

1963-1967 Corvette Assembly Process

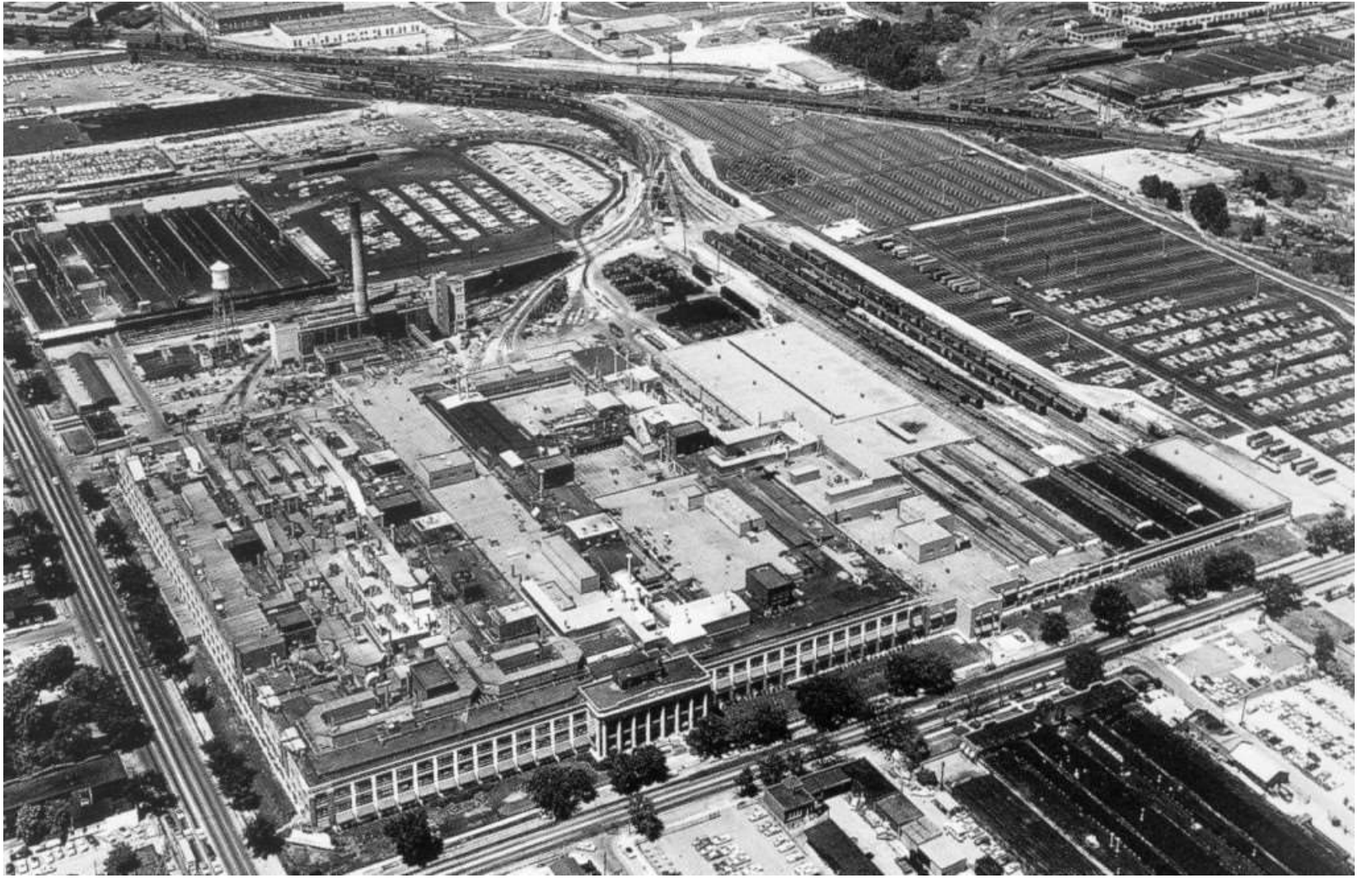
**Body Shop and Paint Shop
NCRS National Convention
July 20, 2011**

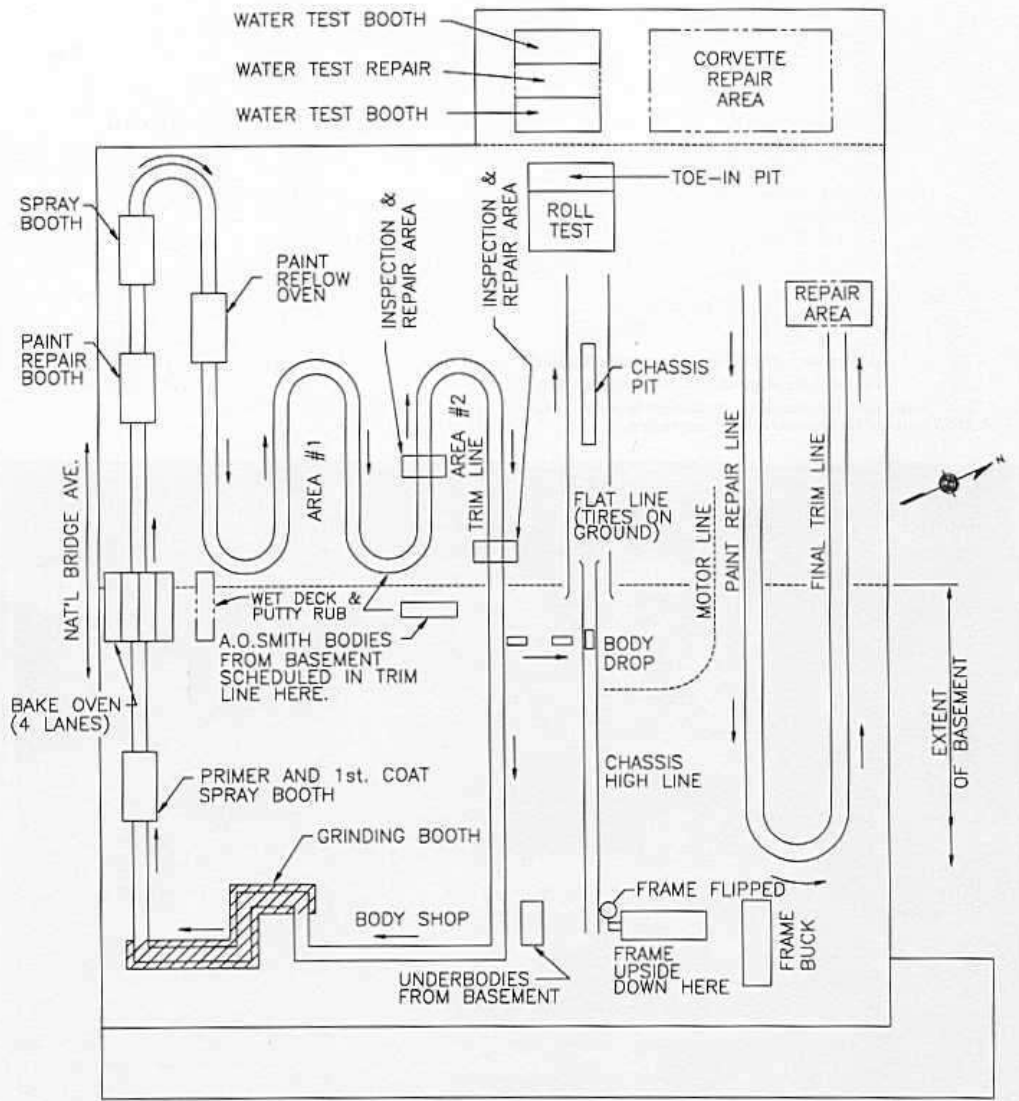
John Hinckley

CHEVROLET MOTOR DIVISION
GENERAL MOTORS CORPORATION



SAINT LOUIS PLANT

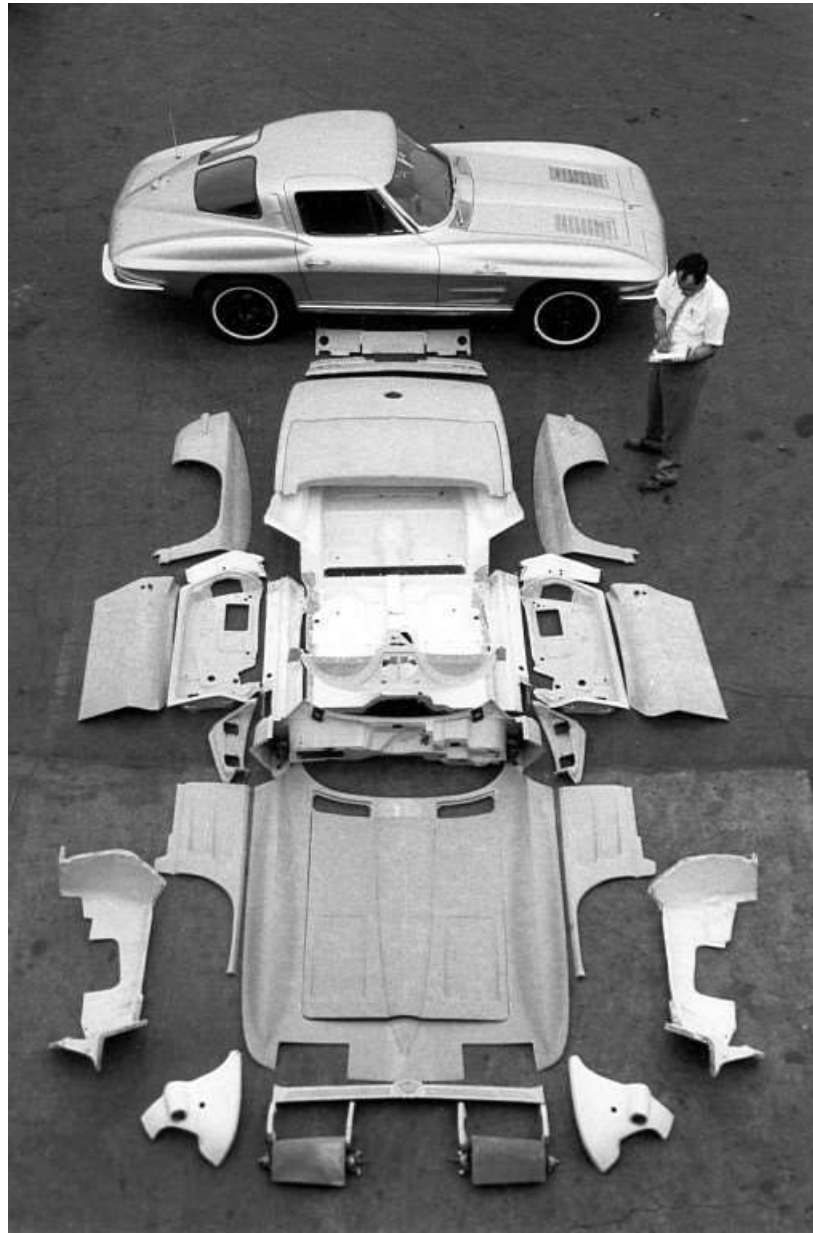




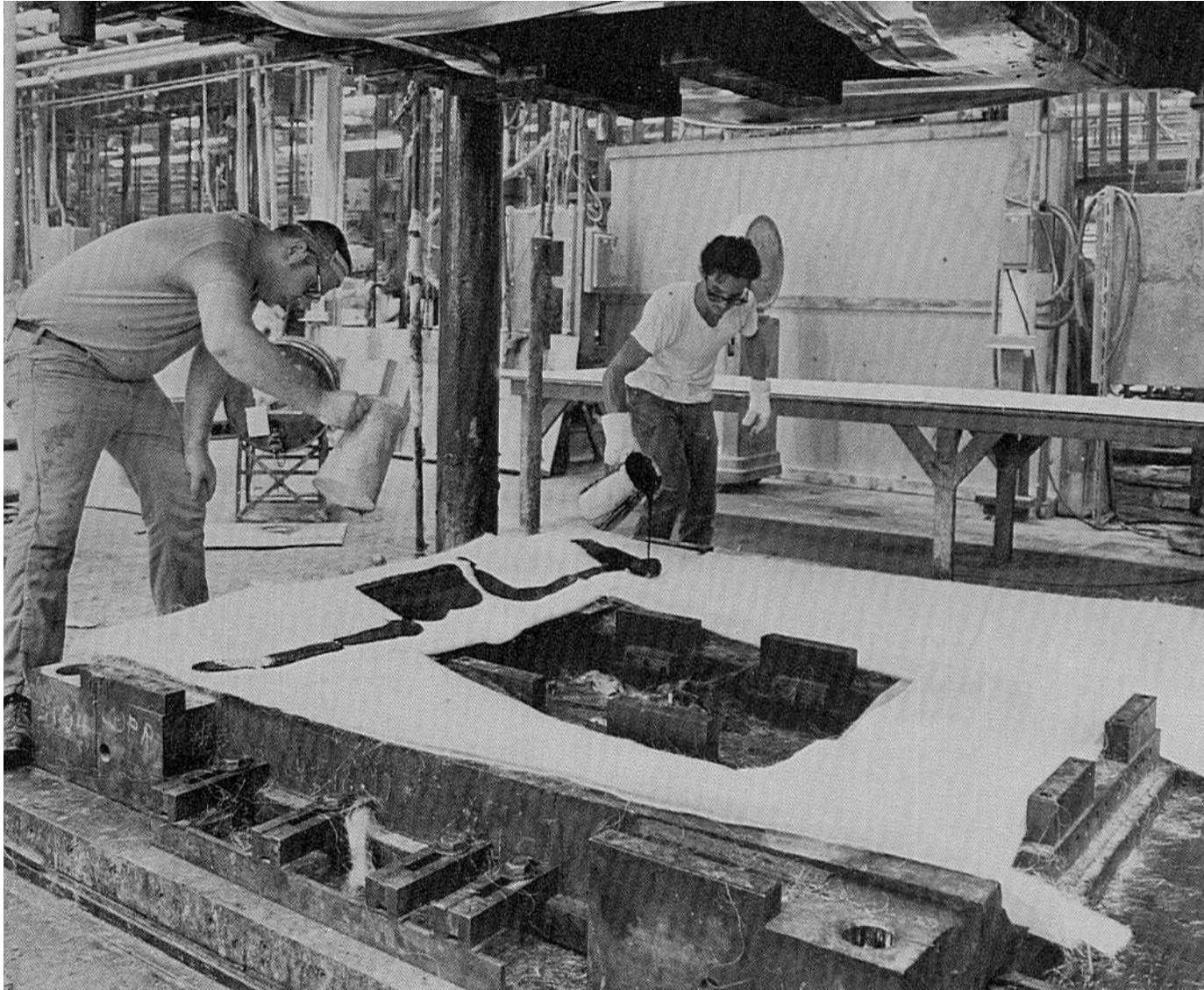
CORVETTE BLDG.

