SAAB

Repair Time Schedule



Ordering No IN 10196

AB INPLASTOR

SAAB

Repair Time Schedule

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SAAB-SCANIA
Saab Car Division
Service Department
NYKÖPING SWEDEN

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Saab-Scania - Service Department-Kundendienstabteilung - Nyköping - Sweden-Schweden

MAY, 1975

SAAB REPAIR TIME SCHEDULES

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233-1	1	1.73
233-2	1	1.73
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261-1	1	1.73
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831-1	1	1.73
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364-1	1	12.74
381-1	2	3.74
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SAAB

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Repair Time Schedule SAAB
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Saab repair time schedule

for Saab 95/96, and Saab 99 **Intended for authorized Saab workshops**

Foreword

The operation time is stated in periods (1 period = 1/100th of an hour) and consists of effective time, secondary time and lost-time allowance. From May 1974 inclusive, the time is rounded off to the nearest ten periods (except for times of 1-7 periods, which are rounded off to 5 periods). Time for driving in and out, clocking on and off, opening and closing the engine hood, positioning fender protectors, ordering and collecting spares and test driving is not included in the listed times. Where applicable, time for such operations must be allocated to the mechanic as special *order time.*

The list-times are in principle based on the MTM-standard as far as the working intensity is concerned.

The times are however decided by clock-studies of actual work performed by trained mechanics with methods, tools and aids according to the book 'Repair Work Descriptions'.

It is to be observed that the trained mechanic should be able to improve on the times given by about 30 % by raising the intensity of work above the norm.

I.e. $\frac{\text{totally allocated time}}{\text{actually used time}} = 1.30$

There will be wide individual variations in the extent to which enhanced performance can be achieved. The degree of enhancement depends on several factors other than equipment and the mechanic's skill and intensity. However, an average improvement of 1.20 to 1.40 is an indication of close agreements between presupposed and actual conditions.

Changing from one time group (rounded-off time) to another is indicated by a cross (x) against the new time in the schedule. Completely new times are indicated by the letter *n* alongside the time. These markings are valid for two months after the date of issue. The markings are omitted on reprinting after this time.

Ex. Work order 0000
Saab 99 CM/69

		Time	
Op.	20138	246	Remove—install power unit
	20181	130	Separate—assemble ('sump-gasket' replace)
	41105	31	Pressure plate assembly and/or clutch disc replace
	21651	30	Seal ring at flywheel replace
	12206	25	Engine oil change (incl. filter change)
		462 periods	(schedule time)

	Time	
Spare parts ordering	6	
Clocking in and off	3	
Driving car in and out opening and closing the hood, placing fender covers	7	
	16	(order time)
Total	478 periods	

The schedule time includes the effective time for the job itself, 'secondary times' for handling the tools and aids and to finish the job and clear the stall. Furthermore, the time includes an amount of 10 % estimated on the sum of the effective time and the secondary time (= lost-time allowance). This amount of time is prepared to cover the mechanic's need for relaxation, answering questions from customers, assisting colleagues and coping with minor interruptions, accidents, etc.

The order times are a type of secondary times not included in the schedule time. They will just occur once a time during the work, regardless of the numbers of operations and/or secondary times the values for which very much depend on the individual conditions in the workshop. Each workshop must determine its own 'order time' and give rules for estimating it.

The Saab Repair Time Schedules with order number 101964 can be ordered from Saab-Scania, Saab Car Division, Fack, S—611 01 Nyköping, Sweden.

This edition replaces the Repair Timetable for Guarantee Repairs of Jan. 1972 (No. 788713)

December 1974

Saab repair time schedule

for Saab 95/96, 1965 onwards and Saab 99 **Intended for authorized Saab workshops**

Foreword

The times given in this schedule are stated in periods (1 period = 1/100 hour) and consist of effective time, secondary time and lost-time allowance. Time for driving cars in and out, clocking in and off, opening and closing the hood, positioning fender protectors, ordering and collecting spares and test driving is not included. Where applicable time for such operations must be allocated to the mechanic as special order time.

The list-times are in principle based on the MTM-standard as far as the working intensity is concerned. The times are however decided by clock-studies of actual work performed by trained mechanics with methods, tools and aids according to the book "Repair Work Descriptions".

It is to be observed that the trained mechanic should be able to improve on the times given by about 30 % by raising the intensity of work above the norm.

I.e. $\frac{\text{totally allocated time}}{\text{actually used time}} = 1.30$

There will be wide individual variations in the extent to which enhanced performance can be achieved. The degree of enhancement depends on several factors other than equipment and the mechanic's skill and intensity. However, an average improvement of 1.20 to 1.40 is an indication of close agreements between presupposed and actual conditions.

Ex. Work order 0000
Saab 99 CM/69

		Time	
Op.	20138	246	Remove–install power unit
	20181	130	Separate–assemble ("sump-gasket" replace)
	41105	31	Pressure plate assembly and/or clutch disc replace
	21651	32	Seal ring at flywheel replace
	12206	25	Engine oil change (incl. filter change)
		464 periods	(schedule time)

	Time	
Spare parts ordering	6	
Clocking in and off	3	
Driving car in and out opening and closing the hood, placing fender covers	7	
	16	(order time)
Total	480 periods	

The schedule time includes the effective time for the job itself, "secondary times" for handling the tools and aids and to finish the job and clear the stall. Furthermore, the time includes an amount of 10 % estimated on the sum of the effective time and the secondary time (= lost-time allowance). This amount of time is prepared to cover the mechanic's need for relaxation, answering questions from customers, assisting colleagues and coping with minor interruptions, accidents, etc.

The order times are a type of secondary times not included in the schedule time. They will just occur once a time during the work, regardless of the numbers of operations and/or secondary times the values for which very much depend on the individual conditions in the workshop. Each workshop must determine its own "order time" and give rules for estimating it.

Changes in job scope and times are indicated by a cross (x) at the new time in the lists. Supplementary new times are indicated by a letter n at the time in the lists. These markings are valid for two months after the issue of the sheet(s). In the event of reprinting after this period changed or new times are no longer indicated.

Model and type codes

The digit indicates the year of the model
E.g. 8 = 1968, 0 = 1970

P = Saab 96 only (sedan (saloon)car)
H = Saab 95 only (station wagon) (estate car)
A = Saab 99 with automatic transmission
E = Saab 99 with fuel injection engine
4d = Saab 99 with 4 doors

Examples:
H5–8 = Saab 95 from 1965 to 1968 inclusive
0– = all models from 1970 on
1A = 1971 model with automatic transmission

Engine type	Coded as model
95/96 2-stroke	1965–66
95/96 V4	1967 on
99 1.7–1.85 litres	1969–72
99 2.0 litre	1973 on

The Saab Repair Time Schedules with order number IN 10196 can be ordered from Saab-Scania, Saab Car Division, Technical Literature, Fack, S–611 01 Nyköping, Sweden.

This edition replaces the Repair Timetable for Guarantee Repairs of Jan. 1972 (No. 788713)

Jan 1973

Codes and Abbreviations

Type Codes

P = Saab 96
H = Saab 95
Rhd = right-hand drive
A = automatic transmission
E = fuel injection engine (EBI 70–74, CI 75–)
1,85 = 1,7–1,85 litre engines
2,0 = 2,0 litre engine
2d = 2-door
4d = 4-door
CC = Combi Coupé
Ps = power steering

If no code is stated, the time relates to all models, for a left-hand drive 2-door saloon model with the commonest carburettor engine, manual gear box and the commonest version in other respects.

Year Model Codes

The year model is indicated by a number, e.g. 8 = 1968, 0 = 1970. From May 1974 on, the last two digits of the year are stated for all year models. A dash after the code (e.g. 73–) indicates that the time applies (from the 1973 model inclusive) until the car is changed in a way which is regarded as noticeably affecting the time.

On pages issued before May 1974, different types of engine have been allocated different year model codes such as:

95/96 with 2-stroke engine has been coded 5-6
95/96 with V4 engine has been coded 7–
99 with 1.7-1.85 litre engine has been coded 9-2
99 with 2.0 litre engine has been coded 3–

The following abbreviations are to be introduced in the Repair Time Schedule:

repl	=	replacement
rem	=	removal
inst	=	installation
rem-inst	=	removal and installation
overh	=	overhauling
check	=	checking
adj	=	adjustment
incl	=	including
excl	=	excluding
compl	=	complete
LH	=	left-hand side
RH	=	right-hand side

To be inserted after the foreword of the Saab Repair Time Schedule

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Saab 95/96

Inspections, service

1

111 Pre-delivery work

112 Warranty inspection

113 Regular inspections

121 Lubrication

122 Oil changing

131 Washing

141 Antirust treatment

151 Tuning and adjustment

191 Registration plates

	Typ Type Typ	Årsmodell Year model Baujahr	Oper.nr Oper.no Arbeitsgang	Tid Time Zeit
111 Pre-Delivery Work				
Pre-delivery inspection		75–76	11102	130
Additional time if TSI is not used		75–		5
Additional time if trestles are used instead of lift		75–		5
Additional jobs				
Adj seat guides, per seat		75–	11125	10
Adj toe-in		67–	11349	10
De-waxing		75–	11104	70
Cleaning windows, rubber parts and around door openings etc		75–	11106	80
Complete body polishing		75–	11108	60
Loose equipment install, miscellaneous protections remove		75	11123	20
		76	11123	30
License plates, see 191				
112 Warranty Inspection at 2000 km				
Warranty inspection		75	11202	190[1)]
		76	11202	180
Extra time if TSI is not used		75–		5
Extra time is trestles are used instead of lift		75–		20

1) Time does not include checking and adjusting front wheel angles.
Additional time for this work as per 601.

	Typ / Type / Typ	Årsmodell / Year model / Baujahr	Oper.nr / Oper.no / Arbeitsgang	Tid / Time / Zeit
111 Pre-delivery work				
Pre-delivery inspection, incl torquing cyl head and valve adj		74	11102	170
Pre-delivery inspection		75	1102	130 n
Additional time if TSI is not used		75		5 n
Additional time if axle stands are used instead of lift		74–75		10
Additional work:				
Fit new gaskets to valve covers, per pair		74	11121	10
Adj seat guides, per seat		74–75	11125	10
Adj toe-in		67–	11349	10
Dewaxing		74–75	11104	70
Pre-delivery polishing		74–75	11108	130
Inst loose equipment, remove various protections		74–75	11123	20
License plates, see 191				
112 Warranty inspection 2000 km				
Warranty inspection		74–75	11202	190 1)
Extra time if TSI is not used		75		5
Extra time if axle stands are used instead of lift		74–75		20

1) Time does not include check and adj front wheel angles.
Extra time for this work as per 601.

Inspection every 10,000 km **11300**

The time allocated is based on a workshop equipped with a column lift. All the necessary instruments, tools, lubricants and other aids must be available adjacent to the place at which the work is to be carried out.

It is assumed that the car has been driven into the work area with the front wheels on turntables and the freewheel locked (for valve adjustment).

Check operation of: Parking, rear, stop, reversing lights, flashers and warning flashers (mirrors in front of and behind car), instrument lighting, warning and indicator lights, brake warning light, from 1974 inclusive seat belt warning light, horn, ventilation fan (both speeds), interior lighting and door switches in doors, windshield and headlamp wipers and washers.

Engage reverse gear, take out starter key, unlock trunk lid, check operation of license plate lighting and trunk lighting. Close trunk lid, insert key in ignition lock, engage 4th gear.

1967 model: Remove LH and RH baskets, lift out front carpet(s) and masonite panel. Check condition of brake lines (lead lamp, screwdriver, anti-rust compound). Replace masonite, carpet(s) and baskets.

Extend lift arms
Raise car half-way

Check tyre tread depth (special gage) and note values on report.

Run out compressed air hose and connect nut runner and socket.
Remove hub caps and all wheels (nut runner, socket 19).

Check brake pad thickness and brake hose condition at front wheels (lead lamp).

Check lining thickness and check wheel cylinders for leaks through holes in rear brake drums (screwdriver, lead lamp). Adjust rear brake shoes (special 5/16 spanner) and release external parking brake pivot if necessary (compressed air gun), check condition of hoses and pipes at rear axle (rag, anti-rust compound).

Up to 1972 inclusive: Inject grease at front. Wipe lubrication nipples, lubricate ball joints and tie rod ends. Put away grease gun, wipe.

Check for leaks and check the condition of the rubber boots of the steering gear and external UJs, and of the rubber seals of the ball joints and tie rod ends (lead lamp).

Check the condition of the exhaust system and check for leaks (hammer and screwdriver).
Where there is a leak at a joint, tighten the clamp (articulated wrench 1/2).

Retract radio antenna (if there is a risk of it reaching the ceiling). Raise car to highest position.
Collect waste oil vessel (on pivoting arm or tank on wheels). Remove drain plug (ratchet wrench, 3/4 or 13 socket). Wipe plug and tools.
From 1971 inclusive: Replace seal at plug.
Install plug.
Lower car to one-quarter raised position.

Place wheels on hubs and start all bolts. Tighten the bolts in opposite pairs, but not to full torque (nut runner).
Set the parking brake to an intermediate setting. Check that the braking effect is uniformly distributed between the two rear wheels. If necessary, adjust the cables by means of the nuts under the brake lever.
Check.
Up to 1970 model (special 9/16 wrench)
From 1971 model inclusive (ratchet handle, medium extension and long 9/16 socket)

Lower car to floor (but keep lift arms in contact with underbody for subsequent lifting). Finally tighten the wheel bolts in opposite pairs (articulated handle or torque wrench, hexagon socket 3/4).

Fit hub caps.
Open engine hood and position fender protectors (order time). Remove engine hood (screwdriver) and put away.

Place rags on engine compartment floor under filter.
Remove filter (strap wrench 786201).
Take new filter, oil seal (oil can).
Install filter.
Remove rags from floor, wipe.

After fitting wheels:
Take filler hose.
Remove cap, put in 3.3 l oil, fit cap, put away hose.

Remove gearbox drain plug (ratchet handle, long and short extension, from 1974 inclusive double hexagon socket 1/2 also). Check oil level (special dipstick). If topping up required: Collect hose or filler can, top up oil. Put away hose (can). Refit filler screw.

Turn front wheels to LH lock. Take hose or grease gun. Wipe steering gear nipple and lubricate moderately (lubrication equipment or hand grease gun). Put away hose/gun.

Raise front of car and lock LH front wheel with a block against the floor.

Remove top of air cleaner (articulated wrench 10 or 11). Remove lower part (articulated wrench 10). Disconnect ignition leads from plugs and coil, remove distributor cap.

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Remove valve covers (special wrench 10, screwdriver). Clean to remove remains of gasket (screwdriver, knife), wipe surfaces on cylinder head. Wash and blow clean valve covers (washing facilities, compressed air gun).
From 1971–1972 models inclusive: Remove washer bottle (for plugs and fuel pump).

Blow clean at and remove spark plugs, visually check (compressed air gun, ratchet wrench, long socket, spark plug wrench).

Turn crankshaft by turning the free front wheel. Check and adjust valve clearances (feeler gage, 7/16 articulated wrench).

Tighten spark plug cap nuts (nut pliers) or unpack and fit cap nuts to new spark plugs. Adjust spark gaps (spark plug tool). Install spark plugs.

Fit new gaskets to valve covers. Install covers.

Check engine oil level.
Check condition of fuel lines in engine compartment, check for leaks. Where necessary, tighten hose clips (screwdriver). Check that the hose union at the carburettor cap has not become loose.

Raise the car slightly, remove the block under LH front wheel. Lower car. If the front wheel angles are not to be measured later, the lift can be lowered to the floor and the arms folded in.

Check the condition of the alternator drive belt and its tension with thumb pressure. Adjust if necessary (ratchet wrench, socket 1/2 and large articulated handle).

Check fluid level in battery cells. Top up with distilled water if necessary. Remove any loose oxide at cable lugs (rag, screwdriver). Wipe top of battery.
Check tightness of battery cable lugs (ring spanner 1/2), and grease with vaseline (brush).

Check freezing point of coolant (tester). Note value on report. Fill cooling system with water, add antifreeze if necessary. Fill washer bottle with water.

Remove cap from radiator tank or expansion vessel and connect cooling system tester. Pump up pressure and note position of needle.

Remove fuel pump cover (ring spanner 5/16 or screwdriver) and carefully remove filter gauze. Blow clean gauze, cover and pump housing (compressed air gun). Replace gasket if necessary. Check the small gasket under the screw head.

Install gauze, gasket and cover.

Check whether the pressure in the cooling system has dropped, and if so why. Visually check condition of all hoses and check for leaks. Tighten any clamps which may be loose (screwdriver). Remove pressure tester and replace cap.

Transfer wiring harness on TSI (on tool panel). Place TSI on care heater installation. Connect leads. (Up to 1974 inclusive). Check that gear lever is in neutral. (From 1975 inclusive). Connect distributor low-voltage lead to coil. Remove distributor. Check voltage drop across contact breaker points. Visually check contact surfaces (screwdriver, lead lamp). Lubricate distributor felt and cams (screwdriver, special grease, oil can).
1967: Lubricate cup at bottom of distributor housing. Check dwell angle, adjust if necessary (screwdriver, TSI).

Visually check, wipe and install distributor. Visually check and wipe distributor cap and ignition leads. Wipe around high-voltage outlet on coil. Install distributor cap, check that leads are properly connected. Connect leads to spark plugs and coil.

Connect exhaust hose and CO-meter exhaust gas collector to rear silencer. Clean around firing point markings on timing gear cover (screwdriver, rag). Start engine, check dwell angle again. Connect firing impulse detector. Disconnect distributor vacuum hose, lower engine speed, check basic ignition setting, adjust if necessary (spanner 7844707 filed out to 13 mm). Re-check. Speed up engine to check that the speed control is operative.

Adjust the speed to about 2,000 rev/min. Check that the vacuum control is operative. Reduce the idling speed, fit ignition timing lamp to TSI.

Leave engine running for carburettor adjustment.

Check that the exhaust pipe connections to the cylinder heads do not leak.

Up to 1969 inclusive: Lubricate clutch shaft upper bearing in clutch housing with a few drops of oil (oil can).

Check level in brake and clutch reservoirs. Top up with disc brake fluid if required.

Check condition of inner UJ rubber boots (lead lamp). Check condition of all brake lines in engine compartment, check for leaks (rag, lead lamp).

Blow clean air cleaner filter (compressed air gun).

Wipe clean inner surfaces of air cleaner halves. Install bottom part of air cleaner. Install filter and top part.

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Collect and position CO-meter trolley. Connect meter to battery. Place condensation trap at rear of car and probe in exhaust pipe. Run out hose from condensation trap to trolley. Start meter pump, calibrate and connect hose to instrument.

1971–1973: Install washer bottle.

Collect and install engine hood.

Lubricate door stops and hinges (vaseline and oil can with long spout). Lubricate engine hood lock (oil can). Lubricate throttle linkage bearings (oil can). Check that the choke shaft moves easily in its bearings. Routine lubrication should not be necessary. If binding occurs, lubricate with a thin, temperature-resistant lubricant such as automatic gearbox oil or lock cylinder oil containing graphite. Force the lubricant in with a compressed air gun and work the choke flap so that it moves easily when repeatedly turned to its end positions.

Adjust the idling mixture setting (screwdriver), adjust idling speed (screwdriver, rev counter), read off CO-meter. If the value is too high, reduce the mixture slightly. Check speed, adjust if necessary. Check CO content. Note value in report.

Stop engine, disconnect all connections, place TSI on panel.

Shut off CO-meter pump and disconnect connection to battery. Roll up hoses. Place condensation trap and exhaust gas collector on meter trolley.

Disconnect exhaust hose from car.

Remove fender protectors, close engine hood (order time).

Roll the car back and forth in the position for toe-in measurement. Set the toe-in tool (784001) for the correct track. Position the tool at the rear edges of the rims. Lock the scale, mark the sides of the tyres with chalk. Move toe-in tool to floor in front of car. Roll the car forward, position tool at front edge of rims. Measure and note value in report. Put away toe-in tool.

Position car for headlamp setting. Wipe headlamp glasses. Visually check condition of headlamps. Switch on headlamps and any cornering lamps. Check settings of dipped and main beams (headlamp setting unit at work area).

1969–1973: Remove trim frames (crosshead screwdriver).

Adjust settings of dipped and main beams.
Fit trim frames (1969–1973).

Start windshield and headlamp wipers (from 1971 inclusive) and washers. Check correct wiping and washing. Stop wipers and washers. Wipe off wiper rubbers and check. If necessary, disconnect-connect washer tubing from/to nozzle and clean nozzle (compressed air gun, wire if necessary).
Adjust nozzle aim if necessary (wire).
Check operation of wipers and washers.

Make the necessary notes in the report.

Spares: 2 valve cover gaskets, fuel pump gasket if nec, 3.3 litre engine oil, sealing ring for engine oil drain plug if nec, oil filter.

Gearbox oil change **67–** **11327**

It is assumed that the car is on the lift in the highest position.

Position the oil collector (swing arm or vessel on wheels).
Remove drain plug (ratchet wrench, short extension or 879036).
Wash plug (washing facilities at work area, brush, compressed air gun).
Install plug.

After installing wheels (time for remove-install drain plugs is included in inspection programme):
Take filler hose.
Put in 1.7 litres oil.
Put away hose

Delete from 11300:
Check level, top up oil.

