

# **1963-1967 Corvette Assembly Process**

**Chassis And Final Assembly  
NCRS National Convention**

**July 20, 2011**

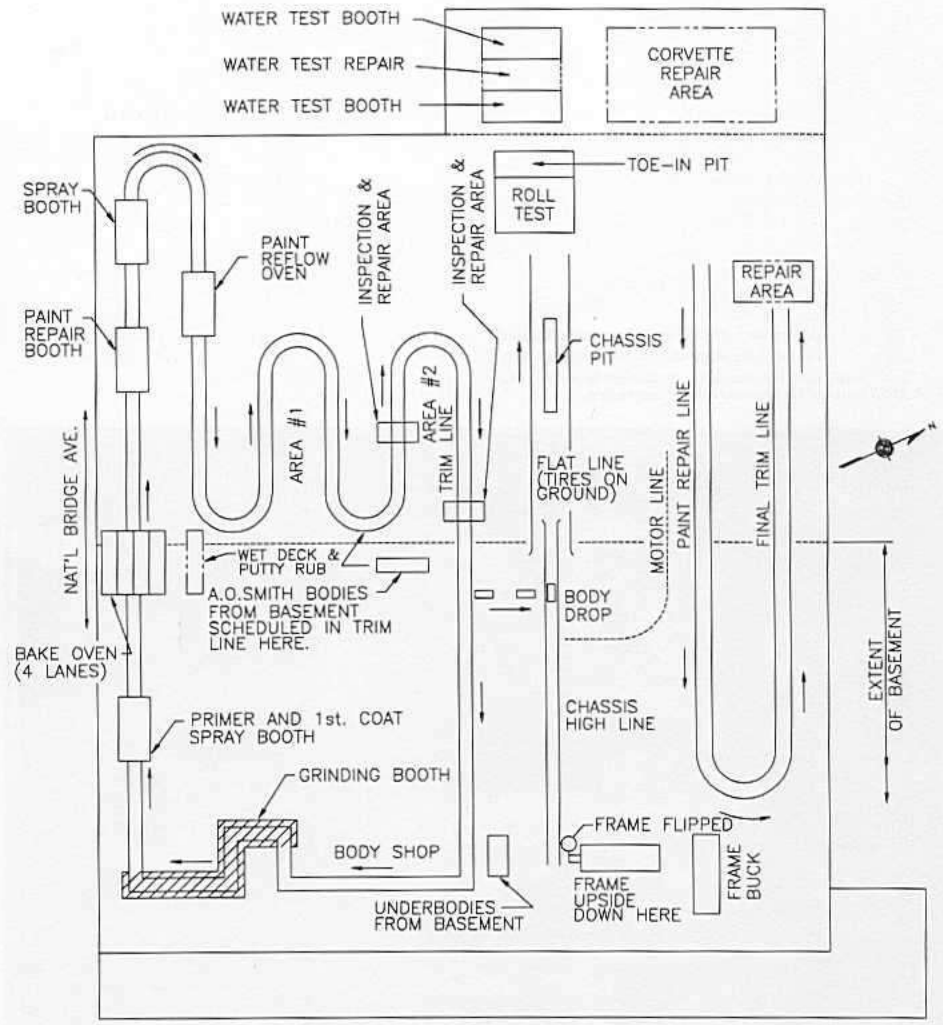
**John Hinckley**

# **Chassis To Final Sequence**

- **Chassis Line - Elevated Floor Conveyor**
- **Final Line - Flat-Top Strand Conveyor**
- **Final Process - Driven On Wheels**
- **Final Trim Line - Strand Conveyor**

# Chassis Line

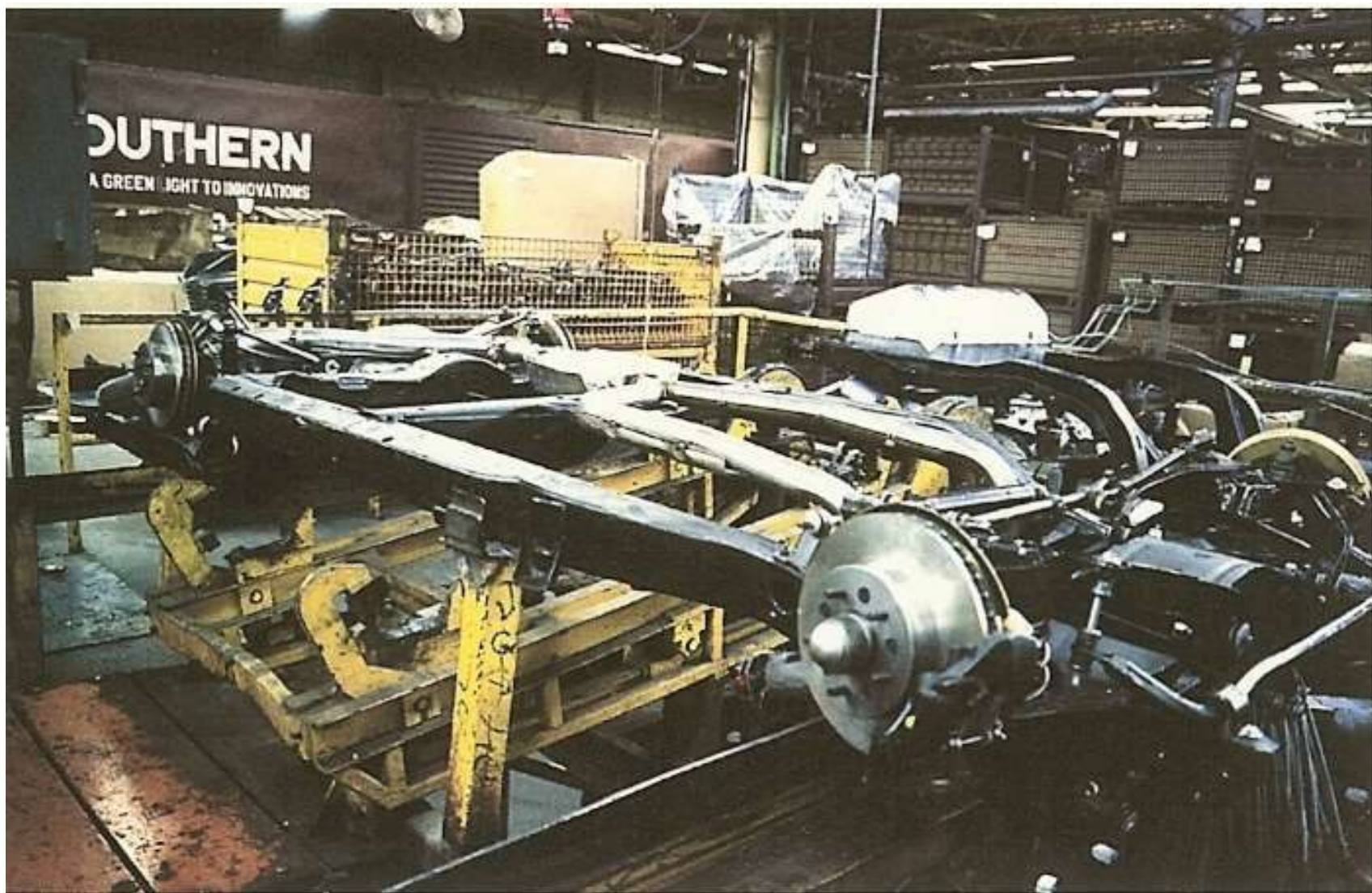
- **Gas Tank, Gas & Brake Lines**
- **Frame VIN Derivative Stamp**
- **Exhaust System**
- **Engine/Transmission/Driveshaft**
- **4-Speed Shift Linkage**
- **Brake Bleed & Test, Install Battery**
- **Chassis Blackout & Body Mount Shims**



CORVETTE BLDG.