R.R. (TYP)

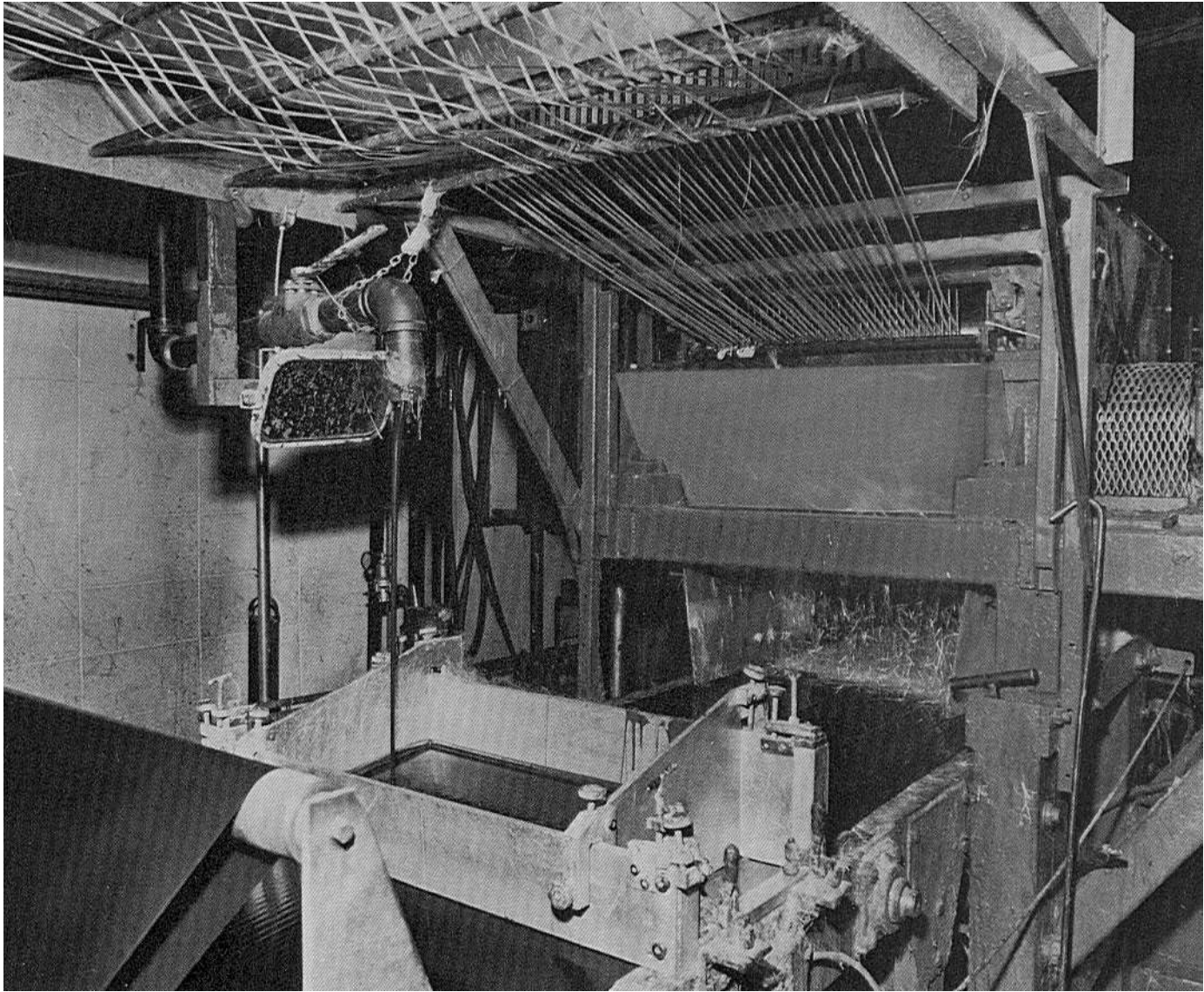
NOT TO SCALE

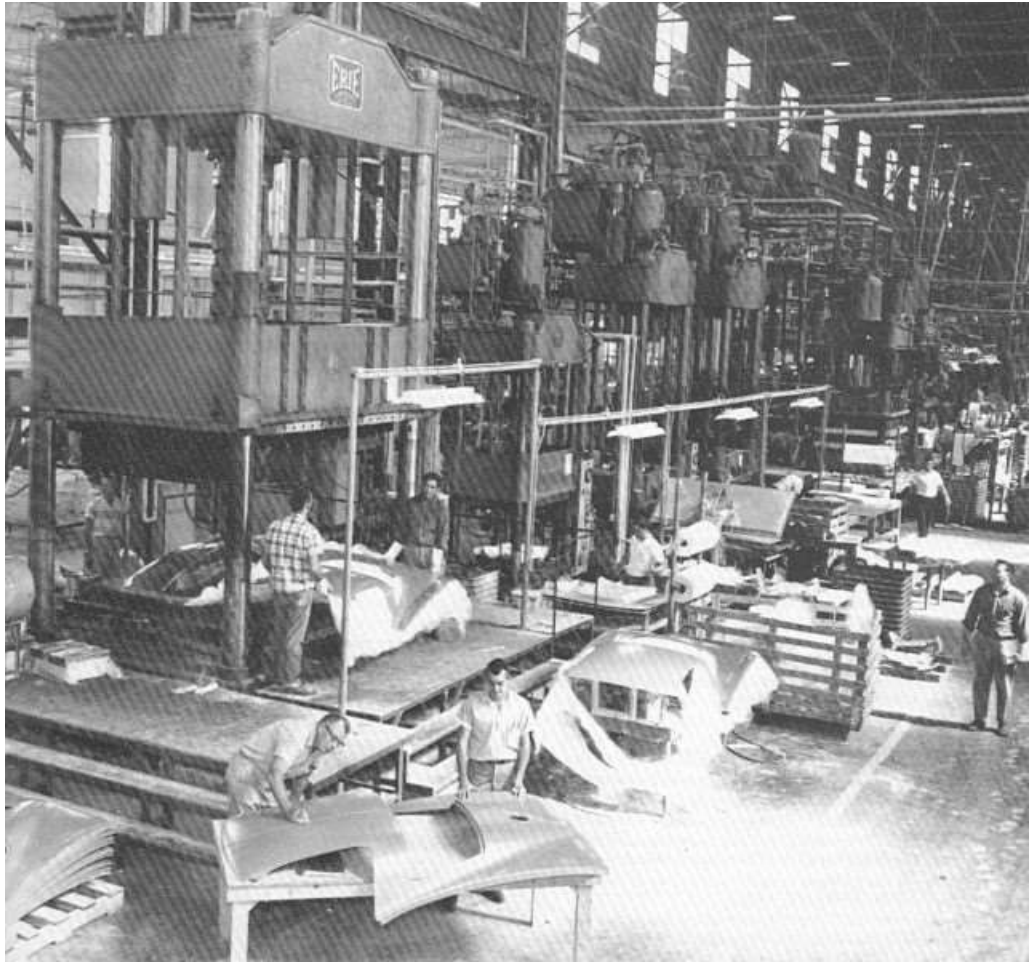


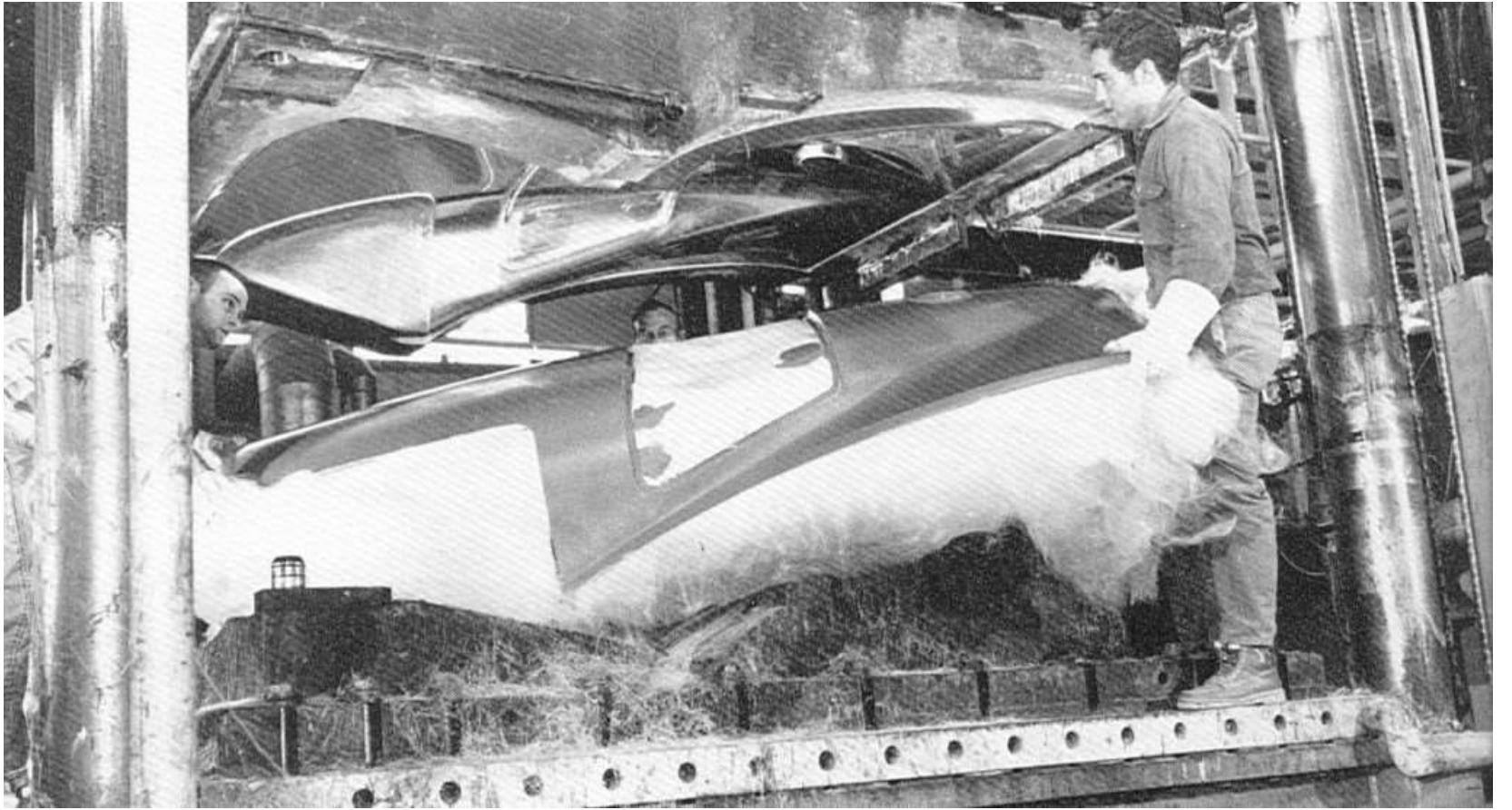












Body Shop Sequence

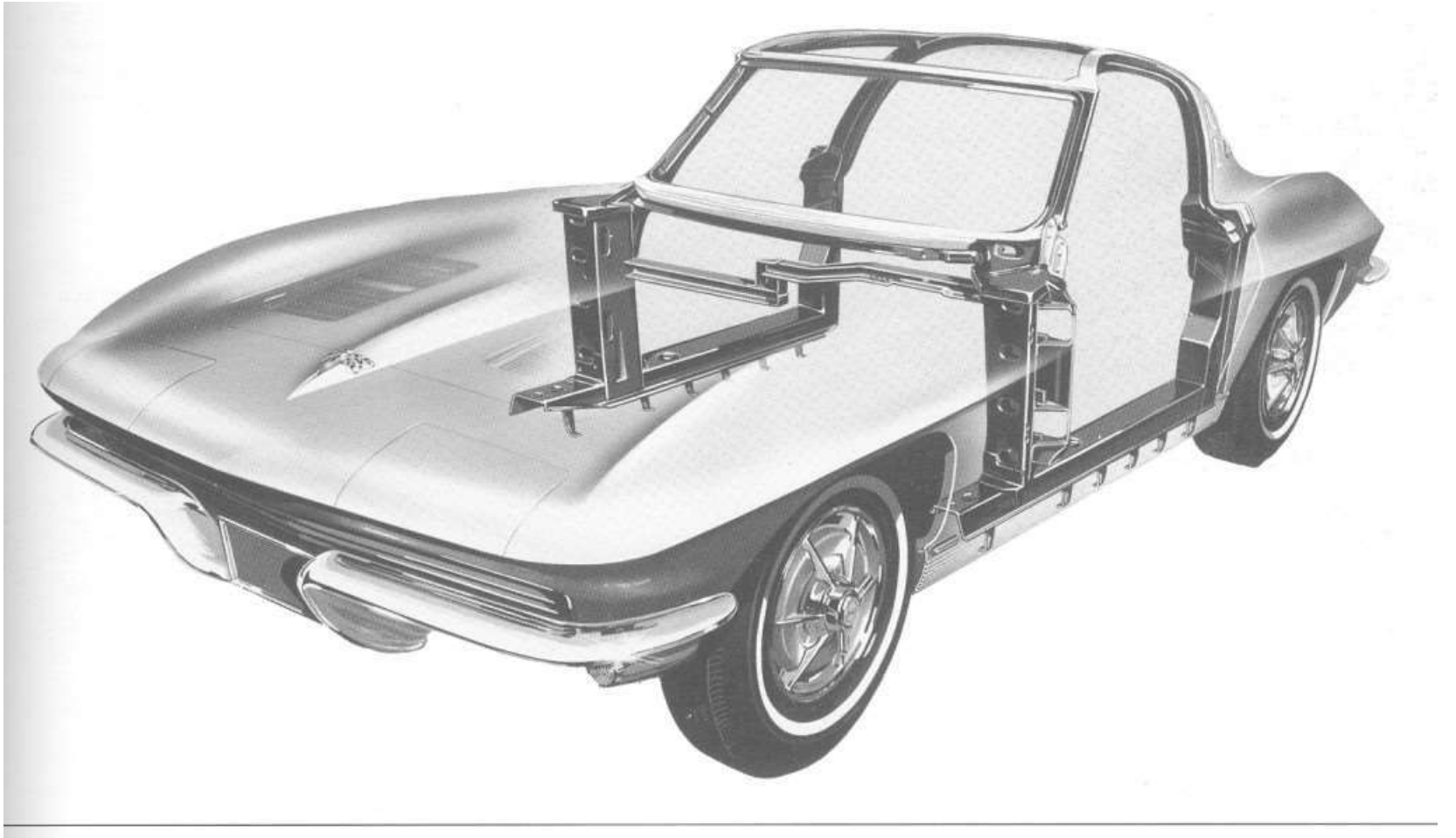
- **Birdcage Welding & Painting**
- **Underbody Off-Line Subassembly**
- **Subassemblies (cowl & dash, front & rear clips, doors and deck lid)**
- **Main Line Body Assembly**
- **Body Grind Booth**

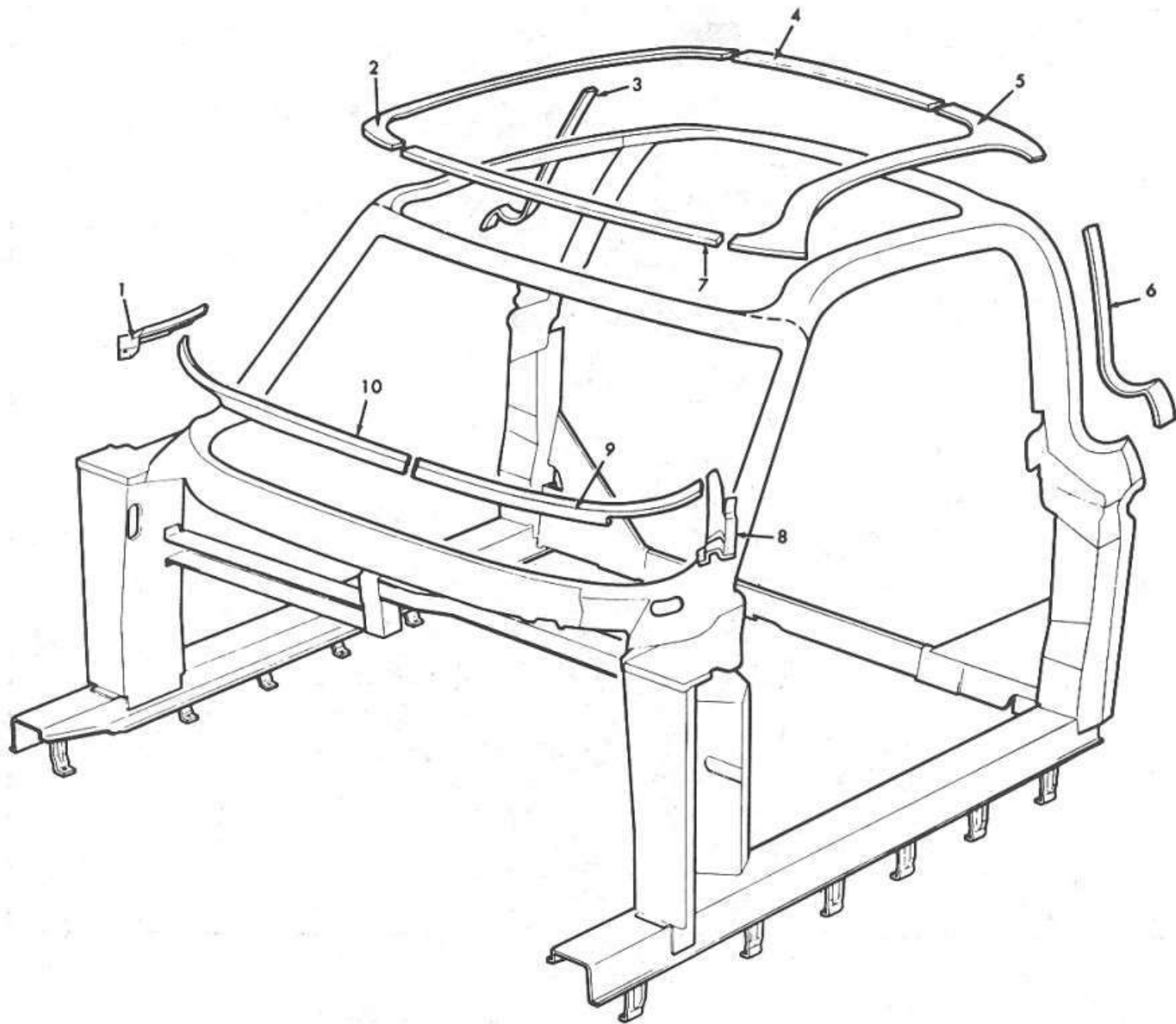
1966 CORVETTE DEALER ORDER No. 34212

ZONE 37	DEALER CODE 066	DISTRICT 01	TO: CHEVROLET MOTOR DIVISION PLEASE ENTER OUR ORDER FOR ONE 1966 CORVETTE TO BE SHIPPED TO US AS SOON AS YOUR SCHEDULE PERMITS.			
DEALER NAME Spiesmaster Motor Co.			<input type="checkbox"/> STOCK <input checked="" type="checkbox"/> SOLD DATE 11-18-65			
STREET ADDRESS			CUSTOMER NAME Brock			
CITY & STATE Croyier, Va.			DEALER SIGNATURE H. Spiesmaster			
X	MODEL	EXTERIOR COLOR	INTERIOR TRIM	CONVERTIBLE TOP		
	DESCRIPTION	Option No.	DESCRIPTION	CODE		
X	19437-COUPÉ	MILANO MAROON 988	BLACK	E	VINYL <input checked="" type="checkbox"/> LEATHER <input type="checkbox"/>	WHITE <input type="checkbox"/> BLACK <input type="checkbox"/> BEIGE <input type="checkbox"/>
	19467-CONVERTIBLE					

OPTIONAL EQUIPMENT

	OPTION DESCRIPTION	OPTION NO.	X	OPTION DESCRIPTION	OPTION NO.	X
T R A N S M I S S I O N	POWERGLIDE (AVAILABLE WITH 300 H.P. ENGINE)	A135	<input type="checkbox"/>	SPECIAL PURPOSE FRONT & REAR SUSPENSION (AVAILABLE WITH 300 OR 425 H.P. ENGINES)	F41	<input type="checkbox"/>
	3 SPEED FULLY-SYNCHRONIZED (AVAILABLE WITH 300 H.P. ENGINE)	M10	<input type="checkbox"/>	FUEL TANK (19437 ONLY, 36 GAL. & WHEEL HOUSE FILLER PANEL)	N03	<input type="checkbox"/>
	4 SPEED — Wide Range (AVAILABLE WITH 300, 350, OR 390 H.P. ENGINES)	M20	<input type="checkbox"/>	HIGHWAY EMERGENCY KIT	Z83	<input type="checkbox"/>
	4 SPEED — Close Ratio (AVAILABLE WITH 350, 390 OR 425 H.P. ENGINES)	M21	<input checked="" type="checkbox"/>	C.M. AIR INJECTION REACTOR (CALIFORNIA VEHICLE REGISTRATION ONLY) (AVAILABLE WITH 300, 350 OR 390 H.P. ENGINE)	K19	<input type="checkbox"/>
	H.D. 4 SPEED — Close Ratio (NOT RECOMMENDED FOR GENERAL USE) (AVAILABLE WITH 425 H.P. ENGINE)	M22	<input type="checkbox"/>	HAZARD WARNING SWITCH	V74	<input checked="" type="checkbox"/>
	300 H.P. 4 BBL. CARB. — Hydraulic Lifters (AVAILABLE WITH POWERGLIDE, 3 SPEED OR M20 4 SPEED)	M70	<input type="checkbox"/>	OFF ROAD EXHAUST (AVAILABLE WITH ALL ENGINES WITH 3 OR 4 SPEED)	N11	<input type="checkbox"/>
	350 H.P. LARGE 4 BBL. CARB. — Hydraulic Lifters (AVAILABLE WITH M20 OR M31 4 SPEED)	L79	<input checked="" type="checkbox"/>	SIDE MOUNTED DUAL EXHAUST (Off Road Service)	N14	<input type="checkbox"/>
