

VOLVO

February 1960

Group 800 No. 5 b**Service Bulletin.**

BODY

PV 444 chassis number
68956 onwards and 544

Sheet 1 of 3

Removing a front mudguard, wheel housing plate and front end
(the parts to be scrapped)

Regarding tool list and figures, see Service Bulletin 800 no. 5

Operation

1. Cut out the mudguard about 20 mm (13/16") from the inner edge, cutting as shown in fig. 11
2. Cut away a strip about 70 x 15 cm (27 1/2 x 5 7/8") from the front end with pneumatic tool, see fig. 8
3. Remove the letters from the strip cut out of the front end
4. Remove the splash apron from the mudguard
5. Remove headlight, traffic indicator, horn and earthing cables from the left wheel housing plate.
6. Undo the clips and pull out the cables in the front end
7. Remove traffic indicator with cables
8. Remove headlight rims, insert and 3-pin connecting piece (see fig. 2) and headlight cables
9. Remove horn with cables
10. Pull out headlight and traffic indicator cables

Tools

- Pneumatic tool,
bit No. 1
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bit No. 1
- Polygrip pliers.
- Ratchet handle
10 mm Socket spanner
10 mm valve spanner
- Screw driver
- "Yankee" screwdriver, see fig. 1
with X-headed bit, drawing pliers
and small screwdriver
- Screwdriver
Thin ground tweezers for early
production. For late production,
thin ground screwdriver.
- Ratchet handle
Extension piece
18 mm socket spanner
6 mm socket wrench.

Operation	Tools
11. Remove the rubber grommets and rubber stop for the bonnet hinge	
12. Remove the four bolts mudguard-cowl side	Brace 13 or 14 mm socket spanner.
13. Remove the bolt wheel housing plate and side member	Brace 12 mm socket spanner
14. Remove the four bolts mudguard-front end (other side)	13 mm internal ratchet See fig. 7.
15. Remove the nuts in the grille (other side).	Ratchet handle extension piece 10 mm socket spanner
16. Remove the two bolts front end - wheel housing plate (other side)	Ratchet handle 10 mm socket spanner 10 mm valve spanner
17. Remove the radiator blind chain	Side-cutting pliers
18. Remove the upper and lower radiator hoses from the radiator	Screwdriver
19. Remove the two nuts front end - tubular member. Then lift off the mudguard and front end	Side-cutting pliers brace 15 mm socket spanner.
20. Remove the radiator	Ratchet handle 10 mm socket spanner
21. Remove the drain-off cock and cover Remove radiator blind	9/16" valve spanner "Yankee" tool with X-headed bit. See fig. 1
22. Remove the bonnet hinges (undamaged)	Ratchet handle 15 mm socket spanner 17 mm valve spanner.
23. Remove the fresh air intake	7 mm socket wrench.

Pre-assembling and fitting a front mudguard, wheel housing plate and front end.

Operation	Tools
1. Fit the rubber washer and contact tab to the studs on the front end	
2. Place the front end in fixture SVO 2371. See fig. 9	SVO 2371
3. Fit rubber bushings for horn, headlight cables and traffic indicator.	
4. Fit rubber stop for bonnet hinges	Screwdriver
5. Fit horn with cables	Screwdriver ratchet handle 18 mm socket spanner 6 mm socket wrench extension piece.
6. Fit the horn relay and connect up its cables (special car)	"Yankee" tool with X-headed bit, see fig. 1 Screwdriver
7. Fit the radiator blind	"Yankee" tool with X-headed bit.
8. Fit the bonnet hinges	Ratchet handle, 15 mm socket spanner 17 mm valve spanner.
9. Fit the fresh air intake with gauze	7 mm socket wrench drift drilling machine 2.4 mm drill.
10. Fit the cables for headlight and traffic indicators.	
11. Fit radiator and drain-off cock	Brace 10 mm socket spanner 10 mm valve spanner 9/16" valve spanner

Operation	Tools
12. Place the front end in position and bolt on but do not tighten the bolts finally	Brace 15 mm socket spanner.
13. Fit the upper and lower radiator hoses	Screwdriver
14. Place the mudguard on a bench, secure it and clip off a strip for the bonnet hinge bolt, see fig 6.	Quick release clamp or screw clamp metal sheers
15. Fit the wheel housing plate to the mudguard. (Bolts not to be tightened)	13 mm internal ratchet, see fig.7
16. Pre-assemble the outer casing with internal casing and then fit them to the mudguard	"Yankee" tool with screwdriver bit 8 mm socket wrench 8 mm valve spanner "Yankee" tool with X-headed bit
17. Place the mudguard in position and fit the bolt wheel housing plate - side member. (Bolt not to be tightened)	Ratchet handle 12 mm socket spanner.
18. Fit the four bolts mudguard - front end and the four bolts mudguard - cowl side. (Bolts not to be tightened)	13 mm internal ratchet
19. Fit the two bolts wheel housing plate - front end	Ratchet handle 10 mm socket spanner 10 mm valve spanner.
20. Fit the weatherstrips in position and tighten the twelve mudguard bolts	13 mm internal ratchet
21. Tighten the bolts wheel housing plate - side member	Ratchet handle 12 mm socket spanner
22. Fit the splash apron	
23. Fit the four bolts mudguard - front end (other side). Do not tighten the bolts	13 mm internal ratchet
24. Fit the two bolts wheel housing plate - front end (other side)	Ratchet handle 10 mm socket spanner 10 mm valve spanner.

Operation	Tools
25. Fit on the weatherstrips and tighten the four bolts mudguard - front end to the mudguard	13 mm internal ratchet screwdriver.
26. Fit the headlight cables with rubber bushing on the connecting piece and insert with inner rim. Then fit outer rim with gasket	screwdriver.
27. Connect the cables to the traffic indicators	Drawing pliers
28. Fit the traffic indicator to the mudguard and then place on the glass and rim	"Yankee" tool with X-headed bit. screwdriver
29. Fit the Volvo emblem	Adjustable spanner 00
30. Fit the grille	Ratchet handle 10 mm socket spanner extension piece 11 mm socket spanner
31. Connect the cables to the junction block on the left wheel housing plate	Screwdriver.
32. Fit the hose to the fresh air intake	
33. Fit the radiator blind chain	Cutting pliers.
34. Tighten up finally and lock the nuts front end - tubular member.	Brace 15 mm socket spanner cutting pliers.