Spares: 1.7 litres EP 80 oil

Contact breaker points replace **67–** **11335**

Single-unit contact breaker set was introduced from chassis No. 96/434.174 (1/3 of 1967 cars)

Having checked contact breaker point surfaces:
Rem contact unit (screwdriver)
Unpack new unit (screwdriver)
Check that surfaces are dry, wipe with trich if nec
Fit contact breaker unit to distributor

Spares: contact breaker unit

Fuel filter replace **70–** **11339**

After valve adjustment:

Rem filter (screwdriver)
Inst filter (screwdriver)

Spares: fuel filter

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Front wheel angles (camber and caster) check — 67– — 11340

After carb adjustment:

Check and adjust tyre pressure (not spare)
Attach instruments to rim edges of front wheels
Connect transformer to instruments and mains
Raise car (lift or jack)
Check treads of front tyres
Compensate for rim throw (optically, against scale in front of car)
Set turntables to correct position, lower car
Fit brake locks
Release turntables, work front of car up and down
Meas camber, 1st wheel
Meas caster, 1st wheel, note values in report
Meas camber, 2nd wheel
Meas caster, 2nd wheel
Meas toe-in, note values
Read off table (Saab) for thickness of any washers that may be required
Rem instruments and put them back in the correct place
Disconnect transformer and put it back in the correct place
Rem brake locks
Lock turntables

Time for toe-in check in 11300 is deleted

Front wheel angles, check and adjust 1 side, toe-in adjust — 67– — 11342

Check camber and caster, see 11340 (67–)
Replace washers in front and rear brgs, one side (ratchet handle or ratchet wrench 899576, short extension, socket 9/16, lever)
Meas, note values
Check toe-in
Adj toe-in (creeper board, U-wrench 7/8, up to 1968 inclusive U-wrench 7/16, then polygrip pliers)
Check, readjust and re-check if nec
Note reading

Front wheel angles, check and adjust 2 sides, toe-in adjust — 67– — 11346

Check camber and caster, see 11340 (67–)
Replace washers in front and rear brgs both sides (ratchet handle or ratchet wrench 899576, short extension, socket 9/16, lever)
Check and note values for 2 sides
Check toe-in
Adj toe-in
Check, readjust and re-check if nec
Note reading

Toe-in adjust — 67– — 11349

This job is an extra either to an inspection in which the wheel angles are not checked or as an addition to 11340

After checking:
Adj toe-in (creeper board, socket wrench 7/8, 7/16 (up to 1968 inc), polygrip pliers)
Roll car back and forth
Posn meas tool (484001) at rear rim edges
Note reading on scale, make chalk mark on tyre
Move tool to floor in front of car
Roll car forward
Posn tool on front rim edges
Meas and note reading in report

Brake fluid replace — 67– — 11352

Before removing wheels:

Fill brake bleeding eqpt with brake fluid
Charge eqpt with air (Cag)
Top up car brake fluid reservoirs, connect nipple caps and pressure hose from eqpt

After draining off oil:
Brush clean and blow at all bleed nipples (wire brush, Cag)
Subject system to pressure
Bleed at LH front wheel (ring wrench 7/16, vessel with tube for excess fluid)
Move vessel to RH rear wheel
Bleed at RH rear wheel (bleeding wrench 786109)
Transfer vessel to RH front wheel etc...

Put away excess fluid container

After refitting wheels:
Disconnect pressure hose from car reservoir
Check level, refit cap, wipe
Check pedal pressure

Torque-tightening of inlet manifold — 67– — 11355

After valve adjustment:

Loosen and torque-tighten inlet manifold bolts and nuts in accordance with instructions laid down (torque gage, special wrench 786062)

Check level, top up, rear shock absorber in Saab 95, per car — H 67– — 11360

After draining oil:

Clean around and rem screw in rear shock absorbers (articulated wrench 9/16 or 14)
Check level (wire)
Top up with oil (shock absorber oil) if nec
Refit screw

113 10000 km inspection, V4 models

	Modelcode	Oper. No.	Time
Inspection (checking program)	67	11310	173
Inspection (checking program)	68	11310	165
Inspection (checking program)	69	11310	171
Inspection (checking program)	70	11310	176
Inspection (checking program)	71–72	11310	184
Inspection (checking program)	73	11310	178
Inspection (checking program)	74	11310	171
Additional time if trestles are used instead of lift	67–		10
Cust program (additional work. Extra to 11310)	7–	11312	35
Additional time if trestles are used instead of lift	7–		2
Maintenance program (order work. Extra to 11310):			
B1. Engine oil change (lift)	7–	11321	7
B1. Engine oil change (trestles)	7–	11322	9
Extra on B1 if oil in cans is used	7–	11323	5
B2. Oil filter replace	7–	11325	5
B3. Gearbox oil change (lift)	7–	11327	7
B3. Gearbox oil change (trestles)	7–	11329	9
B4. Spark plugs replace			
B5. Contact breaker points replace	7–	11335	5
B6a. Fuel filter replace	0–	11339	5
B6b. Air cleaner filter replace	–	–	–
B7a. Front wheel angles (camber and caster) check (rim-mounted instr)	7–	11340	21
B7a. Front wheel angles (camber and caster) check (hub-mounted instr)	7–	11341	24
B7b. Front wheel angles check and adjust, one side, adjust toe-in (rim-mounted instrument)	7–	11342	50
B7b. Front wheel angles check and adjust, one side, adjust toe-in (hub-mounted instr)	7–	11343	52
B7d. Front wheel angles check and adjust 2 sides, adjust toe-in (rim-mounted instr)	7–	11346	63
B7d. Front wheel angles check and adjust 2 sides, adjust toe-in (hub-mounted instr)	7–	11347	66
B8. Toe-in adj	7–	11349	12
B9. Brake fluid replace (lift)	7–	11352	29
B9. Brake fluid replace (trestles)	7–	11353	36
Extra on B9 for replacement of bleed nipples, each	7–	11354	3
B10. Inlet manifold torquing	7–	11355	5
B11. Level check, possibly topping up, rear shock absorbers of model 95, per vehicle	H7–	11360	6

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113 Inspection Programme every 10,000 km

	Typ Type Typ	Årsmodell Year model Baujahr	Oper.nr Oper.no Arbeitsgang	Tid Time Zeit
Inspection		67–70	11300	2 10[n]
		71–73	11300	220[n]
		74–	11300	210[n]
Additional time if TSI not used		67–		5
" " " " axle stands used instead of lift		67–		20
Inspection jobs depending on time and distance driven.				
Add these to Operation No. 11300 if necessary:				
Torque-tightening of inlet manifold (at 10,000 km only)		67–	11355	5
Fuel filter replace (every 20,000 km)		70–	11339	5
Circuit breaker contacts replace (every 20,000 km)		67–	11335	5
Change gearbox oil (every 20,000 km or once yearly)		67–	11327	5
Check camber and caster [1] (every 20,000 km)		67–	11340	20
Check camber and caster and adjust one side, adjust toe-in		67–	11342	50
Check camber and caster and adjust both sides, adjust toe-in		67–	11346	60
Toe-in adjust [1]		67–	11349	10
Check level in rear shock absorber, top up if necessary, per car (Saab 95, every 20,000 km)	H	67–	11360	5
Change brake fluid (every 40,000 km or every other year)		67–	11352	30

[1] Toe-in check is included in 11300

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Examples of jobs which may be necessary at 10 000 km inspections	Typ Type Typ	Årsmodell Year model Baujahr	Oper.nr Oper.no Arbeitsgang	Tid Time Zeit
Motor wash, incl washing floor and wheel hsgs		67–	20103	40
Compression testing		67–	15115	5
Carb cleaning, fast idle adj		67–	23109	50
Carb, fast idle adj		67–	23113	5
Carb, adj aut choke and fast idle		67–75	23121	40
Fuel filter, inst new		67–69	23320	10
Complete exh syst repl, incl mod		67–75	25221	110
Complete exh syst repl		67–	25221	90
Intermediate pipe and rear muffler repl, incl mod		67–75	25203	60
Intermediate pipe and rear muffler repl		67–	25203	40
Topping up antifreeze liquid		67–	26181	10
Fanbelt repl		67–	26212	10
Batt repl		67–	31102	20
Batt, check charge condition and voltage under load		67–	31122	10
Batt shelf, clean and paint (batt out)		67–	31107	20
Headlamp unit (round), repl 1		67–68	35136	20
Headlamp unit (round), repl 2		67–68	35134	40
Headlamp unit (rect), repl 1		69–73	35133	5
		74–	35136	10
Headlamp unit (rect), repl 2		69–73	35135	10
		74–	35134	20
Headlamp bulb, repl 1 or 2		67–	35104	5
Flasher bulb repl		67–	36106	5
Headlamp wipers, wiper blades repl each		71–	36314	5
Windshield wipers, rubbers repl each		67–69	36306	10
		70–	36306	5
Windshield wipers, blades repl each		67–	36301	5
Int lighting door switch, replace each		67–	35183	10
Brake pads front, replace		67–	51713	40
Brake pads rear repl, wheel cylinders repl/overhaul and bleed		67–	51129	150
Steering wheel posn adj		68–69	64101	5
		70–75	64101	20
		75B–	64101	5
Shock absorbers front, rubber bushings repl, 2 sides		67–	76137	20
Shock absorbers front, replace 2		67–	76147	30
Shock absorbers rear, replace 2	P	67–	76145	40
Change tyres, 2 wheels		67–	77247	50
Balancing, 2 wheels		67–	77148	30
Balancing, 2 wheels with light alloy rims		67–	77148	40
Blow clean and lubr all ext lock cylinders		67–	83420	10

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	Typ Type Typ	Årsmodell Year model Baujahr	Oper.nr Oper.no Arbeitsgang	Tid Time Zeit
121 Lubrication				
All-round lubrication	P	67–72	12124	40
	H	67–72	12124	50
		73–	12124	30
Lubrication of front end and steering gear (car raised)		67–72	12123	10
Grease nipple replace, each		67–	12109	5
122 Oil Changes				
Engine oil change, filter not replaced		67–	12212	10
Engine oil change, filter replaced		67–	12206	20
Gearbox oil change		67–	12216	20
Gearbox oil change (car raised)		67–	12223	10
141 Antirust Treatment				
Doors and undersides of doors		67–	14122	30
Doors and undersides of doors, incl drilling holes		67–73	14122	30
Extra work for spraying in:				
Lower side panels	P	67–73	14135	5
	H	67–73	14135	10
Lower side panels, incl drilling holes		67–73	14133	10
Front upper spring support		67–	14131	5
Aerofoil	H	67–	14129	5

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121 Lubrication

	Modelcode	Oper. No.	Time
All-round lubrication (including battery check)	P7–2	12124	36[X]
All-round lubrication (including battery check)	H7–2	12124	45[X]
Chassis lubrication (front end, steering gear, car raised)	5–2	12123	8
Change grease nipple, each	5–	12109	4

122 Oil changes

Engine oil change (filter not changed)	7–	12212	10
Enginge oil change (including filter change)	7–	12206	15[n]
Gearbox oil change	5–	12216	18
Gearbox oil change (car raised)	5–	12223	11

131 Washing

Body (with car shampoo, including inside cleaning)	5–	13106	45
Body "quick wash" (hose-sponge)	5–	13114	17
Body "quick wash" (hose-leather)	5–	13112	17
Body "quick wash" (hose-sponge-leather)	5–	13120	31
Underbody hosing (for inspection of underbody compound)	5–	13116	10
Engine wash	5–	13201	43

141 Antirust treatment

	Doors (2)	Treatment of underside of doors	Rear side panels (2)	"Air planer"	Front spring support (2)		Drilling holes	Spraying antirust fluid	Modelcode	Oper. No.	Time
Basic operation	X	X					X	X	5–	14120	40[n]
Basic operation	X	X						X	5–	14122	33[n]
Extra to above			X				X	X	P5–	14133	6[n]
Basic operations			X				X	X	H5–	14133	11[n]
			X					X	P5–	14135	3[n]
			X					X	H5–	14135	10[n]
				X				X	H5–	14129	6[n]
					X			X	5–	14131	2[n]

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	Typ / Type / Typ	Årsmodell / Year model / Baujahr	Oper.nr / Oper.no / Arbeitsgang	Tid / Time / Zeit
151 Tuning and Adjustment				
Cleaning air filter and fuel pump, adjusting spark plugs, ignition timing and idling		67–	15104	70
Ditto when using TSI		75–	15104	60
Extra work to above operations:				
Valve clearances adjust		67–	15125	40
Carburettor cleaning, incl idling adjust		67–	23109	50
Automatic choke check and adjust, incl idling adjust		69–	23121	40
Fast idling adjust		67–	23113	5
Fuel filter replace		70–	23322	5
Fuel filter, install new		67–69	23320	10
Contact breaker points replace		67–	11335	5
151 Compression Testing				
Incl remove-install spark plugs		67–68	15114	20
		69–	15114	30
In conjunction with inspection, engine tuning or similar work		67–	15115	5
191 License Plates				
Install new, 2		75–	19110	20
Replace 1		67–	19102	20
Replace 2		67–	19104	30

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201 Engine, power unit, engine mountings

211 Cylinder head

212 Pistons, cylinder block

214 Valve mechanism

215 Distributor gearing, timing gear, camshaft

216 Crankshaft, flywheel

217 Oil sump

221 Oil pump

222 Oil filter

231 Carburetor

232 Air cleaner

233 Fuel pump and filter

234 Fuel tank and fuel lines

251 Inlet manifold, exhaust manifold

252 Exhaust system

261 Radiator, hoses

262 Collant pump, fan, thermostat

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201–1	March 1974	2	201–1

	Modelcode	Oper. No.	Time
201 Rem-inst power unit (engine and gearbox)			
Power unit rem-inst	67–70	20138	281
Power unit rem-inst, RHD car	67–70	20138	310
Power unit rem-inst	71–	20138	292
Power unit rem-inst, RHD car	71–	20138	321
Power unit remove	7–0	20174	117
Power unit remove	1–	20174	122
Power unit install	7–8	20176	185
Power unit install	9–0	20176	177
Power unit install	1–	20176	187
Extra for 2 aux headlights (1969 on, incl adjustment)	7–	20165	12
Extra for Eberspächer BL2ZW	7–	20167	21
201 Work with power unit out			
Power unit separate (in conj with lifting in and out)	7–	20191	14
Power unit assemble (in conj with lifting in and out)	7–	20193	13
Sep and assemble (incl rem-inst power unit from/on stand)	7–	20195	59
Separate (incl inst power unit on stand)	7–	20183	37
Assemble (incl rem power unit from stand)	7–	20185	32
Short eng, transfer of equipment, incl ign timing, adjustment of mixture, CO content and speed	7–	20112	639
Exchange eng (with cyl head etc), transfer of equipment incl ign timing, adjustment of mixture, CO content and speed	7–	20133	289
Engine washing			
Power unit, floor and wheel hsgs wash	67–	13201	43
Engine compartment and clutch hsg clean (engine out)	67–	20107	18

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	Modelcode	Oper. No.	Time
201 Engine mountings			
LH side replace	5–6	20106	109
RH side replace	5–6	20120	119
RH and LH side replace	5–6	20108	132
Replace 1 (engine out)	5–6	20139	7
Replace 2 (engine out)	5–6	20161	12
Front rubber blocks replace both	7–	20108	36
Front rubber blocks replace both (power unit out)	7–	20141	10
Rear (gearbox) mounting replace, (power unit out)	5–	20129	7
Side stay replace	5–	20151	12
211 Cylinder head 2-stroke			
Replace (not torquing)	5–6	21120	127
Remove	5–6	21170	31
Install (not torquing)	5–6	21172	77
Replace gasket replace (not torquing)	5–6	21102	103
Decarbonizing (not torquing) including spark plug cleaning	5–6	21128	153
Heli-Coil install 3 (head off)	5–6	21176	35
Heli-Coil install No. 1 (head off)	5–6	21178	17
Heli-Coil install the others, each (head off)	5–6	21179	9
Torquing	5–6	21108	17
211 Cylinder head V4			
Replace 1 (not torquing)	7–	21120	224
Replace 2 (not torquing)	7–	21104	295
Replace 1, engine in stand (not torquing)	7–	21111	162
Replace 2, engine in stand (not torquing)	7–	21113	206
Remove 1	7–	21170	91
Remove 2	7–	21180	117
Install 1 (not torquing)	7–	21172	128
Install 2 (not torquing)	7–	21182	164
Gasket replace, 1 (not torquing)	7–	21102	211
Gaskets replace 2, (not torquing)	7–	21118	272
Gasket replace 1, engine in stand (not torquing)	7–	21115	144
Gaskets replace 2, engine in stand (not torquing)	7–	21123	190
Combustion chambers and piston tops decarbonize, per side (cylinder head off)	7–	21125	47
Piston heads decarbonize per side (cylinder head off)	7–	21127	22
Torquing 1 (inclusive valve adjustment)	7–	21108	50
Torquing 2 (inclusive valve adjustment)	7–	21112	73
Torquing 2, valve covers removed (excluding valve adjustment)	7–	21107	11[n]

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	Modelcode	Oper. No.	Time
212 Cylinder block, pistons, 2-stroke			
Pistons replace (including remove-install) no machining of bores	5–6	21266	536
Pistons replace (engine out) no machining of bores	5–6	21230	365
Bore honing (A, AB, B to C) first	5–6	21275	33
Bore honing (A, AB, B to C) the others, each	5–6	21293	15
Bore honing (A to AB or AB to B) first	5–6	21251	26
Bore honing (A to AB or AB to B) the others, each	5–6	21253	9
Cylinder block and head decarbonize, clean and adjust spark plugs (engine dismantled)	5–6	21237	53
Additional time when reconditioning Sport engine (cover and check oil ways)	Sport 65-		+75
212 Cylinder block, pistons V4			
First piston replace (power unit out)	7–	21230	365[X]
Piston the others replace, each	7–	21217	35
Piston remove, first (cylinder head and sump off)	7–	21299	34
Piston remove, the others, each (cylinder head and sump off)	7–	21259	20
Piston rings replace, first piston (power unit out)	7–	21236	376[X]
Piston rings replace, the others, each	7–	21225	47
All piston rings replace (power unit out)	7–	21260	519[X]
Bore measuring (pistons out)	7–	21235	28
All bores and pistons measure (pistons out)	7–	21231	42
Bore honing, first	7–	21275	36
Bore honing, the others, each	7–	21293	11
Cylinder block replace (power unit out)	7–	21228	800[X]

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	Typ Type Typ	Årsmodell Year model Baujahr	Oper.nr Oper.no Arbeitsgang	Tid Time Zeit
Valve guide reaming the others, each per size		67—	21409	5
Valves adjust (including changing valve cover gasket)		67—	21440	50
215 Timing gear cover				
Replace (in car)		67—	21546	200
Replace (power unit out), incl rem-inst sump		67—	21529	200
Replace (engine in stand), incl rem-inst sump		67—	21545	150
Replace (front panel and radiator out)		67—	21561	120
Fit new gasket (in car)		67—	21502	210
Fit new gasket (power unit out), incl rem-inst sump		67—	21505	200
Fit new gasket (engine in stand), incl rem-inst sump		67—	21543	150
Fan bearing replace, see 262				
215 Timing gears				
Replace all, incl adj ignition timing (power unit out)		67—	21549	250
Replace all (engine in stand, timing gear cover and sump off)		67—	21531	20
Camshaft gear change (in car), incl adj ignition timing		67—	21504	240
215 Camshaft				
Replace (in car), incl adj ignition timing		67—	21542	500
Replace (in car), incl adj ignition timing (cylinder heads off)		67—	21521	260
Replace (engine in stand)		67—	21533	360
Replace (engine in stand, timing gear off), incl rem-inst cylinder head		67—	21547	230

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	Modelcode	Oper. No.	Time
214 Valve cover			
Gasket replace 1 (dismantle in car)	7–	21414	28
Gaskets replace 2 (dismantle in car)	7–	21436	42
214 Rocker assembly			
Remove-install 1 (valve cover off) (no valve adjustment)	7–	21439	9
Remove-install 2 (valve cover off) (no valve adjustment)	7–	21447	17
Remove 1	7–	21470	8
Remove 2	7–	21480	12
Install 1	7–	21472	31
Install 2	7–	21482	55
Recondition 1	7–	21434	55
Recondition 2	7–	21446	96
Recondition, each (removed)	7–	21495	18
Valve adjuster screw replace, each (valve cover off)	7–	21431	3
214 Valve springs and seals			
Replace 1st in one cylinder head	7–	21426	70
Replace 1st in two cylinder heads	7–	21458	111
Replace 1st (valve cover off)	7–	21415	29
Replace the others, each (valve covers off)	7–	21437	10
Replace all	7–	21438	172
Replace all (valve covers off)	7–	21479	110
Replace generator, loosen and tighten (see work description)	7–	21497	9
214 Valves			
Decarbonizing (excluding machining) 1 cylinder head	7–	21404	334
Decarbonizing (excluding machining) 2 cylinder heads	7–	21454	512
Decarbonizing (excluding machining) 1 cylinder head (engine in stand)	7–	21491	264
Decarbonizing (excluding machining) 2 cylinder heads (engine in stand)	7–	21443	420
Decarbonizing (excluding machining) 1 cylinder head (off)	7–	21450	123
Decarbonizing (excluding machining) 2 cylinder heads (off)	7–	21448	243
Turning, 1st (off)	7–	21455	15
Turning, the others, each (off)	7–	21445	4
Grinding, 1st (off)	7–	21405	17
Grinding, the others, each (off)	7–	21407	3
Grinding with paste, 1 cylinder head	7–	21433	23
Grinding with paste, 2 cylinder heads	7–	21487	42
Valve seat milling, all in 1 cylinder head	7–	21461	33
Valve seat milling, all in 2 cylinder heads	7–	21401	61
Valve guide reaming, 1st (1 size)	7–	21457	7

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	Typ / Type / Typ	Årsmodell / Year model / Baujahr	Oper.nr / Oper.no / Arbeitsgang	Tid / Time / Zeit	
215 Timing gear cover					
Replace (in car)		67–	21546	200X	110:00
Replace (power unit out), incl rem-inst sump		67–	21529	200X	110:00
Replace (engine in stand), incl rem-inst sump		67–	21545	150X	82:00
Fit new gasket (in car)		67–	21502	210X	115:00
Fit new gasket (power unit out), incl rem-inst sump		67–	21505	200X	110:00
Fit new gasket (engine in stand), incl rem-inst sump		67–	21543	150X	82:00
Fan bearing replace, see 262					
215 Timing gears					
Replace all, incl adj ignition timing (power unit out)		67–	21549	250X	137:00
Replace all (engine in stand, timing gear cover and sump off)		67–	21531	20	11:00
Camshaft gear change (in car), incl adj ignition timing		67–	21504	240X	131:00
215 Camshaft					
Replace (in car), incl adj ignition timing		67–	21542	500X	274:00
Replace (in car), incl adj ignition timing (cylinder heads off)		67–	21521	260X	142:00
Replace (engine in stand)		67–	21533	360X	197:00
Replace (engine in stand, timing gear off), incl rem-inst cylinder head		67–	21547	230X	126:00

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	Modelcode	Oper. No.	Time
215 Pulley (vibration damper) 2-stroke			
Replace	5–6	21512	64
215 Distributor gear 2-stroke			
Pinion and all seals replace	5–6	21544	171
Pinions and all seals replace (front panel and radiator off)	5–6	21539	97
All seals replace	5–6	21538	156
All seals replace (front panel and radiator off)	5–6	21537	83
Front cover seal replace (pulley off)	5–6	21541	29
215 Timing gear cover			
Replace (in car)	7–	21546	176
Replace (power unit out)	7–	21529	142
Replace (engine in stand)	7–	21545	102
Fit new gasket (in car)	7–	21502	189
Fit new gasket (power unit out)	7–	21505	152
Fit new gasket (engine in stand)	7–	21543	114
Intermediate plate gasket replace (timing gear cover off)	7–	21535	22
Fan bearing replace, see 262			
215 Timing gears			
Replace all (power unit out)	7–	21549	158[X]
Replace all (engine in stand, timing gear cover off)	7–	21531	18
Cam shaft gear change (in car)	7–	21504	197
215 Camshaft			
Replace (in car)	7–	21542	513
Replace (in car) (cylinder heads off)	7–	21521	238
Replace (engine in stand)	7–	21533	343
Replace (engine in stand, timing gear off)	7–	21547	218

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	Modelcode	Oper. No.	Time
216 Flywheel, 2-stroke			
Replace (clutch off)	5–6	21621	20
Replace starter ring (engine in car)	5–6	21604	224
Replace starter ring (engine out)	5–6	21606	54
Replace starter ring (flywheel off)	5–6	21644	14
216 Flywheel V4			
Replace (clutch off)	7–	21621	18
Replace starter ring (flywheel off)	7–	21644	14
216 Crankshaft, 2-stroke			
Replace (engine in car)	5–6	21628	554
Replace (engine out)	5–6	21652	383
Front bearing replace (engine in car)	5–6	21620	543
Front bearing replace (engine out)	5–6	21648	371
Front bearing replace (crankshaft out)	5–6	21693	17
216 Crankshaft V4			
Replace (power unit out)	7–	21652	382[X]
Replace (connecting rods off)	7–	21643	194
216 Main bearings			
Replace (inspect) all (power unit out)	7–	21682	253[X]
Replace (inspect) all (sump off)	7–	21685	174[X]
Test (replace) (in addition to 1 st testing) per bearing	7–	21647	13
Main bearing seal replace (power unit out) including remove-install in stand	7–	21684	108[X]
Main bearing seal replace (power unit separated)	7–	21649	62
Main bearing seal replace (clutch off)	7–	21651	28
216 Connecting rod bearings			
Replace (inspect) all (power unit out)	7–	21686	212[X]
Replace (inspect) all (sump off)	7–	21683	130[X]
Replace (inspect) all (in conjunction with main bearing change)	7–	21653	99
Test (replace) (in addition to 1st testing) per bearing	7–	21655	9
216 Balance shaft			
Replace (power unit out)	7–	21670	219[n]
Replace (engine in stand, timing gear cover off)	7–	21671	81[n]

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	Modelcode	Oper. No.	Time
217 Sump			
Remove (power unit out)	7–	21710	50[X]
Install (power unit out)	7–	21708	53[X]
Gasket replace (power unit out)	7–	21702	94[X]
Gasket replace (power unit in stand)	7–	21707	55
221 Oil pump			
Replace (remove-install) (power unit out)	7–	22120	99[X]
Replace (remove-install) (sump off, power unit in stand)	7–	22111	12[X]
Recondition (power unit out)	7–	22122	122[X]
Recondition (off)	7–	22171	28
222 Oil filter			
Replace	7–	22211	7
Oil pressure transmitter see 382			

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231 Carburettors, Solex 32 PDSIT–7 and –4

"Adj idling" means check and adj mixture, CO-content and speed. It is assumed that the engine has been warmed up where carburettor adj requires this. Time for rem-inst air cleaner is not included.

