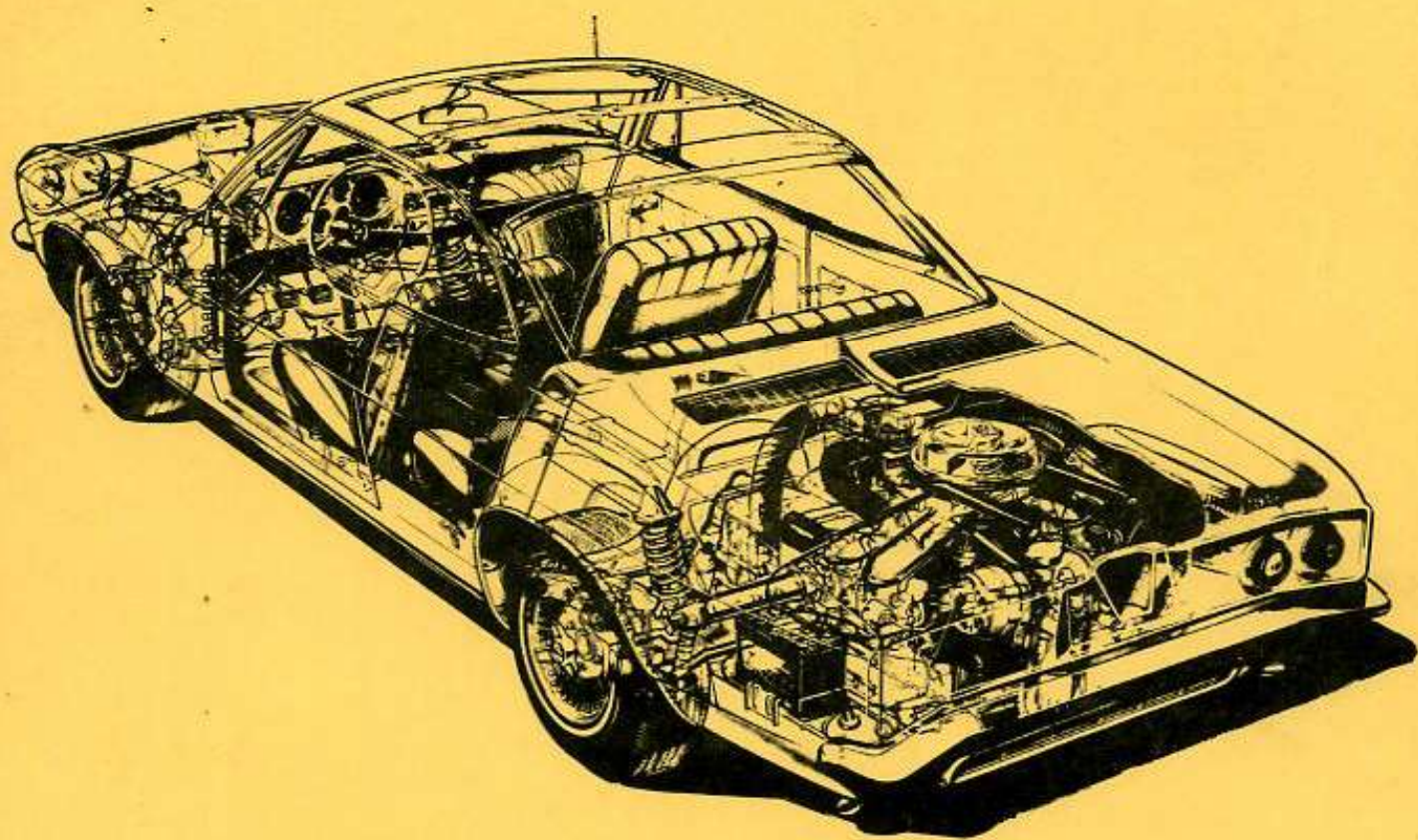


# **ASSEMBLY MANUAL**



**1965  
CORVAIR**

**C7315**

SECTION 9  
STEERING



CHEVROLET

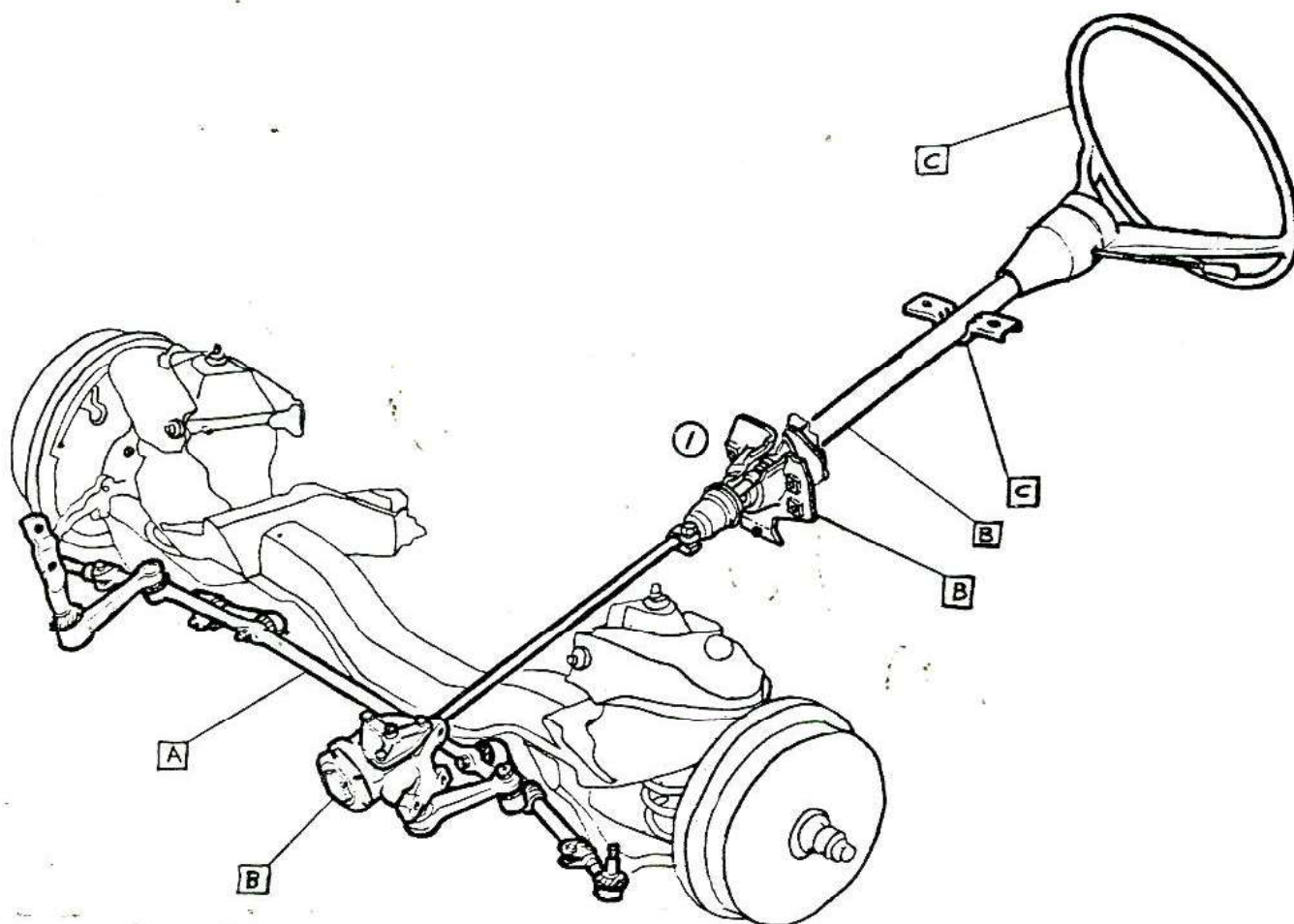
## ASSEMBLY INSTRUCTIONS

3862100

CORVAIR 10000 SERIES

SHEETTITLE

1. CONTENTS
- A** 2. RELAY & TIE ROD ASM
- B** 3. STEERING GEAR, JACKET ASM. ②
4. SEQUENCE OF ASSEMBLY
5. SEQUENCE OF ASSEMBLY
- C** 6. STEERING WHEEL



CHEVROLET MOTOR DIVISION, GMC		UPC	DATE	SYM	REVISION RECORD	AUTH	DR	CK
STEERING-CONTENTS		9	1-25-65	1	JACKET DWG. REVISED	67250	AP	
10000				2	JACKET ASM. WAS JACKET			CI
DWG PREL 5-19		1.						
DATE REL 5-19								
REF: Prel. 1		SHEET 1						
L-74625 L-								
L- L-								