NOT TO SCALE

R.R. (TYP)







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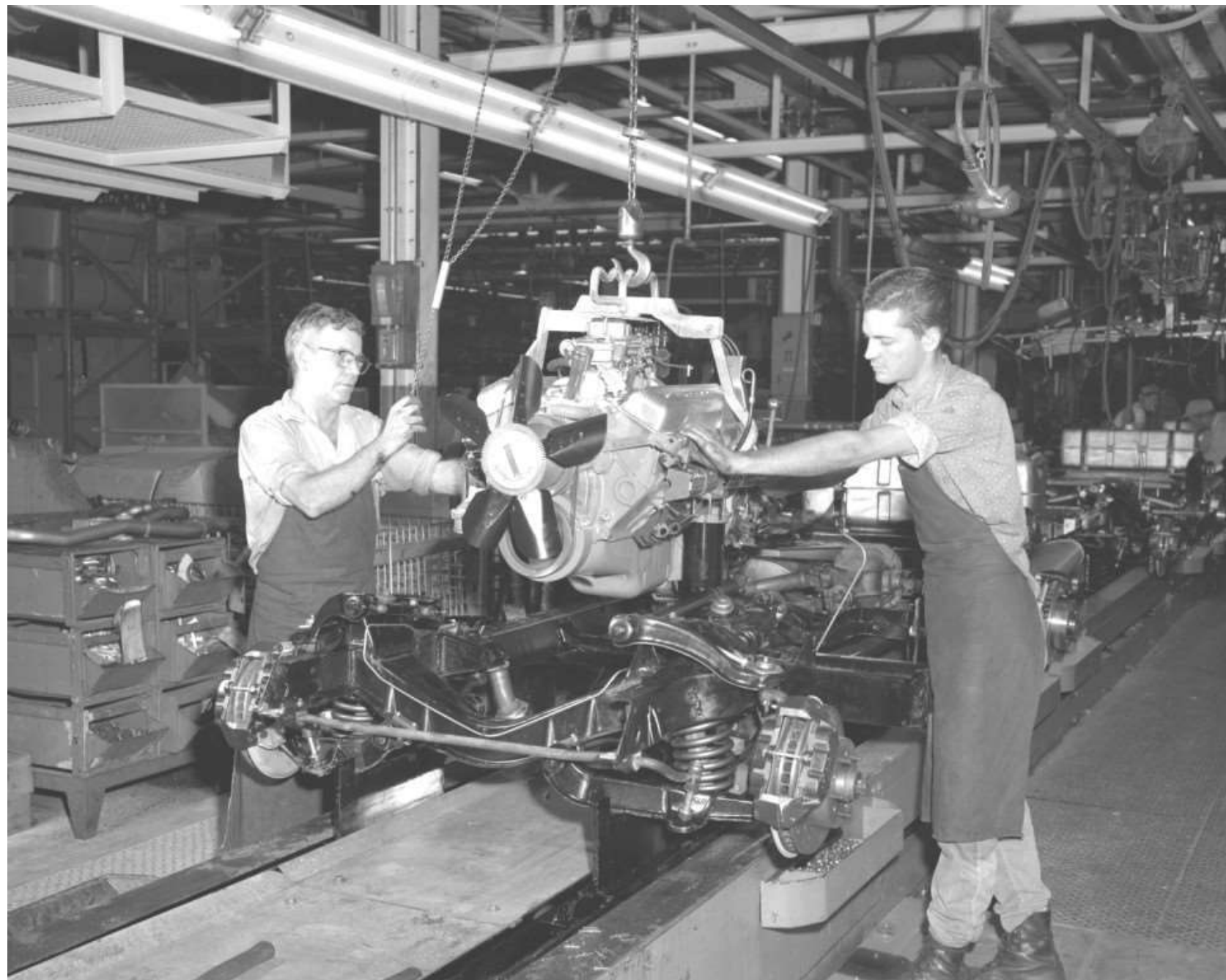




















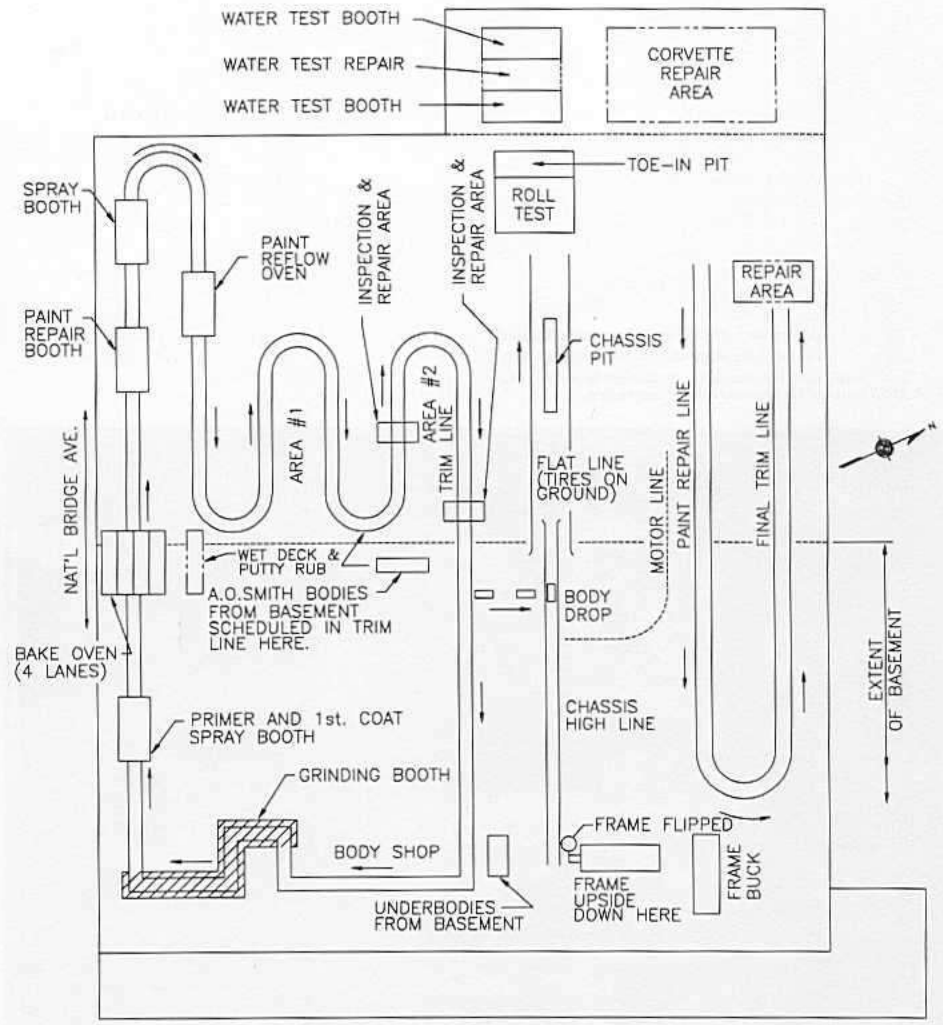






# **Final Assembly**

- **Body Drop To End Of Final Line**
- **Roll Test & Toe-In**
- **Water Test**
- **Final Paint Repair**
- **Final Trim Line**
- **Headlight Aim, Inspection & Ship**



CORVETTE BLDG.

