

SAAB

Metodbeskrivningar (ackordsmeddelanden)

Repair Work Descriptions Methodenbeschreibungen Tillsyner, Underhåll Inspections, Service Wartung, Service

Förord, Informationer Foreword, Information Vorwort, Informationen

2 Motor Engine Motor

Elektriskt system, Instrument Electrical system, Instruments Elektrisches System, Instrumente

Kraftöverföring, Bakaxel
Transmission, Rear axle
Kraftübertragung, Hinterachse

5 Bromsar Brakes Bremsen

Framvagn, Styrinrättning Front assembly, Steering Vorderwagen, Lenkung

Fjädringssystem, Hjul Suspension, Wheels Federung, Räder

Raross, Värme- och ventilationssystem
Body, Heating and ventilation system
Karosserie, Heiz- und Klimaanlage

9 Tillbehör Accessories Zubehör

SAAB-SCANIA

Saab Car Division

Service Department NYKÖPING SWEDEN

Repair work descriptions

The work descriptions state the extent of the work, the order of the various stages involved in the operation, the tools and other conditions taken into consideration when determining the duration of the relevant work sub-categories.

The Standard Time sheets serve as a register of the Repair Work Descriptions which are to be found in each Section of this Manual. In addition, they show how the schedule time is made up of effective time, secondary time and lost time. The latter concepts are defined in the foreword of the Time Schedule and in Section 0 of this Manual.

In the work descriptions, tools and aids are abbreviated as explained in the attached "List of hand tools and aids" (see Section 0).

Further copies of each "Repair Work Description" can be ordered from Saab-Scania Technical Literature Dept. The ordering number for Repair Work Descriptions for the 95 and 96 models is IN 10189 and for the 99 model IN 10190. The price is 50 Swedish crowns each.

Effective time, secondary time and lost time

The standard times for the work operations are shown divided between the three components effective time, secondary time and lost time (distribution time). The reason for dividing up the times in this way is to make it easier for the employee to judge the fairness of the time, to facilitate adaptation to local conditions and to help determine certain "foreman rates" when the operation unit is not the same as listed.

Note that it is necessary to add "order time" to the schedule time in order to arrive at the total allocated time for the job.

Effective time

The expression "effective time" is taken to mean the time required for regular and predetermined activity defined in principle in the step-by-step description of the work operation, and which is specific for the job in question and the particular object to be worked on.

Tightening bolts, cleaning, measuring, checking, dismantling and assembling are all examples of effective time operations. Picking up and putting down tools are counted as effective time operations if they take place within the limited working area (4 x 7 m) of the main operation.

Secondary time

A repair job involves certain operations of a preparatory or terminative nature. They may recur in several stages of the job, and whether or not these operations actually take place depends on the arrangement of the work and the work combinations in each individual case. The time required for these operations is known as secondary time and is separated from effective time for the reasons given above and because the frequency and duration (or existence) of secondary times depend to some extent on the arrangement and application of the piecework system. Examples of secondary time (operations) are given in the special secondary time specification.

In most cases the secondary times have been laid down for a particular working environment and have been given certain standard values. Theoretically, the actual working environment must correspond to the one used as a basis for the times, if the standard times are to be applicable. For instance, it is assumed that the mechanics will have seat protectors, fender protectors, an undercar board, etc., within their working area (4 x 7 m) as well as an exhaust hose connection. It is also assumed that each mechanic has a draining vessel for coolant in his working area. The special tools, etc., for common or less frequent use are assumed to be positioned at the most 20 meters from the working area of the mechanics, and the same distance is assumed to apply, for instance, to the collection of an engine hoist or headlamp setting instrument or for walking to a machine room or washing area.

As regards the collection of spares, circumstances differ greatly in practice and the necessary time for this operation depends largely on the actual combination of the operations involved in the job. For these reasons this type of secondary time is not included in the scheduled time. The same applies to the time for clocking in and out, driving the car in and out, opening and closing the hood and fitting fender covers. These are all typical "order times" (see Foreword, Saab Repair Time Schedule) and must be added to the scheduled time.

Lost time

Normal lost time is the time for irregular activity which is not directly related to a particular operation but for which a mean value per week or other time unit can be determined. Normal lost time is broken down into working lost time and personal lost time.

Working lost time includes for instance helping a colleague, receiving instructions from a foreman, minor working hitches, cleaning out the working area (normally part of effective time) and arranging tools at the end of the day (when the mechanic is clocked on to piecework and the same work is to continue the next day).

The working lost time is 5% of the total of working time and secondary time.

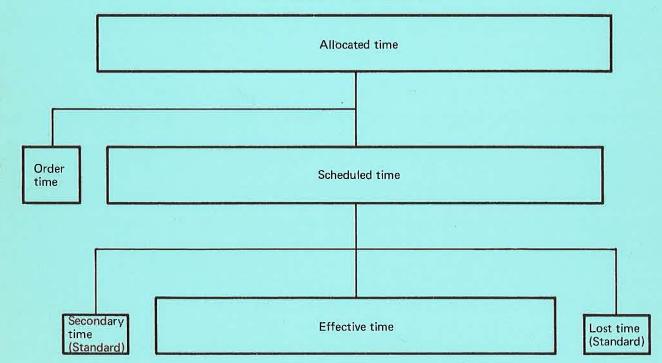
Personal lost time is the time for breaks in work caused by the physical needs of the employee (rests, visits to lavatory, etc.)

Personal lost time is 5% of the total of working time and secondary time.

Examples of secondary time

Arranging hand tools Connecting and disconnecting exhaust hose Collecting and putting away undercar board Collecting and putting away garage jack Fitting and removing seat protector (not for driver's seat) Connecting and disconnecting lead lamp Draining vessel for coolant, collecting and putting away Draining vessel for oil, collecting and putting away, subsequent walking and cleaning Arranging materials (normally part of effective time) Arranging special tools and aids Collecting and putting away brake servicing equipment Collecting and putting away light setting unit Collecting and putting away engine hoist Walking to and from cleaning area, transporting to and from machine area, etc.

Composition of allocated time



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Repair Work Descriptions

Methodenbeschreibungen

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Förord, Informationer Foreword, Information Vorwort, Informationen

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Saab Car Division

Service Department NYKÖPING SWEDEN

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Repair Work Description SAAB 95/96

Saab Car Division	Replaces page		Date	1 6400	T. D.	
30	neplaces page		73-01-02	Edition 1	Page	
List of hand tools and aids						
WRENCHES						
			HAMMERS			
Combination wrench						
Combination wrench 1/2" Articulated socket wrench 12 n			Hammer			H
Internal hexagon ('Allen') key			Hammer, forging Hammer, copper		** *** **.** **.**	
Adjustable wrench 6"		Wadj 6	Hammer, plastic			Hc Hp
Spark plug wrench		Wspp	Hammer, rubbei			Hr
Starter motor wrench		Wsm Wsp 5/16	Chipping hamm	er		Hch
TURNING TOOLS			CLEANING AID	os		
Air-driven nut runner	000 1000 1000 000 0004 000 0	Tanr	Knife			Ck
Ratchet handle 3/8" spigot		Trh 3/8	Steel wire brush Spatula			
Articulated handle		Tah	Compressed air			
Brace	* * * * * * * * * * * * *	Tbr				
Turning handle		Tthn Tta	LIETING ALDO			
Torque head, 4 kpm		Tthd	LIFTING AIDS			
Extension bar, short		Tebs	Column lift .		TO 0 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	Lc
Extension bar, medium		Tebm	Garage jack .			Lj
Extension bar, long	** * ** ** ** ** ** ** ** ** ** ** ** *	Tebl Tebf	Trestles			Ltr
Universal joint		Tuj	Engine hoist . Gearbox jack .			Leh Lgbi
			Dividing jack, m	oving foot		Ldim
SOCKETS			Dividing jack, fix	xed foot		Ldif
JOCKETS			***			-
Double-hexagon socket, 13 mm		Sdh 13	MISCELLANEO	US AIDS		
Double-hexagon socket, long						
Hexagon socket (heavy duty) 3, Hexagon socket, long	/4	Shhd 3/4" Shl	Lead lamp			MI
Cross-slot socket			Oil can			Moc Mdv
Internal hexagon socket ('Allen'	')	Sinh	Filling can			Mfc
Spark plug socket		Sspp	Crowbar			Mcb
Tubular socket	* * * * * * * * * * * * * * * * * * * *	Stu Sre	Power drill			Mpd
	2011 1011 1011 1011 1011		Oxy-acetylene w Rotary grinder			Mwe Mrg
SCREWDRIVERS, CHISELS etc	c		Sheet metal saw			Mms
		60		18.00 L	***	
Straight-slot screwdriver, short ((stubby)	SCs SCssh	0.00			
Cross-slot screwdriver		SCcs				
Cross-slot screwdriver, short (stu	ubby)	SCcssh				
Angled screwdriver, straight-slot Angled screwdriver, cross-slot		Scas SCac				
Chisel		SCch				
Center punch		SCcp				
PLIERS						
Welding pliers		Pw				
lat pliers		PfI				
Polygrip pliers		Ppo Pnu				
Combination pliers		Pco				
Pointed-nose pliers		Ppn				
Side cutters		Psc				
Circlip pliers, for shafts		Pcsh			357	
Circlip pliers, for bores, holes et Clip pliers	.c	Pcb Pcl				
Cable lug pliers		Polg				
		. cig				

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Metodbeskrivningar (ackordsmeddelanden)

Repair Work Descriptions Methodenbeschreibungen

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Tillsyner, Underhåll Inspections, Service

Wartung, Service

Repair Work - Standard Times SAAB 95/96 Saab Car Division Edition Date Replaces page Jan. 1973 11102 - 11203 Effective time time allow-ance Effective time Secondary Lost time time allow-ance Schedule time Oper, No Modelcode Oper, No Modelcode 147 13 16 176 11102 2-3 7 11104 66 1 74 2-3 11108 2-3 118 4 12 134 9 13 11121 2-3 2 20 2-3 17 11123 8 11125 2-3 11202 2-3 165 18 200 0,4 4 11203 To this sheet belong 2 sheets of repair work description

Saab Car Division

Replaces page Predelivery inspection 2 - 3It is assumed that a column lift and all the necessary tools and aids are available in the workshop. Check operation of parking, rear, stop and reversing lamps, flashers, warning flasher, instrument lighting, indicator lamps, brake warning lamp, horn, blower, interior lighting, windshield and headlamp wipers/washers, licence plate lighting, trunk lighting. Pressure-test braking system (with approx. 100 kg/220 lbs-foot pressure on pedal for 10 seconds) Check seat adjustment mechanisms Position lifting arms, raise car on lift Check visually front and rear brake hoses Adjust brake shoes-Was 5/16 Check, adjust if nec., p-brake cables-Trh, Tebm, Sdhl 9/16 Lower car, jack up RH front wheel (for valve adjustment)-block Check level, if nec. top up oil in engine Check level, if nec. top up, oil in gearbox-Was 11 (possibly Ppn 3/8, Tebl, Tebs) Check battery charge-electrolyte tester Check battery acid level and top up-distilled Disconnect ground cable from battery-Wco 1/2 Check connections (and tighten screws and nuts) at battery, starter motor, generator and regulator -Wco 10, 5/16, 1/2, 9/16 Connect ground cable to battery-Wco 1/2 Check, if nec. adjust, fan belt tension-Trh 3/8, Sdh 1/2, Wco 1/2, Tah Check freezing point of coolant-coolant tester Top up radiator expansion tank and windshield washer bottle Check fluid level in containers for braking system and clutch operation, if nec. top up-disc brake fluid Remove air cleaner-Was 10-11, Pcl Adjust position of coolant hose at LH valve cover and hose clip at front of RH cover (for accessibility on remove-install valve covers)-SCs Disconnect ignition leads, remove valve covers-Wsp, SCs Disconnect ground lead from cylinder head bolt-Trh, Tebl, Sdh 13 Tighten cylinder head bolts-Ttg, Tebs, Sdh 3/4 Connect ground lead to cylinder head screws Check and adjust valve clearances-feeler gauge, Was 7/16 Refit valve covers, connect ignition leads Lower front wheel, lower lift Fold in lift arms Connect strobe lamp-strobe lamp, adapter 839204 Start engine-exhaust hose Check, adjust if nec., ignition timing-784470 (carb. wrench 2-stroke) Tighten wheel bolts-Tah, Shhd 3/4 Adjust air pressure in all tires (incl. spare)pressure gauge Check that the complete tool kit, guide and servicing card accompany the car Check operation of all locks

Repair Work Description SAAB 95/96

73-01-02

Date

11102

11102

Page

Check, adjust if nec., fast idle setting-786091, rev counter

Edition

Refit air cleaner

Adjust idling quantity and speed-SCs Check, adjust if nec. CO content-CO-meter SCs

Stop engine

Check toe-in-784001, chalk

Check, adjust if nec. headlamp setting (incl. remove-install trim frames)-SCs, headlamp setting equipment

Make the necessary notes on the inspection report

The time does not include test driving with operation checks

Dewaxing

2-3

1,1104

Drench car with tepid water Mix dewaxing agent with warm water (mix ratio 4 %)-Geveclean 826 Spray entire body externally-high pressure equipment and possibly kerosene spray Fetch bucket of tepid water Wash (sponge) body externally (incl wheels)bucket, sponge Drench car externally with tepid water Drench car externally with cold water Wipe down body externally-wiper blade "Blow" body (especially rubber strips) with compressed air-Cag 'Leather" body-chamois leather

Predelivery polishing

2-3

11108

Clean all rubber strips (windows), rubber seals, fuel filler pipe and bumper rubber bufferssynthetic thinners 3810, polishing rags Apply polish to entire body (incl bumpers and wheels)-polish, polishing cloth Remove labels stuck to windows-razor blade Apply window soap to windows internally and externally-window soap, polishing cloth Polish entire body-polishing cloth Dry and polish windows-polishing cloth Open-close trunk lid, doors and engine hood, remove any residual wax spots Clean all tires, synthetic thinners 3810, polishing rags

Valve cover, fit new gasket, 2 (cover off) 2-3 11121

Remove gasket from valve cover Clean mating surfaces-knife Wash valve cover and blow clean-cleaning equipment, Caq Position new gasket in valve cover

Spare parts Valve cover gasket

11203

Installation of loose equipment 2–3 11123 Install external rear view mirrors—SCcs Install hub caps Install external rear view mirrors—SCcs Install hub capes Install appets Remove plastic covers—SCcs Adjusting seat rails, per seat 2–3 11125 Adjusting seat rails, per seat 2–3 11126 Adjusting seat rails, per seat 2–3 11126 Adjustment, 1 seat—SCcs, Wco 7/16, Hp Warranty inspection 2000 km 2–3 11202 It is assumed that a column lift and all the necessary tools and arils are available in the workshop Check operation of parking, rear, stop and reversing lamps, flashers, warning flasher, instrument lighting, indictor lamps, brake warning lamp, horn blower, interior lighting, windshield and head-tapm wipers/washers, Ilecence plate lighting, trunk lighting rear exists of bots attaching rear axis side links to body (rear seat cushion)—Was 11/16 Check kightness of fear power unit mounting bracket (final removal of vantilation duct)—SCcs, SC3, Trh, Tebs, Sch 9/16 Pusition car on lift, raise Check viaber sealing boots on inner and outer Usharian engine oil, replace seal at plug—Trh, Sch 13 Drain gearbox oil, wash magnetic plug—Trh, Sch 3 Higher Lower nut of engine mounting cushions—Trh, Tebs, Sch 9/16 Pusition car on lift, raise Check viaber sealing boots on inner and outer Usharian engine oil replace seal at plug—Trh, Sch 3 Higher Lower nut of engine mounting cushions—Trh, Tebs, Sch 9/16 Pusition are onlift, raise Check viabers decenter bearing bracket—Was 1/2, Wco 1/2 Collant, pressure tast cooling system—cooling system at each of the cooling system as the cooling system as the cooling system—cooling system as the cooling system—cooling system as the cooling sy		Replaces	page		Date	Edition	Page
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bott—Trit, Tebl, Sdh 13 Torque cylinder head botts—Trg, Tebs, Sdh 3 finite manifold botts and nuts—Trg, 786,662 Connect ground lead to cylinder head bott Tighten carb, flange nuts—839,089 Tighten float chamber cover screws—SCS Check that choke spindle moves easily Jack up RH front wheel, lock LH—filting blot Check, agust if nee, old in the arms of the lift Tighten engine side stay—Was 1/2, SCcs, Wad Tighten body attaching points of lower spring halves—Trit, 2 x Tebl, Tebs, Sdh 1/16 Tighten ensows of botts attaching points of lower spring halves—Trit, 2 x Tebl, Tebls, Sdh 1/16 Tighten engine side stay—Was 1/2, SCcs, Wad Tighten body attention to must provide side side inks to body (rear seat cushion)—Was 11/16 Topker engine side stay—Was 1/2, SCcs, Wad Tighten engine side stay—Was 1/2, SCcs, Wad Tighten engine side side inks to body (rear seat cushion)—Was 11/16 Topker engine side stay—Was 1/2, SCcs, Stay—Tighten, Sch 1/2, Wac 1/2 The S	Installation of loose equip	nent	2–3	11123			
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Extra to predelivery inspection Adjustment, 1 seat—SCcs, Wco 7/16, Hp Warranty inspection 2000 km 2—3 11202 Warranty inspection 2000 km 2—3 11202 Warranty inspection 2000 km 2—3 11202 Wash valve covers, replace gaskets—washing equipment, knife and sare available in the workshop. Check operation of parking, rear, stop and reversing lamps, flashers, warning flasher, instrument lighting, indicator lamps, brake warning lamp, horn blower, interior lighting, windshield and head-lamp wipers/washers, licence plate lighting, trunk lighting. Pressure-test braking system (with approx. 100 kg/220 lbs—foot pressure on pedal for 10 seconds) Check tightness of boths attaching rear axile side links to body (rear seat cushion)—Was 11/16 Check tightness of boths attaching rear axile side links to body (rear seat cushion)—Was 11/16 Check (lightness of boths attaching rear axile side links to body (rear seat cushion)—Was 11/16 Check (lightness of boths attaching rear axile side links to body (rear seat cushion)—Was 11/16 Check (lightness of boths attaching rear axile side links to body (rear seat cushion)—Was 11/16 Check (lightness of looks attaching rear axile side links to body (rear seat cushion)—Was 11/16 Check (lightness of looks attaching rear axile side links to body (rear seat cushion)—Was 11/16 Check (lightness of looks attaching rear axile side links to body (rear seat cushion)—Was 11/16 Check (lightness of looks attaching rear axile side links to body (rear seat cushion)—Was 11/16 Check (lightness of looks attaching rear axile side links to body (rear seat cushion)—Was 11/16 Check (lightness of looks attaching per axile side links to body (rear seat cushion)—Was 11/16 Check (lightness of looks attaching per axile side links to body (rear seat cushion)—Th, 78, 801, 91/6, 91/6 Crock (lightness of looks attaching rear axile side links to body (rear seat cushion)—Th, 78, 801, 91/6, 91/6 Check aubstack solid side side links to develop the links of looks attaching per axile side links to develop the links of looks attachi	A -11		0.0	11105			
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equipment, knife Refit valve covers log lamps, flashers, warning flasher, instrument lighting, inclidator lamps, brake warning lamp, horn blower, interior lighting, windshield and head- lamp wipers/washers, licence plate lighting, trunk lighting lighting, flashers, warning flasher, instrument lighting, inclidator lamps, brake warning lamp, horn blower, interior lighting, windshield and head- lamp wipers/washers, licence plate lighting, trunk lighting Pressure-test braking system (with approx. 100 kg/ 220 lbs—foot pressure on pedal for 10 seconds) Check tightness of botts attaching rear axle side links to body (rear seat cushion)—Was 11/16 Check tightness of rear power unit mounting bracket (incl removal of ventilation duct)—SCès, SCs, Trh, Tebs, Schl 9/16 Position car on lift, raise Adjust brake shoes, check and if nec, adjust, p- brake cables—Was 5/16, Trh, Tebm, Schl 9/16 Drain neighe oil, replace seal at plug—Trh, Sdh 13 Drain neighe oil n	Warrante inspection 2000	launa.	2 2	11202			
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Check operation of parking, rear, stop and reversing lamps, flasher, instrument lighting, indicator lamps, brake warning lamp, horn blower, interior lighting, windshield and head-lamp wipers/washers, licence plate lighting, trunk lighting Pressure-test braking system (with approx. 100 kg/220 lbs-foot pressure on pedal for 10 seconds) Check tightness of bolts attaching rear axle side links to body (rear seat cushion)—Was 11/16 Check tightness of bolts attaching rear axle side links to body (rear seat cushion)—Was 11/16 Check tightness of rear power unit mounting bracket (incl removal of ventilation duct)—SC2s, SCs, Trh, Tebs, Sdh 9/16 Position car on lift, raise Adjust brake shoes, check and if nec. adjust, p-brake cables—Was 5/16, Trh, Tebm, Sdh 9/16 Position car on lift, raise Adjust brake shoes, check and if nec. adjust, p-brake cables—Was 5/16, Trh, Tebm, Sdh 9/16 Drain engine oil, replace seal at plug—Trh, Sdh 13 Drain gearbox oil, wash magnetic plug—Trh, 879036, oil drain wash, Cag Check rubber sealing boots on inner and outer UJs and steering gear Check rubber sealing boots on inner and outer UJs and steering gear Check rubber sealing boots on inner and outer UJs and steering gear Check visually front and rear brake hoses Tighten engine oil—3 liters engine oil 1, Tighten engine side stay—Was 1/2, SCs, Wad Tighten engine side stay—Was 1/2, SCs, Wad Tighten engine side stay—Was 1/2, SCs, Wad Tighten engine side stay—Was 1/2, Tybe, Sch 9/16 Tighten body attaching points of lower spring halves—Trh, 2 x Tebl, Tebs, Sch 9/16 Tighten engine enut in mounting ushiance of the lift Tighten engine side stay—Was 1/2, SCs, Wad Tighten engine side stay—Was 9/16 Tighten engine side stay—Was 1/2, X Tebl, Jebs, Sch 1/1/2 Most of the lift Tighten ergine side stay—Was 1/2, SCs, Wad Tighten engine side stay—Was 1/2, Eds Adjust if nec. closing angle-starter cable, ever counter, SCs Refit distributor cover, ignition leads—SCs Refit air cleaner. Tighten under side stay—Was 1/2, Scs, Wad Tighten engine nut i		Tare Transition					
Check operation of parking, rear, stop and reversing lamps, flashers, warning flasher, instrument lighting, indicator lamps, brake warning lamp, horn blower, interior lighting, windshield and headlamp wipers/washers, licence plate lighting, trunk lighting Pressure-test braking system (with approx. 100 kg/ 220 lbs-foot pressure on pedal for 10 seconds) Check tightness of bolts attaching rear axle side links to body (rear seat cushion)—Was 11/16 Check tightness of rear power unit mounting bracket (incl removal of ventilation duct)—SC8s, SCs, Trh, Tebs, Sdh 9/16 Position car on lift, raise Adjust brake shoes, check and if nec. adjust, p-brake ceables—Was 5/16, Trh, Tebn, Sdh 9/16 Position car on lift, raise Adjust brake shoes, check and if nec. adjust, p-brake ceables—Was 5/16, Trh, Tebn, Sdh 9/16 Drain engine oil, replace seal at plug—Trh, Sdh 13 Drain gearbox oil, wash magnetic plug—Trh, Sdh 13 Drain gearbox oil, wash magnetic plug—Trh, S79036, oil drain wash, Cag Check rubber sealing boots on inner and outer UJs and steering gear Check rubber seals on ball joints and tie rod ends Tighten lower nuts of engine mounting cushions— Trh, Tebs, Sdh 9/16 Tighten exhaust system clamps and attachment points—Was 1/2, Wco 7/16 Tighten exhaust system clamps and attachment points—Was 1/2, Wco 7/16 Tighten exhaust system clamps and attachment points—Was 1/2, Wco 7/16 Tighten exhaust system clamps and attachment points—Was 1/2, Wco 7/16 Tighten exhaust system clamps and attachment points—Was 1/2, Wco 7/16 Tighten exhaust system clamps and attachment points—Was 1/2, Wco 7/16 Tighten exhaust system clamps and attachment points—Was 1/2, Wco 7/16 Tighten exhaust system clamps and attachment points—Was 1/2, Wco 7/16 Tighten exhaust system clamps and attachment points—Was 1/2, Wco 7/16 Tighten exhaust system clamps and attachment points—Was 1/2, Wco 7/16 Tighten exhaust system clamps and attachment points—Was 1/2, Wco 7/16 Tighten exhaust system clamps and attachment points—Was 1/2, Wco 7/16 Tighten very 1/2, Wco 7/16 Tighten very 1					Refit valve cove	ers	
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Repair Work - Standard Times SAAB 95/96

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11310	7	152	5	16	173				,			,	,		
11310	8	145	5	15	165										
11310	9	150	5	16	171										
11310	0	156	5	16	177										
11310	1-2	162	5	17	184										
11310	3	158	5	16	179										
11312	7–3	33		3	36										
11321	73	5,3	0,8	0,6	7										
11322	7–3	5,4	2,4	0,8	9										
11325	7–3	4, 1	0,3	0,4	5										
11327	7–3	7,0	0,4	0,7	8										
11329	7–3	7,9	1,4	0,9	10										
11335	7	8,2	0,3	0,9	9										
11335	7–3	3,9	0,3	0,4	5										
11339	0-3	4,5		0,5	5										
11340	7–3	19,0		1,9	21										
11341	7–3	20,8	1,0	2,2	24										
11342	7–3	43,4	1,7	4,5	50										
11343	7–3	44,1	2,7	4,7	52										
11346	7–3	55,4	1,7	5,7	63										
11347	7–3	57,6	2,7	6,0	66										
11349	7–3	9,2	1,4	1,1	12										
11352	7–3	20,1	6,3	2,6	29										
11353	7–3	25,8	7,3	3,3	36										
11354	7–3	2,7		0,3	3										
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11360	7-3	5,6	0,2	0,6	6	112									

Saab Car Division

Inspection

The time is based on a workshop equipped with a flat 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.