1965-106

+





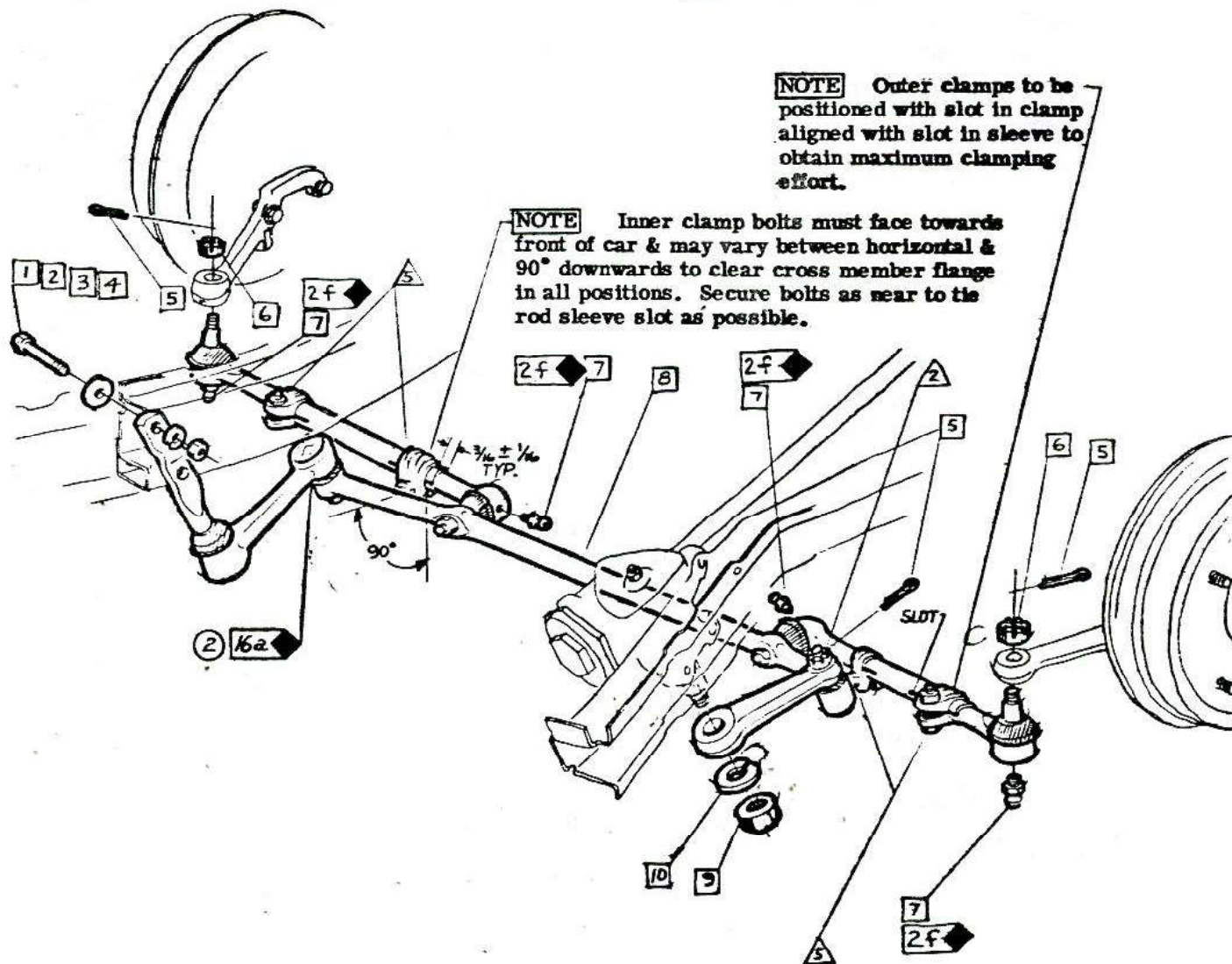
CHEVROLET

## ASSEMBLY INSTRUCTIONS

3862100

CORVAIR 10000 SERIES

- |   |         |             |    |         |                     |
|---|---------|-------------|----|---------|---------------------|
| 1 | 180113  | BOLT        | 6  | 102646  | NUT                 |
| 2 | 3747985 | SPL. WASHER | 7  | 9417901 | FITTING             |
| 3 | 103320  | L. WASHER   | 8  | 3857001 | RELAY & TIE ROD ASM |
| 4 | 120376  | NUT         | 9  | 124944  | NUT                 |
| 5 | 103373  | C. PIN      | 10 | 103331  | L. WASHER           |