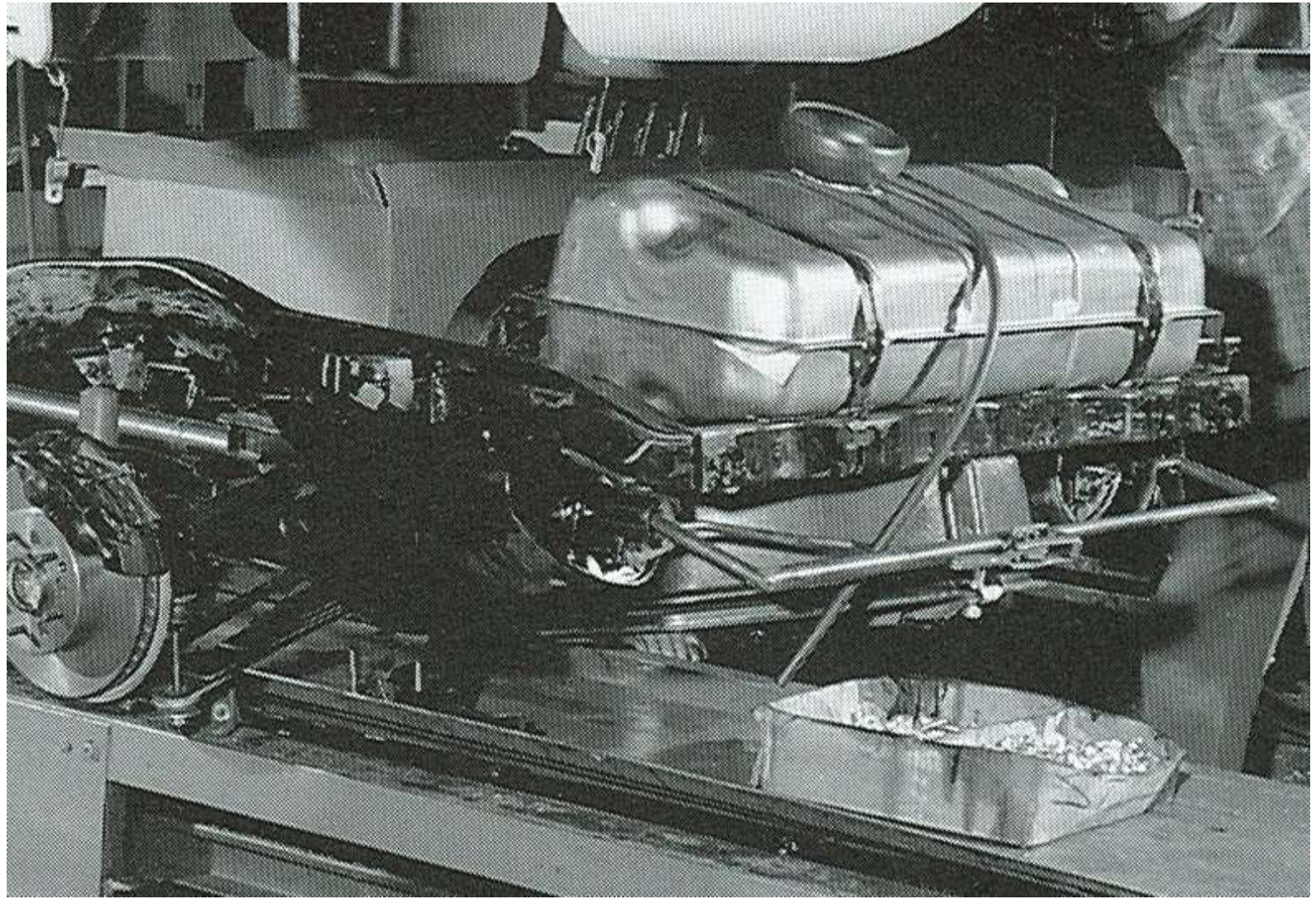
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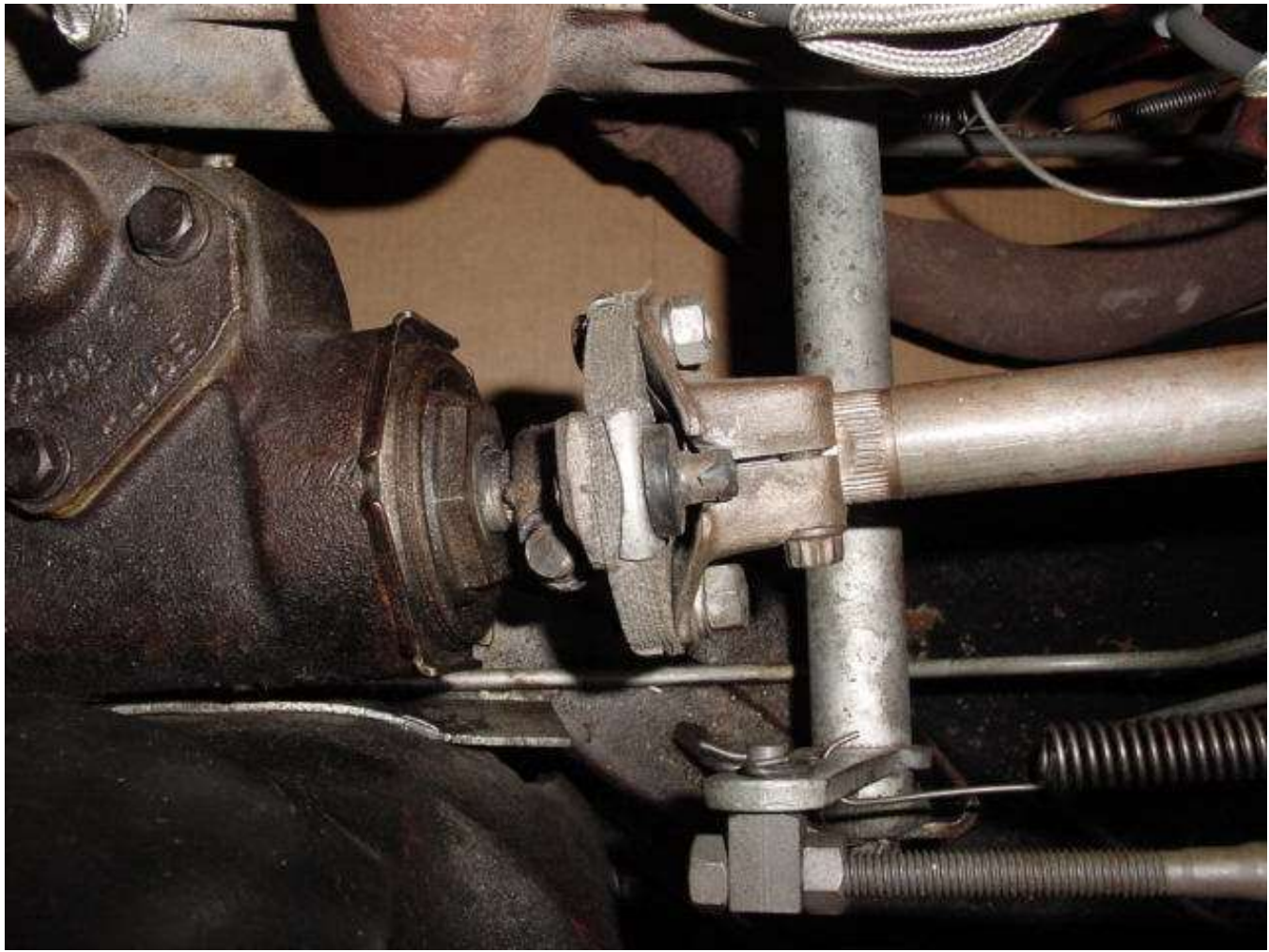
R.R. (TYP)

# **Final Line Operations**

- **Body Drop**
- **Grille, Bumpers, Rear Valance Panel**
- **Wheels & Tires, Rockers & N14 Covers**
- **Underbody/Underhood Button-Up**
- **A/C Refrigerant & Coolant Fill**
- **Convertible Top**
- **Gas Fill, Prime, Car Start, Documents**







