

**Volvo300mania**

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This manual is a photocopy of the  
original service manual

Order No. TP35091/1

We reserve the right to make alterations

# Group 70 General

## General Data

### TIGHTENING TORQUES

In this manual 2 kinds of tightening torques are shown:

- I. Tighten to **40 Nm** (4.0 kgm), indicates that a torque wrench **must** be used when tightening.
- II. Tightening torque 40 Nm (4.0 kgm), indicates a guide value.  
Tightening **need not** be done with a torque wrench.

### Specifications

#### FRONT SUSPENSION

	B14 (up to 1977)	B14 (from 1977)	B19
<b>Stabilizer</b>			
Rod diameter .....	mm ø21	mm ø20	mm ø23
<b>Coil spring</b>			
Free length .....	mm 366	mm 350	mm 357
Number of coils .....	6.5	6.5	6.5
Wire diameter .....	mm 10.4	mm 10.7	mm 11.6
Coil diameter .....	mm 116	mm 116	mm 116

**Note:** always use two springs with the same colour code for any one car.

<b>Shock absorber</b>	
Piston diameter .....	mm ø32
Piston rod diameter .....	mm ø22

#### SUSPENSION

.....	asymmetric, parabolic rolled leaf spring
Number of leaves .....	1
Length, up to chassis No. 435625 .....	mm 1260
Length, from chassis No. 435625 .....	mm 1250
Width .....	mm 60

**Note:** leaf springs must be renewed as a pair (with the same colour code).

#### Shock absorbers

Shock absorbers must be renewed as a pair. Always fit two shock absorbers with the same part numbers to avoid differences in damping force setting.

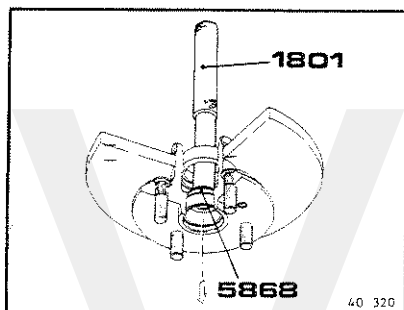
## TIGHTENING TORQUES

	Nm	kgm
<b>Front suspension</b>		
Brake caliper attachment (— 1980) .....	68	6.8
Brake caliper attachment (1980—) .....	118	11.8
<b>Rear suspension</b>		
Axle shaft nuts, B14 .....	245	24.5
B19 .....	220	22.0
Bearing housing/brake backplate bolts .....	52	5.2

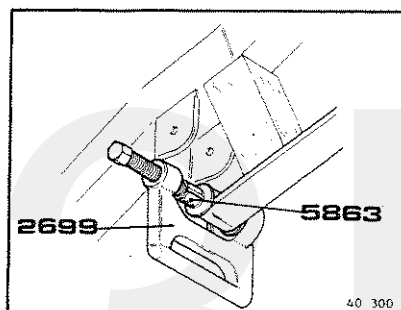
V3M

## Special tools

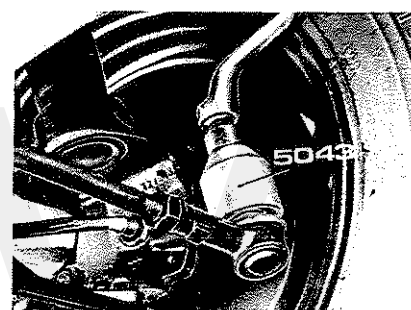
999	Description - Application
1801	Universal handle: for use with drifts 5868 and 5869
2699	Auxiliary pressing tool: for use with drift 5863
5043	Auxiliary pressing tool: for removing steering rod end
5860	Compressor: for coil spring
5861	Compressor: for coil spring
5862	Special ring spanner: for shock absorber union nut
5863	Drift: for use with pressing tool 2699
5866	Auxiliary pressing tool: for removing steering swivel ball joint
5867	Drift: for fitting and removing spring eye rubber bushes
5868	Drift: for removing outer front wheel bearing
5869	Drift: for removing inner front wheel bearing
5938	Drift: for fitting front wheel bearing cups



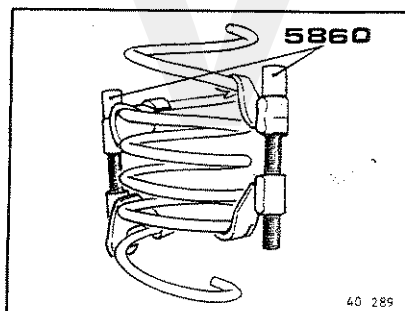
1801



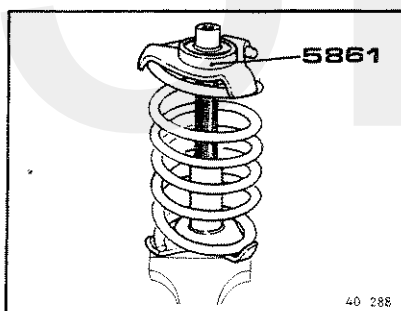
2699



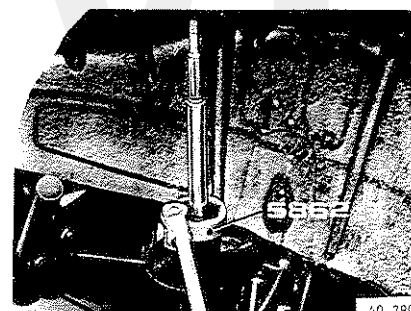
5043



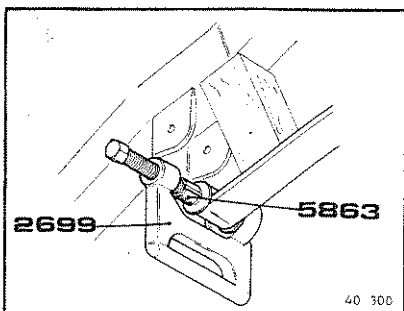
5860



5861



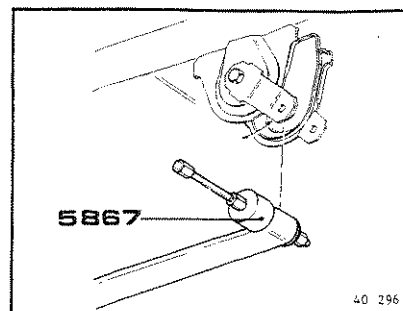
5862



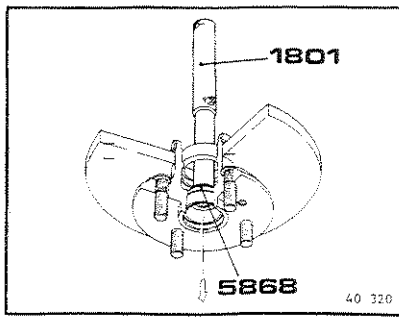
5863



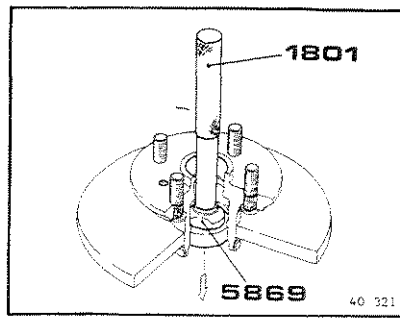
5866



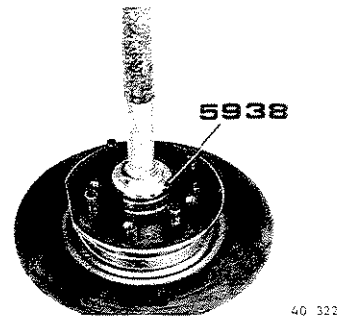
5867



5868



5869

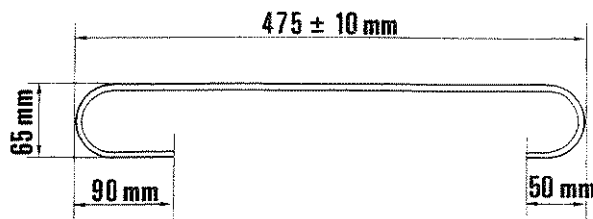


5938

V3M

## A. Upper thrust bearing, coil spring and/or shock absorber cartridge renewal

Special tools: 5043, 5860, 5861 and 5862

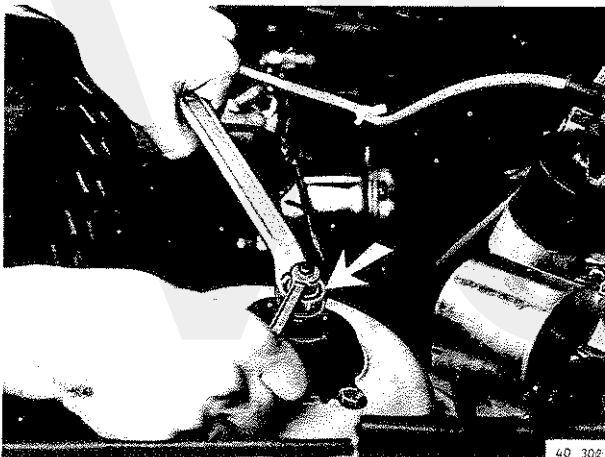


40 281

### Introduction

When carrying out jobs which require the upper attachment of the strut to be released a hook is needed to prevent the strut falling too far to one side. This could damage the brake hose and/or steering swivel ball joint.

The hook can be made from  $\phi 6$  mm wire as shown in the sketch.



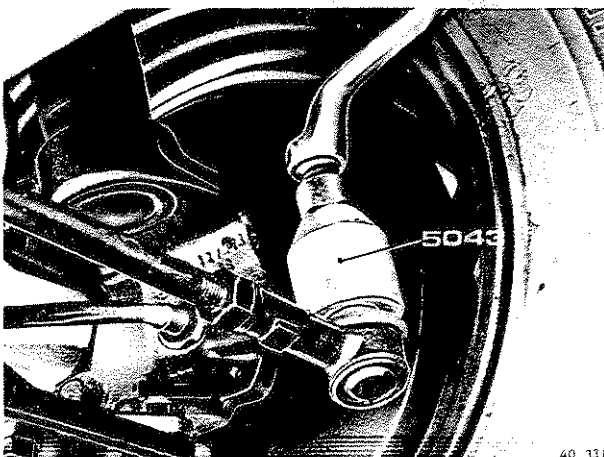
40 302

A1

### Release shock absorber at top

Unscrew the retaining nut of the shock absorber piston rod a few turns.

Remove the shock absorber retaining bolts.



40 331

A2

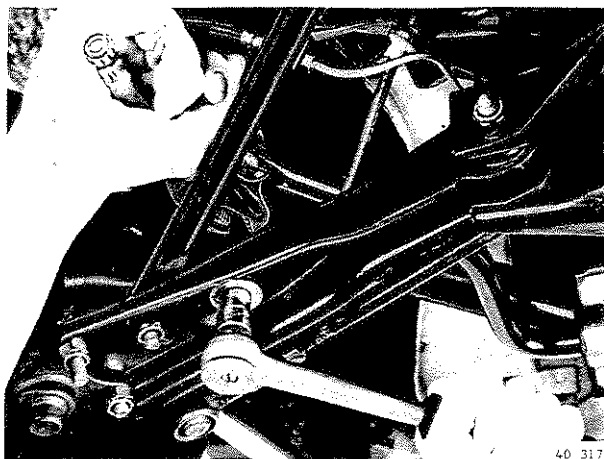
### Press steering rod end out of steering swivel

Remove the split pin and castle nut.

Press the rod end out of the steering swivel with auxiliary pressing tool 5043.

**Note:** when carrying out repairs at the left-hand side of the car the speedometer cable must also be removed from the steering swivel.

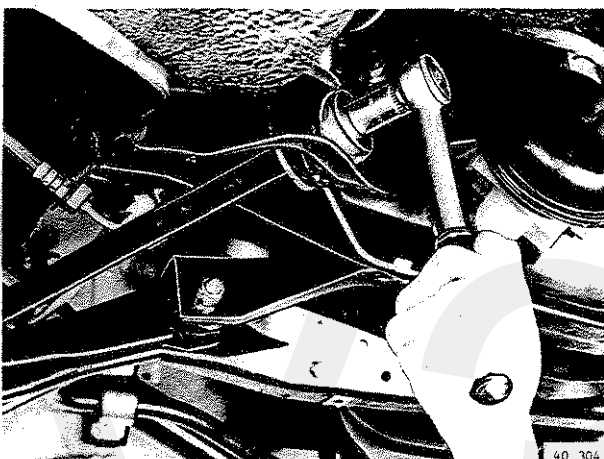
To do this release the grease cap together with the drive pinion and pull the cable out of the steering swivel.



