRORS-Outside Rear View-Delete (Export)	<input type="checkbox"/> Y <input type="checkbox"/> Z
D35 MIRROR-Outside-Rear View-Custom	<input type="checkbox"/> Y <input type="checkbox"/> Z
D80 EXTENSION-Rear Compartment Lid	<input type="checkbox"/> Y <input type="checkbox"/> Z
D88 STRIPE-Sport	<input type="checkbox"/> Y <input type="checkbox"/> Z
D92 TAPE-Door Handle Decor	<input type="checkbox"/> Y <input type="checkbox"/> Z
D98 STRIPE-Rally	<input type="checkbox"/> Y <input type="checkbox"/> Z

2 FRAME

Y Non-Illustrated Option
 Z Fisher Body

3 FRONT SUSPENSION

F41 SUSPENSION-Special Performance-Front & Rear

6AE thru 6HF	SPRING-Front LH
7AE thru 7HF	SPRING-Front RH

4 REAR AXLE & REAR SUSPENSION

G86	AXLE-Rear (2.56 Ratio)
G92	AXLE-Rear (2.73 Ratio)
G94	AXLE-Rear (3.08 Ratio)
G95	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

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

DYNAMIC (Inst'd) K-m		WASH	DATE	SYN	REVISION	DATE	REV	DATE	REV	DATE	REV	DATE	REV
△	△	△	△	△	OPT D28 ADDED	1	17588	1	17588	1	17588	1	17588
△	△	△	△	△	OPT J61 ADDED	2	24080	2	24080	2	24080	2	24080
△	△	△	△	△	OPT D35 REMOVED	3	17596	3	17596	3	17596	3	17596
△	△	△	△	△									
FULLY DRIVEN, SEALED & HOT STRIPPED													
C	6	B	0	P	C	04			1981 CHEV. "F" 4020867				
TITLE CHEVROLET										OPTION-UNIFORM PARTS CLASSIFICATION FA00 ALL (1 Thru 5)		INDEX 4	
DIV MONTREAL										BUICK 86440 C/O 198079		INDEX-3	



ITEM REFERENCE PROCESS MATERIAL TORQUE EXISTING AS PART OF

6 ENGINE

- K05 HEATER-Engine Block
- ① K35 CONTROL-Cruise-Resume Speed
- K77 GENERATOR-AC (55 Amp)

- L33 V6 ENGINE "229" CID 2 (B) Carb-3.8 liter
- L35 V6 ENGINE "231" CID 2 (B) Carb-3.8 liter
- L36 V8 ENGINE "305" CID 4 (B) Carb-5.0 liter
- L44 V8 ENGINE "350" CID 4 (B) Carb-5.7 liter
- L48 V8 ENGINE "301" CID 4.9 liter-Turbocharged
- L39 V8 ENGINE "267" CID 2 (B) 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

- MA5 EMISSION SYSTEM-Federal
- MA6 EMISSION CONTROL-High Altitude
- MB1 EMISSION CONTROL-Closed Loop
- MB2 EMISSION CONTROL-Mandatory California
- MM4 EMISSION CONTROL-Non Closed Loop
- MM5 EMISSION SYSTEM-Canada
- MM6 EMISSION CONTROL-Canada Recalibration

9 STEERING MECHANISM

- H13 WHEEL-Steering-Tilt

10 WHEELS & TIRES

- ③ R18 LOCKING PACKAGE-Wire Wheel Covers
- R65 TIRE-Space Saver Spare
- R90 WHEEL-Aluminum

- PT1 WHEEL-14 X 7.00
- P01 COVER-Wheel Trim

QQR thru QKL TIRES

11 CHASSIS SHEET METAL

Non-Illustrated Option

Fisher Body

OPTIONAL (Not on HARD Copy)	REV	DATE	SYM	REVISION	AUTH	DR	CK	CR	DATE	DIV	CLASSIFICATION	INDEX	SHEET
		3/1/80		REVIEWED TO CONTROL SILENCER RINGS	8001				3/1/80	CHEVROLET	OPTION-UNIFORM PARTS CLASSIFICATION FA00 ALL (6 Thru 11)	5	
				OPTIONAL PARTS MUST BE ADDED	90032								
				W/B OPTION MODEL									
											REFECR 86448	INDEX	5
											C/O 198079		
											INDEX-4		



General Motors Corporation
CHEVROLET MOTOR DIVISION

PRODUCT DESCRIPTION MANUAL
 ITEM REFERENCE PROCESS MATERIAL TORQUE EXISTING AS PART OF

12 ELECTRICAL-CHASSIS & BODY

D1A thru D1W GEAR-Speedometer Driven
 E5Z 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
 T90 LAMPS-Rear End-Export
 T93 LAMP ASM-Tail & Stop-Special

U41 BATTERY-Heavy Duty
 U42 RADIO-AM/FM Stereo Pushbutton & Tape Player
 U43 RADIO-AM/FM Stereo-Cassette Tape Player
 U49 RADIO-Suppression Equipment
 U46 RADIO-AM/FM Stereo With CB (40 Channel)
 U47 RADIO PROVISIONS-Monaural
 U48 RADIO PROVISIONS-Stereo
 U05 HORN-Dual
 U14 GAGE-Instrument
 U18 SPEEDOMETER-Export
 U25 LAMP-Luggage Compartment
 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)

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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

- V04 GOVERNMENT ORDERS OF U.S. VEHICLES (EXPORT)
- YF5 EMISSION CERTIFICATION-California
- YK6 SEO IDENTIFICATION
- YR1 SEAT-Front Custom
- Z21 MOLDING-Exterior
- Z28 SPECIAL PERFORMANCE PACKAGE
- Z49 MANDATORY-Canadian Equipment
- Z54 DECOR-Interior-Silent Sound Group
- Z94 CONVERTER-Mandatory Canadian

Y

Z



1981 CHEV. "F" 14020867

DRMATIC (Inch)	IR	IR-M	DATE	SYN	REVISION	REVISED	DATE	BY	CHK	DATE	BY	DIV	CLASSIFICATION	SHEET
△			3/6/79	1	RFO 277 REMOVED	3/6/79						CHEVROLET	OPTION-UNIFORM PARTS FAOD ALL (12 THRU 15 & SPL ITEMS)	6
△			3/12/79	2	APPO 285 REMOVED	3/12/79								
△			3/13/79	3	OPTION V89 ADDED	3/13/79								
△														
△														
△														
△														

FULLY DRAWN, SEATED & HOT STRIPPED

V Non-illustrated Option
 Z Fisher Body

PRODUCT DESCRIPTION MANUAL
 EXISTING AS PART OF

General Motors Corporation
 CHEVROLET MOTOR DIVISION

ITEM REFERENCE PROCESS MATERIAL TORQUE

0A GENERAL INFORMATION

RES	DIV	DESCRIPTION
	D	CONTENTS
	D	MODELS CHART
	D	MODELS & SYMBOLS
	C	ASSEMBLY NOTICES
	C	TORQUE INSTRUCTIONS
	C	STAPLING INSTRUCTIONS
	C	HOSE CLAMPING INSTRUCTIONS
	C	HOSE INSTALLATION INSTRUCTIONS (WITHOUT CLAMPS)
	C	RETAINER INSTRUCTIONS
	C	RETAINER INSTRUCTIONS
	C	RETAINER INSTRUCTIONS
	C	ALUMINUM CORROSION PROTECTION
	C	ADHESIVE BONDED EMBLEMS & SCRIPTS
	C	DECAL APPLICATION PROCEDURE
	C	DECAL APPLICATION PROCEDURE
	C	ADHESIVE MOLDING INSTRUCTION-SOLUTION LACQUER (PLANT APPLIED ADHESIVE)
	C	ADHESIVE MOLDING INSTRUCTION-DISPERSION LACQUER (BUTYL ADHESIVE)
	C	ADHESIVE MOLDING INSTRUCTION-SOLUTION LACQUER (PRE-APPLIED ADHESIVE)
	C	ADHESIVE MOLDING INSTRUCTION-SOLUTION LACQUER (PRE-APPLIED ADHESIVE) WITH PROMOTER
	D	TRIM HEIGHTS

★ Instructions Carryover
 ● Waiting Info.

DATE	SYM	REVISION	ADJN	DE	CK	AM	CK	DATE	DIV	1981 CHEV. "F" 14020867
								OR / /	CHEVROLET	THIS
								DATE	FOR	CONTENTS-GENERAL INFORMATION
								APPR	BY	FAOY-ALL
								APPR	FOR	
								APPR	NEW	
								APPR	12/01/79	
										SHEET
										1



General Motors Corporation
CHEVROLET MOTOR DIVISION

PRODUCT DESCRIPTION MANUAL
 ITEM REFERENCE PROCESS MATERIAL TORQUE EXISTING AS PART OF

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	1UN69	6	GMC Pickup Delivery available as RPO on El Camino
		2 Dr. Coupe	1UN47	6	
		4 Dr. Station Wagon	1UN35	2 Seat*	
		2 Dr. Notchback Coupe	1AT27	6	
A CAR	MALIBU	4 Dr. Sedan	1AT69	6	
		4 Dr. Station Wagon	1AT35	2 Seat	
		2 Dr. Notchback Coupe	1AW27	6	
	MALIBU CLASSIC	4 Dr. Sedan	1AW69	6	
		4 Dr. Station Wagon	1AW35	2 Seat	
		2 Dr. Pickup Delivery	1AW89	3	
A SPEC X CAR (FWD)	EL CAMINO	2 Dr. Sport Coupe	1AZ37	6	
	MONTE CARLO	2 Dr. Hatchback Coupe	1X X00	5	
F CAR	CITATION	4 Dr. Hatchback Sedan	1X X60	5	
		2 Dr. Sport Coupe	1F P87	4	
		2 Dr. Sport Coupe	1F S87	4	
I CAR	CAMARO SPORT COUPE BERLINETTA	2 Dr. Sport Coupe	1T J00	4	"Scouter"
		2 Dr. Hatchback Coupe	1T J00	4	
		2 Dr. Hatchback Coupe	1T J00	4	
Y CAR	CORVETTE	4 Dr. Hatchback Sedan	1Y J00	4	
		2 Dr. Sport Coupe	1Y J07	2	

1981 CHEVROLET "A" 14020865*	DATE	SYM	REVISION	AGN	DR	CC	DATE	DIV	1981 ALL PASSENGER CARS*
1981 CHEVROLET "B" 14020866	1/15/81	1	1/15/81	1/15/81	1/15/81	1/15/81	01 / 10/15/81	CHEVROLET	TITLE
1981 CHEVROLET "C" 14020867	1/15/81	2	1/15/81	1/15/81	1/15/81	1/15/81	1/15/81	CHEVROLET	MODEL CHART
1981 CHEVROLET "T" 14020869									ALL PASSENGER
1981 CHEVROLET "X" 14020871									
1981 CHEVROLET "Y" 14020870									
								REI LCR 86A-18	UFC
								REV 12/01/79	0A
									SHEET 2

C X 0 0 P G

PRODUCT DESCRIPTION MANUAL

EXISTING AS PART OF

General Motors Corporation
CHEVROLET MOTOR DIVISION



ITEM REFERENCE

PROCESS MATERIAL

TORQUE

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

- "A" AA00
- "B" BA00
- "F" FA00
- "J" JA00
- "X" XA00
- "Y" YA00

SYMBOLS

- 1 Indicates cross referencing of part numbers.
- Z Indicates cross referencing of notes.
- △ 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.

DATE	YR	REVISION	REV	BY	CHK	DATE	DIV	TITLE	SHEET
1981	CHEVROLET "A"	14020865*	1	1	1	03/19/80	CHEVROLET	1981 ALL PASSENGER CARS*	3
1981	CHEVROLET "B"	14020866	2	1	1	03/19/80	CHEVROLET	MODELS & SYMBOLS ALL PASSENGER	0A
1981	CHEVROLET "F"	14020867					ECR 86448		
1981	CHEVROLET "J"	14020869					NEW 030E79		
1981	CHEVROLET "X"	14020871							
1981	CHEVROLET "Y"	14020870							

Ch 1 1 0 0 1 1 Gg



General Motors Corporation
CHEVROLET MOTOR DIVISION

PRODUCT DESCRIPTION MANUAL
 ITEM REFERENCE PROCESS MATERIAL TORQUE EXISTING AS PART OF

QUANTITY

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

Quantity of staples represents number required per part.

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

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.

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 (mm). 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.

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.