	Adj idling	Adj fast idling	Årsmodell Year model Baujahr	Oper.nr Oper.no Arbeitsgang	Tid Time Zeit
Repl (rem-inst)	X	X	67-68	23108	50[n]
Rem	X		67-68	23170	20[x]
Inst			67-68	23180	40[n]
Inst	X	X	67-68	23172	30[x]
Compl dismantling and assembly (incl rem-inst)	X		67-68	23102	140[x]
Compl dismantling and assembly (off)	X	X	67-68	23154	40
Cleaning			67-68	23110	70[n]
Cleaning			67-68	23140	60[x]
Cleaning (off)	X	X	67-68	23111	30[n]
Accelerator pump diaphragm repl	X		67-68	23116	10[n]
Accelerator pump capacity, check and adj (off)			67-68	23117	30[n]
Fuel level check			67-68	23127	10
Fuel level adj and recheck			67-68	23129	30[x]
Adj idling			67-68	23143	20[x]
Adj fast idling			67-68	23166	10[n]
Adj fast idling and idling			67-68	23133	20[x]
Automatic choke, temp adj (turn thermostat housing)			67-68	23131	5
Work on inspection or in similar circumstances					
Repl (rem-inst) incl adj fast idling			67-68	23105	40[n]
Compl dismantling and assembly (incl adj fast idling)			67-68	23107	130[n]
Cleaning incl adj fast idling			67-68	23109	50[n]
Adj fast idling			67-68	23113	5[n]

232 Cleaner (for Solex carburettors)

Rem-inst			67-68	23211	5
Wipe, blow clean (incl rem-inst air cleaner top)			67-	23207	5

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231 Carburetter Fo Mo Co

"Adj idling" means check and adj mixture, CO-content and speed. It is assumed that the engine has been warmed up where carburetter adj requires this. Time for rem-inst air cleaner is not incl.

	Adj. idling	Adj. fast idling	Typ / Type / Typ	Årsmodell / Year model / Baujahr	Oper.nr / Oper.no / Arbeitsgang	Tid / Time / Zeit
Repl/rem-inst	x	x		69–	23108	60
	x			69–	23106	50
Repl/rem-inst (power unit out)				69–	23103	30
Compl dismantling and assembly (incl rem-inst)	x	x		69–	23102	150
	x			69–	23160	140
Compl dismantling and assembly (off)				69–	23154	90
Cleaning	x	x		69–	23110	70
	x			69–	23140	60
Cleaning (off)				69–	23111	20
Check and adj automatic choke	x	x		69–	23122	60
Choke housing incl check and adj automatic choke	x	x		69–	23124	70
Check and adj mechanical opening of choke butterfly				69–	23126	5
Check and adj float level				69–	23128	40
Check and adj float level (float chamber cover off)				69–	23129	10
Accelerator pump diaphragm repl				69–	23116	10
Accelerator pump capacity, check and adj (off)				69–	23117	30
Adj idling				69–	23143	20
Adj fast idling				69–	23166	10
Adj fast idling and idling				69–	23133	20
Manual choke						
Inst manual choke incl adj carburettor				70–	23174	120
Adj manual choke				70–	23173	20
Tune-up in connection with installation of manual choke				70–	23171	60
Work on inspection or in similar circumstances						
Repl/rem-inst incl adj fast idling				69–	23105	40
Compl dismantling and assembly (incl adj fast idling)				69–	23107	130
Cleaning incl adj fast idling				69–	23109	50
Check and adj automatic choke incl adj fast idling				69–	23121	40
Choke housing repl incl check and adj automatic choke and fast idling				69–	23123	50
Adj fast idling				69–	23113	5
232 Air cleaner						
Rem-inst				69–	23211	5
Wipe, blow clean incl rem-inst air cleaner top				67–	23207	5

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	Modelcode	Oper. No.	Time
CO content of exhaust gases measure and adjust (in conjunction with carburetor adjustment)	7–8	23151	8
231 Carburetor (FoMoCo)			
Replace (remove-install) (including air cleaner clean)	9–	23106	44
Remove	9–	23170	22
Install (including air cleaner clean)	9–	23172	25
Dismantling, cleaning, assembly and adjust all settings (including remove-install) 1)	9–	23102	147
Dismantling, cleaning, assembly and adjust all settings (off)	9–	23154	94
Clean and idle adjust 1)	9–	23140	59
Cleaning, float level check and adjusting idle	9–	23136	72
Choke valve adjust (in conjunction with carburetor clean)	9–	23173	25
Adjusting idle mixture and speed	9–	23143	11
Fast idle and idle setting adjust 1)	9–	23120	22
Fast idle and idle setting adjust (air cleaner off) 1)	9–	23133	17
CO content of exhaust gases measure and adjust 1)	9–	23150	12
Co content of exhaust gases measure and adjust (in conjunction with carb.adjust)	9–	23151	8
1) Time does not allow for warming up			
232 Air cleaner			
Remove-install	7–8	23211	5
Remove-install	9–	23211	6
Wipe-blow (including remove-install)	5–6	23207	10
Wipe-blow (off)	5–6	23217	4
Wash-blow (remove-install)	5–6	23205	17
Wash-blow (off)	5–6	23215	11
Wipe-blow (including remove-install upper part of air cleaner)	7–	23207	6

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	Modelcode	Oper. No.	Time
233 Fuel pump, 2-stroke			
Replace (remove-install)	5–6	23312	21
Remove	5–6	23370	10
Install	5–6	23372	12
Recondition (including remove-install)	5–6	23308	45
Recondition (off)	5–6	23380	28
233 Fuel pump V4			
Replace (remove-install)	7–0	23312	24
Replace (remove-install)	1–	23312	29n
Replace (engine out)	7–	23307	17
Remove	7–0	23370	13
Remove	1–	23370	14n
Remove (engine out)	7–	23374	11
Install	7–0	23372	12
Install	1–	23372	15n
Install (engine out)	7–	23376	7
Recondition (including remove-install)	7–0	23308	52
Recondition (including remove-install)	1–	23308	57n
Recondition (off)	7–	23380	30
Filter cleaning	7–0	23305	5
Filter cleaning	1–	23305	8n
233 Fuel filter			
New installation	7–9	23320	11n
Replace	0–	23322	7n
234 Fuel lines			
Fuel line from tank to engine compartment, replace (power unit out)	5–	23408	42
Fuel line from tank to engine compartment, replace (power unit and upholstery etc. out)	5–	23401	28
Clipped hoses, change, each	7–	23425	7
Hose between fuel line and pump, replace	7–	23427	21
234 Fuel tank			
Remove	P5–9,H5–	23470	41
Remove	PO–	23470	47
Install	P5–9,H5–	23472	64
Install	PO–	23472	72
Replace	P5–9,H5–	23412	112
Replace	PO–	23412	124

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	Modelcode	Oper. No.	Time
Filler pipe replace (wheel off)	5–	23421	22
Tank transmitter and/or gasket replace	5–	23418	18
Tank transmitter and/or gasket replace (tank out)	5–	23476	9
Cleaning tank in car, including cleaning of lines, pump, carburetor	7–	23478	116

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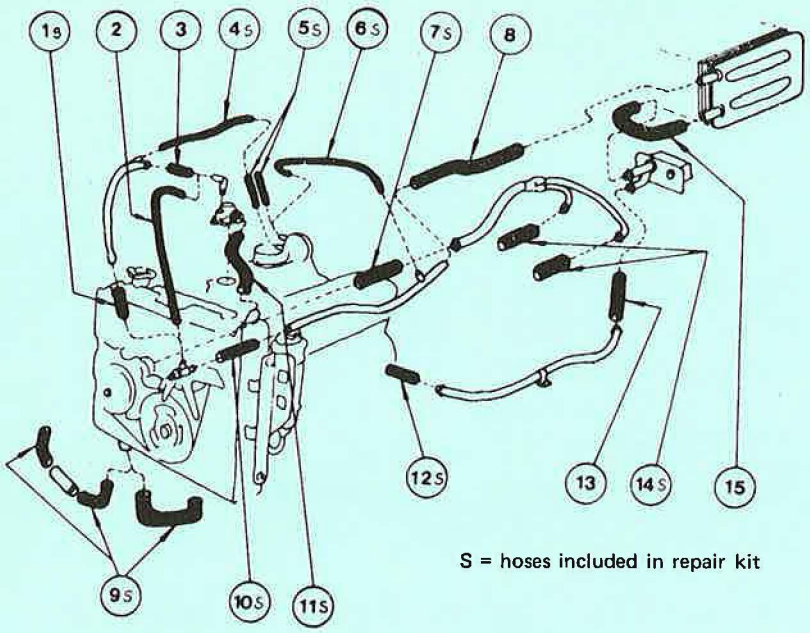
	Modelcode	Oper. No.	Time
251 Inlet manifold			
Replace	67–	25120	164
Replace (engine in stand)	7–	25145	128
Remove	7–	25170	71
Install	7–	25172	80
Gasket replace, incl rem-inst carb	7–	25102	150
Gasket replace (eng in stand) incl rem-inst carb	7–	25147	113
Torquing, incl rem-inst air cleaner	7–	25122	10
Torquing, air cleaner off	7–	25123	6
252 Exhaust system			
Replace complete	7–	25222	136
Replace complete (car on trestles, rear wheel off)	7–	25221	123
Change to complete performance kit system (scrap old system)	7–	25224	185
Change to complete performance kit system (new car or new exh system)	7–	25226	190
Front muffler replace	7–	25212	95
Front muffler and intermediate pipe replace	7–	25216	124
Rear muffler replace	67–	25210	53
Rear muffler replace (rear wheel off)	67–	25241	43
Rear muffler and intermediate pipe replace	67–	25204	77
Rear muffler and intermediate pipe replace (rear wheel off)	67–	25243	67
Intermediate pipe replace	67–	25206	58
Intermediate pipe replace (rear wheel off)	67–	25245	48

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	Modelcode	Oper. No.	Time
261 Radiator and hoses, 2-stroke			
Radiator replace	5–6	26108	59
Radiator remove	5–6	26170	18
Radiator install	5–6	26172	28
Radiator blind replace	5–6	26102	28
Hose thermostat-radiator replace (including coolant)	5–6	26112	14
Hose radiator-pump replace (including coolant)	5–6	26114	19
Upper and lower hose on pipe replace (including coolant)	5–6	26120	22
All hoses replace (including coolant)	5–6	26116	43
261 Radiator V4			
Replace (including remove-install front panel)	7–	26108	74
Remove	7–	26170	24
Install	7–8	26172	50
Install	9–	26172	44
Expansion tank replace	9–	26118	7
Entire cooling system flush	7–	26151	47
Hoses pressure-test and check	7–	26153	10

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S = hoses included in repair kit

261 Coolant hoses

	Modelcode	Oper. No.	Time
Hoses 9 replace (incl.remove-install radiator)[1]	7–8	26114	74
Hoses 9 replace (radiator or engine out)	7–8	26111	20
Hoses 9 replace (incl. remove-install radiator)[1]	9–	26114	66
Hoses 9 replace (radiator or engine out)	9–	26111	15
Hoses 1 replace (incl. remove-install generator)[1]	0–	26155	23[n]
Hose 1 replace (generator or engine out)[1]	0–	26159	10[n]
Hose 5 replace (air cleaner off)[1]	7–8	26169	20[x]
Hose 14 replace[1]	7–	26136	29
Hose 9 + 10 replace,in conjunction with changing coolant pump	7–8	26141	32[n]
Hoses 9 + 10 replace, in conjunction with changing coolant pump	9–	26141	25[n]
Hoses 7 + 10 replace (incl. remove-install generator)[1]	7–	26134	37
Hoses 7 + 10 replace (generator off or engine out)[1]	7–	26183	22
Hoses 4 + 5 + 6 + 12 replace (air cleaner off)[1]	7–8	26143	40[n]
Hoses 7 + 9 + 10 + 14 replace (incl. remove-install radiator)[1]	7–	26144	141[n]
Hoses 7 + 9 + 10 + 14 replace (radiator off)	7–	26145	85[n]
Hoses 1 + 7 + 10 + 14 replace (including remove-install generator)[1]	9–	26146	70[n]
Hoses 1 + 7 + 10 + 14 replace (generator off)[1]	9–	26147	48[n]
Hoses 2–3–4–6–8–11–12–13–15 replace one (air cleaner off)	7–	26148	8[n]
Hoses 2–3–4–6–8–11–12–13–15, replace additional each (air cleaner off)	7–	26149	7[n]
Coolant drain, fill; leakage check	7–	26181	12
Coolant fill; system vent	7–	26189	4[n]

1) Coolant drain-fill **not included.**

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	Modelcode	Oper. No.	Time
262 Coolant pump			
Replace	67–68	26202	111
Replace	69–	26202	119
Replace (front panel off, rad out)	67–	26213	101
Replace (power unit out)	7–	26211	70
Replace (timing gear cover off)	7–	26209	17
Recond (off)	7–	26250	28
262 Thermostat			
Replace	7–	26298	61
Replace (excl coolant)	7–	26297	50
Replace (carb off)	7–	26299	15
Test (out)	67–	26273	23
262 Fan belt			
Replace	7–	26212	9
Adjust	7–	26214	8
262 Fan belt			
Replace (incl rem-inst front panel)	7–8	26216	72
Replace (incl rem-inst front panel)	9–	26216	66
Replace (rad out)	7–	26227	13
262 Fan bearing			
Replace [1]	7–	26210	116
Replace (power unit out) [1]	7–	26251	46
Replace (timing gear cover off)	7–	26201	34

[1] For replacement without removal of timing gear cover

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Electrical system, instruments

3

311 Battery
321 Generator/alternator
322 Charging regulator
331 Starter motor
340 Ignition lock/starter switch
341 Ignition coil
342 Distributor
344 Spark plugs
345 Ignition cables
351 Lighting
361 Flashing direction indicators
362 Horn
363 Windshield wipers and washers
363 Headlight wipers and washers
364 Controls and switches
371 Wiring and fuses
381 Instrument panel, instruments, speedometer drives
382 Transmitters

	Typ / Type / Typ	Årsmodell / Year model / Baujahr	Oper.nr / Oper.no / Arbeitsgang	Tid / Time / Zeit
321 Alternator				
Replace		67–	32102	30
Replace (power unit out)		67–	32117	20
Remove-install		67–	32140	20
Remove-install (power unit out)		67–	32115	10
Remove		67–	32170	10
Remove (power unit out)		67–	32111	5
Inst.		67–	32172	20
Inst (power unit out)		67–	32113	10
Pulley replace (front panel off or power unit out)		67–	32121	20
Mounting bracket replace (alternator off, front panel off or power unit out)		67–	32119	5
Dismantle, clean, assemble (= bearings replace) (incl rem-inst alt)		67–	32132	110
Dismantle, clean, assemble (= bearings replace) (alternator off)		67–	32134	90
Testing in car		67–	32174	20
Bench testing (alternator off)		67–	32178	20
Work on dismantled alternator				
Remove-install heat sink (not nuts), stator winding and rectifier plate, check armature, stator winding and all rectifiers		67–	32165	70
Carbon brushes replace		67–	32131	20
Slip rings, clean		67–	32176	10
Rectifier, replace 1		67–	32145	10
Rectifier, replace others, each		67–	32147	5
Fan belt replace and adjust, see 262				
322 Voltage regulator				
Replace/remove-install		65–	32204	10

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	Typ Type Typ	Årsmodell Year model Baujahr	Oper.nr Oper.no Arbeitsgang	Tid Time Zeit
331 Starter Motor				
Replace/remove-install		67–73	33118	40
		74–	33118	50
Replace/remove-install (power unit out)		67–	33115	10
Remove		67–73	33170	20
		74–	33170	30
Remove (power unit out)		67–	33111	10
Install		67–73	33172	20
		74–	33172	30
Install (power unit out)		67–	33113	10
Solenoid replace (incl remove-install starter motor)		67–73	33110	50
		74–	33110	70
Dismantle, clean, check, assemble and test run (incl remove-install)		67–73	33104	120
		74–	33104	140
Work on removed starter motor				
Solenoid replace		67–	33179	10
		67–	33199	30
Switch on solenoid replace (incl remove-install solenoid)		67–	33199	30
Dismantle, clean, check, assemble and test		67–	33127	90
Bench test		67–	33131	5
Work on dismantled starter motor				
Brushes replace		67–	33123	20
Brush springs replace		67–	33197	5
Pinion bushing replace		67–	33167	20
Armature bushings replace		67–	33181	10
Commutator turning and slotting		67–	33125	30
Switch on solenoid replace		67–	33189	20
Starter motor pinion replace		67–	33121	20
340 Ignition Lock/Starter Switch				
Switch replace		67–	34002	10
Lock cylinder in ignition lock replace		67–	34010	20
341 Ignition Coil				
Replace		67–	34104	5
Replace incl test		67–	34108	20
Test		67–	34106	10

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	Modelcode	Oper. No.	Time
331 Starting motor			
Replace (remove-install)	5-6	33118	26
Replace (remove-install)	7-	33118	36
Removal	5-6	33170	13
Removal	7-	33170	21
Install	5-6	33172	15
Install	7-	33172	21
Solenoid, replace (including remove-install)	5-6	33110	35
Solenoid replace (including remove-install)	7-	33110	44
Solenoid replace (starting motor out)	5-6	33179	11
Solenoid replace (starting motor out)	7-	33179	12
Dismantle, clean, inspect, assemble and test run (incl remove-install)	5-6	33104	111
Dismantle, clean, inspect, assemble and test run (incl remove-install)	7-	33104	117
Dismantle, clean, inspect, assemble and test run (starting motor out)	5-6	33128	90
Dismantle, clean, inspect, assemble and test run (starting motor out)	7-	33128	85
Brushes, replace (motor disassembled)	7-	33123	22
Brush springs, replace (motor disassembled)	5-	33197	4
Pinion bushing, replace (motor disassembled)	5-	33167	15
Rotor bushings, replace (motor disassembled)	5-	33181	11
Turning and slotting commutator (rotor out)	5-	33126	29
Bench test (starting motor out)	5-	33132	7
340 Ignition lock/starter switch			
Switch replace	5-	34002	14
Lock cylinder replace (incl lock cylinder in door)	5	34010	40
Lock cylinder replace (incl lock cylinder in doors)	6-	34010	62
341 Ignition coil			
Replace	5-	34104	7
Test in car	5-	34106	12
Test in car (including replace)	5-	34108	18

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342 Distributor V4

	Typ Type Typ	Årsmodell Year model Baujahr	Oper.nr Oper.no Arbeitsgang	Tid Time Zeit
Replace incl ignition timing adjust		67–	34206	50
Remove		67–	34270	20
Install incl setting firing point		67–	34272	20
Remove-install, dismantle, clean, check, assemble incl check on bench and ignition timing adjust		67	34208	130
		68–	34208	100
Contact breaker points replace incl ignition timing adjust		67–	34202	40
Contact breaker points replace in conjunction with check or adjust ignition timing		67–	34217	10
Distributor cap replace		67–	34220	10
Remove-install, test and adjust on bench, incl setting firing point		67–	34210	50
Vacuum regulator replace (incl ignition timing adjust)		67–	34214	40
Vacuum regulator replace (in conjunction with ignition timing adjust)		67–	34215	5
Capacitor replace		67–	34216	10
Capacitor replace (in conjunction with ignition timing adjust)		67–	34291	5
Work on removed distributor				
Dismantle, clean, check, assemble incl check and adjust on test bench		67	34236	100
		68–	34236	70
Testing and adjustment on test bench		67–	34211	20
Ignition distributor pinion replace		67–	34223	20
Checking and Adjustment				
Ignition timing adjust		67–	34276	30
Ignition timing adjust with TSI		75–	34278	30
Ignition timing check		67–	34275	20
Ignition timing check with TSI		75–	34277	10
Firing point adjust		67–	34212	20
Firing point adjust with TSI		75–	34222	10
Firing point check		67–	34213	10
Firing point check with TSI		75–	34225	10

