

## Service Bulletin.

BODY  
PV 444 and 544

Sheet 1 of 3

Instructions for fitting and removing side and extension members  
on PV 444 and 544

As a result of thorough method studies we have arrived at the procedure given below for carrying out the above work.

The instructions are listed as follows:

1. Removing of side member only.
2. Fitting of side member only.
3. Removing of both side and extension members
4. Fitting of both side and extension members.
5. Removing of both the side members with tubular members
6. Fitting both the side members with tubular members

Removing of side member only

1. Burn off with a cutting torch the side member 1 - 2 mm ( 1/32 - 5/64" ) from the flanges and the welds between the extension and side members and between the side and tubular members.
2. Roll up the remaining flanges on the bulkheads with rolling tool SVO 2330, see fig.3.
3. Chisel off with a pneumatic chisel any points on the bulkhead, the side member contact with the extension member and any remnants on the bulkhead reinforcing member and tubular member.
4. Grind the welds with a portable grinder.

Fitting side members only

1. Attach fixture SVO 2328 to the gear box suspension and the undamaged side member. Then secure the new side member in the fixture. Use ratchet handle and 14 mm (0.55") sleeve. See fig. 1.

2. Locate fixture SVC 2331 in the hole for the pedal position - extension member (only on left-hand side) and fixture SVC 2327 to side member - bulkhead.
3. Check with a steel tape measure the measurement 975 mm ( 38.38" ) from the hole for the cowl insulation button in the bulkhead to the front edge of the side member, see Fig. 2. Adjust in the side member against the bulkhead and extension member in the floor with the help of two wrenches and hammer and by turning the adjusting screws on the fixtures SVC 2327 and SVC 2323 in relation to each other. Recheck measurement 975 mm ( 38.38" ).
4. Spot weld ( TP 2 mm = 5/64" electrodes ) the side member flanges to the bulkhead. Electric weld ( electrodes TP 2 mm = 5/64" ) the side member and bulkhead reinforcing member and weld on the extension member to the side member ( electrodes TP 2.5 mm = 0.10" ).
5. Adjust the side member to the tubular member with fixture SVC 2329 ( see Fig. 1.) Then weld these together ( electrodes TP 2.5 mm = 0.10" ).
6. Check the measurement 975 mm ( 38.38" ) and then remove the fixtures.

#### Removing side and extension member

1. Warm up the floor with cutting torch and remove the floor insulation with a putty knife.  
Burn off (with a cutting torch) 1 - 2 mm ( 1/32" - 5/64" ) from the flanges and the weld between the side and tubular member.
2. Drill out the points in the extension member from above and the weld in the rear edge of the extension member ( 5.5 mm = 7/32" drill ).
3. Remove the side and extension members ( using pneumatic chisel if necessary ).
4. Roll up the remaining flanges on the bulkhead with rolling tool SVC 2330, see Fig. 3.
5. Chisel off any points on the bulkhead, on the bulkhead reinforcing member and any remnants on the tubular member. ( Use pneumatic chisel ).
6. Grind the welds with a portable grinder.

#### Fitting side and extension member

1. Place fixture SVC 2328 on the gearbox suspension and fit a new side member in the fixture. Use a ratchet handle and 14 mm ( 0.55" ) sleeve. See Fig. 1.

2. Mark out and drill holes in the new extension member (6 mm = 15/64" drill).
3. Fit fixture SVC 2331 at the hole for the pedal position - extension member (only on left-hand side), then spot-weld the extension member to the floor (electrodes TP 2 mm = 5/64").
4. Fit fixture SVC 2327 to side member - bulkhead. Check with a steel tape measure, measurement 975 mm (38.38") from the hole for the cowl insulation button in the bulkhead to the front edge of the side member, see Fig. 2. Adjust the side member to the bulkhead and extension member to the floor with the help of two wrenches and hammer and by turning the adjusting screws on the fixtures SVC 2327 and SVC 2328 in relation to each other. Recheck the measurement 975 mm (38.38").
5. Spot weld (electrode TP 2 mm = 5/64") the side member flanges to the bulkhead.
6. Electric weld the side member and bulkhead reinforcing member (electrode TP 2 mm = 5/64"), extension member to side member (electrodes TP 2 mm = 5/64"), extension member to the floor from underneath (electrodes TP 2 mm = 5/64").
7. Adjust the side member to the tubular member with fixture SVC 2329, see Fig.1, and weld these together (electrodes TP 2.5 mm = 0.10").
3. Check the measurement 975 mm (38.38") with a steel tape measure and remove the fixtures.

#### Removing both side members with tubular member

1. Burn off with a cutting torch 1-2 mm (1/32 - 5/64") from the side member flanges, the welds between the extension and side member, and the welds between the side and tubular member.
2. Roll up the remaining flanges on the bulkhead with rolling tool SVC 2330, see Fig.3.
3. Chisel off with a pneumatic chisel any points on the bulkhead, side member joint with the extension member and any remnants on the bulkhead reinforcing member and tubular member.
4. Grind the welds with a portable grinder.