The car must, before work starts, be driven into position with the front wheels on turntables and the freewhel locked (for valve adjustment).

1967 model: remove LH and RH storage baskets, lift out front carpet (s) and masonite panel. Check condition of brake pipes (lead lamp, chisel, rust preventive). Replace masonite, carpet (s) and baskets.

Fold out lift arms Raise car half way (lift)

Run out compressed air hose and connect nut runner and sockets. 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 sealing of wheel cylinders through holes in rear drums (screwdriver, lead lamp). Adjust the rear brake shoes outwards (special wrench 5/16) and if nec, binding outer link of parking brake (compressed air gun). Check condition of brake hoses and pipes at rear axle (rag, rust preventive).

Up to 1972 inclusive: take grease gun. Wipe off grease nipples, lubricate ball joints and tie rod ends. Replace grease gun, wipe.

Check sealing and condition of rubber boots on steering gear and outer UJs, and of rubber seals at ball joints and tie rod ends (lead lamp).

Lower radio antenna (where it may touch roof). Raise car to highest position, (for oil draining). Lower car to alter height.

Refit wheels on hubs and start all screws. Tighten screws in opposite pairs, but not to full torque (nut runner).

Set p-brake to an intermediate position. Check that the braking effect is equal on both rear wheels. If necessary, adjust cables by means of nuts under lever.

Check.

Up to and incl. 1970 model (special wrench 9/16) From 1971 model (ratchet handle, medium extension bar and long socket 9/16).

Lower car to floor (but with lift in contact with underbody for subsequent lifting). Tighten wheel bolts in opposite pairs (articulated handle or torque wrench, hexagon socket 3/4). Refit hub caps.

Open engine hood and position fender protector (order time).

Remove engine hood (screwdriver) carry away and hang up.

Remove gearbox level plug (articulated wrench 11) and check level (wire). Not applicable if job B 3 is added. When topping up is necessary: remove topping up screw (ratchet handle, medium extension, possibly long extension), collect hose or filling can, top up oil. Take away hose or can. Refit level screw (not applicable if job B 3 is added). Refit topping up screw.

Turn front wheels to LH stop. Collect hose or grease gun. Wipe steering gear nipple and lubricate sparingly (lubrication equipment or hand gun). Remove hose/gun.

Raise front of vehicle and lock LH wheel by means of a block against the floor.

Remove top of air cleaner (articulated wrench 10 or 11). Remove bottom of air cleaner (articulated wrench 10). Remove ignition leads from plugs and coil.

Remove valve covers, (special wrench 10, screwdriver)

Clean off remains of old gasket (screwdriver, knife) Wipe surface on cyl. head. Wash and blow clean valve covers (washing equipment, compressed air gun). From 1971 model inclusive: remove washer bottle (for plugs and fuel pump).

Blow clean around spark plugs. Remove spark plugs, visual 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 gauge, articulated wrench 7/16).

Clean spark plugs (steel wire brush, compressed air gun) and tighten terminal nuts (nut pliers) / alternatively, open pack and fit terminal nuts to new spark plugs. Adjust spark gap (spark plug tool).

Refit spark plugs.

Position new gaskets in valve covers. Refit covers.

Raise car slightly, remove block under LH front wheel, lower car. If front wheel angles are not to be measured (B 7) subsequently, the lift can be lowered to the floor and the arms folded in.

Check condition of generator belt and its tension by pressing with thumb. Adjust if nec. (ratchet wrench, socket 1/2, ring wrench 1/2 and large articulated handle).

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

Saab Car Division

Repair Work Description SAAB 95/96

Remove cover of radiator tank/expansion vessel and connect cooling system tester. Pump up pressure and make mental note of pointer position.

Remove fuel pump cover (5/16 ring wrench) and remove gauze with care. Replace gasket if necessary. Check small gasket under head of screw.

Check whether pressure in cooling system has dropped and if so why. Visually check all hoses for sealing and condition. Tighten any clamps that may be loose (straight slot screwdriver).

Remove pressure tester and refit the normal cap.

Remove distributor cap (screwdriver) and rotor arm. Visually check condition of contact breaker points (screwdriver, lead lamp). If points require replacement see order job B 5.

Lubricate CB cam carefully (special grease and screw-driver). Lubricate felt on distributor spindle (coil can). Up to 1967 incl.: lubricate dashpot at bottom of distributor housing.

Connect rev counter to battery earth cable and ignition coil (for ignition coil with round pin, use adapter 839205). Connect starter lead to battery and starter motor solenoid (remove the yellow lead from the lug and replace it by the starter lead). Set the ignition key to the ignition position. Check and if nec. adjust the closing angle while the starter motor turns over the engine (starter lead, straight slot screwdriver). Remove starter lead and re-connect yellow lead to solenoid.

Visually check and wipe clean distributor cap internally and externally, ignition leads and HT terminal of coil. Check that the carbon brush in the centre of the distributor cap moves freely. Fit rotor arm and distributor cap. Connect ignition leads to spark plugs and coil.

Connect strobe lamp to battery and number 1 cyl. terminal in distributor cap (adapter 839204). Clean ignition setting markings in timing chain cover (screwdriver, rag).

Connect exhaust hose and CO meter intake to rear muffler. Start engine. Re-check closing angle. Remove vacuum hose to distributor. Reduce speed to approx. 500 r/min. Check ignition timing (strobe lamp). If necessary adjust by slackening the distributor locking screw (784470) and turning distributor until correct timing is obtained. Tighten screw. Re-check ignition timing. If nec. readjust and re-check. Check that the centrifugal advance-retard is operating by increasing the speed and checking that the ignition timing changes. Check the vacuum advance-retard by connecting the vacuum pipe while observing the change in ignition timing.

Now allow the engine to run at increased speed by using the fast idle position, until it reaches the operating temperature required for subsequent carb. adjustment.

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

Check ply of clutch release bearing. Adjust if necessary (combination wrench 1/2 to 5/16).

Check the level in the braking system and clutch operation containers. Top up with disc brake fluid if necessary. If the level in the brake container has fallen owing to wear of the brake pads, topping up is not necessary.

Check the condition of the rubber boots on the inner UJs (lead lamp). Check the condition and sealing of all brake lines in the engine compartment (rag, lead lamp).

Check that the connections of the muffler pipes to the cylinder heads are gas tight by feeling and listening.

Blow clean the air cleaner filter (compressed air gun).

Wipe clean the inner surfaces of the halves of the air cleaner. Refit filter and other part.

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

From 1971 incl.: refit washer bottle.

Adjust idling mixture setting (srewdriver) and idling speed (screwdriver/rev counter). Check reading of CO meter. If the value is too high, weaken the mixture slightly. Check engine speed and adjust if nec. Check CO content. Note the value on the report.

Stop engine.

Disconnect rev counter and strobe lamp and replace them in the correct positions. Check that all ignition leads are properly attached to distributor cap and ignition coil. Shut off CO meter pump and disconnect from battery. Roll up hoses, place condensate trap and exhaust gas collector on meter trolley.

Disconnect exhaust hose from car

Remove fender protector, 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 edge of the rim. Read off the scale and make a chalk mark on the side of the tire. Move the toe-in tool onto the floor in front of the car. Roll the car forward, position the tool at the front edge of the rim. Measure and note the value in the report (if adjustment is required see B 8). Remove toe-in tool. NB.: if order job B 7 is added, the enclosed toe-in check is not included. Position the car for headlamp setting check. Wipe the headlamp glasses and visually check condition of headlamps. Switch on main beams and any cornering lamps. Check setting of dipped and main beams (the headlamp setting equipment is assumed to be to hand).

Service department and demander of the service of t

Saab Car Division

From 1969 incl.: remove trim frames (cross slot screw-driver).

Adjust main and dipped beam settings. Refit trim frames.

Check and adjust the setting of any cornering lamp that may be fitted. Switch off lights.

Make any notes that may be necessary on the inspection report (Saab—Ana IN No. 11659)

Spares:

2 valve cover gasket Possibly 1 fuel pump gasket

Additional inspection work

7-3

11312

The car must be in position with the mechanic in the drivers seat.

Check operation of: parking, rear, stop, reversing lamps, flashers and warning flasher (mirrors in front of and behind car), instrument lighting, indicator lamps, brake warning lamp, horn, blower fan, both speeds, interior lighting and door switches in doors, windshield and headlamp wipers and washers.

Engage reverse gear, remove ignition key, unlock trunk lid, check operation of lighting for licence plate and trunk. Close lid and replace key in ignition lock; engage fourth gear.

Before removing wheels:

Check tire tread depth (special gauge) and note values on report.

After checking the sealing of the UJs and ball joints: check condition and gas tightness of exhaust system (hammer and chisel). If there is leakage at a joint in the pipe, tighten the clamp (articulated wrench 1/2).

After mounting valve covers:

check engine oil level. Check condition and sealing of fuel lines in engine compartment. If necessary tighten hose clips (cross slot screwdriver). Check that the hose nipple of the carb. cover has not become loose.

Check acid level in battery cells. If nec. top up with distilled water. Remove any corrosion at the battery terminals (rag, chisel). Wipe off the top of the battery. Tighten the battery terminals (ring wrench 1/2) and smear them with vaseline (brush).

Check freezing point of coolant (tester). Note value in report. Top up coolant in cooling system. Mix in anti-freeze if necessary. Top up water in washer bottle.

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 spindle moves easily in its bearings. No routine lubrication necessary. If binding occurs lubricate with a low viscosity temperature resistant lubricant such as automatic transmission oil or lock cyl. oil containing graphite. Blow in the

lubricant with a compressed air gun and work the choke butterfly repeatedly between its extreme positions until it operates smoothly.

Start windshield and headlamp wipers and washers. Check that they all operate correctly. Stop wipers and washers, wipe and check blade rubbers. If nec., remove washer tubing from nozzle and clean nozzle (compressed air gun, possibly wire), reconnect tubing. If nec., adjust bore in nozzle (wire). Run wipers/washers again to check.

Five periods are allocated for checks and adjustments over and above those described in the text.

aab-scania - service Department-Kundendienstabteilung - Nykoping - sweden-schwede

11335

11339

11340

0 - 3

7-3

Saab Car Division Date Edition Page Replaces page 73-01-02 1 11321 7-3 11321 tion of contact surfaces if necessary. B 1 Engine oil change (on lift) The lift must be at the highest position. Contact breaker set Position the oil collector (on swinging arm or wheeled tank). Remove drain plug (ratchet wrench, socket 3/4 or 13) B 5 Contact breaker points replace Wipe clean plug and tools single unit 1971 on: change sealing plug Refit plug The single unit contact breaker set was introduced from chassis No. 96/434.174 (= 1/3 of the cars of After wheel mounting: 1967 model) Position filling hose Remove cap, put in 3.3 liters oil, refit cap After checking contact surfaces: Replace hose remove contact breaker unit (screwdriver) Open pack (screwdriver) Spares: Check that the contact surfaces are dry; wipe with Sealing ring (1971 on) trich if necessary. 3.3 liters engine oil Install contact unit in distributor. Spares: B 2 Oil filter replace 7-3 11325 Contact breaker set Lay rags on engine compartment floor under filter. Remove filter (strip wrench 786201) B 6 fuel filter replace Take new filter, apply oil to seal (oil can) Install filter After valve adjustment: Remove rags from engine compartment floor, wipe clean Remove filter (screwdriver) Install filter (screwdriver) Spares: Oil filter Spares: Fuel filter B 3 Gearbox oil change (on lift) 7-3 11327 B 7 a Front wheel angles (camber The lift must be at the highest position and caster) check (with rim-mounted instrument) Position the oil collector (on swinging arm or wheeled tank). Remove drain plug (ratchet wrench, short exten-After carb, adjustment: sion bar or, from late 1969 cars on, with 879036) Check and adjust tire pressure (not spare) Wash the plug (washing facilities at the work position, Attach the instruments to the rim edges of the front brush, compressed air gun) wheels Refit plug Connect transformer to instrument and mains Raise car (lift or jack) After refitting wheel: Check front wheel tire treads Remove filling screw (ratchet handle, long and medium Compensate for rim throw (optically, against extension bars) scale in front of car) Position filling hose Set turntables to correct position, lower car Put in 1.7 liters oil Fit brake locking devices Replace hose Release turntables, work front of car up and down Refit filling screw Measure camber of first wheel Measure caster of first wheel, note values in report Delete from basic inspection: Measure camber of second wheel remove-install level screw, check Measure caster of second wheel Measure toe-in, note values Spares: Read off table (Saab) for thickness of any washers 1.7 liters EP 80 oil that may be required Remove instruments and replace them in the correct B 5 Contact breaker points replace (early place version with separate components) 11335 Disconnect transformer and replace it in the correct After contact points surface check: Remove brake blocking devices

Lock turntables

Time for toe-in check in inspection is deleted.

Remove contacts (screwdriver, pointed pliers) Open pack (screwdriver) lubricate contact spindle (special grease) Check that contact surfaces are dry, wipe with

trich if necessary.

Fit contact breaker components, adjust mutual posi-

extra to B 7 a.

Saab Car Division	eplaces page		Date	Edition	Page	-	
			73-01-02	1	11341		
B 7 a Front wheel angles (cambe caster) check (with hub-mounted strument) See 60112 (5—), but excl.: Write report Remove-install hub caps		11341	After check mea Adjust toe-in (bo 7/8, 7/16 (up to Roll car back and Position measuri Note reading on Move tool to floo Roll car forward	oard for lying u 1968 inclusive d forward ng tool (78400 scale, make ch), polygrip 11) on rear i alk mark or	pliers rim edges	
B 7 b Front wheel angles check a adjust 1 side toe-in adjust (rim-med instrument)		11342	Position tool on Measure and not				
Check camber and caster, see 113 Replace washers in front and real (ratchet handle or ratchet wrench extension bar, socket 9/16, break Measure, note values Measure toe-in Adjust toe-in (board for lying un	bearings, 1 side n 899576, short king spike)		B 9 Brake fluid r Before removing Fill equipment w Fill quipment wi Fill the brake flu	wheels: vith brake fluid th air (compre- id containers c	ssed air gun of the car w) ith fluid	11352 t)
7/8, up to 1968 U-wrench 7/16, grip pliers) Check, adjust and re-check if nec Note reading	later models, poly-	' ă	and connect nipped equipment. After oil draining Brush and blow compressed air g	g operations: clean all bleed (ush,
B 7 b Front wheel angles check a adjust 1 side, toe-in adjust (hubmounted instrument) Check camber/caster and adjust (5—) but excl remove-install hub report Toe-in adjust, see 60125 (5—), but for checking toe-in incl in inspec	1 side, see 60114 caps and write ut excl. the time	11343	Subject system to Bleed at LH from and tube for exco Move vessel to R Bleed at RH rear Move vessel to R Dispose of excess	o pressure t wheel (ring w ess fluid) H rear wheel wheel (bleedir H front wheel	ng wrench 7 etc		er
B 7 d Front wheel angles, check 2 sides, toe-in adjust (rim-mount strument)		11346	After wheel mou Remove pressure Check level, refit Check pedal pres	hose from car cap, wipe	brake fluid	containe	r
Check camber and caster, see 113 Replace shims in front and rear besides (ratchet handle or ratchet with short extension bar, socket 9/16. Measure and note values of two sockets when the sockets of two sockets with the sockets of two sockets with the sockets of two sockets with the sockets with	earings, both vrench 899576, breaking spike)		Extra to B 9 for nipples, each Replacement of		bleed	7–3	11354
Adjust toe-in Check, if nec. readjust and re-che	eck.		B 10 Inlet manife			7–3	11355
B7 d Front wheel angles check a adjust 2 sides, toe-in adjust (hubmounted instrument) Check camber/caster and adjust to 60118 (5-), but excl:		11347	Slacken and torq bolts and nuts in laid down in the special wrench 7	the order and workshop man	to the torqu	ues	
remove-install hub caps and write Toe-in adjust, see 60126 (5), but for toe-in adjust incl in inspection	excl. the time		B 11 Level check	bers of 95, per		7–3	11360
B 8 Toe-in adjust This job is an extra either for an in which order job B 7 is not to be determined by the extra to B 7 a.		11349	After oil draining Clean around and sorbers (articulat Check level (wire Top up with oil Refit screw	d remove screw ed wrench 9/1 e)	6 or 14)		

SAAB-SCANIA

Repair Work - Standard Times SAAB 95/96

Baab Car Di		F	Replaces pag	le		Date	 Edition		Pag	je	-	
						Jan. 1973	1			12109 -	14135	
Oper, No	Modelcode	Effective	Secondary time	Lost time allow- ance	Schedule time	Oper. No	delcode	Effecti		Secondary time		Schedule time
12109	5-	2	1	1	4							
12123	5-	7		1	8							
12124	P7-2	27	6	, 3	36							
12124	H7-2	35	6	4	45							
12206	7-	9	5	1	15							
12212	7-	5	4	1	10							
12216	5-	11	5	2	18	-						
12223	5 –	8	2	1	11							
	_	5 0	7		4E							
13106	5-	38	3	4	45							
13112	5-	14	1	2	17 17							
13114	5 - 5-	13 9	2	1	10							
13116 13120	5-	25	3	3	31							
13201	5-	38	1	4	43							
10201												
14120	5-	28	8	4	40							
14122	5-	23	7	3	33							
14129	H5 -	5		1	6							
14131	5-	2			2							
14133	P5 -	5		1	6							
14133	H5-	10		1	11							
14135	P5-	3			3							
14135	H5-	9		1	10							
To this s	heet belong	3 sheets	of repair	work	description							

Edition Date Page Replaces page 73-01-02 1 12109 Lubrication, lubricating nipples 12109 Engine oil change (without filter 7-12212 replace each replacement) Lubricating nipple remove-Wadj Remove drain plug-Was 19, Mdv Lubricating nipple install Clean and refit drain plug Replace seal in plug (71-) Put in oil—oil supply system (or cans and funnel) Chassis lubrication (car raised) 12123 Spares: Seal (71-) Lubricate ball joints and tie rod ends-grease gun Lubricate steering gear Gearbox oil change 12216 All-round lubrication (incl battery check) P7-2 12124 Raise, support, lower front end-Lj, Ltr every 10000 km or twice per year Change oil, see 12223 (5-) All-round lubrication as per diagram in workshop manual (instruction book-guide) Gearbox oil change (car raised) 5-12223 Unlock RH door Lubricate door hinges-Moc Remove drain plug-Trh, Tebs 3/8 Lubricate engine hood lock mechanism-Moc Clean drain plug magnet Lubricate door stops-Vaseline Refit drain plug Lubricate throttle linkage-Moc Remove filler plug-Trh, Tebl, Tebs 3/8 Remove distributor cap and rotor arm-SCs Put in oil-EP 80 Lubricate distributor felt-Moc Refit filler plug. Lubricate contact breaker cam-special grease, SCs Refit rotor arm and distributor cap Check gearbox oil level-Was 7/16, wire Adjust gearbox oil level-Trh 7/16, Tebm Check engine oil level Check fluid level in brake and clutch master

All-round lubrication (incl battery check) H7-2 12124

See 12124 (P7-2)

These items are added:

cylinders—disc brake fluid Top up if necessary

Lubricate steering gear Check acid level in battery

Raise car

Check fluid level in rear shock absorbers-Was 9/16,

Lubricate ball joints and tie rod ends-grease gun

wire

Top up if necessary-shock absorber oil

Top up with distilled water if necessary Clean cable lugs, wipe battery top. Tighten and grease cable lugs.

Refit screw

Lubricate rear side window hinges

Change engine oil (inl filter replace) 7— 12206

Remove drain plug-Was 19, Mdv

Clean and refit drain plug

Change seal in plug (71-)

Place rags on engine compartment floor below filter

Remove and dispose of filter-786201

Fit new filter-Moc

Wipe clean, remove rags

Put in oil-oil supply system (or cans and funnel)

Spares: Seal (71-)

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Saab Car Division					on SAAB 95/S
	Replaces page		73-01-02	Edition 1	Page 13106
Washing, with additive	5-	13106			
Clean and wipe rubber mats i	n car—Sponge, chamo	ois			
leather					
Wet body, windows, wheels, t					
both sides of mudflaps—sham Wash body, outsides of windo					
with additive.	wa ana omomo parte				
Rinse car.					
Go over body, windows and o Wipe insides of windows, inst					
and sills.	rument paner, door s	uips			
Removal and replacement of	loose rubber mats inc	el in			
standard time			1		
Washing (light wash) (hose, le	athor out) E	12112			
	ather ext) 5—	13112			
Hose body—chamois leather Leather body and windows—v	wringer				
Leather body and windows	Williget		2		
Washing (light wash)	5	13114			
(hose, 'sponge' ext)					
Hose body—sponge Wash body with additive—sha	mnoo				
Rinse body—bucket	троо				
Hosing underbody for inspect underbody compound	ion of 5—	13116			
Hose underbody-high pressu	re pump				
Hose under fenders Blow dry with compressed air					
- The state of the					
Light wash, hose-sponge-leath	er-body 5	13120			
Hose body					
Wash body with additive, rins	e-sponge, shampoo,				
bucket					
Leather windows and body—	chamois leather, wrin	ger ————			
Engine wash (incl floor, whee	l housings) 5—	13201			
Drive car to washing area	J-, -				
Open-close hood	100				
Remove refit battery earth (g		/2			
Cover distributor—plastic bag Cover generator—plastic bag					
Spray on Oil-veck					
Spray on Sumakraft					
Hose with hot water Blow with compressed air—co	moressed air aun				
Remove plastic bags	mprosacu an yun				
Dry fenders, hood, windshield	d etc—leather				
Drive out car					

Spares: sealing plug

Repair Work Description SAAB 95/96

Saab Car Division				Repair work	_			
	Replaces page	е		73-01-02	Edition 1	Page 1412	0	
			4.4400					4 4 4 5
Antirust treatment, hole drill spraying antirust fluid in door undersides of doors		5—	14120		ent, extra for di ing antirust flui		H5-	1413
Connect drill to compressed a	air hose—drill			See 14138 P5-				
Fit bit to drill and lubricate-		meter bit		add this item:				
Measure position and drill ho	le (s) in lower	edge of			ne seat cushion o			d
door-rule					I shielding arour			
Go to other side	1.63.5.1	-1 -		Remove cardbo	ard and replace	seat cushic	on	
Measure position and drill ho	ole(s) in lower	edge of		-				
door Remove bit, disconnect drill				Antiquet treatm	ent, spraying an	tirust	P5-	14135
Place paper on floor under do	oors-paper			fluid into rear s		tirast		1,4100
Brush and blow clean undersi		ag, Cwb			excl drilling of	holas		
Apply antirust fluid with a br			nt	Remove rubber		Holes		
until the space is full. On olde		underside		- Temove rabber	piugo			
of door—antirust fluid, brush								4
Wipe off excess antirust fluid Fill spray gun with antirust fl		2			ent, extra for sp		H5-	14135
Connect compressed air hose		"		antirust fluid in	to rear side pan	els		
Spray indoors	to spray garr			See 14133 H5-	- (excl drilling o	f holes)		
Change from nozzle to hose-t	ube-plastic h	ose, bent		Remove rubber				
copper tube								
Spray rear edges of door								
Disconnect spraygun and cha	nge from hose	e-tube to						
nozzle Fit rubber plug and wipe—SC								
Remove paper from floor	3							
Spares: sealing plug								
Antirust treatment, spraying fluid in doors and treating un		5—	14122					
doors								
See 14120 excl drilling of ho	les							
This item to be added:								
Remove rubber plugs								
Antirust treatment, extra for spraying antirust fluid in aero	e e e e e e e e e e e e e e e e e e e	H5-	14129					
Spraying anti-ust train in dere								
Position paper at rear window Spray in antirust fluid at thre		e serofoil		A second of				
Remove paper and wipe off e								
Antirust treatment, extra for		5-	14131					
antirust fluid in front upper s through holes in wheel housing								
Control of the contro		A Commission						
Spray antirust fluid into fron through holes in RH and LH								
Go to other side	wheel housing	js.						
Wipe off any excess fluid								
Position paper at rear window Spray in antirust fluid at three Remove paper and wipe off each antirust treatment, extra for antirust fluid in front upper sthrough holes in wheel housing Spray antirust fluid into front through holes in RH and LH Go to other side Wipe off any excess fluid Antirust treatment, extra for holes and spraying antirust fluid into front through holes in RH and LH Go to other side Wipe off any excess fluid Antirust treatment, extra for holes and spraying antirust fluid panels. Measure position and drill hospray into side panels. Spray into rear edges of side Fit rubber plug and wipe					- 1			
		\b=	0.000	2 2 2		7		
Antirust treatment, extra for		P5-	14133					
holes and spraying antirust fl side panels.	uid into rear			A				
orac pariora,		55 1		1 -1 -1				
Measure position and drill ho	les in rear side	e panels						
Spray into side panels Spray into rear edges of side	nanels							
Fit rubber plug and wipe	Patiers							
The state of the s							100	
Sparge: coaling plug								