Ignition timing adjust = adjustment of dwell angle and firing point

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	Modelcode	Oper. No.	Time
342 Distributor 2-stroke			
Replace (dwell angle tester and stroboscope)	5	34206	47
Replace (dwell angle tester and stroboscope)	6	34206	58
Remove	5	34270	11
Remove	6	34270	13
Install (stroboscope)	5	34272	23
Install (stroboscope)	6	34272	29
Recondition incl remove-install (stroboscope)	5	34208	134
Recondition incl remove-install (stroboscope)	6	34208	141
Recondition, (distributor out)	5–6	34271	99
Contact breaker points replace (dwell angle tester and stroboscope)	5	34202	53
Contact breaker points replace (dwell angle tester and stroboscope)	6	34202	59
Contact breaker points replace (cover off) no adjustment	5–6	34217	13
Distributor cover and/or ignition cables replace	5	34220	10
Distributor cover and/or ignition cables replace	6	34220	21
Setting (testing) in synchrograph, incl remove-install (stroboscope)	5	34210	52
Setting (testing) in synchrograph, incl remove-install (stroboscope)	6	34210	58
Ignition setting (dwell angle tester and stroboscope)	5	34276	39
Ignition setting (dwell angle tester and stroboscope)	6	34276	46
Ignition check (dwell angle tester and stroboscope)	5–6	34275	17
342 Distributor V4			
Replace (dwell angle tester and stroboscope)	7–	34206	45
Remove	7–	34270	19
Install (stroboscope)	7–	34272	24
Recondition including remove-install (stroboscope)	7–	34208	132
Recondition (distributor out)	7–	34236	95
Contact breaker points replace (cam angle meter and stroboscope)	7–	34202	42
Contact breaker points replace (cover off) no adjustment	7–	34217	9
Distributor cover and/or ignition cables replace	7–	34220	15
Setting (testing) in synchrograph, incl remove-install (stroboscope)	7–	34210	53
Ignition setting (dwell angle tester and stroboscope)	7–	34276	34
Ignition check (dwell angle tester and stroboscope)	7–	34275	18

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	Typ Type Typ	Årsmodell Year model Baujahr	Oper.nr Oper.no Arbeitsgang	Tid Time Zeit
344 Spark plugs				
Replace all (short thread)		67–68	34406	10
Replace all (long thread)		69–	34406	10
Clean and adj all, short thread (incl rem-inst)		67–68	34408	20
Clean and adj all, long thread (incl rem-inst)		69–	34408	30
Clean and adj all (plugs out)		67–	34405	10
345 Ignition leads				
Replace all		67–	34504	20
Replace all (air cleaner off)		67–	34505	10
Spark plug connections replace, each		67–70	34506	5
Resistance measurement, all		67–	34510	10
Resistance measurement, all, or replace		67–	34512	20
351 Headlights				
Light unit repl 1, excl adj		67–68	35136	20
Light unit repl 1, eacl adj (trim frame off)		69–	35136	5
Light unit repl 1, incl adj both		67–68	35110	30
		69–70	35110	20
		71–	35110	30
Light unit repl 2, excl adj		67–68	35134	40
Light unit repl 2, excl adj (trim frames off)		69–	35135	10
Light unit repl 2, incl adj		67–68	35114	50
		69–	35114	30
Bulb, 1 or 2, repl		67–	35104	5
Switch repl		67–	35142	10
Foot switch repl		67–68	35130	5
Main beam relay repl		67–68	35182	5
Lighting relay repl		69–	35182	10
Screw in light unit holder repl, incl adj both headlights		67–68	35128	40
Trim frames, drill holes for adj screws		69–73	35120	20
Adj		67–68	35102	10
Adj, incl rem-inst trim frames		69–73	35102	20
Adj, trim frames off, holes drilled		69–	35111	10
Adj auxiliary headlights, each, in conj with adj main headlights		67–	35137	5

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	Typ Type Typ	Årsmodell Year model Baujahr	Oper.nr Oper.no Arbeitsgang	Tid Time Zeit
351 Tail light				
Tail light repl, complete	P	67–	35126	20
	H	67–	35126	30
Bulb and/or glass repl		67–	35118	10
351 License plate light				
Bulb and/or glass repl, each		67–	35122	10
Bulb and/or glass repl 1 (incl rem-inst handle)	P	67–69	35106	20
Bulb and/or glass repl 2 (incl rem-inst handle)	P	67–69	35108	20
Joining worn wire	P	67–	35132	10
351 Interior light				
Lamp hsg complete and/or bulb replace		67–	35190	5
Door switch repl		67–	35183	10
Door switch clean and grease		67–	35185	10
351 Instrument lighting				
Dimmer switch repl		67–	35112	10
Bulb repl, each, irrespective of posn		67–	35116	5
351 Warning lamps				
Bulb repl, irrespective of posn		67–	35138	5
Flasher/parking lights				
Flasher/parking light complete repl		67–68	36124	10
		69–	36124	40
Bulb and/or glass repl		67–	36106	5
361 Flasher unit				
Replace		67–	36102	5
361 Direction indicator switch				
Repl (incl rem-inst steering wheel)		67	36108	20
Repl		68–	36108	10

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	Typ / Type / Typ	Årsmodell / Year model / Baujahr	Oper.nr / Oper.no / Arbeitsgang	Tid / Time / Zeit
362 Horn				
Replace LH		67–71	36202	5
Replace RH		67–71	36216	20
Replace		72–	36202	20
363 Windshield wiper motor				
Repl (rem-inst) complete		67–	36302	20
Rem complete		67–	36370	20
Inst complete		67–	36372	20
Dismantle, clean and assemble (incl rem-inst)		67–	36310	70
Dismantle, clean and assemble (out)		67–	36342	50
Parking switch on motor repl		70–	36348	10
363 Windshield wipers				
Switch repl		67–	36340	10
Wiper spindle LH repl (rem-inst) (drill out link arm attachment)		67–	36360	80
Add to 36360 for repl nut and bushing (inside bulkhead)		67–	36325	10
Wiper spindle RH repl (rem-inst)		65–	36362	90
Wiper spindle RH or LH repl (when spindle and bushing hace seized)		67–	36334	120
Bushings, 2, in linkage arm repl		68–	36308	10
Wiper arm repl, each		67–	36304	10
Wiper blade repl, each		67–	36301	5
Rubber insert repl, each		67–69	36306	10
		70–	36306	5
Wiper arm adj posn, both		67–	36321	5

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	Typ / Type / Typ	Årsmodell / Year model / Baujahr	Oper.nr / Oper.no / Arbeitsgang	Tid / Time / Zeit
363 Washers				
Washer pump (mechanical) repl		67	36336	20
Washer pump or motor (in cover) repl		68–73	36336	10
Washer pump repl		74–	36336	5
Nozzle in eng hood repl		68–	36313	5
Nozzle in headlight rim repl, each		71–	36328	10
Hose in eng hood repl		68–73	36323	20
Hose for headlight washers repl, each		71–	36332	10
Bottle repl		68–73	36312	5
		74–	36312	10
363 Headlight wipers				
Wiper blades repl, each		71–	36314	5
Motor repl		71–	36316	30
Gearing repl (wiper motor off)		71–	36318	40
Parking switch or carbon brush repl (wiper motor off)		71–	36320	30
Linkage complete rem-inst		71–	36322	40
Linkage complete rem-inst, dismantle and assemble incl repl faulty parts		71–	36324	80
Linkage complete rem-inst, clean and grease		71–	36330	50
Relay repl, each		71–	36326	5
364 Switches				
Brake light switch (hydraulic) repl		67	36408	5
Brake light switch (mechanical) repl		68–	36408	5
Brake warning switch repl		68–	36430	10
Warning flasher switch repl		69–	36436	10
371 Fuses				
Fusebox repl		67–	37111	20
Fusebox, clean and check cable connections		67–	37110	10

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	Modelcode	Oper. No.	Time
363 Windshield wiper			
Motor complete replace (remove-install)	5–6	36302	19
Motor complete replace (remove-install)	7–	36302	24
Motor complete remove	5–6	36370	14
Motor complete remove	7–	36370	17
Motor complete install	5–6	36372	10
Motor complete install	7–	36372	15
Motor (SWF) lubricate (rotor remove-install)	5–6	36346	13
Motor (SWF) clean and adjust (incl remove-install)	5–6	36310	69
Motor (SWF) clean and adjust (motor out)	5–6	36342	54
Motor (Lucas) disassemble, clean and assemble (incl remove-install)	7–	36310	68
Motor (Lucas) diassemble, clean and assemble (motor out)	7–	36342	52
Switch replace	5–	36340	11
Rubber grommet with spindle replace (remove-install) LH	5–	36360	79
Rubber grommet with spindle replace (remove-install) RH	5–	36362	87
Wiper arm replace each	5–	36304	8
Wiper blade replace each	5–	36301	2
Rubber section replace each	5–9	36306	8
Rubber section replace each	0–	36306	6
Wiper arms adjust position both	5–9	36321	5
Wiper arms adjust position both	0–	36321	7
363 Windshield washer			
Pump (mechanical) replace	5–7	36344	18
Electric motor (in cover) replace	8–	36336	10
Nozzle on engine hood replace	8–	36313	5
Tubing at engine hood replace	8–	36323	19
364 Headlight dimmer switch			
Foot operated switch replace	5–8	36402	7
Steering column mounted switch, see direction indicator switch 361	9–		
364 Stop light switch			
Replace (hydraulic)	5–7	36408	4
Replace (mechanical)	8–	36408	7
364 Brake warning switch			
Replace	8–	36430	9

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	Modelcode	Oper. No.	Time
366 Headlight wiper			
Wiper blade replace each	1-	36601	4
Motor replace	1-	36602	31
Complete linkage remove-install	1-	36603	42
Complete linkage disassembly and assembly incl defective parts replace (incl remove-install)	1-	36604	81
Relay replace each	1-	36605	6
366 Headlight washers			
Motor, see windshield washer	1-		
Nozzle replace each	1-	36606	11

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381 Instruments				
Speedometer repl (rem-inst)		67–69	38108	20
		70–	38108	30
Combined instrument repl (rem-inst)		70–	38139	10
Temp gage repl		67–69	38114	10
Temp gage repl (combined instrument out)		70–	38133	10
Fuel gage repl (rem-inst)		67–69	38104	20
Fuel gage repl (rem-inst) (combined instrument out)		70–	38137	10
381 Clock				
Repl (rem-inst)		67–	38124	10
Rem		67–	38184	10
Inst		67–	38186	10
Install new clock, see 931				
381 Speedometer drive and cable				
Cable complete repl		67–	38140	50
Inner wire repl		67–	38142	20
Inner wire clean and grease		67–	38144	30
Pinion in gearbox repl		67–	38146	30
Cable nuts, lead-seal		70–	38150	60
382 Transmitters				
Oil pressure switch repl		67–	38202	20
Oil pressure switch repl (eng out)		67–	38203	5
Water temp switch repl		67–	38230	20
383 Seat belt warning switch				
Seat switch repl		74–	38302	10
Buckle with switch repl		74–	38304	10
Switch at handbrake lever repl		74–	38306	20
Warning lamp repl		74–	38308	5

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	Modelcode	Oper. No.	Time
381 Instrument			
Instrument unit replace (remove-install)	0–	38139	13
Fuel gauge replace (remove-install)	5–9	38104	23
Fuel gauge replace (remove-install), instrument unit out	0–	38104	10
Temperature gauge (fluid type) replace (no testing)	5–6	38136	34
Temperature gauge replace	7–9	38114	9
Temperature gauge replace, instrument unit out	0–	38114	11
Temperature gauge testing in car	5–6	38160	25
Temperature gauge testing, out	5–6	38175	15
Speedometer replace (remove-install)	5–9	38108	24
Speedometer replace (remove-install)	0–	38108	30
Speedometer remove	5–9	38198	9
Speedometer remove	0–	38198	11
Speedometer install	5–9	38188	18
Speedometer install	0–	38188	22
382 Speedometer drive			
Cable assembly replace	5–	38212	46
Inner wire replace	5–	38208	24
Inner wire clean and lubricate	5–	38210	30
Pinion (in gearbox) replace	5–	38232	30
Cable nuts lead-seal	0–	38214	58
382 Transmitters			
Oil pressure switch replace	7–	38202	17
Water temperature switch replace	6–	38230	17

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Transmission, rear axle 4

411 Clutch

412 Clutch control

432 Transmission control

471 Gearbox

473 Differential and crownwheel-and-pinion

475 Universal joints

477 Rear axle

	Modelcode	Oper. No.	Time
411 Clutch 2-stroke			
Pressure plate assembly, clutch disc and release bearing replace (incl engine remove-install)	5–6	41120	212x
Pressure plate assembly and clutch disc replace (engine out)	5–6	41105	47
Pressure plate assembly and clutch disc remove-install excl clean (engine out)	5–6	41107	23
Pressure plate assembly recondition (engine out)	5–6	41118	85
Pressure plate assembly (out) recondition	5–6	41175	56
Clutch release levers adjust (engine out)	5–6	41173	17
Clutch release bearing replace (engine out)	5–6	41121	9n
Clutch release bearing and clutch shaft seal replace (engine out)	5–6	41119	17x
Clutch shaft seal replace (release bearing out)	5–6	41111	13n
Clutch lining replace (clutch disc out)	5–6	41171	25
Clutch shaft replace (power unit out)	5–6	41115	34
Clutch housing replace (power unit out)	5–6	41103	94
Release bearing play adjust	5–6	41123	5
411 Clutch V4			
Pressure plate assembly, clutch disc and release bearing replace (incl power unit remove-install and install in/remove from stand)	7–0	41120	369x
Pressure plate assembly, clutch disc and release bearing replace (incl power unit remove-install and install in/remove from stand)	1–	41120	380n
Pressure plate assembly, clutch disc and release bearing replace (power unit out, install in/remove from stand)	7–	41125	91n
Pressure plate assembly and clutch disc replace (power unit separated)	7–	41105	43
Pressure plate assembly and clutch disc remove-install excl clean (power unit separated)	7–	41107	20
Pressure plate assembly (out) recondition	7–	41175	31
Release bearing replace (power unit out)	7–	41127	40n
Release bearing and clutch shaft seal replace (power unit separated)	7–	41119	17x
Clutch shaft seal replace (release bearing out)	7–	41111	13n
Clutch lining replace (clutch disc out)	7–	41171	25
Clutch release plate replace (power unit separated)	7–	41129	8n
Clutch shaft replace (power unit out)	7–	41115	45x
Clutch housing replace (power unit out)	7–	41103	105x
Release bearing play adjust	7–	41123	5

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Replaces page	Date	Edition	Page
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	Modelcode	Oper. No.	Time
412 Clutch control			
Master cylinder replace (remove-install), incl bleeding	5–8	41240	36
Master cylinder replace (remove-install), incl bleeding	9–	41240	34
Master cylinder (out) recondition	5–	41231	25
Pressure hose replace, incl bleeding	5–	41246	14
Pressure hose replace, excl bleeding	5–	41239	5
Slave cylinder replace (remove-install), incl bleeding	5–	41244	13
Slave cylinder replace (remove-install), excl bleeding	5–	41227	7
Slave cylinder (out) recondition	5–	41215	15n
Bleeding master and slave cylinders	5–	41225	10
432 Gearshift control			
Gear shift lever housing disassembly, greasing and assembly (incl remove-install)	5–	43234	30
Gear shift joint, replace	5–	43208	32
Gear positions (steering column), adjust	5–	43215	10
Gear positions (steering column) and turn stop adjust	5–	43214	21n

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471–1 ed. 2 and 471–2 ed. 2	September 1976	3	471–1

	Typ / Type / Typ	Årsmodell / Year model / Baujahr	Oper.nr / Oper.no / Arbeitsgang	Tid / Time / Zeit
471 Gearbox				
Rem-inst (repl) complete, incl rem-inst power unit [1]		67–70	47132	340
		71–	47132	350
	Rhd	67–70	47132	370
	Rhd	71–	47132	380
Rem-inst (repl) complete (power unit out)		67–	47141	60
Rem complete (power unit out)		67–	47133	40
Inst complete (power unit out)		67–	47139	30
Cover rem-inst (power unit out)		67–	47144	20
Cover and/or driver shaft repl (power unit out)		67–	47198	40
End cover rem-inst (incl rem-inst top cover) (power unit out)		67–	47158	70
End cover repl (incl rem-inst top cover) (power unit out)		67–	47156	90
Needle rollers in inner universal joint rem-inst, clean and grease, per removed bearing unit		67–	47535	10
1) Supplementary work to gearbox complete remove-install				
A Layshaft rem-inst, incl repl main and layshaft rear bearings		67–	47117	250
B Main and layshaft rem-inst, incl repl rear bearings		67–	47113	280
C Dismantle, check and assemble (excl diff and freewheel) and repl main and layshaft rear bearings		67–	47173	360
Dismantle, check and collect together parts for recond gearbox		67–	47175	220
D All bearings repl (excl diff and clutch shaft brgs)		67–	47171	490
E Freewheel complete repl (rem-inst)		67–	47101	50
F Layshaft friction wheel repl		67–	47193	80
G Fit new gaskets and seals to gearbox complete (incl rem-inst clutch hsg)		67–	47153	90
Extras:				
To B and C: Main shaft and/or front bearing repl		67–	47155	20
To A, B, C, D, E, F and G: Clutch shaft and/or bearing repl		67–	47181	20
To C: 4th gear and/or front pinion shaft bearing repl		67–	47317	20
To B, C, D and E: Freewheel (removed) recond		67–	47103	20
To A, B, C, D, F and G: Cover and/or operating rod repl		67–	47179	20
To A, B, C, D, F and G: Clutch housing repl		67–	47119	30
To A, B, C, D and G: Selector shafts rem-inst		67–	47105	5

1st and 2nd speed synchronizer rings are mounted on the layshaft,
3rd and 4th are mounted on the main shaft

1st and 2nd speed gears are mounted on the layshaft
3rd and 4th speed gears are on the main shaft and pinion shaft

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Typ Type Typ	Årsmodell Year model Baujahr	Oper.nr Oper.no Arbeitsgang	Tid Time Zeit

1st and 2nd speed synchronizer rings are mounted on the layshaft,

3rd and 4th are mounted on the main shaft

1st and 2nd speed gears are mounted on the layshaft

3rd and 4th speed gears are on the main shaft and pinion shaft

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471 Gearbox	Typ / Type / Typ	Årsmodell / Year model / Baujahr	Oper.nr / Oper.no / Arbeitsgang	Tid / Time / Zeit
Rem-inst (repl) compl, incl power unit rem-inst[1]		67–70	47132	340
Rem-inst (repl) compl, incl power unit rem-inst[1]	Rhd	67–70	47132	370[n]
Rem-inst (repl) compl, incl power unit rem-inst[1]		71–	47132	350
Rem-inst (repl) compl, incl power unit rem-inst[1]	Rhd	71–	47132	380[n]
Rem-inst (repl) compl (power unit out)		67–	47141	60
Rem compl (power unit out)		67–	47133	40
Inst compl (power unit out)		67–	47139	30
Cover rem-inst (power unit out)		67–	47144	20
Cover and/or driver shaft repl (power unit out)		67–	47198	40
End cover rem-inst (incl rem-inst top cover) (power unit out)		67–	47158	70
End cover repl (incl rem-inst top cover) (power unit out)		67–	47156	90
Rem-inst needle rollers in inner universal joint, rem-inst, clean and grease, per bearing		67–	47535	10
1) Supplementary work to gearbox complete remove-install				
A. Layshaft rem-inst, incl layshaft and main shaft rear bearing repl		67–	47117	250[x]
B. Layshaft and main shaft rem-inst, incl rear bearings repl		67–	47113	280[x]
C. Disassemble, check and assemble (excl diff and freewheel) incl layshaft and mainshaft rear bearings repl		67–	47173	360[x]
Dissassemble, check and collect together parts for reconditioned gearbox		67–	47175	220
D. All bearings replace (excl. diff gearings and clutch shaft bearing)		67–	47171	490[n]
E. Freewheel repl compl (rem-inst)		67–	47101	50
F. Layshaft friction wheel repl		67–	47193	80
G. Fitting new gaskets and seals to gearbox compl incl clutch housing rem-inst		67–	47153	90
Extras				
to B and C: main shaft and/or front bearing repl		67–	47155	20
to A, B, C, D, E, F and G: clutch shaft and/or bearing repl (clutch housing off)		67–	47181	20
to C: 4th speed gears and/or front pinion shaft bearing repl		67–	47317	20
to B, C, D and E: freewheel (off) recond		67–	47103	20
to A, B, C, D, F and G: Cover and/or operating rod repl (cover off)		67–	47179	20
to A, B, C, D, F and G: clutch housing repl		67–	47119	30[n]
to A, B, C, D and G: selector shafts rem-inst (end cover off)		67–	47105	5

1st and 2nd speed synchronizer rings are placed on the layshaft, 3rd and 4th are placed on the main shaft
1st and 2nd speed gears are placed on the layshaft
3rd and 4th speed gears are on the main shaft and the pinion shaft

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473 Differential and crownwheel-and-pinion

	Typ Type Typ	Årsmodell Year model Baujahr	Oper nr Oper.no Arbeitsgang	Tid Time Zeit
Diff rem-inst (incl rem-inst power unit)		67–70	47314	410
		71–	47314	420
Diff rem-inst (gearbox complete off)		67–	47316	90
Diff bearings repl (diff out)		67–	47315	50
Diff bearings repl, in conj with cwp repl		67–	47345	30
Diff gears and pinion repl (diff out)		67–	47329	30
Diff housing repl (diff out)		67–	47331	100
Diff housing repl, in conj with cwp repl		67–	47333	40
Cwp repl, add to 47173 dismantle, check		67–	47313	170
Cwp repl, add to 47171 all bearings repl		67–	47335	70
Cwp backlash adj (before 10,000 km) (diff out)		67–	47311	30
Pinion shaft front bearing repl, add to 47173 dismantle, check		67–	47317	20
Pinion shaft rear bearing repl (gearbox complete off)		67–	47312	270
Pinion shaft rear bearing repl, add to 47173 dismantle, check		67–	47319	80
Pinion shaft rear bearing repl, in conj with pinion shaft repl		67–	47321	5

Where adjustments of pinion position and final gear backlash are to be made, time for two readjustments is allowed for.