A3

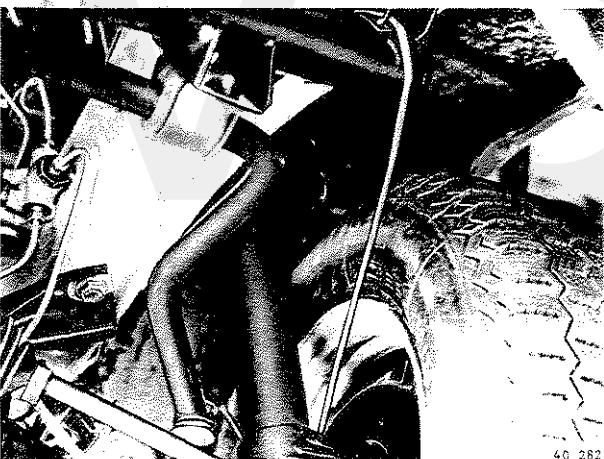
**Remove lower nut from stabilizer link**

**Note:** prevent the link from turning with the aid of a mole wrench.  
Remove the washer.



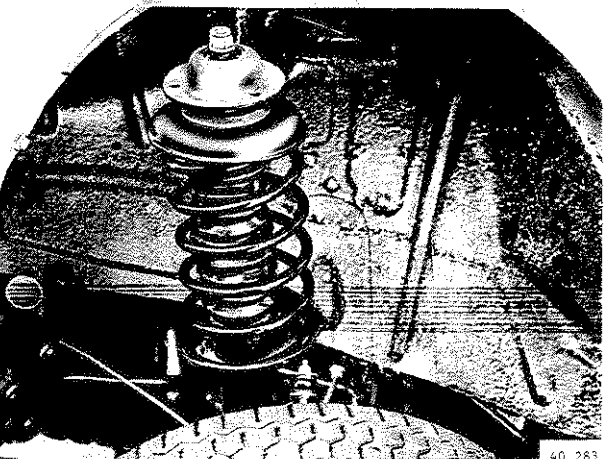
A4

**Unscrew nut at rear of reaction rod a few turns**



A5

**Fit wire hook between strut and front (engine) cross member**

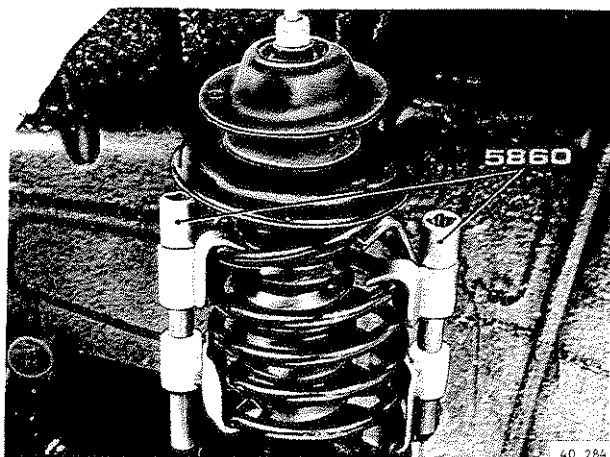


A6

**Pull out strut to side**

Support the car.  
Lower the car lift until the front wheel is free of the ramp.



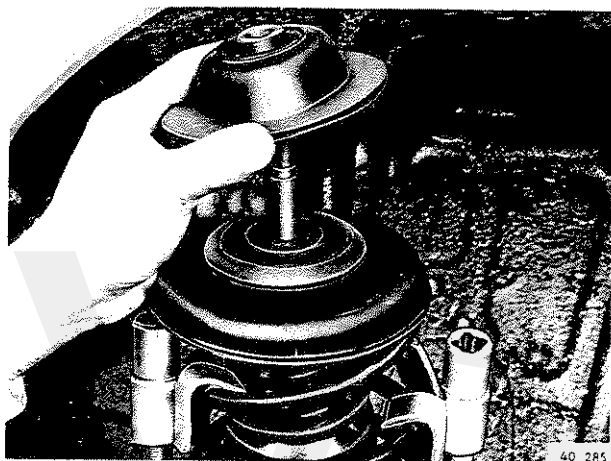


A7

**Compress coil spring so that the upper spring retainer is no longer under tension**

Use spring compressors 5860.

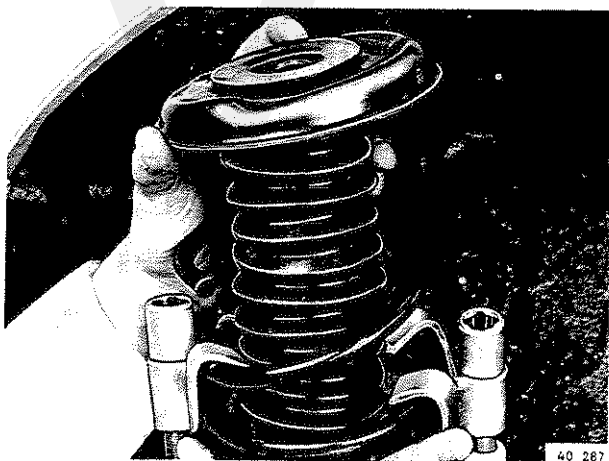
**Note:** the spring compressors must be located opposite each other.



A8

**Remove upper shock absorber attachment**

Remove the nut and washer from the shock absorber piston rod.



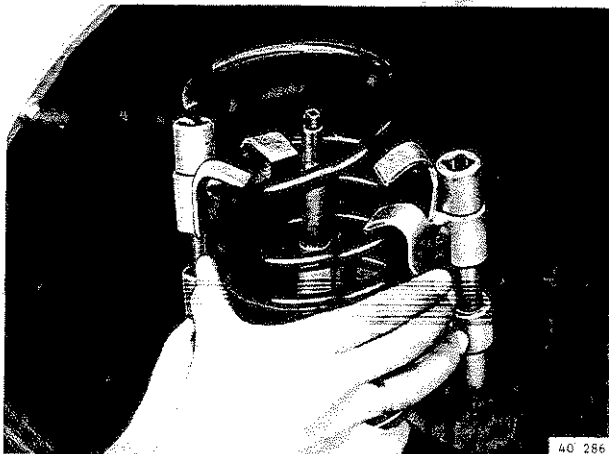
A9

**Remove upper spring retainer with dust gaiter**

Remove the washers, dust cover plate and thrust bearing.

Release the clamp on the dust gaiter.

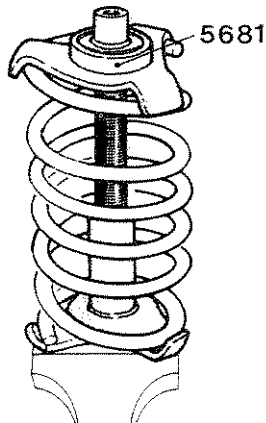
When replacing the thrust bearing alone the clamp need not be released.



A10

**Remove coil spring and rubber bump stop**

A11

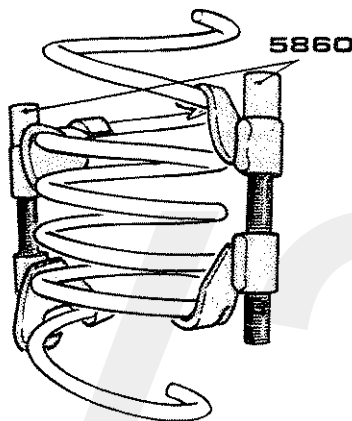


### Remove spring compressor 5860

Clamp the spring compressor **5861** in a bench vice. Locate the coil spring in spring compressor **5861**. Compress the coil spring so that spring compressor **5860** is released. Remove spring compressor **5860**.

40 288

A12

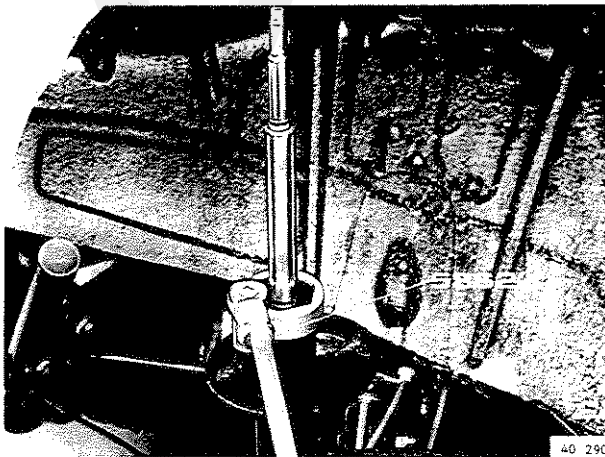


### Renew coil spring

Remove the bolt and upper plate from spring compressor **5861**. Remove the old coil spring and locate a new one. Locate the upper plate and bolt and compress the spring. Locate spring compressor **5860**. Remove spring compressor **5861**.

40 289

A13



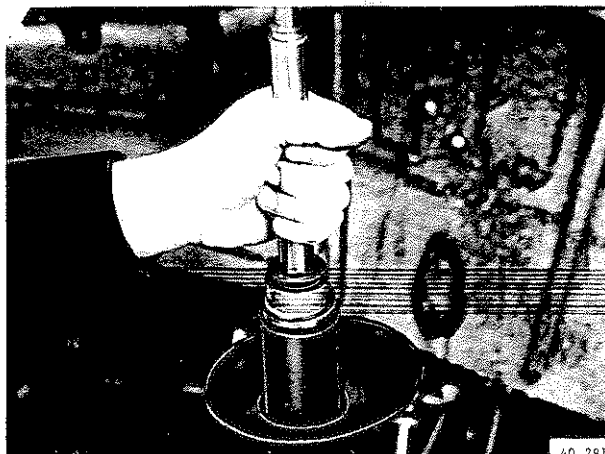
### Remove shock absorber union nut

Use ring spanner **5862**.

**Note:** when it concerns the right-hand shock absorber, this must be restrained with a pipe between the wheel rim and the bottom of the strut to prevent damage to the brake hose.

40 290

A14

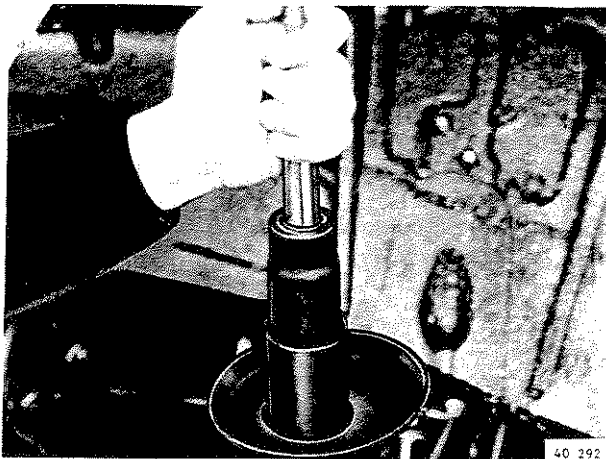


### Remove shock absorber cartridge together with seal, O-ring and retaining sleeve

Clean the inside of the strut.

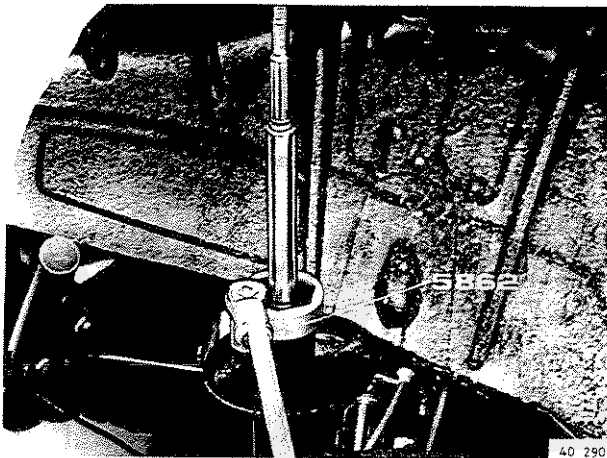
**Note:** a shock absorber cartridge which has already been renewed is removed as a single unit with seal, O-ring and retaining sleeve.