SAAB-SCANIA

Repair Work - Standard Times SAAB 95/96

			Replaces pa	ye		Date Jan. 1973	Edition 1		15104	- 19128	
Oper. No	Modelcode	Effectiv	e Secondar time	Y Lost time allow- ance	Schedule time	Oper, No	delcode	Effect time		dary Lost time allow ance	Schedule
15104	5	63	10	7	80						
15104	6	70	10	8	88						
15104	7-	46	15	6	67	-					
15113	5	26	2	3	31						
15113	6	65	3	7	75						
15113	7-8	29	2	3	34						
15113	9-	31	1	3	35						
15114	7–8	17	3	2	22						
15114	9-	23	3	3	29						
15115	7-	4	1	1	6						
15125	7–	37	2	. 4	43						
15127	7–8	7	1	1	9						
15127	9–	7	1	1	9						
19102	5-	12	3	2	17						
19104	5-	20	3	2	25						
19110	2-	19	3	2	24						
19117	2-	24	3	3	30						
19124	5-	26	3	3	32						
19126	5-	14	3	2	19						
19128	5-	2			2						

Replaces page

Page 15104

Edition

1

Date

73-01-02

Tuning and adjustment, cleaning sparking 5 15104 plugs, fuel pump and cleaner, adjusting ignition timing and idling	Tuning and adjustment, cleaning sparking 7— 15104 plugs fuel pump and cleaner, adjusting ignition timing and idling
Disconnect-connect earth (ground) cable from/to battery— Wco 1/2 Remove-install, wipe clean, blow clean air cleaner and filter—Was 7/16 SCs, rag, Cag Remove-install clean and adjust spark plugs—Cag, Tah, Tebl, spark plug tool, Remove-install and clean fuel pump filter—Wco 5/16 (Was 11/16), Cag Tighten flange nuts and bolts of choke and carburetter neck Lift and clean distributor cap	Disconnect-connect earth (ground) cable from/to battery—Wco 1/2 Remove-install air cleaner with upper part, wipe and blow clean—Wco 10, rag, Cag. Remove-install clean and adjust spark plugs—Cag, Tah, Tebl, spark plug tool. Remove-install and clean fuel pump filter—Was 11 Tighten flange nuts—Wco 13 Remove distributor cap, vacuum tube and rotor arm—SCs Clean cap and leads—Ck Lubricate distributor—Moc, special grease, SCs
Remove rotor arm and clean—SCs, Ck Remove condensation trap and wipe Visually check contact breaker points Lubricate distributor—Moc, special grease Connect cam angle meter and starter cable—cam angle meter, starter cable	Visually check contact breaker points Connect starter lead and cam angle meter—starter lead, cam angle meter. Adjust cam angle—SCs Disconnect starter lead, refit rotor arm and distributor cap Clean at ignition timing marks, connect strobe lamp—
Adjust cam angle—SCs Refit parts removed from distributor Connect strobe—strobe lamp Start-stop engine, adjust engine timing Remove cam angle meter and strobe, refit distributor cap Start-stop engine, adjust idling—SCs, rev counter	strobe lamp Start engine, switch on dipped headlights Reduce idling speed, adjust ignition timing—SCs, Trh 786053 Connect vacuum tube, check ignition timing at higher speed Connect and position CO meter trolley Connect meter to battery
Spares: Fuel pump gasket (possibly sparking plugs, air filter) Tuning and adjustment, cleaning spark 6 15104 plugs fuel pump and air cleaner, adjusting ignition timing and idling	Place condensation trap at rear of car and position probe in exhaust pipe Run hose from condensation trap to trolley Start meter pump, calibrate and connect hose to instrument Adjust idling mixture screw—SCs Adjust idling speed—rev counter
Disconnect-connect earth (ground) cable from/to battery—Wco 1/2 Remove-install, wipe clean, blow clean air cleaner and filter—Was 7/16 SCs, rag, Cag Remove-install clean and adjust spark plugs—Cag, Tah, Tebl, spark plug tool. Remove-install and clean fuel pump filter—Wco 5/16,	Read CO meter, adjust if nec. Stop engine Remove and put away all meters. Spares: fuel pump gasket (possibly spark plugs, air filter)
Cag. Tighten choke housing and inlet manifold—Wco 7/16, Was 7/16 Sdh 7/16, Tebl, Trh, SCcs.	Tuning and adjustment, cleaning 5 15113 carburetter(s) in car (in conj. with 15104)
Remove fan belt—Wco 1/2, Was 1/2 Lift and clean distributor cap Remove rotor arm and clean—SCs, Ck Remove condensation trap and wipe Visually check contact breaker points Lubricate distributor—Moc, special grease Connect cam angle meter and starter cable—cam angle meter, starter cable. Adjust cam angle Refit parts removed from distributor and refit fan belt	Position rag, clean outside of carburetter, remove rag—brush, washing facilities at place of work Disconnect fuel line and remove carburetter cover— Wco 11/16, Wadj 8, Wadj 4, SCs Remove starting, idling and main jets—Wco 12, Wco 9/16, SCs Remove needle valve and float—Was 9/16, SCs Blow out carburetter housing, tighten jets—Cag, SCs Blow and refit starting, idling and main jets

Refit parts removed from distributor and refit fan belt Connect strobe-strobe lamp Start engine, adjust ignition timing Remove cam angle meter and strobe Refit distributor cap Start-stop engine, adjust idling-SCs, rev counter

Saab-Scania

Spares: fuel pump gasket, spring washer (rotor arm), (possibly spark plug air filter)

Spares: Float chamber gasket needle valve gasket

Check and install float

Refit carburetter cover

Reconnect fuel line

Remove-install and clean fuel filter

Blow, check and install needle valve

Test-start engine, check for leaks

			Date	Edition	Page	
	Replaces page		73-01-02	1	15113	
			73-01-02	1, 1	10110	_
Funing and adjustment, clea ter(s) (in conj with 15104)	ning carburet- 6	15113	Refit stepped d	isc		
			Reconnect fuel		tters	
Nash, blow clean carburette	r externally—brush,		Reconnect cool			
washing facilities at place of	work					
Disconnect three fuel lines-			Pump up fuel (r			
			Start-stop engin	e, check for lea	iks	
Remove three covers—SCs, 7				A CONTRACTOR OF THE PARTY		
Remove-install, blow clean a	and check float chambe	er,	C Carley			
with float, needle gauze and	filter-Wco 9/16, Cag		Spares: Carbure	tter cover gaske	∍ τ	
Position paper rags under ca			-			
Remove main, idling, startin	g and low speed jets-		Compression tes	et (1 massuram	ent) 7-8	151
Nco 9/16, Wadj 4			Oomprossion to	ot () moasarom	J. 7 3	
Blow clean all float chamber	s and ducts-Cag		Remove upper p	part of air clean	er-Was 10	
Remove paper rags	· · · · · · · · · · · · · · · · · · ·		Remove 4 spark			
	into in bookings CCs					
Fighten main and emulsion	jets in busnings—SCs				ompression meter	
Blow clean all removed jets			Run starter mot	tor (assistant), r	measure compression	ı,—
Refit main, idling and starting	na iets		assistant			
Refit idling screw	.9 1020		Dismantle comp	raccion tactor		
Refit cover			Refit 4 spark plu			
Reconnect fuel lines			Refit upper part	of air cleaner		
Refit low speed jet						
Test-start engine and check	for looks					
lest-start engine and check	IOI ICAKS			- 10		454
			Compression te	st (1 measurem	ent) 9-	151
Spares: Float chamber gaske	t, washer		See 15114 (7-8	51		
			(extra time for	iong spark plug	S)	
Tuning and adjustment also	ning 7–8	15113				
Funing and adjustment clear		19113				
carburetter(s) in car (in con	j with		Compression te	et (incl inspecti	on, 7-	151
15104)					011,	
			motor tuning, e	tc)		
Position rag under carburett	ers		Compression to	et /1 meacurem	ent)-compression	
Disconnect fuel line				st (1 micasarom	cirty compression	
Disconnect throttle linkage-	-Pcsh		meter, assistant			
						_
Wash carburetters externally	/-brush, washing facili	•				
ties at place of work			Tuning and adju	ietmant value e	adjustment 7-	151
Remove carburetter cover a	nd gasket—SCs, Ck				iujustinent 7—	101
Remove float			(in conj with 15	104)		
	W 12 CC		Domovo install	ignition loads (from/to spark plugs)	
Remove plug and main jet-	vvco 13, 50cs			The second secon		
Remove idling jet—SCs					covers-cleaning	
Remove emulsion jet-SCs			area, Cag, Tbr, S	Sdhl 10		
Remove needle valve—Was 1	Λ		Adjust valve cle		1 feeler gauge	
Blow clean jets, housing and	cover		Start-stop engin	e, check for lea	IKS	
Refit jets and plug						
Check and install float			Spares: 2 valve	cover gaskets		
Check and install needle val	VO.			3		-
Tighten diaphragm screws (The state of the s			
Refit carburetter cover and	gasket		Tuning and adju	ıstment, fast id	le, 7–8	151
Reconnect throttle linkage			check and adjus			
Reconnect fuel line						
			Start engine			
Remove rags			Adjust idling sp	eed-SCs		
Start engine, check for leak:	S					
			Set fast idle to		3.	
C	alaste.		Adjust speed to	1200-1300 r/	min-Wadj 4	
Spares: carburetter cover ga	sket		Check step 3			
era-artico			Adjust mixture-	-SCs		
				303		
Tuning and adjustment, clea	aning 9–	15113	Stop engine			
		.0110	-			
arburetter(s) in car (in con) With					
l5104)			Tuning and adju	etment fact id	lle check 9-	151
A					io olicon 3—	101
Wash carburetters externally	ybrush, Cag, washing		and adjust (air o	cleaner off)		
facilities at place of work.			Ctout andies	itah an dimerel	handlights	
Disconnect coolant hoses fr	om choke housing_so	S	Start engine, sw		neadiignts	
		3	Check fast idle	speed		
Disconnect fuel line from ca					r/min-special wrenc	h
Remove stepped disk from	carburetters—SCs					Vi.
Remove carburetter cover—			Adjust mixture			
			Switch off head	llights, stop eng	jine	
	-was b/16					
Remove main jet and float– Blow clean float chamber, c						

19128

	Replaces	paye		73-01-02	Edition 1		Page 1910:
Licence plates, replace 1		5-	19102	Licence plates		late and	-
Open-close trunk lid Remove old licence plate Drill holes for fixing screws in l drill, 6 mm dia. bit Fit licence plate Spares: licence plate, fixing scre		ate—power		tax disc Fit tax disc to Fit nameplate	holder		
Licence plates, replace 2		5	19104				
Open-close trunk lid Remove old licence plates Drill holes for fixing screws in drill, 6 mm dia. bit Fit licence plates—SCs	licence pl						
Spares: licence plates, fixing sc washers	rews and	nuts, spacer					
Licence plates, intall new, 2		2-	19110				
Open-close trunk lid Drill two holes 6 mm dia. in tro drill 6 mm dia. bit Fit front and rear licence plate	s—SCs						
Spares: licence plates, fixing sc washers	rews and	nuts, spacer					
Licence plates, make and instal	l new, 2	2-	19117				
Open-close trunk lid Fit letters and numbers to two Drill two 6 mm dia. holes in tre drill 6 mm dia. bit Fit front licence plate—SCs Fit rear licence plate			ower ₃₀				
Spares: licence plates, numbers and nuts, spacer washers	, letters,	fixing screw	3				
Licence plates, make and repla	ce, 2	5-	19124			(6)	
Remove old licence plates Fit letters and numbers to new Drill holes for fixing screws in 6 mm dia. bit Fit licence plates—SCs			drill,				
Spares: licence plates, fixing sc washers, numbers, letters	rews and	nuts, spacer					
Licence plates, make and replace Remove old licence plate Fit letters and numbers to new Drill holes for fixing screws in drill, 6 mm dia. bit	licence p		19126				

Spares: See 19117 (5-)

SAAB

Metodbeskrivningar (ackordsmeddelanden)

Repair Work Descriptions Methodenbeschreibungen

2

Motor Engine Motor

SAAB-SCANIA

Saab Car Division
Service Department
NYKÖPING SWEDEN

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Repair Work - Standard Times SAAB 95/96

			Replaces pag	,,,		Jan. 1973	Edition 1		Pa	20108 -	20195	V4
per, No.	Modelcode	Effective	Secondary	Lost time allow- ance	Schedule time	Oper, No	 delcode	Effect	ive	Secondary		
20108	7-	23	10	3	36							
20133	7-	208	26	23	257							
20138	7-8	237	21	26	284							
20138	9-0 7-	232	21	25	278							
20138	1-	244	21	27	292							
20141	7-	7	2	1	10							
20165	7-8	11		1	12 } 12	3						
20165	9- } (-	6	4	1	11)							
20167	7-	22		2	24							
20167	₋ 7–	18	1	2	21							
20169	7-	11	1	1	13							
20174	7-8	88	18	11	117							
20174	9-0	89	18	11	118							
20174	1-	93	18	11	122							
20176	7–8	149	19	17	185							
20176	9-0	142	19	16	177							
20176	1-	151	19	17	187							
20183	7-	24	10	3	37							
20185	7–	24	10	3	37							
20191	7-	11	2	1	14							
20193	7-	14	3	2	19							
20195	7-	48	10	6	64							

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Ī	Replaces page		73-01-02	Edition	Page 20108	V4	
	Engine mountings, Replace front rubber 7— 20 blocks	0108	Separate and clea	n air cleaner, a		V4	
	Hood remove-install Remove preheater plate—Wco 1/2		Spares: exchange		5		
	Fit lifting hook—lifting hook Remove 4 fixing nuts—Sdh 1/2, Tebs, Trh, Tebl Connect engine hoist, raise engine—engine hoist Remove rubber blocks		Power unit (engir	ne + gearbox)		7-0	20138
	Fit new rubber blocks Lower engine into position, remove hoist Fit 4 fixing nuts		Remove power unit				
	Remive liftning hook Refit preheater plate		Power unit (engi	ne + gearbox)		1–	20138
	Spares: rubber blocks	2422	Remove power uni				
	Exchange engine: transfer of equipment, 7— 20 power unit out Fit lifting hook—786202	0133	Engine mounting replace (power u		blocks	7–	20141
	Remove LH and RH engine mounting—Wco 12 Fit bracket and place power unit in stand—Leh Disconnect and remove lifting hook Drain engine oil—Was 19, Mdv		Remove 2 lower Remove blocks a Refit 2 lower nut	nuts-Trh, Teb nd position nev			
	Separate power unit—Ppo, SCcs, Was 15 Remove generator and fan belt—Wco 1/2, Wco 12 Remove emission leads and distributor—Wco 13		Spares: rubber er	ngine mounting	blocks		
	Remove carburetters and thermostat housing—Wco 13, Pcl, Ppn, SCs 5 Remove spark plugs—Sspp		Power unit, add unit for 2 auxilia		all power	7–8	20165
	Remove water manifold—SCs 7 Remove fuel pump—Wco 13 Remove oil pressure transmitter—Wco 27 Remove cluth—Sdh 1/2, Tbr, shims		Disconnect leads SCs, Ppn Connect leads to			s—	The state of the s
	Remove flywheel—Sdh 16, Tah, Tbr Remove oil duct plug—Wih Remove fan blades—Was 12 Take engine block out of stand, remove bracket		Power unit, extrumit for 2 auxilia				20165
eu	Unpack new exchange engine Clean and check all parts removed Fit bracket, mount new engine in stand—Leh		Extra for aux. he	eadlamps see 20	165 (99)		
n-Schwed	Fit clutch housing guide sleeves—Hp Fit plug and for crankcase ventilation Fit plug for oil duct		Power unit, extr unit for Eberspä		stall power	7–	20167
pping - Swede	Fit flywheel Fit fan blades Fit oil pressure transmitter		Lift up heater Remove hoses fr Connect hoses to Lower heater and	o water pipes—S d tighten	6Cs		•
llung - Nyko	Fit fuel pump Fit water manifold Clean flywheel, clutch plate and pressure plate— emery cloth, trich		Extra time must affected by the h		or operation	is .	
dienstabte	Assemble clutch—784060 Fit carburetters and thermostat housing Clean, adjust and fit spark plugs—spark plug		Power unit, extra unit for Eberspä	cher BL2ZW		7-	20167
Saab-Scania - Service Department-Kundendienstabteilung - Nyköping - Sweden-Schweden	tool, Sspp, Ck, Cwb Fit distributor and ignition leads Fit gearbox to engine, fit starter motor Fit generator and generator belt Fill up with engine oil—engine oil		Remove fan mot Remove water p Refit water pipe Refit fan motor	ipe hoses—SCs hoses	Vco 10, SCs		
- Service Depa	Fit lifting hook and connect hoist Disconnect power unit from stand Lower power unit into position Fit 4 fixing nuts	: - 11	Power unit, extra unit for Eberspä	cher BN2S		7-	20169
Saab-Scania	Fit water drain plugs to block Fit RH and LH engine mounting Disconnect and remove lifting hook		Remove heater k Clean and refit h replace)—Cwb, S Spares: sealing ri	eater body (ind Cs			

Saab Car Division

Date Edition Replaces page Page 73-01-02 20174 **V4** Power unit, (engine + gearbox) remove 7-20174 Refit speedometer cable-ppo from car Refit gear shift UJ-Wco 5/16 Refit freewheel control-Ppn Remove engine hood-SCs Refit slave cylinder-Was 1/2 Position drain vessel and open radiator drain plug-Mdv, Refit side stay-Trh, Sdh 12, 13 Wco 7/16 Refit heater hoses-SCs Open both drain plugs on block—Trh, Tebm, Sdh 11 Refit throttle linkage-Trh, Tebm, Sdh 10, SCs, Ppo Remove front panel-SCcs, Wco 1/2, Was 7/16, Tebf, Refit servo and drain hose from 1969 on-SCs Trh, Sdh 7/16 Refit leads to ignition coil and generator-Wco 10, Remove radiator 1 Trh, Temb, Sdh 1/2, SCs Wadj, SCs Disconnect starter motor cable from battery—Wco 1/2 Refit earth (ground) lead to cyl head-Trh, tebm, Sdh 13 Disconnect leads from ignition coil and generator-Wadj, Refit air cleaner-Was 10, Wco 11 Wco 10, SCs Tighten drain tap and install radiator-Wco 7/16, Disconnect earth (ground) lead from cyl head-Trh, Tebm, Th, Tebm, Sdh 1/2, SCs Sdh 13 Refit front panel-SCcs, Was 7/16, Wco 1/2, Trh, Tebf, Disconnect air cleaner-Was 10, Wco 11 Sdh 7/16 Remove draining and servo hose from 1969 on Fill up with coolant, vent and check for leaks-cooling Move washer bottle from 1969 on system tester Remove preheater plate-Was 11/16 Clean and reconnect starter motor cable to battery-Remove engine mounting nuts and muffler bracket-Trh, Cwb, Wco 1/2 Tebl, Tebm, Tuj, Sdh 9/16, Wco 1/2 Check engine oil Remove muffler connection from engine Wco 11/16 Remove cable from starter motor-Wco 9/16 1/2 Refit washer bottle Start engine, check affected functions, stop engine-ex-Remove oil pressure and temperature connections haust hose Disconnect fuel line from pump-SCs Refit hood Disconnect heater hoses-SCs Check operation of hood lock Disconnect throttle linkage-Trh, Tebm, Sdh 10, SCs Disconnect side stay from cyl head-Trh, Sdh 12-13 Spares: flange gasket, taper pin, nut Disconnect slave cylinder—Was 1/2 Disconnect freewheel control-Ppn, SCs Disconnect gear shift linkage-Wco 5/16, Ppo Engine, separating power unit when 7-Disconnect speedometer cable-Ppo Remove carpet, board and rubber plugs out of car (incl mounting power unit Remove hot air duct from 1971 on-Wadj, SCcs Remove screw at rear mounting-Trh, Tebn, Sdh 9/16 Remove LH engine mounting-Tanr, Sdh 13, Was 13 Support front of car on trestles-Li, Ltr Fit lifting hook-786202, Was 11/16 Release rubber boot clips-SCs, Psc Connect lifting hook to engine hoist-Leh Fit lifting hook and connect to hoist-786202, hoist Fit stand bracket, mount power unit in stand-Tanr, Sdh 13 Lift power unit out of car and place on floor Separate power unit-Wco 14, Ppo, SCcs, Was 15, Fit protective covers to inner UJs-783846, 732373 SCcs, Ppo, 786085 Disconnect lifting hook Remove lifting hook-Was 11/16 Power unit (engine + gearbox) install in car 7-20176 7-Engine, assembling power unit out of car (incl removal of power unit from Fit drain plugs to block-Trh, Tebm, Sdh 11

Check adjust if nec, clutch play-Wco 1/2, Wadj Check gearbox oil-Trh, Sdh 11

Fit new flange gaskets-Ck

Fit lifting hook and connect hoist 1 Was 11/16, 786202, hoist

Remove covers and grease inner UJs-grease

Position power unit in car

Position needle bearing cap if nec

Disconnect hoist and remove hook—Was 11/16

Fit screw for rear mounting (incl rubber plugs)-Trh,

Tebm, Sdh 9/16, M1

Refit hot air duct from 1971 on-SCcs, Wadj

Arrange board and carpet

Install muffler/engine connection—Wco 11/16

Install stays and nuts for engine mounting—Trh.