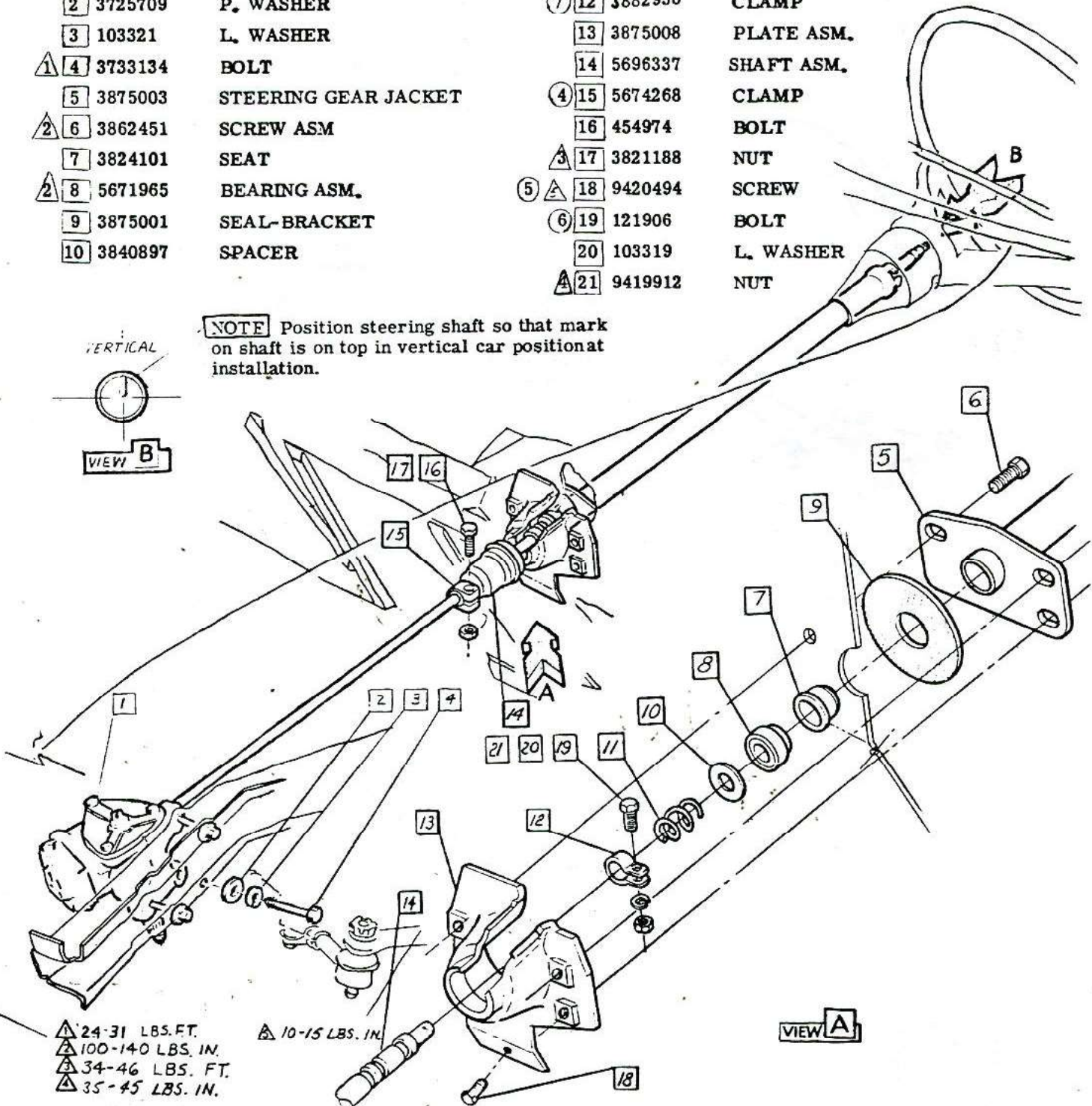
- |                 |                |
|-----------------|----------------|
| △ 14-20 LBS FT  | △ 12-16 LBS FT |
| △ 29-43 LBS FT  |                |
| △ 40-60 LBS IN  |                |
| △ 80-105 LBS FT |                |