	390 H.P. LARGE 4 BBL. CARB. — Hydraulic Lifters (AVAILABLE WITH M20 OR M21 4 SPEED & POSITRACTION)	L36	<input type="checkbox"/>	BRAKES, HEAVY DUTY DISC (AVAILABLE WITH 390 OR 425 H.P. ENGINES)	J56	<input type="checkbox"/>
	425 H.P. LARGE 4 BBL. CARB. — Mechanical Lifters (AVAILABLE WITH M21 OR M22 4 SPEED, POSITRACTION AND R&M IGNITION SYSTEM)	L72	<input type="checkbox"/>	IGNITION SYSTEM (FULL TRANSISTOR) (AVAILABLE WITH 350, 390 OR 425 H.P. ENGINES)	X66	<input type="checkbox"/>
	POSITRACTION 3.08 TO 1 (AVAILABLE WITH 3 SPD., OR M30 & 300 H.P., M30 OR M31 & 390 H.P., M31 & 425 H.P.)	G81	<input type="checkbox"/>	RADIO, AM-FM (INCLUDES POWER REAR ANTENNA)	U69	<input checked="" type="checkbox"/>
E N G I N E	POSITRACTION 3.36 TO 1 (AVAILABLE WITH 3 SPD., PG. OF M30 & 300 H.P., M30 & 390 H.P., M30 OR M31 & 390 H.P., M31 OR M22 & 425 H.P.)	G81	<input type="checkbox"/>	SOFT RAY WINDSHIELD ONLY	A02	<input type="checkbox"/>
	POSITRACTION 3.55 TO 1 (AVAILABLE WITH M30 & 390 H.P., M31 & 390 H.P., M31 OR M32 & 425 H.P.)	G81	<input type="checkbox"/>	SOFT RAY ALL WINDOWS	A01	<input checked="" type="checkbox"/>
	POSITRACTION 3.70 TO 1 (AVAILABLE WITH M31 & 390 H.P., M31 & 390 H.P., M31 OR M32 & 425 H.P.)	G81	<input checked="" type="checkbox"/>	SPECIAL CAST ALUMINUM WHEELS	P48	<input type="checkbox"/>
	POSITRACTION 4.11 TO 1 (AVAILABLE WITH M31 & 390 H.P., M31 OR M22 & 425 H.P.)	G81	<input type="checkbox"/>	GENUINE WOOD STEERING WHEEL	N32	<input checked="" type="checkbox"/>
	POSITRACTION 4.56 TO 1 (AVAILABLE WITH M22 & 425 H.P.)	G81	<input type="checkbox"/>	TELESCOPIC STEERING SHAFT	N36	<input type="checkbox"/>
	POWER STEERING	F140	<input type="checkbox"/>	AIR CONDITIONING (AVAILABLE WITH 300, 390 OR 390 H.P. ENGINES)	C60	<input checked="" type="checkbox"/>
	POWER BRAKES	.50	<input type="checkbox"/>	HEATER & DEFROSTER DELETION (NOT AVAILABLE WITH AIR CONDITIONING)	C48	<input type="checkbox"/>
	WHITE SIDEWALL 7.75 x 15-4 PR. (SHINE STYLE)	192	<input type="checkbox"/>	REMOVABLE HARD TOP (IN PLACE OF SOFT TOP—19467 MODEL)	C07	<input type="checkbox"/>
	NYLON BLACKWALL 7.75 x 15-4 PR. (GOLD STRIPS)	701	<input type="checkbox"/>	REMOVABLE HARD TOP (IN ADDITION TO SOFT TOP—19467 MODEL)	C07	<input type="checkbox"/>
				HEADRESTS (DRIVER & PASSENGER)	A82	<input type="checkbox"/>
			POWER WINDOWS (ELECTRICAL CONTROL)	A31	<input type="checkbox"/>	
TO BE COMPLETED BY THE ZONE PRESENT INDICATIONS ARE THIS ORDER WILL BE PLACED WITH THE PLANT FOR PRODUCTION IN THE MONTH OF <i>February</i> DEALER SHOULD ADVISE CUSTOMER ACCORDINGLY				ZONE USE ONLY ZONE ORDER NO. <i>376-1</i> DATE MAILED TO PLANT <i>1-13-66</i>		