Tebl, Tebm, Tuj, Sdh 9/16, Wco 1/2

Refit preheater plate-Was 11/16

Reconnect cable to starter motor-Wco 9/16, 1/2

Reconnect oil pressure and temp. connections-Ppn

Reconnect fuel line to pump-SCs

Lower front of car-Lj

Refit rubber boot clips-SCs, Ppn, Psc

20185 stand)

20183

Assemble gearbox to engine—Tanr, Sdh 15, Was 15, SCcs. Loctite

Fit lifting hook-Was 11/16, 786202

Connect lifting hook to hoist-Leh

Release power unit from stand, remove bracket-Tanr, Sdh 13, Was 13

Fit LH engine mounting-Tanr, Sdh 13, Was 13 Remove lifting hook-Was 11/16

Spares: Screw for shield plate

7-20191 Engine, separating power unit (in conj with lifting in and out)

Remove starter motor-Wco 9/16 Remove shield plate-Ppo, SCcs Remove, fixing screws-Tanr, Sdh 15, Was 15

Separate engine from gearbox

SAAB-SCANIA aab Car Division		Repair Work Description SAAB 95/96					
Gad Strick	Replaces page	Date 73-01-02	Edition 1	Page 20193 V4			
Engine, assembling power unit (in conj with lifting in and out)	7- 20193						
Fit together engine and gearbox Refit fixing screws—Tanr, Was Refit shield plate—Loctite, SCc Refit starter motor—Wco 9/16	5, Sdh 15						
ingine, separating and assembling remove-install from/in stand	ng 7- 20195						
eparating of power unit out of ower unit in stand) see 20103	3 (7—)						
nit from stand) ee 20185 (7–)							

SAAR-SCANIA

aab Car Divi	Repair W		Edition		Page							
		F	Replaces pag	е		Jan. 1973		Edition 1			- 21182	V4
per. No	Modelcode	Effective time	Secondary time	Lost time allow- ance	Schedule time	Oper. No		delcode	Effectiv		dary Lost time allow ance	Schedule
21102	7–	176	16	19	211							
21104	7–	250	18	27	295							
21108	7-	36	9	5	50							
21111	7-	133	14	15	162							
21112	7–	57	9	7	73							
21113	7–	173	14	19	206							
21115	7–	118	13	13	144							
21118	7–	231	16	25	272							
21120	7-	186	18	20	224							
21123	7–	160	13	17	190							
21125	7–	36	7	4	47							
21127	7–	18	2	2	22							
21170	7-	71	12	8	91							
21172	7-	105	11	12	128							
21180	7–	94	12	11	117							
21182	7-	138	11	15	164		×					
o this she	eet belong	3 sheets	of repair	work	description							

	Replaces page		Date	Edition	Page	
			73-01-02	1	21102 V4	
Cylinder head, replace 1 gaske (excl tightening)	7-	21102	Refit spark plu Refit ignition I			
Remove head, see 21170 (7—) Refit head, see 21172 (7—)				te cyl head, inlet ilve cover gasket.	manifold gasket, cy	linder
Cylinder head, replace 2, (exkl tightening)	7-	21104		EADS, torquing	2 7-	211
Removal of cylinder heads see	21180 (7-)		(incl valve adju			
Transfer for studs-stud remov	er			eaner–Wco, 10, 1	1, Pcl	
Transfer and clean 4 spark plus	gs—spark plug wrenc <mark>l</mark>	n, Cwb, Ck,	Remove ign le			
spark plug tool	177 V			covers-Sdhl 10,		
Refit cylinder head see 21182	(7-)			ding strip—Wco 1		
Spares: Cylinder head, cylinde	r head gasket inlet m	anifold		ad bolts-ShI 19,		
gasket, valve cover gaskets, flan		idiliiold	Refit groundir	manifold bolts—7	86062, 1 tg	
				ig strip /ers–Cleaning are		
		8		over gaskets–Ck	d	
Cylinder heads, tightening, 1 (incl 7-	21108	Refit ign leads	The state of the s		
valve adjustment)			Start engine			
Remove air cleaner-Wco 10, 1	1, Pcl			earances-Feeler	gauge Wee 11	
Remove ignition leads				peed to 500-600		
Remove valve cover-Sdhl 10,			Stop engine	peca to 500-000	71711111-303	
Remove earthing (ground) stri		Nco 13	Refit valve cov	vers		
Tighten cylinder head bolts—S			Refit air clean			
Tighten inlet manifold bolts—7 Reconnect earthing strip when			Start engine			
Wash valve cover—Cleaning are			The second secon	o 800–900 r/mir		
Replace valve cover gasket—Ck			Stop engine			
Reconnect ignition leads			C V I			
Start engine			Spares: Valve of	cover gaskets		
Adjust speed to 500/600 r/mir						
Adjust valve clearances—feeler	gauge, Wco 11		CVLINDED	EADC		0444
Stop engine				EADS, replace 2	7–	2111
Refit valve cover Refit air cleaner			(engine in stan	a)		
Start engine			Remove ign lea	ads and distribute	or-Wco 13	
Adjust speed to 800/900 r/mir			Remove valve	covers-Sdhl 10,	Tbr, Pcl, Tfl	
Stop engine					Vco 7/16), Pcl, Ppn	
		ж.	Remove inlet r	manifold—Sdh 13	, Tbr	
Spares: valve cover gasket			Remove rocke	r arm mechanism	s-Trh, Tebs, Sdh 17	2
			Remove push			
			Remove cyl he	ads-Shl 19, Tebs	s, Tah	

Cylinder head, replace 1 (engine in stand) 21111

Remove ignition leads and distributor-Wco 13

Remove valve covers-Sdhl 10, Tbr, Pcl

Remove carburetters-Wco 13, (Wco 7/16), Pcl, Ppn

Remove inlet manifold-Sdh 13, Tbr

Remove rocker mechanism-Trh, Tebs, Sdh 17

Remove push rods

Remove cyl head-Shhd 19, Tebs, Tah

Clean mating surfaces on cyl block-Ck

Clean syl head, push rods rocker mechanism, inlet

manifold and valve cover-Ck, cleaning area

Transfer to studs-Stud remover

Remove and clean all spark plugs-Wspp, Cwb, Ck, spark

plug tool

Refit cyl head-Ttg

Refit push rods

Refit rocker mechanism

Refit inlet manifold-Ttg

Refit carburetters

Coarse adjust valve clearances-feeler gauge, Wco 11

Refit valve covers (new gasket)

Refit distributor

Remove cyl heads—Shl 19, Tebs, Tah

Clean mating surface on block-Ck

Clean cyl head, push rods, rocker arm mechanisms,

13

manifold and valve covers-Cleaning area, Ck

Transfer 4 studs-Stud remover

Remove and clean all spark plugs-Spark plug

wrench and tool, steel wire brush, knife

Refit cyl head-Ttg

Refit push rods-Moc

Refit rocker arm mechanisms

Refit inlet manifold-Ttg

Refit carburetter

Coarse adjust valve clearances-Feeler gauge, Wco 11

Refit valve covers (new gaskets)

Refit distributor

Refit spark plugs

Refit ign leads

Spares: Cyl heads complete, inlet manifold gasket, cyl head gaskets, valve cover gaskets, flange gasket

Saab Car Division			Repair Work D	escription	SAAD 3	5/90
	Replaces page		73 - 01 - 02	Edition 1	Page 21115	V4
CYLINDER HEADS, replace of (engine in stand) See 21111 (7—) cyl head replace 2 studs, clean spark plugs Spares: Cyl head gasket, inlet replace of the control of the cont	ce, excl transfer	21115	Drain coolant from block—Wco 7/16 or Remove air cleaner- Remove ign leads ar Remove valve cover	radiator and en 11, Mdv -Wco 11, 10, Po nd distributor—\	el Wco 13	21170
CYLINDER HEADS, replace 2 gaskets (excl subsequent tig Remove heads, see 21180 (7-	htening)	21118	Remove carburetter Remove inlet manif Remove muffler cor Wco 17, Sdh 15, Te Remove rocker arm Remove push rods	old—Sdh 13, Th nnection to engi bl, Tah, Mcb	or ine—	
Refit heads, see 21182 (7–) CYLINDER HEADS, replace subsequent tightening) Remove cyl heads, see 21170		21120	Remove cyl head—S Clean mating surfact Clean cyl head, pus mechanism, inlet ma Ck, cleaning area	e on engine bloc h rods, rocker a	ck-Ck irm	
Transfer 2 studs—Stud remove Transfer and clean 2 spark plu plug tool Refit cyl head, see 21172 (7— Spares:	er ugs—Wspp, Ck, spark		CYLINDER HEADS subsequent tightenion Refit cyl head—Shh Refit inlet manifold	ng) d 19, Tebs, Tah		21172
CYLINDER HEADS, replace (engine in stand) See 21 113 (7—) cyl heads rep		21123	sealing compound Refit push rods—Mo Refit rocker arm mo Refit muffler conne Sdh 15, Tebl, Tah, I Refit carburetter—V Refit distributor—W	echanism—Trh, ection to engine Mcb Vco 13 (7/16) P	— Wco 17,	
4 studs, clean spark plugs Spares: Cyl head gaskets, inlet valve cover gaskets, flange gas			Coarse adjust valve Close drain cock on drain plugs to engin Tebm, 3dh 11	radiator and re e block—Wco 7,	fit	. 11
DECARBONIZING COMBUS CHAMBERS AND PISTON T (per removed cyl head) Fit steel wire burr to power de Wipe away water from cylinder Place rags around cylinders Decarbonize piston tops—Pow Scrape off carbon around top	rill ers ver drill, wire burr	21125	Fill with coolant—N Start engine, adjust Adjust valve clearan Stop engine Refit valve covers—S Refit ign leads Adjust ign and chec Refit air cleaner—W Start engine	speed to 500-6 ices Sdhl 10, Tbr, Po k sealing-Strob co 11, 10, Pcl	el, Pfl	13
Clean and oil bores—Moc Remove 2 spark plugs—Wspp Decarbonize combustion chan tops—Power drill, steel wire by Remove steel wire burr from p Clean and refit 2 spark plugs—	nber and valve urr power drill		Adjust speed to 800 Stop engine Spares: Cyl head gasket, inl cover gasket, flange	et manifold gasl	ket, valve	
DECARBONIZING PISTON (per side) cyl head off Fit steel wire burr to power de Wipe away water from cylinders Place rags around cylinders Decarbonize piston tops—Pow steel wire burr	rill ers ver drill,	21127				

Saab-Scania - Service Department-Kundendienstabteilung - Nykôping - Sweden-Schweden Scrape off carbon around top of bores-Steel scraper Clean and oil bores-Moc Remove steel wire burr from power drill

		Repair work Description SAAB 99/8					
	Replaces page		73 - 01 - 02	Edition 1	Page 21180	V4	
YLINDER HEADS, rem	ove 2 7-	21180					
rain coolant from coole		21100					
/co 7/16, Trh, Tebs, Sdh							
Remove air cleaner—Wco							
Remove ign leads and dist							
Remove valve covers-Sdf							
Remove carburetter—Wco							
Remove inlet manifold—S	dh 13, Tbr						
lemove muffler connecti	on to engine- Wco 17,						
dh 15, Tebl, Tah, Mcb							
Remove rocker arm mech	anisms—Trh, Tebs, Sdh	า 17					
Remove push rods							
Remove cyl heads—Shhd							
Clean mating surfaces on							
Clean cyl heads, puch rod nechanism, inlet manifolo							
Ck, cleaning area	a and valve COVEIS-						
YLINDER HEADS, refi		21182					
excl. subsequent tighteni	ng)						
Refit cyl heads-Shhd 19,	Tebs, Tah, Ttg						
Refit inlet manifold—Sdh	13, Tbr, Tebs,						
tg, sealing compound	13, Tbr, Tebs,						
tg, sealing compound Refit push rodsMoc							
tg, sealing compound Refit push rods—Moc Refit rocker arm mechani	sms—Trh, Tebs, Sdh 17	7					
tg, sealing compound Refit push rods—Moc Refit rocker arm mechani Refit muffler connection	sms—Trh, Tebs, Sdh 17	7					
tg, sealing compound Refit push rods—Moc Refit rocker arm mechani Refit muffler connection Idhl 15, Tebl, Tah, Mcb	sms—Trh, Tebs, Sdh 17 to engine—Wco 17,	7					
tg, sealing compound Refit push rods—Moc Refit rocker arm mechani Refit muffler connection Idhl 15, Tebl, Tah, Mcb Refit carburetter—Wco 13	sms—Trh, Tebs, Sdh 17 to engine—Wco 17,	,					
tg, sealing compound Refit push rods—Moc Refit rocker arm mechani Refit muffler connection Idhl 15, Tebl, Tah, Mcb Refit carburetter—Wco 13 Refit distributor—Wco 13	sms—Trh, Tebs, Sdh 17 to engine—Wco 17, (7/16), Pcl, Ppn, SCs						
tg, sealing compound Refit push rods—Moc Refit rocker arm mechani Refit muffler connection Idhl 15, Tebl, Tah, Mcb Refit carburetter—Wco 13	sms—Trh, Tebs, Sdh 17 to engine—Wco 17, (7/16), Pcl, Ppn, SCs						
tg, sealing compound Refit push rods—Moc Refit rocker arm mechani Refit muffler connection Refit muffler connection Refit carburetter—Wco 13 Refit distributor—Wco 13 Refit distributor—Wco 13 Refit distributor—Refit ign leads	sms—Trh, Tebs, Sdh 17 to engine—Wco 17, (7/16), Pcl, Ppn, SCs nces—Feeler gauge, Wco						
tg, sealing compound Refit push rods—Moc Refit rocker arm mechani Refit muffler connection Idhl 15, Tebl, Tah, Mcb Refit carburetter—Wco 13 Refit distributor—Wco 13 Coarse adjust valve clearar	sms—Trh, Tebs, Sdh 17 to engine—Wco 17, (7/16), Pcl, Ppn, SCs nces—Feeler gauge, Wco tor and refit drain						
tg, sealing compound Refit push rods—Moc Refit rocker arm mechani Refit muffler connection Refit muffler connection Refit carburetter—Wco 13 Refit distributor—Wco 13 Refit distributor—Wco 13 Refit ign leads Refit ign leads Refit ign cock on radiat Refit to engine block—Wc Refil with coolant—Mfc	sms—Trh, Tebs, Sdh 17 to engine—Wco 17, (7/16), Pcl, Ppn, SCs nces—Feeler gauge, Wco tor and refit drain to 7/16						
tg, sealing compound Refit push rods—Moc Refit rocker arm mechani Refit muffler connection Refit muffler connection Refit carburetter—Wco 13 Refit distributor—Wco 13 Refit distributor—Wco 13 Refit ign leads Refit ign leads Refit ign cock on radiat Refit ign to engine block—Wc Refit ign engine block—Wc Refit ign engine block—Wc Refit engine, adjust speed	sms—Trh, Tebs, Sdh 17 to engine—Wco 17, (7/16), Pcl, Ppn, SCs nces—Feeler gauge, Wco tor and refit drain to 7/16						
tg, sealing compound Refit push rods—Moc Refit rocker arm mechani Refit muffler connection and 15, Tebl, Tah, Mcb Refit carburetter—Wco 13 Refit distributor—Wco 13 Refit distributor—Wco 13 Refit ign leads Refit ign leads Refit ign cock on radiated and the sealing sealing to engine block—Wco III with coolant—Mfc Refit engine, adjust speed adjust valve clearances	sms—Trh, Tebs, Sdh 17 to engine—Wco 17, (7/16), Pcl, Ppn, SCs nces—Feeler gauge, Wco tor and refit drain to 7/16						
tg, sealing compound Refit push rods—Moc Refit rocker arm mechani Refit muffler connection adhl 15, Tebl, Tah, Mcb Refit carburetter—Wco 13 Refit distributor—Wco 13 Refit distributor—Wco 13 Refit ign leads Refit ign leads Refit ign cock on radiated and the sealing stolenge to engine block—Wco III with coolant—Mfc Refit engine, adjust speed Adjust valve clearances Refore Etart engine	sms—Trh, Tebs, Sdh 17 to engine—Wco 17, (7/16), Pcl, Ppn, SCs nces—Feeler gauge, Wco for and refit drain to 7/16 to 500—600 r/min						
tg, sealing compound Refit push rods—Moc Refit rocker arm mechani Refit muffler connection Refit muffler connection Refit carburetter—Wco 13 Refit carburetter—Wco 13 Refit distributor—Wco 13 Refit distributor—Wco 13 Refit ign leads Refit valve clearances Refit valve covers—Sdhl 1	sms—Trh, Tebs, Sdh 17 to engine—Wco 17, (7/16), Pcl, Ppn, SCs nces—Feeler gauge, Wco for and refit drain to 7/16 to 500—600 r/min	o 11					
tg, sealing compound Refit push rods—Moc Refit push rods—Moc Refit rocker arm mechani Refit muffler connection Refit carburetter—Wco 13 Refit carburetter—Wco 13 Refit distributor—Wco 13 Refit distributor—Wco 13 Refit ign leads Refit ign leads Refit ign leads Refit ign engine block—Wc Refit engine, adjust speed Refit valve clearances Refit valve covers—Schl 1 Refit valve covers—Schl 1 Refit valve covers—Schl 1	sms—Trh, Tebs, Sdh 17 to engine—Wco 17, (7/16), Pcl, Ppn, SCs nces—Feeler gauge, Wco or and refit drain to 7/16 to 500—600 r/min 0, Tbr, Pcl, Pfl ing—Strobe lamp, Wco	o 11					
tg, sealing compound Refit push rods—Moc Refit rocker arm mechani Refit muffler connection Refit muffler connection Refit carburetter—Wco 13 Refit distributor—Wco 13 Refit distributor—Wco 13 Refit distributor—Wco 13 Refit ign leads Refit ign leads Refit ign leads Refit ign engine block—Wc Refit mith coolant—Mfc Refit engine, adjust speed Refit valve clearances Refit valve covers—Sdhl 1 Refit air cleaner—Wco 10,	sms—Trh, Tebs, Sdh 17 to engine—Wco 17, (7/16), Pcl, Ppn, SCs nces—Feeler gauge, Wco or and refit drain to 7/16 to 500—600 r/min 0, Tbr, Pcl, Pfl ing—Strobe lamp, Wco	o 11					
tg, sealing compound Refit push rods—Moc Refit rocker arm mechani Refit muffler connection Refit muffler connection Refit carburetter—Wco 13 Refit distributor—Wco 13 Refit distributor—Wco 13 Refit distributor—Wco 13 Refit ign leads Refit with coolant—Mfc Refit engine, adjust speed Refit valve clearances Refit valve covers—Schl 1 Refit valve covers—Schl 1 Refit air cleaner—Wco 10, Refit air cleaner—Wco 10, Refit air cleaner—Wco 10,	sms—Trh, Tebs, Sdh 17 to engine—Wco 17, (7/16), Pcl, Ppn, SCs nces—Feeler gauge, Wco for and refit drain to 7/16 to 500—600 r/min 0, Tbr, Pcl, Pfl ing—Strobe lamp, Wco	o 11					
tg, sealing compound Refit push rods—Moc Refit rocker arm mechani Refit muffler connection and Italian Refit carburetter—Wco 13 Refit carburetter—Wco 13 Refit distributor—Wco 13 Refit distributor—Wco 13 Refit ign leads Refit with coolant—Mfc Refit valve clearances Refit valve clearances Refit valve covers—Schl 1 Refit valve covers—Schl 1 Refit valve covers—Schl 1 Refit air cleaner—Wco 10, Start engine	sms—Trh, Tebs, Sdh 17 to engine—Wco 17, (7/16), Pcl, Ppn, SCs nces—Feeler gauge, Wco for and refit drain to 7/16 to 500—600 r/min 0, Tbr, Pcl, Pfl ing—Strobe lamp, Wco	o 11					
tg, sealing compound Refit push rods—Moc Refit rocker arm mechani Refit muffler connection Refit muffler connection Refit carburetter—Wco 13 Refit distributor—Wco 13 Refit distributor—Wco 13 Refit distributor—Wco 13 Refit ign leads Refit with coolant—Mfc Refit engine, adjust speed Refit valve clearances Refit valve covers—Schl 1 Refit valve covers—Schl 1 Refit air cleaner—Wco 10, Refit air cleaner—Wco 10, Refit air speed to 800—900 Refit speed to 800—900 Refit engine	sms—Trh, Tebs, Sdh 17 to engine—Wco 17, (7/16), Pcl, Ppn, SCs nces—Feeler gauge, Wco for and refit drain to 7/16 to 500—600 r/min 0, Tbr, Pcl, Pfl ing—Strobe lamp, Wco	o 11					
tg, sealing compound Refit push rods—Moc Refit rocker arm mechani Refit muffler connection and Italian Refit carburetter—Wco 13 Refit carburetter—Wco 13 Refit distributor—Wco 13 Refit distributor—Wco 13 Refit ign leads Refit with coolant—Mfc Refit valve clearances Refit valve clearances Refit valve covers—Schl 1 Refit valve covers—Schl 1 Refit valve covers—Schl 1 Refit air cleaner—Wco 10, Start engine	sms—Trh, Tebs, Sdh 17 to engine—Wco 17, (7/16), Pcl, Ppn, SCs nces—Feeler gauge, Wco for and refit drain to 7/16 to 500—600 r/min 0, Tbr, Pcl, Pfl ing—Strobe lamp, Wco	o 11					

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

aab Car Di	Vision					Repai	r Work	c — Stan	dard T	imes SA	AAB S	95/96
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per, No	Modelcode	Effective	Secondary time	Lost time allow- ance	Schedule time	Jan. Oper, No		1 odelcode	Effecti		ry Lost time allow- ance	V4 Schedule time
1217	7-	32		3	35							
1225	7–	43		4	47							
1228	7–	683	44	73	800							
1230	7–	302	30	33	365							
1231	7–	33	5	4	42							
1235	7-	21	4	3	28							
1236	7–	312	30	34	376							
1259	7-	18		2	20							
1260	7–	442	30	47	519							
1275	7-	26	7	3	36							
1293	7–	10		1	11							
1299	7–	26	5	3	34							
o this s	heet belong	4 sheets	of repair	work	description							

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Replaces page Pistons, replace others, each 7-21217 Remove conn rod bearing cap-Sdh 1/2, Tebs, Tah Remove conn rod brg Scrape off carbon edge-steel scraper Remove piston from cyl-hammer handle Wipe and check cyl bore Wipe and check conn rod brg and brg surfaces on crankshaft Remove piston rings from new piston-piston ring pliers, SCs Mark conn rod and cap-H, number punch Measure piston clearance-spring balance, feeler gauge 1/2" x 0.03-0.06 mm Measure, adj piston ring gap-feeler gauge 0.25-0.50, 0.38-1.4 mm, thin fine file Refit and adjust piston rings Apply oil and place piston in cyl-oil can, tool 786228, hammer handle Position and oil conn rod brg Fit conn rod bearing cap-Sdh 1/2, Tebs, Tah, Ttg

Piston rings, replace others, each

7-

21225

Remove conn rod brg cap-Sdh 1/2, Tebs, Tah Remove conn rod brg Scrape off carbon edge-steel scraper Remove piston from cyl-hammer handle Wipe and check cyl bore Wipe and check conn rod brg and brg surfaces on crankshaft Remove piston rings-piston ring pliers, SCs Clean piston ring grooves and decarbonize piston top Wash piston-Ck, washing facilities Measure piston clearance-spring balance, feeler gauge 1/2" x 0.03-0.06 mm Measure, adj piston ring gap-feeler gauge 0.25 x -0.50, 0.38-1.4 mm, thin fine file Change conn rod brg cap bolts-H Arrange piston rings Refit, adj piston rings-piston ring pliers SCs Apply oil and fit piston to cyl-tool 786228,

Cylinderblock replace (power unit out) 7-

Fit conn rod brg cap-Sdh 1/2, Tebs, Tah, Ttg

21228

Fit lifting hook-lifting hook 786202 Remove starter motor-Wco 14 Remove LH and RH engine mounting bracket-Wco 12 Fit bracket and place power unit in standengine hoist, slewing fixture Disconnect and remove lifting hook Drain engine oil-Was 19, draining vessel Separate engine at clutch housing-Was 15 Remove gen and fan belt-Wco 1/2, Wco 12

Remove ign leads and distributor-Wco 13 Remove valve covers-Sdhl 10, Tbr, Pcl, Pfl

Remove carburetter-Wco 13, Pcl, Ppn, SCs

Remove inlet manifold-Sdh 13, Tbr

Remove rocker arm mechanisms-Was 13

Remove push rods

hammer handle

Posn and oil conn rod brg

Remove spark plugs-Spark plug wrench Remove cyl heads-Shhd 19, Tah, Tbr

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21217

V4

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Remove tappts-bent wire

73-01-02

Date

Remove crankcase ventilation pipe-Ppo

Remove water manifold-SCs

Remove fuel pump-Wco 13

Remove oil pressure transmitter-Wco 27

Remove oil filter cartridge-tool 786201

Scrape off carbon edge-steel scraper

Remove clutch-3 spacers, Sdh 1/2, Tbr

Remove flywheel-Sdh 16, Tah, Tbr

Remove oilway plug-Wadi

Remove fan-Was 12

Remove balance shaft pulley-Was 17

Remove timing gear cover-Sdh 13, Tbr

Remove timing gear pinion—Was 17, tool 786218

Remove intermediate plate-Was 13

Remove camshaft—Was 13

Remove balance shaft-Hp

(Turn engine over in stand)

Remove sump-Sdh 10, Tbr

Remove oil pump-Wco 10 and 13

Turn crankshaft

Remove crankshaft brg caps

Remove crankshaft bearings

Remove pistons from cylinders-hammer handle

Remove main brg caps-Was 19

Lift out camshaft

Remove main brg shells-SCs

Remove balance shaft seal-Mandrel 786214' H

Remove cyl block from stand

Remove bracket

Unpack new cyl block

Wash both cyl blocks-kerosene

Clean mating surfaces on, and check and inspect,

valve covers, inlet manifold, cyl heads, rocker arm mechanisms, push rods, tappets, sump,

pistons, timing gear cover, intermediate plate, conn

rod and main brgs, crankshaft, camshaft, balance shaft, timing gear pinion, flywheel and clutch-

kerosene bath, knife

Refit bracket on stand, mount new cyl block

in stand-engine hoist

Fit main brg shells

Fit crankshaft

Oil bearings and fit main brg caps (assistant)-

Sdh 19, Tah, Ttg, SCs

Remove piston rings-piston ring pliers, SCs

Measure piston clearance—spring balance, feeler

gauge 1/2" x 0.03-0.06 mm

Clean piston ring grooves and decarbonize piston tops, replace crankshaft brg cap bolts, check and adj piston ring gaps-(or alternatively remove piston rings from new piston, measure piston clearance, check and adj piston ring gap and mark conn rod at cap)-groove scraper, knife, Hp, feeler gauge 0.25-0.50, 0.38-1.4 mm, thin fine file, piston ring pliers,