NOTE: Cwp = crownwheel and pinion

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473 Differential and crownwheel-and-pinion

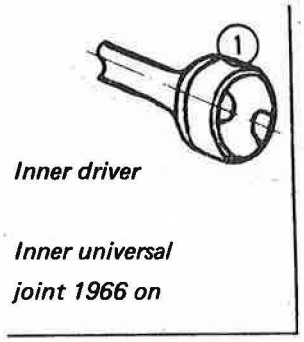
	Typ Type Typ	Årsmodell Year model Baujahr	Oper.nr Oper.no Arbeitsgang	Tid Time Zeit
Diff rem-inst incl rem-inst power unit		67–70	47314	410X
Diff rem-inst incl rem-inst power unit		71–	47314	420X
Diff rem-inst (compl gearbox off)		67–	47316	90
Diff bearings repl (diff off)		67–	47315	50
Diff bearings repl, in conjunction with cwp repl		67–	47345	30
Diff gears and pinion repl (diff off)		67–	47329	30
Diff housing replace, (diff off)		67–	47331	100
Diff housing repl, in conjunction with cwp repl		67–	47333	40
Cwp repl, add to 47173 disassemble, check		67–	47313	170
Cwp repl, add to 47171, all bearings repl		67–	47335	70
Crownwheel/pinion backlash adj (before 10000 km) (diff out)		67–	47311	30
Pinion shaft front bearing repl, add to 47173 disassemble, check		67–	47317	20
Pinion shaft rear repl (compl gearbox off)		67–	47312	270
Pinion shaft rear bearing repl, add to 47173 disassemble, check		67–	47319	80
Pinion shaft rear bearing repl, in conjunction with pinion shaft repl		67–	47321	5

Where adjustments of pinion position and final gear backlash are to be made, time for two readjustments is allowed for.

NOTE: Cwp = Crownwheel/pinion

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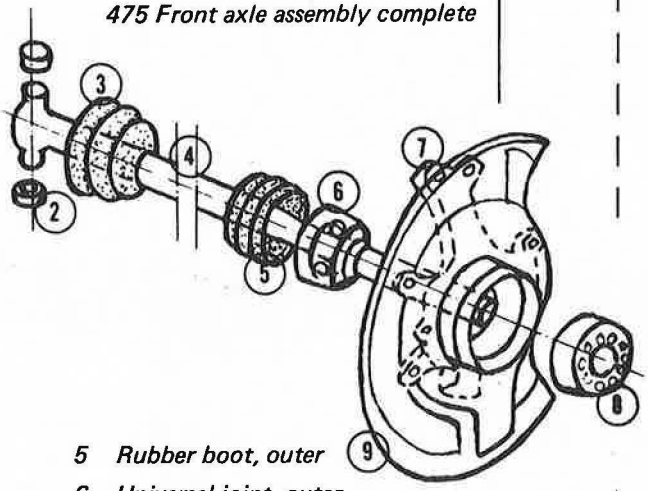
475 Front axle assembly complete



Inner driver

Inner universal joint 1966 on

475 Front axle assembly complete



1	*Socket*	5	*Rubber boot, outer*
2	*Needle roller bearing*	6	*Universal joint, outer*
3	*Rubber boot, inner*	7	*Steering knuckle*
4	*Inner driveshaft*	8	*Bearing*
		9	*Shield*

	Typ / Type / Typ	Årsmodell / Year model / Baujahr	Oper.nr / Oper.no / Arbeitsgang	Tid / Time / Zeit
Remove-install, 1 side		67–	47582	100
Remove-install, 1 side (wheel off)		67–	47586	90
Remove-install, 2 sides		67–	47584	190
Remove, 1 side		67–	47574	60
Remove, 2 sides		67–	47578	100
Install, 1 side		67–	47576	50
Install, 2 sides		67–	47580	100

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	Typ / Type / Typ	Årsmodell / Year model / Baujahr	Oper.nr / Oper.no / Arbeitsgang	Tid / Time / Zeit
731 Coil springs (front)				
Repl 1		65–	73104	60X
Repl 1 (wheel off)		65–	73105	50X
Repl 2		65–	73102	100X
Repl 2 (wheels off)		65–	73115	90X
732 Coil springs (rear)				
Repl 1		65–	73202	30
Repl 1 (wheel off)		65–	73203	20
Repl 2		65–	73206	50
Repl 2 (wheels off)		65–	73215	30
Stop straps, repl 1		65–	73204	20
Stop straps, repl 2		65–	73212	40
Stop straps, repl each (wheel off)		65–	73201	10

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475 Front axle assembly complete

475 Front axle assembly complete

Inner driver

Inner universal joint 1966 on

1	*Socket*	5	*Rubber boot, outer*
2	*Needle roller bearing*	6	*Universal joint, outer*
3	*Rubber boot, inner*	7	*Steering knuckle*
4	*Inner driveshaft*	8	*Bearing*
		9	*Shield*

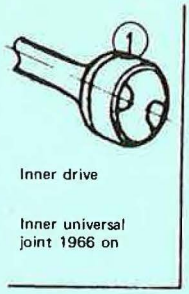
	Typ Type Typ	Årsmodell Year model Baujahr	Oper.nr Oper.no Arbeitsgang	Tid Time Zeit
Rémove-install, 1 side		67–	47582	100
Remove-install, 1 side (wheel off)		67–	47586	90
Remove-install, 2 sides		67–	47584	190
Remove, 1 side		67–	47574	60
Remove, 2 sides		67–	47578	100
Install, 1 side		67–	47576	50
Install, 2 sides		67–	47580	100

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475–2 edn 1 475–3 edn 1	February 1976	2	475–2

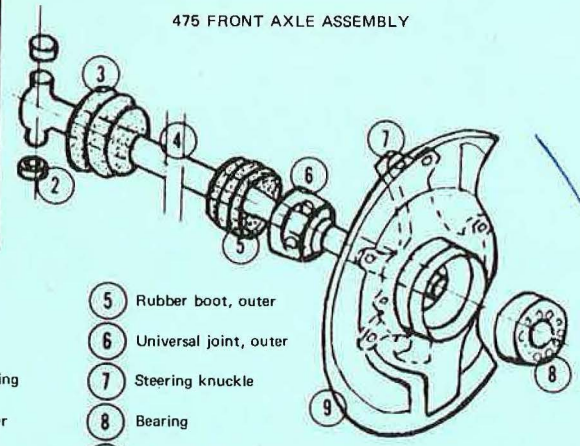
	Typ / Type / Typ	Årsmodell / Year model / Baujahr	Oper.nr / Oper.no / Arbeitsgang	Tid / Time / Zeit
475 Universal joints, outer				
Dismantle, clean, check, assemble and grease (= replace complete joint), 1 side		67–	47541	70
Dismantle, clean, check, assemble and grease (= replace complete joint), 2 sides		67–	47543	120
Additional to above operations:				
Rubber boot replace, 1 side		67–	47569	5
Driveshaft and rubber boot replace, per side		67–	47549	20
Front wheel bearings remove-install, clean and grease (= replace), per side		67–	47573	20
Rubber boot replace. To be fitted over driveshaft, no replacement of grease in outer UJ, per side.		67–	47575	20
Rubber boot replace, incl replace grease in outer UJ, per side.		67–	47577	50
Remove-install front axle assembly, outer UJ, bearing and rubber boot. Including clean and grease 1 side		67–	47579	200
475 Universal joints, inner				
Rem-inst, replace grease in inner driver and replace sealing ring, 1 side		67–	47524	60
Ditto, 2 sides		67–	47534	120
Rem-inst, replace grease in inner driver and replace sealing ring, 1 side (front axle assembly lowered or off)		67–	47521	30
Ditto, 2 sides		67–	47527	60
Rubber boot replace, LH side (front axle assembly lowered)		67–	47581	10
Rubber boot replace, RH side (front axle assembly lowered)		67–	47583	20
Sleeve on inner driver remove-install/replace, each (driver off)		67–	47559	10
Sealing ring in clutch housing replace, per side (driver off).		67–	47523	10
Sealing ring in clutch housing replace, both sides (power unit out)		67–	47529	20
Filling inner driver with grease, 1 side (in car)		67–	47556	20
Filling inner driver with grease, 2 sides (in car)		67–	47558	40
Needle roller bearing caps replace, 1 side (front axle assembly lowered or off)		67–	47555	5
Needles in needle roller bearing cap, clean and grease, per bearing (front axle assembly lowered or off)		67–	47535	10

Rem-inst front axle assembly, see page 475–1

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475 FRONT AXLE ASSEMBLY



1. Socket
2. Needle roller bearing
3. Rubber boot, inner
4. Inner drive shaft
5. Rubber boot, outer
6. Universal joint, outer
7. Steering knuckle
8. Bearing
9. Shield

475 Front axle assembly complete

	Modelcode	Oper. No.	Time
Front axle assembly remove-install 1 side	5	47582	90[n]
Front axle assembly remove-install 1 side (wheel off)	5	47586	80[n]
Front axle assembly remove-install 2 sides	5	47584	165[n]
Front axle assembly remove-install 2 sides (wheels off)	5	47588	152[n]
Front axle assembly remove-install 1 side	6	47582	98[n]
Front axle assembly remove-install 1 side (wheel off)	6	47586	88[n]
Front axle assembly remove-install 2 sides	6	47584	179[n]
Front axle assembly remove-install 2 sides (wheels off)	6	47588	166[n]
Front axle assembly remove-install 1 side	7–	47582	103[n]
Front axle assembly remove-install 1 side (wheel off)	7–	47586	94[n]
Front axle assembly remove-install 2 sides	7–	47584	188[n]
Front axle assembly remove-install 2 sides (wheels off)	7–	47588	175[n]
Front axle assembly remove 1 side	5	47574	55
Front axle assembly remove 2 sides	5	47578	92
Front axle assembly assembly remove 1 side	6	47574	58
Front axle assembly assembly remove 2 sides	6	47578	99
Front axle assembly assembly remove 1 side	7–	47574	59
Front axle assembly assembly remove 2 sides	7–	47578	101
Front axle assembly assembly install 1 side	5	47576	46
Front axle assembly assembly install 2 sides	5	47580	81
Front axle assembly assembly remove 1 side	6	47576	50
Front axle assembly assembly remove 2 sides	6	47580	90
Front axle assembly assembly remove 1 side	7–	47576	54
Front axle assembly assembly remove 2 sides	7–	47580	97[x]

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	Modelcode	Oper. No.	Time
475 Universal joint outer			
Dismantle, clean, check, assemble and grease (replace complete joint) 1 side[1]	5–	47541	66[n]
Dismantle, clean, check, assemble and grease (replace complete joint) 2 sides[1]	5–	47543	124[n]
Add to 47451 and 47543 for replacement of rubber boot per side	5–	47569	6[n]
Add to 47541 and 47543 for replacement of drive shaft and rubber boot per side	5	47549	12[n]
Add to 47541 and 47543 for replacement of drive shaft and rubber boot per side	6–	47549	21[n]
Add to 48541 and 47543 remove-install, clean and grease bearing one side	5–	47573	23[n]
Rubber boot replace (to be fitted over drive shaft, no replacement of grease in outer joint) per side[1]	5	47575	6[n]
Rubber boot replace (to be fitted over drive shaft, no replacement of grease in outer joint) per side[1]	6–	47575	15[n]
Rubber boot replace (incl replacement of grease in outer joint) per side[1]	5–	47577	54[n]
Front axle assembly complete, outer joint, bearings and rubber boot remove-install incl clean and grease, one side	5	47579	182[n]
Front axle assembly, outer joint, bearings and rubber boot remove-install incl clean and grease one side	6	47579	189[n]
Front axle assembly, outer joint, bearings and rubber boot remove-install incl clean and grease one side	7–	47579	195[n]
[1] Front axle assembly off. Time for remove-install front axle assembly, see previous page.			
475 Universal joint, inner (rubber ring type)			
Remove-install, disassemble, clean and reassemble, replace sealing ring 1 side	5	47524	73
Remove-install, disassemble, clean and reassemble, replace sealing ring 2 sides	5	47534	130
Remove-install, disassemble, clean and reassemble, replace sealing ring (front axle assembly lowered or off) 1 side	5	47521	43
Remove install, disassemble, clean and reassemble, replace sealing ring (front axle assembly, lowered or off) 2 sides	5	47527	78
Sealing ring in clutch housing replace per side	5	47522	57[n]
Sealing ring in clutch housing replace (inner joint off) per side	5	47523	9[n]
Sealing ring in clutch housing replace (front axle assembly lowered or off) per side	5	47525	17[n]
Disassembly, cleaning, checking and reassembly (inner joint off) each	5	47571	26
475 Universal joint, inner (needle roller bearing type)			
Remove-install, replace grease in inner driver and replace sealing ring 1 side	6–	47524	63[n]
Remove-install, replace grease in inner driver and replace sealing ring 2 sides	6–	47534	116[n]
Remove-install, change grease in inner driver and replace sealing ring (front axle assembly lowered or off) 1 side	6–	47521	32[n]
Remove-install, change grease in inner driver and replace sealing ring (front axle assembly lowered or off) 2 sides	6–	47527	58[n]

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	73–01–02	1	475–3

	Modelcode	Oper. No.	Time
Rubber boot replace (front axle assembly lowered) LH	6–	47581	13
Rubber boot replace (front axle assembly lowered) RH	6–	47583	22
Sleeve on inner driver remove-install (replace) (inner driver off) one	6–	47559	11n
Sleeve on inner driver remove-install (replace) (inner driver off) two	6–	47561	18n
Sealing ring in clutch housing replace (inner driver off) per side	6–	47523	9n
Filling inner driver with grease (in car) 1 side	6–	47556	22n
Filling driver with grease (in car) 2 sides	6–	47558	35n
Needle rollers in inner joint bearings clean and grease (front axle assembly lowered or off) 1 side	6–	47553	20n
Needle rollers in inner joint bearings clean and grease (front axle assembly lowered or off) per bearing	6–	47535	12n
Universal joint bearings replace (front axle assembly lowered or off) 1 side	6–	47555	6n

477 Rear axle

	Modelcode	Oper. No.	Time
Remove complete	5–	47774	108
Install complete	5–	47776	120
Rear axle tube replace	5–	47706	349
Rubber bushing, rear axle (axle off) replace	5–	47702	53
Side link and/or bushing replace 1 side	5–	47704	57
Check toe-in/out total both wheels with Saab tool	5–	47724	9n
Check toe-in/out (tracking check) 1 side	5–	47726	24n
Check toe-in/out (tracking check) 2 sides	5–	47728	37n
Check wheelbase	5–	47730	9n
Check camber 1 side	5–	47732	20n
Check camber 2 sides	5–	47734	28n
Check toe-in/out (tracking) and camber 1 side	5–	47736	25n
Check toe-in/out (tracking) and camber 2 sides	5–	47738	41n
Check toe-in/out (tracking), camber and total camber both wheels (optical) 2 sides	5–	47740	44n

Wheel bearings see 774

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Brakes 5

510 Braking system, general

511 Brake shoes

512 Brake linings

515 Brake drums

516 Brake discs

517 Brake pads

521 Master cylinder

522 Brake lines

523 Wheel cylinders, brake housings (calipers)

524 Brake pedal bracket

541 Brake servo

551 Parking brake

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	73–01–02	1	510–1

Braking systems general

	Modelcode	Oper. No.	Time
Road and parking brake adjust	5–0	51002	16[x]
Road and parking brake adjust	1–	51002	20[n]
Road and parking brake adjust (car raised)	5–0	51003	11
Road and parking brake adjust (car raised)	1–	51003	15[n]
Lining thickness front and rear, check, incl brakes adjust	5–6	51004	68[n]
Lining thickness front and rear, check, incl brakes adjust	7–0	51004	36[n]
Lining thickness front and rear, check, incl brakes adjust	1–	51004	40[n]
Lining thickness front and rear, check, incl brakes adjust (wheels off)	5–6	51005	46[n]
Lining thickness front and rear, check, incl brakes adjust (wheels off)	7–0	51005	13[n]
Lining thickness front and rear, check, incl brakes adjust (wheels off)	1–	51005	18[n]
Extra to 51004 and –05 for checking brake lines at wheels and in engine compartment	5–6	51007	9[n]
Extra to 51004 and –05 for checking brake lines at wheels and in engine compartment	7–	51007	6[n]
Check brake lines in passenger compartment floor (incl remove-install mats/carpets and panels)	5–7	51009	15[n]
Pressure testing (foot force for approx 1 min with pressure gauge)	5–	51011	12

Bleeding

At 2 wheels, manual pumping (on lift)	5–	51021	18[n]
At 2 wheels, manual pumping (on trestles)	5–	51023	21[x]
At 2 wheels, bleeding equipment (on lift)	5–	51025	20[n]
At 2 wheels, bleeding equipment (on trestles)	5–	51027	23[n]
At all wheels/brake fluid replace (on lift)	5–	51029	26[n]
At all wheels/brake fluid replace (on trestles)	5–	51031	33[n]
Extra for bleed nipple replace, each	5–	51033	4[n]

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	Modelcode	Oper. No.	Time
511 Brake shoes (front, front + rear)			
Front, replace (remove-install) both sides	5–6	51102	95
Front, replace (remove-install) both sides (wheels off)	5–6	51103	77
Front, replace both sides (drums off)	5–6	51105	43[n]
Front, remove-install per side (drum off)	5–6	51107	18[n]
Replace all (remove-install)	5–6	51130	195
Replace all (remove-install) wheels off	5–6	51131	167[n]
Replace all (remove-install) drums off	5–6	51133	100[n]
Wheel cylinders, see 523–			
511 Brake shoes (rear)			
Replace (remove-install) both sides	5–0	51110	108[x]
Replace (remove-install) both sides	1–	51110	111[n]
Replace (remove-install) both sides (car raised)	5–0	51111	102[x]
Replace (remove-install) both sides (car raised)	1–	51111	107[n]
Replace (remove-install) both sides (wheels off)	5–0	51115	94[x]
Replace (remove-install) both sides (wheels off)	1–	51115	97[n]
Replace (remove-install) both sides (on inspection)	7–	51113	87[n]
Replace, both sides (drums off)	5–	51117	59[n]
Remove-install per side (drum off)	5–	51119	25[n]
Adjuster screw replace, per side (shoes off)	5–	51121	12[n]
Wheel cylinders, see 523–			
512 Brake linings			
Replace (riveting) on remove shoes, per pair	5–	51271	13
Eccentric grinding, first pair of shoes	5–	51289	8
Eccentric grinding, per additional pair	5–	51291	4

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515 Brake drums	Modelcode	Oper. No.	Time
Front remove-install, one side (wheel off)	5–6	51501	24[x]
Front remove-install, both sides	5–6	51502	57[n]
Front remove-install both sides (wheels off)	5–6	51503	43[n]
Front, replace, each (drum off)	5–6	51505	8
Rear, remove-install, one side (wheel off)	5–0	51511	26[x]
Rear, remove-install, one side (wheel off)	1–	51511	30[n]
Rear, remove-install one side (on inspection)	7–	51513	20[n]
Rear, remove-install, both sides	5–0	51514	57[n]
Rear, remove-install both sides	1–	51514	61[n]
Rear, remove-install both sides (car raised)	5–0	51515	53[n]
Rear, remove-install both sides (car raised)	1–	51515	55[n]
Rear, remove-install both sides (wheels off)	5–0	51517	43[n]
Rear, remove-install both sides (wheels off)	1–	51517	46[n]
Rear, remove-install both sides (on inspection)	7–	51519	36[n]
Rear, replace, each (drum and bearing off)	5–	51521	9[n]
Remove-install all	5–6	51530	105[x]
Remove-install all (wheels off)	5–6	51531	83[x]
Turning, first (drum off)	5–	51579	22[x]
Turning, others, each (drum off)	5–	51573	19[x]
Rear wheel bearings, see 774			
516 Brake disc			
Remove hub (with disc) each (pads out)	7–	51614	17[n]
Install hub (with disc) each (not install pads)	7–	51616	15[n]
Remove-install one hub (with disc) (pads out)	7–	51618	29[n]
Remove-install one hub (with disc) (brake housing off)	7–	51617	17[n]
Remove-install, two hubs (with disc) (pads out)	7–	51620	52[n]
Remove-install, two hubs (with disc) (brake housing off)	7–	51619	30[n]
Replace each (remove-install disc from/on hub), hub off	7–	51659	10[n]
Turning both sides, per disc (disc off)	7–	51671	65[n]
Grinding (rotary machine) first side (wheel off, for inside, brake housing off)	7–	51677	14[n]
Grinding (rotary machine) per other side (wheel off, for inside, brake housings off)	7–	51679	11[n]
Outer front wheel bearing seal replace each (hub off)	5–	77437	16
517 Brake pads			
Replace	7–	51710	56[x]
Replace (car raised)	7–	51711	52[n]

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	Modelcode	Oper. No.	Time
Replace (wheels off)	7–	51713	42[X]
Remove-install, per side (wheel off)	7–	51721	12[n]

All operations under 517–include cleaning the brake housing and lubricating the hinge bolt

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	Modelcode	Oper. No.	Time
521 Master cylinder			
Replace (remove-install) excl bleeding at wheel cylinders	5–8	52130	46^{x}
Replace (remove-install) excl bleeding at wheel cylinders	9–	52130	33^{x}
Recond (cyl off), Lockheed	5–0	52102	73^{x}
Recond (cyl off), Ate	1–	52102	45^{n}
Brake servo, see 541			
522 Brake lines			
All the times given are exclusive of bleeding			
At front wheels (between wheel cylinders) replace 1 (wheel off)	5–6	52230	14^{n}
At front wheels (between wheel cylinders) replace 2 (wheels off)	5–6	52232	24^{n}
Short at master cyl replace, each	5–	52204	9^{n}
LH long in engine compartment replace	5–	52206	14^{n}
RH long in engine compartment replace	5–	52208	24^{n}
Long in passenger compartment floor replace both	P5–7	52210	87
Long in passenger compartment floor replace both	H5–7	52210	92^{n}
Long in passenger compartment floor replace both (fittings remove)	5–7	52223	72^{n}
Long at cill replace both	P8–9	52210	61^{n}
Long at cill replace both	P0–	52210	66^{n}
Long at cill replace both	H8–	52210	61^{n}
Long at cill replace both (fittings removed)	8–	52223	31^{n}
At rear wheel replace each (wheel cyl off)	5–	52241	7^{n}
At rear wheel replace 1 (wheel off)	5–	52240	11
At rear wheel replace 2 (wheels off)	5–	52242	21^{n}
522 Brake hoses			
All the times given are exclusive of bleeding			
Front replace each (wheel cyl off)	5–	52219	14^{n}
Front replace 1 (wheel off)	5–	52218	22^{x}
Front replace 2 (wheel off)	5–	52224	42^{x}
Rear replace 1 (wheel off)	5–9,H0–	52216	20
Rear replace 1 (wheel off)	P0–	52216	26^{n}
Rear replace 2 (wheels off)	5–9,H0–	52220	33
Rear replace 2 (wheels off)	P0–	52220	39^{n}
Bleeding, see 510–			

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523 Wheel cylinders (drum brakes)