CHEVROLET MOTOR DIVISION, GMC		UPC	DATE	SYM	REVISION RECORD	AUTH.	DR	CK
RELAY & TIE ROD ASM.		9	8-12-64	1	WAS 187119 L. WASHER	63431	WS	QC
			1-25-65	2	LUBE SYM. ADDED	68471	BR	CI
10000		2.						
DWG PREC 2-3-64 WE REF: Prel.2 L-74625 L-70428								
DATE REC 5-7-64 L-72599 L-		△ SHEET						



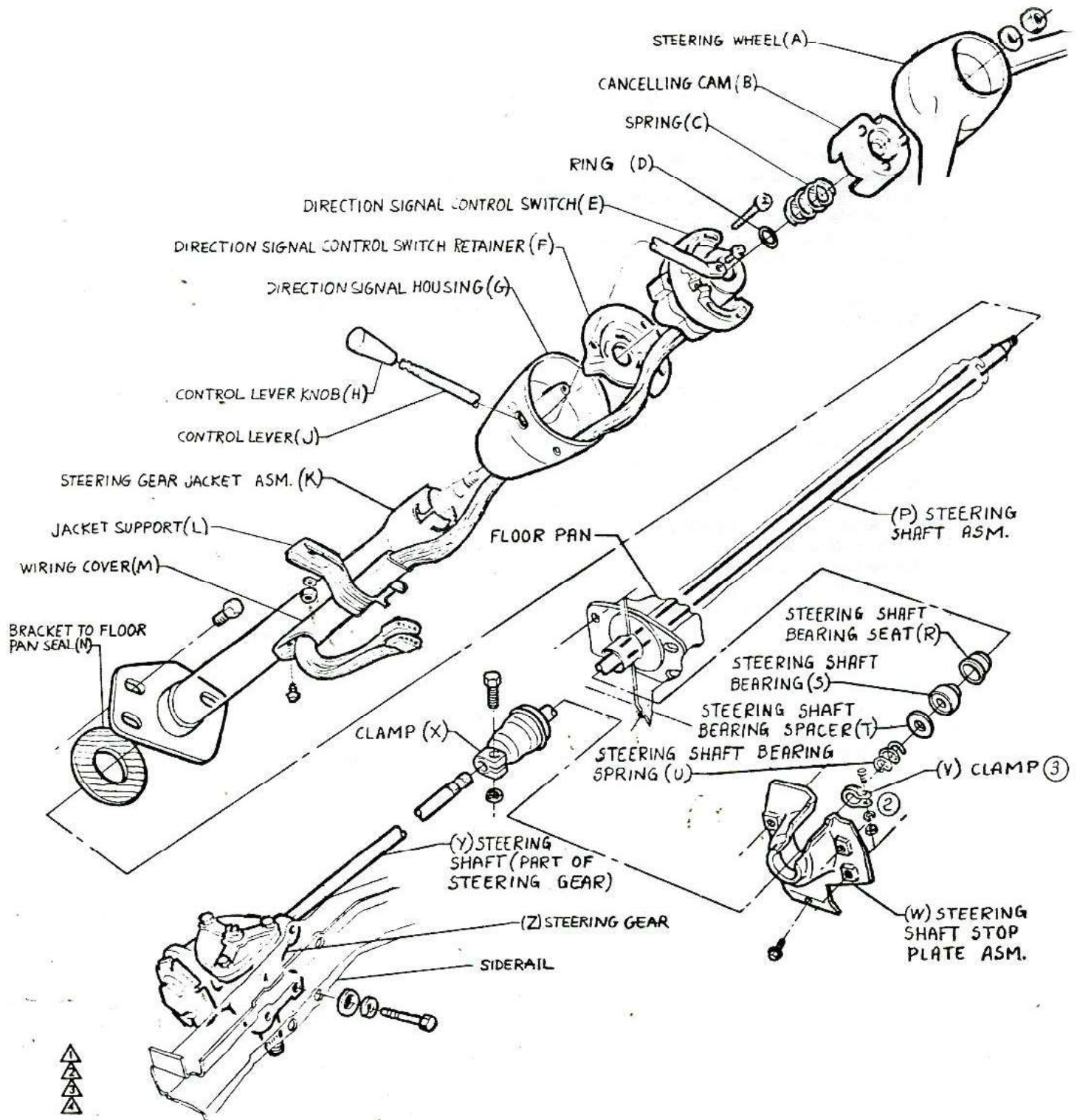
- |    |         |                      |      |         |            |
|----|---------|----------------------|------|---------|------------|
| 1  | 5695482 | GEAR ASM             | 11   | 3758803 | SPRING     |
| 2  | 3725709 | P. WASHER            | 7 12 | 3862938 | CLAMP      |
| 3  | 103321  | L. WASHER            | 13   | 3875008 | PLATE ASM. |
| 4  | 3733134 | BOLT                 | 14   | 5696337 | SHAFT ASM. |
| 5  | 3875003 | STEERING GEAR JACKET | 15   | 5674268 | CLAMP      |
| 6  | 3862451 | SCREW ASM            | 16   | 454974  | BOLT       |
| 7  | 3824101 | SEAT                 | 17   | 3821188 | NUT        |
| 8  | 5671965 | BEARING ASM.         | 18   | 9420494 | SCREW      |
| 9  | 3875001 | SEAL-BRACKET         | 19   | 121906  | BOLT       |
| 10 | 3840897 | SPACER               | 20   | 103319  | L. WASHER  |
|    |         |                      | 21   | 9419912 | NUT        |