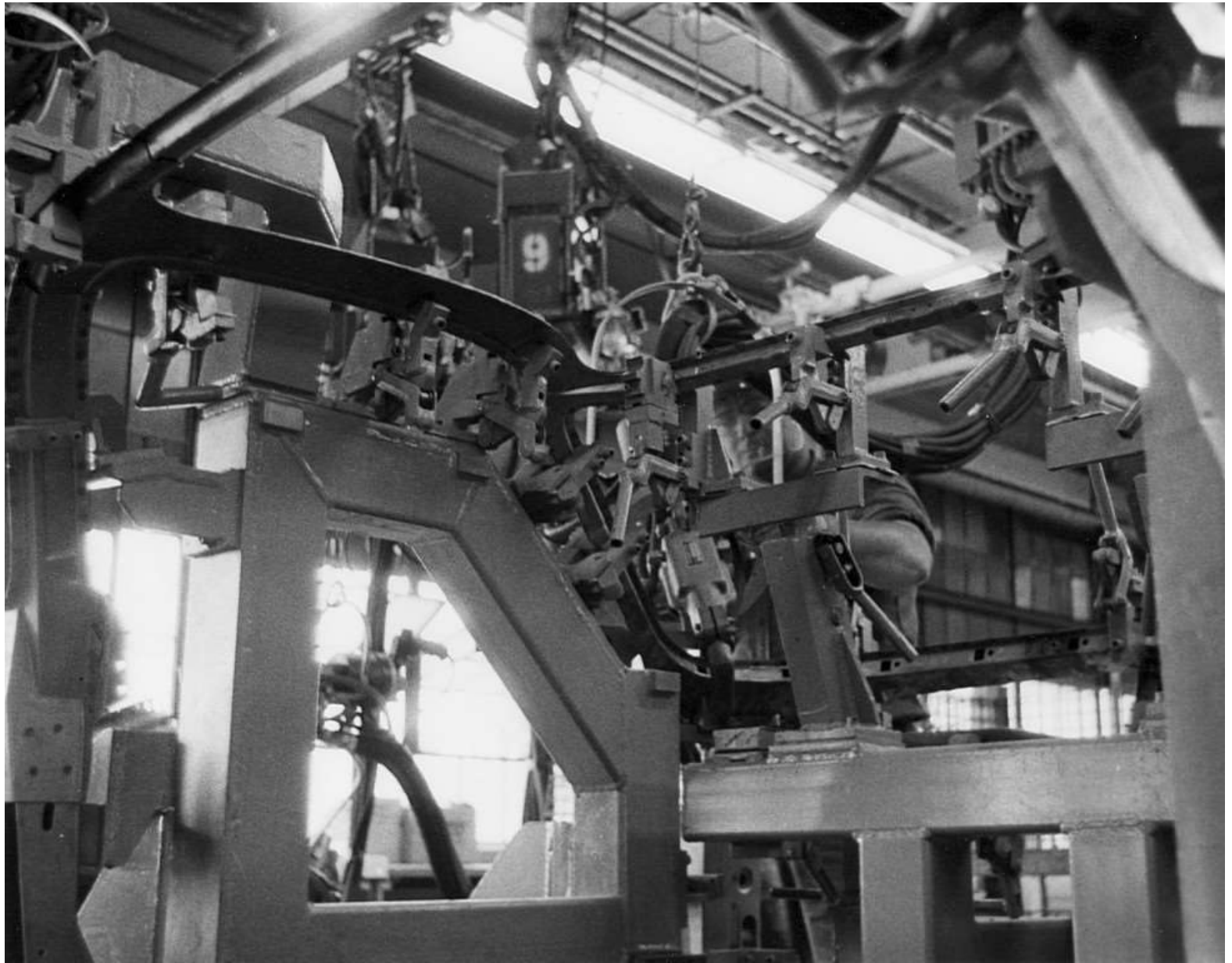




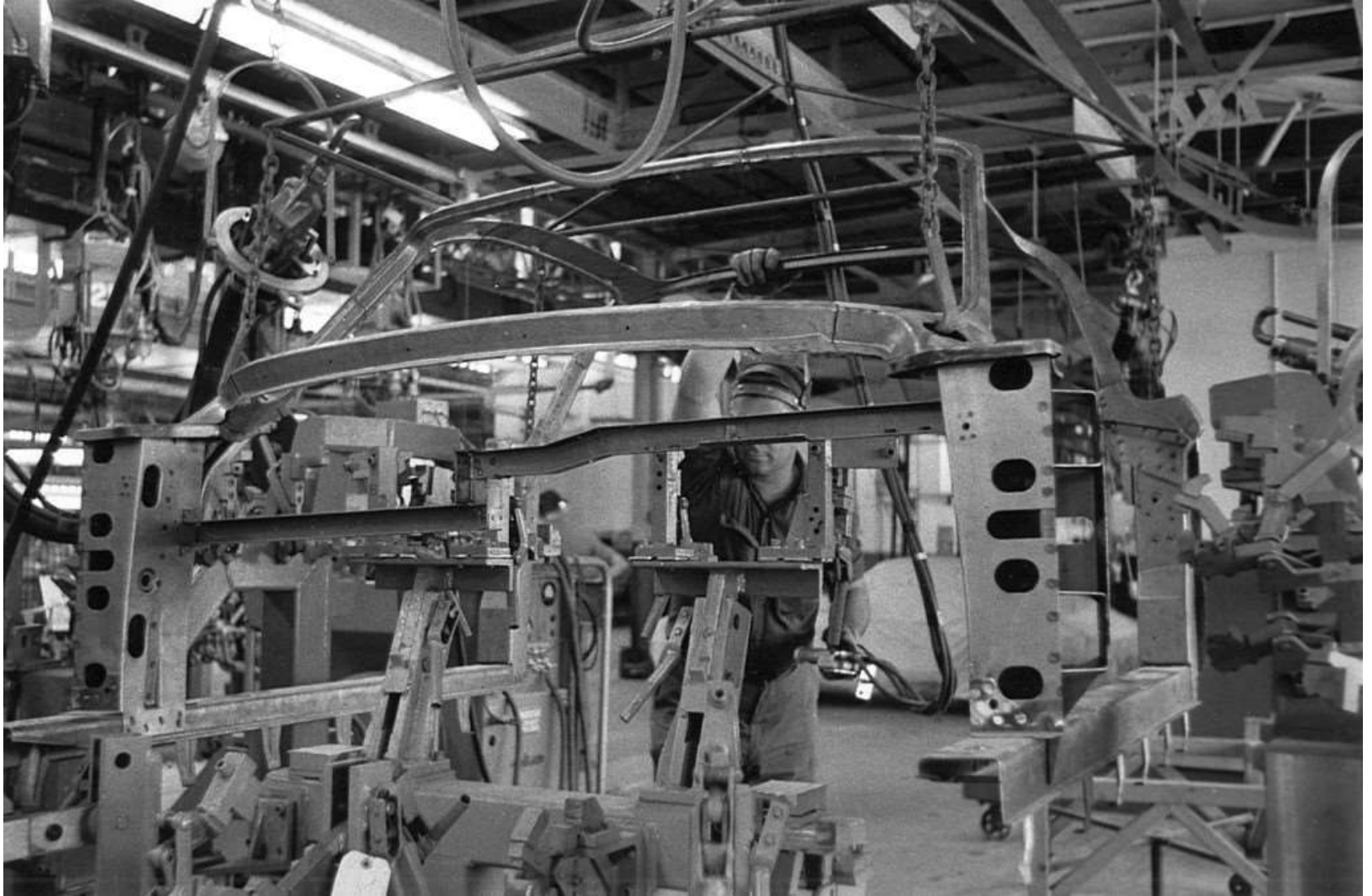


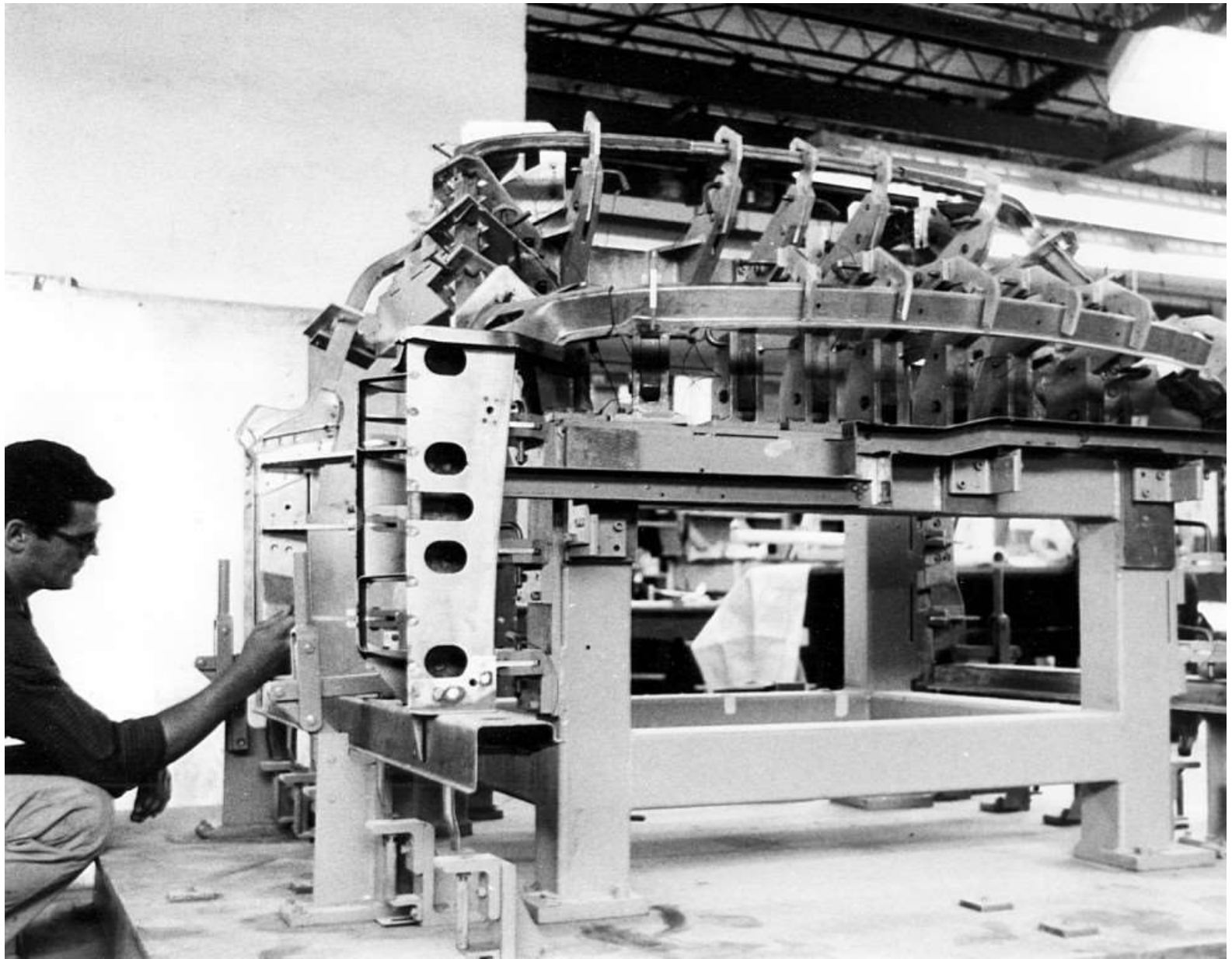




















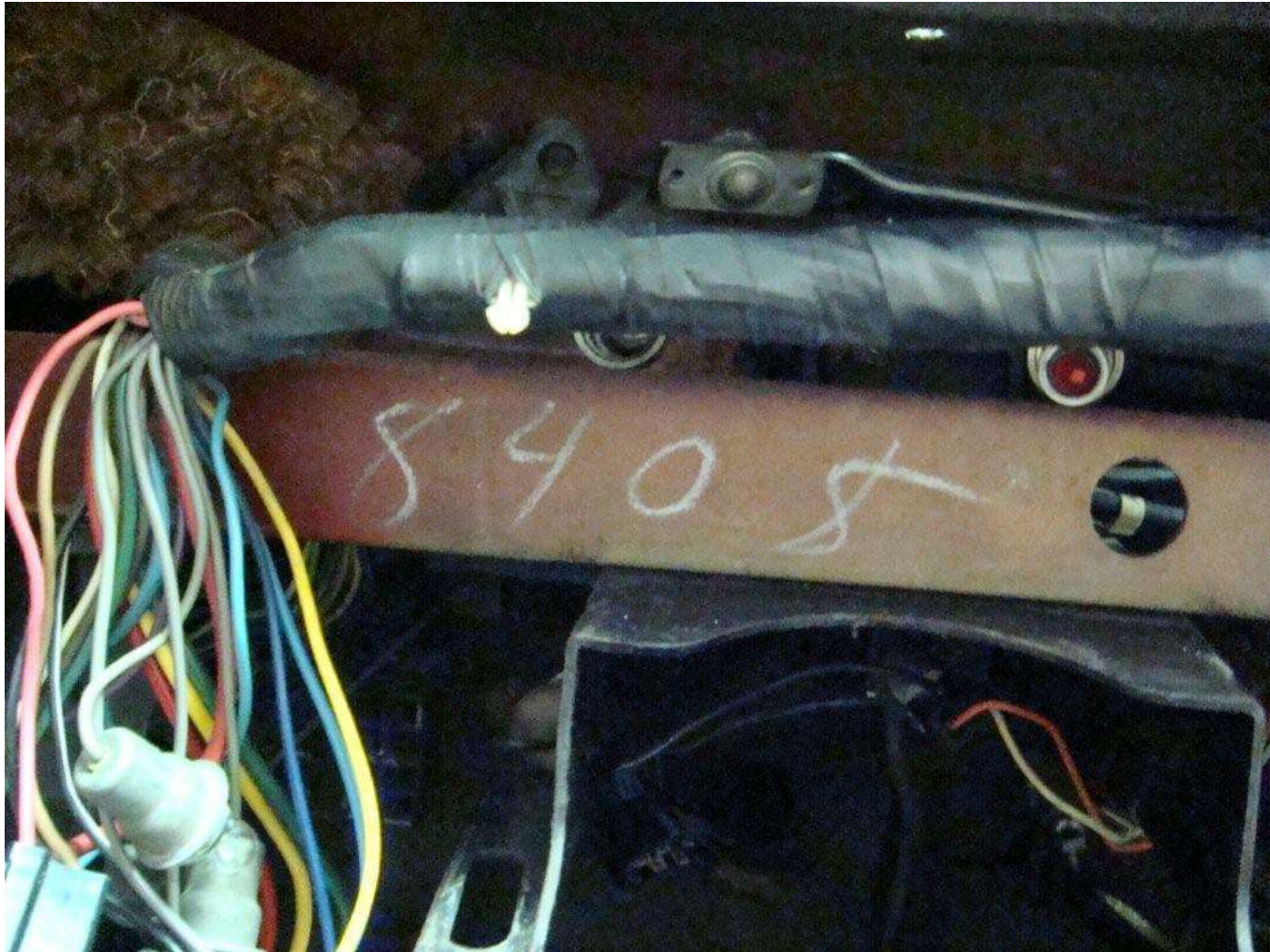










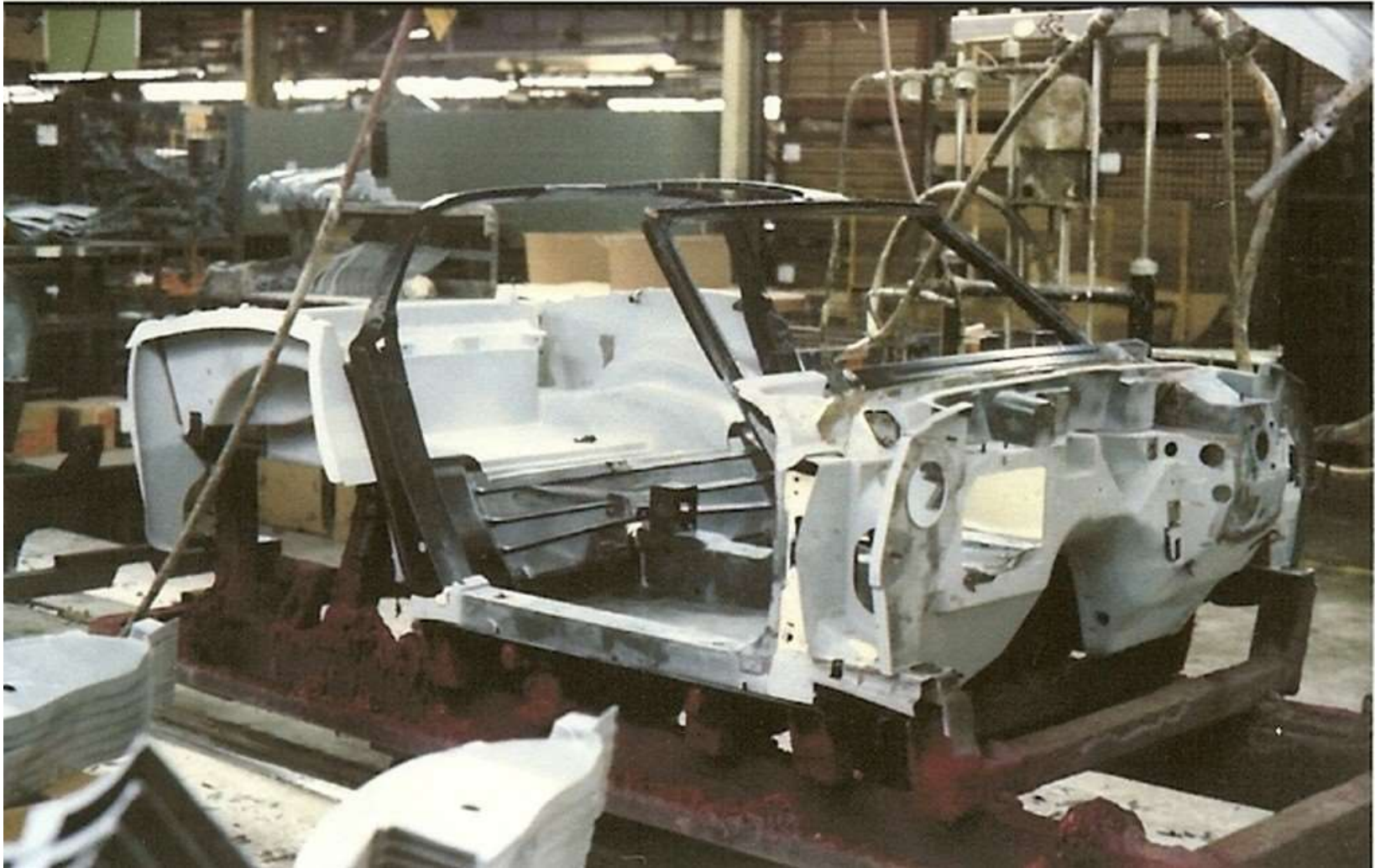






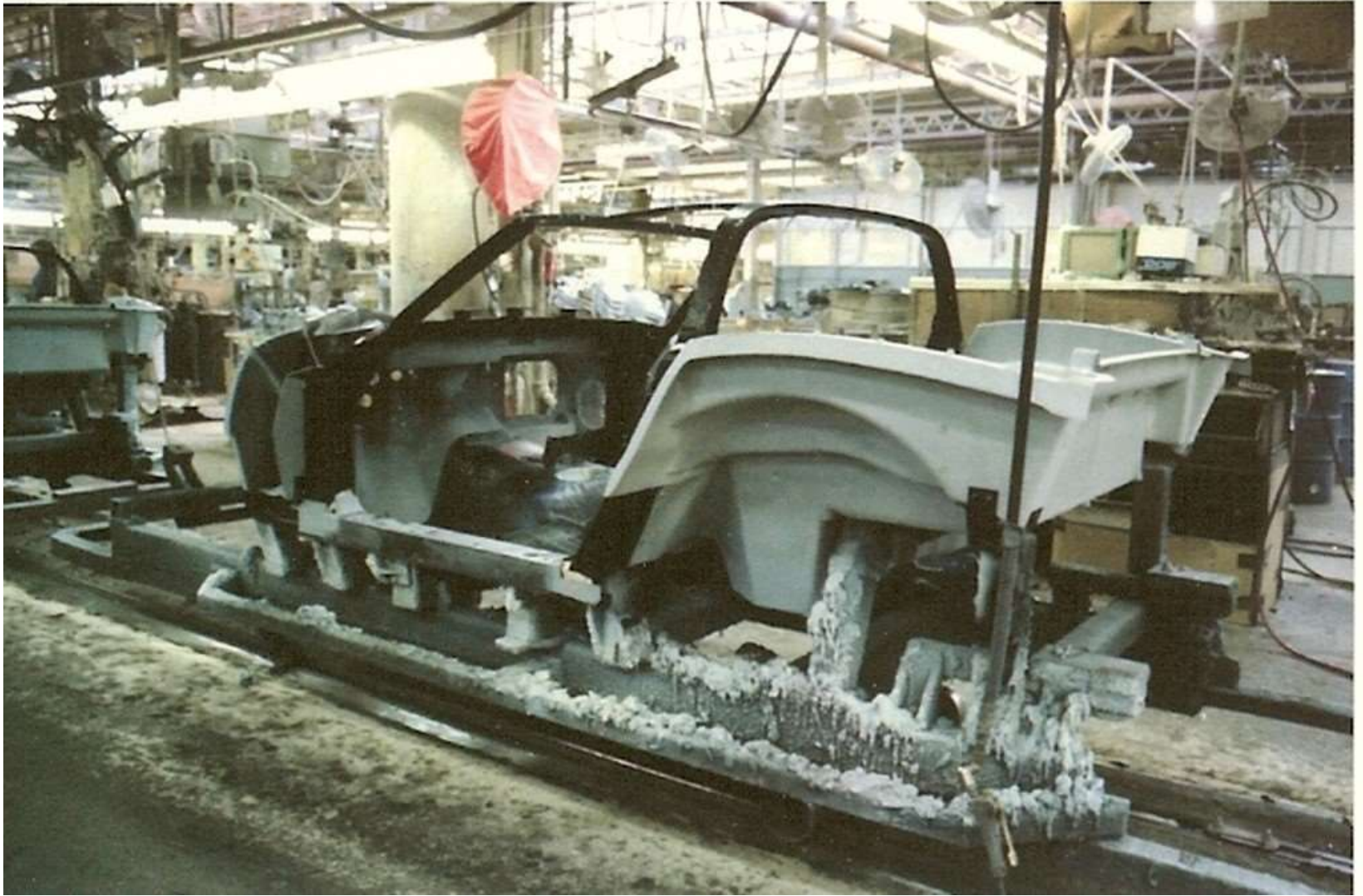




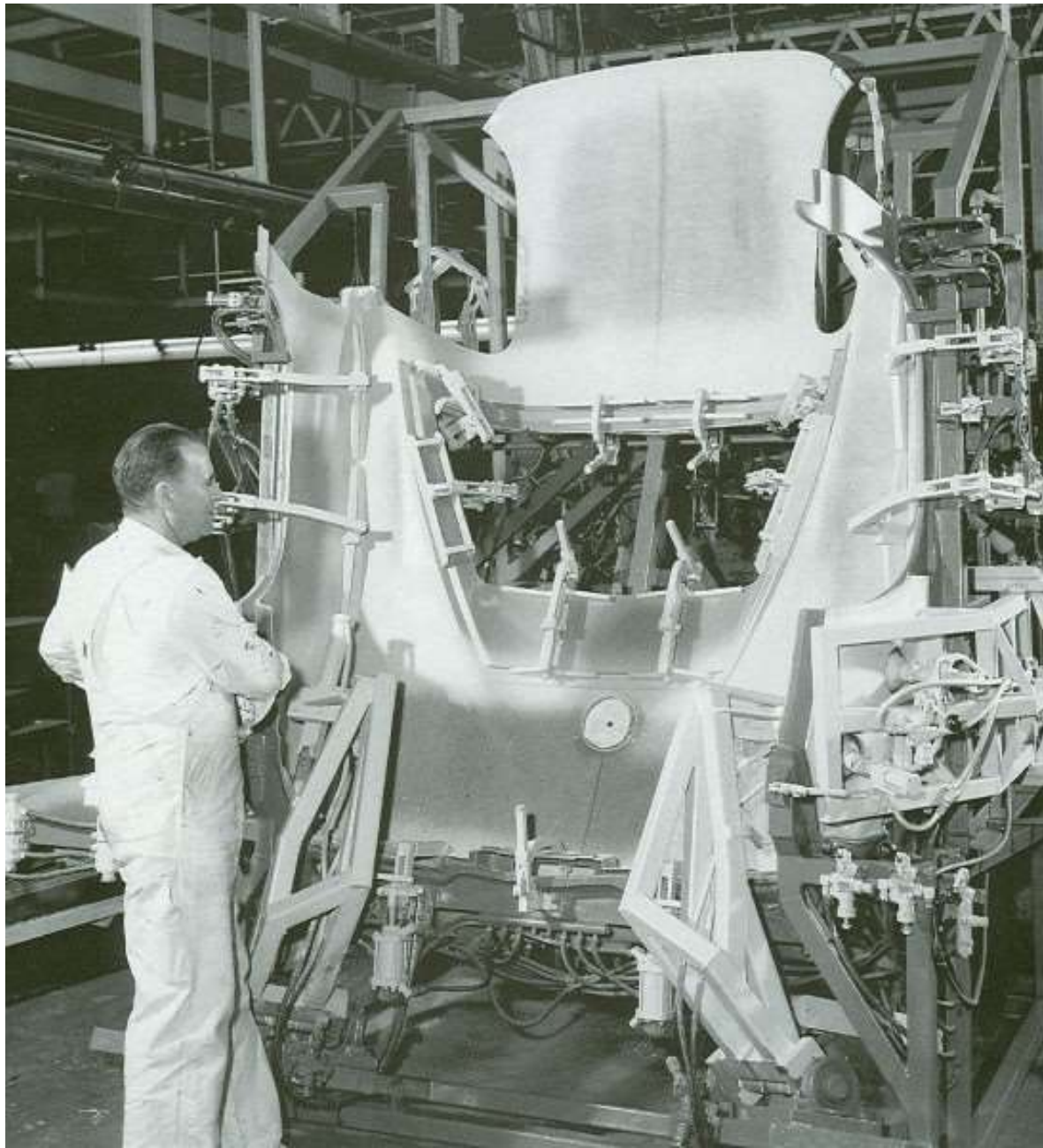


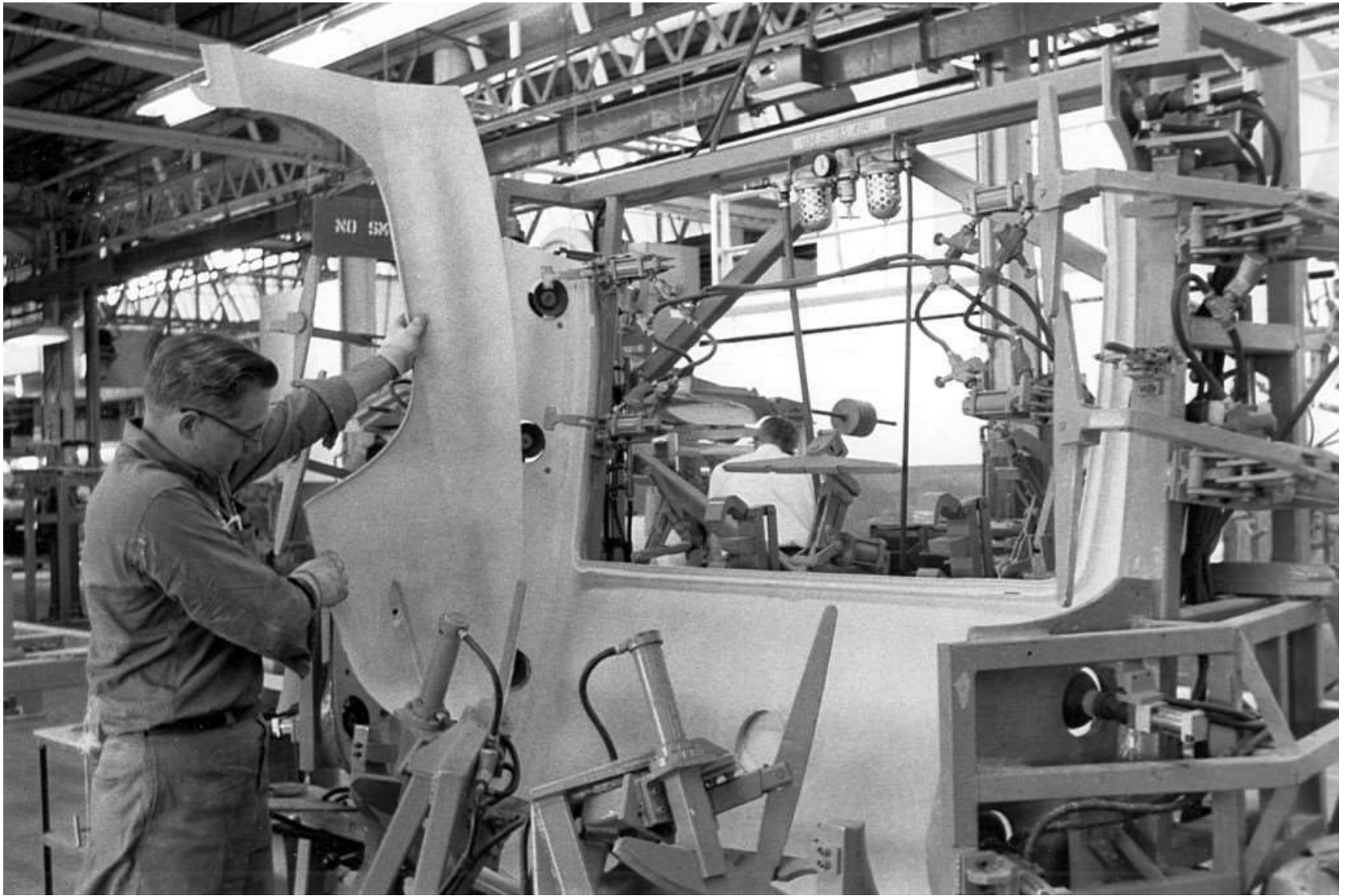


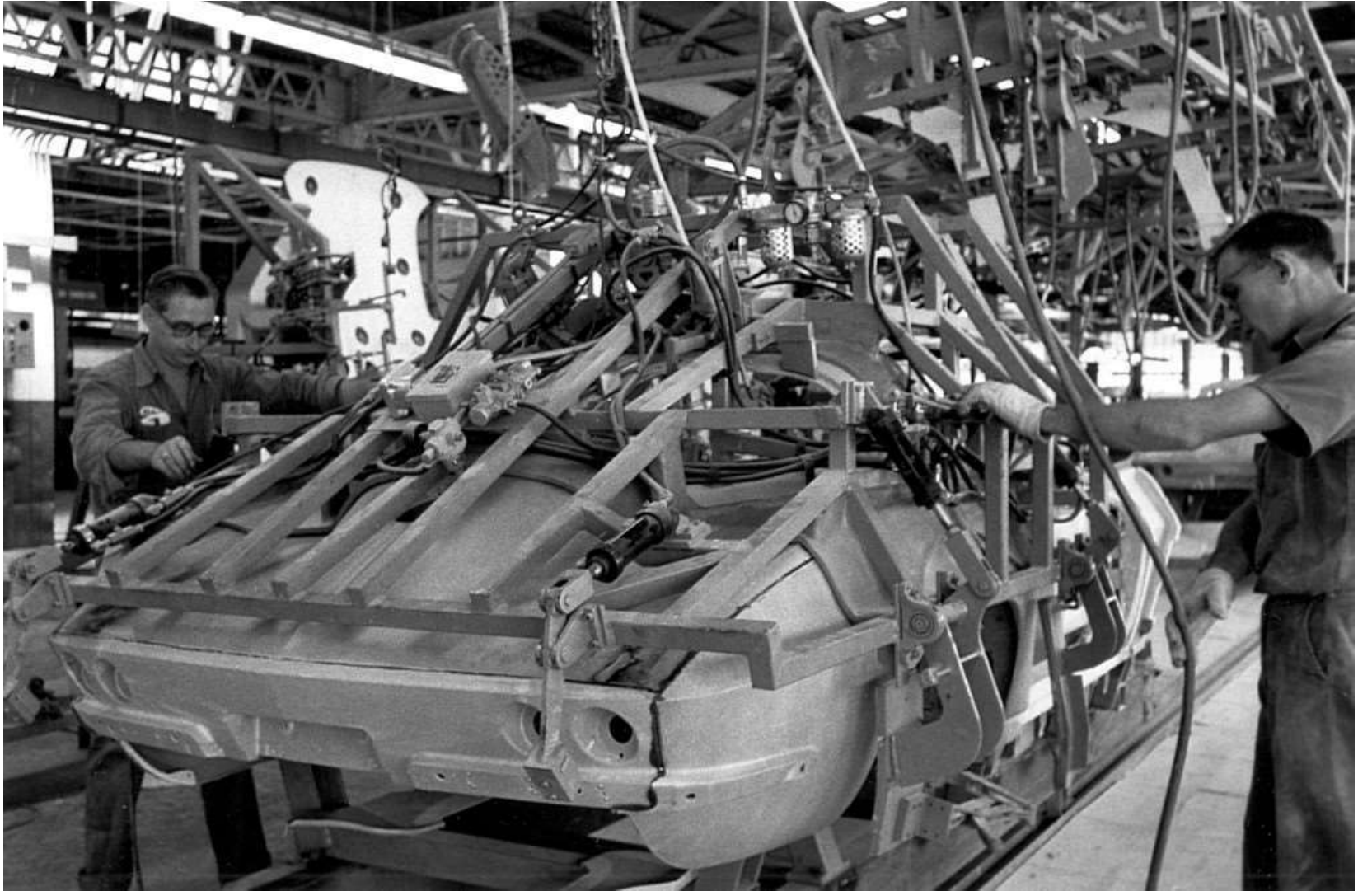