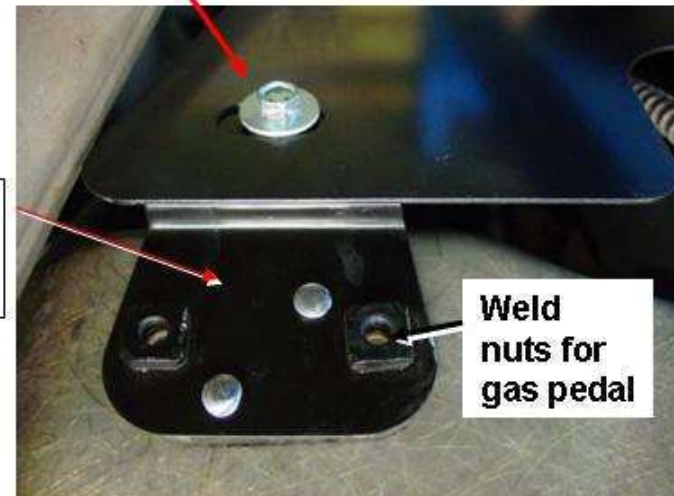
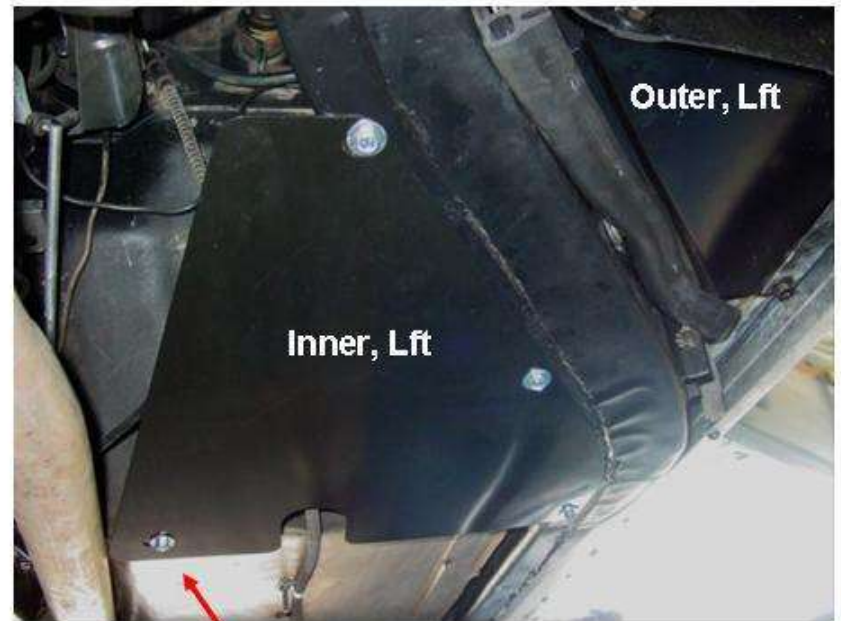
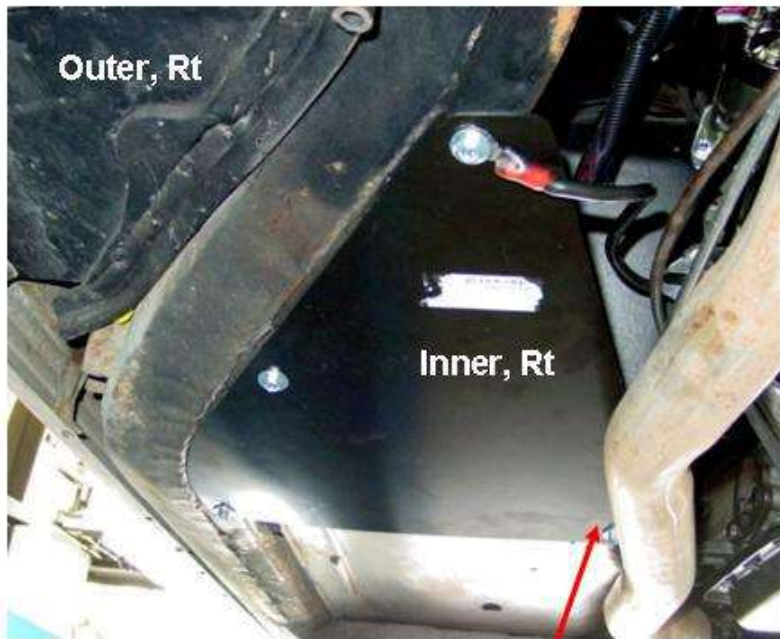
