1981 CHEVROLET "A" 14020865*	DATE	SYM	REVISION	AUTH	DR	CK	REV	DATE	DIV	1981 ALL VEHICLES*
1981 CHEVROLET "B" 14020866								DR I. MORENCY	CHEVROLET	ASSEMBLY NOTES ALL VEHICLES
1981 CHEVROLET "F" 14020867								APPR		
1981 CHEVROLET "H" 14020868								APPR		
1981 CHEVROLET "T" 14020869								APPR		
1981 CHEVROLET "X" 14020871								APPR		
1981 CHEVROLET "Y" 14020870								APPR		
1981 THUCK "C-K" 14020862								APPR		
1981 THUCK "G" 14020863								APPR		
1981 THUCK "P" 14020864								APPR		
									REF ECR 864428 C/O 1990/79 UA-4	UPC OA
										SHEET 4



General Motors Corporation
CHEVROLET MOTOR DIVISION

PRODUCT DESCRIPTION MANUAL
 ITEM REFERENCE PROCESS MATERIAL TORQUE EXISTING AS PART OF

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 stripping 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.

1981 CHEVROLET "A" 14020865*	DATE	SYM	REVISION	ADDITION	DR	CR	CHK	DATE	BY	1981 ALL VEHICLES*
1981 CHEVROLET "B" 14020866										1981
1981 CHEVROLET "F" 14020867										TORQUE INSTRUCTIONS ALL VEHICLES
1981 CHEVROLET "H" 14020868										
1981 CHEVROLET "J" 14020869										
1981 CHEVROLET "X" 14020871										
1981 CHEVROLET "Y" 14020870										
1981 TRUCK "C-K" 14020862										
1981 TRUCK "G" 14020863										
1981 TRUCK "P" 14020864										

(1) (2) (3) (4) (5) (6) (7) (8) (9) (10) (11) (12) (13) (14) (15) (16) (17) (18) (19) (20) (21) (22) (23) (24) (25) (26) (27) (28) (29) (30) (31) (32) (33) (34) (35) (36) (37) (38) (39) (40) (41) (42) (43) (44) (45) (46) (47) (48) (49) (50) (51) (52) (53) (54) (55) (56) (57) (58) (59) (60) (61) (62) (63) (64) (65) (66) (67) (68) (69) (70) (71) (72) (73) (74) (75) (76) (77) (78) (79) (80) (81) (82) (83) (84) (85) (86) (87) (88) (89) (90) (91) (92) (93) (94) (95) (96) (97) (98) (99) (100)



ITEM REFERENCE PROCESS MATERIAL TORQUE

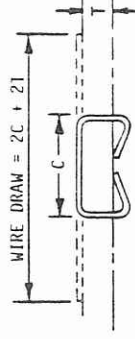
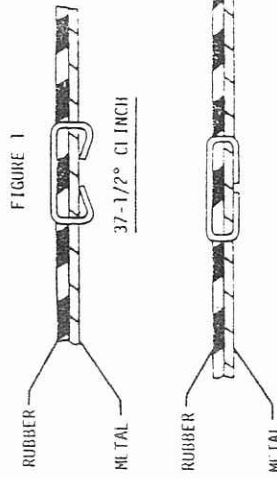


FIGURE 1



37-1/2° CLINCH
FLAT CLINCH

[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.

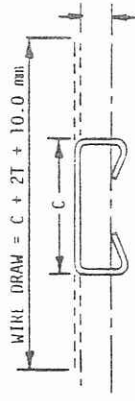
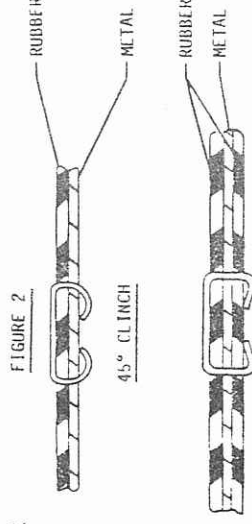


FIGURE 2



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

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.

1981 CHEVROLET "A" 14020865*						1981 ALL VEHICLES*						
DATE	SYM	REVISION				JUV		TITLE		STAPLING INSTRUCTIONS		SHU
1981 CHEVROLET "b" 14020866						CHEVROLET				0A		6
1981 CHEVROLET "c" 14020867						E/C		E/C				
1981 CHEVROLET "d" 14020868						R/L		R/L				
1981 CHEVROLET "e" 14020869						L/C		L/C				
1981 CHEVROLET "f" 14020870						R/C		R/C				
1981 CHEVROLET "g" 14020871						L/C		L/C				
1981 CHEVROLET "h" 14020872						R/C		R/C				
1981 CHEVROLET "i" 14020873						L/C		L/C				
1981 CHEVROLET "j" 14020874						R/C		R/C				
1981 CHEVROLET "k" 14020875						L/C		L/C				
1981 CHEVROLET "l" 14020876						R/C		R/C				
1981 CHEVROLET "m" 14020877						L/C		L/C				
1981 CHEVROLET "n" 14020878						R/C		R/C				
1981 CHEVROLET "o" 14020879						L/C		L/C				
1981 CHEVROLET "p" 14020880						R/C		R/C				
1981 CHEVROLET "q" 14020881						L/C		L/C				
1981 CHEVROLET "r" 14020882						R/C		R/C				
1981 CHEVROLET "s" 14020883						L/C		L/C				
1981 CHEVROLET "t" 14020884						R/C		R/C				



General Motors Corporation
CHEVROLET MOTOR DIVISION

PRODUCT DESCRIPTION MANUAL
EXISTING AS PART OF

ITEM REFERENCE PROCESS MATERIAL TORQUE CLAMP

METHOD A	METHOD B	METHOD C	METHOD D	METHOD E	METHOD F	METHOD G	METHOD H	METHOD I	METHOD J	METHOD K	METHOD L	METHOD M
<p>3.0 mm min PIPE 3.0 mm min HOSE CLAMP CLAMP WIDTH 6.0 mm OR 12.0 mm</p>	<p>3.0 mm min PIPE 3.0 mm min HOSE CLAMP</p>	<p>3.0 mm min PIPE 3.0 mm min HOSE CLAMP</p>	<p>0.0-3.0 mm LOCATING BEAD PIPE 0.0-1.0 mm CLAMP</p>	<p>3.0 mm min SECOND BEAD 3.0 mm min HOSE 0.0-2.0 mm PIPE CLAMP FIRST BEAD</p>	<p>3.0 mm min SECOND BEAD 3.0 mm min HOSE 0.0-2.0 mm PIPE CLAMP FIRST BEAD</p>	<p>0.0-3.0 mm FITTING 0.0-1.0 mm HOSE CLAMP</p>	<p>0.0-3.0 mm FITTING 0.0-1.0 mm HOSE CLAMP</p>	<p>0.0-2.0 mm TYPICAL PART 0.0-2.0 mm HOSE 0.0-1.0 mm CLAMP</p>	<p>0.0-2.0 mm PART WITH INTEGRAL NIPPLE 3.0 mm min HOSE 0.0-1.0 mm CLAMP AIR CLEANER, RADIATOR</p>	<p>0.0-2.0 mm HOSE 0.0-1.0 mm CLAMP</p>	<p>0.0-2.0 mm HOSE 0.0-1.0 mm CLAMP</p>	<p>PIPE LOCATING BEAD ALIGN CLAMP TAB WITH END OF HOSE ALIGN END OF HOSE WITH BEAD OR PIPE HOSE BARB PIPE WITH TAB CLAMP</p>
<p>PIPE WITH NO BEADS OR 12.0 mm</p> <p>SINGLE BEAD PIPE SAE STYLE "A" APPLIES TO ALL SIZES OF PIPES, HOSES & CLAMPS.</p> <p>SINGLE BEAD PIPE SAE STYLE "B" APPLIES TO ALL SIZES OF PIPES, HOSES & CLAMPS.</p> <p>STRAIGHT PIPE WITH LOCATING BEAD</p> <p>DOUBLE BEAD PIPE SAE STYLE "A"</p> <p>DOUBLE BEAD PIPE SAE STYLE "B"</p> <p>FITTING WITHOUT BEAD</p> <p>FITTING WITH BEAD</p> <p>INTEGRAL SHORT NIPPLE WITH BEAD THROUGH A PART</p> <p>INTEGRAL SHORT NIPPLE WITHOUT BEAD</p> <p>INTEGRAL PART WITH INTEGRAL NIPPLE TYPICAL PART</p> <p>INTEGRAL SHORT NIPPLE WITH BEAD</p> <p>HOSE BARB PIPE WITH TAB CLAMP</p>												
<p>DATE</p> <p>1981 CHEVROLET "A" 1402065*</p> <p>1981 CHEVROLET "B" 1402066</p> <p>1981 CHEVROLET "C" 1402067</p> <p>1981 CHEVROLET "D" 1402068</p> <p>1981 CHEVROLET "E" 1402069</p> <p>1981 CHEVROLET "F" 1402070</p> <p>1981 CHEVROLET "G" 1402071</p> <p>1981 TRUCK "C-K" 1402062</p> <p>1981 TRUCK "G" 1402063</p> <p>1981 TRUCK "P" 1402064</p>												
<p>SYMBOL</p> <p>13</p>												
<p>DIVISION</p> <p>CHEVROLET</p>												
<p>DATE</p> <p>1981</p>												
<p>DESCRIPTION</p> <p>HOSE CLAMPING INSTRUCTIONS ALL VEHICLES</p>												
<p>1981 ALL VEHICLES*</p>												
<p>UFC</p> <p>0A</p>												
<p>SHEET</p> <p>7</p>												

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General Motors Corporation
CHEVROLET MOTOR DIVISION

PRODUCT DESCRIPTION MANUAL
ITEM REFERENCE PROCESS MATERIAL TOPIC EXISTING AS PART OF

METHOD A	METHOD D	METHOD G	METHOD K
METHOD B	METHOD E	METHOD H	METHOD L
METHOD C	METHOD F	METHOD J	METHOD M

0.0 TO WALL THICKNESS
OF HOSE

DATE	SYM	REVISION	ADH	DR	BY	DIV	TITLE	
1981 CHEVROLET "A"	14020865*					CHEVROLET	1981 ALL VEHICLES*	
1981 CHEVROLET "B"	14020866						HOSE INSTALLATION INSTRUCTIONS	
1981 CHEVROLET "C"	14020867						(WITHOUT CLAMPS)	
1981 CHEVROLET "D"	14020868						ALL VEHICLES	
1981 CHEVROLET "E"	14020869							
1981 CHEVROLET "F"	14020870							
1981 TRUCK "G"	14020862							
1981 TRUCK "H"	14020863							
1981 TRUCK "I"	14020864							
							U7C	8
							OA	

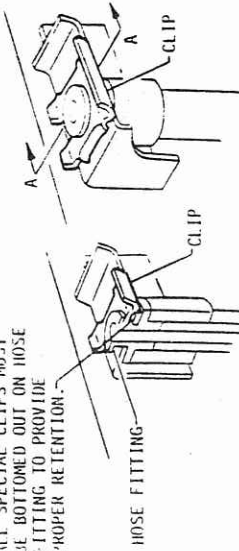


General Motors Corporation
CHEVROLET MOTOR DIVISION

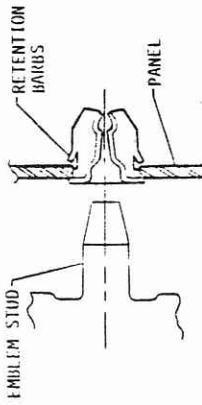
PRODUCT DESCRIPTION MANUAL

ITEM REFERENCE
 PROCESS MATERIAL
 TORQUE
 EXISTING AS PART OF

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

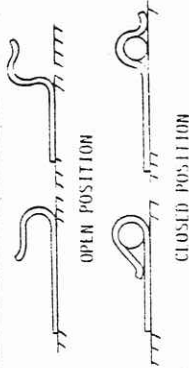


SPRING YOKE BRAKE CLIP



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



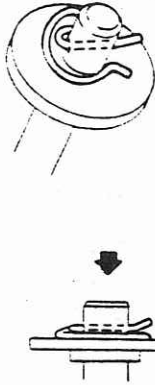
ALL NON-HARDENED STEEL CLIPS ARE TO BE CLINCHED CLOSED AFTER WIRE TUBES OR BOMBER CABLES ARE INSTALLED.

CLIP CLIPPING



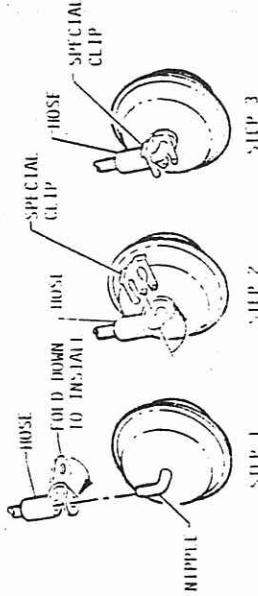
RETAINER MUST BE INSTALLED AS SHOWN.