SCs 2, spring balance, feeler gauge 1/2" x 0.03-

0.06 mm, number punch, H

Arrange piston rings

Fit and adj piston rings-piston ring pliers, SCs

Apply oil and fit pistons to cylinders-tool

786228, hammer handle

Position and oil conn rod brgs

Turn crankshaft

Fit conn rod brg caps 1 Sdh 1/2, Tebs, Tah, Ttg

Check dimension of oil pump drive shaft-slide gauge

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Replaces page Date Edition Page **V4** 73-01-02 21228 7-21228 Oil filter cartridge Bolt (flywheel) Fit camshaft plug Plug (balance shaft) Fit oil pump Plug (camshaft) Fit sump-Ttg Plug (crankcase, ventilation pipe) (Turn engine over in stand) Locating sleeve (cyl head and clutch housing) Fit balance shaft-tool 786215, H Fit main brg seal-tool 786216, H Fit locating sleeves for cyl head and clutch Pistons, replace 1st (power 21230 7housing-Hp unit out) Fit plug and pipe for crank case ventilation Fit lifting hook—lifting hook 786202 Fit oilway plug Remove starter motor-Wco 14 Fit flywheel-Sdh 16, Tah, Tbr, Ttg Fit and adj camshaft-Was 13, Sdh 13, Ttg, Remove LH engine mounting bracket-Wco 12 Fit bracket and place power unit in stand,—engine hoist Fit intermediate plate-Was 13, sealing compound Disconnect and remove lifting hook Fit timing gear pinion Drain engine oil-Was 19, draining vessel Fit balance shaft seal-Mandrel 786215, H Separate engine at clutch housing-Was 15 Fit timing gear cover-Sdh 13, Tbr, Ttg, Remove gen and fan belt-Wco 1/2, Wco 12 sealing compound Remove ign leads and distributor-Wco 13 Fit balance shaft pulley Remove valve covers-Sdhl 10, Tbr, Pcl Fit fan Remove carburetter-Wco 13, Pcl, Ppn, SCs Fit oil filter cartridge Remove inlet manifold-Sdh 13, Tbr Fit oil pressure transmitter Remove rocker arm mechanisms-Was 13 Fit fuel pump Remove push rods Fit water manifold Clean flywheel, disc and pressure plate-Remove cyl heads (2)-Shhd 19, Tah, Tbr emery cloth, trich Remove tappets-bent wire Fit clutch-Sdh 1/2, Tbr, Ttg, Tool 784060 Scrape off carbon edge-steel scraper Oil and fit templates (turn engine over in stand) Fit cyl head-Shhd 19, Tebs, Tah Ttg Remove sump-Sdh 10, Tbr Fit push rods (turn engine over in stand) Fit and oil rocker arm mechanisms-Was 13 Remove oil pump-Wco 10 and 13 Fit inlet manifold-Sdh 13, Tbr, Tebs, Turn crankshaft Ttg, sealing compound Remove conn rod brg caps-Sdh 1/2", Tebs, Tah Fit carburetter Remove conn rod brgs Coarse adj valves-feeler gauge 786239, Wco 11 Fit valve covers Remove pistons from cylinders-hammer handle Clean, adj and fit spark plugs-steel wire brush, Wipe clean and check all cylinders knife, spark plug tool, spark plug wrenches Wipe clean and check crankshaft brg and brg surface of Fit distributor and ignition leads Assemble lifting hook and connect Clean mating surface on, and wash, cyl head, inlet manifold, Fit gen fanbelt rocker arm mechanisms, valve covers and sump-knife, Fill with engine oil-filling vessel kerosene bath Assmeble lifting hook and connect Clean mating surfaces on engine block, knife Remove power unit from stand Remove piston rings from new piston-piston ring pliers,SCs Remove bracket Mark conn rod and clamp-H, number punch Fit drain plugs to block-Wco 11 Measure piston clearance—spring balance, feeler gauge 1/2" Fit RH and LH engine mounting bracket x 0.03 - 0.06 mm Fit starter motor Place power unit on floor Measure, adj piston ring gap-feeler gauge 0.25 -0.50, Disconnect and remove lifting hook 0.38 - 1,4 mm, thin fine file Separate, wipe/blow and assemble air Fit, adj piston rings-piston ring pliers, SCs cleaner-Wco 10 Oil piston, place in cyl-oil can, tool 786228, hammer handle Spares: Pos and oil conn rod brgs Cyl block Fit conn rod brg caps-Sdh 1/2, Tebs, Tah, Ttg Piston ring set Check dimension of oil pump driveshaft-slide gauge Bolt (conn rod brg) Fit oil pump-Wco Alt. piston with conn rod, std Fit sump-sealing compound-Sdh 10, Tbr, Ttg Gasket (oil pump) (Turn engine over in stand) Gaskets (timing gear cover) Wipe clean, check, oil and fit tappets Gasket (fuel pump) Fit cyl head-Shhd 10, Tebs, Tah, Ttg, Gasket set Fit push rods Sealing ring (crankshaft) Fit rocker arm mechanisms-Was 13 Sealing ring (balance shaft) Fit inlet manifold-Sdh 13, Tbr, Tebs, Ttg, sealing compound

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		73 – 01 – 02	1	21230 V4
	7 04000			
Eit aavhusattas	7- 21230	Remove ign leads a		
Fit carburetter	700000 W 44	Remove valve cover		
Coarse adj valves—feeler gauge	786239, Wco 11	Remove carburette	r-Wco 13, Pcl,	Ppn, SCs
Fit valve covers		Remove inlet manif	fold-Sdh 1 <mark>3,</mark> T	br
Fit distributor and ign leads		Remove rocker arm	mechanisms—	Was 13
Assemble engine to clutch hou		Remove push rods		
Fill with engine oil—filling ves		Remove cyl heads (2)-Shhd 19, T	ah, Tbr
Assemble lifting hook and con		Remove tappets-b		
Remove power unit from stand	d	Scrape off carbon e		per
Remove bracket		(Turn engine over in		
Fit drain plugs to block-Wco	11	Remove sump—Sdh		
Fit LH engine mounting brack	et	(Turn engine over in	n stand)	
Fit starter motor		Remove oil pump-	Wco 10 and 13	
Place power unit on floor		Turn crankshaft		
Disconnect and remove lifting	hook	Remove conn rod b		/2'', Tebs, Tah
Spares:		Remove conn rod b		
Piston with conn rod (complet	te) std	Remove pistons fro		ammer handle
Gasket (oil pump)	OF COLUMN	Wipe clean and che		
Gasket (sump)			ck crankshaft b	rg and brg surface of crank
Seal (sump)		shaft	a mistan aliana	SC ₂
Seal (sump)		Remove piston ring		
Gasket set			ooves and deca	rbonize piston top-knife,
- Gusket set		groove scraper		
Cylinder bores and pistons (al	1), 7- 21231		es on, and was	h, piston, cyl head, inlet
gauging (pistons out)	.,,	manifold,		
		rocker arm mechan	isms, valve cove	ers and sump-knife, keros
Obtain bore dial gauge, micror		bath		
Read workshop manual and no	ote tolerances-workshop	Clean mating surface		
manual		Measure piston clea	rance—spring b	alance, feeler
Set dial gauge, micrometer 75	-100	gauge 1/2" x 0.03 -	0.06 mm	
Collect stand with pistons-pis	ston stand	Measure, adj piston	ring gap-feele	r gauge 0.25 - 0.50,
Place piston in vice, measure,	place piston in stand-micro-	0.38 - 1.4 mm, thin	fine file	
meter 75-100, vice		Replace conn rod b	rg cap bolts-H	р
Note measurements-noteboo	k	Arrange piston ring	5	
Put away stand with pistons		Fit, adj piston rings	piston ring pl	iers, SCs
Measure ovality and taper of b	oores-bore dial gauge			ool 786228, hammer
Note measurements		handle		
Replace dial gauge and micron	neter in box	Posn and oil conn r	od bras	
		Fit conn rod brg ca		ebs. Tah. Ttg
		Check dimension of		
Cylinder bores (all), gauging	7- 21235	Fit oil pump-Wco		
(pistons out)	, 21200	Fit sump—sealing c	ompound —Sdh	10 Tbr Tta
		(Turn engine over i		. 10, 10., 119
Obtain bore dial gauge, micro		Wipe clean, check,		ets
Read workshop manual and no	ote tolerances-workshop	Fit cyl heads—Shho		
manual		Fit push rods	i io, iebs, iair	, 119
Set dial gauge, micrometer 75	—100	Fit rocker arm med	hanisms Was 1	2
Measure ovality and taper of b	oores-bore dial gauge			
Note measurements			Sun 13, 101, 1	ebs, Ttg, sealing compoun
Replace dial gauge and micror	neter in box	Fit carburetter(s)	700	2000 W 11
		Coarse adj valves—f	eeier gauge 786	239, WCO 11
		Fit valve covers		
Piston rings replace, 1st pistor	n 7– 21236	Fit distributor and		
(power unit out)		Assemble engine to		
Fit lifting book lifting book	786202	Fill with engine oil-		
Fit lifting hook—lifting hook		Assemble lifting ho		
Remove starter motor—Wco 1		Remove power unit	t from stand	
Remove LH engine mounting		Remove bracket		
Fit bracket and place power u		Fit drain plugs to b	lock-Wco 11	
Disconnect and remove lifting		Fit LH engine mou	nting bracket	
Drain engine oil-Was 19, drai		Fit starter motor		
Separate engine at clutch hou		Place power unit or	n floor	
Remove gen and fan belt-Wo	o 1/2, Wco 12			

Remove gen and fan belt-Wco 1/2, Wco 12

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V4

21299

SAAB-SCANIA Saab Car Division Date Edition Replaces page 73 - 01 - 021 7-21236 Pistons, remove-install 1st (cyl head and 7sump off) Disconnect and remove lifting hook Remove oil pump-Wco 10 and 13 Compressing ring, std Turn crankshaft Oil scraper ring Remove conn rod bearing caps—Sdh 1/2, Tebs, Tah Expander ring Remove conn rod bearing Bolt (conn rod) Scrape off carbon edge-steel scraper Gasket (oil pump) Remove piston from cylinder-hammer handle Gasket (sump) Wipe clean and check cylinder Seal (sump) Wipe clean and check conn rod bearing and bearing surface Gasket set on crankshaft Replace conn rod brg cap bolts-Hp Adjust piston ring-SCs Pistons, remove-install others, each 21259 Oil piston and place in cylinder-oil can, tool 786228, (cyl heads and sump off) hammer handle See Operation No 21299 (7-) excl remove-install oil pump Position and oil conn rod brgs and check dimensions of oil pump driveshaft. Fit conn rod brg caps-Sdh 1/2, Tebs, Tah, Ttg Check dimensions of oil pump driveshaft-slide gauge Fit oil pump Piston rings, replace all, (power unit out) 7-21260 See Operation No 21236 (7-) Spares: Piston ring set, std Bolt (conn rod) Gasket (oil pump) Gasket (sump) Seal (sump) Gasket set Cyl bores, honing, 1st 7-21275 Turn engine over Cover with rags Assemble power drill with other honing equipment—hand power drill 5/8 (250)-450 r/m) SUNNEN grinding head 903-AN-110 Set stroke Grind (with cyl bore horizontal) Measure piston clearance-spring balance, feeler gauge 1/2" x 0.03 - 0.06 mm Clean bore-kerosene, rags Remove rags Turn engine over Remove and clean honing equipment

7-

21293

Saab-Scania - Service Department-Kundendienstabteilung Cyl bores, honing, others, each Turn engine over Grind Measure piston clearance Clean bore Turn engine over

SAAB-SCANIA

Repair Work - Standard Times SAAB 95/96

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Oper, No	Modelcode	Effectiv	e Secondary time	Lost	Schedule time	Oper. No	Modelcode	Effective		y Lost time	Schedule time
				allow-			l	1	1	allow- ance	
0.101		5.0		6	6.4	04470	7	0.4		40	440
21401	7-	53	2	6	61	21479	7-	94	6	10	110
21404	7–	282	22	30	334	21480	7–	10	1	1	12
21405	7–	13	2	2	17	21482	7–	45	5	5	55
21407	7-	2		1	3	21487	7–	36	2	4	42
21409	7-	3		1	4	21491	7-	225	15	24	264
21414	7-	20	5	3	28	21495	7-	13	3	2	18
21415	7-	20	8	3	29	21497	7-	7	1	1	9
21426	7-	51	13	6	70	1					
21431	7-	3			3	To this	sheet belor	ng 5 sheet	s of repa	air wor	k descript
21433	7-	19	2	2	23						
21434	7-	44	6	5	55						
21436	7-	33	5	4	42						
21437	7-	9		1	10						
21438	7-	143	13	16	172						
21439	7-	7	1	1	9						
						1					
21440	7-	41	4	5	50						
21443	7-	365	17	38	420						
21445	7-	4			4						
21446	7-	81	6	9	96						
21447	7-	14	1	2	17						
21447	7-	211	10	22	243						
21450	7-	106	6	11	123						
21454	7-	443	22	47	512						
21455	7-	11	3	1	15						
21457	7-	4	2	1	7						
21458	7-	88	13	10	111						
21461	7-	28	2	3	33						
21470	7-	6	1	1	8						
21472	7-	26	5	3	34						
61412	/	20	J	J	0+						

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			73-01-02		21401	
Valve seat milling (all) 2 cyl heads	7-	21401	Valve spring an	d/or seal, replace	1st 7—	2141
z cyr neads			Remove rocker	arm mechanism	-Was 13	
See Operation No 21461			Remove 1 spar			
			Release grip of	retainer-H, pied	e of tubing (ID	22 mm)
	100 V =			compressor-Va	lve spring comp	ressor
/alves, decarbonizing (excl ma	ichining) 7—	21404	786240, Wco 1		W	
I cyl head				er, washer, spring	and seal—Tool	
Remove cyl head, Operation N	o 21170		786227, SCcs	washer and retai	ner	
Valves, decarbonizing (excl ma	chining) cyl head o	off,		pring compressor		
Operation No 21450			Knock on valve	spring washer-I	- Ip	
Refit cyl head, Operation No 2	1172			spark plug-Cwb		
Spares:				m mechanism-k		
Oil seal			Fit rocker arm	mechanism—Was	13, San 13, 11g	
Valve spring						
Valve			Value amine on	d/or seal, replace	1st. 7-	21426
Cyl head gasket			cyl head	d/or seal, replace	1st, /-	2142
nlet manifold gasket			**			
Valve cover gasket				aner–Wco 10, Pc	ļ.	
Flange gasket			Remove ign lea			
				over-SdhI 10, T		
				arm mechanism	-Was 13	
Valve grinding (valve out), 1st	7–	21405	Remove 1 spar			٠. ١
Arrange grinding machine, sha	rpen grinding whee	al		retainer-H, piec		
Mount valve			786240, Wco 1	compressor—val	ve spring compr	essor
Grind valve—valve grinding ma	chine			, er, washer, spring	and seal-Tool	786227.
Remove valve from grinding m	achine		SCcs	.,		
Wash valve—kerosene bath				washer, retainer		
Wipe dry, lubricate and cover (rinding machine			pring compressor		
				spring washer—		
Value minding (males and) add		01407		spark plug-Cwb		
Valve, grinding (valve out) oth	ers, each 7-	21407	Wash rocker ar	m mechanism an	d valve—cover k	erosene
Mount valve				m mechanism—W	Inc 12 Cdb 12 T	E+a
Grind valve—valve grinding ma				m mechanism—w over gasket—Ck	as 15, Sull 15,	ı ıg
Remove valve from grinding m	achine		Mount valve co			
Wash galve-kerosene bath			Refit ign leads	7701 (2 50110)		
			Start engine			
Valve guide reaming, others, g	uide and 7—	21409	Warm up			
limensions	riue anu 7—	21409	Adjust speed to	500-600 r/min	-SCs	
			Stop engine			
_ubricate and ream valve guide			The second secon	ids and valve cover	er ·	
Blow clean reamer and valve g	uide–Holder, cuttii	ng oil	Start engine			
(kerosene)				earance-feeler ga	auge 786239, W	co 11
Check valve guide			Stop engine			
			Refit valve cov	er		
Valve covers, fit new gasket, 1	7-	21414	Refit ign leads			
			Refit air cleane	er		
Remove air cleaner—Wco 10			Start engine	2		
Remove ign leads				o 800–900 r/mir		
Remove valve cover—Sdhl 10,	Ibr		Stop engine			
Replace gasket–Ck	th Con		Spares:			
Refit valve cover-kerosene ba	tn, Cag		Valve cover gas	sket		
Refit ign leads			gu			
Start engine						
Refit air cleaner Check sealing			Rocker arm as	semblies, valve	7-	2143

Remove adjusting screw—Was 11

Fit adjusting screw

	Replaces page		73-01-02	Edition 1	Page 21433	
Valves, grinding with paste, 1	cyl head 7-	21433	Valve springs and/			21438
Apply grinding paste and oil		nacto			,	21100
Grind valve and seat—Grindir		paste	Remove air cleane Remove ign leads	r—vvco 10, Pci		
Wipe clean and check surface	1 Total Control of the Control of th		Remove valve cove	re_Sdbl 10 Ti	or Pol	
			Remove rocker arr			
			Slacken and "swin			3
Rocker arm mechanisms, rec	ond 1 7—	21434	Remove all spark p			
Remove ari cleaner-Wco 10			Release grip of ret			22 mm)
Remove spark plug leads			Fit valve spring co			
Remove valve cover—Sdhl 10	Thr		786240, Wco 17			
Remove rocker arm mechanis			Remove retainers,	washers, spring	is and seals—T	ool
Disassemble rocker arm mech			786227, SCcs		-1	
Inspect, replace defective par			Fit seals, springs, v		amers	
Assemble rocker arm mechan			Remove valve com			
Refit rocker arm mechanism-	-Was 13, Sdh 13, Tte	g	Knock on valve sp		In	
Adjust valves- feeler gauge,			Clean and fit all sp			
Replace valve cover gasket—C	Ck, kerosene, bath, C	ag	Reposition general	The second secon	, ,	
Wash, refit valve cover			Tighten fan belt			
Refit plug leads			Wash rocker arm n	nechanisms and	l valve covers-	-kerosene
Start engine			bath			
Check sealing			Fit rocker arm me		13, Sdh 13, T	tg
Stop engine Refit air cleaner			Replace valve cove			
Adjusting screw replacement	not included		Position valve cove	ers (2 bolts)		
Adjusting screw replacement	not included		Refit ign leads			
Spares:			Start engine			
Rocker arm shaft			Warm up	00 600 #/min	CC.	
Rocker arm			Adjust speed to 50 Stop engine	000 r/min-	SUS	
Adjusting screw			Remove ignition le	ads and valve o	over_refit	
Valve cover—gasket			Start engine	ads and varve e	.0001 10111	
			Adjust valve cleara	nces-feeler gar	uge 786239. V	Vco 11
Valve covers, fit new gaskets,	.2 7-	21436	Stop engine		,	
		21100	Refit valve covers			
Remove air cleaner,—Wco 10	1 1 1 1 1 1 1 1 1 1 1		Refit ign leads			
Remove ign leads	0.71		Refit air cleaner			
Remove valve covers—Sdhl 1 Change gaskets—Ck	U, Ibr		Start engine			
Refit valve covers—kerosene	hath Can		Adjust speed to 80	00-900 r/min		
Refit ign leads	batir, Cag		Stop engine			
Start engine			Spares:	*		
Refit air cleaner			Valve cover gasket	S		
Check sealing			-			
Stop engine						
		-	Rocker arm mecha	inisms, remove-	install 7—	21439
			1, valve cover off			
Valve springs and/or seals, re		21437	Remove rocker arr	m mechanism—	Was 13	
others, each (valve covers off			Refit rocker arm n	nechanism-Wa	s 13, Sdh 13,	Ttg
Remove 1 spark plug-Wspp			A ltrace			
Release grip of retainer-H, p		2 mm)	Valves adjust, incl	gaskets replace	7-	21440
Turn or move valve spring co		0007 00	(excl warming up)			
Remove retainer, washer, spr Fit seal, spring, washer, retai		86227, SCcs		. 100- 10		
Knock on valve spring washe			Remove air cleane			
Clean and fit 1 spark plug—C			Remove ignition le		ar.	
	, , , , , , , , , , , , , , , , , , ,		Remove valve cove			
			Adjust valves—feel			
			Replace gaskets—C Wash, refit valve c		iii, Gay	
			Refit ignition lead			
			Start engine	3		
			Fit air cleaner			

Fit air cleaner

SAAB-SCANIA

Saab Car Division

Repair Work Description SAAB 95/96

Replaces page Date Edition Page 73-01-02 21440 7-21440 Valve decarbonizing (excl machining) 7-21448 Check sealing 2 cyl heads (cyl heads off) Stop engine See Operation No 21450 Spares: Valve decarbonizing (excl machining) 7-21443 Oil seal 2 cyl heads (engine in stand) Valve spring Valve Operation No 21113 cyl head replace, excl transfer of 4 studs Operation No 21450 valves, decarbonizing, excl machining Valve decarbonizing (excl machining) 7-21450 (cyl head off) 1 cyl head (cyl head off) Spares: Mount cyl head in stand Oil seal Remove spark plugs-Wspp Valve spring Decarbonize combustion chamber and valve tops—power Valve drill, steel wire burr Cyl head gasket Remove valve springs-Hp, valve compressor Inlet manifold gasket Check play in valve guides Valve cover gasket Remove valves and seals Decarbonize ducts in cyl head-power drill, steel wire burrs, steel scrapers 21445 Valve turning (valve out), others, each Blow clean cyl head Mount valve Decarbonize valves-jack, Ck, power drill, steel wire burr Turn valve (0.05 mm cutter) -HUNGER valve lathe Wipe clean valves and seats Remove valve from lathe Check valve sealing surfaces—marking dye Clean valve-kerosene bath Remove cyl head from stand Wash cyl head, valves, springs, retainers and washerskerosene bath, wire mesh basket Rocker arm mechanisms, recond 2 21446 7-Mount cyl head in stand (excl warming up) Fit valves and seals Fit valve springs Remove air cleaner-Wco 10 Clean and refit spark plugs-Cwb, Ck, Wspp Remove spark plug leads Remove cyl head from stand Remove valve covers-Sdhl 10, Tbr Remove rocker arm mechanisms-Was 13 Spares: Disassemble rocker arm mechanisms-H, mandrel Oil seal Inspect, replace defective parts Valve spring Assemble rocker arm mechanisms Valve Refit rocker arm mechanisms-Was 13, Sdh 13, Ttg Adjust valves-feeler gauge, Wco 11 Replace valve cover gaskets-Ck Valves, decarbonizing (excl machining) 21454 Wash, refit valve covers 2 cyl heads Refit plug leads Remove cyl heads, Operation No 21180 Start engine Valves, decarbonizing (excl machining) cyl heads off, Check sealing Operation No 21450 Stop engine Refit cyl head, Operation No 21182 Refit air cleaner Adjusting screw replacement not included Spares: Oil seal Spares: Valve spring Rocker arm shaft Valve Rocker arm Cyl head gasket Adjusting screw Inlet manifold gasket Valve cover gasket Valve cover gasket Flange gasket Rocker arm mechanisms. 21447 remove install 2, valve covers off Valves, turning (valve out), 1st 7-21455 Remove rocker arm mechanisms-Was 13 Arrange lathe Refit rocker arm mechanisms-Was 13, Sdh 13, Ttg

Mount valve

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		73-01-02	1	21455	
Turn valve (0.05 mm cutter)—HURemove valve from lathe Clean valve—kerosene bath Wipe clean, lubricate and cover lateral valve guide reaming, 1st (1 dimensional distribution).	the nsion) 7— 21457	Valve seat milling Take tool from bo Fit pilot arbor—Ne Cut valve seats—ty Check adjust if nee Remove pilot arbo Clean tool, place in Blow clean cyl hea	x eway valve seat pe 8–311–SA c, seat width–s r n box	cutter	2146
Blow clean reamer and valve guid (kerosene) Turn cyl head Check valve guide Turn cyl head Valve springs and/or seals, replace 2 cyl heads	e—Holder, cutting oil	Rocker årm mecha Remove air cleane Remove plug leads Remove valve cove Remove rocker me	r–Wco 10 er–Sdhl 10, Tb	or	2147
Remove air cleaner—Wco 10, Pcl Remove ignition leads Remove valve covers—Sdhl 10, Tk Remove rocker arm mechanisms— Remove 2 spark plugs—Wspp Release grip of retainer—H, piece Fit valve spring compressor—valve 786240, Wco 17 Remove retainer, washer, spring a SCcs Fit seal, spring, washer and retain Move valve spring compressor Replace 1st valve spring and/or se Remove valve spring compressor Knock on valve spring washers—h	of tubing (ID 22 mm) e spring comressor and seal—Tool 786227, er eal on 2nd cyl head	Rocker arm mechanisms and pust valves—feel Replace valve cover Refit valve cover Refit plug leads Start engine Check sealing Stop engine Refit air cleaner Spares: Valve cover gasket	nechanism—Wa er gauge 0.40 r er gasket—Ck, k	as 13, Sdh 13, 1 mm, Wco 11	
Clean and fit 2 spark plugs—steel plug tool Wash rocker arm mechanisms and bath Refit rocker arm mechanisms—W Change valve cover gaskets—Ck Mount valve covers (2 bolts) Refit ignition leads Start engine Warm up Adjust speed to 500—600 r/min—Stop engine Remove ign leads and valve cover Start engine Adjust valve clearance—feeler gaustop engine Refit valve cover Refit ign leads	wire brush, knife, spark I valve covers—kerosene as 13, Sdh 13, Ttg -SCs 5.3	Valve springs and/ (valve covers off) Remove rocker arr Slacken and "Swir Remove all spark p Release grip of ret Fit valve spring co 786240, Wco 17 Remove retainers, Fit seals, springs, v Turn or move valv Remove valve com Knock on valve sp Clean and fit all sp Reposition general Wash rocker arm me	m mechanisms- ag out" generate blugs—spark plus ainers—H, piece mpressor—valv washers, spring vashers and rete e compressor ring washers—h bark plugs— tor—tighten fainechanisms	-Was 13 tor-2 x Wco 13 ug wrench ee of tubing (ID e spring compre gs, seals tainers	22 mm)
Refit air cleaner Start engine Adjust speed to 800–900 r/min Stop engine Spares: Valve spring Oil seal Valve cover gasket		Rocker arm mechanger Remove air cleane Remove plug leads Remove valve cover Remove rocker arm	r-Wco 10 ers-Sdhl 10, T	'br	21480

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locker arm mechanisms, instal	12 7-	21482			
Refit rocker arm mechanisms—		Ttg			
djust valves-feeler gauge, Wc					
Replace valve cover gaskets-Cl	k				
Replace valve covers					
lefit plug leads tart engine					
tart engine theck seals					
top engine					
Refit air cleaner					
pares:					
/alve cover gasket					
arve cover gasker					
alve grinding with paste, 2 cy	I heads 7—	21487			
ee Operation No 21433					
alve decarbonizing (excl macl	hining) 7—	21491			
cyl head (engine in stand)					
peration No 21111 cyl head r	eplace excl transfe	r 2 studs			
peration No 21450 valves, de	carbonizing excl m	achining,			
cyl head off)		16			
pares:					
Dil seal					
alve spring					
'alve					
Cyl head gasket					
nlet manifold gasket					
/alve cover gasket					
Rocker arm mechanisms (off),	recond 7-	21495			
ach		+			
Disassemble rocker arm mecha	nism—H, mandrel				
nspect, replace defective parts					
Assemble rocker arm mechanis					
Adjusting screw replacement n	ot included				
pares:					
Rocker arm shaft					a a
Rocker arm					
Adjusting screw					
Generator (loosen and fix)	7-	21497			
.oosen gen and fixing bolts—2	v Woo 12				
.ift off fan belt and swing gen					
wing gen inwards	Gutwarus				
Refit and tighten fan belt					
This time is taken when replace	cing springs and/or	seals on			
yl No 1. Not Operations No 2	1438 and 21479).				