40 291



Fit new shock absorber cartridge

A15



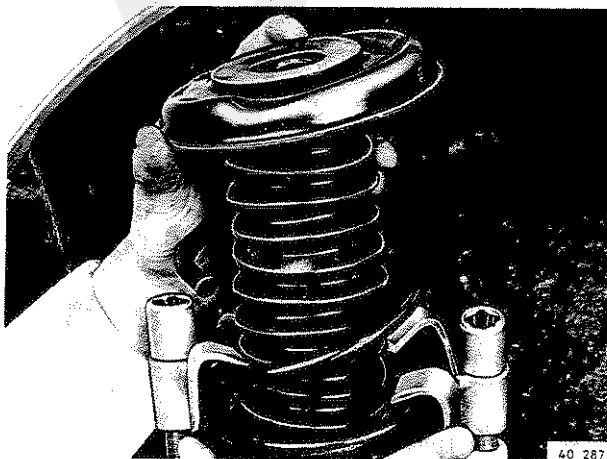
Fit and tighten shock absorber union nut

A16

Use ring spanner 5862.

**Note:** when it concerns the left-hand shock absorber, this must be restrained by a pipe between the wheel rim and the bottom of the strut to prevent damage to the brake hose.

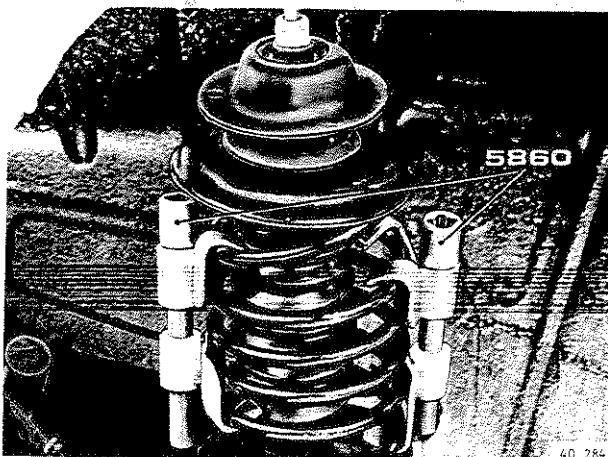
Tightening torque: 120 Nm (12.0 kgm).



Fit coil spring and upper spring retainer

A17

Pull out the piston rod and locate the coil spring. Locate the rubber bump stop and upper spring retainer with the dust gaiter. Tighten the clamp.



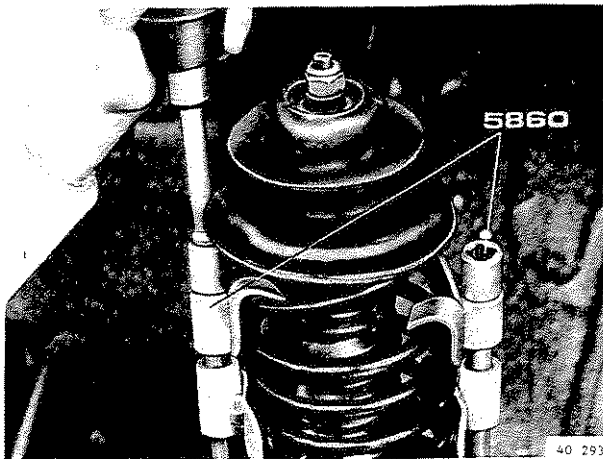
Locate thrust bearing, dust cover plate, washers and upper shock absorber attachment

A18

Tighten the nut finger-tight on the shock absorber piston rod.

A19

**Slacken and remove spring compressor 5860**



A20

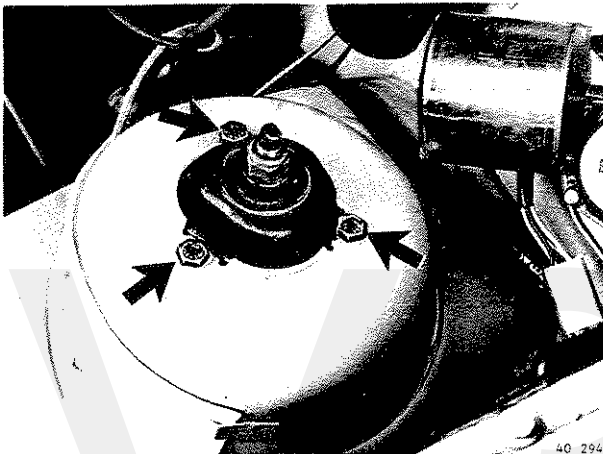
**Fit and tighten bolts in upper shock absorber attachment**

Locate the strut under the front wing and raise the car lift. Make sure that the upper shock absorber attachment and the stabilizer link with washer are correctly located.

Tightening torque: 22 Nm (2.2 kgm).

Remove the wire hook.

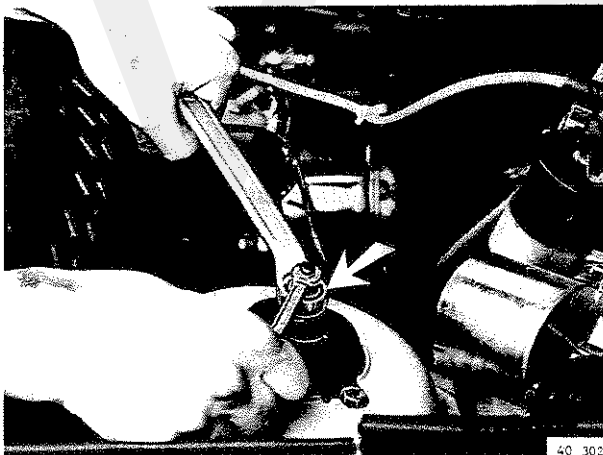
**Note:** coat the bolts with locking compound (Part No. 1161053/54) before fitting.



A21

**Tighten self-locking nut of shock absorber piston rod**

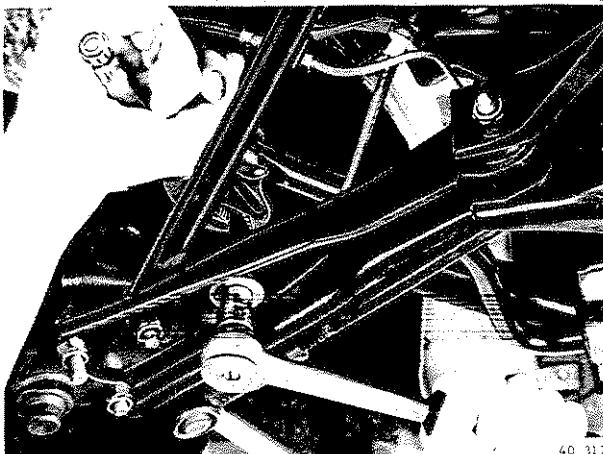
Tightening torque: 65 Nm (6.5 kgm).

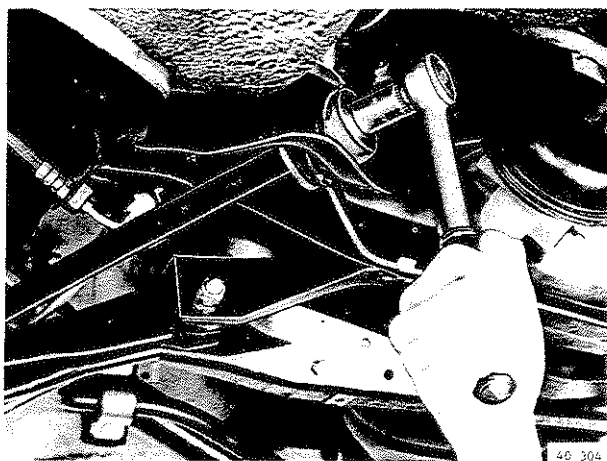


A22

**Fit and tighten washer and nut of stabilizer link.**

Tightening torque: 22 Nm (2.2 kgm).

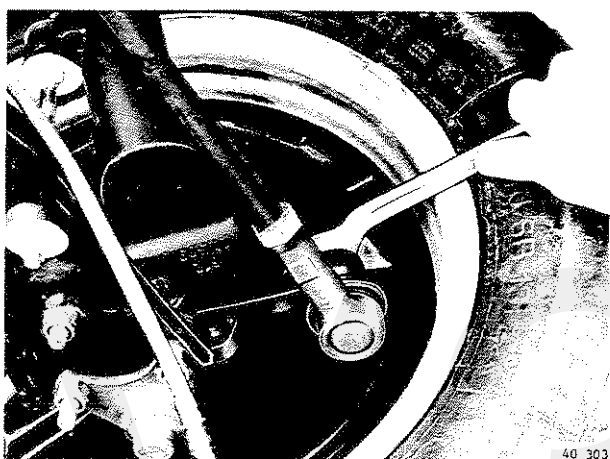




A23

**Tighten rear nut on reaction rod**

Tightening torque: 27 Nm (2.7 kgm).



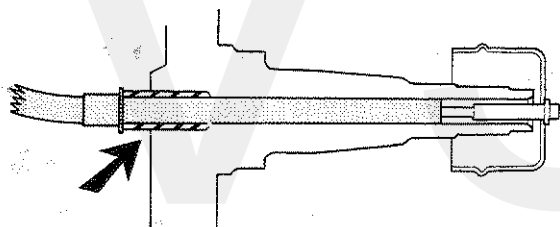
A24

**Locate steering rod end in steering swivel**

Fit and tighten the castle nut.

Tightening torque: 55 Nm (5.5 kgm).

Lock the castle nut with a new split pin.



A25

**Fit speedometer cable (if removed)**

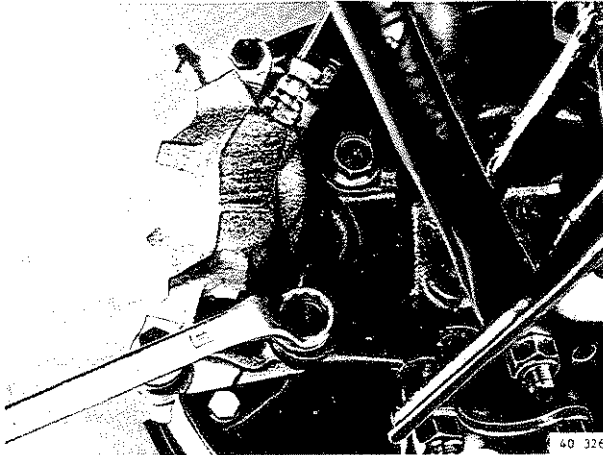
Lightly coat the rubber bush of the speedometer cable with vaseline before fitting.

Fit the speedometer cable.

Fit the grease cap together with the drive pinion.

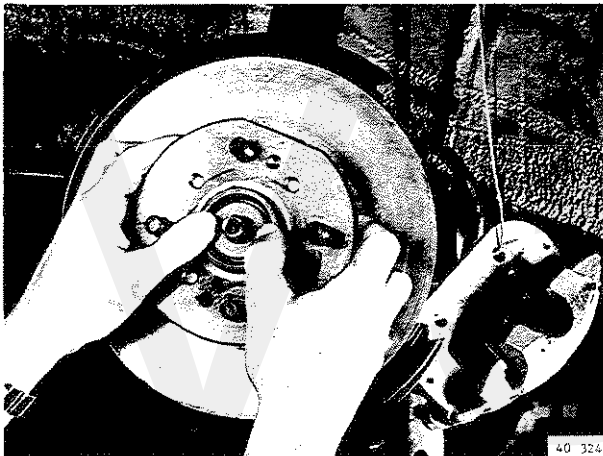
## B. Steering swivel assembly renewal

Special tools: 5043, 5860, 5861 and 5866



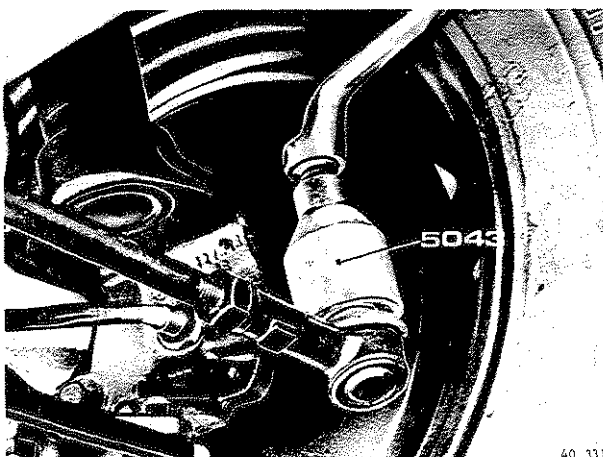
### B1 Release brake caliper

**Note:** never leave the caliper suspended from the brake hose.



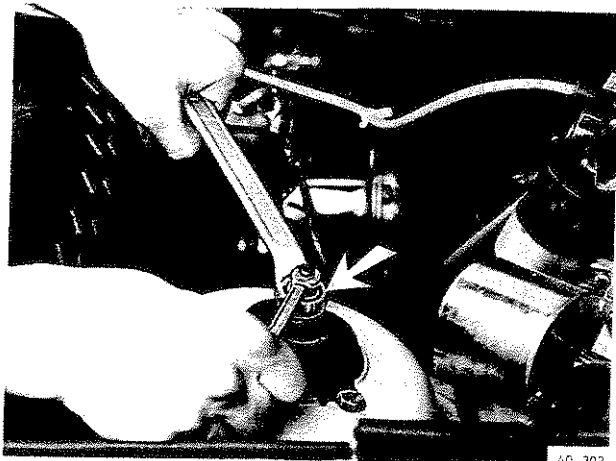
### B2 Remove wheel hub with brake disc and dust plate

Remove the grease cap and lock nut.  
Remove the hub with brake disc from the stub axle end.  
Remove the dust plate.