RETAINER



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

RETAINER



SPECIAL CLIP



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

RETAINER

DATE	SYM	REVISION
1981 CHEVROLET "A"	14020865*	
1981 CHEVROLET "B"	14020866	
1981 CHEVROLET "C"	14020867	
1981 CHEVROLET "D"	14020868	
1981 CHEVROLET "E"	14020869	
1981 CHEVROLET "F"	14020870	
1981 CHEVROLET "G"	14020871	
1981 TRUCK "C-K"	14020872	
1981 TRUCK "G"	14020863	
1981 TRUCK "H"	14020864	

DATE	BY	CHK	APP	REV
05-22-81	MOORE	MCY		
	APP			
	APP			
	APP			

DIV	DATE	BY	CHK	APP	REV
CHEVROLET	05-22-81	MOORE	MCY		
		APP			
		APP			

DIV	DATE	BY	CHK	APP	REV
CHEVROLET	05-22-81	MOORE	MCY		
		APP			
		APP			

1981 ALL VEHICLES*	UFC	SHEET
RETAINER INSTRUCTIONS ALL VEHICLES	0A	9

G
 F
 E
 D
 C
 B
 A



General Motors Corporation

CHEVROLET MOTOR DIVISION

PRODUCT DESCRIPTION MANUAL

ITEM REFERENCE PROCESS MATERIAL TORQUE EXISTING AS PART OF

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.

WITH FORMED THREAD NUT

WITH SELF-THREADING NUT

REGULAR TYPE STAMPED NUT

SPECIAL TOOL & MANDREL

NUT THREADED TO MANDREL PRIOR TO UPSET.

AFTER

BEFORE

HEADER TOOL PULL UP STUD TO EXTEND THRU NUT

AVOID DEFORMED OR STRIPPED THREADS.

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 WASHER

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

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.

WITH FORMED THIRLAD NUT

WITH SELF-THREADING NUT

WASHER TYPE STAMPED NUT

MUST BE INSTALLED AS SHOWN TO FUNCTION PROPERLY

SPRING OR WAVE WASHERS

PREVAILING TORQUE NUT

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.

NOTE: Flat surface is the bearing surface.

U. NUTS & J. HOLES

YEAR	MODEL	SYMBOL	DESCRIPTION
1965	CHEVROLET "A"	14020865*	
1961	CHEVROLET "B"	14020866	
1961	CHEVROLET "C"	14020867	
1961	CHEVROLET "D"	14020868	
1961	CHEVROLET "E"	14020869	
1961	CHEVROLET "F"	14020870	
1961	CHEVROLET "G"	14020871	
1961	TRUCK "C-K"	14020862	
1961	TRUCK "G"	14020863	
1961	TRUCK "H"	14020864	

SPRING WASHER WITH CORLAVAL

FLAT SURFACE

SPRING WASHER

SCREW ASSEMBLY

DO NOT SPRING WASHER WITH CORLAVAL UNLESS ADVISED THAT SURFACE TO PROVIDE PROPER TIGHTENING.

BLIND RIVET PART INSTALLATION

1981 ALL VEHICLES*

SEE OTHER INSTRUCTIONS ALL VEHICLES

CHEVROLET

1/70 1590/79

UP: 10

UPC

0A

SHEET 10

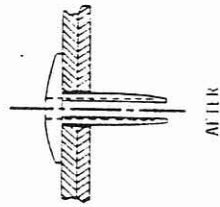
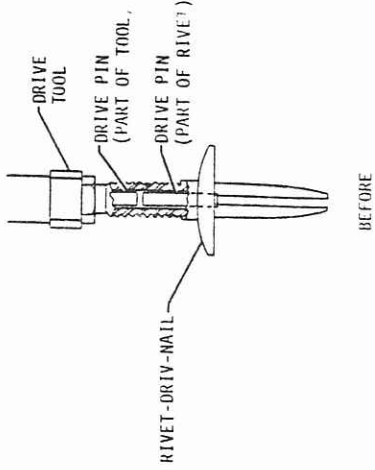


General Motors Corporation
CHEVROLET MOTOR DIVISION

PRODUCT DESCRIPTION MANUAL
EXISTING AS PART OF

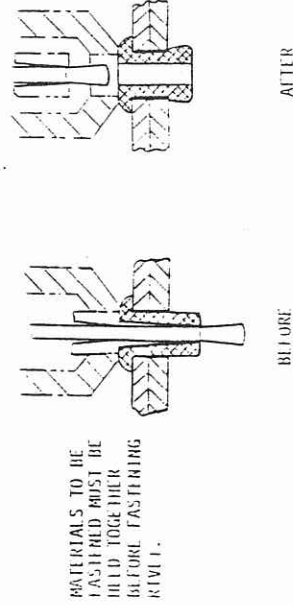
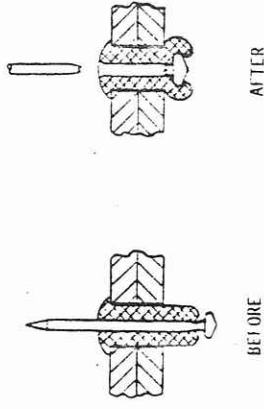
ITEM REFERENCE PROCESS MATERIAL TORQUE EXISTING AS PART OF

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.



RIVET - DRIV-NAIL

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

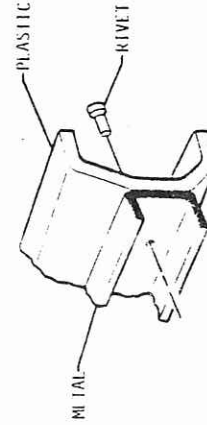


TYPE P DOME HEAD BLIND RIVETS (OPEN OR CLOSED)

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

TYPE D DOME HEAD BLIND RIVETS (OPEN)

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



RIVET

YEAR	MODEL	DESCRIPTION	DATE	SYM
1981	CHEVROLET	"A"	14020865	
1981	CHEVROLET	"B"	14020866	
1981	CHEVROLET	"C"	14020867	
1981	CHEVROLET	"D"	14020868	
1981	CHEVROLET	"E"	14020869	
1981	CHEVROLET	"F"	14020870	
1981	CHEVROLET	"G"	14020871	
1981	BUICK	"H"	14020872	
1981	BUICK	"I"	14020873	
1981	BUICK	"J"	14020864	

DIVISION				17	
BUICK	CHEVROLET				
BU	LCR 00-348	UFC	0A	SHEET	11
	C/O 1/10/79				

1981	CHEVROLET	"A"	14020865
1981	CHEVROLET	"B"	14020866
1981	CHEVROLET	"C"	14020867
1981	CHEVROLET	"D"	14020868
1981	CHEVROLET	"E"	14020869
1981	CHEVROLET	"F"	14020870
1981	CHEVROLET	"G"	14020871
1981	BUICK	"H"	14020872
1981	BUICK	"I"	14020873
1981	BUICK	"J"	14020864

1981 ALL VEHICLES*

REFER TO INSTRUCTIONS FOR ALL VEHICLES

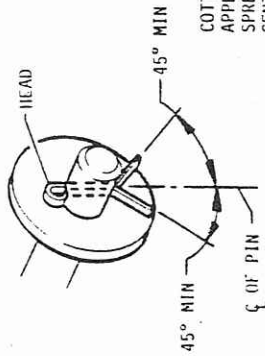
Ch B 0 p 1 c



General Motors Corporation
CHEVROLET MOTOR DIVISION

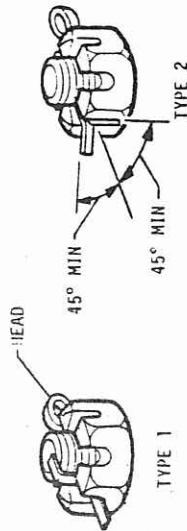
PRODUCT DESCRIPTION MANUAL

ITEM REFERENCE
 PROCESS MATERIAL
 TORQUE
 EXISTING AS PART OF



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.

COTTER PINS



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 (1/6 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

SYM	DATE	REVISION	DATE	BY	CHK	DATE	BY	CHK	DATE	BY	CHK	TITLE	SHEET
14020865*	1/10/80	NOTE REVISED	08-14-82	MOORE	MOORE	08-14-82	MOORE	MOORE	08-14-82	MOORE	MOORE	1981 ALL VEHICLES*	12
CHEVROLET "A"	14020866											RETAINER INSTRUCTIONS ALL VEHICLES	
CHEVROLET "B"	14020867												
CHEVROLET "C"	14020868												
CHEVROLET "D"	14020869												
CHEVROLET "E"	14020870												
CHEVROLET "F"	14020862												
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General Motors Corporation
CHEVROLET MOTOR DIVISION

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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).

DATE	SYM	REVISION	AUTH	CHK	APP	DATE	BY	CHK	APP	DIV	TITLE	SHEET
										CHEVROLET	1981 ALL VEHICLES*	13
										CHEVROLET	ALUMINUM CORROSION PROTECTION ALL VEHICLES	0A
										1CR 06-418		
										6/0 1980/79		
										DA-13		

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General Motors Corporation
CHEVROLET MOTOR DIVISION

PRODUCT DESCRIPTION MANUAL
EXISTING AS PART OF

ITEM REFERENCE PROCESS MATERIAL TORQUE

INSTALLATION AND TESTING OF EMBLEMS AND SCRIPTS

1. BODY AND EMBLEM OR SCRIPT PREPARATION

- A. Clean area of body surface where emblem or script is to be applied (maximum of three (3) job lengths prior to emblem or script installation) with a suitable solvent (150-PROPYL ALCOHOL 50-50 MIXTURE BY VOLUME WITH WATER, HIGH-FLASH NAPHTHA 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 script 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 script are free of moisture during installation).

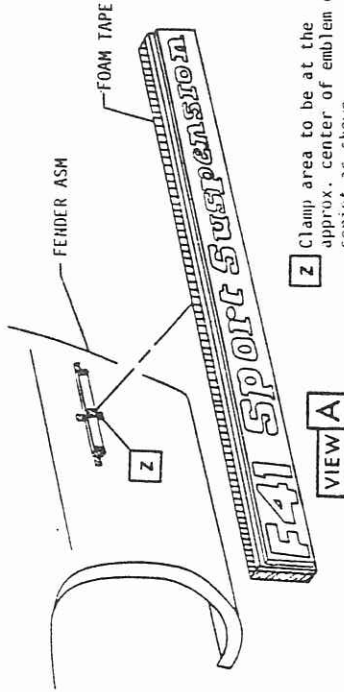
2. EMBLEM OR SCRIPT APPLICATION TO BODY

- A. Load emblem or script 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.



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	CR	ASM	DATE	OR L. MORENCY	DIV	TITLE	1981 ALL VEHICLES*	SHEET	14
1981 CHEVROLET "B" 14020866									CR A. B. B. L. P.	CHEVROLET	ADHESIVE BONDED EMBLEMS & SCRIPTS			
1981 CHEVROLET "C" 14020867									APPR		ALL VEHICLES			
1981 CHEVROLET "D" 14020868									APPR					
1981 CHEVROLET "E" 14020869									APPR					
1981 CHEVROLET "F" 14020870									APPR					
1981 CHEVROLET "G" 14020871														
1981 TRUCK "C-K" 14020862														
1981 TRUCK "C" 14020863														
1981 TRUCK "P" 14020864														
										REF DRG NO.	UPC			
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INSTALLATION PROCEDURE

- 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 (151062) high flash Naptha, or equivalent.
- Wipe cleaned surfaces dry with clean cloth.
- For large decals or those applied on rubber (non-rigid) surfaces, use the "WET" method of application.

- 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 maintained.
- While the entire area is still wet with solution, remove paper backing from transfer, locate and press on lightly.
- Start at center of transfer and squeeze from middle to edges, removing all air bubbles and wetting solution to assure a satisfactory bond. Use Teflon-backed plastic squeegee only. (GEF. D1-900 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.

- 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.
- 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.
- 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.
- 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). 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.
- This tape stripe highlights metal imperfections so that all dings and rough metal must be repaired before applying.
- 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:

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

The following repair procedure is recommended:

- 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.
- 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

- 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).

- Body surface preparation
 - Surfaces to be smooth and free of paint defects such as pits, rough two-tone paint break lines, etc.
 - 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.
 - Dry surfaces with clean cloth. Do not allow surface re-contamination prior to decal installation.