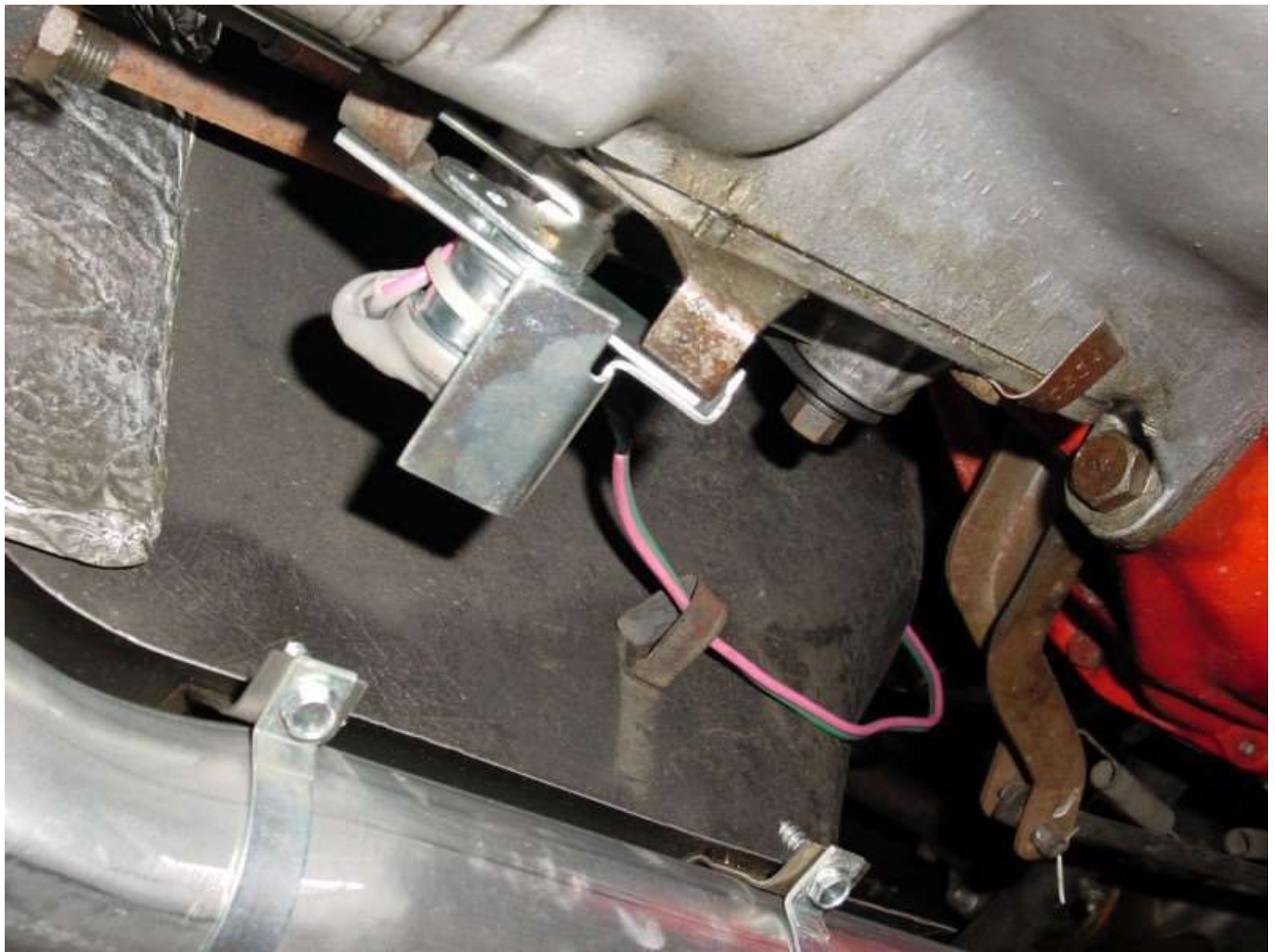


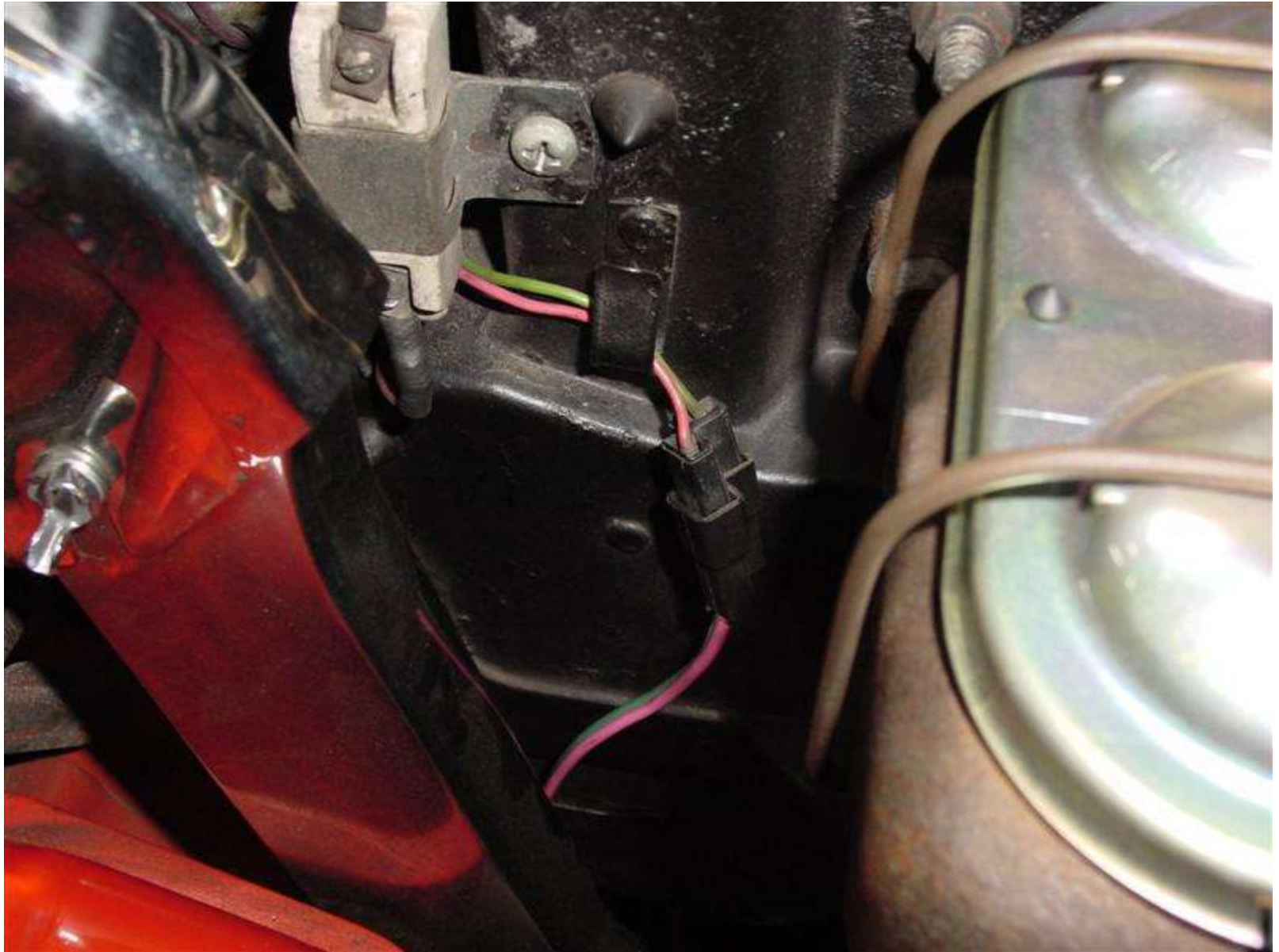




























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CHEVROLET MOTOR DIVISION  
GENERAL MOTORS CORPORATION

Dealer To Whom Delivered **HARRY MANN CHEVROLET CO** **813516**  
**5735 CRENSHAW BLVD**  
**20307 LOS ANGELES CALIF**

Delivered To Dealer At (If Different From Above) **6810 WEST BLVD**  
**LOS ANGELES 43 CA**

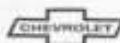
Make **CHEVROLET**  
Vehicle Identification Number **194376S 110847** Final Assembly Point **ST. LOUIS, MISSOURI**

Manufacturer's Suggested Retail Price: (Includes Federal Excise Tax & Suggested Dealer Delivery & Handling Charge)		
Model:	<b>19437 CORVETTE SPT CPE</b>	<b>4265 00</b>
Destination Charge		<b>141 75</b>
	<b>Subtotal</b>	<b>4406 75</b>

Manufacturer's Suggested Retail Delivered Prices on Options and Accessories installed on this Vehicle by the Manufacturer		
<b>2M21AA</b>	<b>4 SPD CL RATIO TRAN</b>	<b>182 98</b>
<b>2982AA</b>	<b>MOSPORT GREEN</b>	<b>00 00</b>
<b>2A31AA</b>	<b>POWER WINDOWS</b>	<b>57 51</b>
<b>2A01AA</b>	<b>TINTED GLASS</b>	<b>15 68</b>
<b>2U69CB</b>	<b>P8 AM/FM RADIO</b>	<b>197 62</b>
<b>2K66BA</b>	<b>TRANSISTOR IGN EQ</b>	<b>73 19</b>
<b>2N11AA</b>	<b>OFFROAD SER EXHAUST</b>	<b>36 60</b>
<b>2P92AA</b>	<b>775X15X2 PLY WSW</b>	<b>31 13</b>
<b>2G81NA</b>	<b>POSITRACT AXLE 37OR</b>	<b>41 82</b>
<b>2L72AA</b>	<b>425 HP V-8 TURBOJET</b>	<b>310 54</b>

* BASED ON REDUCED EXCISE TAX RATE EFFECTIVE JAN. 1, 1966		
Factory Installed Options And Accessories	<b>Subtotal</b>	<b>947 07</b>
<b>Total Amount</b> (Does not include dealer installed options or accessories, state or local taxes, or license)		<b>\$ 5353 82</b>

THIS LABEL AND THE INFORMATION THEREON HAS BEEN AFFIXED TO THIS MOTOR VEHICLE BY CHEVROLET MOTOR DIVISION, GENERAL MOTORS CORPORATION, PURSUANT TO THE REQUIREMENTS OF PUBLIC LAW 85-906, 85TH CONGRESS, WHICH PROHIBITS THE REMOVAL OR ALTERATION OF THIS LABEL PRIOR TO THE TIME THAT SUCH AUTOMOBILE IS DELIVERED TO THE ACTUAL CUSTODY AND POSSESSION OF THE ULTIMATE PURCHASER.



CHEVROLET MOTOR DIVISION

Corvette  
Order

7

Ident. No.	Date Received	Exp. Date of Prod.	Order Number	Zone No.	Dealer	COPO/FB50
813357	12-29-65	01-21-65	09352	61	425	
Model			Paint		Prod. Seq. No.	
19467 CORVETTE CONVERT			2972AA ERMINE WHITE			

Equip. Code	Option No.	Type	Description
	24078A	Trim	RED TRIM
	STD EN	Engine	STD ENGINE
		Air Con.	
		Transistor Ign.	
	2G81CA	Axle	POSITRACT AXLE 336R
	2M20AA	Transmission	4 SPD TRANSMISSION
	2P92AA	Tires	775X15X2 PLY WSW
	2C058A	Conv. Top	CONVERT TOP WHITE
		Aux. Top	
	2U69AA	Radio	PB AM/FM RADIO
		Comfort & Con.	
	2A02AA		TINTED WINDSHIELD
	2Y55AA		PB AM/FM RADIO
	2Y58AA		TINTED WINDSHIELD
	2Y608A		CONVERT TOP WHITE
	2Y718A		RED TRIM
	2Y908B		ERMINE WHITE
	2Y99YB		CORVETTE CONVERT

*BR*

112024

Carburetor Code	H
Engine Number	F0118HE
Rear Axle No.	AM 1-6
Transmission No.	P0113
Key Number	8698 & 8704
Date Produced	1-25-66

Serial Number	Invoice Number	Driver	Row	Spot	Driver
1946765 112024					
OPTION TOTAL 15		Loading Dock	<input type="checkbox"/>	Haul-away	<input type="checkbox"/>

CHEV. 200C REV. 5-65 PRINTED IN U.S.A.

7. DEALER'S COPY



1/2 VLGHEK W1416 ALLOY U.S.A. 7/16





# Car Shipper

(Dealer Copy)

HARTZ CHEVROLET INC  
61425 MENOMONEE FALLS WIS

811495

110539

1946765

ST. LOUIS, MISSOURI

19467 CORVETTE CONVERT

4056 00

56 25

4112 25

2R20AA	4 SPD TRANSMISSION	182 98
2C71CA	POSITRACT AXLE 336R	41 82
2U69AA	PS AM/FM RADIO	197 62
2984AA	SUNFIRE YELLOW	00
2P92AA	775X15X2 PLY MSW	31 13

9178

8377

\* BASED ON REDUCED EXCISE TAX RATE  
EFFECTIVE JAN. 1, 1966

493 55

4565 80

For:

GMAC 2036

Dealer Order 148

09353

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# L RECORDS

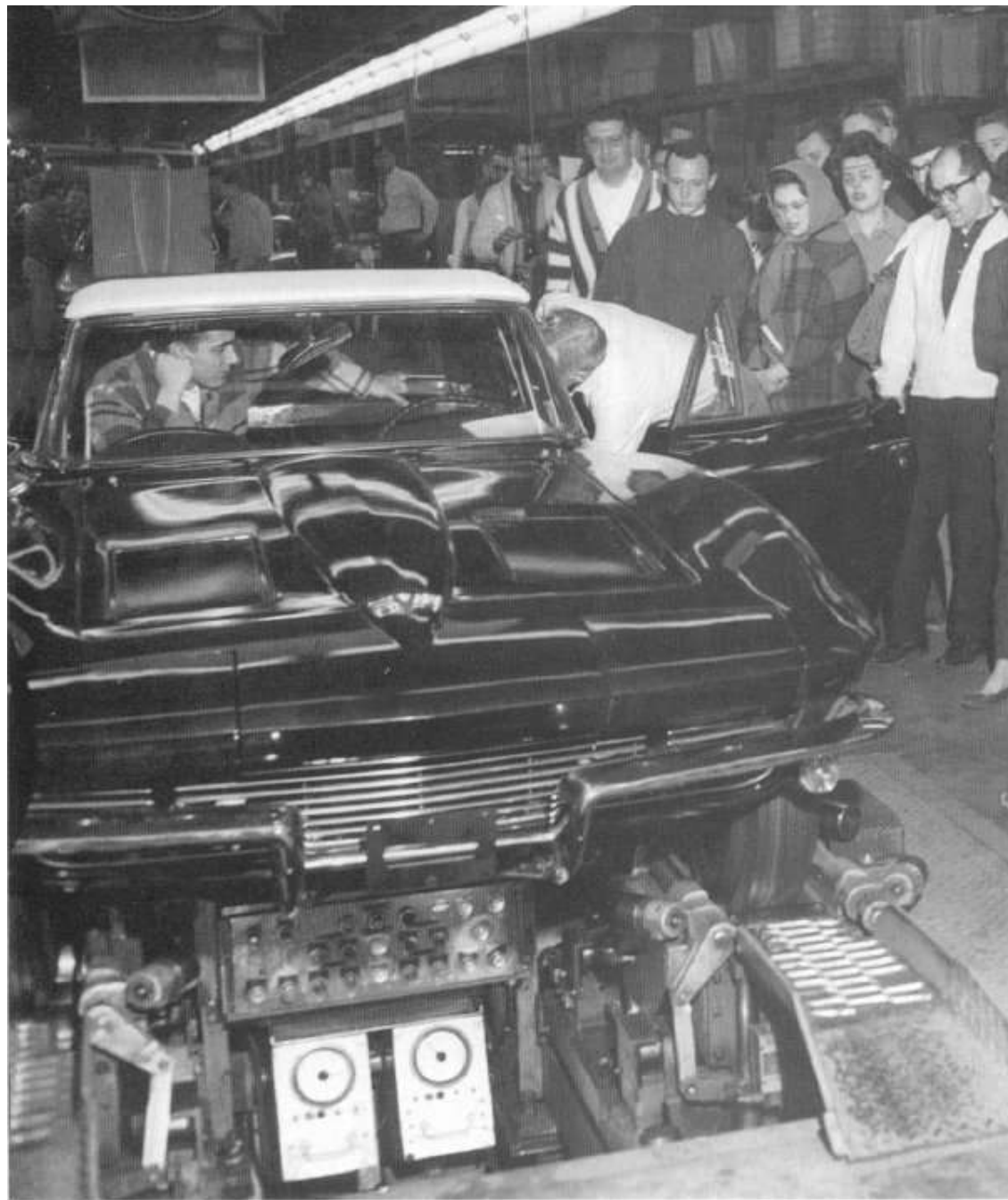
SERIAL NO. 900638

QRS  
X-30  
AZ  
XN  
QCO  
AB

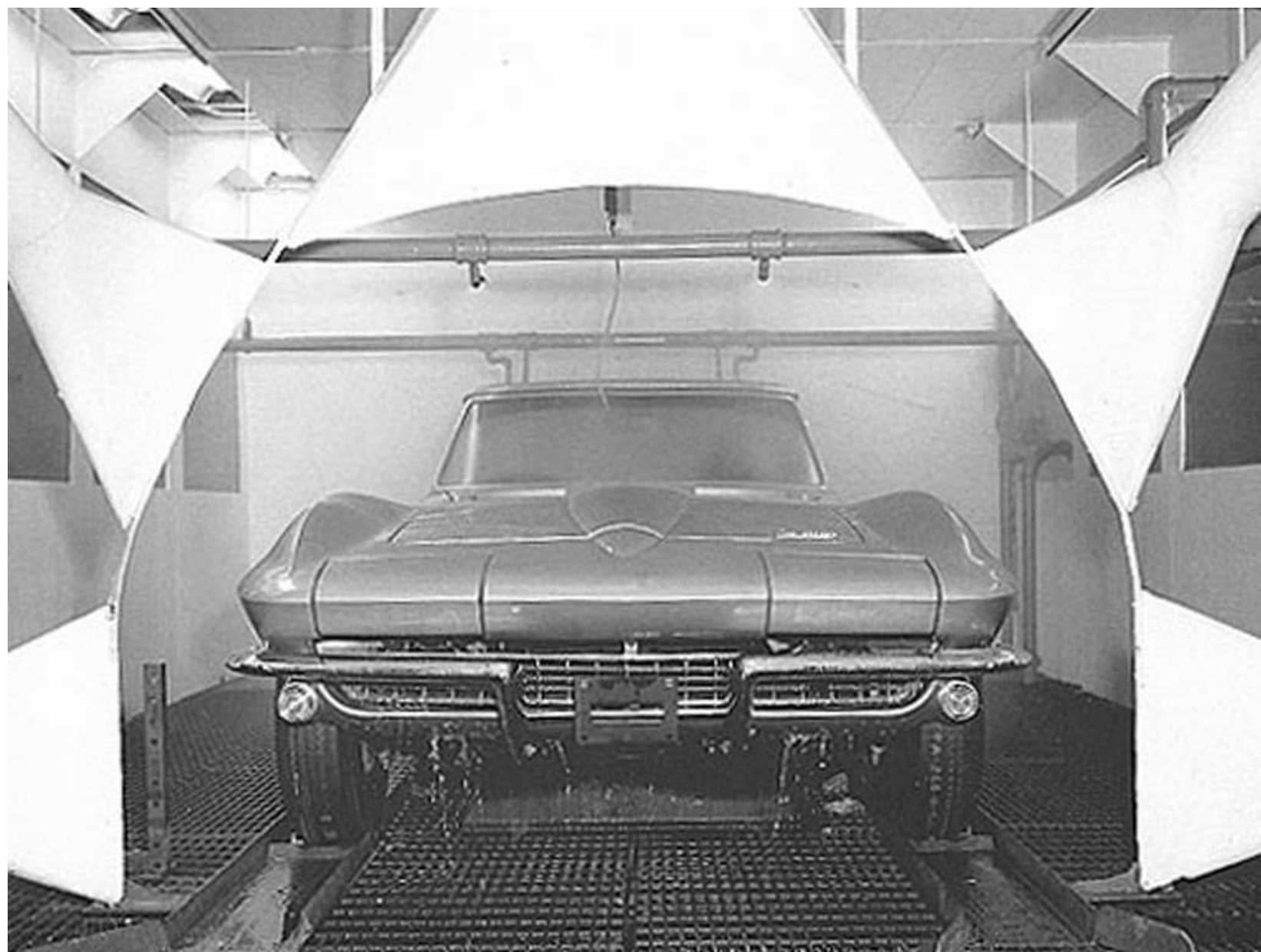
L	R	ITEM DESCRIPTION	REP	INSP
L		456 WHEEL ASM FRT REAR dam shy wrq*		
L		456 TIRE ASM FRT REAR pop wrq shy flat*		
L		401 B/BOLTS CUSHION INSULATORS # 2 lse shy*		
L		401 B/BOLTS CUSHION INSULATOR #4 lse shy*		
L		INTR CONT CIG LIGHTER INST PNL LITE out		
L		DIST WIRE COVER seat pos lse shy*		
L		BACK UP WIRE TACH WIRE clip lse shy*		
L		TEMP WIRE pos lse shy*		
L		SPEEDO CABLE GROMMET SEALER lse shy wrq*		
L		419 M/CYL LINES shy lse dam pos*		
L		419 POWER BRAKE HOSE CLIP pos shy wrq*		
L		CLUTCH JAM NUTS GREASE PIN lse shy*		
L		CLUTCH SPRING lse shy*		
L		CLUTCH FREE TRAVEL adj		
L		440 BRAG JOINT distort space align lse shy*		
L	R	FW/S/WSHR WPR ARM & BLD PATTERN adj shy inop		
L		467 ACCEL BRKT SPRG CABLE bind lse shy wrq*		
L		PCV HOSE VALVE GROMMET clip pos shy		
L		431 EXH EMISSION HOSE AT pos wrq shy*		
L		431 EXH EMISS AT CARB/CLAMP pos lse wrq shy*		
L		ALTERNATOR WIRE HARNESS BRKT pos lse shy		
L		ALTERNATOR WIRE BOOT pos lse shy		
L		UPPER RAD HOSE CLAMP pos lse wrq shy		
L		POWER WINDOW SWITCH pos shy inop		
L		CONTROL ARM FLAP pos lse shy		
L		NO ELJC CHECK PIT BATT VAC no prr		
L		BATT W CABLE grease lse pos shy		
L		DOOR WONT OPEN/CLOSE (fit dbag squeak)		
L		COURTESY LIGHT/DOME stays on out		
L	R	HEADLIGHTS HI LOW IND stays on out		
L		HEADLIGHT WARNING LIGHT BUZZER stays on out		
L	R	HEADLIGHT DOOR slow won't/open won't/close		
L	R	TAIL LIGHTS stays on out		
L	R	BRAKE LIGHTS stays on out		
L		MARKER LIGHTS FRT REAR stays on out		
L		LICENSE LIGHTS stays on out		
L	R	DIRECTIONAL LIGHTS stays on out		
L	R	HAZARD LIGHTS stays on out		
L		DIRECTIONAL LEVER REG K30 shy wrq		
L		DASH WIRES pos clip rts		
		U41 FUEL MODUL inop		
		OIL GAGE INDICATOR inop		
		HARNESS WIRE CLIP pos lse shy		
L		106 DOOR STRIKER dam pos lse*		
		DIP STICK TUBE lse pos shy		
		WIRE UNDER DIST COVER pos lse		
L		POWER DOOR LOCKS shy inop		
L		401 B/BOLT #3 INS CUSH COVER PLATE lse shy *		