#### Fitting both side members and tubular member

1. Attach fixture SVC 2323 at the gearbox suspension, then place the new side members in the fixture. Use ratchet handle and 14 mm (0.55") sleeve. See Fig. 1.

2. Attach fixture SVO 2331 at the hole for the pedal position - extension member on left-hand side. Then fit fixture SVO 2327 to side member - bulkhead on both sides. See Fig. 1.
3. Check with a steel tape measure the measurement 975 mm ( 38.38" ) from the hole for the cowl insulation button in the bulkhead to front edge of the side member, see Fig. 2. Adjust in the side member to the bulkhead and extension member with the help of two wrenches and hammer and by turning the adjusting screws on the fixture SVO 2327 and SVO 2323 in relation to each other. Recheck the measurement 975 mm ( 38.38" ).
4. Spot weld ( electrodes TP 2 mm = 5/64" ) the side member flanges to the bulkhead. Weld the side member and bulkhead reinforcing members ( electrodes TP 2 mm = 5/64" ) and the extension member to the side member ( electrodes 2.5 mm = 0.10" ).
5. Fit the tubular member to the side members with the help of fixtures SVO 2329 and adjust the welding joint on both sides, then weld the tubular members to the side members ( electrode 2.5 mm = 0.10" ).
6. Check the measurement 975 mm ( 38.38" ) with a steel tape measure and then remove the fixtures.

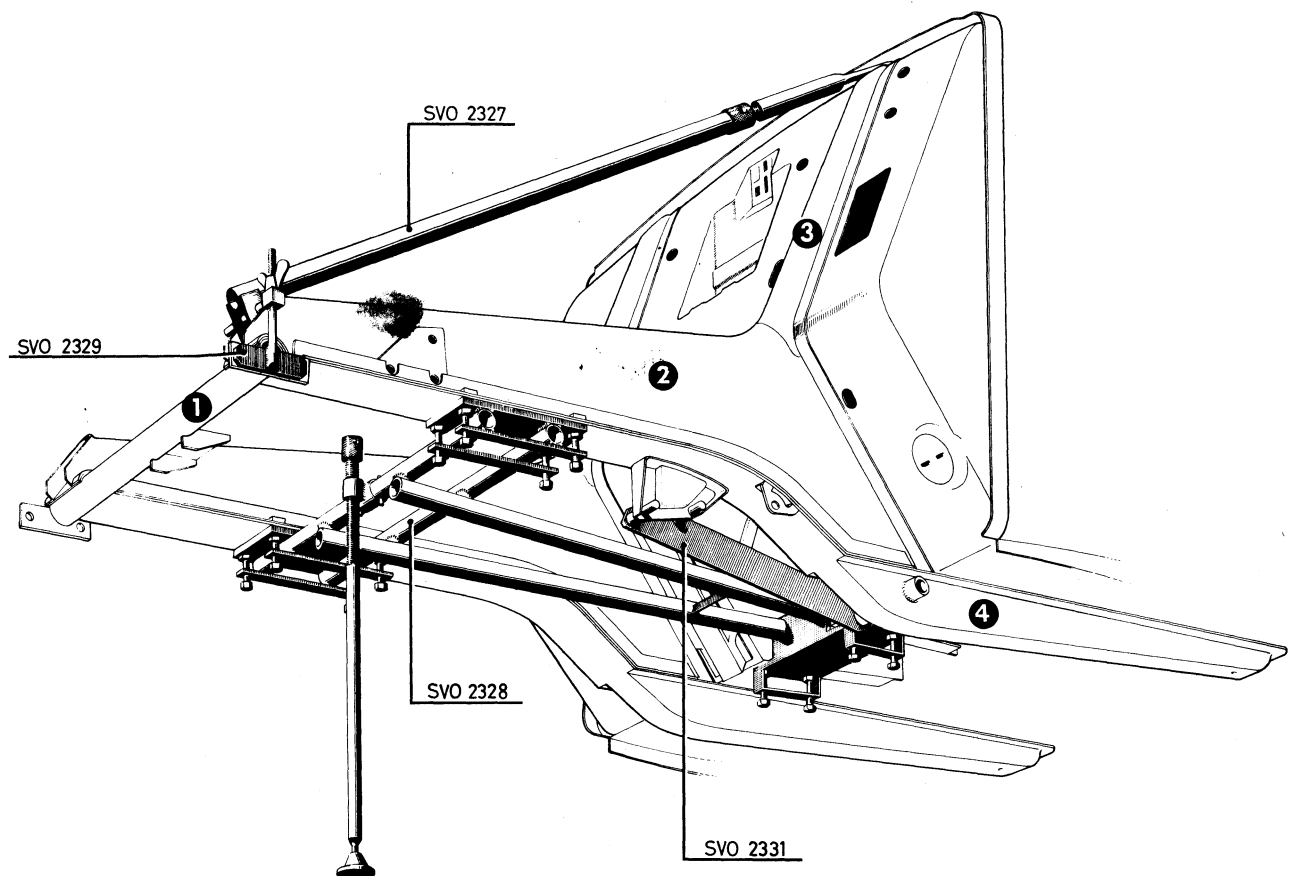


Fig. 1.