C. Decal preparation - liner (backing paper) removal

- 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.
 - 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

1981 CHEVROLET "A" 14020865*		REVISION		DATE		SYM		BY		1981 ALL VEHICLES*	
1981 CHEVROLET "B" 14020866	ZDANK	1	NOTE REVISED	(PC-310A)	12/21/80	DR. MURPHY	CR. BARNHART	APPE	APPE	APPE	TITLE
1981 CHEVROLET "F" 14020867											DECAL APPLICATION PROCEDURE
1981 CHEVROLET "H" 14020868											ALL VEHICLES
1981 CHEVROLET "J" 14020869											
1981 CHEVROLET "K" 14020870											
1981 CHEVROLET "L" 14020871											
1981 CHEVROLET "M" 14020872											
1981 CHEVROLET "N" 14020873											
1981 CHEVROLET "O" 14020874											
1981 CHEVROLET "P" 14020875											
1981 CHEVROLET "Q" 14020876											
1981 CHEVROLET "R" 14020877											
1981 CHEVROLET "S" 14020878											
1981 CHEVROLET "T" 14020879											
1981 CHEVROLET "U" 14020880											
1981 CHEVROLET "V" 14020881											
1981 CHEVROLET "W" 14020882											
1981 CHEVROLET "X" 14020883											
1981 CHEVROLET "Y" 14020884											
1981 CHEVROLET "Z" 14020885											
1981 TRUCK "C-K" 14020862											
1981 TRUCK "G" 14020863											
1981 TRUCK "P" 14020864											
DIVISION CHEVROLET REF. ECR 86448 NEW 110880 UPC 0A SHEET 15											



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CHEVROLET MOTOR DIVISION

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II. Decal application to body

- A. "DRY" application method
 - The dry application method is suitable for installation of relatively small decals or narrow stripes to rigid body surfaces.
 - Apply dry decal to surface using techniques noted under general application method below.

- B. "WET" application method
 - The wet application method is recommended for application of larger decals or wide 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.
 - Prior to proceeding with general application method below thoroughly wet the body surfaces with a solution of 1/4 ounce of neutral detergent cleaner (must not contain oils, perfumes or breaches) per 1 gallon (3.785 liters) of clean water. Remove backing paper and apply to body while surfaces are wet.

- C. General application method
 - Major body surfaces - locate the wet or dry decal or stripe to surface as defined on the installation instructions (locate to body openings, flanges, release 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, overlapping 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. Wrap or flange areas & creases - pressurize decal on to surface, soften with heat, and re-pressurize.

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-squeezed to ensure adhesive contact.

IV. Repair

- A. Repair is required if decal or paint is damaged or decal is mislocated. 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 ambient temperature not to exceed 90°F (32°C) and after a minimum of 72 hours aging.

DATE	SYM	REVISION	AUTH	DR	CE	AM	DATE	APPROVED	DIV	1981 ALL VEHICLES*		
1981 CHEVROLET "A"	14020865*						DR	10/1/80	CHEVROLET	DECAL APPLICATION PROCEDURE ALL VEHICLES		
1981 CHEVROLET "B"	14020866						DR	10/1/80	RU ECR 86448	UPC	OA	SHEET 15.1
1981 CHEVROLET "F"	14020867						DR	10/1/80	NEW 11JABO			
1981 CHEVROLET "H"	14020868						DR	10/1/80				
1981 CHEVROLET "I"	14020869						DR	10/1/80				
1981 CHEVROLET "X"	14020871						DR	10/1/80				
1981 CHEVROLET "Y"	14020870						DR	10/1/80				
1981 TRUCK "C-K"	14020862						DR	10/1/80				
1981 TRUCK "C"	14020863						DR	10/1/80				
1981 TRUCK "P"	14020864						DR	10/1/80				

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ITEM REFERENCE PROCESS MATERIAL TORQUE

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 110 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.

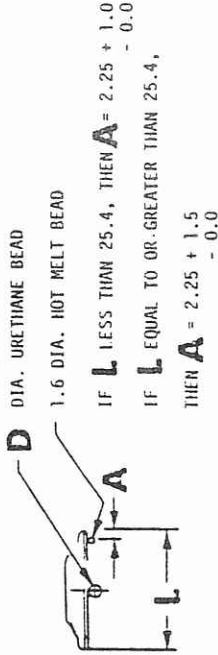
II. MOLDING APPLICATION TO BODY

- 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 lb. (min).
- D. Final roller application - line (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 naphtha (use of 9981293 isopropyl alcohol is strictly forbidden when urethane is present.)



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.691	.830	17.6	21.1	.090
.831	1.160	21.2	29.5	.120
1.170	1.530	29.7	38.9	.160
				2.3
				3.0
				4.0

1981 CHEVROLET "A" 14020865 *	DATE	SYM	REVISION	AMIN	DR	CK	CHK	DATE	BY	DIV	TITLE
1981 CHEVROLET "B" 14020866								05/14/82	DR L. MORTENCOY	CHEVROLET	1981 ALL PASSENGER CARS*
1981 CHEVROLET "F" 14020867									(K D FOWLER / CS		ADHESIVE MOLDING INSTRUCTION-SOLUTION LACQUER (PLANT APPLIED ADHESIVE)
1981 CHEVROLET "H" 14020868									APPR		ALL PASSENGER
1981 CHEVROLET "T" 14020869									APPR		
1981 CHEVROLET "X" 14020871									APPR		
1981 CHEVROLET "Y" 14020870									APPR		
										REF ECR 86448 C/0 19N079 0A-15	REF DNG NO. 3071451
											UPC 0A
											SHEET 16

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ITEM REFERENCE
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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 naphtha 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 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. 45-9) 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.

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	1981 CHEVROLET "B" 14020866	1981 CHEVROLET "C" 14020867	1981 CHEVROLET "D" 14020868	1981 CHEVROLET "E" 14020869	1981 CHEVROLET "F" 14020870	1981 CHEVROLET "G" 14020871	1981 CHEVROLET "H" 14020872	1981 CHEVROLET "I" 14020873	1981 CHEVROLET "J" 14020874	1981 CHEVROLET "K" 14020875	1981 CHEVROLET "L" 14020876	1981 CHEVROLET "M" 14020877	1981 CHEVROLET "N" 14020878	1981 CHEVROLET "O" 14020879	1981 CHEVROLET "P" 14020880	1981 CHEVROLET "Q" 14020881	1981 CHEVROLET "R" 14020882	1981 CHEVROLET "S" 14020883							
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1981 ALL PASS* (exc "Y")
 TITLE: ADHESIVE MOLDING INSTRUCTION-DISPERSTOR LACQUER (BUTYL ADHESIVE) ALL PASSENGER (exc "Y")
 REF: ECR 86448 C/O 1980/79 3072503
 UPRC 0A-16
 UPRC 0A
 SHEET 17



ITEM REFERENCE PROCESS MATERIAL TOOLING

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 naphtha 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 (- 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 PIM 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 adhesive 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 #3081268

1981 CHEVROLET "A"	14020865*	DATE	SYM	REVISION	WITH	OK	CK	ASH	DATE	DIV	1981 ALL PASSENGER CARS*
1981 CHEVROLET "B"	14020866								05/21/90	CHEVROLET	ADHESIVE MOLDING INSTRUCTION-SOLUTION LACQUER (ADHESIVE PRE-APPLIED) ALL PASSENGER
1981 CHEVROLET "C"	14020867								DR L. MORENCY	REF. DWS. NO. 1651142 (S)	SHEET 18
1981 CHEVROLET "H"	14020868								APPL 1/5/90	UPC OA	
1981 CHEVROLET "T"	14020869								APPL	REF. DWS. NO. 1651142 (S)	
1981 CHEVROLET "X"	14020871								APPL	C/O 19N079	
1981 CHEVROLET "Y"	14020870								APPL	0A-15	
23											



INSTALLATION AND TESTING OF ADHESIVE MOLDINGS WITH PROMOTER 9981801
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.

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 naphtha 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 (consistent) 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 C) 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.

DATE	SYN	REVISION	AUTH	CHK	APP	DATE	BY	CHK	APP	DATE	BY	CHK	APP
1981 CHEVROLET "A" 14020865 *													
1981 CHEVROLET "B" 14020866													
1981 CHEVROLET "C" 14020867													
1981 CHEVROLET "D" 14020868													
1981 CHEVROLET "E" 14020869													
1981 CHEVROLET "X" 14020871													
1981 CHEVROLET "Y" 14020870													
DIY											1981 ALL PASSENGER CARS*		
DR L. MORENCY											III		
APPR											CHEVROLET		
APPR											REF ECR 86448		
APPR											C/O 19R079		
APPR											DA-15.1		
APPR											REF DMG NO. 3081288		
APPR											REF PASSENGER		
APPR											REF DMG NO. 0A		
APPR											REF 19		

PRODUCT DESCRIPTION MANUAL
 ITEM REFERENCE PROCESS MATERIAL TORQUE EXISTING AS PART OF

DRAFTING
General Motors Corporation
 CHEVROLET MOTOR DIVISION

0₂ MISCELLANEOUS SHIPPING LIST

DIV RESP
 0

OC-1 MISCELLANEOUS SHIPPING LIST

DIV RESP

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

- CONTENTS
- 0B-1 ENGINE TUNE-UP EMISSION LABEL D
 - 0B-2 COMBINED TIRE PRESS. & CERT & CANADIAN SAFETY LABELS D
 - 0B-3 COMBINED TIRE PRESS. & CERT PRINTED INFO C
 - 0B-4 SPECIFICATIONS-PRICE LABEL (U.S.) D
 - ① 0B-4-1 NOTICE TO BUYER, EPA FUEL ECONOMY-PRICE LABELSVC5 D
 - 0B-5 EXPORT LABEL INFORMATION D
 - 0B-6 EPA FUEL ECONOMY PRINTED INFORMATION749 D
 - 0B-7 CONSIGNMENT UNDER LIMITED CERT LABEL D
 - 0B-8 FUEL ECONOMY & PRICE LABEL PRINTED INFORMATION749 D
 - 0B-9 UNLEADED FUEL DECAL D
 - 0B-10 AUTO. JACK USAGE LABEL D
 - 0B-11

DATE	SYN	REVISION	AUTH	DR	CK	ASW	DATE	DIV	TITLE	REF	UPC	SHEET
12/11/80	1	SHEET 0B-4-1 ADDED	86448	MP	116		12/27/80	CHEVROLET	1981 CHEV. "F" 14020867	ECR 86448		1
5/1/86	2	TITLE REVISED	87721	MP	21				CONTENTS-LABELS & MISCELLANEOUS SHIPPING FA00 ALL	NEV 170C79		
2/9/80	3	CHART NO ADDED	JKTB	ADI	2							

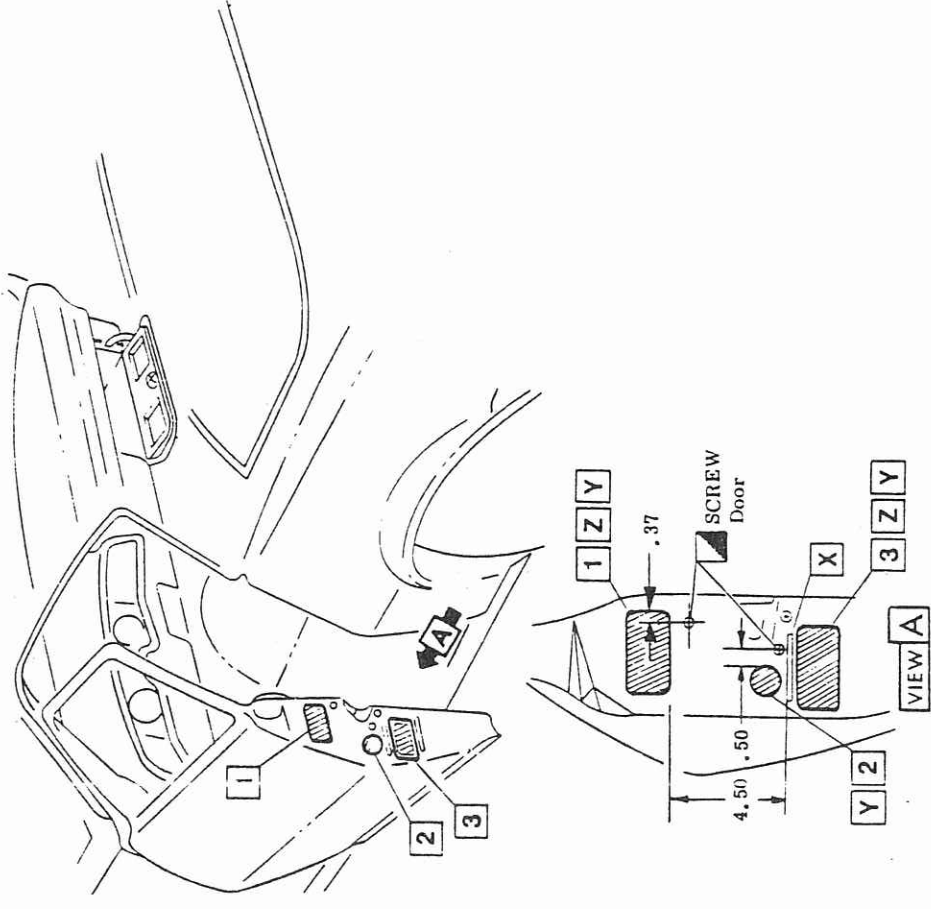
★ Instructions Carryover
 ● Waiting Info.