L RECORDS  
OK DATE 6

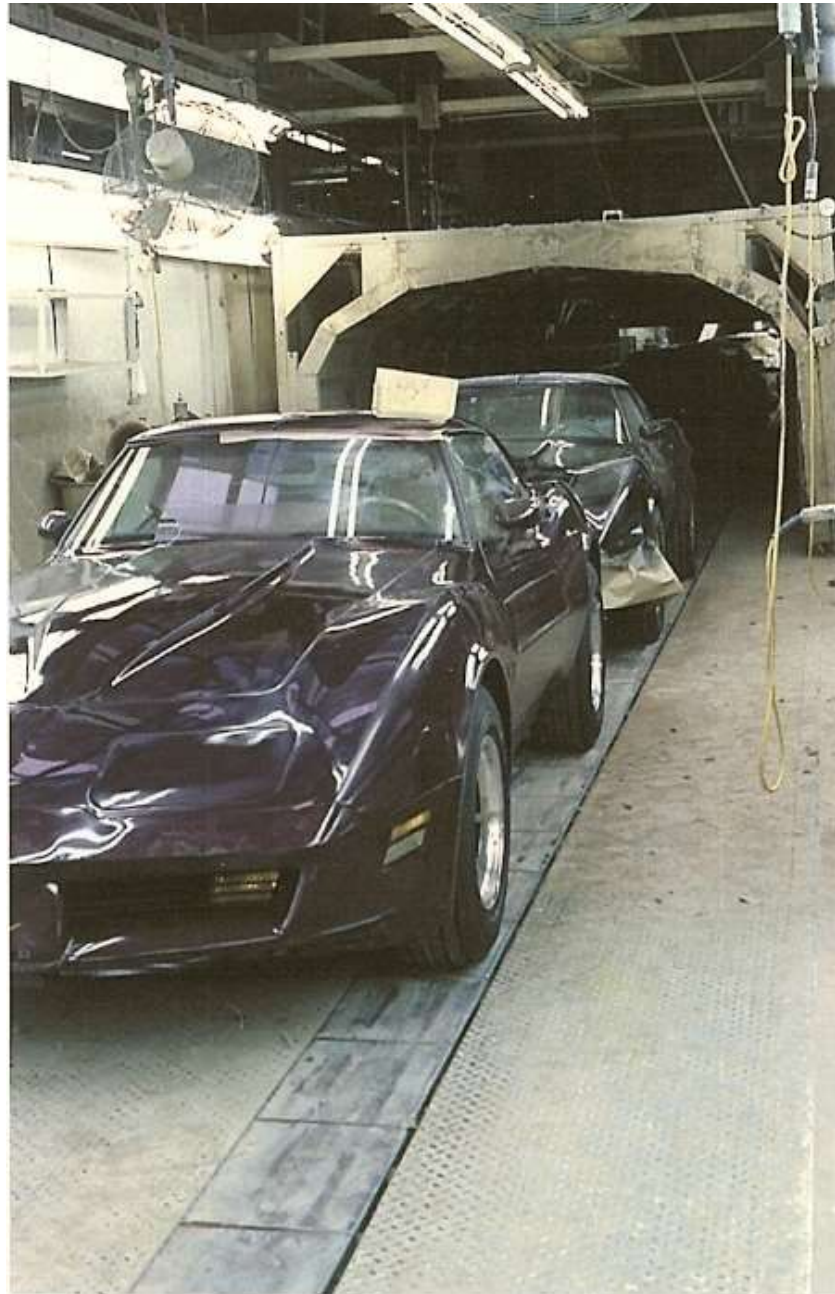












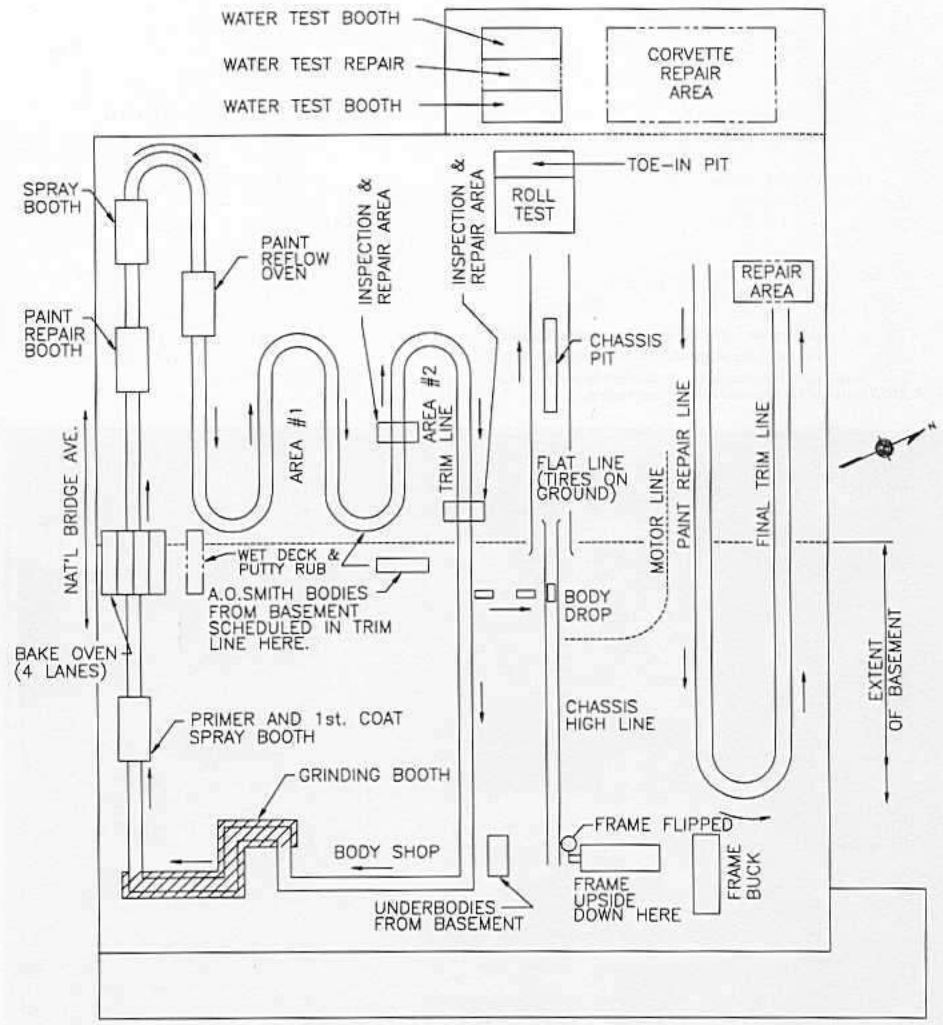












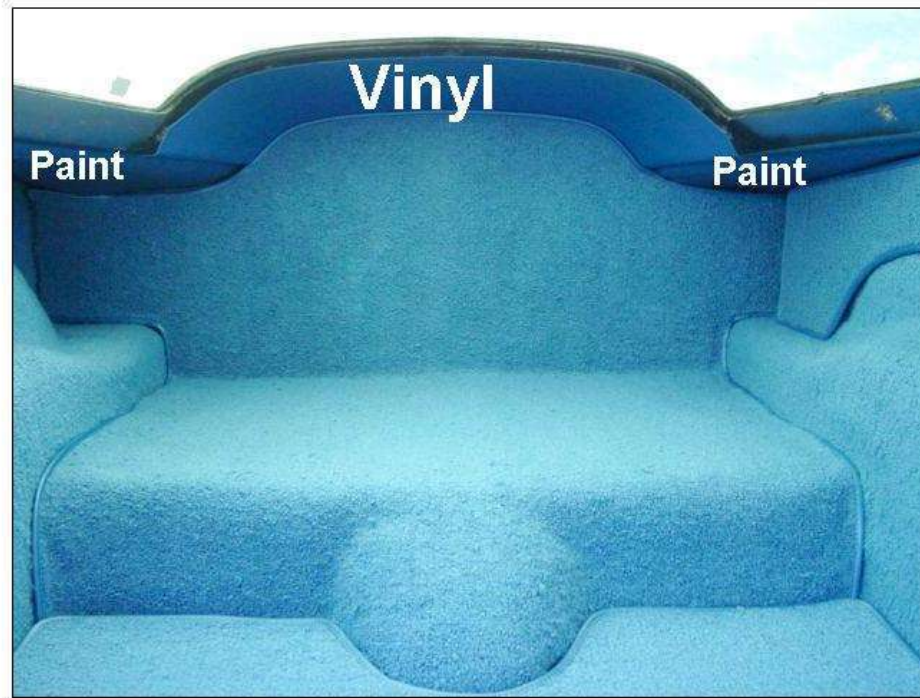
CORVETTE BLDG.

NOT TO SCALE

R.R. (TYP)

# **Final Trim Line Operations**

- **Back Window Garnish Moldings**
- **Rear Carpets, 1/4 Trim, Jack Board**
- **Door Trim Panels, Cranks, Handles**
- **Front Carpets, Sill Plates, Seat Belts**
- **Center Pad, Shifter Console Plate**
- **Seats**
- **Inspection, Final Polish, Ship**



**Rear carpet sans window trim**



























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blue  
1984

1984

invoice.  
CHEV. CO.  
Miller

### MANUFACTURER'S STATEMENT OF ORIGIN TO A MOTOR VEHICLE

The undersigned CORPORATION hereby certifies that the new motor vehicle described below, the property of said CORPORATION, has been transferred

this 27 day of OCT 1966 on Invoice No. 5027975

to GENE JANTZEN CHEVROLET CO.  
(Distributor, Dealer, Etc.)

whose address is 5434 NATURAL BRIDGE  
(Street, City and State)  
ST. LOUIS, MISSOURI 63120

Trade Name CHEVROLET Series or Model 19467 Year 1967

Body Type CORVETTE CONVERT No. Cylinders 8

Manufacturer's Motor Vehicle Identification No. 194677S102237

H. P. (SAE) 57.8 Shipping Weight 3233

If Truck or Commercial Vehicle Give Capacity.  
(To be given in terms as required by the State.)

The CORPORATION further certifies that this was the first transfer of such new motor vehicle in ordinary trade and commerce.

CHEVROLET MOTOR DIVISION  
General Motors Corporation  
(Corporation)

By: *D. Koch* Att'l. Cashier  
Sign Name Title or Position

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Credit Dept. OK		Date P		CHEVROLET MOTOR DIVISION		Truckaway or Straight B/L		
Dealer Code	Car No. or Route	Date Shipped	General Motors Corporation		Zone	Car S. No.	Date of Execution	Invoice Number
31 192	RAIL	07 06 66	ATLANTA, GEORGIA		31	204958	07 07 66	AS07409
Type	Serial Number	Description	Suggested Retail Price	Car & Option Price	D & H	Amount	Int. & Flat Chgs	
19467	194676S125487	CORVETTE CONVERT	4084.00	2953.72	208.00	3161.72		
	2N21AA	4 SPD CL RATIO TRAN	184.35	133.00	9.35	142.35		
	2A02AA	TINTED WINDSHIELD	10.55	7.60	.55	8.15		
	2974AA	RALLY RED	.00	.00	.00	.00		
	2U69EA	PB AM/FM RADIO	199.10	143.64	10.10	153.74		
	2P92AA	775X15X2 PLY WSW	31.30	22.80	1.30	24.10		
	2G81NA	POSITRACT AXLE 370R	42.15	30.40	2.15	32.55		
33203	2L36AA	390 HP V-8 TURBOJET	181.20	130.72	9.20	139.92		
		DESTINATION CHARGE				66.25		

1299

2877.50  
500.81  
274.25  
76.72  

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3728.78

ENTERED  
JUL 4 1966

Ident. No.	GMAC Branch	Suggested Retail Price	Model Dealer Net	Model D & H	Option Dealer Net	Option D & H	Destination Charge	Invoice Total	Invoice Number