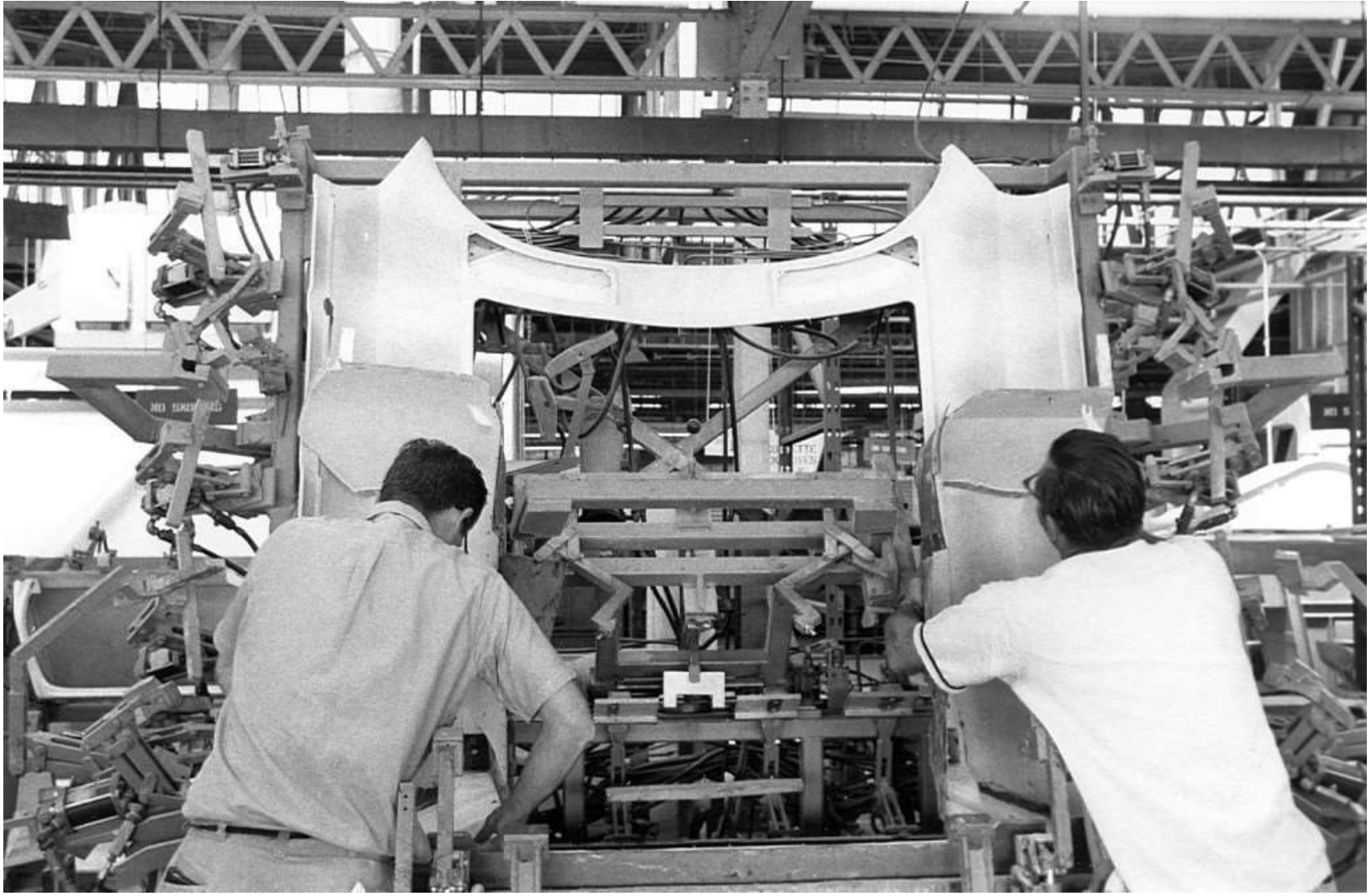








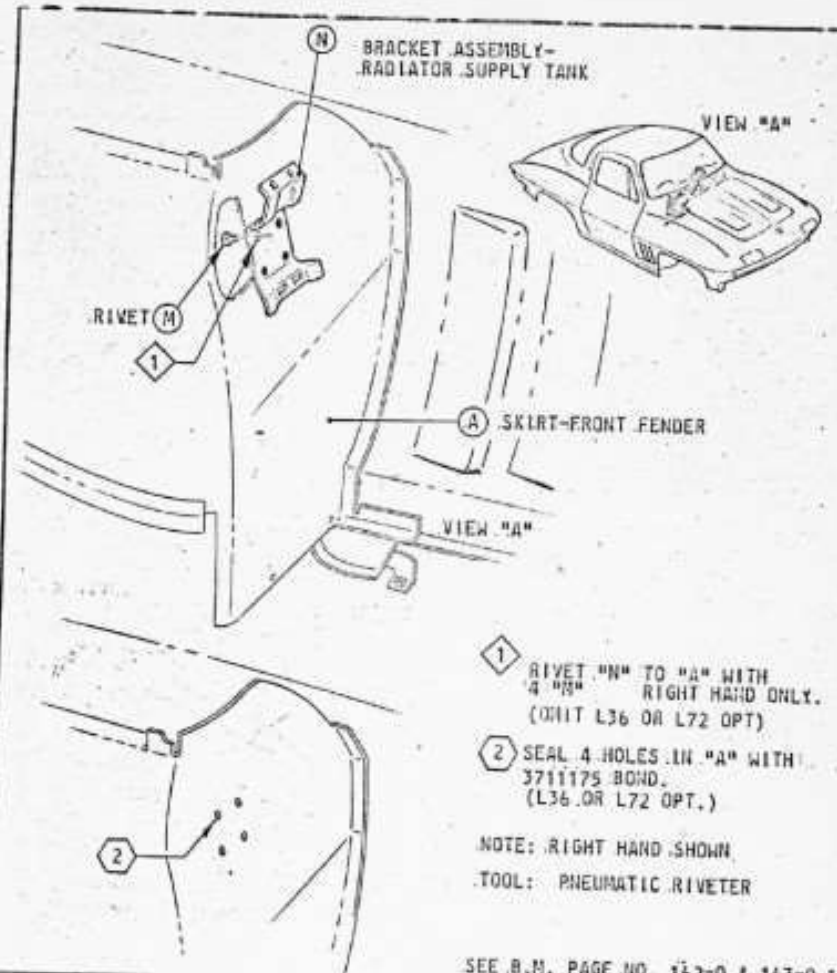












- ① RIVET "M" TO "A" WITH 4 "M" RIGHT HAND ONLY. (OMIT L36 OR L72 OPT)
- ② SEAL 4 HOLES IN "A" WITH 3711175 BOND. (L36 OR L72 OPT.)

NOTE: RIGHT HAND SHOWN
 TOOL: PNEUMATIC RIVETER

SEE B.M. PAGE NO. 162-0 & 163-0-1-2

		TITLE		ASSEMBLY INSTRUCTIONS	
		PREVIOUS INSTRUCTION		SKIRT ASSEMBLY-FRONT FENDER-R.H.	
		NEXT INSTRUCTION		DS DOWSMITH INC.	
		OPERATION		IONIA DIVISION	
		DRAWN		PRODUCT ENGINEERING	
		DATE		STATION	
		L.C.G.		RIVET	
		10-14-63		SUB ASSY	
		CORVETTE		NUMBER	
				PAGE	
				75405	
				166-0	
REV. NO.	REVISIONS	DATE	CHK.	APP.	
B	INST 2 & OPT'S ADDED.	10-14-63			
A	INST 2 & VIEW B REMOVED	8-17-63			
-	REL FOR 1966 PROD.	8-6-63			
-	REL. FOR PRODUCTION.	8-3-63			