		IR	leplaces page	Э		Date		Edition	777	Page	•			
						Jan. 19	73	1		21	502 -	2154	9 \	4
Oper, No.	Modelcode	Effective	Secondary time	Lost time allow- ance	Schedule time	Oper, No	Mod	delcode	Effect time	ive	Second time	ary Lo tim allo and	e ti	chedule me
21502	7–	160	12	17	189									
21504	7-	167	12	18	197									
21505	7-	117	21	14	. 152									
21521	7-	204	12	22	238									
21529	7-	107	22	13	142									
21531	7-	15	1	2	18									
21533	7-	294	18	31	343									
21535	7–	19	1	2	22									
21542	7-	445	21	47	513									
21543	7–	93	11	10	114									
21545	7–	82	11	9	102									
21546	7-	151	9	16	176									
21547	7–	187	11	20	218									
	7–	122	22 -	14	158									

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Replaces page Date Edition Page 73-01-02 **V4** 21502 7-Timing gear cover, fit new gasket 21502 Remove hoses from water pump-SCs 7, Pcl (in car) Turn engine over in stand Remove sump-Sdh 10 + Tbr Remove-install engine hood-Ppn Turn engine over in stand Open coolant drain cock on radiator-Wco 7/16 Remove timing gear cover Disconnect—connect ground lead from/to battery—Wco 1/2 Remove balance shaft seal—H + mandrel 786214 Remove front panel-Was 7/16, SCcs, Wco 1/2, Ppn Clean sump, timing gear cover and other components— Remove radiator-SCs, Wco 1/2, Was 1/2 kerosene bath Remove gen Change sump gasket Remove hoses from coolant pump-Pcl Change outer timing gear gasket-knife, sealing compound Remove fan and pulley-Was 1/2 Fit balance shaft seal—H + mandrel 786215 Remove balance shaft pulley-Was 17 Fit timing gear cover-Sdh 13 + Tbr, Ttg, centering mandrel Remove timing gear cover bolts and 5 sump bolts-Sdh 13, Tbr 786214 Remove cover and place rag over sump Connect hoses to water pump Scrape off gasket between plate and sump-Ck Fit balance shaft pulley-Was 17, Sdh 17 + Ttg Scrape off gasket from timing gear cover Fit gen and fan belt Remove balance shaft seal-H, + mandrel 786214 Turn engine over in stand Wash timing gear cover Fit sump-Sdh 10 + Tbr, Ttg Fit sump gasket Turn engine over in stand Apply adhesive and position sump and timing gear cover Fill engine with oil-filling vessel gasket-sealing compound Connect lifting hook Fit balance shaft seal-786215 Remove engine from stand, remove bracket Postion timing gear cover Refit LH engine mounting bracket Fit fixing screws to cover and sump-Ttg Refit starter motor Fit balance shaft pulley Disconnect lifting hook Fit pulley and fan blades Fit hoses to coolant pump Spares: Fit gen and belt Timing gear cover gasket Fit radiator Sealing ring Fit front panel (1967-1968) Sump gasket Check engine oil level,-fill with coolant-Mfc Check hood lock Start-stop engine, check sealing Camshaft, replace in car (cyl head off) Spares: Remove front panel-Was 7/16, SCcs 2, Wco 1/2, Ppn Timing gear cover gasket Remove radiator-PcI, Wco 1/2, Was 1/2 Sump gasket Remove gen-Wco 13 Balance shaft gasket Remove fuel pump with push rod-Wco 9/16 Remove tappets-bent wire Remove balance shaft pulley-Was 17 21504 Camshaft pinion, replace in car 7-Remove hoses from coolant pump-Pcl Remove fan with pulley-Was 1/2 See 21502, adding the following: Remove timing gear cover-Sdh 13, Tbr Check pinion Remove timing gears-Was 17 Remove camshaft pinion-Was 17 Remove camshaft-Was 13 Fit camshaft pinion Remove-install balance shaft seal-786214 and 786215 Spares: Clean, wash timing gear cover-Ck, kerosene bath Timing gear cover gasket Clean mating surface on intermediate plate and sump-Ck Sump gasket Fit sump gasket,-sealing compound Balance shaft gasket Fit camshaft-Was 13 + Sdh 13, Ttg, micrometer Camshaft pinion Refit timing gear pinion-Was 17, Sdh 17, Ttg Apply adhesive and position timing gear cover gasketsealing compound 21505 Timing gear cover, fit new gasket 7-Refit timing gear cover-786214 (power unit lifted out) Refit pulleys and fan Refit hoses to pump Remove starter motor-Wco 14 Refit generator and belt Remove LH engine mounting bracket-Wco 12 Refit tappets Fit bracket and install power unit in stand-engine hoist Refit fuel pump Disconnect lifting hook Refit radiator Drain engine oil-Was 19, draining vessel Refit front panel

Check hood lock

Remove gen and fan belt-Wco 13

Remove balance shaft pulley-Was 17

Saab Car Division	Repair Work Description SAAB 95/96
Replaces page	Date Edition Page 73-01-02 1 21521 V4
	73-01-02 1 21521 V4
7- 21521	Remove inlet manifold-Sdh 13 + Tbr
Spares:	Remove rocker arm mechanisms—Was 13
Camshaft	Remove push rods
iming gear cover gasket	Remove cyl heads—Shhd 19 + Tah
Sump gasket	Remove tappets—bent wire
	Turn engine over in stand
Fiming gear cover replace (power unit 7- 21529	Remove sump—Sdh 10 + Tbr
ifted out)	Remove gen and fan belt – Wco 13
	Remove balance shaft pulley—Was 17 Disconnect hoses from water pump—SCs 7, Pcl
Remove starter motor—Wco 14	Remove timing gear cover—Sdh 13 + Tbr
Remove LH engine mounting bracket—Wco 12	Remove timing gears—Was 17
Fit bracket and install power unit in stand—engine hoist Disconnect lifting hook	Remove camshaft—Was 13
Drain engine oil—Was 19, draining vessel	Remove balance shaft seal—H + mandrel 786214
Remove gen and fan belt–Wco 13	Clean timing gear cover
Remove fan and fan belt pulley–Was 1/2	Change sump gasket
Remove balance shaft pulley—Was 17	Change outer timing gear cover and gasket—Ck, adhesive
Remove water pump—Was 10	Fit balance shaft gasket—H + mandrel 786215
Turn engine over in stand	Fit camshaft—Was 13, Sdh 13 + Ttg, micrometer
Remove sump—Sdh 10 + Tbr	Refit timing gear cover-Sdh 13 + Tbr, Ttg, centring
Turn engine over in stand	mandrel 786214
Remove timing gear cover—Sdh 13 + Tbr	Reconnect hoses to water pump
Clean sump	Refit balance shaft pulley—Was 17, Sdh 17 + Ttg
Change sump gasket	Refit gen and fan belt
Change outer timing gear gasket—Ck, permatex	Turn engine over in stand
Refit timing gear cover-Sdh 13 + Tbr, Ttg, centring mandrel	
786214	Turn engine over in stand
Refit water pump	Refit tappets
Refit balance shaft pulley—Was 17, Sdh 17 + Ttg	Refit cyl heads—Shhd 19 + Tah, Ttg
Refit fan and fan belt pulley	Refit push rods
Fit gen and fan belt	Refit rocker arm mechanisms—Was 13, Sdh 13 + Ttg
Turn engine over in stand	Refit inlet manifold—Sdh 13 + Ttg
Fit sump—Sdh 10 + Tbr, Ttg	Refit carburetter
Turn engine over in stand	Adjust valves—feeler gauge 0.40 mm, Wco 11 Change valve cover gaskets—Ck
Fill engine with oilfilling vessel Connect lifting hook	Refit valve covers
Remove engine from stand, remove bracket	Refit distributor
Refit LH engine mounting bracket	Fill engine with oil—filling vessel
Refit starter motor	Remove-install fuel pump
Disconnect lifting hook	
	Spares:
Spares:	Camshaft Timing door nover gookst
Timing gear cover gasket	Timing gear cover gasket Sump gasket
Sealing ring Sump gasket	Cyl head gaskets
South Agreet	Inlet manifold gasket
	Valve cover gaskets
Timing gear pinion, replace (engine 7— 21531	
in stand) timing gear cover off	
	Timing gear cover gasket, inner 7- 21535
Remove timing gear pinion—Was 17	replace (timing gear cover off)
Install timing gear pinion—Was 17, Sdh 17 + Ttg	
Spares:	Remove camshaft gear—Was 17 Remove intermediate plate—Was 13
Timing gear pinion set	Change inner timing gear cover gasket—Ck, permatex
	Refit intermediate plate
	Refit camshaft gear—Was 17, Sdh 17 + Ttg
Camshaft replace (engine in stand) 7— 21533	Therit Camanart gear—was 17, Sun 17 + 1 tg
	Spares:
Drain engine oil—Was 19, draining vessel Remove distributor—Wco 13	Gasket
Remove valve covers—Sdhl 10 + Tbr	The second secon
Remove carburetter—Woo 13	

Remove carburetter-Wco 13

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	<u> </u>	73-01-0			
Camshaft, replace in car (incl v	/alves 7— 21542	Remove valve co	.orc		
adjust)	aives 7— 21342	Start engine	7613		
		Adjust valve clear	cananc		
Open coolant drain cock on ra		Stop engine	arices		
Remove-install engine hood—P	•	Refit valve covers	verith contilotio	on been	
Disconnect-connect earth (ground	und) cable from/to battery	Reconnect ign lea		on nose	
-Wco 7/16		Refit air cleaner	aus		
Remove front panel-Was 7/16	S, SCcs 2, Wco 1/2, Ppn	THE RESERVE OF THE PERSON OF T	and fulfilled the second	000 000/ .:	21
Remove radiator-Pcl, Wco 1/2	2, Was 1/2	Start engine, adju	ist lating speed	800-900 r/mi	n
Remove air cleaner-Wco 10		Stop engine			
Remove distributor, ign leads-	-Wco 13	Spares:			
Remove gen-Wco 13		Timing gear cove	r gasket		
Remove valve covers-Sdhl 10,	, Tbr	Camshaft	, , , , , , , , , , , , , , , , , , ,		
Remove carburetter(s)-Wco 1	3	Sump gasket			
Remove inlet manifold-Sdh 1	3, Tbr	Cyl head gaskets			
Remove fuel pump and push re	od-Wco 9/16	Inlet manifold ga	sket		
Remove rocker arm assemblies	-Was 13, Sdh 13, Ttg	Valve cover gaske			
Remove push rods		Exhaust flange ga			
Disconnect muffler, remove 2	cyl heads-Wadj 19, Tah, Wco	15			
Sdh 15, Tebl, Tah					
Remove tappets-bent wire		Timing gear cove	r fit new gaske	t 7–	2154
Remove balance shaft pulley-	Was 17	(engine in stand)	, it note gaste		_,,
Disconnect hoses from coolant					
Remove fan and pulley-Was 1	/2	See Operation No	21505, excl p	ower unit into	and out
Remove timing gear cover scre	ws + 5 sump screws-Sdh 13, T	br stand			
Remove cover and place rag ov	ver sump	-			
Remove timing gears-Was 17					
Remove camshaft—Was 13		Timing gear cove	r replace (engin	e 7–	2154
Remove-install balance shaft se	eal-GC 6059, GC 7600-B	in stand)-			
Clean mating surface of timing	gear cover—Ck	See Operation No	21529, excl p	ower unit into	and out
Wash-kerosene bath		stand			
Clean mating surface on intern	nediate plate and sump-Ck				
Fit sump gasket—sealing comp	ound				
Fit camshaft-Was 13, Sdh 13,		Timing gear cove	r replace (in ca	7—	2154
Refit timing gears,—Was 17, So					
Apply adhesive and position ti	ming gear cover gasket-	Remove-install er			
sealing compound		Open coolant dra			1/16.50
Refit timing gear cover-GC 60)59	Remove-install gr	ound lead from		
Refit timing gear cover—GC 60 Refit pulleys and fan		Remove-install gr Remove front pa	ound lead from nel—Was 7/16,	SCcs, Wco 1/2	
Refit timing gear cover—GC 60 Refit pulleys and fan Reconnect hoses to coolant pu		Remove-install gr Remove front pa Remove radiator	ound lead from nel—Was 7/16,	SCcs, Wco 1/2	
Refit timing gear cover—GC 60 Refit pulleys and fan Reconnect hoses to coolant pu Refit gen and belt		Remove-install grands Remove front particles Remove radiator Remove gen	ound lead from nel-Was 7/16, -Pcl, Wco 1/2,	SCcs, Wco 1/2 Was 1/2	
Refit timing gear cover—GC 60 Refit pulleys and fan Reconnect hoses to coolant pu Refit gen and belt Refit tappets	ump	Remove-install grade Remove front particles Remove radiator Remove gen	ound lead from nel—Was 7/16, –Pcl, Wco 1/2, om coolant pun	SCcs, Wco 1/2 Was 1/2 np-Pcl	
Refit timing gear cover—GC 60 Refit pulleys and fan Reconnect hoses to coolant pu Refit gen and belt Refit tappets Refit cyl heads and muffler pip	ump	Remove-install grade Remove front particles Remove radiator Remove gen Remove hoses from Remove fan and	ound lead from nel—Was 7/16, –Pcl, Wco 1/2, om coolant pun pulley—Was 1/2	SCcs, Wco 1/2 Was 1/2 np—Pcl	
Refit timing gear cover—GC 60 Refit pulleys and fan Reconnect hoses to coolant pu Refit gen and belt Refit tappets Refit cyl heads and muffler pi Refit push rods	ump	Remove-install grands Remove front particles Remove radiators Remove gen Remove hoses from Remove fan and Remove balance	ound lead from nel—Was 7/16, –Pcl, Wco 1/2, om coolant pun pulley—Was 1/2 shaft pulley—W	SCcs, Wco 1/2 Was 1/2 np—Pcl 2 as 17	, Ppn
Refit timing gear cover—GC 60 Refit pulleys and fan Reconnect hoses to coolant pu Refit gen and belt Refit tappets Refit cyl heads and muffler pi Refit push rods Refit both rocker arm assembl	ump	Remove-install grands Remove front particles Remove radiator Remove hoses from Remove fan and Remove balance Remove fixing so	ound lead from nel—Was 7/16, –Pcl, Wco 1/2, om coolant pun pulley—Was 1/2 shaft pulley—W rews (incl 5 sur	SCcs, Wco 1/2 Was 1/2 np—Pcl 2 as 17 np screws)—Sd	, Ppn
Refit timing gear cover—GC 60 Refit pulleys and fan Reconnect hoses to coolant pu Refit gen and belt Refit tappets Refit cyl heads and muffler pip Refit push rods Refit both rocker arm assemble Refit fuel pump	ump	Remove-install grands and semove front particles and semove front particles and semove far and semove far and semove fixing so semove cover an and semove cover an and semove cover an and semove cover an and semove semov	ound lead from nel—Was 7/16, —Pcl, Wco 1/2, om coolant pun pulley—Was 1/2 shaft pulley—W rews (incl 5 sur d place rag ove	SCcs, Wco 1/2 Was 1/2 np—Pcl 2 as 17 np screws)—Sd r sump	, Ppn
Refit timing gear cover—GC 60 Refit pulleys and fan Reconnect hoses to coolant pu Refit gen and belt Refit tappets Refit cyl heads and muffler pi Refit push rods Refit both rocker arm assembl	ump	Remove-install gramove front particles Remove radiators. Remove gen Remove hoses from Remove fan and Remove balance Remove fixing so Remove cover an Remove coolant.	ound lead from nel—Was 7/16, —Pcl, Wco 1/2, om coolant pun pulley—Was 1/2 shaft pulley—W rews (incl 5 sur d place rag ove pump and gask	SCcs, Wco 1/2 Was 1/2 hp—Pcl 2 as 17 hp screws)—Sd r sump ets—Was 10	, Ppn h 13, Ťb
Refit timing gear cover—GC 60 Refit pulleys and fan Reconnect hoses to coolant pu Refit gen and belt Refit tappets Refit cyl heads and muffler pi Refit push rods Refit both rocker arm assembl Refit fuel pump Refit inlet manifold Refit carburetter	ump	Remove-install gramove front particles Remove front particles Remove gen Remove hoses from Remove fan and Remove fixing some Remove cover an Remove coolant Clean mating sur	ound lead from nel—Was 7/16, —Pcl, Wco 1/2, om coolant pun pulley—Was 1/2 shaft pulley—W rews (incl 5 sur d place rag ove pump and gask	SCcs, Wco 1/2 Was 1/2 hp—Pcl 2 as 17 hp screws)—Sd r sump ets—Was 10	, Ppn h 13, Ťb
Refit timing gear cover—GC 60 Refit pulleys and fan Reconnect hoses to coolant pu Refit gen and belt Refit tappets Refit cyl heads and muffler pi Refit push rods Refit both rocker arm assembl Refit fuel pump Refit inlet manifold Refit carburetter Adjust valves	ump	Remove-install gramove front paragramove front paragramove radiators. Remove gen Remove fan and Remove balance Remove fixing so Remove coolant Clean mating surrous fixed from the coolant clean mating surrous from the coolant from the coolant clean mating surrous from the coolant from the coolan	ound lead from nel—Was 7/16, —Pcl, Wco 1/2, om coolant pun pulley—Was 1/2 shaft pulley—W rews (incl 5 sur d place rag ove pump and gask faces on interm	SCcs, Wco 1/2 Was 1/2 np—Pcl 2 as 17 np screws)—Sd r sump ets—Was 10 ediate plate an	, Ppn h 13, Ťb
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1		04540						
e e		21546						
Check engine oil level, fill wi Check hood lock	th coolant							
Check hood lock Start-stop engine, check seali	na							
Spares:	9							
Timing gear cover								
Timing gear cover gasket								
Sump gasket								
Coolant pump gaskets								
Camshaft replace (engine in s	tand), 7-	21547						
timing gears off			V					
Remove distributor-Wco 13								
Remove valve covers—Sdhl 1								
Remove carburetter—Wco 13								
Remove inlet manifold—Sdh Remove rocker arm mechani								
Remove push rods	1143 10							
Remove cyl heads—Sdh 19 +	Tah		1 4					
Remove tappets—bent wire								
Remove camshaft—Was 13 Install camshaft—Was 13, Sdl	13 + Tta micrometer							
Refit tappets	1 13 + 1 tg, micrometer							
Refit cyl head—Sdh 19, + Ta	n, Ttg							
Refit push rods								
Refit rocker arm mechanisms Refit inlet manifold–Sdh 13								
Refit carburetter	· Ttg							
Adjust valves-feeler gauge 0	40 mm, Wco 11							
Change valve cover gaskets—(Ck							
Refit valve covers Refit distributor								
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21671 7- 67 7 7 81 21682 7- 212 18 23 253 21683 7- 114 4 12 130 21684 7- 82 16 10 108 21685 7- 144 14 16 174 21686 7- 182 11 19 212	21671 7- 67 7 7 81 21682 7- 212 18 23 253 21683 7- 114 4 12 130 21684 7- 82 16 10 108 21685 7- 144 14 16 174 21686 7- 182 11 19 212	21671 7- 67 7 7 81 21682 7- 212 18 23 253 21683 7- 114 4 12 130 21684 7- 82 16 10 108 21685 7- 144 14 16 174 21686 7- 182 11 19 212	21671 7- 67 7 7 81 21682 7- 212 18 23 253 21683 7- 114 4 12 130 21684 7- 82 16 10 108 21685 7- 144 14 16 174 21686 7- 182 11 19 212	21655	7-	8		1	9							
21682 7- 212 18 23 253 21683 7- 114 4 12 130 21684 7- 82 16 10 108 21685 7- 144 14 16 174 21686 7- 182 11 19 212	21682 7- 212 18 23 253 21683 7- 114 4 12 130 21684 7- 82 16 10 108 21685 7- 144 14 16 174 21686 7- 182 11 19 212	21682 7- 212 18 23 253 21683 7- 114 4 12 130 21684 7- 82 16 10 108 21685 7- 144 14 16 174 21686 7- 182 11 19 212	21682 7- 212 18 23 253 21683 7- 114 4 12 130 21684 7- 82 16 10 108 21685 7- 144 14 16 174 21686 7- 182 11 19 212	21670	7–	174	25	20	219							
21683 7- 114 4 12 130 21684 7- 82 16 10 108 21685 7- 144 14 16 174 21686 7- 182 11 19 212	21683 7- 114 4 12 130 21684 7- 82 16 10 108 21685 7- 144 14 16 174 21686 7- 182 11 19 212	21683 7- 114 4 12 130 21684 7- 82 16 10 108 21685 7- 144 14 16 174 21686 7- 182 11 19 212	21683 7- 114 4 12 130 21684 7- 82 16 10 108 21685 7- 144 14 16 174 21686 7- 182 11 19 212	21671	. 7-	67	7	7	81				×			
21684 7- 82 16 10 108 21685 7- 144 14 16 174 21686 7- 182 11 19 212	21684 7- 82 16 10 108 21685 7- 144 14 16 174 21686 7- 182 11 19 212	21684 7- 82 16 10 108 21685 7- 144 14 16 174 21686 7- 182 11 19 212	21684 7- 82 16 10 108 21685 7- 144 14 16 174 21686 7- 182 11 19 212	21682	7-	212	18	23	253							
21685 7- 144 14 16 174 21686 7- 182 11 19 212	21685 7- 144 14 16 174 21686 7- 182 11 19 212	21685 7- 144 14 16 174 21686 7- 182 11 19 212	21685 7- 144 14 16 174 21686 7- 182 11 19 212	21683	7-	114	4	12	130							
21686 7- 182 11 19 212	21686 7- 182 11 19 212	21686 7- 182 11 19 212	21686 7- 182 11 19 212	21684	7-	82	16	10	108							
				21685	7-	144	14	16	174							
To this sheet belong 4 sheets of repair work description	To this sheet belong 4 sheets of repair work description	To this sheet belong 4 sheets of repair work description	To this sheet belong 4 sheets of repair work description	21686	7–	182	11	19	212							
				To this sh	neet belong	4 sheets	of repair	work	description							