### B3 Press steering rod end out of steering swivel

Use auxiliary pressing tool: 5043.  
Remove the split pin and castle nut.



40 302

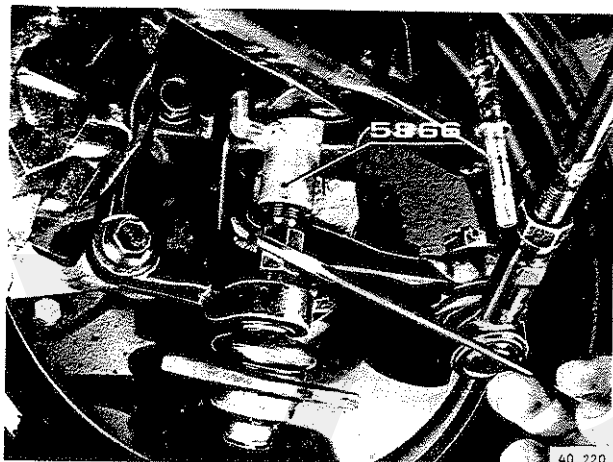
B4

#### Release shock absorber at top

Unscrew the retaining nut on the shock absorber piston rod a few turns.

Remove the shock absorber retaining bolts.

**Note:** when carrying out repairs at the left-hand side of the car the speedometer cable must be taken out of the steering swivel.



40 220

B5

#### Release ball joint from steering swivel

Slacken the rear nut on the reaction rod a few turns. Remove the split pin and castle nut and press out the steering swivel ball joint as far as possible with auxiliary pressing tool 5866.

Press the ball joint downwards and out of the steering swivel.



40 341

B6

#### Remove steering swivel with coil spring and shock absorber.

B7

#### Remove coil spring

Clamp the steering swivel in a bench vice. See section A, page 8, jobs A7-A10.

B8

#### Locate coil spring

See section A, page 10, jobs A17-A19.

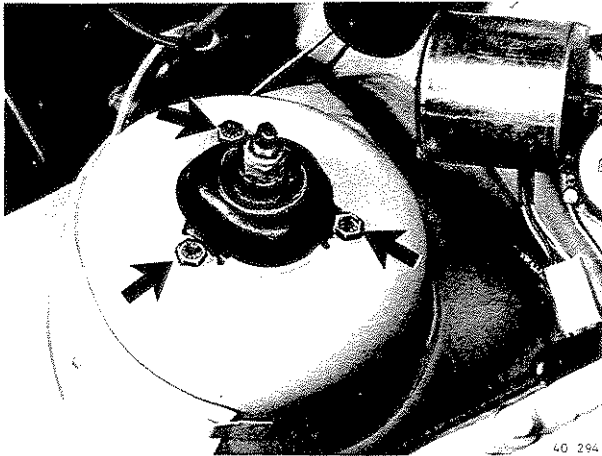
B9

### Locate steering swivel

Fit the steering swivel on the ball joint.  
Fit and tighten the upper shock absorber attachment bolts.

Tightening torque: 22 Nm (2.2 kgm).

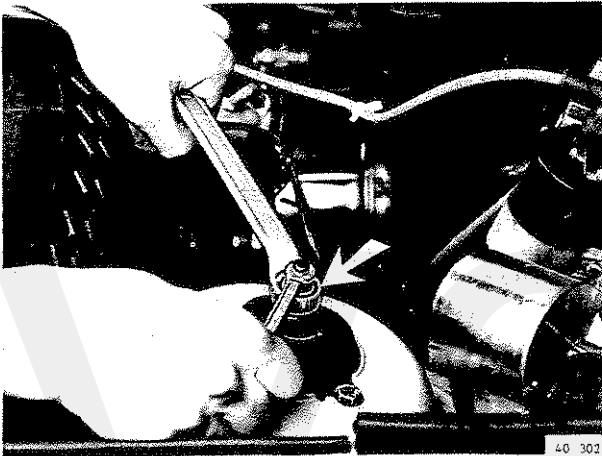
**Note:** coat the bolts with locking compound (Part No. 1161053/54) before fitting.



B10

### Tighten nut on shock absorber piston rod

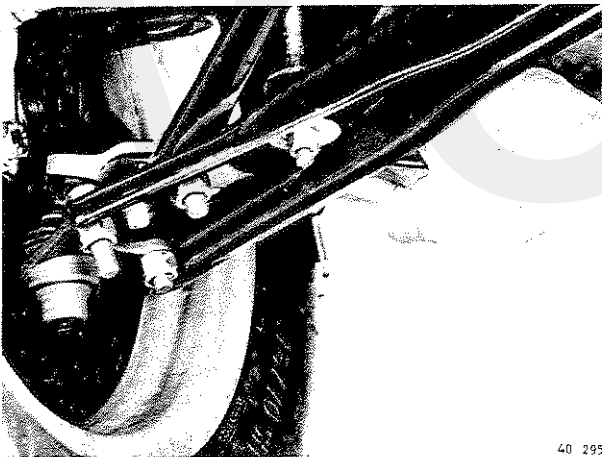
Tightening torque: 65 Nm (6.5 kgm).



B11

### Fit ball joint to steering swivel

Fit and tighten the castle nut.  
Tightening torque: 55 Nm (5.5 kgm).  
Lock the castle nut with a new split pin.



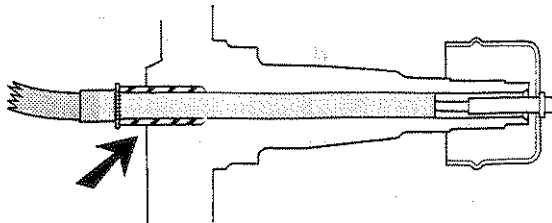
B12

### Fit speedometer cable (if removed)

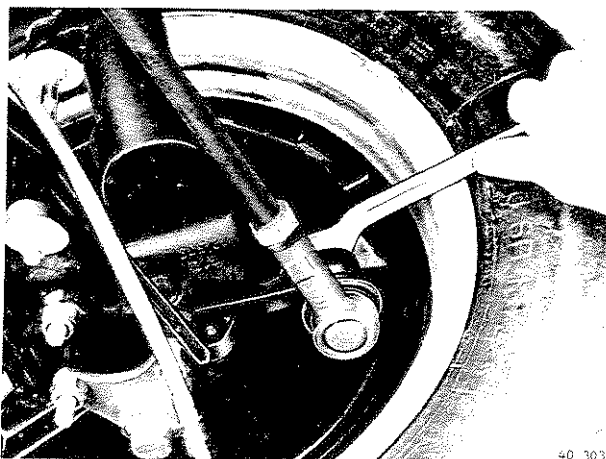
Lightly coat the rubber bush of the speedometer cable with vaseline before fitting.

Fit the speedometer cable.

Fit the grease cap together with the drive pinion.







**Locate steering rod end in steering swivel**

Fit and tighten the castle nut.  
Tightening torque: 55 Nm (5.5 kgm).  
Lock the castle nut with a new split pin.

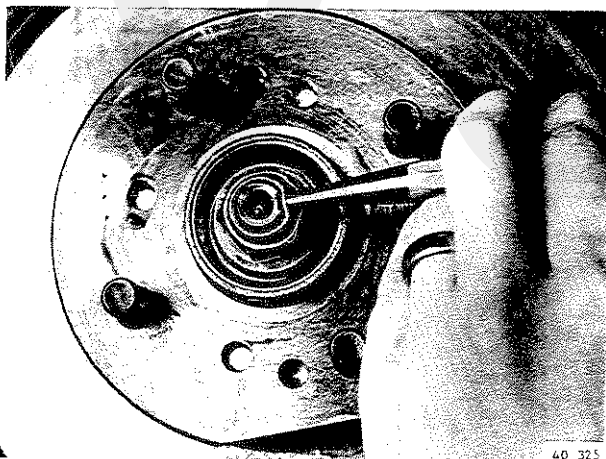
B13



**Locate dust plate and hub with brake disc on stub axle end**

Fit and tighten the dust plate.  
Tightening torque: 16 Nm (1.6 kgm).  
Locate the hub with brake disc.  
Lubricate the outer bearing with wheel bearing grease (Part No. 1212388-1) and fit.  
Fit the washer and a new lock nut.

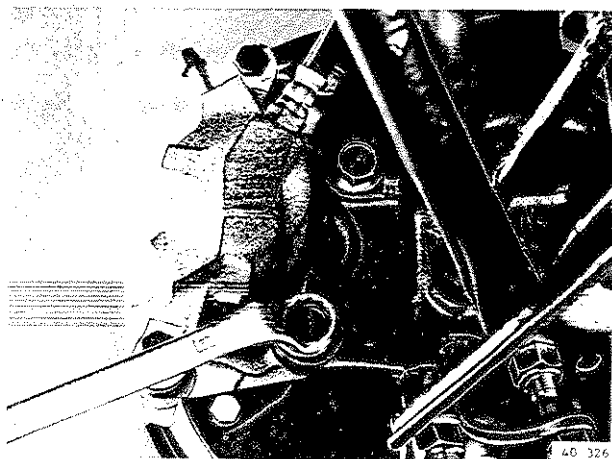
B14



**Adjust front wheel bearing**

Tighten the lock nut.  
Tightening torque: 52 Nm (5.2 kgm).  
Slacken the lock nut 90°.  
Lock the nut.  
Fit the grease cap.

B15

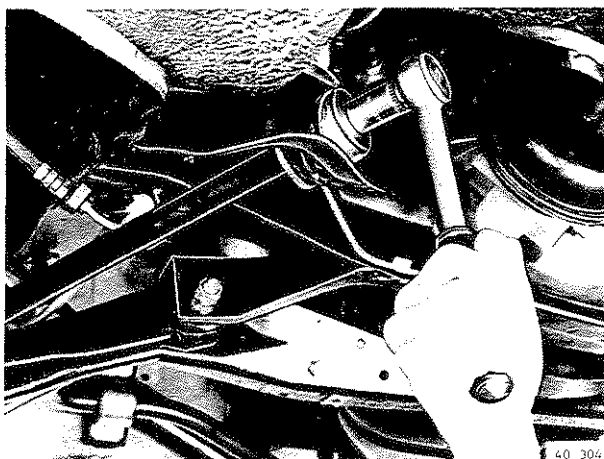


**Fit brake caliper**

Locate the brake caliper on the steering swivel.  
Fit and tighten the retaining bolts.  
Tighten to 68 Nm (6.8 kgm).  
From 1980: fit the dust plate to the brake caliper.  
Tightening torque: 16 Nm (1.6 kgm).  
Fit the wheel.  
Tightening torque: 115 Nm (11.5 kgm).  
**Note:** a new lock washer plate or new self-locking bolts must always be used when fitting.  
Lock the bolts with the lock washer plate (if fitted).

B16

**B17**



**Tighten rear nut on reaction rod**

Tightening torque: 27 Nm (2.7 kgm).