**NOTE** Position steering shaft so that mark on shaft is on top in vertical car position at installation.



CHEVROLET MOTOR DIVISION, GMC				UPC	DATE	SYM	REVISION RECORD	AUTH	DR	CK
STEERING GEAR, JACKET				9	1-12-65	3	REDESIGNED & REDESIGNED	68664		
10000				3.			67533-67250		AP	C1
DWG PREL 2-11-64					3-31-65	4	WAS 3767107 CLAMP		KN	
DATE REL 5-14-64						5	ITEM 18 & TORQUE ADDED			
REF: Prel. 4						6	ITEM 19, 20, 21 & TORQUE ADDED	69820	LS	
L-71683						7	WAS 3875002 CLAMP		C1	
L-74625										
L-										
SHEET 1										





• CHEVROLET MOTOR DIVISION, GMC •				UPC	DATE	SYM	REVISION RECORD	AUTH.	DR	CK
SEQUENCE OF ASSEMBLY				9	1-12-65	1	REDRAWN & REDESIGNED	67250	HP	CI
					3-31-65	2	CLAMP DRAWINGS REVISED	69320	KN	
10000				REF. 5 4.		3	CLAMP WAS "CLAMP ASM"			CI
DWG PREL 4-1-64	REF: Prel. 5	L-74625	L-							
DATE PREL 4-2-64	L-	L-	L-							



ENGINEERING

## ASSEMBLY INSTRUCTIONS

3862100

CORVAIR 10000 SERIES

## PHASE I JACKET SUB-ASSEMBLY

- 1) Assemble the bearing seat (R) to bottom of jacket.
- 2) Assemble the bearing asm. (S) to bearing seat (R).
- 3) Insert directional signal control switch wires (E) thru direction signal housing (G), then install direction signal housing onto steering gear jacket (K) allowing switch to hang free.
- 4) Assemble direction signal control switch retainer (F) onto steering gear jacket (K) by inserting tang on jacket into slots in retainer.
- 5) Assemble switch (E) to housing (G).
- 6) Route switch wires thru wiring cover (M).
- 7) Push cover (M) into housing (G) until cover hits stop on jacket (K). Fasten cover to jacket.
- 8) Heat control lever knob (H) to 100-130° F. and install to control lever (J).
- 9) Install control lever (J) to switch (E).

## PHASE II SHAFT &amp; JACKET SUB-ASSEMBLY

- 1) Loose assemble special clamp (V) to steering shaft (P) and push down until clamp is near universal joint coupling.
- 2) Follow clamp with spring (U) and spacer (T).
- 3) Assemble steering shaft up thru the bottom of jacket (K).
- 4) Assemble upper bearing ring (D) to steering shaft (P).
- 5) Adjust bearing preload and set end play from .005 to .030 and torque special clamp (V).