	Replaces page	73-01-02	Edition 1	Page 2162	1 \	/4
Flywheel replace (clutch off) Remove flywheel—Sdh 16, Tah Wash, check new flywheel—keo Fit flywheel—Ttg	, Tbr	Heat new starte solder)—gas we	er ring gear to 20 Iding equipmen- gear to flywhee	00°C (melti t, solder		mp. of
Spares: Flywheel (complete) Bolts		Main bearings, (in addition to	check (replace) 1st check), per l		7—	21647
Doits		Remove-install	A STATE OF THE STA			
		Posn plastigage				**
Crankshaft replace (con rod bearings off)	7- 21	Fit main brg ca Remove main b				
	V	Read off cleara				
Remove gen and fanbelt-Wco		Wipe away plas	tigage			
Remove balance shaft pulley—V Remove timing gear cover—Sdh		-				
Remove crankshaft pinion—Was		Main law and w			,	21040
Remove clutch-3 spacers, Sdh		separated)	eplace (power ui	π	7-	21649
Remove flywheel-Sdh 16, Tah				1		
Remove main bearing caps—Wa	s 19		-3 spacers, Sdh			
Lift out crankshaft			eel—Sdh 16, Tah Tool 786216, Wo			
Remove main bearing shells—SC Remove balance shaft seals—Ma		Wipe clean at m		.0 22		
Unpack new crankshaft	marci 7002 14, 11		of seal, fit seal-	oil can, too	1 786	217, H
Wash old crankshaft-kerosene	bath		wheel and cluto		bath	١
Clean mating surfaces on, check			dh 16, Tah, Tbr			
cover conn rod and main bearing	igs, flywheel and clutch—l	cero- Clean flywheel,	clutch disc and	pressure pl	atee	emery clo
sene bath, knife	ulture of the		1/2, Tbr, Ttg, 7	Tool 78406	n	
Clean mating surface on intermediate Posn main bearing shells	ediate plate		1/2, 151, 119,	00170400		
Fit bushing to crankshaft—Bras	s mandrel. H	Spares:				
Position crankshaft		Sealing ring Bolt (flywheel)				
Measure main bearing clearance	-Sdh 19, Tah, Ttg, SCs,	- Boit (Hywhite)				
Plastigage						
Apply oil to bearings and fit ma	ain bearing caps (assistan)-	man bearing so	al replace		7—	21651
19, Tah, Ttg, SCs Fit main bearing seal—mandrel	786216 H	(clutch off)				
Fit flywheel-Sdh 16, Tah, Tbr,			el-Sdh 16, Tah			
Fit crankshaft pinion-Was 17,		Remove seal—T Wipe clean at m	ool 78 6216, Wo	o 2 2		
Fit balance shaft seal—mandrel	786215, H		ore, fit seal—Oi	I can.		
(Turn engine over in stand)		Tool 786217, H	1			
Fit timing gear cover—Sdh 13, 7 Fit balance shaft pulley	Ibr, Itg, Permatex		wheel-kerosen			
Fit gen and fanbelt			-Sdh 16, Tah, T	or, Itg		
(Turn engine over in stand)		Spares:				
Clean flywheel, clutch disc and	pressure plate-emery clo	th, Sealing ring Screw (flywhee	1)			
trich.	1704000		<u> </u>			
Fit clutch—Sdh 1/2, Tbr, Ttg, T	001 /84060		14	×		
Spares:						
Camshaft Bushing		Crankshaft rep	lace (power unit	out)	7-	21652
Sealing ring (crankshaft)		Fit lifting hook	-lifting hook 7	86202		
Sealing ring (balance shaft)			motor-Wco 14			
Gasket (timing gear cover)		The second secon	gine mounting b			
Bolt (flywheel)		The second secon	l mount power u		-eng	jine hoist
			remove lifting			
Elevision of the state of			I–Was 19, drain		Coc	
Flywheel, starter ring gear repla (flywheel off)	ice 7– 216		e and clutch hsg d fanbelt-Wco			
Try Wilder Off/				., 2, 1100 12		
Remove starter ring gear from fl		,, (Turn engine o	ver in standi			

(7-)

Ī	Replaces page	Date	Edition	Page	
I		73-01-02	1	21652	V4
	7- 21652	Spares:			
		Crankshaft			
	Remove oil pump—Wco 10 and 13	Bushing			
J	Remove balance shaft pulley—Was 17	The second secon			
Ì	Remove timing gear cover—Sdh 13, Tbr	Bolt (crankshaft)	1 (1)		
	Remove crankshaft pinion-Was 17, Tool 786218	Sealing ring (crank			
	Turn crankshaft	Sealing ring (balan			
ı	Remove conn rod brg caps—Sdh 1/2, Tebs, Tah	Gasket (timing gea	r cover)		
١	Remove conn rod brgs	Gasket (sump)			
	Remove clutch—3 spacers, Sdh 1/2, Tbr	Seal (sump)			
	Remove flywheel—Sdh 16, Tah, Tbr	Seal (sump)			
	Remove main brg caps—Was 19	Gasket (oil pump)			
	Lift out crankshaft	Bolt (flywheel)			
	Remove main bearing shells—SCs		-		
1					
1	Remove balance shaft seals—Mandrel 786214, H	Conn rod brgs repl	ace (check) all	7-	21653
1	Unpack new crankshaft	(in conj with main			
	Wash old crankshaft—kerosene bath		J		
Ì	Clean mating surfaces on, check and inspect, timing gear	Turn crankshaft			
į	cover, conn rod and main brgs, flywheel and clutch—kerosene	Remove conn rod		/2, Tebs, Ta	ıh
	bath, Ck	Remove conn rod	brgs		
ł	Clean mating surfaces on block and intermediate plate-Ck	Wipe clean and che	eck brg surfaces	on cranksha	aft
	Change conn rod brg cap bolts—Hp	Posn conn rod brg	s		
Ì	Position main bearing shells	Check conn rod br	g play-Sdh 1/2	2, Tebs, Tah,	Ttg,
	Fit bushing to crankshaft—brass mandrel, H	Plastigage			
	Pos crankshaft	Turn crankshaft 90	o°		
	Measure main brg clearance—Sdh 19, Tah, Ttg, SCs, 10,	Check conn rod br	g play		
	Plastigage	Change conn rod b	org cap bolts—So	dh 1/2, Tebs	, Tah, Ttg,
	Apply oil to bearings and fit main brg caps (assistant)-Sdh 19,				
	Tah, Ttg, SCs	Apply oil to conn	rod brgs-Moc		
	Fit main brg seal-mandrel 786216, H	Turn crankshaft			
	Fit flywheel—Sdh 16, Tah, Tbr, Ttg	Fit conn rod brg c	ans-Sdh 1/2. T	ebs. Tah. Tt	a
Ì	Posn conn rod brgs				
	Check conn rod brg play-Sdh 1/2, Tebs, Tah, Ttg,	Spares:			
	Plastigage	Bearing shells			
	Turn crankshaft	-			
	Apply oil to brgs and fit conn rod brg caps—Sdh 1/2, Tebs,				
Ì	Tah, Ttg	Conn rod brgs, tes			21655
	Fit crankshaft pinion-Was 17, Sdh 17, Ttg	in addition to 1st	testing, per bear	ring	
5	Fit balance shaft seal –mandrel 786215, H	Remove-install cor	on rod bra		
	(Turn engine over in stand)	Posn plastigage str			
5	Fit timing gear cover—Sdh 13, Tbr, Ttg, Permatex	Fit conn rod brg c		he Tab Tto	
5	Fit balance shaft pulley	The state of the s			
	Fit gen and fanbelt	Remove conn rod	big cap—Sun 1/	z, reps, rai	a - 11
	(Turn engine over in stand)	Read off play	1 - 65		
		Wipe away plastiga	ige		
	Check dimensions of oil pump driveshaft—slide gauge				
	Fit oil pump				04050
n	Fit sump	Balance shaft repla	ice (power unit	out) 7—	21670
	Clean flywheel, clutch disc and pressure plate-emery cloth,	Timing gear cover	replace (power	unit out) ser	e 21529 (7-)
9	trich	Balance shaft repla			
	Fit clutch—Sdh 1/2, Tbr, Ttg, Tool 784060		,,		
	(Turn engine over in stand)	*			
	Assemble engine to clutch hsg	0			
	Fill with engine oil—Filling vessel				
D	Assemble and connect lifting hook				
5	Remove power unit from stand	⁷ 00			
	Remove bracket	100			
3	Fit LH engine mounting bracket		With the second		
	Fit starter motor				
,					

Place power unit on floor

Disconnect and remove lifting hook

SAAB-SCANIA Saab Car Division	Repair Work Description SAAB 95/96
Replaces page	Date Edition Page
	73-01-02 1 21671 V4
Balance shaft replace (engine in stand 7— 21671 timing gear cover off) Remove timing gears—Trh, Sdh 17, SCs Remove clutch—784209, Sdh 1/2, Trh Remove flywheel—Sdh 16, Trh	Assemble engine to clutch hsg Spares: Bearing shells Bolt (conn rod) Gasket (oil pump)
Remove balance shaft—Hp Unpack and clean new balance shaft—Ck Fit balance shaft (incl. sealing ring and cover replace)—H, adhesive, 786215 Fit flywheel—Tanr, Sdh 16, Ttg	Main brgs, main brg seal replace, (power 7— 21684 unit out) incl remove from/mount in stand
Clean flywheel, clutch disc and pressure plate— emery cloth, trich Fit clutch—Sdh 1/2, Trh, Ttg, 784060 Fit timing gears—Sdh 17, Ttg	Remove starter motor—Wco 9/16 Remove LH engine mounting bracket—Trh, Tebm, Sdh 12-1/2 Fit bracket and mount power unit in stand— Leh, Was 9/16
Spares: Balance shaft Sealing ring Bolt (flywheel)	Separate engine and clutch hsg—SCcs, Pnu, Trh, Sdh 15 Main brg seal see 21649 (7—) Assemble engine to clutch hsg Remove power unit from stand and remove bracket
Main brgs replace (check) all 7— 21682 (power unit out)	Fit LH engine mounting bracket Fit starter motor
Fit lifting hook Drain engine oil—Mdv, Wco 3/4 Remove starter motor—Wco 9/16 Remove LH engine mounting bracket—Trh, Tebm, Sdh 12—1/2 Fit bracket and place power unit in stand— Leh, Was 9/16 Disconnect and remove lifting hook Remove sump (incl turning engine in stand)— Trh, Sdh 10, Tebm, H, Scs Replace (check) all main brgs (sump off), see 21685 (7—) Clean and fit sump—Ttg (Turn engine over in stand) Fill engine with oil Connect lifting hook	Main brgs replace (check) all, (sump off) 7— 21685 Separate engine and clutch hsg—SCcs 2, Was 15 Remove clutch—3 spacers, Sdh 1/2, Tbr Remove flywheel—Sdh 16, Tah, Tbr Remove oil pump—Wco 10 and 13 Remove main brg caps—Waas 19 Remove main brg shells—special tool for main brgs (The brgs should be replace one at a time to avoid the risk of changing the setting of the timing gears. The caps of the two other brgs should then be in position) Wipe clean and check brg surfaces on crankshaft Clean main brg mounting surfaces on block Fit main bearing shells—special tool for main brgs Check main brg play—Sdh 19, Tah, Ttg, Plastigage Turn crankshaft 90°

Check main brg play

Sdh 19, Tah, Ttg, SCs

Fit oil pump

Spares:

Fit flywheel-Ttg

emery cloth, trich

Bolt (flywheel)

Gasket (oil pump)

Assemble engine to clutch hsg

Sealing ring (crankshaft)

Apply oil to, and fit, main brg caps (assistant)—

Check dimensions of oil pump driveshaft-slide gauge

Wash and check flywheel and clutch-kerosene bath

Clean flywheel, clutch disc and pressure plate-

Fit clutch-Sdh 1/2, Tbr, Ttg, Tool 784060

Fit main brg seal-oil can, tool 786217,

Conn rod brgs replace (check) all, 7-21683

Remove power unit from stand and remove bracket

(sump off)

Separate engine and clutch hsg-SCcs 2, Was 15 Remove oil pump-Wco 10 and 13

Turn crankshaft

Fit LH engine mounting bracket

Remove conn rod brg caps-Sdh 1/2, Tebs, Tah

Remove conn rod brgs

Wipe clean and check brg surfaces on crankshaft

Posn conn rod brgs

Fit starter motor

Check conn rod brg play-Sdh 1/2, Tebs, Tah,

Ttg, Plastigage

Turn crankshaft 90°

Check conn rod brg play

Change conn rod brg cap bolts-Hp

Apply oil to conn rod brgs

Turn crankshaft

Fit conn rod brg caps-Sdh 1/2, Tebs, Tah, Ttg

Check dimensions of oil pump drive shaft-

slide gauge

Fit oil pump

Remove lifting hook

Saab Car Division

Date Edition Réplaces page Page 21686 V4 73-01-02 Connirod brgs replace (check) all power 7-21686 unit out) Fit lifting hook Drain engine oil-Mdv, Wco 3/4 Remove starter motor-Wco 9/16 Remove LH engine mounting bracket-Trh, Tebm, Sdh 12-1/2 Fit bracket and mount power unit in stand-Was 9/16, Leh Disconnect and remove lifting hook Remove sump (incl turning engine over in stand) Conn rod brgs replace (check) all (sump off), see 21683 (7-) Clean and fit sump Turn engine over in stand Fill engine with oil Fit lifting hook Remove power unit from stand and remove bracket Fit LH engine mtg bracket Fit starter motor Remove lifting hook Saab-Scania - Service Department-Kundendienstabteilung - Nyköping - Sweden-Schweder

SAAR-SCANIA

Saab Car Div		IR	eplaces page	В		Date	Edition		Page		
			- X			Jan. 1973	1		21702 -	22211	
Oper, No	Modelcode	Effective time	Secondary time	Lost time allow- ance	Schedule time	Oper. No	Modelcode	Effectiv time	e Secondary time	Lost time allow- ance	Schedule time
21702	7-	68	17	9	94						
21707	7-	41	9	5	55						
21708	7-	37	-11	5	53						
21710	7-	31	14	5	50						
22111	7-	9	2	1	12						
22120	7-	73	17	9	99						
22122	7-	92	19	11	122						
22171	7–	19	6	3	28						
22211	7–	4	2	1	7						
To this st	neet belong	1 sheets	of repair	work	description						

	Saab Car Division		Repair Work D	escription	SAAB 9	0/96
	Replaces page	rada 5	73-01-02	Edition 1	Page 21702	N.
	Sump gasket replace (power unit out) 7— Remove sump, see 21710 (7—) Fit sump, see 21708 (7—) Sump gasket replace (engine in stand) 7— Drain engine oil—Was 19, draining vessel (Turn engine over in stand) Remove sump—Sdh 10, Tbr (Turn engine over in stand) Clean sump—paint brush Change gasket—Ck, sealing compound Fit sump—Sdh 10, Trh, Ttg Fit oil drain plug (Turn engine over in stand) Fill engine with oil Spares: Sump gasket		Remove LH engine Tebm, Sdh 12–1/2 Fit bracket and mo Was 9/16, Leh, 786 Turn power unit ov Remove sump—Trh Remove oil pump a Unpack new pump Clean drive shaft, constall drive shaft a Clean and fit sump Turn power unit ov Fill engine with oil Remove power unit bracket—Leh, Was Fit LH mounting b Fit starter motor Disconnect and rem Spares:	eunt power uni 6085 ver in stand n, Tebl, Sdh 10 and drive shaft- check dimensio and pump—Ttg, —Ck, Trh, Teb ver in stand t from stand ar 9/16 aracket	Trh, t in stand— , Hp, SCs —Wco 13 ns—slide gauge , Sdh 13, Tebm I, Sdh 10, Ttg	
			Oil pump Sump gasket			
	Fit sump (power unit out) Clean and fit sump—Ck, Trh, Tebl, Sdh 10, sealing compound Turn power unit over in stand Fill engine with oil Fit lifting hook—Wadj 786202 Remove power unit from stand and remove bracket—Leh, Was 9/16 Fit LH engine mounting bracket—Trh Fit starter motor—Wco 9/16 Disconnect and remove lifting hook Spares: Sump gasket Remove sump (power unit out) 7—		Oil pump, recond (Oil pump remove-i see 22120 (7–) Oil pump recond (Oil pump recond (Remove suction pi Remove cover Measure axial and i Fit relief valve and Fit plug and cover Fit suction pipe	pump off) pe radial clearance spring	nit out) 22171 (7–) 7 –	22122
Nykoping - Sweden-Schweden	Fit lifting hook—Wadj 786202 Drain engine oil—Mdv, Wco 3/4 Remove starter motor—Wco 9/16 Remove LH engine mtg bracket—Trh, Tebm, Sdh 12—1/2 Fit bracket and mount power unit in stand— Was 9/16, Leh, 786085 Remove lifting hook Turn power unit over in stand Remove sump—Trh, Tebl, Sdh 10, H, SCs		Spares: Repair kit Oil filter replace Remove oil filter— Clean mounting su Fit oil filter Spares: Oil filter		7-	22211
aab-Scania - Service Department-Kundendienstabteilung - Nyköping	Oil pump replace (remove-install) 7—sump off (power unit in stand) Remove oil pump and drive shaft—Wco 13 Clean drive shaft, check dimensions—slide gas Unpack new pump Install drive shaft and pump Torque/tighten fixing scres—Ttg, Tebs, Sdh 1	uge				
ab-Scania - Service Dep	Oil pump replace (remove-install) 7— (power unit out) Fit lifting hook—Wadj 786202 Drain engine oil—Mdv, Wco 3/4 Remove starter motor 1 Wco 9/16	22120				

Repair Work - Standard Times SAAB 95/96

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Oper. No	Modelcode	Effective	Secondary time	Lost time allow- ance	Schedule time	Oper, No	Mod	delcode	Effecti			Lost time allow ance	Schedi
23102	7-8	138	18	16	172								
23102	9-	120	14	13	147								
23104	7–8	49	7	6	62								
23106	7-8	38	6	4	46								
23106	9-	34	6	4	44								
23120	7–8	14	4	2	20								
23120	9–	15	5	2	22								
23127	7-8	8	3	1	12								
23129	7–8	21	5	3	29								
23131	7 - 8	3	1		4								
23133	7–8	11	4	2	17								
23133	9-	10	5	2	17								
23136	9–	56	9	7	72								
23140	9–	45	9	5	59								
23143	7–8	6	4	1	11								
23143	9–	6	4	1	11								
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23154	9-	77	8	9	94								
23156	7 - 8	11	4	2	17								
23170	7-8	16	4	2	22	-							
23170	9-	15	5	2	22								
23172	7–	23	5	3	31								
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	9-	19	4	2	25								

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		Replaces page		73-01-02	Edition 1	Page 23102	V4
	CARBURETTER recond (Sole	(x) 7–8	23102	CARBURETTER cl	***		23104
	Remove carburetter, Operation			car) (Solex)			
	Recond carburetter, Operation Pos flange gasket	No 23154 (7-8)		Start, run (idle), sto Disconnect earth (gr		m	
	Fit carburetter-Wco 13			battery—Wco 7/16,		111	
	Fit throttle linkage—Ppn			Remove and separat	e air cleaner—W	co 10	
	Fit fuel and vacuum lines Fit hose on automatic choke—	SCs		Place rag under carb Remove fuel line	ouretter		
	Remove hose between thermos	stat and branch		Remove throttle lin	kage—Pcsh		
	nipple at automatic choke—Pcl			Wash carb externally	y-paint brush, k	oowl	
1	Fit hose with thermometer—hothermometer, Pol	ose with		with cleansing agent Remove carb top an		Sle	
	Fit earth (ground) lead to batte	ery-Wco 7/16,		Measure fuel level—s		/K	
0.00	Ck, Vaseline Fill with coolant—Mfc			Remove float	-::	COI-	
	Connect rev counter—rev coun	ter		Remove plug and m Remove idling jet—S	the state of the s	SUSSIN	
	Start cold engine			Remove emulsion je	et—SCs		
	Check temp and choke flap op Adjust temp setting—SCs	ening		Remove needle valve			
	Warm up to normal operating t	temp		Clean jets, hsg and t Fit jets and plug	op with compre	ssed air	
	(Clean air cleaner and filter dur	ring warming up)		Check and install flo	oat		
	Check, adjust, idling speed—SC Set stepped disk to step 1	s		Check and install ne			
	Adjust speed—Wco 7			Check tightness of c (3 + 4 screws)—SCs	naphragm screw	S	
	Check steps 2 and 3			Refit carb top with			
	Check, adjust, idling speed—SC Stop engine	s		Refit throttle linkag	je		
	Disconnect rev counter			Refit fuel line Remove rag			
	Remove hose with thermometer			Reconnect earth (gr	ound) cable to b	oattery-	
	Reconnect hose between therm branch nipple—Pcl	nostat and		Wco 7/16, Ck, Vase		10	
	Start engine			Check tightness of f Start engine	lange nuts—vvco	13	
	Remove any coolant with com	pressed air		Wipe and blow clear	n air cleaner and	filter	
	Check sealing Stop engine			Check sealing			
	Assemble and fit air cleaner—W	/co 10		Stop engine Assemble and refit a	air cleaner		
	Spares:			Spares:			
	Gasket set (black engine) Gasket set (others)			Carb top gasket (bla Carb top gasket (oth			
	Repari kit			Carb top gasket (otr	iers/		
	CARBURETTER (FoMoCo) di clean, assemble and adjust all se		23102	CARBURETTER re 32PDSIT—) (remove Drain coolant (not a	e-install)	7–8 ⁄/dv	23106
Swed	remove-install), not warming u			Disconnect earth (gr			
- 61	Remove-install carb from/in ca			battery-Wco 7/16,		aa 10	
30 I	Dismantle, clean, assemble, adj After warming up:	ust, see 23154 (9-)		Remove and separat Place rag under carb		10	
z				Remove hose at the	rmostat-Pcl		
	Connect rev counter—rev count Check idling speed	ter		Remove hoses from Remove fuel and va		e—SCs	
apte	Adjust idling speed to 800 r/mi			Disconnect throttle			
enst	Fit air cleaner, switch on dippe	d headlights-		Remove rag	•		
	Was 10, Was 11 Adjust idling mixture at 500 r/	min		Blow clean at carb f Remove carb—Wco	lange		
	Adjust idling speed to 850 r/mi	in-SCs		Empty out fuel and			
nent-	Stop engine, switch off dipped	headlights		Remove flange gask		ing	
a	Remove rev counter			surface on inlet mar Pos new flange gask			
	Spares: flange gasket			Fit new carb			
	gasket set			Reconnect throttle Refit fuel and vacuu			
1			· ·	Refit hoses to autor			1×1-1-1
cani				Refit hose to therm	ostat		
Saab-Scania				Reconnect earth (gr Wco 7/16, Ck, Vase		oattery—	
Sa				wco // to, ck, vase	III IE		

Saab Car Division Edition Replaces page Date Page 23106 V4 1 73 - 01 - 027-8 23106 CARBURETTER, adjust and check 23129 7-8 fuel level (air cleaner off) (Solex) Top up coolant-Mfc Disconnect earth (ground) cable from battery-Start engine Wco 7/16, SCs Wipe and blow clean air cleaner and filter Disconnect fuel line Check for leaks Disconnect throttle linkage-Pcsh Stop engine Remove carb top and gasket-SCs, Ck Assemble and refit air cleaner Remove float Remove needle valve-Was 14 Carb (non-enclosed crankcase ventilation) Blow clean needle valve and float chamber Flange gasket Check needle valve Replace washer and refit needle valve Check and install float Refit carb top and gasket CARBURETTER (FoMoCo) replace 23106 Reconnect throttle linkage (remove-install) incl cleaning air filter Reconnect fuel line Reconnect earth (ground) cable to battery-Remove carb see 23170 (9-) Wco 7/16, Ck, Vaseline Install carb see 23172 (9-) Start engine, run (idle) Spares: Check level and check for leaks Carb Stop engine Flange gasket Spares: Carb top gasket (black engine) Carb top gasket (others) CARBURETTER (Solex), fast idle and 7-8 23120 Needle valve gasket idle adjust (excl warming up) Remove air cleaner-Wco 10 Connect rev counter-rev counter CARBURETTER automatic choke temp 7-8 23131 Start engine-exhaust hose setting (turn thermostat housing) Adjust idling speed-SCs (air cleaner off) Set fast idle to stop 1 Loosen housing, turn and tighten-SCs Adjust speed to 1200-1300 r/min-Wadj 4 Check step 3 CARBURETTER (Solex), fast idle 7-8 23133 Refit air cleaner and idle adjust (air cleaner off) excl Adjust mixture-SCs warming up Adjust speed-SCs Remove rev counter See fast idle and idle adjust 23120 (7-8) Stop engine excl remove-install air cleaner CARBURETTER (FoMoCo), fast idle and 9-23120 CARBURETTER (FoMoCo) fast idle idle adjust (excl warming up) 9-23133 and idle adjust (air cleaner off) excl Remove air cleaner-Was 10, 11 warming up Connect rev counter-rev counter See 23120, excl remove-install air cleaner Start engine, switch on dipped headlights Check fast idle Adjust fast idle to 1800 r/min-special wrench Refit air cleaner CARBURETTER (FoMoCo) clean, float 9-23136 Adjust mixture at 500 r/min-SCs level and idle adjust (not warming up) Increase idle to 850 r/min See 23140 (9—) and add the following: Remove rev counter Check float level (carb top off)-slide gauge Switch off dipped headlights, stop engine Adjust float level-Ppn CARBURETTER, check fuel level 7-8 23127 CARBURETTER (FoMoCo) clean, idl 23140 (air cleaner off) (Solex) adjust (not warming up) Place rag under carb Remove-install engine hood-SCs Remove plug for main jet-Wco 13 Remove-install air cleaner-Wco 10, Wco 11 Fit level meter-Wco 13, level meter 786230 Blow clean air cleaner filter-Cag Start engine, run (idle) Wash carb externally-paint brush, Cag, bowl Check level with cleaning agent Stop engine Disconnect coolant hose from choke hsg-SCs Remove level meter Disconnect fuel line from carb-SCs Refit plug for main jet Remove stepped disk from carb-SCs Remove rag Remove carb top-SCs