V3M

## C. Renewing spring shackle rubber mounting

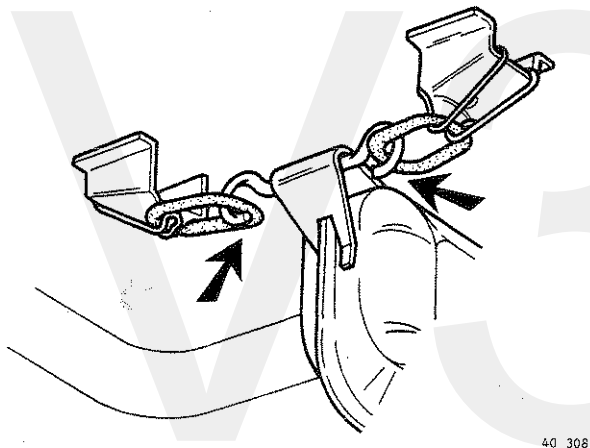
Special tool: 5867



C1

**Remove plug in spare wheel recess - B19  
(only when renewing spring shackle rubber  
mounting at right-hand side)**

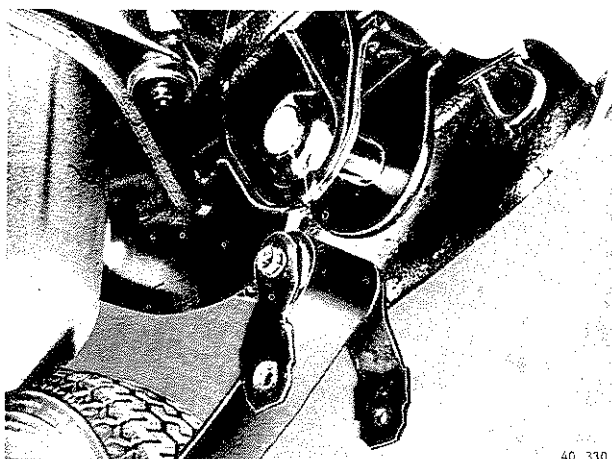
Remove the spare wheel.



C2

**Release exhaust at rear  
(only when renewing spring shackle rubber  
mounting at left-hand side)**

Raise the car to working height.  
Release the O-rings, the rubber mounting at the rear  
silencer and (B19 only) the retaining bolts of the mid-  
dle silencer.



C3

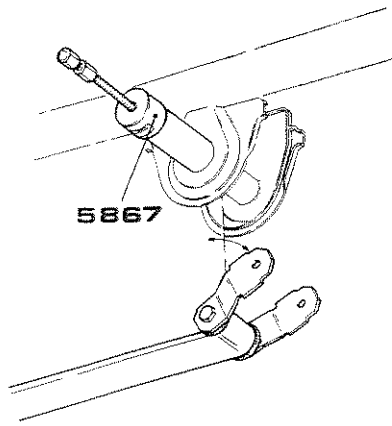
**Release spring shackle and spring eye  
attachments**

Support the body to relieve the load on the leaf  
spring.  
Slacken the nut on the rear spring eye.  
Remove the nut and bolt from the spring shackle.  
Swing the shackle links downwards.

C4

#### Remove spring shackle rubber mounting (B14)

Locate drift 5867 with spacer and press out the rubber mounting.

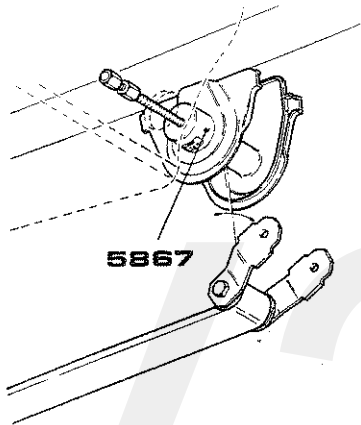


40 305

C5

#### Remove spring shackle rubber mounting (B19)

Use drift 5867 without the spacer to press out successively the left and right-hand parts of the rubber mounting as far as possible. Then remove these parts with a pair of pliers.

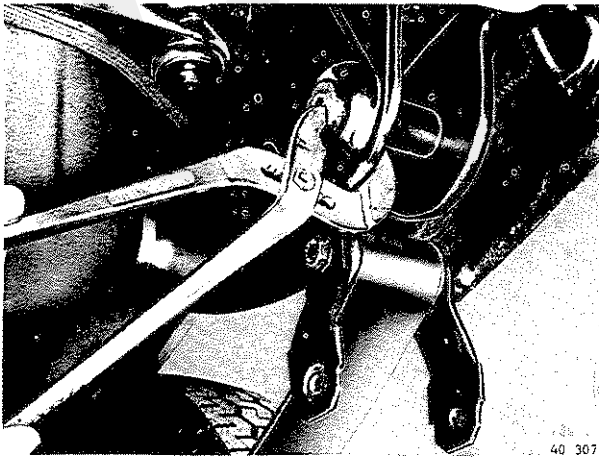


40 306

C6

#### Fit new spring shackle rubber mounting

**Note:** for service purposes on B14 cars the one-piece rubber mounting can be replaced by the two-piece mounting which is used on B19 cars. Lubricate the mountings with a soapy solution. Locate the mountings with the aid of adjustable pliers.

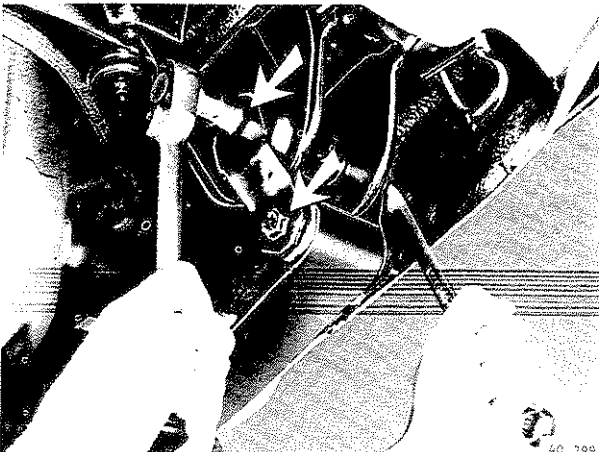


40 307

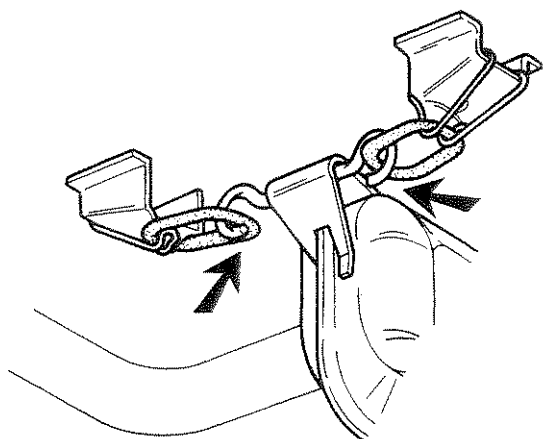
C7

#### Locate spring shackle and spring eye attachments

Fit the removed bolt and nut.  
Remove the support.  
Tighten all nuts.  
Tightening torque: 53 Nm (5.3 kgm).



40 299



40 308

### Tighten exhaust at rear

Locate the O-rings, the rubber mounting at the rear silencer and (B19 only) the retaining bolts of the middle silencer.

Tightening torque: 19 Nm (1.9 kgm).

C8



40 309

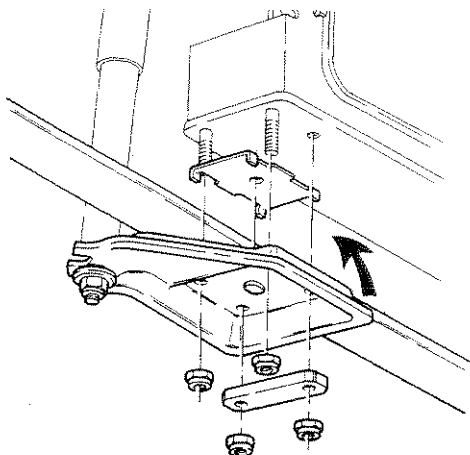
### Fit plug in spare wheel recess - B19

Locate the spare wheel.

C9

## D. Leaf spring renewal

Special tools: 1801 and 5867



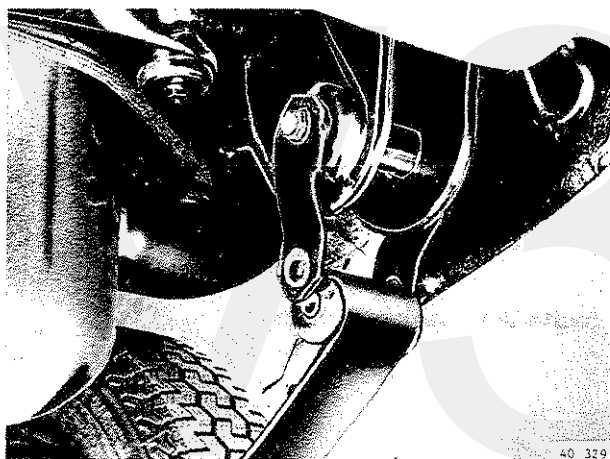
D1

### Release leaf spring from rear axle

Support the body to relieve the load on the leaf spring.

Remove the nuts from the lower spring anchor plate and turn the plate to one side.

Take out the intermediate plates.

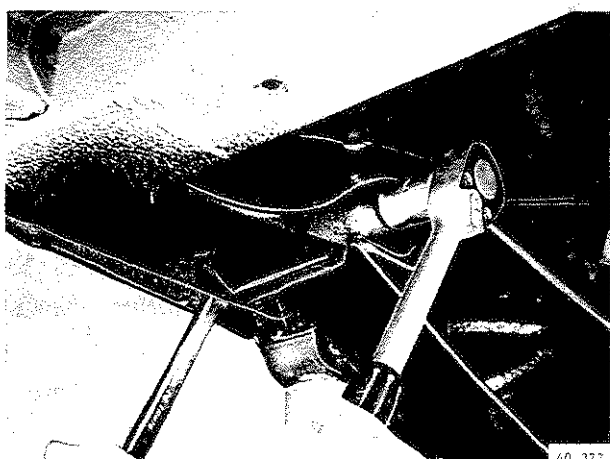


D2

### Release leaf spring from spring shackle

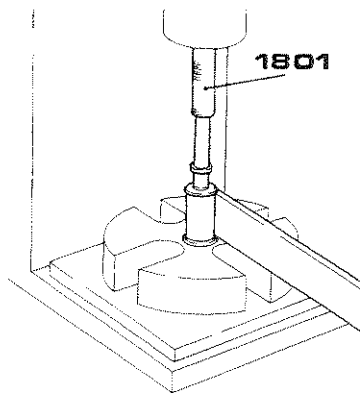
Slacken the nut on the spring shackle.

Remove the nut from the spring eye and withdraw the bolt.



D3

### Release leaf spring at front from mounting point.

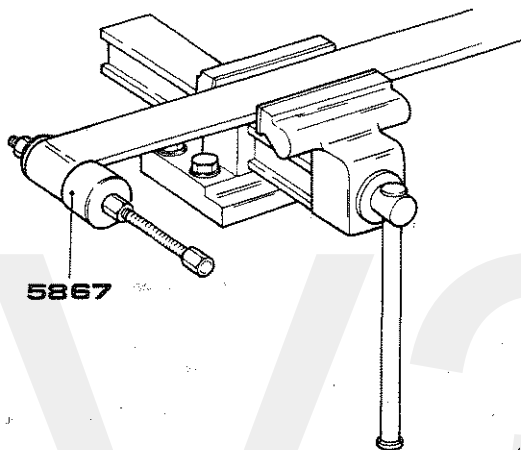


46 310

#### Renew spring eye rubber bush

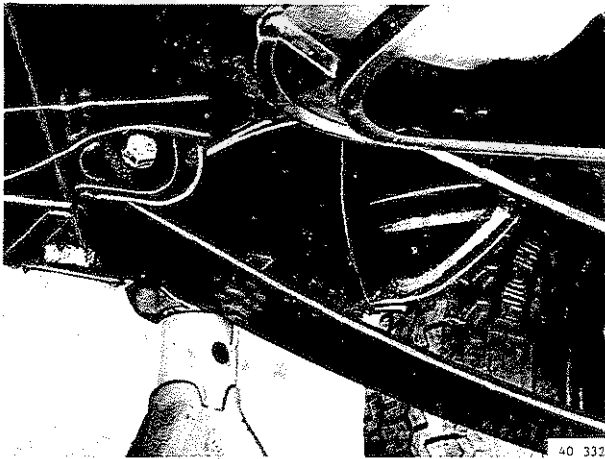
Press out the bush with a hand press and universal handle 1801.

D4



40 311

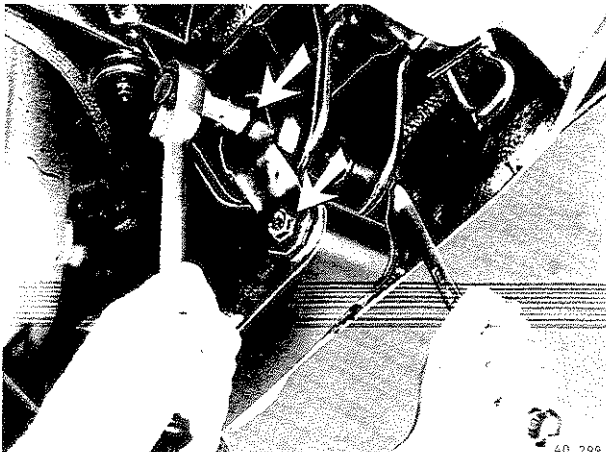
Lubricate the new rubber bush with a soapy solution. Pull in the rubber bush with drift 5867 without the spacer.