Ch X B 0 P Gg

PRODUCT DESCRIPTION MANUAL

ITEM REFERENCE PROCESS MATERIAL TORQUE EXISTING AS PART OF

- 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 (Instal) Rev HARD (Instal) Rev DATE SYM REVISION AUTH DE CK ESM DATE DEPT DIV	HARD (Instal) Rev HARD (Instal) Rev DATE SYM REVISION AUTH DE CK ESM DATE DEPT DIV	CHEVROLET C/O 15/JA80 OB-3	DIV CHEVROLET C/O 15/JA80 OB-3	1981 CHEV. "F" 14020867 COMBINED TIRE PRESSURE & CERT & CANADIAN SAFETY LABELS FA00 ALL
FULLY DRIVEN, SEATED & NOT STRIPPED Ch X B 0 P G	30	3	3	SHEET 3

PRODUCT DESCRIPTION MANUAL

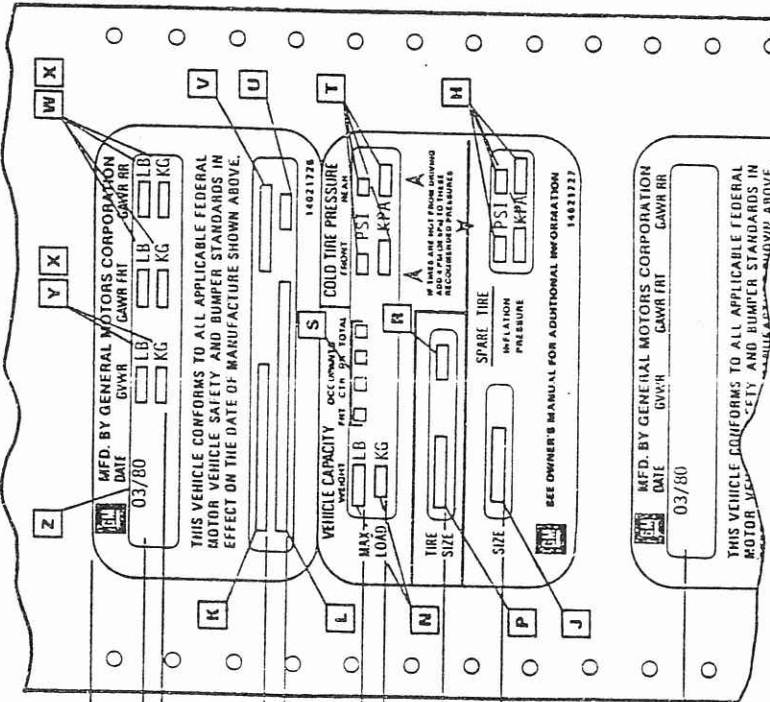
General Motors Corporation
CHEVROLET MOTOR DIVISION

HIGH REFERENCE □ PROCESS MATERIAL △ TORQUE ▽ EXISTING AS PART OF

ASSEMBLY PLANT INSTRUCTIONS

- 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.
- 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.
- 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.
- 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. 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
- T TIRE PRESS. WITH MAXIMUM OCCUPANTS FRT & RR
- U SEE CONSUMER INFO CHART FOR ENTRY
- V VEH CLASS TYPE: "PASS. CAR" exc for A880 Type: "TRUCK"
- W GROSS AXLE WEIGHT RATING-FRT & RR
- X To add GVWR & GAHR information use "AS MANUFACTURED" date from vehicle rating plate instruction, chart or car manifest.
- Y GROSS VEHICLE WEIGHT RATING
- Z DATE



- H SPARE TIRE PRESSURE
- J SIZE OF SPARE TIRE
- K VEHICLE IDENTIFICATION NUMBER

1981 CHEVROLET "A" 14020865*	DATE	SYM	FINISH	STATION	DATE	BY	CHK	BY	CHK
1981 CHEVROLET "B" 14020366	02/24/80	/	AS TO SPACES		03/80				
1981 CHEVROLET "F" 14020867									
1981 CHEVROLET "T" 14020869									
1981 CHEVROLET "X" 14020871									
1981 CHEVROLET "Y" 14020870									

1981 CHEVROLET "A" 14020865*	DATE	SYM	FINISH	STATION	DATE	BY	CHK	BY	CHK
1981 CHEVROLET "B" 14020366	02/24/80	/	AS TO SPACES		03/80				
1981 CHEVROLET "F" 14020867									
1981 CHEVROLET "T" 14020869									
1981 CHEVROLET "X" 14020871									
1981 CHEVROLET "Y" 14020870									

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1981 CHEVROLET "F" 14020867									
1981 CHEVROLET "T" 14020869									
1981 CHEVROLET "X" 14020871									
1981 CHEVROLET "Y" 14020870									


PRODUCT DESCRIPTION MANUAL

EXISTING AS PART OF

OLDSMOBILE DIVISION
GENERAL MOTORS CORPORATION LANSING, MICHIGAN 48921

ITEM REFERENCE PROCESS MATERIAL TORQUE EXISTING AS PART OF

CHEVROLET
Division of General Motors Corporation
VEHICLE IDENTIFICATION NUMBER



FINAL ASSEMBLY POINT

DELIVERED TO DEALER AT NO EXTRA CHARGE UNLESS REPLACED BY OPTIMAL EQUIPMENT

THE FOLLOWING ITEMS ARE STANDARD ON THIS MODEL AT NO EXTRA CHARGE UNLESS REPLACED BY OPTIMAL EQUIPMENT

MANUFACTURER'S SUGGESTED RETAIL PRICE OF THIS MODEL INCLUDING DEALER PREPARATION

MANUFACTURER'S SUGGESTED RETAIL PRICE FOR OPTIONAL EQUIPMENT INSTALLED ON THIS VEHICLE BY MANUFACTURER

SEPA FUEL ECONOMY RATING

ESTIMATED MPG FOR COMPARISONS

ANNUAL FUEL COST: /GAL.

ASK THE DEALER FOR THE FREE GAS MILEAGE GUIDE TO COMPARE THE ESTIMATED MPG OF OTHER IF IT WILL TELL YOU HOW TO USE THESE NUMBERS.

OPTIONAL SUBTOTAL ESTIMATION CHARGE

TOTAL AMOUNT

IS TO BE COMPARED WITH OTHER ESTIMATED MPG'S AND YOUR OWN MILEAGE MAY BE POORER DEPENDING UPON OPTIONS, DRIVING CONDITIONS, YOUR DRIVING STYLE AND YOUR OPERATING CONDITION.

- A - YEAR, MODEL, BODY STYLE
- B - V.I.H.
- 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 08-7 FOR FUEL ECONOMY LABEL CONTENT

DATE	STN	REVISION	DIV	TITLE	SHEET
15-5111D			CHEVROLET	1981 ALL VEHICLES* (exc "P")	4.1
14020865*			ECR 86447	SPECIFICATIONS-PRICE LABEL (U.S.)	
14020866			NEW 23FE80	ALL VEHICLES (exc. "P")	
14020867			08-22		
14020869					
14020871					
14020870					
14020862					
14020863					

CHEVROLET



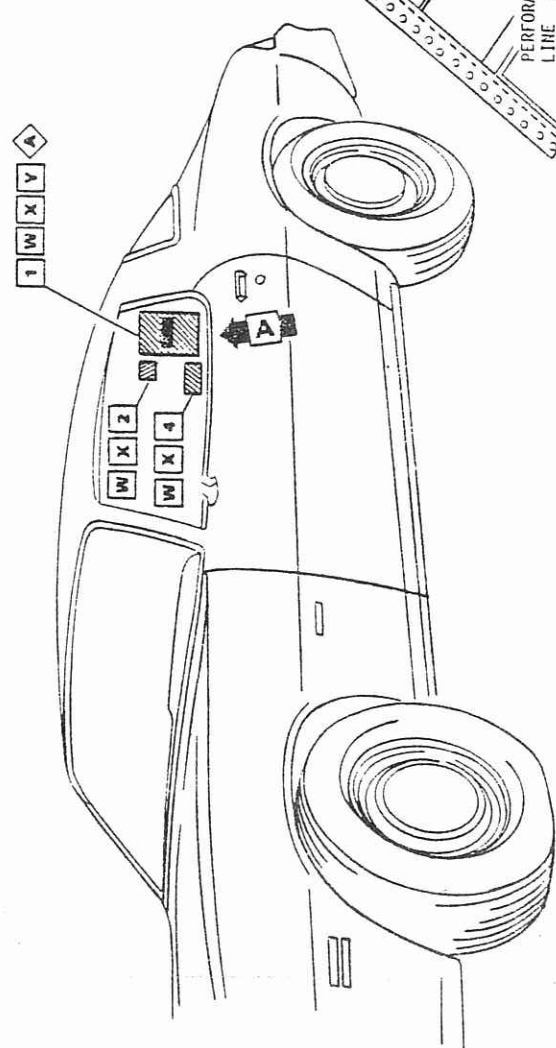
General Motors Corporation
CHEVROLET MOTOR DIVISION

PRODUCT DESCRIPTION MANUAL
EXISTING AS PART OF

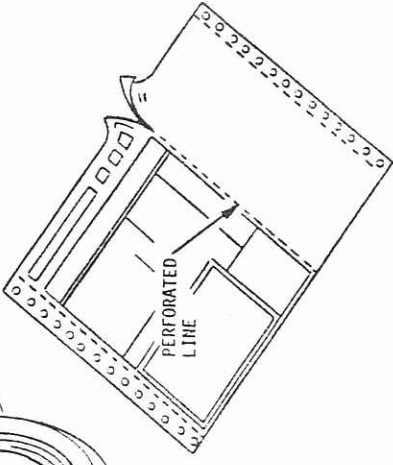
ITEM REFERENCE PROCESS MATERIAL TORQUE

- 1 LABEL-PRICE & FUEL ECONOMY EXC Z49 (14F)
- 1 8749 (14F)
- 2 LABEL-NOTICE TO BUYER 8HB2 (14F)
- 3 LABEL-MILEAGE ACCUMULATION EXC V7B/Z49 (14F)
- 4 LABEL-CLUTCH TYPE TORQUE 8HV4/MX2/MX3/M31 (7)
- ADHESIVE .005L (14F)

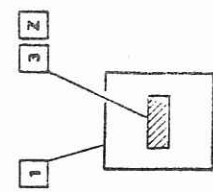
22508105
22510295
418351
10004244
25509931
3764800



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.



- Y Remove RH portion (Dealer Copy) of Label and place in instrument compartment. Affix LH portion to window.
- Z Affix Label to back of & readable from inside of vehicle. Chevrolet General Director of Reliability will advise which vehicle will be tested and labeled.
- 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.



VIEW A

DYNAMIC (Initial) []	HAND (Insp.) []	Rm	DATE	SYM	REVISION	DATE	BY	DATE	BY	DATE	BY
			4/10/80	Z	REGRANULAR REVIEWED		DE LUCCA, J. C.	2/24/80			
							DE LUCCA, J. C.				
							APPR				
							APPR				
							APPR				
							APPR				
<p>3??</p>							<p>ECR 86448 NEW 21MY80</p>	<p>UPC</p>	<p>OB</p>	<p>5</p>	<p>SHEET</p>
<p>1981 CHEV. "F" 14020867</p>							<p>CHEVROLET</p>	<p>NOTICE TO BUYER, EPA FUEL ECONOMY-PRICE, MILEAGE ACCUR., & TORQUE TRAMS LABELS</p>			

FULLY DRIVEN, SEALED & NOT STRIPPED
 U P Co

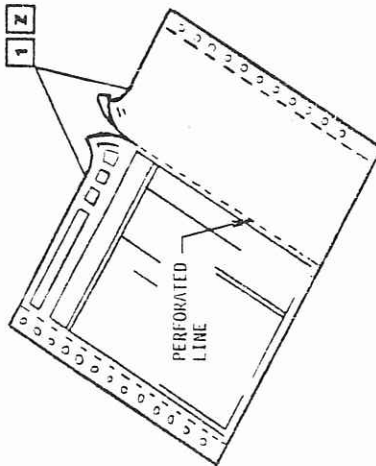
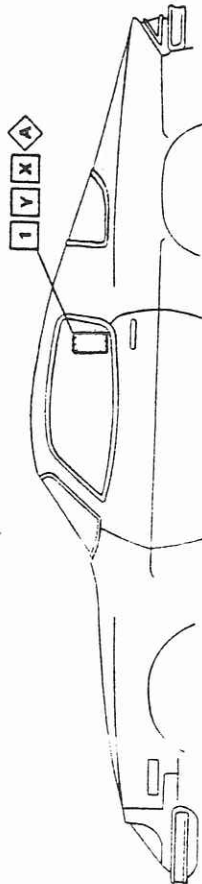


General Motors Corporation
CHEVROLET MOTOR DIVISION

PRODUCT DESCRIPTION MANUAL

ITEM REFERENCE PROCESS MATERIAL TORQUE EXISTING AS PART OF

22508105 **1** LABEL-PRICE (14F)
 3764800 **A** ADHESIVE .005L (14F)



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 near 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.