## PHASE III ASSEMBLY TO VEHICLE

- 1) Push shaft & jacket asm. thru floor pan and loose assemble to instrument panel.
- 2) Loose assemble steering gear (Z) to side rail.
- 3) Assemble universal joint coupling to steering gear and torque.
- 4) Torque steering gear to side rail.
- 5) Assemble stop plate (W) to underside of toe pan and torque attaching screw.
- 6) Assemble and torque jacket mounting flange to toe pan.
- 7) Torque jacket to instrument panel.
- 8) Assemble cancelling cam (B) to steering wheel (A) by inserting tangs on cam into holes in wheel. Line up cartridge in wheel with hole in cam.
- 9) Assemble spring (C) to steering shaft.
- 10) Line up mark on steering wheel with mark on steering shaft. Install wheel to shaft.



• CHEVROLET MOTOR DIVISION, GMC •		UPC	DATE	SYM	REVISION RECORD	AUTH.	DR	CK
SEQUENCE OF ASSEMBLY		9	12-65	1	REDRAWN & REDESIGNED	AP	CI	
10000		REF 4.						
DWG PPL 4-21-64		5.						
DATE PPL 4-21-64		SHEET 1						
REF: Prel. 6 L-74625 L-								
L- L- L-								





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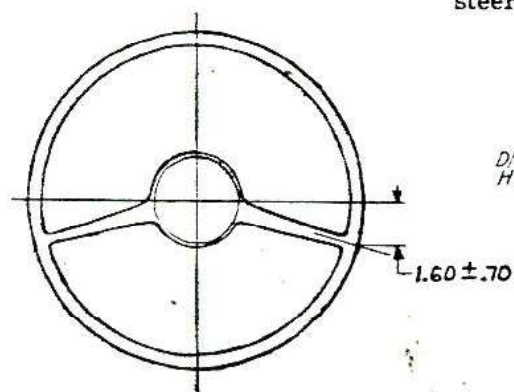
# ASSEMBLY INSTRUCTIONS

3862100

CORVAIR 10000 SERIES

- ① 1 271506 NUT
- 2 103342 L. WASHER
- 3 9741610 STEERING WHEEL  
CHART 10100-300  
9741790 10500-700
- 4 3862907 SPRING
- ① 5 580074 RING
- 6 3852899 SUPPORT
- ② 7 3847758 SCREW ASM

**NOTE** Position Mast Jacket axially until this clearance is obtained between direction signal housing & steering wheel.



DIRECTION SIGNAL HOUSING

1.60 ± .70

**CAUTION** Direction Signal lever must be in neutral position when assembling steering wheel to prevent damage to control asm & cancelling cam.