40 332

#### Locate leaf spring at front

D5

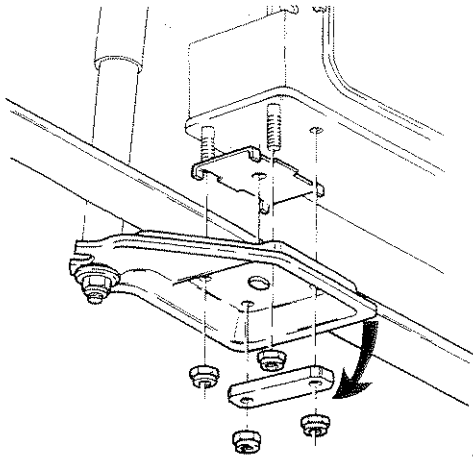


40 298

#### Tighten spring shackle and spring eye(s) attachments

Insert the removed bolts and tighten all nuts finger-tight.

D6

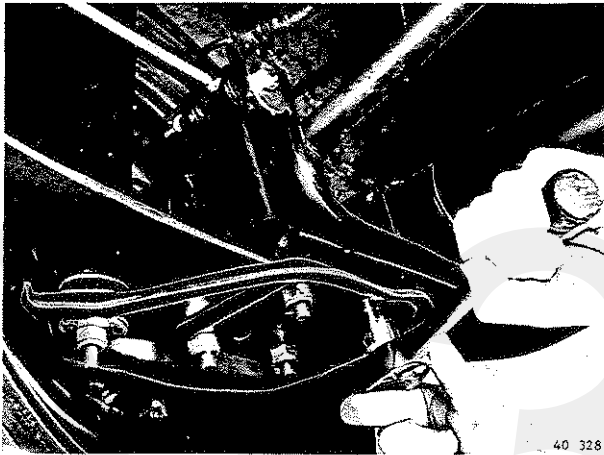


40 298

D7

### Fit lower spring anchor plate

**Note:** if necessary renew the intermediate plates.  
Fit the lower spring anchor plate and nuts and tighten finger-tight.

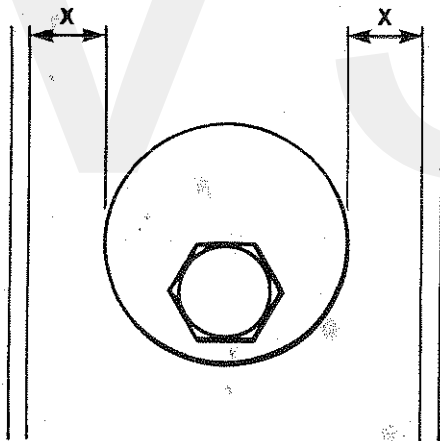


40 328

D8

### Tighten leaf spring attachment

Remove the support.  
Tighten all bolts and nuts.  
Tightening torque: 52 Nm (5.2 kgm).



40 089

D9

### Adjust reaction rod

#### Variant with eccentric adjusting bolt

Locate the adjusting bolt and washers and turn them so that the eccentric disc of the retaining bolt is centrally located in the bracket.

For this purpose the two "X" dimensions must be identical.

Tighten the retaining bolt.

Tightening torque: 53 Nm (5.3 kgm).

#### Variant with elongated hole in bracket on rear axle

Make sure that the retaining bolt is free to move in and out.

Fit and tighten the retaining bolt.

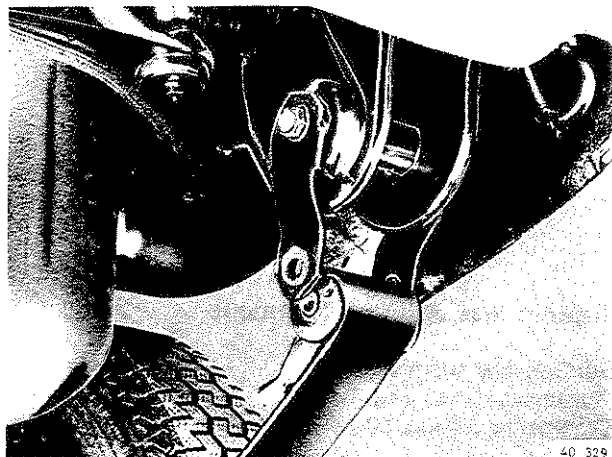
Tightening torque: 53 Nm (5.3 kgm).

**Note:** ensure that the brake hose bracket is in the correct position.



## E. Renewing spring eye rubber bush under the car

Special tools: 2699, 5863 and 5867



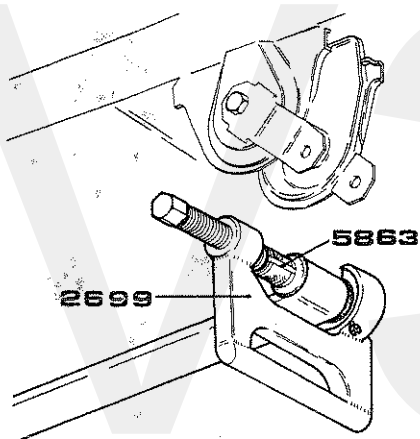
E1

### Release rear spring eye attachment

Support the body to relieve the load on the leaf spring.

Slacken the spring shackle nut.

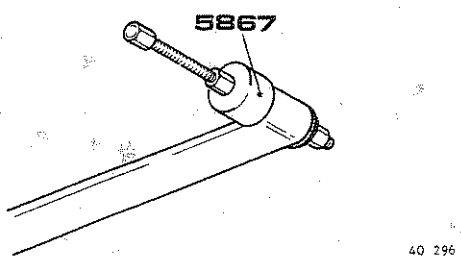
Remove the nut and bolt from the spring eye.



E2

### Renew rear spring eye rubber bush

Remove the rubber bush with auxiliary pressing tool 2699 and drift 5863.



Pull the rubber bush into the eye with drift 5867 without the spacer.

**Note:** lubricate the rubber bush with a soapy solution before fitting.

E3

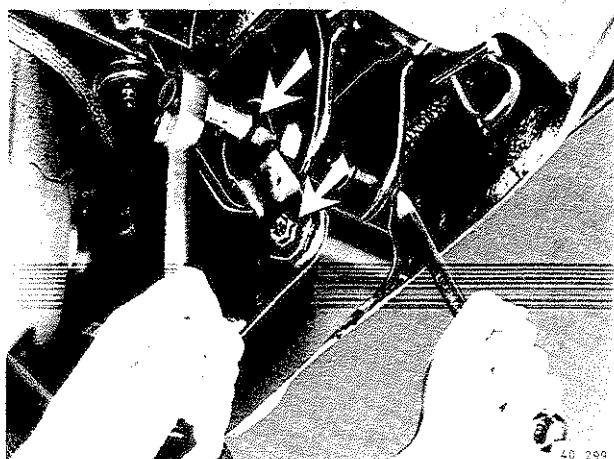
### Fit spring shackle and spring eye attachments

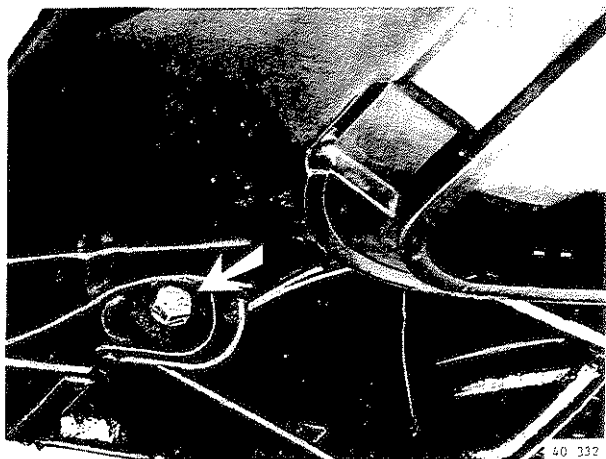
Locate the removed bolt and nut and tighten all nuts finger-tight.

Remove the support.

Tighten the nuts.

Tightening torque: 53 Nm (5.3 kgm).





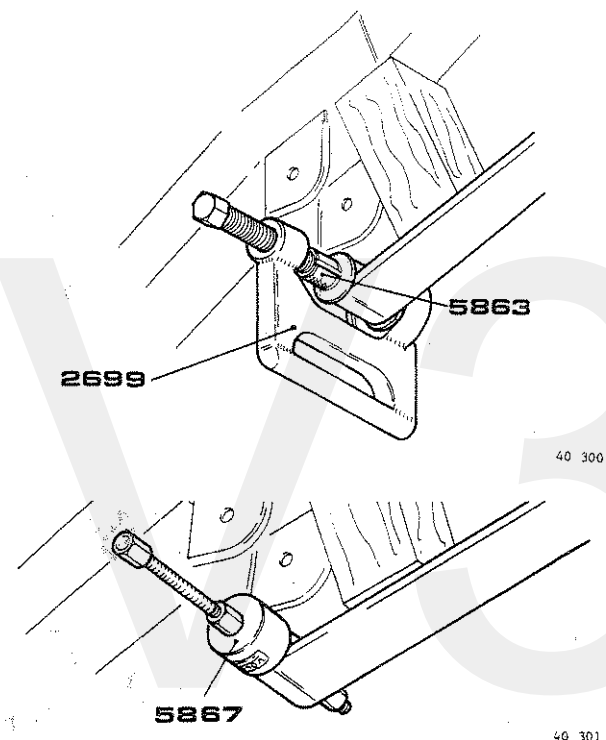
E4

#### Release front spring eye attachment

Support the body to relieve the load on the leaf spring.

Remove the bolt and nut from the spring eye.  
Place a block of wood between the leaf spring and the body.

**Note:** in the case of the right-hand side the reaction rod must be released at the rear.



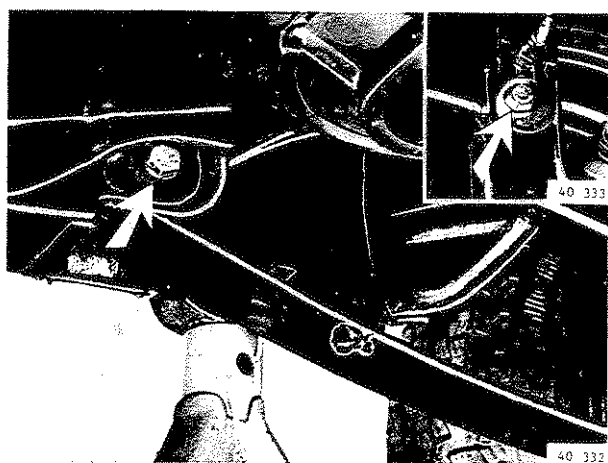
E5

#### Renew front spring eye rubber bush

Remove the rubber bush with pressing tool 2699 and drift 5863.

Pull the rubber bush into the eye with drift 5867 without the spacer.

**Note:** lubricate the rubber bush with a soapy solution before fitting.



E6

#### Tighten spring eye attachment

Remove the block of wood.

Locate the bolt and nut and tighten finger-tight.

Remove the support.

Tighten the nuts.

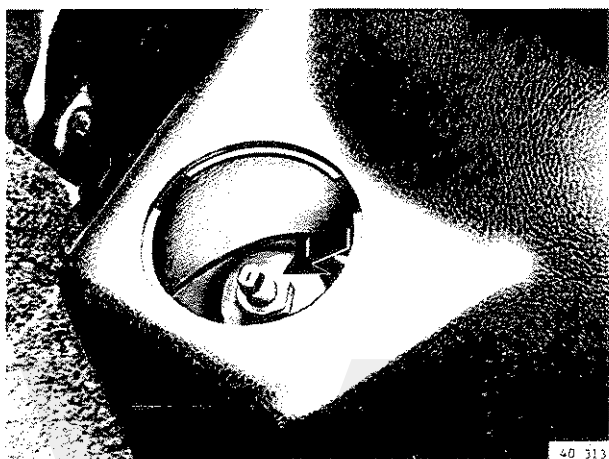
Tightening torque: 53 Nm (5.3 kgm).