- 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.

DATE	SYN	REVISION	QTY	DR	CR	AM	DATE	DIV	1981 CHEV. "F" 14020867		
8/1/80	1	QUANTITY WAS CORRECT		8/1/80			20/7/80	CHEVROLET	EXPORT LABEL INFORMATION FAO & VCS		
							OR L. MCKENY				
							BY J. Buch HB				
							APPE				
							APPE				
							APPE				
							APPE				

FULLY DRIVEN, SEATED & HOT STRIPPED
 Ch D O P Ca


GENERAL MOTORS CORPORATION LANSING, MICHIGAN 48921



PRODUCT DESCRIPTION MANUAL

ITEM REFERENCE PROCESS MATERIAL TORQUE EXISTING AS PART OF

- 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)



CHEVROLET

FUEL ECONOMY RATING

ESTIMATED MPG: [] THE COMPANIES

ANNUAL FUEL COST: []

ESTIMATED MILEAGE FOR THIS [] OF THIS []

DATE MUST BE USED TO COMPARE THE ESTIMATED MPG OF OTHER

IF YOU WANT TO KNOW HOW TO USE THESE NUMBERS

SEE THE DRIVER FOR THE FULL

THE ESTIMATED MILEAGE FOR THIS [] OF THIS []

WAS TO COMPARE []

WITH OTHER []

YOUR OWN []

THESE NUMBERS []

AND YOUR []

WARRANTY []

OPTIONAL CHARGE

TOTAL AMOUNT

VEHICLE IDENTIFICATION NUMBER

1981 CHEVROLET "A"	14020865*	DATE	2/22/82	SYN	ISSUED	REVISION		DATE	28/10/79	DIV	CHEVROLET	1981 ALL VEHICLES* (exc "P")	
1981 CHEVROLET "B"	14020866								DP	MANSEU		III	
1981 CHEVROLET "C"	14020867								APP	R. E. Arndt		EPA FUEL ECONOMY PRINTED INFORMATION	
1981 CHEVROLET "H"	14020869								APP	R. E. Arndt		ALL VEHICLES exc "P" (exc 749)	
1981 CHEVROLET "Y"	14020871								APP	R. E. Arndt			
1981 CHEVROLET "Y"	14020870												
1981 TRUCK "C-K"	14020862												
1981 TRUCK "C"	14020863												
										REF	ECR 86448		
											NEW 09AP80		
												WFC	OB
													SHEET
													7

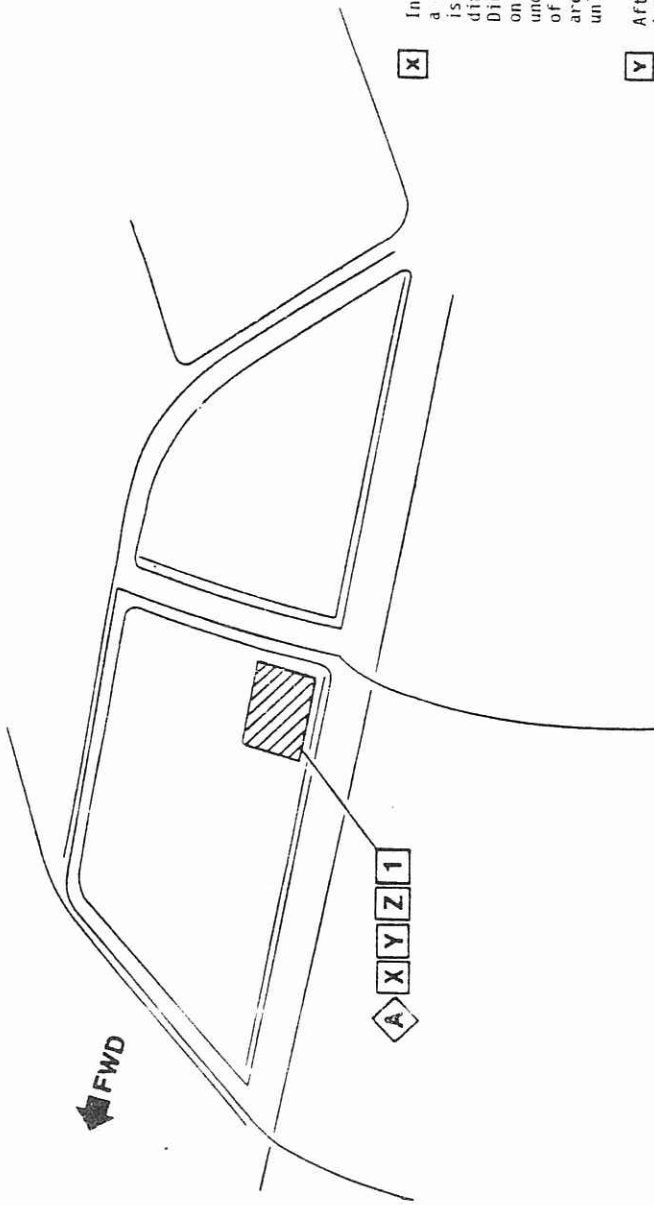


General Motors Corporation
CHEVROLET MOTOR DIVISION

PRODUCT DESCRIPTION MANUAL

ITEM REFERENCE PROCESS MATERIAL EXISTING AS PART OF

14014402 **1** LABEL-CONSIGNMENT UNDER LIMITED CERT & M45/M46/M82
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*	DATE	SYM	REVISION
1981 CHEVROLET "B" 14020866			
1981 CHEVROLET "F" 14020867			
1981 CHEVROLET "T" 14020865			
1981 CHEVROLET "Y" 14020870			

DATE	APPROVAL	DR	CK	DATE	OR L AGENCY	DIV	1981 ALL PASS* (exc "X")
				08/14/80	Chevrolet	CHEVROLET	TITLE CONSIGNMENT UNDER LIMITED CERT LABEL ALL PASSENGER exc "X"
						REF ECR 86448	IPC
						C/O 15F80	SHEET
						08-8	03

PRODUCT DESCRIPTION MANUAL

ITEM REFERENCE PROCESS MATERIAL TORQUE EXISTING AS PART OF

OLDSMOBILE DIVISION
GENERAL MOTORS CORPORATION LANSING, MICHIGAN 48921

General Motors of Canada Limited
General Motors du Canada Limitee

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

ITEM REFERENCE **PROCESS MATERIAL** **TORQUE** **EXISTING AS PART OF**

GENERAL MOTORS OF CANADA LIMITED
 1981 CHEVROLET 86448
 A 1981 CHEVROLET 86448
 B 1981 CHEVROLET 86448
 C 1981 CHEVROLET 86448
 D 1981 CHEVROLET 86448
 E 1981 CHEVROLET 86448
 F 1981 CHEVROLET 86448
 G 1981 CHEVROLET 86448
 H 1981 CHEVROLET 86448
 J 1981 CHEVROLET 86448
 K 1981 CHEVROLET 86448
 L 1981 CHEVROLET 86448
 M 1981 CHEVROLET 86448
 N 1981 CHEVROLET 86448
 P 1981 CHEVROLET 86448
 Q 1981 CHEVROLET 86448
 R 1981 CHEVROLET 86448
 S 1981 CHEVROLET 86448

FUEL CONSUMPTION - CONSUMPTION DE CARBURANT
 ESTIMATE - ESTIMATION
 URBAIN URBAIN
 ROUTIERE ROUTIERE

REMEMBER: THE FUEL CONSUMPTION RATING AND ESTIMATES
 APPROVED TRANSPORT CANADA TEST PROCEDURES AND GUIDE
 WILL VARY DEPENDENT ON CONSUMPTION OF THE VEHICLE
 YEARS (DRIVE NUMBER, HOW WELL YOU MAINTAIN YOUR VEHICLE
 CONDITIONS. CONSULT THE CURRENT TRANSPORT CANADA
 FUEL CONSUMPTION GUIDE FOR FURTHER DETAILS

REMARQUE: LES NIVEAUX DE CONSUMATION ET D'ESTIMATION
 APPROUVES PAR LE SERVICE DES TRANSPORTS CANADA
 SONT BASEES SUR LES PROCEDURES ET LE GUIDE D'ESTIMATION
 QUI VONT VARIER EN FONCTION DE LA CONSUMATION DE
 VOTRE VEHICULE (NUMERO DE CHASSIS, LA MANIERE DE
 CONDUITE, L'ETAT DE VOTRE VEHICULE, LES CONDITIONS
 D'UTILISATION. CONSULTEZ LE GUIDE ACTUEL DES
 TRANSPORTS CANADA POUR PLUS DE DETAILS.

ESTIMATED TOTAL PRICE
 TOTAL AMOUNT
 TOTAL AMOUNT (Does not include
 dealer installed options or accessories
 additional to listed base or invoice price)

ESTIMATED CITY MILEAGE
 ESTIMATED HIGHWAY MILEAGE
 ESTIMATED AVERAGE MILEAGE

DISPLACEMENT, & NO. OF CYLINDERS
 CARBURETOR TYPE
 TRANSMISSION TYPE
 CATALYST EQUIPPED

1981 CHEVROLET "A" 14020865*	ISSUED	REVISION	DATE	SYB	BY	DATE	BY	DATE	BY	DATE	BY
1981 CHEVROLET "B" 14020866											
1981 CHEVROLET "T" 14020867											
1981 CHEVROLET "T" 14020869											
1981 CHEVROLET "X" 14020871											
1981 CHEVROLET "Y" 14020870											
1981 TRUCK "C-K" 14020862											
1981 TRUCK "C" 14020863											

DATE: 1981
 DIV: 24AP80
 DIV: CHEVROLET
 REF: ECK 86448
 NEW 09MY80
 SHEET: 9

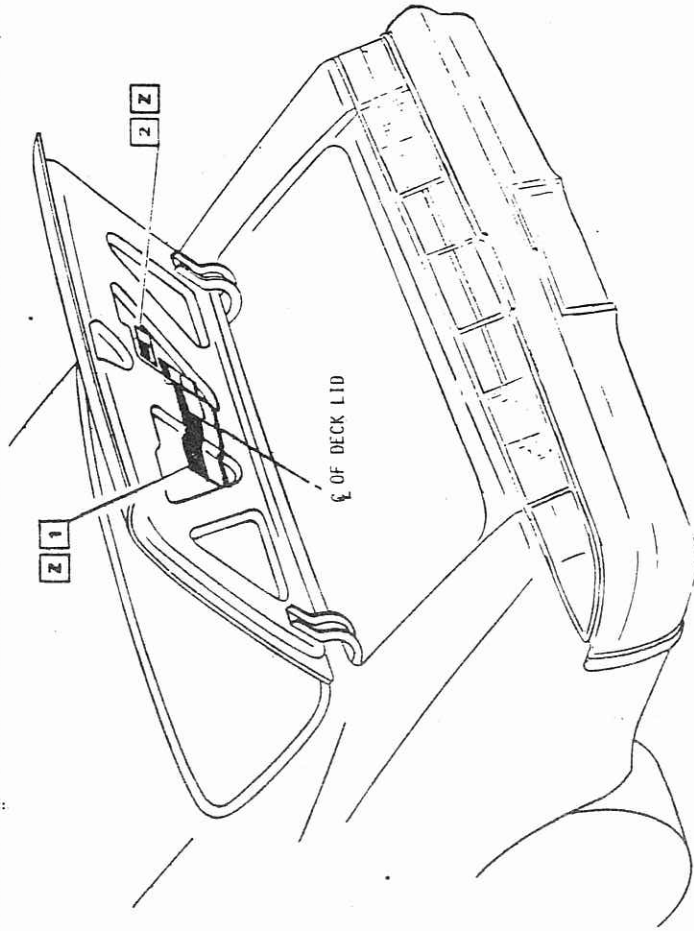
1



General Motors Corporation
CHEVROLET MOTOR DIVISION

PRODUCT DESCRIPTION MANUAL

ITEM REFERENCE PROCESS MATERIAL TORQUE EXISTING AS PART OF



- 14032195 **1** LABEL-AUTO JACK USAGE (14E)
- 10000182 **2** LABEL-CAUTION XN90

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

DYNAMIC (Instal) W/m	HAND (Instal) W/m	DATE	SYM	REVISION	AUTH	DR	CK	SM	DATE	OR L. MORENCY	DIV	TITLE	REF	QTY	QTY	QTY	QTY
△	△								25-7-80		CHEVROLET	1981 CHEV. "F" 14020867	ECR 86448				
△	△								25-7-80		CHEVROLET	AUTO JACK USAGE LABEL	C/O 25AP80				
△	△								25-7-80		CHEVROLET	FA00 ALL	1-96735-S				
△	△								25-7-80		CHEVROLET		1-96735-S				
△	△								25-7-80		CHEVROLET		1-96735-S				
△	△								25-7-80		CHEVROLET		1-96735-S				
FULLY DRIVEN SEATED & NOT STRIPPED																	
Ch	X	B	0	P	Cg												