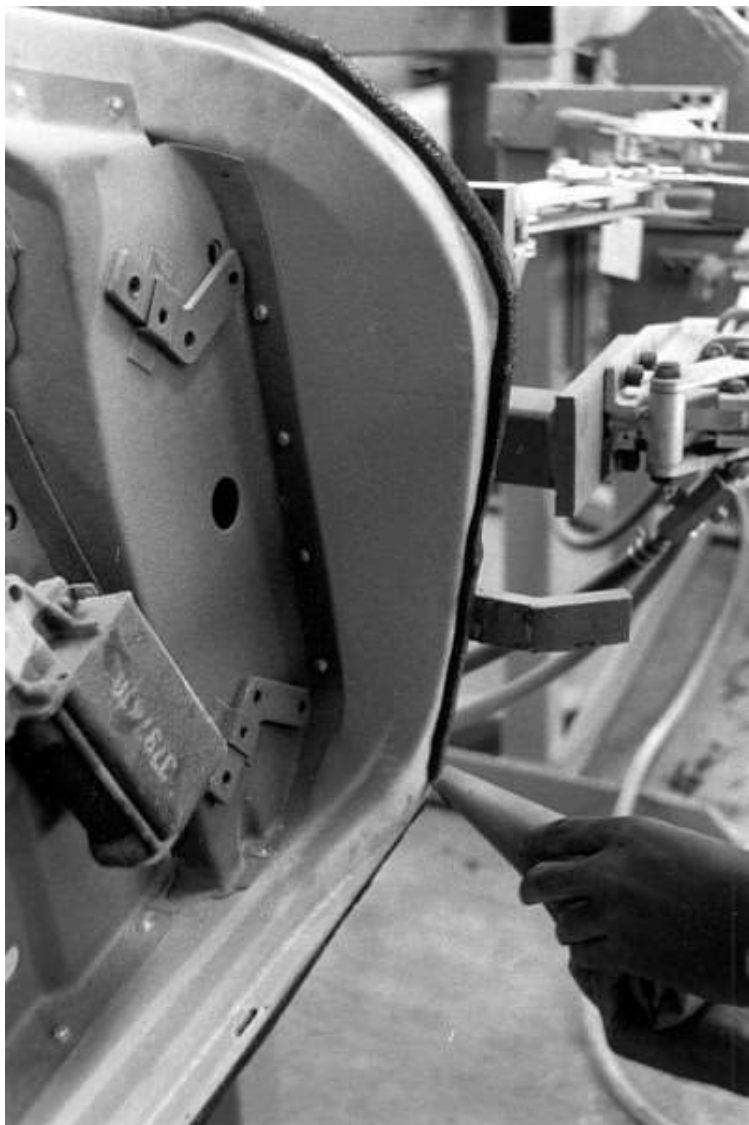


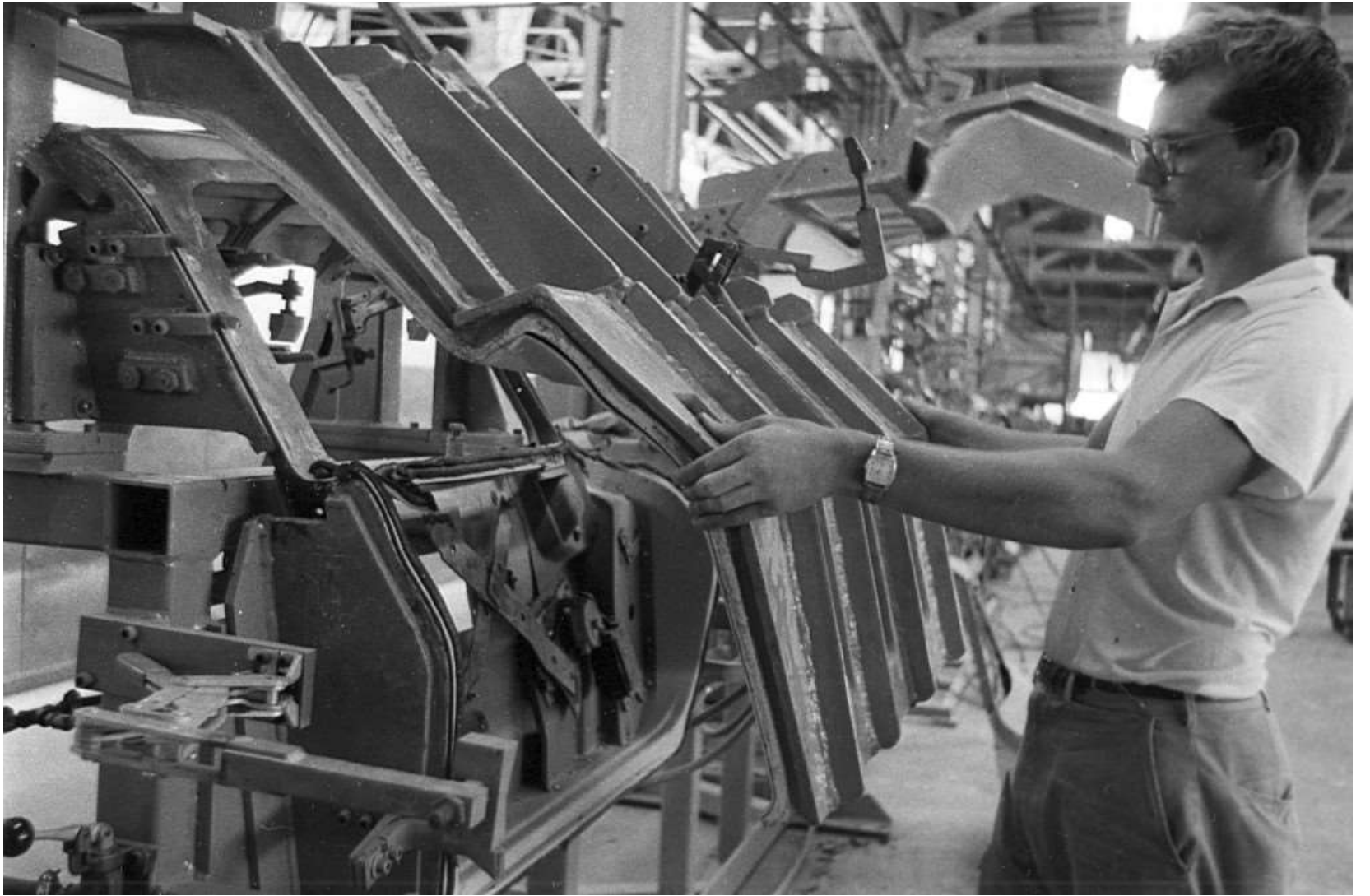


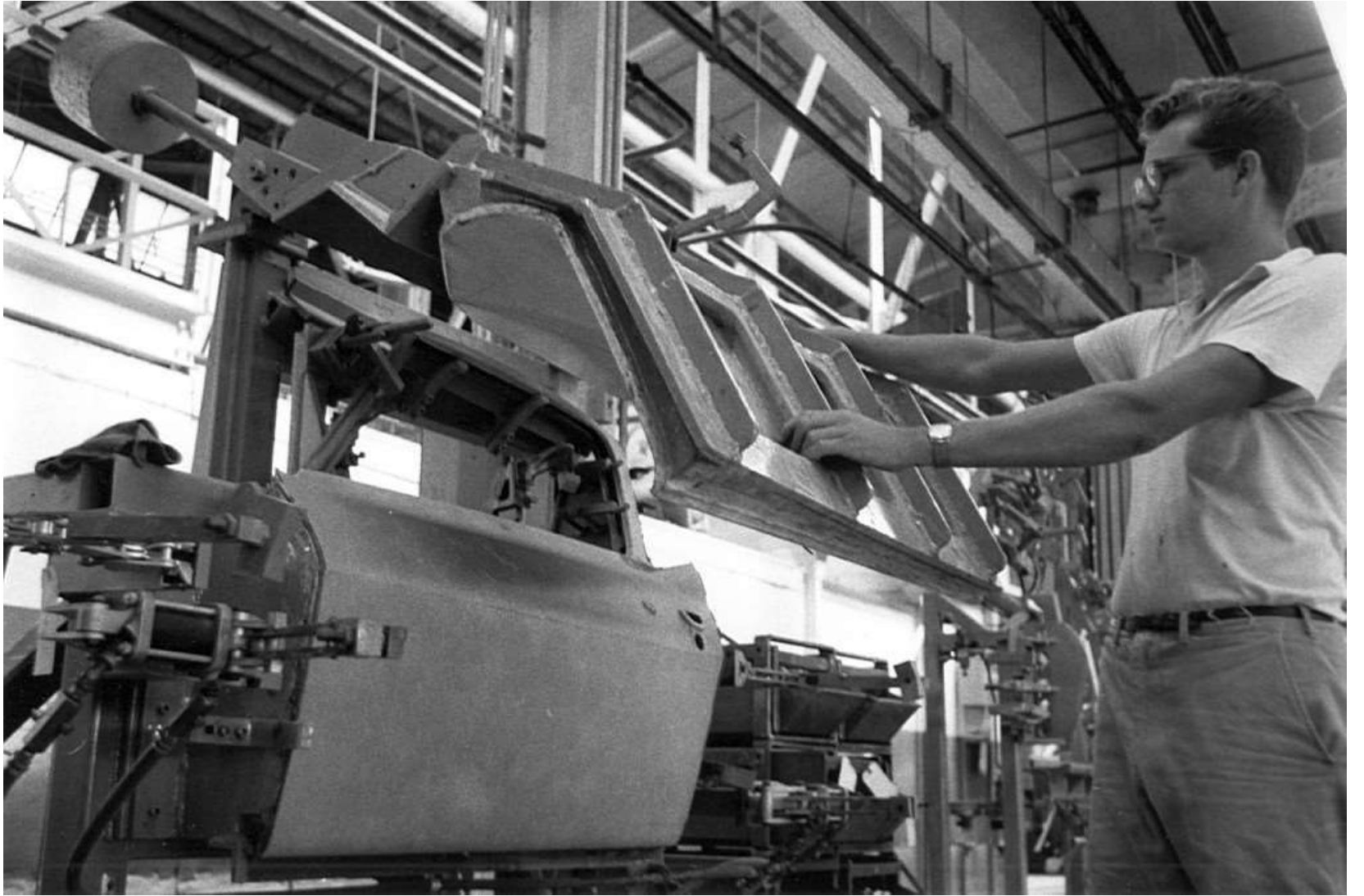
















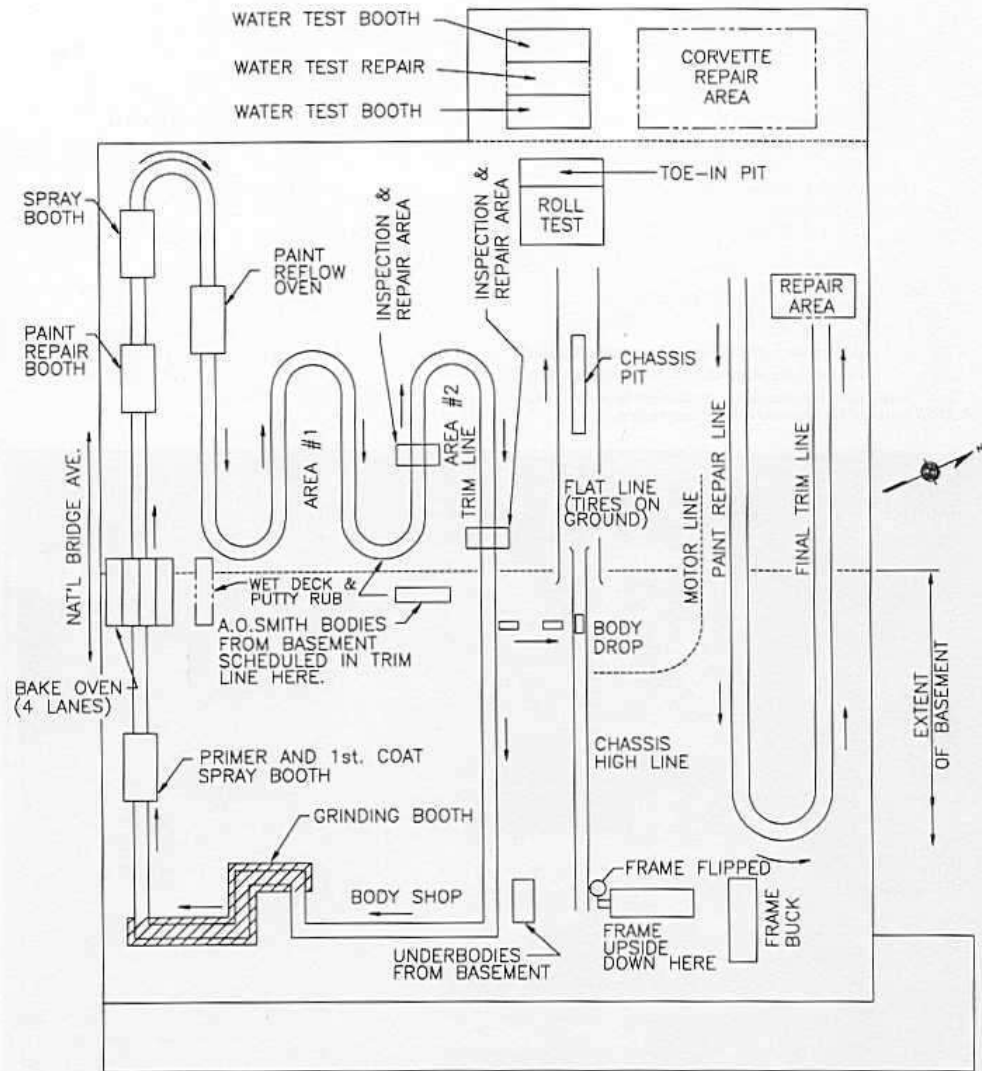












CORVETTE BLDG.
NOT TO SCALE

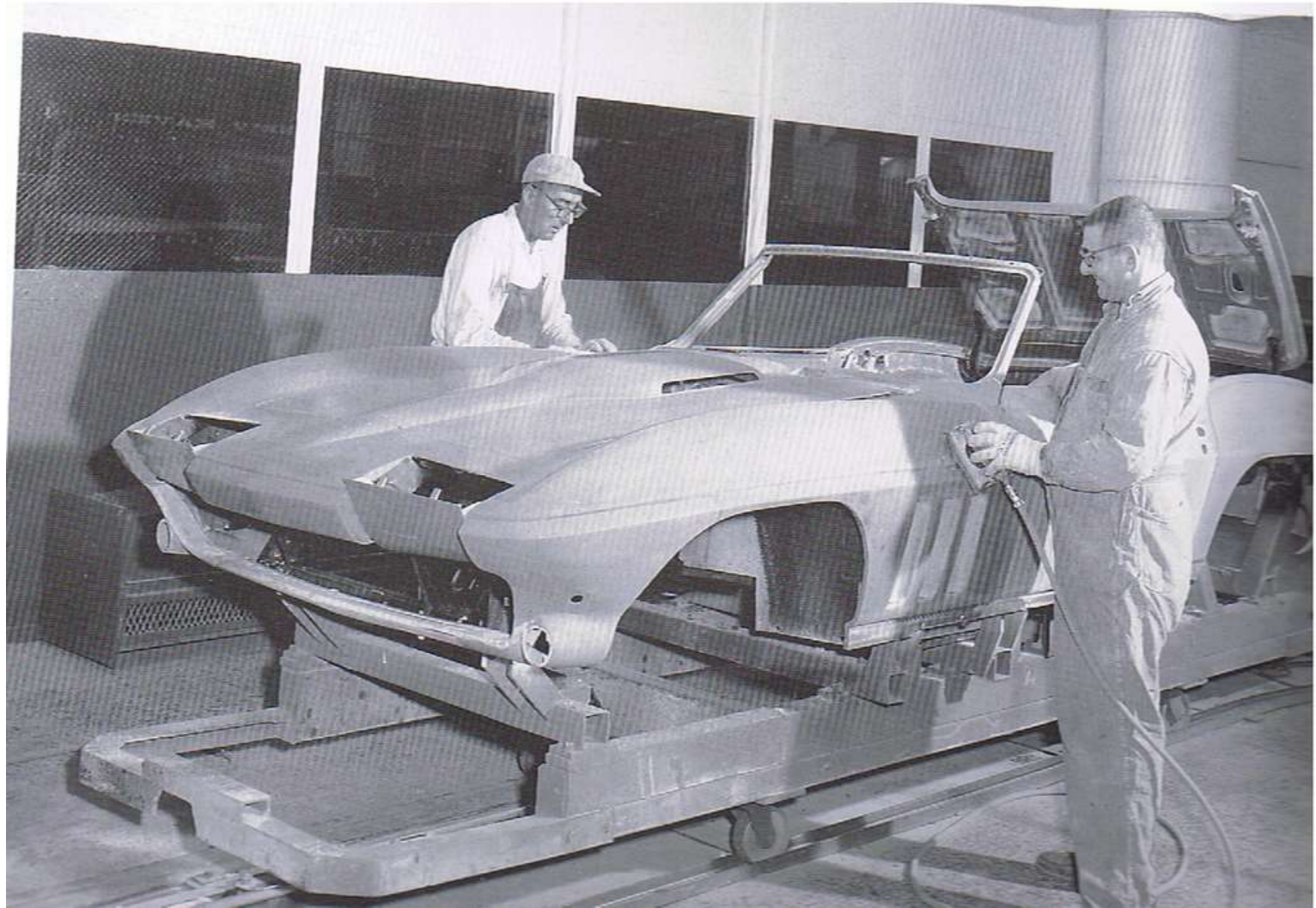


Corvette Paint Process

- **Dry-Sand Panels & Joints, Pit-Fill, Blow-Off, Tack Off, Place Parts On Floor**
- **Red & Gray Primer, Bake 60/280°F.**
- **Wet-Sand To Smooth, Oven-Dry**
- **Sealer, 3 Coats Lacquer, Wet-On-Wet**
- **First Color Bake, 20 Min. @ 160°F.**

Corvette Paint Process

- **Sand Any Imperfections, Tack Off**
- **Mask 427 Hood And Interior**
- **Re-Coat, Thinner-Blend, Interior Color**