All the times given are for removed brake shoes and exclusive of bleeding

	Modelcode	Oper. No.	Time
Front replace first cylinder	5–6	52310	23[X]
Front replace other cylinders, each	5–6	52311	20
Front, gasket replace (incl honing) first cylinder	5–6	52313	28[X]
Front, gasket replace (incl honing) other cylinders, each	5–6	52315	15[X]
Rear, replace one side	5–	52320	22[X]
Rear, replace both sides	5–	52321	41[X]
Rear, gasket replace (incl honing) one side	5–	52323	25[X]
Rear, gasket replace (incl honing) both sides	5–	52325	47[X]

523 Brake housing (i.e. caliper) (disc brakes)

Remove-install (not brake hose) and suspend, one side (wheel off)	7–	52351	13[n]
Remove-install (not brake hose) and suspend, both sides (wheels off)	7–	52353	24[n]
Remove-install (not brake hose) and suspend, both sides incl pads replace	7–	52354	80[n]
Remove-install (not brake hose) and suspend, both sides incl pads replace (wheels off)	7–	52355	66[n]
Remove-install (replace) complete, 1 hsg (pads out, excl bleeding)	7–	52357	23[n]
Remove-install (replace) complete, 2 housings (pads out, excl bleeding)	7–	52359	43[n]
Remove-install, complete, 2 housings incl pads replace (excl bleeding)	7–	52360	98[n]
Remove-install, complete, 2 housings incl pads replace (wheels off,excl bleeding)	7–	52361	84[n]
Hinged bolt, yoke and/or brake cylinder remove-install (replace) 1 (complete brake housing off)	7–	52381	26[n]
Hinged bolt, yoke and/or brake cylinder remove-install (replace) 2 (complete brake housings off)	7–	52383	48[n]
Brake cyl remove-install (replace) 1 (complete brake hsg off)	7–	52385	5[n]
Brake cyl remove-install (replace) 2 (complete brake housings off)	7–	52387	8[n]
Piston seal and dust excluder replace 1 (brake cyl out)	7–	52391	15[n]
Piston seal and dust excluder replace 2 (brake cylinders out)	7–	52393	26[n]

Bleeding, see 510–

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	Modelcode	Oper. No.	Time
524 Pedal stand			
Remove (steering column out)	5–7	52477	11
Remove (steering column out)	8–	52477	17
Install (steering column out)	5–7	52479	18
Install (steering column out)	8–	52479	24
541 Brake servo			
Vacuum cyl (and master cyl) replace	9–	54104	66
Filter replace or remove-install and blow clean	9–0	54118	19
Non-return valve (in hose) replace	9–	54120	8
Vacuum hose replace	9–	54122	11
551 Parking brake			
Cable complete replace 1 side (wheel off)	P5–9	55109	66^{x}
Cable complete replace 1 side (wheel off)	P0–	55109	78^{n}
Cable complete replace 1 side (wheel off)	H5–0	55109	72^{x}
Cable complete replace 1 side (wheel off)	H1–	55109	76^{n}
Cable complete replace both sides (wheels off)	P5–9	55111	103^{n}
Cable complete replace both sides (wheels off)	P0–	55111	116^{n}
Cable complete replace both sides (wheels off)	H5–0	55111	109^{n}
Cable complete replace both sides (wheels off)	H1–	55111	113^{n}
Inner cable lubrication 1 side (wheel off)	P5–9	55113	43^{x}
Inner cable lubrication 1 side (wheel off)	P0–	55113	54^{n}
Inner cable lubrication 1 side (wheel off)	H5–0	55113	48
Inner cable lubrication 1 side (wheel off)	H1–	55113	53^{n}
Inner cable lubrication both sides (wheels off)	P5–9	55115	65^{n}
Inner cable lubrication both sides (wheels off)	P0–	55115	76^{n}
Inner cable lubrication both sides (wheels off)	H5–0	55115	72^{n}
Inner cable lubrication both sides (wheels off)	H1–	55115	75^{n}
Lever ratchet and/or ratcher rod replace	5–	55120	20^{n}
Lever replace (remove-install)	5–	55122	57^{n}
Remove-install 2 rear wheels (incl raise-lower car on list)	5–	55102	14^{n}
Remove-install 2 rear wheels (incl jacking rear of car up and down)	5–	55104	17^{n}

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Front assembly, steering 6

601 Wheel alignment

631 Ball joints, steering knuckle housing

632 Control arms (wishbones)

641 Steering wheel, steering column tube

642 Steering gear

643 Tie-rod ends

601 Front wheel alignment

	Check		Adjust			Modelcode	Oper. No.	Time
	Camber caster	Toe-in	Camber/Caster 1 side	Camber/Caster 2 sides	Toe-in			
With Saab tool		X				5–	60124	9
With Saab tool		X			X	5–	60126	22n
With rim-mounted instrument (optical)	X	X				5–	60102	31
With rim-mounted instrument (optical)	X	X			X	5–	60110	45n
With rim-mounted instrument (optical)	X	X	X		X	5–	60104	61
With rim-mounted instrument (optical)	X	X		X	X	5–	60108	74
With hub-mounted (magnetic) instrument	X					5–	60112	28
With hub-mounted instrument and Saab tool	X	X				5–	60130	35n
With hub-mounted instrument and Saab tool	X	X			X	5–	60132	48n
With hub-mounted instrument	X		X			5–	60114	45
With hub-mounted instrument and Saab tool	X	X	X		X	5–	60134	67n
With hub-mounted instrument	X			X		5–	60118	59
With hub-mounted instrument and Saab tool	X	X		X	X	5–	60138	81n
Turning angles, check (turntables)						5–	60127	3
King pin inclination check, when checking camber/caster						5–	60125	2n
Positioning the car on special place for wheel alignment operations						5–	60160	6
Steering wheel position adjustment, see 641 Steering wheel								

Turning angles vary with toe-in and cannot be adjusted

King Pin inclination (KPI) vary with camber angle and cannot be adjusted

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631 Ball joints

	Modelcode	Oper. No.	Time
Tighten upper, 1 side	5	63112	43
Tighten upper, 1 side	6–	63112	59
Tighten upper, 1 side (wheel off)	5	63111	33n
Tighten upper, 1 side (wheel off)	6–	63111	50n
Tighten lower, 1 side	5–	63114	42n
Tighten lower, 1 side (wheel off)	5–	63113	32n
Tighten upper and lower, 1 side	5	63102	62
Tighten upper and lower, 1 side	6–	63102	77
Tighten upper and lower, 1 side (wheel off)	5	63103	52n
Tighten upper and lower, 1 side (wheel off)	6–	63103	67n
Tighten, each (ball joint off)	5–	63101	6
Tighten, each (front axle assembly off)	5	63117	14
Replace upper 1 side	5	63134	67
Replace upper 1 side	6–	63134	81
Replace upper 1 side (wheel off)	5	63137	56n
Replace upper 1 side (wheel off)	6–	63137	70n
Replace lower 1 side	5–	63132	34
Replace lower 1 side (wheel off)	5–	63131	24n
Replace upper and lower 1 side	5	63128	86
Replace upper and lower 1 side	6–	63128	100
Replace upper and lower 1 side (wheel off)	5	63129	76n
Replace upper and lower 1 side (wheel off)	6–	63129	90n
Replace, each (front axle assembly off)	5–	63133	14
Replace rubber boot, lower, 1 side	5–	63150	43n
Replace rubber boot, lower, 1 side (wheel off)	5–	63151	33n
Replace rubber boot upper 1 side	5–	63152	39n
Replace rubber boot upper 1 side (wheel off)	5–	63153	30n
Replace rubber boots upper and lower 1 side	5–	63154	75n
Replace rubber boots upper and lower 1 side (wheel off)	5–	63155	65n
Replace rubber boots, each (front axle assembly off)	5–	63135	8

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	Modelcode	Oper. No.	Time
631 Steering knuckle housing			
Steering knuckle housing replace (incl cleaning and replacing seals) 1 side	5	63139	173n
Steering knuckle housing replace (incl cleaning and replacing seals) 1 side	6	63139	180n
Steering knuckle housing replace (incl cleaning and replacing seals) 1 side	7–	63139	193n
Add to 63139 for disassemble, clean, grease and reassemble outer UJ	5–	63143	25n
Add to 63139 for outer UJ rubber boot replace	5–	63145	6n
Steering arm replace 1 side	5–	63140	41n
Steering arm replace 1 side (front axle assembly off)	5–	63141	14n
Brake disc mud shield replace 1 side	7–	63160	65n
Brake disc mud shield replace 1 side (brake disc off)	7–	63161	11n
632 Control arms (wishbones)			
Upper replace, 1 side	5–	63216	117
Upper replace, 1 side (power unit out, car on trestles)	5–	63217	86
Upper replace, 2 sides	5–	63218	223
Upper replace, 2 sides (power unit out, car on trestles)	5–	63219	165
Lower replace, 1 side	5–	63208	83
Lower replace, 1 side (wheel off)	5–	63209	70
Upper and lower replace, 1 side	5	63212	224
Upper and lower replace, 1 side	6–	63212	239
Upper and lower replace, 1 side (wheel off)	5	63213	213
Upper and lower replace, 1 side (wheel off)	6–	63213	228
Upper and lower replace, 2 sides	5	63214	431
Upper and lower replace, 2 sides	6–	63214	458
Upper and lower replace, 2 sides (wheels off)	5	63215	415
Upper and lower replace, 2 sides (wheels off)	6–	63215	441

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	Typ Type Typ	Årsmodell Year model Baujahr	Oper.nr Oper.no Arbeitsgang	Tid Time Zeit
641 Steering wheel				
Replace		67–69	64104	10
		70–75	64104	20
		76–	64104	10
Steering wheel position adjust (= remove-install steering wheel)		67	64101	10
		68–69	64101	5
		70–75	64101	20
		76–	64101	5
641 Steering column stand				
Remove		67–	64174	40
Remove (power unit out)		67–	64123	30
Install		67–	64176	60
Install (power unit out)		67–	64125	50
Lower		67–	64178	10
Install after lowering		67–	64180	20
Steering wheel shaft replace (steering column stand out)		67–	64121	20
Steering wheel shaft bushings replace (steering wheel shaft out)		67–	64103	10

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	Modelcode	Oper. No.	Time
642 Steering gear (rack-and-pinion)			
Remove-install (replace)	5–8	64218	156
Remove-install (replace) incl remove-install brake servo	9–	64218	209[n]
Remove-install (replace) (power unit out, car on trestles)	5–	64211	70
Remove (power unit out, car on trestles)	5–	64201	41[n]
Install (power unit out, car on trestles)	5–	64205	35[n]
Recondition, locking washer type (out)	5–8	64275	112[x]
Recondition, locking pin type (out)	8–	64275	96[n]
Radial play, adjust in car	5–	64212	31[n]
Radial play, adjust in car (car on trestles, excl lubrication)	5–	64213	23[n]
Radial play, adjust (out)	5–	64223	11[n]
Axial and radial play, adjust in car	5–	64210	51
Axial and radial play, adjust in car (car on trestles, excl lubrication)	5–	64203	42
Axial and radial play, adjust (out)	5–	64221	19[n]
Ball joints adjust, locking washer type (out)	5–8	64207	57[n]
Ball joints adjust, locking pin type (out)	8–	64207	58[n]
Rubber boot replace, 1 side	5–	64238	65
Rubber boot replace 1 side (wheel off, excl lubrication and toe-in adjustment)	5–	64217	41
Rubber boot replace 2 sides	5–	64214	106
Rubber boot replace 2 sides (wheels off, excl lubrication and toe-in adjustment)	5–	64219	77
Rubber boot replace each (tie-rod end off)	5–	64215	22
643 Tie-rod ends			
Replace, 1 side	5–	64310	44
Replace, 1 side (excl toe-in adjust)	5–	64321	32[n]
Replace, 1 side (wheel off, excl lubrication and toe-in adjust)	5–	64313	19
Replace, 2 sides	5–	64348	68
Replace, 2 sides (excl toe-in adjust)	5–	64325	53[n]
Replace, 2 sides (wheels off, excl lubrication and toe-in adjust)	5–	64317	33
Rubber boot replace, 1 side (wheel off)	5–	64315	21
Rubber boot replace, 2 sides (wheels off)	5	64381	35

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Suspension, wheels 7

731 Coil spring suspension, front

732 Coil spring suspension, rear

761 Shock absorbers

771 Wheels

772 Tires

774 Hubs, bearings

	Modelcode	Oper. No.	Time
731 Coil springs (front)			
Replace 1	5–	73104	80
Replace 1 (wheel off)	5–	73105	68
Replace 2	5–	73102	146
Replace 2 (wheels off)	5–	73115	130
Remove 1	5–	73170	45
Remove 2	5–	73174	78
Install 1	5–	73172	45
Install 2	5–	73176	80
732 Coil springs (rear)			
Replace 1	5–	73202	28
Replace 1 (wheel off)	5–	73203	15
Replace 2	5–	73206	45
Replace 2 (wheels off)	5–	73215	28
Remove 1	5–	73274	15
Remove 2	5–	73270	23
Install 1	5–	73276	19
Install 2	5–	73272	29
Stop strap replace 1	5–	73204	22
Stop straps replace 2	5–	73212	35
Stop straps replace each (wheel off)	5–	73201	12

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761 Shock absorbers, front

	Modelcode	Oper. No.	Time
Replace 1	67–	76102	25
Replace 1 (wheel off)	67–	76111	14
Replace 2	67–	76122	41
Replace 2 (wheels off)	67–	76147	26
Shock absorbers rear 96			
Replace 1	P 67–	76104	31
Replace 1 (car raised)	P 67–	76141	22
Replace 2	P 67–	76124	47
Replace 2 (car raised)	P 67–	76145	39
Shock absorber, rear 95			
Replace 1	H 67–	76104	64
Replace 1 (wheel off)	H 67–	76141	50
Replace 2	H 67–	76124	114
Replace 2 (wheels off)	H 67–	76145	96
Check fluid level, top up if nec, 2 sides	H 67–	76150	24
Check fluid level, top up if nec, 2 sides (wheel off)	H 67–	76151	8
Shock absorbers front and rear			
Replace all	P 67–	76106	85
Replace all (car raised, front wheels off)	P 67–	76183	63
Replace all	H 67–	76106	152
Replace all (wheels off)	H 67–	67–76183	122
Shock absorber bushings			
Front, replace 1 side	67–	76130	22
Front, replace 1 side (wheel off)	67–	76131	12
Front, replace 2 sides	67–	76136	36
Front, replace 2 sides (wheels off)	67–	76137	22
Rear, replace 1 side	P 67–	76134	28
Rear, replace 1 side (car raised)	P 67–	76135	19
Rear, replace 2 sides	P 67–	76138	43
Rear, replace 2 sides (car raised)	P 67–	76139	34
Replace all	P 67–	76140	76
Replace all (car raised, front wheels off)	P 67–	76143	55

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	Modelcode	Oper. No.	Time
771 Wheels			
Using column lift: (man adjustment of arms)			
Rem-inst 1	67–	77152	10
Rem-inst 2	67–	77154	14
Remove-inst all	67–	77156	22
Change wheels supplied (summer/winter(2 incl cleaning removed wheels	67–	77158	28
Change wheels supplied (summer/winter) all incl cleaning removed wheels	67–	77160	47
Using trestles:			
Rem-inst 1	67–	77110	12
Rem-inst 2	67–	77112	17
Rem-inst all	67–	77122	28
Change wheels supplied (summer/winter) 2 incl cleaning removed wheels	67–	77128	32
Change wheels supplied (summer/winter) all incl cleaning removed wheels	67–	77108	52
Car raised:			
Rem-inst 1	67–	77101	6
Rem-inst 2	67–	77135	10
Rem-inst all	67–	77133	18
Change wheels supplied (summer/winter) 2 incl cleaning removed wheels	67–	77115	22
Change wheels supplied (summer/winter) all incl cleaning removed wheels	67–	77131	42
771 Wheel balancing (wheels off)			
1 wheel	67–	77175	19
2 wheels	67–	77148	34
4 wheels	67–	77179	68
Others, each	67–	77177	15
Extra cleaning of wheel inside (abnormal amount of grease) each	67–	77145	3
772 Tires (wheels off)			
Replace 1	67–	77210	26
Replace 2	67–	77247	48
Replace 4	67–	77249	96
Replace others, each	67–	77207	23
Fit to rim, 1st	67–	77212	13
Fit to rim, others, each	67–	77214	12

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	Modelcode	Oper. No.	Time
774 Front wheel bearing			
Replace (incl changing grease in outer UJ and sealing rings replace) 1 side	5	77404	176[n]
Replace (incl changing grease in outer UJ and sealing rings replace) 1 side	6	77404	184[n]
Replace (incl changing grease in outer UJ and sealing rings replace) 1 side	7–	77404	189[n]
Replace (incl changing grease in outer UJ and sealing rings replace) 2 sides	5	77408	328[n]
Replace (incl changing grease in outer UJ and sealing rings replace) 2 sides	6	77408	343[n]
Replace (incl changing grease in outer UJ and sealing rings replace) 2 sides	7–	77408	351[n]
Sealing ring, outer, replace per side	5–	77439	23[n]
Sealing ring, outer replace per side (brake drum/disc off)	5–	77437	16[x]
Add exchange of outer UJ rubber boot to replacement of bearing	5–	77449	6[n]
Front hub remove-install, see 516 Brake discs			
774 Rear wheel bearing			
Replace (remove-install) 1 side	5–0	77416	59[x]
Replace (remove-install) 1 side	1–	77416	63[n]
Replace (remove-install) 2 sides	5–0	77428	100[x]
Replace (remove-install) 2 sides	1–	77428	102[n]
Replace (remove-install) 1 side (wheel off)	5–0	77451	47[n]
Replace (remove-install) 1 side (wheel off)	1–	77451	51[n]
Replace (remove-install) 2 sides (wheels off)	5–0	77453	84[n]
Replace (remove-install) 2 sides (wheels off)	1–	77453	87[n]
Replace (remove-install) 1 side (brake drum off)	5–	77401	25
Replace (remove-install) 2 sides (brake drums off)	5–	77455	47[n]
Sealing ring replace 1 side (brake drum off)	5–	77405	4
Rear axle see 447			

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Body, heating and ventilation system

8

811 Floor

822 Hood lock

825 Front fenders

826 Rear fenders

831 Doors

834 Door locks and handles

834 Trunk lid or rear door

843 Windows

844 Window seals

851 Headlining

852 Seats and cushions

854 Heating and ventilation system

855 Safety belts

861 Bumpers

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804 Body sealing

	Typ Type Typ	Årsmodell Year model Baujahr	Oper.nr Oper.no Arbeitsgang	Tid Time Zeit
To find leak points, hose the body with water at the places indicated below				
Front section: windscreen, bulkhead, A-frames, front wheel arches		67–	80401	40
Doors, 2 sides		67–	80403	20
Rear section: rear of roof, rear window, rear axle tunnel, rear wheel arches, trunk lid or tailgate		67–	80407	30
Sealing. These operations relate to sealing where water leaks in at or collects at the positions indicated below				
Below instrument panel, carpets in front seat (incl seal windshield)		67–	80402	90
On and at sills, per side		67–	80404	30
Front carpet, wheel arches and bulkhead insulation, sill beadings		67–	80408	70
Door, door weatherstrip, lower edge of door trim, per door		67–	80410	110
Rear floor, under rear seat, bottom of side panels, rear axle panel cavities		67–	80416	80
Trunk floor, trunk lid (incl seal rear window)	P	67–	80414	80
Load space floor, rear floor, tailgate fixing (incl seal rear window)	H	67–	80414	110
Tailgate rubber seal to body and door	H	67–	80432	100
Rear floor space, fuel tank space		67–	80430	50
Side window		67–	80420	20
Rear window		67–	80422	30
Tailgate window	H	67–	80424	30
Windshield		67–	80426	30
Side window, front	H	67–	80428	20

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811 Floor (economy components)

	Floor section			Modelcode	Oper. No.	Time
	Front	Middle	Rear			
Floor section, replace, incl antirust treatment						
(floor exposed)	X			5–	81129	165ⁿ
(The combinations are for replacement on *one* side. For	X	X		5–	81131	290ⁿ
replacement on *two* sides the times for the appropriate com-	X		X	5–	81133	292ⁿ
binations must be added together)	X	X	X	5–	81135	421ⁿ
		X		5–	81137	184ⁿ
		X	X	5–	81139	310ⁿ
			X	5–	81141	169ⁿ
Basic time, remove-install parts to expose floor	X			5–9	81114	37ⁿ
(Time must only be taken for *one* combination, irrespective	X	X		5–9	81116	55ⁿ
of which or how many floor sections are replaced)	X		X	5–9	81118	68ⁿ
	X	X	X	5–9	81120	79ⁿ
The basic time for all operations except 81114 includes		X		5–9	81122	55ⁿ
time for remove-install seat belt (middle floor section) or		X	X	5–9	81124	75ⁿ
side link and rear wheel (rear floor section) *one* side.			X	5–9	81126	65ⁿ
For remove-install on both sides the time for operations	X			0–	81114	37ⁿ
81143 and 81121 must be added.	X	X		0–	81116	61ⁿ
	X		X	0–	81118	81ⁿ
	X	X	X	0–	81120	92ⁿ
		X		0–	81122	61ⁿ
		X	X	0–	81124	87ⁿ
			X	0–	81126	77ⁿ
Add to basic times						
Remove-install side link and rear wheel				5–	81121	10ⁿ
Remove-install seat belt				7–	81143	5ⁿ
Remove-install spare wheel				H5–	81145	5ⁿ
Remove-install alternator wiring				7–	81119	9ⁿ
Remove-install cover plate at seat guide				8–	81103	15ⁿ
Remove-install floor duct				1–	81147	9ⁿ
Remove-install wiring for heated seat				2–	81149	3ⁿ

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	Typ Type Typ	Årsmodell Year model Baujahr	Oper.nr Oper.no Arbeitsgang	Tid Time Zeit
815 Instrument panel				
Rem-inst (steering column stand off)		67–69	81533	110
		70–	81533	80
Rem (steering column stand off)		67–69	81555	40
		70–	81555	20
Inst (excl steering column stand)		67	81557	80
		68–69	81557	70
		70–	81557	60
Instruments and controls, transfer all (instrument panel off)		67	81561	50
		68–	81561	40
815 Safety padding				
Repl (steering column stand off)		67–	81565	110
Repl (instrument panel off)		67–	81567	50
Inst (instrument panel off)		67–	81569	30
815 Glove pocket				
Glove pocket lid repl		67–69	81562	10
		70–	81562	20
Glove pocket lid rem-inst		67–	81538	5
Glove pocket repl		67–	81564	10
Glove pocket lock repl		67–	81570	5
Grab handle repl		70–	81534	5