B26676	3047	4798.90	2953.72	208.00	468.16	32.65	66.25	3728.78	AS07409

Memo: Dealer's Name and Address: **TOM GLOOR CHEVROLET INC BESSEMER ALA**

Vehicle Serial Number: **194676S125487**

Date of GMAC Note: **07 14 66**

Date Interest From: **07 29 66**

Bill To: General Motors Acceptance Corporation (Grantor)

Upped To: Dealer and Destination Shown Below

I hereby certify that these goods were produced in compliance with all applicable requirements of sections 5, 7 and 12 of the Fair Labor Standards Act, an amended, and of regulations and orders of the United States Department of Labor issued under Section 14 thereof.

Bill to Consignee—Important: When accepting delivery of this shipment be sure to examine car carefully and have shortage or damage noted on your delivery receipt to carrier. We cannot assume responsibility for loss or damage to cars in transit unless notation of shortage or damage is noted when accepting delivery.

Terms: Net Cash—Promissory note attached payable at the office of General Motors Acceptance Corporation designated above.

**TOM GLOOR CHEVROLET INC**

Instructions to Dealer: Fill in the Wholesale Release Order on the reverse side of your Promissory Note Copy and attach it to your remittance when releasing car from trust. Amount due car is shown above, to which amount must be added the applicable flat charge and interest. Interest accrues from the interest date indicated above to date of payment. To release car demonstration, follow instructions shown in the current GMAC Demonstration Agreement.

Copy of Promissory Note:

Demand for value received, I (we) promise to pay to the order of General Motors Acceptance Corporation their office to be hereafter designated, the amount of \$ **3,728.78** in interest from the date hereinabove specified at the rate per annum herein incorporated by reference to the rate designated under the GMAC Wholesale Plan as the rate currently in force. I (we) agree, the event this note is placed in the hands of an attorney for collection, to pay 10% of the amount due as attorney's fees or, if prohibited, the amount permitted by law. I (we) hereby waive all benefits of valuation, appraisal and exemption laws, and all rights of appeal and release all errors.

Dealer Name and Address:

Expiration of Transit Time	Zone	GMAC Branch	Date Interest From	Invoice Number
07 14 66	31	3047	07 29 66	AS07409

Vehicle Serial Number: **194676S125487**

To Dealer: For releasing the above car from trust, detach this copy of Promissory Note, fill in the reverse side and forward to above GMAC Branch with payment of the invoice amount plus applicable charges.

**31192 TOM GLOOR CHEVROLET INC**  
**2829 BESSEMER SUPER HWY**  
**BESSEMER ALA 35021**



CHEVROLET MOTOR DIVISION  
GENERAL MOTORS CORPORATION



SAINT LOUIS PLANT