- **Final Bake - 45 minutes at 250°F.**
- **Blackout Underhood, Wheel Wells**
- **Deadener/Undercoat Wheel Wells**
- **Polish Upper Surfaces For Gloss**





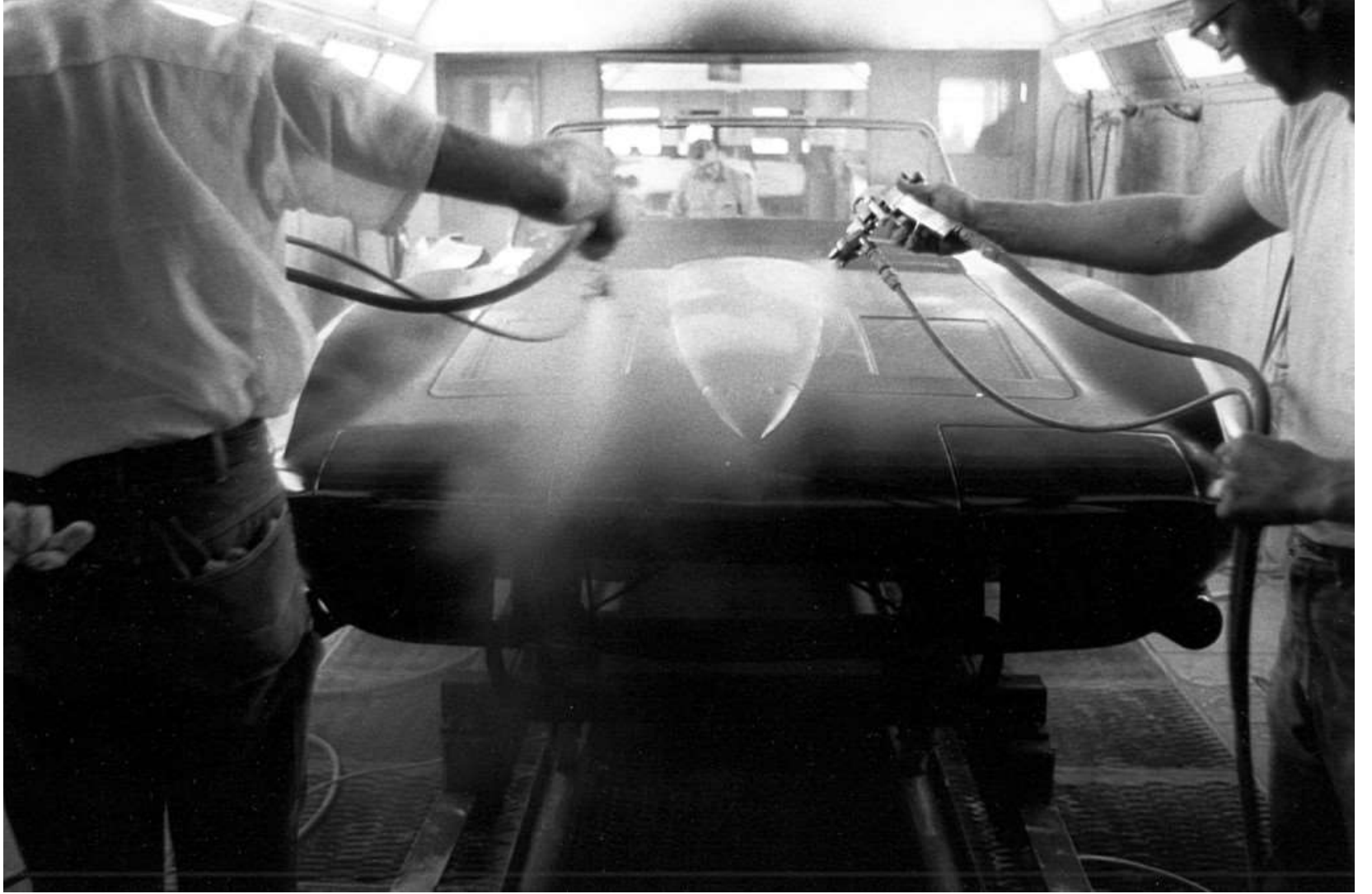


























Wheel Paint Process

- **Degrease/Phosphate/Chromate Rinse**
- **Flow-Coat Semi-Gloss Black Primer**
- **Bake 45 Minutes @ 325°F.**
- **Spray Face 83° Gloss Wheel Enamel**
- **Bake 30 Minutes @ 275°F.**
- **Deliver to Corvette Plant**
- **Same Process For Small Parts**





Interior Small Parts

- **Plastic Parts, Speaker Grille, S/W Hub**
- **Off-Line Dry Spray Booth In Trim Shop**
- **Bake In I.R. Oven - 10 Minutes @ 180°F.**
- **Deliver Parts To Line Stations**