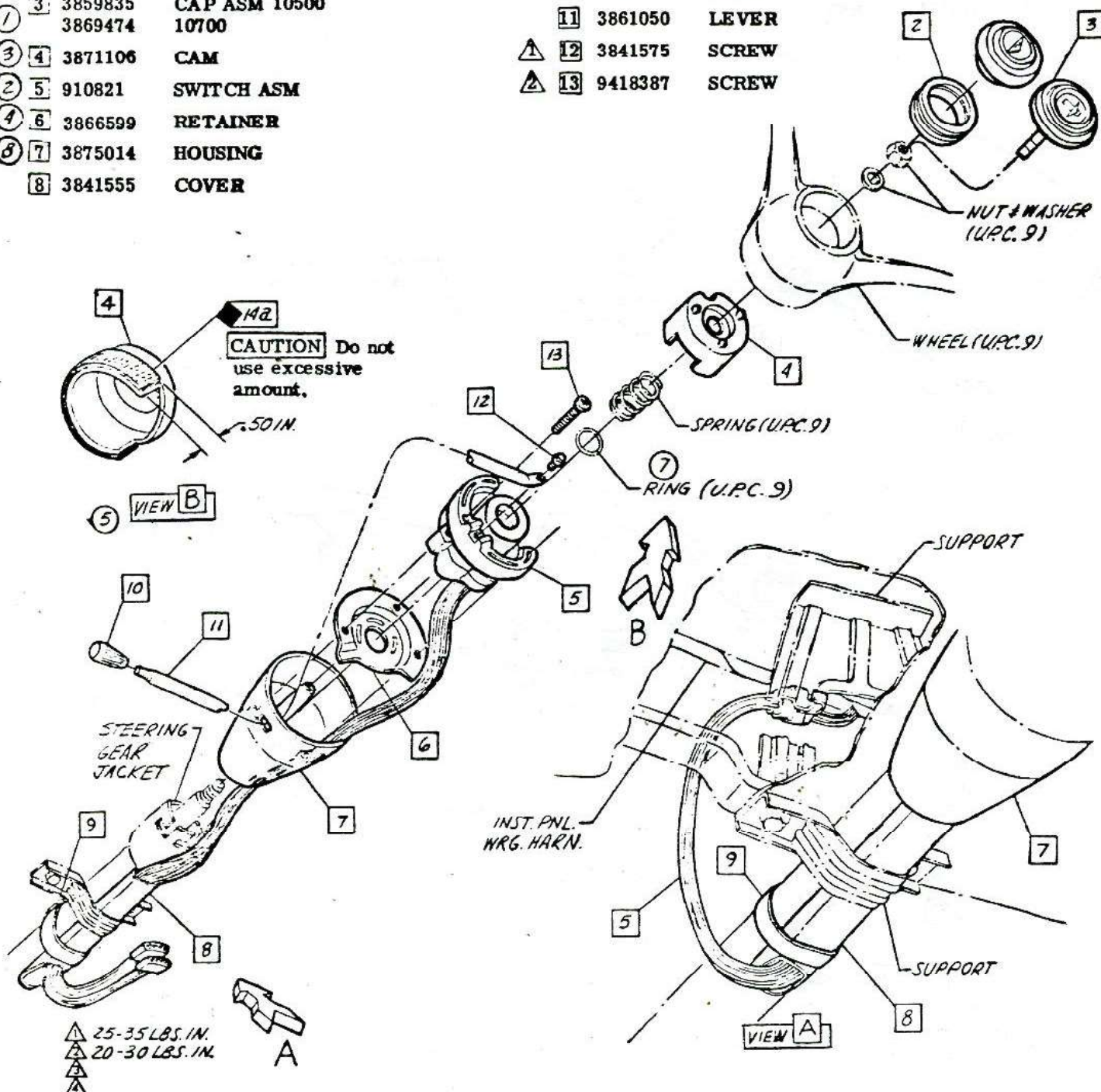
△ 25-35 LBS FT  
△ 100-140 LBS IN.  
△

• CHEVROLET MOTOR DIVISION, GMC •				UPC	DATE	SYM	REVISION RECORD	AUTH.	DR	CK	
STEERING WHEEL				9	2-2-65	1	WAS 3863555 SLEEVE	67850	HP		
						2	COLUMN DWG REVISED			CI	
10000				6.							
DWG PREL-2-5-64											
DATE REL 5-7-64											
REF: Prel. 3 L-71683 L-73921				SHEET 1							
L- L- L-											



- ⑦ 3859834 CAP 10100  
② 764427 RING 10100  
③ 3859835 CAP ASM 10500  
③ 3869474 10700  
③ ④ 3871106 CAM  
② ⑤ 910821 SWITCH ASM  
④ ⑥ 3866599 RETAINER  
⑥ ⑦ 3875014 HOUSING  
⑧ 3841555 COVER

- ⑥ ⑨ 3724851 TAPE (APPROX 3 IN. TAPE  
COVER TO STEERING GEAR JACKET)  
⑩ 3782965 KNOB  
⑪ 3861050 LEVER  
① ⑫ 3841575 SCREW  
① ⑬ 9418387 SCREW



• CHEVROLET MOTOR DIVISION, GMC •			UPC	DATE	SYM	REVISION RECORD	AUTH	DR	CK
DIRECTION SIGNAL SWITCH			12	7-7-64	1	3869474 S-F ADDED	64894	WF	
					2	WAS 910746 SWITCH	61704		DP
				7-25-64	3	W-S 3861049 CAM	65709	WF	
					4	WAS 3852139 RETAINER	63892		
					5	VIEW B ADDED	65681		DF
				9-22-64	6	WAS 3793789 FASTENER	15875	WF	DF
				1-25-65	7	WAS SLEEVE	67250	AP	
					8	WAS 3861048 HOUSING			C1
10000			C1						
DWG PREL 3-6									
DATE REL 3-6-64									
REF: Prel. C-5 L-71683 L-									
L- L- L-									
			SHEET						

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