E7

#### Adjust reaction rod

See section D, page 23, job D9

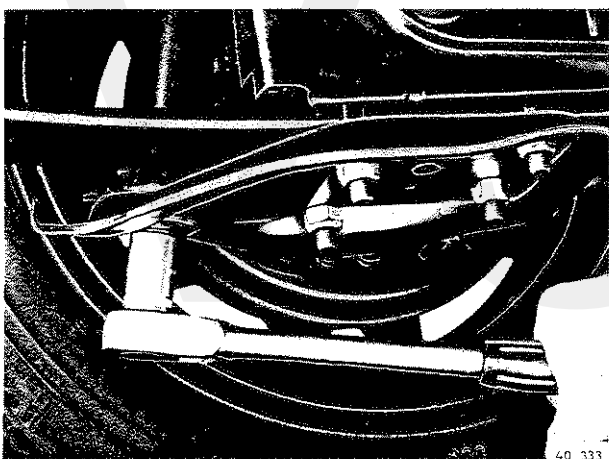
## F. Rear shock absorber renewal



F1

### Release shock absorber at top

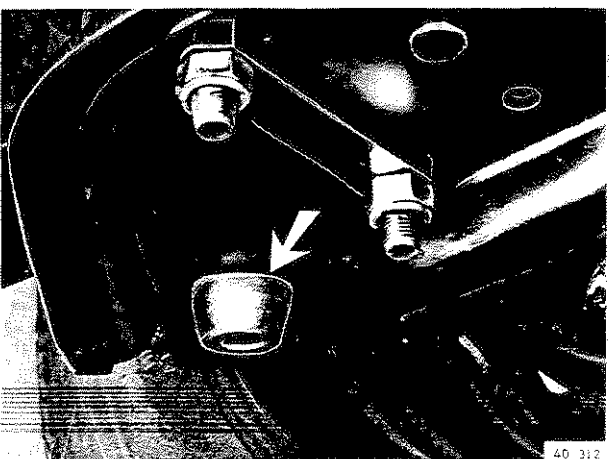
Remove the cover plate from the side panel in the boot.  
Remove the upper nuts and washer from the shock absorber spindle.



F2

### Remove shock absorber

Raise the car to working height.  
Remove the lower nut(s) and washer from the shock absorber.  
Take out the shock absorber.  
Remove the two washers.  
**Note:** it is possible for the spacers to come out-also.



F3

### Renew rubber mountings

F4

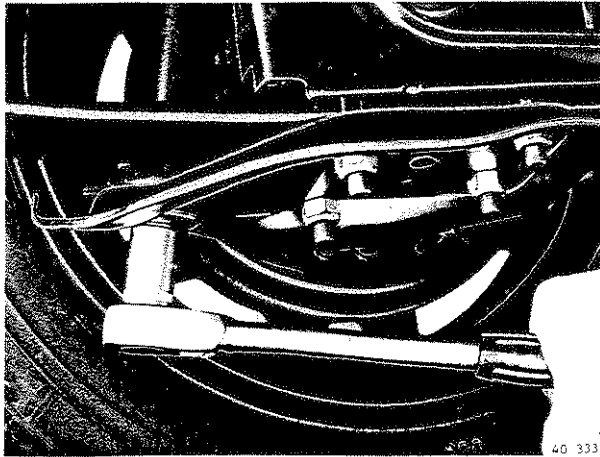
#### Fit and tighten new shock absorber

Fit the upper and lower washers on the shock absorber.

Locate the shock absorber in its mounting points.

Fit the lower washer and nut(s) and tighten.

Tightening torque: 65 Nm (6.5 kgm).



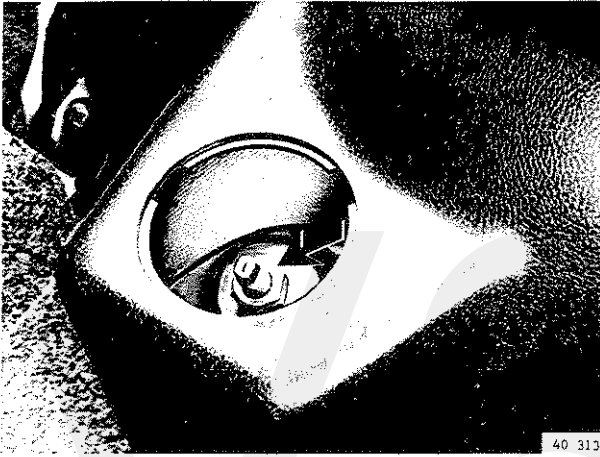
F5

#### Tighten shock absorber at top end

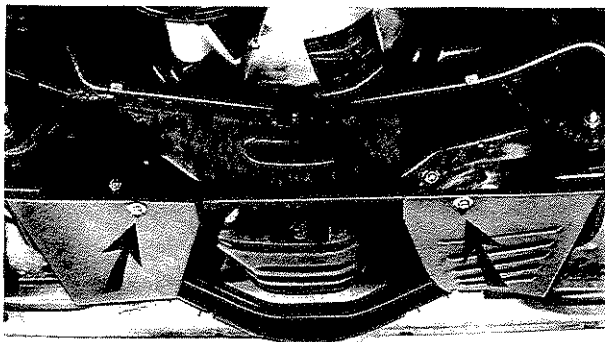
Fit the upper washer and nut(s) and tighten.

Tightening torque: 65 Nm (6.5 kgm).

Fit the cover plate.



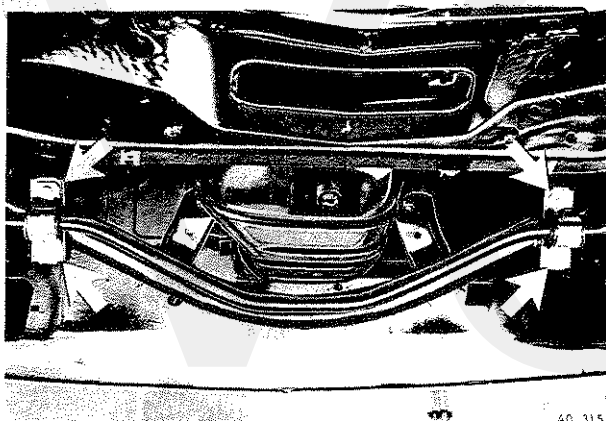
## G. Stabilizer renewal



G1

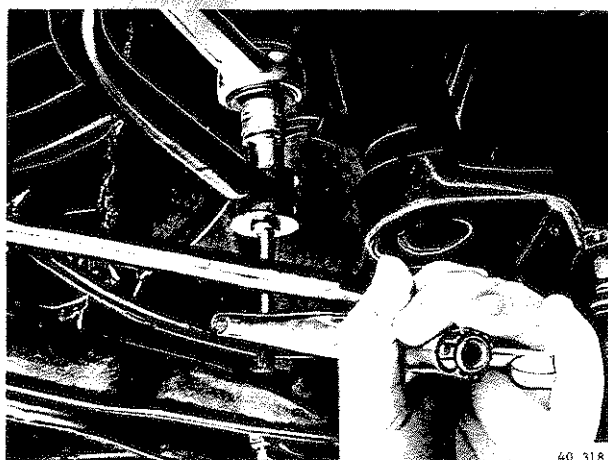
**Remove both engine splash guards**

B19 variant: also remove front engine splash guards.



G2

**Remove retaining bolts from stabilizer**



G3

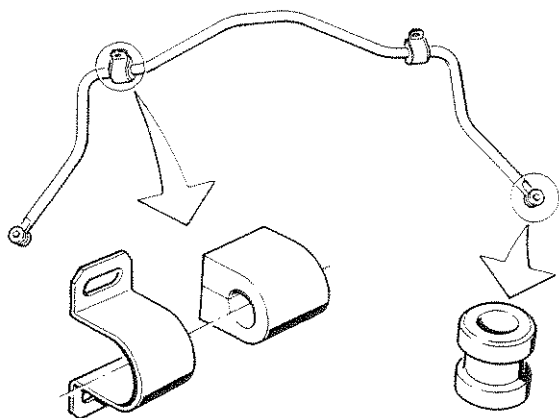
**Remove upper retaining nut from stabilizer link at left and right**

**Note:** prevent the stabilizer link from turning with the aid of a mole wrench.  
Remove the washers.  
Remove the stabilizer.

G4

If necessary renew the retaining clamps, rubber bushes and rubber mountings of the stabilizer

Lubricate the rubber parts with a soapy solution before fitting.



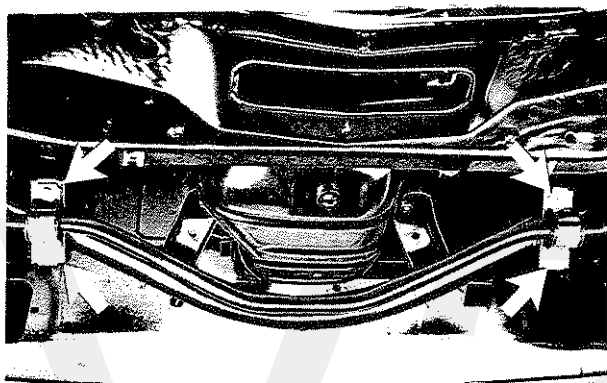
40 314

G5

Locate new stabilizer

Fit the retaining clamps over the rubber mountings and tighten the retaining bolts.

Tightening torque: 22 Nm (2.2 kgm).



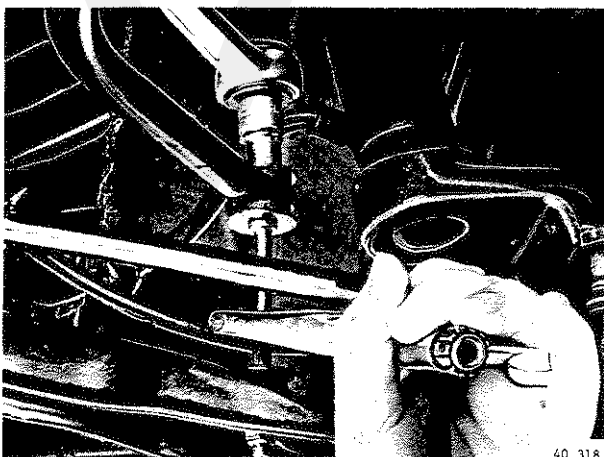
40 315

G6

Secure stabilizer to stabilizer links

Locate the upper washers and retaining nuts and tighten.

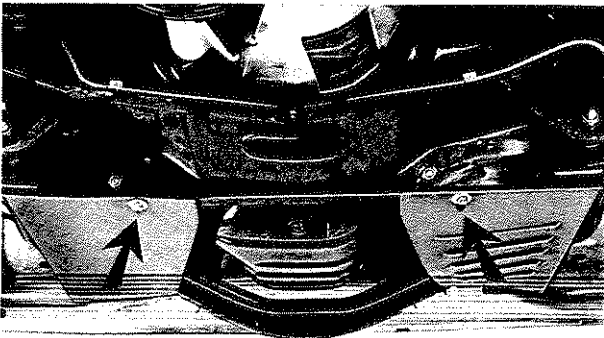
Tightening torque: 22 Nm (2.2 kgm).



40 318

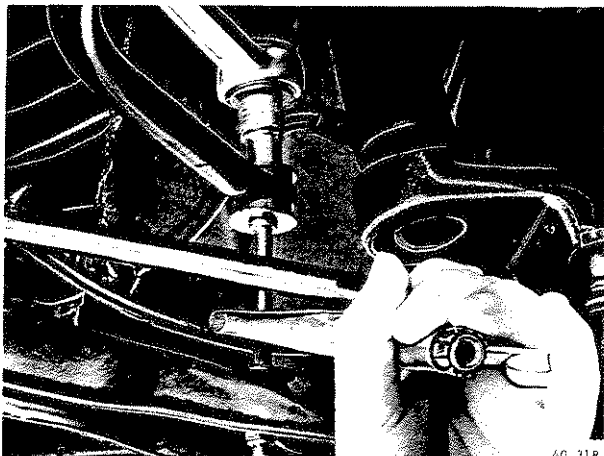
G7

Fit engine splash guards



40 046

## H. Stabilizer link renewal

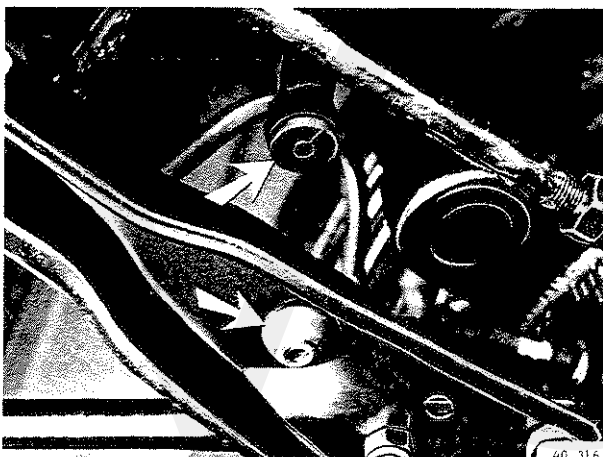


40 318

### Remove stabilizer link

H1

**Note:** prevent the stabilizer link from turning with the aid of a mole wrench.

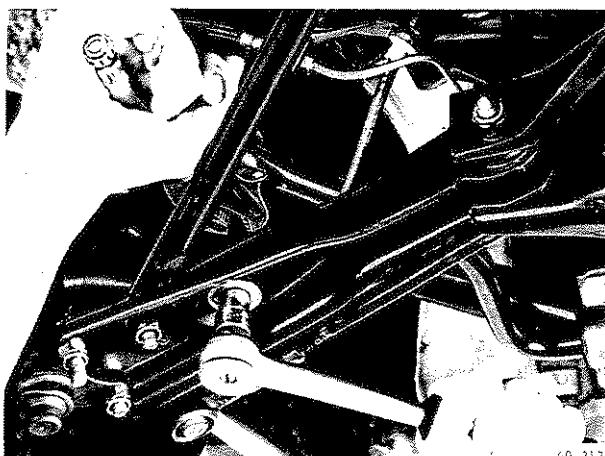


40 316

### Renew rubber bushes (if necessary)

H2

Lubricate the rubber bushes with a soapy solution before fitting.