39

11

OB

SHEET



General Motors Corporation
CHEVROLET MOTOR DIVISION

PRODUCT DESCRIPTION MANUAL
 ITEM REFERENCE PROCESS MATERIAL TORQUE EXISTING AS PART OF

UPC GROUP	PART NO.	PART NAME	QTY	SHIP INFO
1A2A	1242652 353960	MAT-FRT FLR MAT-RR FLR	2	<input checked="" type="checkbox"/> W <input checked="" type="checkbox"/> V
10B	337284 362089 474362 14009860 14012635 14023356 14018259 14034425 475018 352979 362091 474361 10013782 14035311 9590439 9590313 16010780 499728 329716 14005980	CAP UNIT-HUB FP00 &PE1 &ZJ7 8Z28 &N90 OR Z28 FP00 &N90 EXC Z78, F500 &N90 COVER UNIT-WHL TR FP00 &P01 F500 EXC N90 RING UNIT-WHL TR FP00 &P01 FP00 &Z28 EXC N90 FP00 &PE1 BEZEL-WHL FP00 &Z37 NUT UNIT-SECURITY WHL LKG F5000 &N18 LOCKING UNIT-WHL TR CVR F500 &N18 FOLDER-TIRE OWNERS GDE & GUARANTEE FOLDER-COMPACT SPARE TIRE OWNERS GDE & GUARANTEE MANUAL-CB RDO OWNERS &UP6 BRACKET-FRT LIC &VK3 ATTACHMENT UNIT-RR LIC &VK3	1 24 1	<input checked="" type="checkbox"/> W <input checked="" type="checkbox"/> V <input checked="" type="checkbox"/> Z <input checked="" type="checkbox"/> V <input checked="" type="checkbox"/> Z <input checked="" type="checkbox"/> X

UPC GROUP	PART NO.	PART NAME	QTY	SHIP INFO
14F	14021745 14021777 14021731 746697 52350481 14021736 14021737 14021798 52350568 9798083 746680	MANUAL-OWNERS FOLDER CONSUMER INFO EXC V78 OR Z49 FOLDER-VEH MAINT &L39 &N45; &LC3/L05/LG4/LM1 &L39 &N46 FOLDER-CANADIAN PASS. VEHICLE WARR &Z49 &N45 &N82 SUPPLEMENT-WARRANTY FOLDER &Z49 ENVELOPE-OWNER INFO BKLT SUPPLEMENT-OWNERS MANUAL &N44	1	<input checked="" type="checkbox"/> Z <input checked="" type="checkbox"/> Y <input checked="" type="checkbox"/> Z

- 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	SW	REVISION	DATE	BY	CHK	DATE	BY	CHK
01/12/80		1	01/12/80			01/12/80		
REORDER POINTS			MISCELLANEOUS SHIPPING LIST			1981 CHEV. "F" 14020867		
40			EGR VALVE			EGR VALVE		
40			EGR VALVE			EGR VALVE		



General Motors Corporation
 CHEVROLET MOTOR DIVISION

PRODUCT DESCRIPTION MANUAL
 □ ITEM REFERENCE △ TORQUE ▣ EXISTING AS PART OF

OD REPAIR PROCEDURES

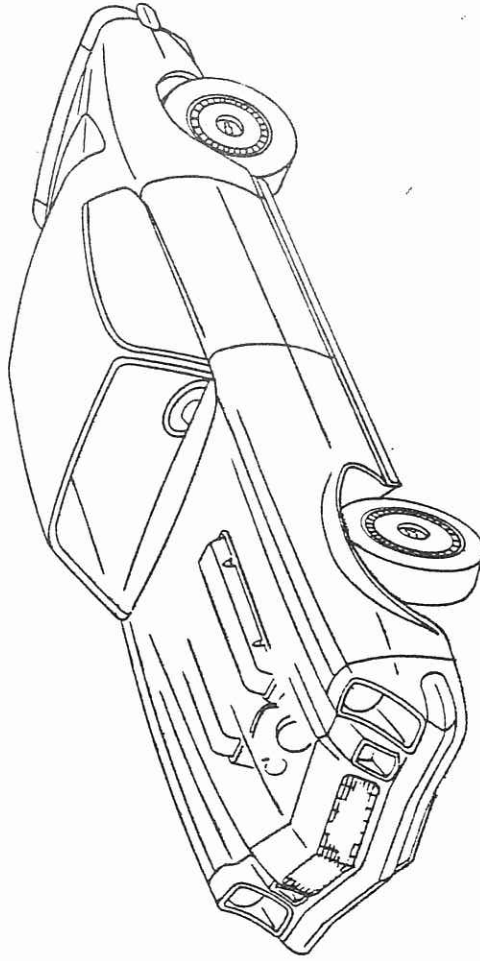
DIV. RESP. D

- OD-1 CONTENTS
- ② OD-2 TRANSFERRED
- OD-2.5 TRANSFERRED
- OD-3 TRANSFERRED

OE PAINT & TRIM EXTERIOR ORNAMENTATION

- OE-1 PAINT & TRIM EXTERIOR ORNAMENTATION FP87
- OE-2 PAINT & TRIM EXTERIOR ORNAMENTATION FS87
- OE-3 OPEN
- OE-4 ● PAINT & TRIM EXTERIOR ORNAMENTATION FQ87
- OE-5 PAINT & TRIM EXTERIOR ORNAMENTATION FS87

.....Z28
CC1 or C87



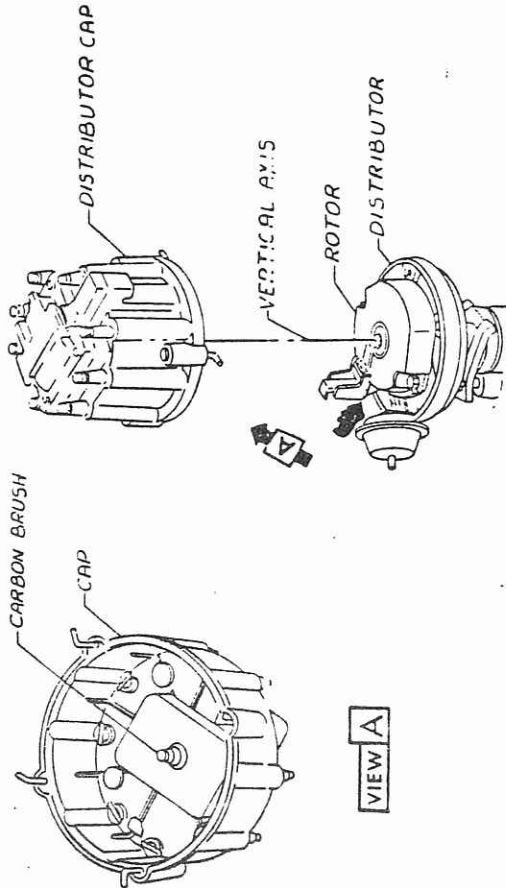
DATE	SYN	REVISION	AUTH	DE	CK	DATE	DIV
2/21/80	1	SHEET OE-3 REMOVED	8648	48	88	14 FEB 80	1981 CHEV. "F" 14020867
	2	SHEETS OD-2, OD-2.5 & OD-3 TRANSFERRED TO UPG 15-R	8648	AC/AB	88	14 FEB 80	CHEVROLET
							CHEVROLET
							CONTENTS-REPAIRS & ORNAMENTATION
							FAO ALL
							NEW DONOR
							UPC
							OD
							SHEET
							1

★ Instructions Carryover
 ● Waiting Info.

C	X	B	0	P	Ca
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PRODUCT DESCRIPTION MANUAL
 PROCESS MATERIAL TORQUE EXISTING AS PART OF

General Motors Corporation
 CHEVROLET MOTOR DIVISION



**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.

EWD

TRANSFERRED
 INFORMATION NON 152
 SEE SECTION

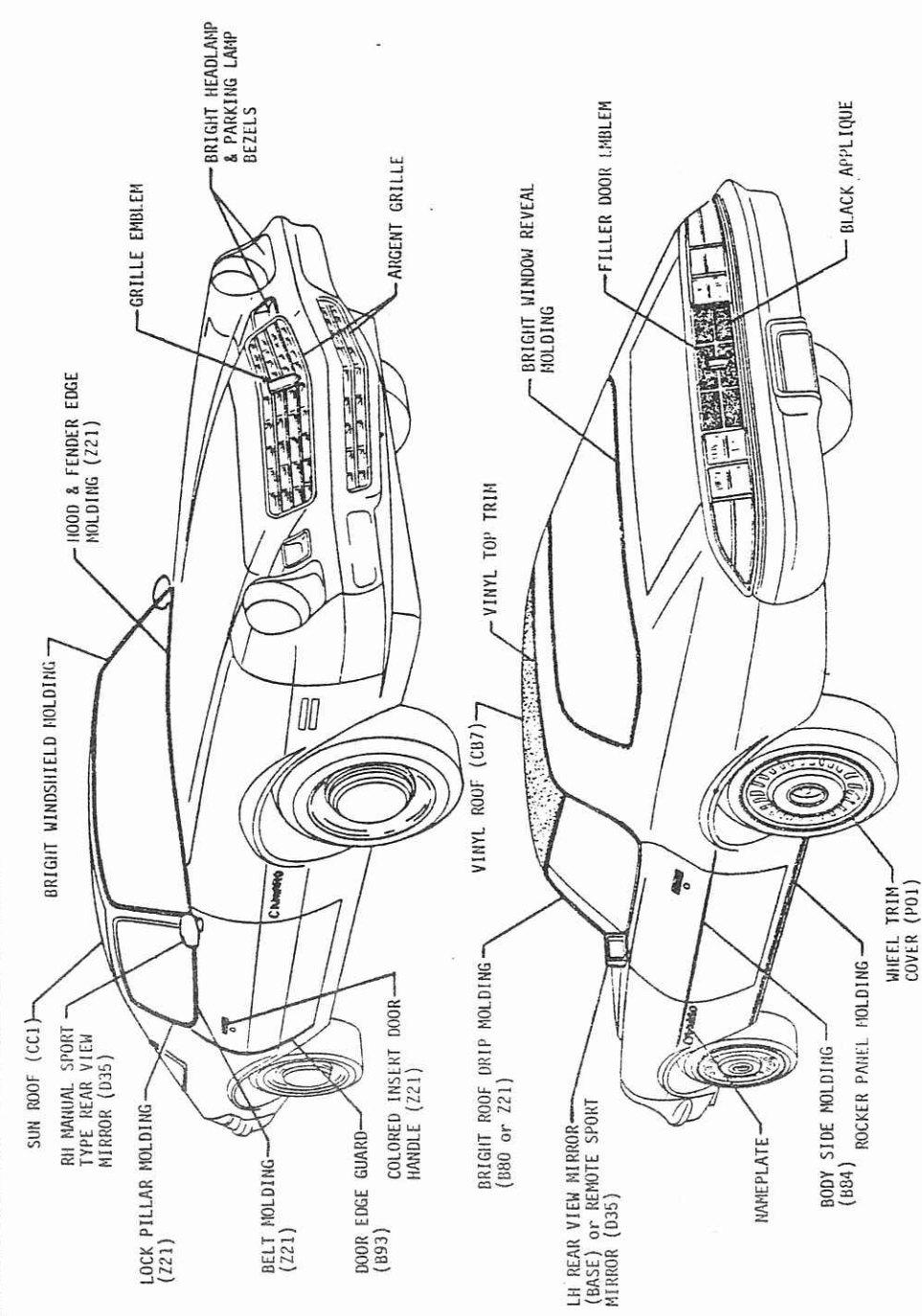
1981 CHEVROLET "A" 14020865	DATE	SIM	REVISION	AUT	DR	CR	CHK	DATE	DIV	TITLE	SHEET
1981 CHEVROLET "B" 14020866	15/11/80	/	SHEET TRANSFERRED	80-448	7D	WB		14FE80	CHEVROLET	DISTRIBUTOR CAP REMOVAL	2
1981 CHEVROLET "F" 14020867								DR L. DAVIS		ALL PASS. V6 or V8 ENGINE	OD
1981 CHEVROLET "X" 14020871								CR J. J. Buckle HB			
1981 CHEVROLET "Y" 14020870								APPR	REF ECR 864-8		
								APPR	C/O 07DE79		
								APPR	OD-2		
				42							