1. Tubular member
2. Side member
3. Bulkhead reinforcing member
4. Extension member

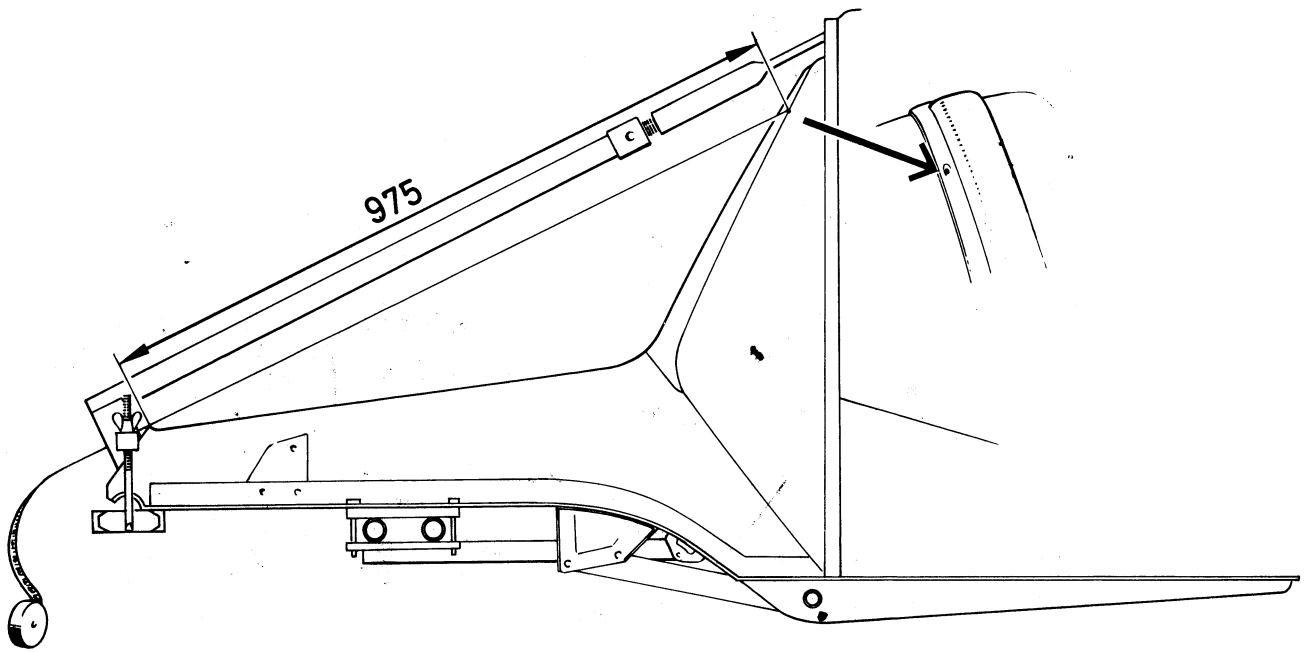


Fig. 2.

Bild 2

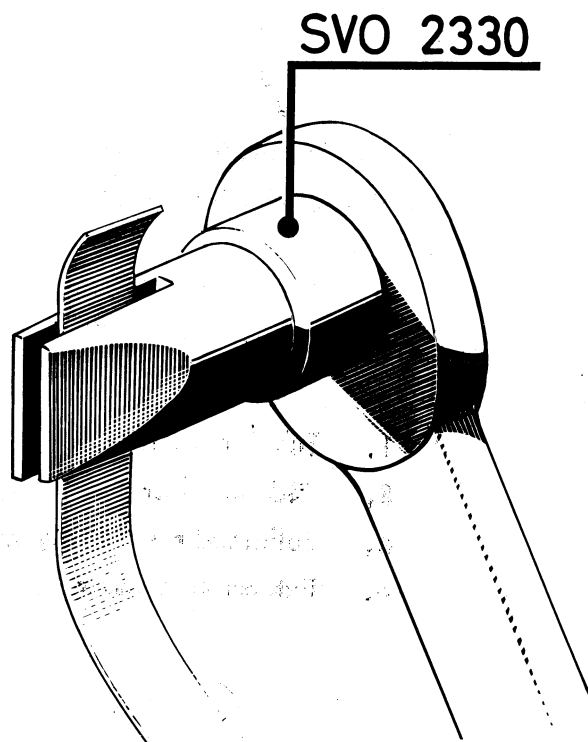


Fig. 3.

Bild 3