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	Modelcode	Oper. No.	Time
822 Hood lock			
Replace (remove-install)	5–8	82206	17
Replace (remove-install) (incl remove-install center grille)	9–	82206	17
Replace (remove-install) (front panel off)	5–	82203	7
Clean and relubricate (off)	5–	82209	10
Control cable complete (and hood lock) replace	5–8	82204	25
Control cable complete replace	9–	82204	13
Control cable complete replace (removed from front panel)	5–	82207	9
823 Front panel			
Remove-install complete	5–6	82306	40
Remove-install complete	7–8	82306	46
Remove-install complete	9–	82306	40
Center grille and/or emblem replace	5–8	82312	50
Center grille and/or emblem replace	9–	82312	8
Center grille and side grilles replace	9–	82304	20
825 Front fender (not damaged)			
Clean, antirust treat and paint fenders and contact surfaces between fender and body, incl remove-install both	5–	82592	231
Remove 1	5–	82570	21
Remove 2	5–	82588	37
Install 1	5–	82574	41
Install 2	5–	82590	75
Trim strip replace 1	5–	82550	28
Trim strip replace, each (wheel off)	5–	82551	19
Clean, antirust treat and paint front fender contact surfaces to body	5–	14121	37
Clean antirust treat and paint body contact surfaces to front fender	5–	14125	48
826 Rear fender (not damaged)			
Clean, antirust treat and paint fenders and contact surfaces between fender and body, incl remove-install both	5–	82692	414
Remove 1	5–	82670	46
Remove 2	5–	82688	84
Install 1	5–	82674	78
Install 2	5–	82690	141
Mud flap, each, replace	5–	82642	8
Clean, antirust treat and paint rear fender contact surfaces to body	5–	14123	55
Clean, antirust treat and paint body contact surfaces to rear fender	5–	14127	70
Trim strip replace, see front fender			

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	73–01–02	1	831–1

	Modelcode	Oper. No.	Time
831 Door (not damaged)			
Replace[1]	5–8	83104	238
Replace[1]	9–0	83104	245
Replace[1]	1–	83104	275
Remove	5–	83174	30
Install[2]	5–	83176	63
Adjust complete	5–	83132	59
Adjust at striker plate	5–	83112	7
831 Inner and outer door panel (not damaged)			
(Joining at lower part of door panel)			
Outer panel, lower, replace[1]	5–0	83130	310
Outer panel, lower, replace[1]	1–	83130	323
Outer panel, lower, replace (door off)[3]	5–0	83123	228
Outer panel, lower, replace (door off)[3]	1–	83123	242
Outer panel, lower and inner panel, replace[1]	5–8	83128	369
Outer panel, lower and inner panel, replace[1]	9–0	83128	377
Outer panel, lower and inner panel, replace[1]	1–	83128	392
Outer panel, lower and inner panel, replace (door off)[3]	5–8	83125	287
Outer panel, lower and inner panel, replace (door off)[3]	9–0	83125	295
Outer panel, lower and inner panel, replace (door off)[3]	1–	83125	309
831 Inner and outer door panels (not damaged)			
(Joining at upper part of door panel)			
Outer panel, replace[1]	5–0	83142	329[n]
Outer panel, replace[1]	1–	83142	359[n]
Outer panel, replace (door off)[3]	5–0	83127	249[n]
Outer panel, replace (door off)[3]	1–	83127	278[n]
Outer panel and inner panel replace[1]	5–8	83154	387[n]
Outer panel and inner panel replace[1]	9–0	83154	395[n]
Outer panel and inner panel replace[1]	1–	83154	409[n]
Outer panel and inner panel replace (door off)[3]	5–8	83129	307[n]
Outer panel and inner panel replace (door off)[3]	9–0	83129	315[n]
Outer panel and inner panel replace (door off)[3]	1–	83129	329[n]

1) Includes adjustment and antirust treatment

2) Includes adjustment

3) Includes antirust treatment

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	Modelcode	Oper. No.	Time
831 Door hinges			
Replace[1]	5–	83108	84
Replace 2 (same door)[1]	5–	83134	120
Replace each (door off)	5–	83121	22
831 Door stops			
Replace complete	5–	83106	46
Replace complete (trim off)	5–	83115	14
831 Window regulators			
Replace	5–	83152	46
Replace (trim off)	5–	83141	14
831 Door weather strips			
Door weather strip, body side replace	5–	83110	20
Door weather strip (channel mounted) replace	5–9	83114	23
Door weather strip (clip mounted) replace	9–	83114	7
Protective strip, replace	1–	83136	18
831 Door trim			
Remove	5–	83182	10
Replace	5–	83184	23
831 Rear view mirror			
Replace complete or glass	5–	83156	6

1) Includes adjustment

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	Typ Type Typ	Årsmodell Year model Baujahr	Oper.nr Oper.no Arbeitsgang	Tid Time Zeit
832 Trunk lid (Saab 96)				
Lock mechanism, repl	P	65–	83212	10
Lock cyl, repl	P	65–	83218	30
License plate lamp housing (handle), repl	P	65–	83226	20[n]
Trunk lid support, repl	P	65–	83220	10[n]
Weatherstrip, repl	P	65–	83208	50
Lock catch, adj	P	65–	83222	5
832 Rear door (Saab 95)				
Door lock, repl 1 side	H	65–	83212	40[n]
Door lock, repl 2 sides	H	65–	83234	40[n]
Lock cyl, repl	H	65–	83218	20
Latch (outer handle bushing), repl	H	65–	83216	40[n]
Inner handle, repl	H	65–	83228	10[n]
Outer handle, repl	H	65–	83230	20[n]
Door lift (stay), repl	H	65–	83232	70[n]
Weatherstrip, repl	H	65–	83208	150
Adj striker	H	65–	83222	10
Adj balance spring	H	65–	83224	20
834 Door locks (excluding adjust strikers)				
Repl		65–	83406	60
Repl (trim off)		65–	83411	30
834 Lock cylinders				
Repl		67–	83408	40
Repl (trim off)		65–	83417	30
Blow clean and lubricate all (incl trunk lid or rear door)		65–	83420	10
834 Door handles				
Outer, repl		65–	83404	20
Outer, repl (trim off)		65–	83403	20
Window regulator handle, repl		65–	83402	5
Striker plate, repl incl adj		65–	83410	20

For door adj, see 831

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	Modelcode	Oper. No.	Time
843 Windshield			
Replace excl rem-inst sealing strip from/on body	72–	84302	81
Replace incl replace sealing strip	67–	84304	95
Remove [1]	67–71	84374	24
Remove [1]	72–	84374	25
Install [1]	67–71	84376	59
Install [1]	72–	84376	73
Sealing [2]	67–	84388	32
843 Door window or window bracket			
Replace	67–	84306	74
Replace (trim off)	67–	84311	54
Replace (door window out)	67–	84371	34
843 Side window (96, non-opening)			
Replace incl cleaning sealing strip	P 67–	84310	58
Replace incl cleaning sealing strip	P 67–	84330	47
Remove [1]	P 67–	84378	12
Install [1]	P 67–	84380	36
Sealing [2]	P 67–	84392	20
843 Side window, front (95)			
Replace incl cleaning sealing strip	H 67–	84310	47
Replace incl replace sealing strip	H 67–	84330	39
Remove [1]	H 67–	84378	9
Install [1]	H 67–	84380	32
Sealing [2]	H 67–	84392	17

[1] Cleaning or replacement of sealing strip not included, see 844

[2] Sealing of window included in replacement or installation of window.

Does not include time for removal of glass debris inside car.

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	Modelcode	Oper. No.	Time
843 Side window, rear (95)			
Replace	H 67–	84320	39
Replace incl replace sealing strip	H 67–	84322	74
Remove	H 67–	84360	13
Install	H 67–	84362	26
Re-rivet lock bracket	H 67–	84366	101
Re-rivet lock bracket (window out)	H 67–	84367	65
Sealing	H 67–	84396	15
843 Rear window			
Replace incl cleaning sealing strip	P 67–	84312	114
Replace incl replace sealing strip	P 67–	84328	96
Remove [1]	P 67–71	84382	17
Remove [1]	72–	84382	19
Install [1]	P 67–71	84384	65
Install [1]	P 72–	84384	78
Sealing [2]	P 67–	84394	33
843 Tailgate window			
Replace incl cleaning sealing strip	H 67–	84312	80
Replace incl replace sealing strip	H 67–	84328	64
Remove [1]	H 67–	84370	13
Install [1]	H 67–	84372	48
Sealing [2]	H 67–	84394	26
843 All windows (excl door windows)			
Remove [1]	P 67–71	84332	53
Remove [1]	P 72–	84332	56
Remove [1]	H 67–71	84332	85
Remove [1]	H 72–	84332	86
Install [1]	P 67–71	84334	176
Install [1]	P 72–	84334	202
Install [1]	H 67–71	84334	198
Install [1]	H 72–	84334	211

[1] Cleaning or replacement of sealing strip not included, see 844

[2] Sealing of window included in replacement or installation of window.

Does not include time for removal of glass debris inside car.

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	Modelcode	Oper. No.	Time
844 Windshield sealing strip			
Replace in conj with rem-inst windshield (windshield out)	67–71	84403	25
Replace in conj with rem-inst windshield (windshield out)	72–	84403	17
Clean in conj with rem-inst windshield (windshield out)	67–	84415	15
844 Door window sealing strip			
Replace upper and rear	67–	84316	62
Replace upper and rear (door trim off)	67–	84301	44
Replace outer	67–	84364	58
Replace outer (door trim off)	67–	84333	39
844 Side window sealing strip (96)			
Replace in conj with rem-inst side window (side window out)	P 67–	84421	8
Clean in conj with rem-inst side window (side window out)	P 67–	84419	10
844 Sealing strip for side window (95)			
Front, replace in conj with rem-inst side window (side window out)	H 67–	84421	8
Front, clean in conj with rem-inst side window (side window out)	H 67–	84419	8
Rear, remove excl sealing strip (side window out)	H 67–	84461	14
Rear rem incl sealing strip (side window out)	H 67–	84465	23
Rear install (side window out) [1]	H 67–	84463	28
844 Rear window sealing strip			
Replace in conj with rem-inst rear window (rear window out)	P 67–71	84401	23
Replace in conj with rem-inst rear window (rear window out)	P 72–	84401	13
Clean in conj with rem-inst rear window (rear window out)	P 67–	84427	17
844 Sealing strip for tailgate window			
Replace in conj with rem-inst tailgate window (window out)	H 67–	84401	17
Clean in conj with rem-inst tailgate window (window out)	H 67–	84427	13

[1] Incl sealing

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851 Headlining

	Modelcode	Oper. No.	Time
Replace incl rem-inst windows and cleaning sealing strips	P 67–71	85180	440
Replace incl rem-inst windows and cleaning sealing strips	P 72–	85180	473
Replace	H 67–	85180	54
Remove incl windows and cleaning sealing strip	P 67–71	85182	143
Remove incl windows and cleaning sealing strip	P 72–	85182	149
Remove	H 67–	85182	20
Install incl windows	P 67–71	85184	295
Install incl windows	P 72–	85184	321
Install	H 67–	85184	37

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	Typ / Type / Typ	Årsmodell / Year model / Baujahr	Oper.nr / Oper.no / Arbeitsgang	Tid / Time / Zeit
851 Headlining				
Replace	P	65–66	85180	40
Replace incl rem-inst windows, clean sealing strips	P	67–71	85180	440
	P	72–	85180	470
Replace	H	65–	85180	50
852 Front seat				
Rem-inst		65–	85230	5
Adj seat rails per seat		65–	85228	10
Backrest cover replace (seat out)		65–	85238	20
Seat cover replace (seat out)		65–	85236	30
Backrest cover and seat cover replace (seat out)		65–	85268	40
852 Heated seat cushion				
Heated cushions and thermostat check		72–	85298	20
Heated cushion, backrest, replace incl check		72–	85292	40
Heated cushion, seat, replace incl check		72–	85294	50
Thermostat replace incl check		72–	85296	40
852 Rear seat				
Backrest rem-inst	P	65–69	85232	5
	P	70–	85232	10
	H	65–	85232	5
Seat cushion rem-inst	P	65–69	85234	5
	P	70–	85234	10
	H	65–	85234	5
Backrest and seat cushion, rem-inst	P	65–69	85264	10
	P	70–	85264	20
	H	65–	85264	5
Backrest cover replace (backrest cushion out)	P	65–66	85244	50
	P	67–70	85244	70
	P	71–	85244	90
Backrest cover or seat cover replace (cushion out)	H	65–	85262	60
Seat cover replace (seat cushion out)	P	65–66	85242	40
	P	67–	85242	60
Backrest cover and seat cover replace (cushions out)	P	65–66	85266	80
	P	67–70	85266	120
	P	71–	85266	140
Load floor plate on seat cushion replace (cushion out)	H	65–	85252	20
Load floor plate on backrest cushion repl (cushion out)	H	65–	85254	20

	Typ / Type / Typ	Årsmodell / Year model / Baujahr	Oper.nr / Oper.no / Arbeitsgang	Tid / Time / Zeit
852 Extra seat or spare wheel cover				
Backrest cushion rem-inst	H	65–75	85270	10
Seat cushion rem-inst	H	65–75	85272	5
Backrest cushion and seat cushion rem-inst	H	65–75	85274	10
Backrest cover or seat cover repl (cushion out)	H	65–75	85256	40
Handle for backrest cushion, seat cushion or spare wheel cover repl	H	65–	85226	10
Load floor plate repl (cushion out)	H	65–75	85260	20
853 Seat belts				
Front RH or LH repl		67–73	85302	10
		74–	85302	40
Rear RH or LH repl		68–74	85304	20
		75–	85304	30
Rear center repl		75–	85306	10
Flap lock repl, each		74–	85308	10
Bracket lock plastic sheath and spring repl per belt		68–73	85310	20
854 Heating and ventilation system				
Heat exchanger repl	2T	65–66	85404	60
		67–	85404	100
Heat exchanger repl (power unit out)		67–	85473	60
Heater valve repl	2T	65–66	85452	80
		67–	85452	110
Heater valve repl (power unit out)		67–	85471	70
Fan motor complete repl		65–	85406	10

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	Typ / Type / Typ	Årsmodell / Year model / Baujahr	Oper.nr / Oper.no / Arbeitsgang	Tid / Time / Zeit
853 Seat Belts				
Front RH or LH replace		67–73	85302	10
		74–	85302	40
Rear RH or LH replace		68–74	85304	20
		75–	85304	30
Rear center replace		75–	85306	10
Flap lock replace, each		74–	85308	10
Stirrup lock plastic cover and spring replace, per belt		68–73	85310	20
854 Fresh Air Heater				
Remove (power unit out)		67–	85421	10
Install (power unit out)		67–	85403	20
Fresh air duct replace		67–	85481	20
Fresh air duct replace (fresh air heater out)		67–	85423	5
Front cover replace (power unit out)		67–	85419	60
Front cover replace (fresh air heater out)		67–	85425	30
Front and rear covers replace (fresh air heater out)		67–	85427	40
Rear cover and fresh air duct replace (fresh air heater out)		67–	85429	20
Heat exchanger replace		67–	85404	60
Heat shut-off valve (and heat exchanger) replace		67–	85452	80
Fan motor complete replace		67–	85406	10
861 Bumpers				
Front or rear complete replace (not rear 95)		67–	86166	60
Rear complete replace	H	67–68	86166	130
	H	69–	86166	90
External panel replace (not rear 95) (overriders off)		67–	86171	10
External panel rear replace	H	67–	86104	30
Center panel replace (not rear 95)		67–	86118	30
Center panel rear replace	H	67–68	86158	80
	H	69–	86158	40
Overriders replace each (not rear 95)		67–	86106	20
Overrider, rear LH, replace	H	67–68	86102	40
Overrider, rear RH, replace	H	67–68	86154	60
Overriders, replace each	H	69–	86102	20
Rubber buffer, replace each (overriders off)		69–71	86127	10

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	Typ / Type / Typ	Årsmodell / Year model / Baujahr	Oper.nr / Oper.no / Arbeitsgang	Tid / Time / Zeit
861 Bumpers up to 75				
Front or rear complete repl (not rear 95)		65–75	86166	60
Rear complete repl	H	65–68	86166	130
	H	69–75	86166	90
Ext plate repl (not rear 95) (overriders off)		65–75	86171	10
Outer plate rear repl	H	65–75	86104	30
Center plate repl (not rear 95)		65–75	86118	30
Center plate rear repl	H	65–68	86158	80
	H	69–75	86158	40
Overriders repl, each (not rear 95)		65–75	86106	20
Overrider rear LH repl	H	65–68	86102	40
Overrider rear RH repl	H	65–68	86154	60
Overrider repl, each	H	69–	86102	20
Rubber buffer repl each (overriders off)		69–71	86127	10
861 Bumpers front 76–				
Trim tape repl		76–	86126	10
Rubber sheath repl incl rem-inst bumper		76–	86128	90
Cellular blocks (any number) on one side repl incl rem-inst bumper		76–	86132	70
Ditto in conj with rubber sheath repl		76–	86107	5
Cellular blocks (any no.) on two sides and/or center repl incl rem-inst bumper		76–	86134	100
861 Bumpers rear 76–				
Trim tape repl		76–	86126	10
Rubber sheath repl incl rem-inst bumper	P	76–	86130	90
	H	76–	86130	110
Cellular blocks (any no.) on one side repl incl rem-inst bumper	P	76–	86132	70
Ditto in conj with rubber sheath repl	P	76–	86107	5
Cellular blocks (any no.) on two sides and/or center repl incl rem-inst bumper	P	76–	86134	100
Cellular blocks (any no.) repl incl rem-inst bumper	H	76–	86136	90

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Accessories 9

921 Accessories, mechanical

931 Accessories, electrical

932 Heaters, engine, passenger compartment

952 Towbar

	Typ / Type / Typ	Årsmodell / Year model / Baujahr	Oper.nr / Oper.no / Arbeitsgang	Tid / Time / Zeit
921 Accessories (mechanical, installation when new)				
Headrests with cushions, per pair		69--	92122	20
Ski rack		67--	92204	20
Luggage rack (Saab original)	H	67--	92120	30
Luggage rack (Saab original)	P	67--	92120	20
Caravan towing mirrors, per pair		67--	92220	40
Cornering handle in glove box lid		67–69	92109	30
Protective net	H	67--	92113	80
Extra seat covers, front		67--	92244	10
Extra seat cover, rear	P	67--	92245	20
Extra seat covers front and rear	P	67--	92246	30
Spring stiffeners (rubber cones in rear springs)		67--	92110	70[n]
931 Accessories (electrical, installation when new)				
Cigarette lighter		67--	93106	30
Clock		68--	93132	20
Compressed-air horns with relay		68--	93152	90
Time-lag relay		68--	93146	40
Heating pad, driver's seat		67–71	93118	70[x]
Heating pad, passenger seat		67--	93120	90[x]
Heating pads, both seats		67–71	93122	160[x]
Rear window wiper (with washer)	H	67--	93154	280[n]
931 Auxiliary lamps (installation when new)				
One lamp (switched on when high beam is on)		69--	93162	90[x]
Two lamps (switched on when high beam is on)		69--	93159	130[x]
Two fog lamps (to be used instead of low beam)		69--	93168	140[n]
Addition to 93168 if the fog lamps are to be used together with high beam.		69--	93170	60[n]
Cable set with relay, making up, each		69--	93167	20
931 Radio (new installation, removal and transfer)				
New installation (glove box mounted)		67--	93148	220
New installation (in underslung cover)		70--	93148	70[n]
Removal (for transfer, glove box mounted)		67--	93140	60
Removal (for transfer, mounted in underslung cover)		70--	93140	20[n]
Installation compl (transfer, excl removal, mounted in glove box)		67--	93114	140
Installation compl (transfer excl removal, mounted in underslung cover)		70--	93114	80[n]
Transfer compl (from glove box to glove box)		67--	93142	200

Cont.

