

Service Bulletin.

BODY

PV 444 chassis number
68956 onwards and 544Removing both front mudguards and front end.

(The parts to be scrapped)

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

Operation

1. Remove the splash apron from the mudguard, left side
2. Cut off the mudguard about 20 mm (13/16") from the inner edge cutting in accordance with fig. 11, left side
3. Remove the splash apron from the mudguard, right side
4. Cut off the mudguard about 20 mm (13/16") from the inner edge, cutting in accordance with fig. 11, right side
5. Using pneumatic tool, cut away a strip about 70 x 15 cm (27 1/2 x 5 7/8") on the front end, see fig. 8.
6. Remove the letters on the strip cut out from the front end.
7. Remove rims, inserts and 3-pin connecting pieces, see fig. 2
8. Remove headlight, traffic indicator, horn and earthing cables from the left wheel housing plate
9. Remove traffic indicators with cables
10. Remove the headlight cables

Tools

- Ratchet handle, 10 mm socket
spanner
10 mm valve spanner.
- Pneumatic tool
bit no. 1. See fig. 5.
- Ratchet handle, 10 mm socket
spanner, 10 mm valve spanner.
- Pneumatic tool
bit no. 1. See fig. 5.
- Pneumatic tool
bit no. 1.
- Polygrip pliers.
- Screwdriver
Thin-ground tweezers for early
production. For late production,
thin-ground screwdriver.
- Screwdriver
- Screwdriver, "Yankee" tool
with X-headed bit, see fig. 1.

Fitting both front mudguards and front end

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

Operation**Tools**

14. Place the mudguards on a bench and secure them and then cut off a strip for the bonnet hinge bolt, see fig. 6 (the following operations apply to both sides)
Quick-release clamp or screw clamp, metal cutting shears.
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 external casing with internal casing and then fit them to the mudguard
"Yankee" tool with screwdriver bit, hook, see fig. 12
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 - side of cowl. 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 and tighten the twelve mudguard bolts
13 mm internal ratchet,
screwdriver.
21. Tighten the wheel housing plate to the side member
Ratchet handle, 12 mm socket spanner.
22. Fit the splash apron to the mudguard
Ratchet handle, 10 mm socket spanner
10 mm valve spanner.
23. Fit the headlight cables with rubber bushing 3 - pin connecting piece and insert with inner rim and then outer rim with gasket
Screwdriver.
24. Connect the cables to the traffic indicators
Drawing pliers.

Operation	Tools
25. Fit the traffic indicators to the mudguards and place on glasses and rims	Screwdriver.
26. Fit the Volvo emblem	Adjustable spanner 00.
27. Fit the grille	Ratchet handle, 10 mm socket spanner extension piece, 11 mm socket spanner.
28. Connect the cables to the junction block on the left wheel housing plate	Screwdriver.
29. Fit the hose to the fresh air intake	
30. Fit the radiator blind chain	Cutting pliers.
31. Finally tighten and lock the nuts front end - tubular member	Brace, 15 mm socket spanner, cutting pliers.