40 317

### Locate stabilizer link

H3

Locate the lower washer and retaining nut and tighten.

Tightening torque: 22 Nm (2.2 kgm).

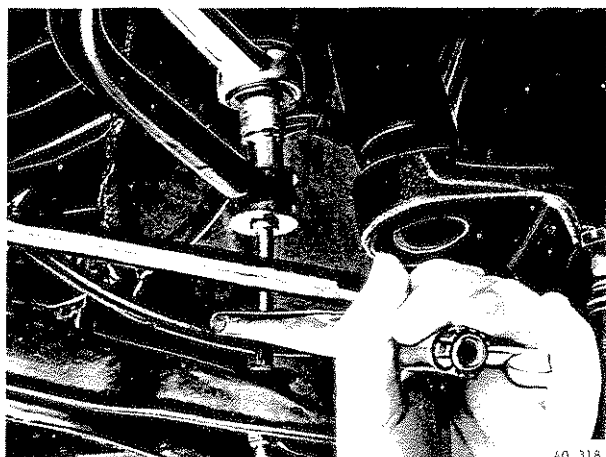
**Note:** prevent the stabilizer link from turning with the aid of a mole wrench.

H4

### Secure stabilizer to stabilizer link

Locate the upper washer and retaining nut and tighten.

Tightening torque: 22 Nm (2.2 kgm).

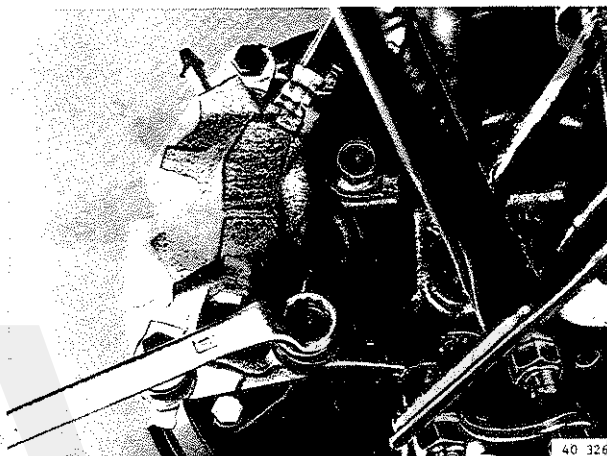


V3M



## J. Renewing front wheel bearings

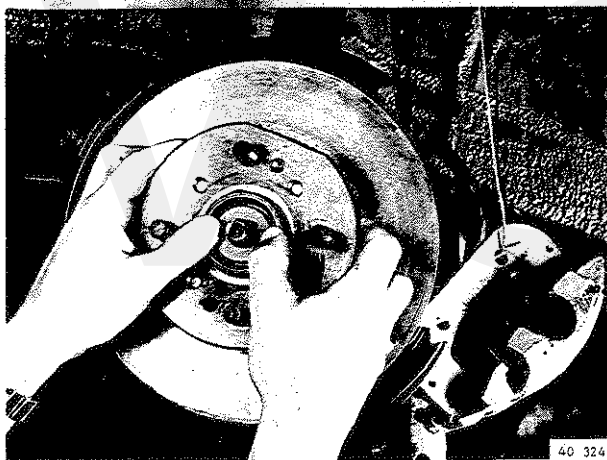
Special tools: 1801, 5868, 5869 and 5938



### J1 Release brake caliper

Remove the wheel.

**Note:** never leave the brake caliper suspended from the brake hose.

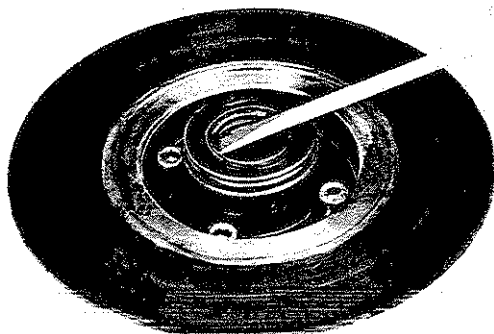


### J2 Remove hub with brake disc

Remove the grease cap and lock nut.

Remove the hub with brake disc from the stub axle end.

Remove the washer and the outer bearing.  
Clean the stub axle end.



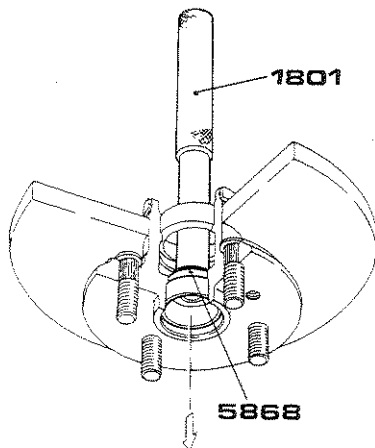
### J3 Remove grease retainer

### J4 Remove inner bearing

J5

### Remove bearing cups

Remove the old grease from the hub.  
Remove the outer bearing cup with the aid of drift 5868 and universal handle 1801.

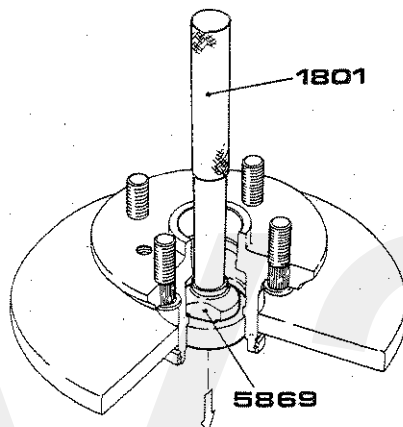


40 320

Remove the inner bearing cup with the aid of drift 5869 and universal handle 1801.

**Note:** these drifts can only be used on cars from chassis number 383087.

For old variants use a punch.



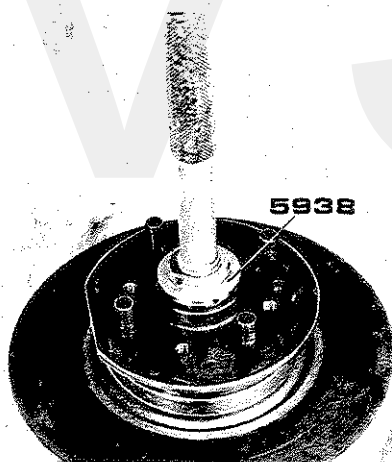
40 321

J6

### Locate new bearing cups

Locate the bearing cup with drift 5938 and universal handle 1801.

Pack the grease chamber of the hub three-quarters full with wheel bearing grease (Part No. 1212388-1).



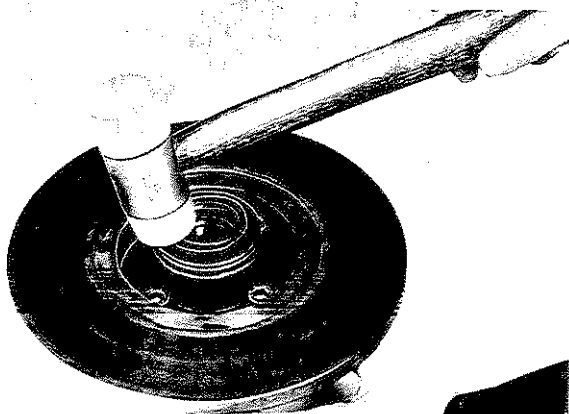
40 322

J7

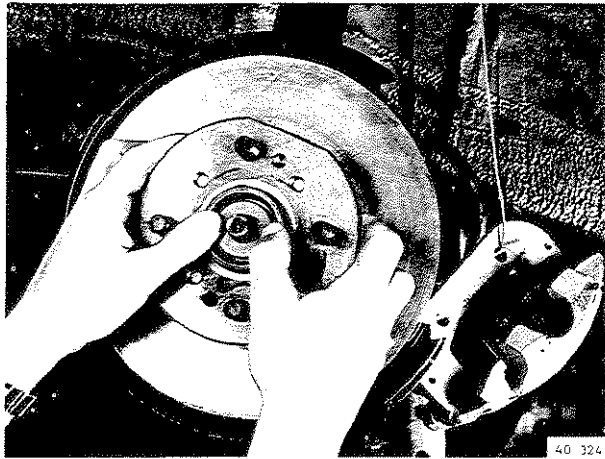
### Locate the grease retainer

Grease the bearing beforehand with wheel bearing grease (Part No. 1212388-1).

Locate the inner bearing in the hub.

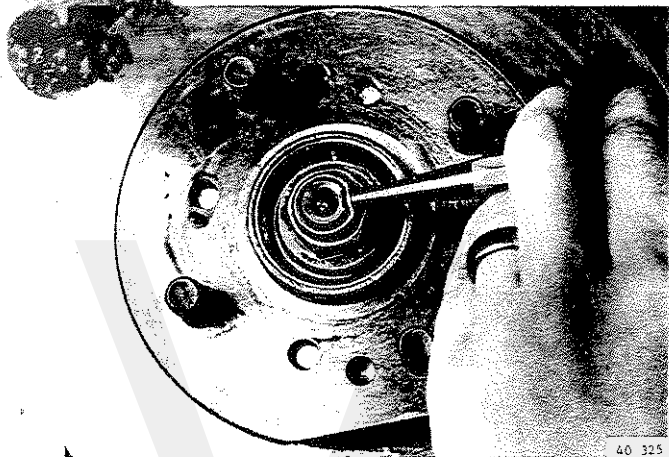


40 323



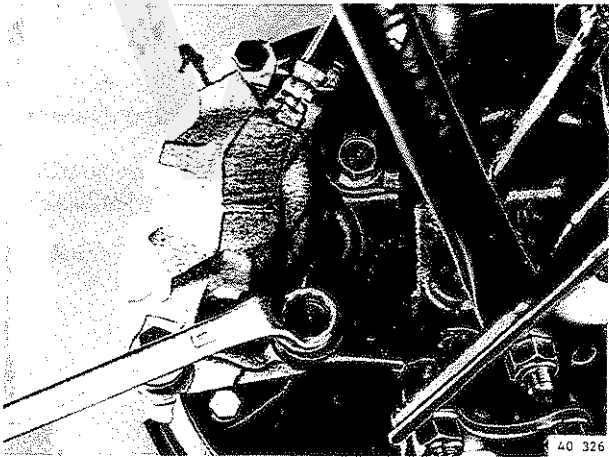
#### J8 Locate hub with brake disc on stub axle end

Locate the hub with the brake disc.  
Grease the outer bearing with wheel bearing grease (Part No. 1212388-1) and fit.  
Fit the washer and a new lock nut.



#### J9 Adjust front wheel bearing

Tighten the lock nut.  
Tightening torque: 52 Nm (5.2 kgm).  
Slacken the lock nut 90°.  
Lock the nut.  
Fit the grease cap.



#### J10 Fit brake caliper

Locate the brake caliper on the steering swivel.  
Fit and tighten the retaining bolts.  
Tighten to 68 Nm (6.8 kgm).  
From 1980: fit the dust plate on the brake caliper.  
Tightening torque: 16 Nm (1.6 kgm).  
Fit the wheel.  
Tightening torque: 115 Nm (11.5 kgm).  
**Note:** a new lock washer plate or new self-locking bolts must always be used when fitting.  
Lock the bolts with the lock washer plate (if fitted).

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