Cont.	Typ / Type / Typ	Årsmodell / Year model / Baujahr	Oper.nr / Oper.no / Arbeitsgang	Tid / Time / Zeit
Transfer compl (from glove box to underslung cover)		70--	93144	130[n]
Transfer compl (from underslung cover to underslung cover)		70--	93156	90[n]
Antenna, new installation (incl in 93148, 93114, 93142, 93144 and 93146)		67–	93178	20
Suppressor set (addition)		67–	93150	10[n]
932 Parking heater (Eberspächer)				
New installation (BL2ZW)		67–73	93244	470[x]
New installation (BL2ZW)		74--	93244	490[n]
Annual inspection (BL2ZW)		70–	93264	40
952 Towbar				
Towing ball with electrical socket, new installation	P	67–	95202	270
Towing ball with electrical socket, new installation	H	67–	95202	290

Supplement

	Refer. No.	Time
215 Transmission cover		
Replacement or repacking (in car)	21502	205
Gasket, transmission cover plate, replacement, add to 21502	21535	25
Fan bearing, replacement see 262		
215 Transmission gear		
Replacement all (incl. removal and install. power unit)	21510	460
Camshaft gear, replacement (in car)	21504	220
215 Camshaft		
Replacement (in car)	21542	555x)
Replacement (in car) removed cylinder heads	21521	275x)
216 Flywheel		
Flywheel, replacement (incl. removal and install. power unit)	41120 21621	395x)
Ring gear, replacement (incl. removal and install. power unit)	21604	410
Ring gear, replacement (removed flywheel)	21644	15x)
216 Crankshaft		
Replacement (incl. removal and install. power unit)	21628	700x)
216 Main bearings		
Replacement (inspection) all (incl. removal and install. power unit)	21620	570
Crankshaft seal ring, replacement (incl. removal and install. power unit)	21624	410
216 Connecting rod bearings		
Replacement (inspection) all (incl. removal and install. power unit)	21648	515

	Refer. No.	Time
Replacement (inspection) all (when replacing main bearings)	21653	105
217 Oil pan		
Replacement of gasket or oil pan (incl. removal and install. power unit)	21704	380
221 Oil pump		
Replacement (removal and install.) (incl. removal and install. power unit)	22110	390
Reconditioning (incl. removal and install. power unit)	22112	430
Reconditioning (removed)	22171	40
222 Oil filter		
Replacement of oil filter cartridge	22211	20
Oil pressure switch, see 382		
231 Carburetor (FoMoCo)		
Replacement (removal and install.) incl. cleaning air cleaner	23106	60
Disassembly, cleaning, reassembly and adjustment (incl. removal and install.)	23102	160
Cleaning, adjustment float level and idling (incl. removal and install of float chamber cover)	23136	85n)
Exhaust gases, **CO-contents, measurement and adjustment**	23150	15n)
232 Air filter		
Air filter cartridge, replacement	23211	15n)
233 Fuel pump		
Replacement	23312	40
Reconditioning (removed)	23380	40

	Refer. No.	Time
234 Fuel tank		
Replacement	23412	140[x)]
Filler tube, replacement	23421	40[x)]
Fuel gauge transmitter and/or gasket replacement	23418	35
Fuel tank cleaning (in car) incl. fuel pipes pump–carburetor	23478	125[n)]
251 Inlet manifold		
Replacement	25120	180
Gasket, replacement	25102	165
Final tightening	25122	20[n)]
252 Exhaust system		
Replacement cpl.	25222	160
Front muffler, replacement	25212	110
Front muffler and exhaust pipe replacement	25216	140
Rear muffler replacement	25210	70
Rear muffler and exhaust pipe replacement	25204	90
Exhaust pipe, replacement	25206	70
261 Radiator		
Replacement (incl. removal and install. of front plate)	26108	90
Expansion tank, replacement	26118	20
Cleaning the cooling system	26151	60[n)]
261 Radiator hoses		
Water hose, upper, replacement	26112	20[x)]
Water hose, lower, replacement (incl. removal and install. radiator)	26114	80[x)]

	Refer. No.	Time
Hoses pump–pipe (2 short), replacement	26134	50[n)]
Hoses pipe–cyl. block rear (2 short), replacement	26136	45[n)]
Hose thermostat–pump, replacement, (incl. removal and install. alternator)	26157	35[n)]
Heating system hoses, see 854		
262 Water pump		
Replacement (year model 1967–68)	26202	115[x)]
Replacement (from year model 1969)	26202	140[n)]
Reconditioning, add to 26202		
262 Thermostat		
Replacement	26298	75[x)]
Inspection, add to 26298	26273	25[n)]
262 Fan belt		
Replacement	26212	25[n)]
Fan belt tension, adjustment	26214	10[n)]
262 Fan blade		
Replacement (incl. removal and install. front plate)	26216	80
Replacement (radiator removed)	26227	25[x)]
262 Fan bearing		
Replacement	26210	230[x)]
Replacement (transmission cover removed)	26201	50[x)]

	Refer. No.	Time
311 Battery		
Replacement	31118	35
Starter motor cable, replacement	31108	30[x)]
Negative cable, replacement	31106	30[x)]
321 Alternator		
Replacement	32102	50
Reconditioning incl. test (removed)	32130	200
322 Voltage regulator		
Replacement	32204	25[x)]
331 Starter motor		
Replacement	33118	50
Operating solenoid, replacement (incl. removal and install.)	33110	60
Operating solenoid, replacement. Add to 33118	33179	15[n)]
Disassembly, cleaning, inspection reassembly and test run (removed)	33128	100
340 Ignition lock		
Lock cylinder replacement (incl. lock cyl. in door)	34010	80[x)]
341 Ignition coil		
Replacement	34104	20
Test in car	34106	20[n)]
342 Distributor		
Replacement incl. adjustment of dwell angle and ignition setting	34206	60

	Refer. No.	Time
Reconditioning (removed) incl. test run in bench	34236	120[x)]
Distributor cover and/or ignition cables, replacement	34220	30
344 Spark plugs		
Spark plugs, replacement	34406	35[n)]
Spark plugs, cleaning and adjustment	34408	45[n)]
352 Headlights		
Insert (rectangular), replacement 1 side	35136	30[x)]
Inserts (rectangular) replacement both	35136	50[x)]
Adjustment both sides	35102	25
Switch, replacement	35142	25[x)]
Control relay for headlight flasher, replacement	35182	20
351 Tail light		
Replacement cpl. (95 and 96)	35126	40
Bulb and/or glass, replacement (95 and 96)	35118	20
351 Licence-plate light		
Bulb and/or glass, replacement	35122	20
351 Dome lamp		
Lamp body assy., replacement (removal and install.)	35190	25[x)]
Door switch, replacement	35183	15[x)]
351 Control lamps		
Bulb, replacement (irrespective of position)	35138	25[x)]

	Refer. No.	Time
361 Direct. indicator/parking light		
Replacement assy. 1 side	36124	30
Bulb and/or glass,replacement	36106	10
361 Flasher		
Replacement	36102	10
361 Direction indicator switch		
Replacement (incl. removal and install. steering wheel)	36108	25
362 Signal horn		
Replacement 1 side	36202	25
Replacement both	36216	40
363 Windshield wiper		
Motor assy. , replacement (removal and install.)	36302	40
Switch replacement	36340	25
Rubber section, replacement, per each	36306	15
363 Windshield washer		
Electric motor (in cover), replacement	36336	20
364 Stop light contact		
Replacement	36408	20
364 Brake warning contact		
Replacement	36430	20
366 Headlight wiper		
Wiper blade, replacement per each	36601	15[n)]

	Refer. No.	Time
Motor, replacement	36602	45n)
Cpl. linkage, replacement	36603	55n)
Cpl. linkage, disassembly, assembly, incl. replacement of defective parts (incl. removal and install.)	36604	95n)
Relay, replacement per each	36605	15n)
366 Headlight washers		
Motor, replacement	36336	20n)
Jet, replacement per each	36606	25n)
381 Instrument panel		
Glove box lid, replacement (no painting)	38162	30x)
Glove box, replacement	38164	30x)
Glove box lock, replacement	38170	20
Handle on glove box lid, replacement	38134	20n)
Clock, replacement (removal and install.)	38124	30n)
Clock, cigarette lighter new installation, see 931		
381 Instrument		
Combined instrument assy., replacement (removal and install.) (mod. 1970–)	38139	30n)
Fuel gauge (removal and install.) (mod. 1967–69)	38104	35
Fuel gauge, replacement (removal and install.) Combined instrument removed. Add. to 38139	38104	25n)
Temperature gauge, replacement (mod. 1967–69)	38114	20
Temperature gauge, replacement. Combined instrument removed. Add to 38139	38114	10n)
Speedometer, replacement (removal and install.) (mod. 1967–69)	38108	40x)
Speedometer, replacement (removal and install.) (mod. 1970–)	38108	45n)

	Refer. No.	Time
382 Speedometer drive		
Cable assy., replacement	38212	60
Wire, replacement	38208	40[x)]
Wire, cleaning and lubrication	38210	40[x)]
Gear (inside gearbox), replacement	38232	45
382 Gauge transmitter		
Oil pressure switch, replacement	38202	30[x)]
Temperature transmitter, replacement	38230	30[x)]

	Refer. No.	Time
411 Clutch		
Replacement (= clutch disc, replacement) incl. removal and install. power unit	41120	400
Reconditioning incl. removal and install. power unit	41104	425n)
Clutch disc lining, replacement. Add to 41120.	41171	25x)
Clutch housing, replacement. Add to 41120	41131	100n)
Clutch shaft seal (and release bearing), replacement. Add to 41120	41119	25x)
412 Clutch operation		
Master cylinder, replacement (incl. bleeding)	41240	50
Master cylinder, reconditioning (removed). Add to 41240	41231	25x)
Slave cylinder, replacement (incl. bleeding)	41244	30
Slave cylinder, reconditioning (removed) . Add to 41244	41212	20x)
Pressure hose, replacement (incl. bleeding)	41246	30
Release bearing, replacement (incl. removal and install. power unit)	41216	350
Clutch shaft, replacement. Add to 20138	41213	45n)
Bleeding master–slave cylinder	41255	15n)
Clutch clearance, adjustment	41223	10n)
432 Gear box control		
Gear lever housing, disassembly, greasing and reassembly (incl. removal and install.)	43234	40
Gear shift joint, replacement	43208	45
Gear positions (steering column stand), adjustment	43215	20n)
(See p. 641–6 in Service Manual)		
471 Gear box		
Gear box, replacement (removal and install.) cpl. incl. removal and install. power unit	47132	375x)

	Refer. No.	Time
Gear box cover, removal and install. Add to 20138	47144	25[n)]
Gear box cover and/or driver shaft, replacement. Add to 20138	47198	45[n)]
End cover, replacement incl. shimming and removal and install. gear box cover. Add to 20138	47156	90[n)]
Reconditioning (excl. differential and freewheel)	47132 47137	935
Reconditioning incl. replacement crown wheel–pinion shaft	47132 47137 47335	990
Synchronizing rings, replacement all (incl. removal and install. power unit)	47132 47173 47183	750[x)]
Gear set 4th gear and/or front pinion shaft bearing, replacement	47132 47173 47317	750[x)]
Clutch shaft and/or bearing, replacement. Add to reconditioning	47181	20[n)]
Freewheel cpl., replacement (removal and install.). Add to 47132	47101	45[n)]
Freewheel, reconditioning. Add to 47101	47103	25[n)]
Repacking of gear box cpl. (incl. removal and install. of clutch housing). Add to 47132	47153	100[n)]
473 Differential and pinion shaft–crown wheel		
Differential bearings, replacement (incl. removal and install. power unit)	47314 47315	450[x)]
Differential bearings, replacement. Add to reconditioning gear box incl. pinion shaft–crown wheel, replacement	47345	30[n)]
Differential side gears and -diff. pinions, replacement (incl. removal and install. power unit)	47314 47329	430[x)]
Differential housing, replacement (incl. removal and install. power unit)	47314 47331	500[n)]
Differential housing, replacement. Add to reconditioning gear box incl. replacement pinion shaft–crown wheel	47333	35[n)]
Rear pinion shaft bearing, replacement (incl. removal and install. power unit)	47132 47312	685[x)]

	Refer. No.	Time
474 Seal rings in clutch housing		
Replacement 1 side	47412	75x)
Replacement both sides	47438	105x)
475 Universal joints, inner		
Reconditioning 1 side (not replacement of rubber bellow, but incl. replacement of seal ring in clutch housing)	47524	110x)
Reconditioning both sides (not replacement of rubber bellow, but incl. replacement of seal rings in clutch housing)		185x)
Bellow, replacement 1 side	47526	150x)
Bellow, replacement both sides	47536	270x)
Driver, replacement per each	47520	95
475 Universal joint, outer		
Bellow 1 side, replacement (incl. disassembly and cleaning of joint)	47512	150
Bellow both sides, replacement (incl. disassembly and cleaning of joint)	47514	270
477 Rear axle		
Removal and install. cpl.	47774	230
Rear axle tube, replacement	47706	365
Rubber bushing rear axle bearing bracket, replacement. Add to 47774	47702	55
Side link and/or bearing, replacement 1 side	47704	75
Wheel bearings, see 774		

	Refer. No.	Time
511 Brake system		
Footbrake, adjustment	51134	25n)
Footbrake and parking brake, adjustment	51116	30n)
Bleeding, see 520		
512 Brake shoes		
Rear 1 wheel, replacement	51262	80n)
Rear 2 wheels, replacement	51212	125n)
Brake linings (drilled), replacement of 2 on removed brake shoes. Add to 51262 and 51212	51271	15n)
Radial grinding of 2 brake shoes	51215	10n)
Radial grinding, remaining per pair	51219	5n)
Inspection of wear of linings incl. adjustment	51280	40n)
Wheel cylinders, see 523		
515 Brake drums		
Brake drum rear, replacement 1 side, incl. removal and install. bearings	51514 51503	90
Brake drum, turning (removed drum)	51579	20n)
516 Brake discs		
Replacement 1 side	51614	80
Replacement both sides	51616	125
517 Brake pads		
Brake pads, replacement both sides	51710	60n)
520 Bleeding		
Safety inspection (pressure test, inspection of brake lines and -linings)	52038	60n)

	Refer. No.	Time
Bleeding the entire system	52008	40[x)]
Bleeding 2 wheels (front or rear)	52011	30[x)]
521 Master cylinder		
Replacement (removal and install.) incl. bleeding	52130	80[x)]
Reconditioning, add to 52130	52195	75
522 Brake lines		
Brake hose front,replacement 1 side (incl. bleeding)	52218	60
Brake hose front, replacement both sides (incl. bleeding)	52224	85[n)]
Brake hose rear, replacement 1 side (incl. bleeding)	52216	55
Brake hose rear, replacement both sides (incl. bleeding)	52220	80[n)]
Brake pipes inner long, replacement both (incl. bleeding)	52210	135[n)]
Brake pipe rear L.H., replacement (incl. bleeding)	52228	55
Brake pipe rear R.H., replacement (incl. bleeding)	52222	75
Pressure test	52209	20[n)]
Stop light contact, see 364		
Bleeding, see 520		
523 Wheel cylinders		
Rear, replacement per each	51262 52309	105
Piston seals, replacement per cylinder	51262 52377	90[n)]
Rear, honing incl. replacement of seals per each (incl. removal and install. brake shoes)	51262 52397 52377	100[x)]

	Refer. No.	Time
523 Brake housing (disc brakes)		
Replacement cpl. 1 side incl. bleeding	52302	70
Replacement cpl. both sides incl. bleeding	52304	95[n)]
Hinge bolt, replacement. Add to 52302	52369	10[n)]
Brake cylinder cpl., replacement 1 side (incl. bleeding)	52336	75
Brake cylinder cpl. replacement both sides (incl. bleeding)	52338	115[n)]
Brake cylinder, seals (and pads), replacement 1 side (incl. bleeding)	52332 52011	100[x)]
Brake cylinder, seals (and pads), replacement both sides (incl. bleeding)	52363 52011	125[n)]
524 Pedal stand		
Pedal stand, replacement (removal and install.) steering column removed see 641	52477 52479	60[n)]
541 Power brake unit (from year model 1969)		
Power brake cylinder (and master cylinder), replacement (incl. test run)	54104	100
Air filter, replacement	54118	35[n)]
Non-return valve (on hose), replacement	54120	15
Vacuum hose, replacement	54122	15
551 Parking brake		
Cable cpl. 1 side, replacement	55116	90
Cable cpl. both sides, replacement	55114	135
Inner cable, cleaning and lubrication (incl. removal and install.) 1 side	55126	70[n)]

	Refer. No.	Time
601 Front wheel alignment		
Inspection all angles (camber, caster, KPI, toe-in and wheel turning angle)	60102	50
Inspection all angles incl. adjustment camber, caster 1 side (incl. adjustment of toe-in)	60132	75[x)]
Inspection all angles incl. adjustment camber, caster both sides (incl. adjustment of toe-in)	60104	90[x)]
601 Toe-in		
Inspection and adjustment	60124 60129	35[n)]
631 Ball joints		
Replacement, lower 1 side	63132	50
Replacement, upper 1 side	63134	95
Replacement upper and lower 1 side	63128	115
Replacement upper and lower both sides	63130	200
Adjustment, upper 1 side	63112	75[n)]
Adjustment upper and lower 1 side	63102	
631 Steering knuckle housing		
Reconditioning 1 side (incl. disassembly, cleaning and regreasing joint)	63116	215[x)]
Reconditioning both sides (incl. disassembly, cleaning and regreasing joints)	63118	390[x)]
632 Control arms		
Replacement lower 1 side	63208	100
Replacement lower and upper 1 side	63212	255
Replacement lower and upper both sides	63214	475

	Refer. No.	Time
641 Steering wheel		
Replacement incl. adjustment of position	64104	30
Steering wheel position, adjustment	64101	20
641 Steering column		
Replacement (removal and install.)	64174 64176	115 n)
Steering wheel shaft, replacement incl. removal and install. steering column	64174 64176 64121	135 n)
Bushings steering wheel shaft, replacement	64174 64176 64121 64103	145 n)
642 Steering gear		
Replacement cpl. incl. adjustment toe-in and steering wheel position	64218	170
Reconditioning (incl. removal and install.)	64222	300
Rubber bellow, replacement 1 side	64238	80
Rubber bellow, replacement both sides	64214	130
Axial and radial clearance, adjustment in car	64210	60 x)
643 Tie rod end		
Replacement 1 side, incl. toe-in adjustment	64310	60
Replacement both sides incl. toe-in adjustment	64348	80
Rubber seal, replacement 1 side	64315	40
Rubber seal, replacement both sides	64381	55

	Refer. No.	Time
731 Coil spring (front)		
Replacement 1 side	73104	95
Replacement both sides	73102	160
Spring support, replacement per each. Add to 73104 and 73102		20[n)]
732 Coil spring (rear)		
Replacement 1 side	73202	45
Replacement both	73206	60
Stop strap, replacement 1 side	73204	35[n)]
Stop strap, replacement both sides	73212	50[n)]
761 Shock absorber (96)		
Front replacement 1 side	76102	40
Front replacement both sides	76122	55
Rear replacement 1 side	76104	45
Rear replacement both sides	76124	60
All,replacement	76106	100
761 Shock absorbers (95)		
Front replacement 1 side	76102	40
Front replacement both sides	76122	55
Rear replacement 1 side	76104	75
Rear replacement both sides	76124	120
All, replacement	76106	160

	Refer. No.	Time
771 Wheel balancing		
1 wheel incl. removal and install.	77130	40[n)]
2 wheels incl. removal and install.	77104	60[n)]
4 wheels incl. removal and install.	77150	105[n)]
4 wheels, removed	77179	80[n)]
774 Front wheel bearings		
Replacement 1 side		205
Replacement both sides		365
Outer seal ring, replacement	51614 77437	90
774 Rear wheel bearings		
Replacement 1 side	77416	70
Replacement both sides	77428	115
Seal ring, replacement per each	51514 77405	50[n)]

	Refer. No.	Time
822 Hood lock		
Replacement (removal and install.) (incl. removal and install. centre grill)	82206	30
Wash and lubricate. Add to 82206	82209	10n)
Control cable, replacement	82204	30
823 Front plate		
Replacement (removal and install.) cpl.	82306	55n)
Centre grill and/or emblem, replacement (model 1967–68)	82312	65n)
Centre grill and/or emblem, replacement (from model 1969–)	82312	20n)
Centre grill and side grills, replacement	82304	35n)
825 Front fender (not damaged)		
Replacement (removal and install.) 1 side	82570 82574	75n)
Replacement (removal and install.) both sides	82588 82590	126n)
Moulding, replacement 1 side	82550	45n)
Cleaning, rust preventive treatment, painting contact surfaces between fender and body, removal and install. both sides	82592	240n)
826 Rear fender (not damaged)		
Replacement (removal and install.) 1 side	82670 82674	140n)
Replacement (removal and install.) both sides	82688 82690	240n)
Moulding, replacement 1 side	82550	45n)
Mud guard, replacement per each	82642	20n)
Cleaning, rust preventive treatment, painting contact surfaces between fender and body, removal and install. both sides	82692	425n)

	Refer. No.	Time
831 Door (sheet metal intact)		
Replacement (incl. transfer all components)	83104	265[n)]
Door trim assy. replacement	85105	35[n)]
Door seal, lower, replacement	83114	40[n)]
Door seal on body side, replacement	83110	55[n)]
Hinge, 1 side, replacement	83108	75[n)]
Door stop assy., replacement	83106	45[n)]
Window regulator, replacement	83152	45[n)]
Rear view mirror cpl. or glass, replacement per each	83143	15[n)]
834 Door lock and -handle		
Door lock, replacement	83406	50
Lock cylinder, replacement	83408	45
Outer door handle, replacement	83404	30
Striker plate, replacement	83410	25[x)]
Striker plate, adjustment	83457	20[n)]
Crank, window regulator or inner handle, replacement per each	83413	20[n)]
834 Trunk lid (96)		
Lock mechanism, replacement	83412	25[x)]
Lock cylinder, replacement	83418	55[x)]
Seal, replacement	83208	65[x)]
834 Rear door (95)		
Lock cylinder, replacement	83418	30
Sealing list (screwed on), replacement	83208	160

	Refer. No.	Time
843 Glass		
Windshield, replacement (removal and install.) or weatherstrip for windshield, replacement	84302	115
Rear window, replacement (removal and install.) or weatherstrip for rear window, replacement (96)	84382 84384	120
Rear window (95), replacement	84370 84372	85
Door window, replacement (incl. glass retainer)	84306	80
Side window, replacement (removal and install.) (on 95 front side window)	84378	65x)
Rear side window, replacement (95)	84362	55n)
Rear side window, riveting of lock (95)	84366	80n)
844 Seal strips for glass		
Replacement rear and lower for door window	84316	70n)
Replacement outer for door window	84364	55n)
851 Ceiling lining		
Replacement (removal and install.) incl. all windows except for door windows (96)	84332 84334 85182 85184	385n)
Replacement (removal and install.) (95)	85182 85184	55n)
852 Front seat		
Seat cover, replacement	85236	80
Back cover, replacement	85238	85
Seat frame, replacement	85228	110n)
Back rest frame, replacement	85240	85n)
852 Rear seat		
Seat cover, replacement (96)	85242	100x)
Back cover, replacement (96)	85244	105x)
Insul. board on seat, replacement (96)	85246	180n)

	Refer. No.	Time
Insul. board on back rest, replacement (96)	85248	195n)
Back- or seat cover, replacement (95)	85262	95n)
Insul. board on seat cushion or back rest, replacement (95)	85250	200n)
Box, seat cushion, replacement (95)	85252	60n)
Luggage floor assy. back cushion, rear seat, replacement (95)	85254	55n)
852 Extra seat (freight space) (95 only)		
Seat- or back cover, replacement	85256	75n)
Insul. board, replacement	85258	85n)
Luggage floor assy., replacement	85260	30n)
854 Heating system		
Fresh-air intake, replacement	85481	30n)
Heat exchanger assy. replacement	85404	75
Water valve (and heat exchanger assy.), replacement	85452	90
Fan unit, replacement	85406	25x)
854 Heating system hoses		
Replacement per each	85411	20n)
Replacement all	85415	30n)
Radiator hoses, see 261		
861 Bumper		
Overrider, replacement per each	86106	30x)
Rubber protection, replacement	86127	20n)
Centre plate, replacement (96)	86118	45n)
Outer plate, replacement, incl. removal and install. overrider (96)	86171	45n)
Outer plate, rear, replacement (95)	86120	40n)

	Refer. No.	Time
921 Accessories (mechanical, new installation)		
Exhaust pipe extension	92135	10n)
Headrest with cushions both sides	92122	30n)
931 Accessories (electrical new installation)		
Back up lights, two pcs. (circular with automatic switch)	93182	155n)
Cigarette lighter	93106	45n)
Clock	93132	35n)
931 Accessory headlamps		
Two, spot or fog lamps	93159	125n)
Two, spot and fog lamps	93164	140n)
931 Radio (new installation)		
New install. cpl.	93148	235n)
Aerial, new install. (incl. in 93148)	93178	40n)
Disturbance elimination kit new install. (incl. in 93148)	93131	35n)
932 Engine heater (Calix plug-in type)		
New installation	93254	80n)
932 Parking heater assy. (Eberspächer)		
New install. (BN 2S)	93244	450n)
New install. (BL 2 ZW)	93244	460n)
Annual inspection (BN 2S)	93262	46n)
Annual inspection (BL 2 ZW)	93262	55n)
Glow plug, replacement (BN 2S)	93266	20n)

	Refer. No.	Time
Glow plug, replacement (BL 2 ZW)	93266	20 n)
Fuel quantity, adjustment (BN 2S)	93260	35 n)
952 Towing device		
Towhook with plug connection, new install. (95 and 96)	95202	285 n)