Cl	X	0	0	P	Cn
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PRODUCT DESCRIPTION MANUAL
 EXISTING AS PART OF

ITEM REFERENCE PROCESS MATERIAL TORQUE

General Motors Corporation
CHEVROLET MOTOR DIVISION



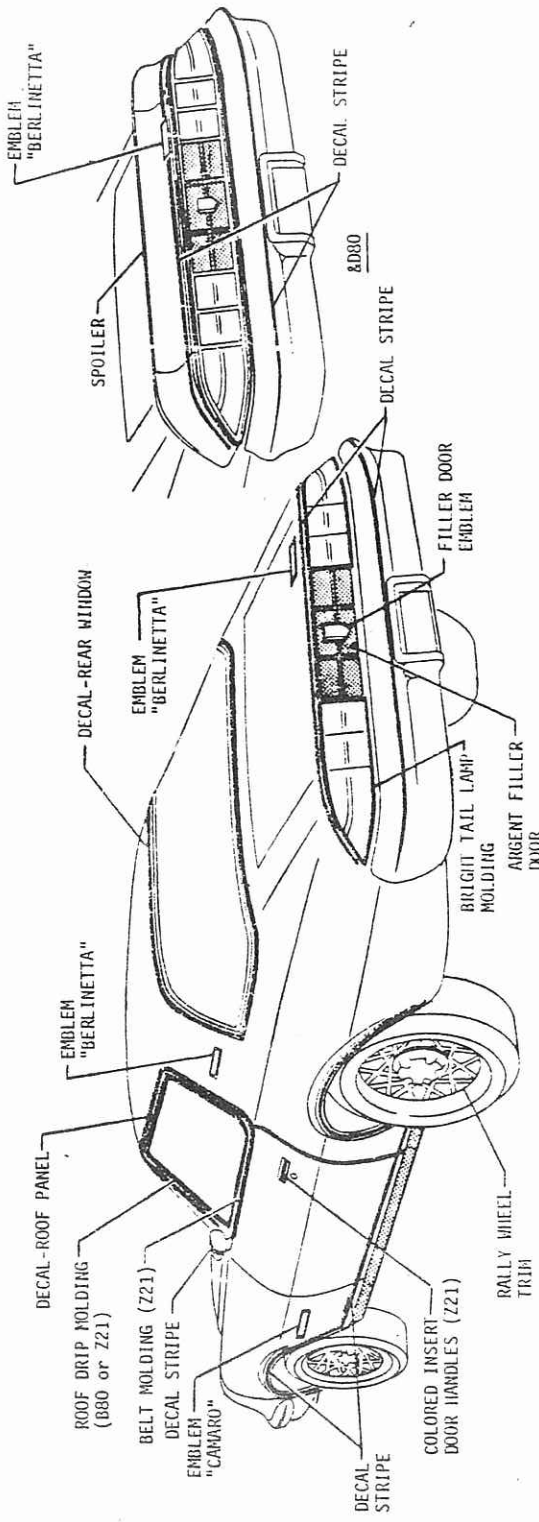
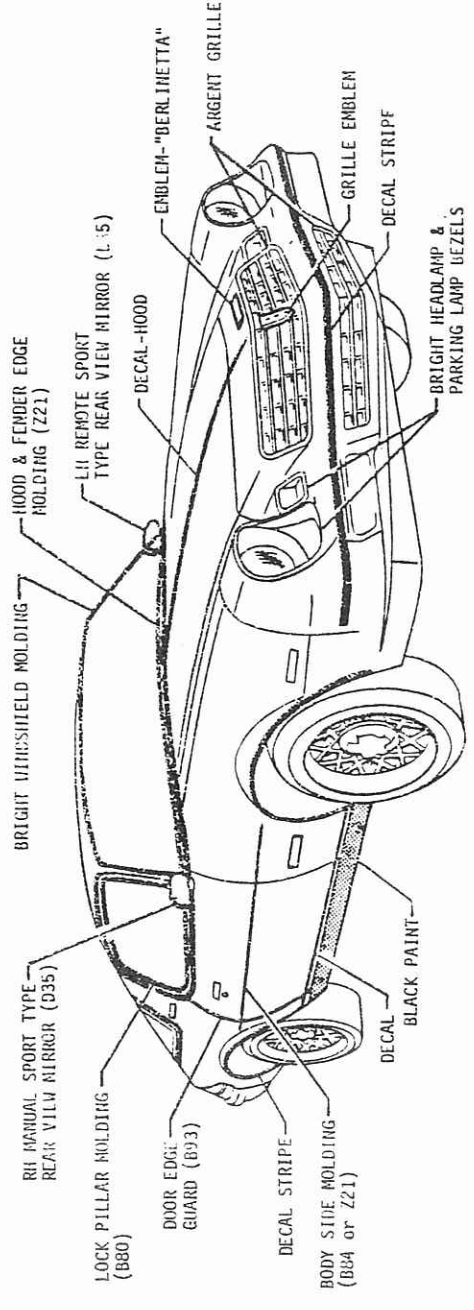
DYNAMIC (Instal) / Mm		DATE	SYN	REVISION	AUTH	DR	CK	ASH	DATE	DIV	TITLE		
<input type="checkbox"/>	<input type="checkbox"/>								1/18/82	CHEVROLET	1981 CHEV. "F" 14020867		
<input type="checkbox"/>	<input type="checkbox"/>								UR L. DAVIS		PAINT & TRIM EXTERIOR ORNAMENTATION		
<input type="checkbox"/>	<input type="checkbox"/>								APP		FP87 ALL		
<input type="checkbox"/>	<input type="checkbox"/>								APP				
<input type="checkbox"/>	<input type="checkbox"/>								APP				
<input type="checkbox"/>	<input type="checkbox"/>								APP				
REF ECR 86448 C/O 04AP80 OE-1											UPC	OE	SHEET
43													1

△ FULLY DRIVEN, SEATED & NOT STRIPPED

Ch B O P Co

PRODUCT DESCRIPTION MANUAL
 CREATING AS PART OF

General Motors Corporation
CHEVROLET MOTOR DIVISION



DYNAMIC (Incl) W/m		HAND (Incl) W/m		DATE	SYM	REVISION	DIV		1981 CHEV. "F" 14020867		
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>				CHEVROLET		PAINT & TRIM EXTERIOR ORNAMENTATION		
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>				REF ECR 86448 C/O DAAP80 OE-2		FS87 ALL		
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>				DATE 11/1/80 OR L. DAVIS		UPC		
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>				APPR		SHEET 2		
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>				APPR		OE		
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>				APPR		UPC		
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>				APPR		SHEET		
46											

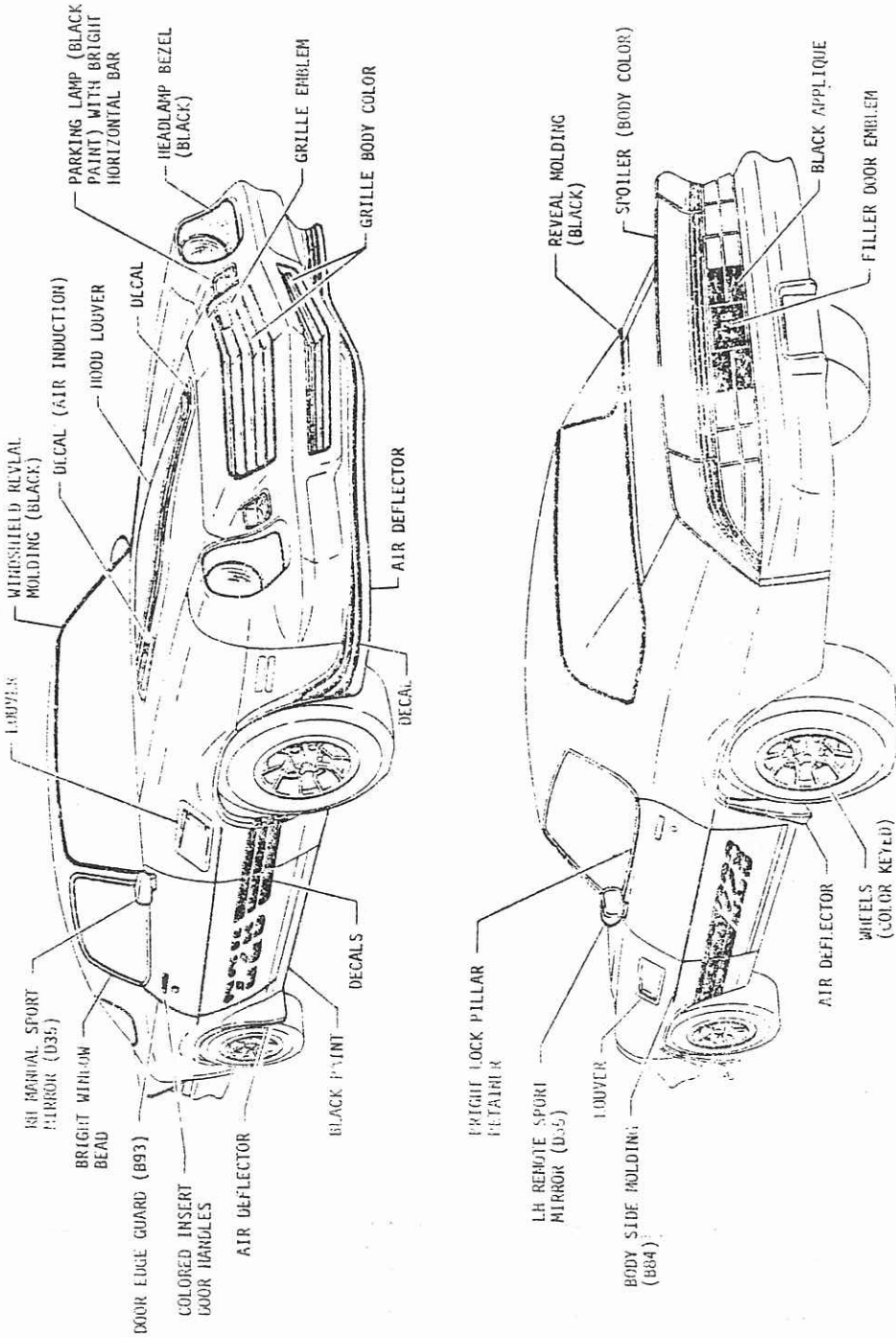
FULLY DRIVEN, SEATED & HOT STRIPPED

Ch B O P Co

PRODUCT DESCRIPTION MANUAL

ITEM REFERENCE PROCESS MATERIAL TORQUE EXISTING AS PART OF

General Motors Corporation
CHEVROLET MOTOR DIVISION



DATE	SYN	REVISION	DATE	BY	DATE	BY	DATE	BY	DATE	BY	DATE	BY
			23/07/80	L. DAVIS/JCA								
DR												
CC												
APP												
APP												
APP												
APP												
<p>1981 CHEV. "F" 14020867</p> <p>TITLE</p> <p>PART & TRIM EXTERIOR ORNAMENTATION</p> <p>FPB/ 8Z78</p> <p>CHEVROLET</p> <p>ECR 86448</p> <p>NEW 07/80</p> <p>UVC</p> <p>WELT</p> <p>4</p>												
<p> <input checked="" type="checkbox"/> FULLY DRIVEN, STATED & NOT STRIPPED </p> <p> <input checked="" type="checkbox"/> B <input checked="" type="checkbox"/> O <input type="checkbox"/> P <input type="checkbox"/> C </p>												