R	aplaces page		73 —	01 – 02	Edition 1	23140	V4
	9_	23140				off) 7–8	2315/
Remove mixture screw—SCs Remove main jet and float—Was 5 Row clean float chamber, top and Refit main jet and float Refit mixture screw Refit carb top Refit stepped disk Reconnect fuel hose to carb Reconnect coolant to check hsg Check tightness of flange nuts—85 Rump up fuel (run starter motor) Refit warming up: Connect rev counter—rev counter Redjust mixture at 500 r/min Remove rev counter Repares: Carb top gasket CARBURETTER (Solex) idle adjuntative and speed) (not warming Connect rev counter—rev counter Redjust speed and mixture—SCs Remove rev counter—stop engine CARBURETTER (FoMoCo), idle Remove rev counter—rev counter Redjust to correct idle Remove rev counter—stop engine CARBURETTER (FoMoCo), idle mixture and speed) (not warming Connect rev counter—rev counter Start engine, switch on dipped he Redjust idle to 850 r/min—SCs Retor engine, switch off dipped he Redjust idle to 850 r/min—SCs Retor engine, switch off dipped he	ust 7–8 j up) adjust 9– g up) adlights	23143	Wash carb Remove of Remove of Remove a Remove of Remove	externally arb top—So loat lap hsg—Pc cc pump—So lug and madding jet—So mulsion jet eck ring nixture screedle valve vater housi hermostat lap hoke flap acuum diaghoke hsg—So utomatic conderside of carb compoli carb compone in reverse of adjust gap —Wco 7, we (black enger (others)	sh, SCs SCs, Psc in jet—Wco 1: Cs :—SCs ew arm—Wco 1: and spindle— —Was 14 ng—Wadj 6 nsg—SCs ind spindle—S bhragm—SCs SCs hoke arm—Wc flap hsg—surf inents—washir conents ints in the gasl order between thre vire or 0.8 mm	3, SCs -SCs, Pcsh Cs co 11 face grinder ng facilities ket set and	2315
CARBURETTERS, exhaust gas Content measure and adjust (excluder)	0 7–	23150		*			
Start engine Measure and adjust CO content, s Adjust idle, stop engine	ee 23151 (7—)			vi i			
CARBURETTER, exhaust gas CC content measure and adjust (in conj with carb adjustment)	7-	23151					
Connect instrument to battery, st CO meter compl on instrument to Place condensation trap behind of Calibrate instrument Place probe in exhaust pipe Read off CO content Adjust mixture screw—SCs Read off CO content Roll up cables, place instrument of Roll up hose, place condensation	olley ar on trolley						

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CAPPIDETTED (F-M-C-)	omale O	00454	73-01-02	1 1	W-00-000	V4
CARBURETTER (FoMoCo) dism clean, assemble and set all adjustm		23154	CARBURETTER	(FoMoCo), rem	ove 9-	23170
(carb off)	ierits		Remove engine ho	od-SCs		
Carb Off/			Remove air cleaner		11	
Remove bimetal spring hsg-SCs			Disconnect coolan			
Remove stepped disk-SCs			Disconnect throttle		HORO OOS	
Remove carb top—SCs			Disconnect fuel pi		C.	
Remove spring (float chamber val	ve)		Disconnect vacuum			
ball and weight			nuts-839038, Was		ove mange	
Remove acc pump			Lift off carb	, 10		
Remove mixture screw			Remove intermedia	ate flance remo	wa naskat	
Remove float and needle valve—W	as 11		place rag	ate nange, reme	ive gasker,	
Remove main jet-Was 5/16			Wash carb external	ly and blow cle	an—washing	
Remove choke hsg from carb top-	-SCcs		facilities, Cag	Ty and blow cie	an—wasiing	
Remove air cleaner bracket-Pfl						
Remove choke flap with spindle-	SCs (Tthn					
1/4, Sdh 3/16)	003 (1 1111)		CARBURETTER,	inetall (Calay)	7-	23172
Clean and check removed parts—C	an		CANBONETTEN,	install (Solex)	/-	231/2
Refit choke spindle and flap	ay		Pos flange gasket			
Refit choke hig to carb top			Fit carb—Wco 13			
Refit main jet			Reconnect throttle	linkage-Ppn		
Refit main jet Refit needle valve and float	1 1		Refit fuel and vacu			
Refit acc pump			Refit hoses to auto		Cs	
	gauge D		Refit hose to thern		Target Control of the	
Check and adjust float level—slide	gauge, Ppn		Reconnect earth (g	round) lead to	batterv-	
Refit ball, weight and carb top			Wco 7/16, Ck, Vas		,	
Refit mixture screw			Top up coolant-fi			
Refit stepped disk			Start engine	ining vossor		
Check play in acc pump—SCs, slid	e gauge		Wipe and blow clea	en air cleaner an	d filter	
Check play in float chamber valve			Check for leaks	in an cleaner an	iu iiitei	
Check choke flap posn (under pre-		5	Stop engine			
Adjust choke flap posn (under pre	ssure)—PfI		Assemble and refit	air cloanor—Wo	0.10	
Refit bimetal spring hsg	7.2 - 7 7		Assemble and rem	all cleaner—vvc	0.10	
Check posn of stepped disk-Drill			Spares:			
Adjust posn of stepped disk-Pfl, s			Flange gasket			
Check mech opening of choke flap		5				
Adjust mech opening of choke flag	p—PtI					
Refit air cleaner bracket—H			CARBURETTER,	(FoMoCo), inst	all 9–	23172
Spares:			F1.	11 . 61		
Gasket set			Fit new gasket, int		e and pos carb	
			Fit nuts—Was 10, 8			
			Connect throttle li			
CARBURETTER, fuel level check	7–8	23156	Connect coolant he			
Solex)	/-0	23150	Connect fuel line t			
oolex)			Pump up fuel (star			
Remove air cleaner—Wco 10			Blow clean air clea	ner filter—Cag		
			Refit air cleaner			
CARBURETTER, remove (Solex)	7–8	23170	Check coolant leve			
		23170	Refit engine hood			
Drain coolant (not all)—Wco 7/16			Start-stop engine			
Disconnect earth (ground) leads fi	om battery—		Spares:			
Wco 7/16, SCs			Flange gasket			
Remove and sep air cleaner-Wco	10					
Place rag under carb			CARBURETTER (FoMoCo), chok	e flap 9-	2317
Remove hose at thermostat-Pcl			adjust (in conj with			
Remove hoses from automatic cho	oke-SCs					
Remove fuel and vacuum lines			Remove bimetal sp			
Disconnect throttle linkage—Ppn			Check choke flap p	osn (under pres	sure)-PfI	
Remove rag			Drill 4, 5			
Bloe clean at carb flange			Adjust choke flap		ssure)—PfI	
Remove carb—Wco 13			Refit bimetal sprin	g hsg		
	on int		Check stepped disk		5	
Empty out fuel and blow carb clear			Adjust stepped disl			
Remove flange gasket and clean m	ating		Check mech openir			.5
surface on inlet manifold—Ck			Adjust mech openi			
				3		

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		R	eplaces pag	е		Date		Edition	F	Page		
						Jan. 1973		1		23205 -		
Oper, No	Modelcode	Effective	Secondary time	Lost time allow- ance	Schedule time	Oper, No	Mod	delcode	Effective time	Secondary time	Lost time allow- ance	Schedule time
23205	5-6	12	3	2	17				g.			
23207	5-6	8	1	1	10							
23207	7-	4	1	1	6							
23211	7-8	3	1	1	5							
23211	9–	4	1	1	6							
23215	5–6	8	2	1	11							
23217	5-6	3		1	4							
To this sh	neet belong	1 sheets	of repair	work	description							

	Replaces	page		Date 72 01 02	Edition	
Air cleaner, wash-blow (i install)	ncl remove-	5–6	23205	73-01-02	1	23
Remove air cleaner—Was 7 Wash air cleaner and blow Refit air cleaner		Cag				
Air cleaner, wipe clean–b remove-install)	low (incl	5–6	23207			
Remove air cleaner—Was 7 Wipe clean air cleaner and Rag, Cag Refit air cleaner		lter—				
Air cleaner, wipe clean—b (incl remove-install upper ari cleaner)		7–	23207			
Remove upper part of air Wipe clean air cleaner and Refit upper part of air clea	blow clean fi		ag			
Air cleaner, remove-install		7-8	23211			
Remove-install air cleaner	-Wco 10					
Air cleaner, remove-install Remove-install air cleaner		9– o 11	23211			
Air claner, wash—blow (cl		5–6	23215			

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23305 23305 23305 23307 23308 23308 23312 23312 23312 23312	7-0 1- 7-0 1- 5-6 7-0 1- 5-6 7-0 1- 1- 1- 1-	3 6 12 34 40 45 14	Secondary time 1 1 3 7 7 5 4	Lost time allowance 1 1 2 4 5	Schedule time 5 8 17 45 52 57	Jan. 19 Oper. No	73 Mode	1 Icode	Effective		- 23380 lary Lost time allow- ance	Sched time
23305 23305 23307 23308 23308 23312 23312 23312 23312 23320	7-0 1- 7- 5-6 7-0 1- 5-6 7-0	3 6 12 34 40 45 14	1 1 3 7 7 7 5	1 1 2 4 5	5 8 17 45 52 57	Oper, No	Mode	lcode	Effective time	e Second	lary Lost time allow-ance	Sched time
23305 23307 23308 23308 23308 23312 23312 23312 23320	1- 7- 5-6 7-0 1- 5-6 7-0	6 12 34 40 45 14	1 3 7 7 7 5	1 2 4 5	8 17 45 52 57							
23307 23308 23308 23308 23312 23312 23312 23320	7- 5-6 7-0 1- 5-6 7-0	12 34 40 45 14	3 7 7 7 5	2 4 5	17 45 52 57							
23308 23308 23308 23312 23312 23312 23320	5-6 7-0 1- 5-6 7-0	34 40 45 14	7 7 7 5	4 5 5	45 52 57							
23308 23308 23312 23312 23312 23320	7-0 1- 5-6 7-0	40 45 14 18	7 7 5	5	52 57							
23308 23312 23312 23312 23320	1- 5-6 7-0	45 14 18	7 5	5	57							
23312 23312 23312 23320	5–6 7–0	14 18	5									
23312 23312 23320	7–0	18		2								
23312 23320			4		21							
23320	1-			2	24							
		22	4	3	29							
	7-9	9	1	1	11							
23322	0-	5	1	1	7							
23370	5-6	5	4	1	10							
23370	7–0	9	3	1	13							
23370	1-	10	3	1	14							
23372	5-6	8	3	1	12							
23372	7–0	9	2	1	12							
23372	1-	12	2	1	15							
23374	7-	7	3	1	11							
23376	7	5	1	1	7							
23380	5-6	21	4	3	28							
23380	7-	22	5	3	30							

	Replaces page		73-01-02	Edition 1	Page 23305	
Fuel pump, clean filter	7-0	23305	Fuel pump repla		23305 (all) 1—	23313
Remove top—Was 11 Remove gasket and filter Clean filter—Cag Refit filter and top		2000	Remove see 233 Install see 23372 Spares: Pump	370 (1—)		20010
Spares: Gasket			Gasket			
Fuel pump, clean filter	1- "	23305	Fuel filter, new (air cleaner off)	installation	7–9	23320
Remove washer bottle Remove top—Was 11 Remove gasket and filter Clean filter—Cag Refit filter and top Refit washer bottle			Disconnect pipe Remove clamps Connect upper h Connect lower h Cut off lower h	from old hoses- nose to carb—SC nose to filter nose to filter	-SCs Cs	
Spares: Gasket			Spares: Fuel filter Upper and lowe			
Fuel pumps replace (remove-inst (engine out)	all) 7—	23307	Hose clips (4) if	nec		
Remove see 23374 (7–)			Fuel filter replace		0-	23322
Install see 23376 (7—)		-	See 23425 (7-)			
Fuel pump recond (incl remove-		23308	Fuel pump remo	ove	5–6	23370
Pump remove-install see 23312 (Pump recond see 23380 (5–6)	5–6)		Remove fixing b Disconnect hose Take away fixin	es g bolts, washers	and gaskets	
Fuel pump recond (inc remove-i	nstall) 7–0	23308	Clean pump ext			
Remove see 23370 (7–0) Recond see 23380 (7–) nstall se 23372 (7–0)			Fuel pump remo	h (ground) cable	7–0 e from	23370
Fuel pump recond (incl remove-i Remove see 23370 (1–) Recond see 23380 (7–) Install see 23372 (1–)	nstall) 1—	23308	battery—Wco 1/ Remove pump— Mark pump push Remove gasket, Clean pump ext	·Wco 13 h rod clean mating su	rface	
1131411 366 23372 (1—)			Fuel pump remo	ove	1-	23370
Fuel pump replace (remove-insta Remove pump—784478 Clean pump externally—washing nstall pump Start engine, check for leaks Spares:		23313	Disconnect eartl battery—Wco 1/ Remove washer Remove pump— Mark pump pusl Remove gasket, Clean pump ext	2 bottle Wco 13, SCs h rod clean mating su	rface	
Sasket			Fuel pump insta		5–6	23372
Fuel pump replace (remove-insta Remove see 23370 (7–0) nstall see 23372 (7–0)	II) 7–0	23313	Install fuel pum Start engine Check for leaks	p-784470		
Spares: Pump complete						

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			73-01-02	1	23372	
Fuel pump install Fit pump—Wco 13 Connect fuel line to pump Start engine, check for leaks Spares:	70	23372	Assemble rod ar Fit spring, wash Assemble upper Refit filter gauz Spares: Repair kit	er and retaining and lower parts	of pump body	
Gasket			nepair kit			+
Fuel pump install	1-	23372				
Fit pump—Wco 13 Connect fuel line to pump—SCs Start engine, check for leaks Refit washer bottle						
Fuel pump remove (engine out) Remove pump—Was 13	7-	23374				
Mark pump push rod Clean pump ext.						
Fuel pump install (engine out)	7-	23376				
Clean mating surface Clean push rod and pump Connect line to pump						
Spares: Gasket						
Fuel pump recond (out)	5–6	23380				
Remove screws, top, gasket and filter ga Wark top and bottom Take out diaphragm and spring Take out valves, springs, remove gasket Blow clean	uze—SCs,					
Refit valves, springs, gasket Refit diaphragm upper part Refit filter gauze, gasket top and screw Check operation of valves		40				
Spares: Repair kit						
Fuel pump recond (pump off)	7-	23380				
Wash pump externally Remove top—Was 11 Remove gasket and filter gauze Sep top and bottom Remove retaining pin—Ppn						
Remove retaining pin—Ppi Remove spring and washer—SCs Sep diaphragm and rod Clean mating surface for top Check valves Blow clean pump components—Cag						
nspect components Open package	ж.					

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		R	eplaces pag	9		Date Jan. 1973		Edition 1		Page 234	01 - 2	3478	
Oper. No	Modelcode	Effective time	Secondary time	Lost time allow- ance	Schedule time	Oper, No	Mod	delcode	Effective	e Se	condary ne	Lost time allow- ance	Schedule time
23401	5-	21	4	3	28								
23408	5-	34	4	4	42								
23412	P5-9 H5-	90	12	10	112								
23412	P0-	101	12	11	124								
23418	5-	14	2	2	18								
23421	5-	17	3	2	22								
23425	7-	5	1	1	7								
23427	7-	18	1	2	21								
23470	.P5-9 H5-	26	11	4	41								
23470	P0-	31	12	4	47								
23472	P5-9 H5-	46	12	6	64								
23472	P0 -	52	13	7	72								
23476	5-	7	1	1	9								

Posn can 1 and put in 20 litres

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Date Edition Page Replaces page 73-01-02 23401 23401 FUEL LINES, tank-engine compart-5-Transfer spout to can 2 and put in 5 litres ment replace (power unit and up-Remove spout from can and refit filler cap holstery out) Take away warning sign Return cans, warning sign and spout to store (secondary Remove clips in engine compartment floor—SCcs Remove rubber wedges in passenger compartment floor-SCs Reconnect leads to transmitter and check fuel gauge-Wadj, Remove rubber bushing in bulkhead-SCs Ppn, SCcs Cut off pipe in front of tank—metal cutter Refit masonite panel in trunk-SCcs Disconnect tank connection of pipe-Wco 5/8 Refit rear seat cushion and backrest Withdraw pipe from car Refit trunk mat and fix backrest Clean floor beading-Cag, rag Cover tank connection of new pipe-insulating tape Spares: Position pipe in car Tank Bend rear part of pipe, remove insulating tape Gasket Connect pipe connection to tank Hoses and bitumenized cardboard Fit rubber bushing in wheel house Fit rubber wedges in floor **FUEL TANK replace** PO-23412 Fit rubber and screw clips in engine compartment Fuel tank replace see 23412 (5-9) Spares: Remove-install venting pipe on tank Pipe FUEL TANK, tank fitting and/or gasket 5-23418 replace (tank in car) Open-close trunk lid FUEL LINES, tank-engine compart-23408 5-Remove-install mat ment pipe replace (power unit out) Remove front floor panel-SCcs See 23407 (7-), and add the following: Remove fitting-SCcs Remove front and rear sets Fit new gasket Remove carpets and masonite panels Refit fitting Open trunk, remove floor--SCcs Refit front floor panel Check operation of gauge **FUEL TANK replace** P5-9 H5- 23412 FUEL TANK, filler pipe replace 23421 Open and close trunk (wheel off) Raise rear of car on trestles-Ltr, Lj Remove-install LH rear wheel-SCs, Tanr, Sdh 3/4 See 23428, excl trestles and remove-install wheel Fetch jerrycans, spout and warning sign (secondary time) Posn warning sign Fit spout with funnel to can 1 FUEL LINE, clipped hose replace 7-23425 Posn can 1 and remove drain plug-Undercar board, Was 9/16 Connect can 1 to can 2 Loosen clips and remove hose-SCs, Ck Remove trunk mat and front masonite panel Fit hose and tighten clips Remove rear seat cushion and backrest Remove leads to fittings-SCcs, Ppn, Wadj Spares: Remove clamping strips and fuel line (to pump) Hose Clean and remove hoses from tank in wheel house Clip Wait for petrol to drain out (251) Refit drain plug and remove cans 1 and 2 from car Lift up tank from car Cut out bitumenized cardboard and stick strips to new FUEL LINE, pipe-pump, hose replace 23427 tank-Scissors, adhesive Loosen clips and remove hose-SCs, SCcs, Ck Check tightness of drain plug and transfer transmitter Fit hose and tighten clips Transfer rubber ring and boot Posn string in boot and rag in filler pipe Spares: Posn tank in car and connect fuel line (to pump) Hose Fit clamping strips and rubber boot Clip Remove rag and old hoses-Pcl, SCs x Time change + 3 because the fuel hoses have been fitted Fit new hoses and clips Posn trolley with cans and remove filler cap with clips.

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Date Replaces page Edition Page 73-01-02 23470 **FUEL TANK remove** P5-9 H5- 23470 **FUEL TANK, install** PO-23472 Open trunk lid Fuel tank, install see 23472 (5-9) Raise rear of car on trestles-Lj, Ltr Reconnect venting hose to tank-Pcl Remove LH rear wheel-Tanr, Sdh 3/4, SCs Fetch jerrycans, spout and warning sign (secondary time) Posn warning sign 23476 FUEL TANK, transmitter and/or gasket 5-Fit spout with funnel to can 1 replace (tank out) Posn can 1 and remove drain plug-undercar board, Was 9/16 Remove fixing screws, withdraw transmitter—SCcs Connect can 2 to 1 Fit new gasket and transmitter Remove trunk mat Remove front masonite panel Spares: Tank unit, fuel gauge, gasket Remove rear seat cushion and backrest Remove leads to transmitter-SCcs, Ppn, Wadj Remove clamping strips 23478 FUEL TANK, clean in car, incl fuel lines 7-Remove fuel line (to pump)-Wadj 6 Clean and remove hoses from tank in wheel housing to pump and carb Refit drain plug Raise rear of car on trestles, lower-Lj, Ltr Remove cans 1 and 2 from car (approx 20 I) Connect jerrycans, spout and warning sign (secondary time) Remove spout and funnel from can 1 Posn warning sign (for fire risk) Lift tank out of car (approx 5 l in tank) Connect spout with funnel to can 1—special lid with spout Remove warning sign Posn can 1'and remove drain plug-Wco 9/16, undercar board Return can, warning sign, spout and tank to store (secon-Connect ca 2 to can 1 dary time) Disconnect hose from pump in engine compartment-SCs, Ck Blow fuel line clean Reconnect hose to pump **FUEL TANK remove** PO-23470 Clean fuel pump filter, see 23305 (7-) Clean carb and adjust idling, see 23150 (9-) Fuel tank remove, see 23470 (5-9) Refit drain plug (not permanent) Remove venting hose on tank-Pcl Take cans 1 and 2 away from car Connect tank washing fluid and clean petrol (secondary time) **FUEL TANK install** P5-9 H5- 23472 Remove filler cap, put in cleaning fluid (5 I) and rock car Collect tank from store (secondary time) Posn vessel, remove plug-draining vessel Posn string in rubber boot-string Wait while tank drains Posn rag in filler tube Refit plug and remove vessel Posn tank in car Posn trolley Connect fuel line (to pump)-Wadj 6 Fit spout to jerrycan Fit clamping strips Place jerrycan on trolley (put in 20 I) Posn rubber boot in wheel housing Remove spout from jerrycan and refit filler cap Remove rag and old hoses-PcI, SCs Take away warning sign Fit new hoses and clips Return cans, vessel, warning sign and spout to store (secondary Connect jerrycans, spout and warning sign (secondary time) time) Posn warning sign (for fire risk) Arrange vessels and jerrycans Fit spout to jerrycan 1 Posn trolley and remove filler cap Posn can 1 on trolley and put in 20 I Transfer spout to can 2 Posn can 2 on trolley and put in approx 5 ! Remove spout from can and refit filler cap Take away warning sign Return cans, warning sign and spout to store (secondary time) Check for leakage at joins Connect leads to transmitter-Wadj, Ppn, SCcs Check fuel gauge Install panel in trunk-SCcs Refit seat cushion and backrest Refit trunk mat and fix backrest Close trunk lid

Refit LH rear wheel-Tanr, Sdh 3/4 Lower rear of car

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25102	5	27	5	3	35								
25102	7-	122	14	14	150								
25110	5	34	3	4	41								
25110	6	38	3	4	45								
25118	5	43	4	5	52								
25118	6	46	4	5	55								
25120	5	60	9	7	76								
25120	7-	133	16	15	164								
25122	7-	6	3	1	10								
25145	7-	104	12	12	128								
25147	7-	93	10	10	113								
25170	5	15	6	2	23								
25 170	7-	57	8	6	71								
25172	5	19	5	2	26								
25172	7-	64	9	7	80								
25177	5-6	3	3	1	7								
25 181	5	6	2	1	9								

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Date Edition Replaces page Page 73-01-02 1 25102 Refit preheater pipe 5 25102 Inlet manifold, gasket to block Tighten muffler suspension bolt replace Start-stop engine, check for leaks Disconnect-connect earth (ground) cable from/to battery-Was Spares: Exhaust gasket Remove air cleaner and preheater tube-SCs, Was 7/16 Muffler gasket Remove rubber boot Remove gen stay from gen-Wco 1/2, Was 1/2 Blow clean and remove inlet manifold-Cag, Wco 7/17, Exhaust manifold, all gaskets re-6 25110 Sdh 7/16, Tebl, Trh Clean inlet manifold mating surface—Ck Clean cyl block mating surface See 25110 (5) plus remove-install air cleaner Fit inlet manifold Fit gen stay Fit rubber boot Exhaust manifold replace 5 25118 Fit air cleaner and preheater tube Undo muffler suspension bolts-Wco 9/16 Start-stop engine, check for leaks Remove preheater pipe Spares: Remove muffler flange screws—Wco 9/16, Was 9/16 Gasket Remove preheater covers (large)—Wco 7/16, Was 7/16 Remove exhaust manifold-Wco 1/2, Was 1/2 Clean mating surfaces on block-Ck Inlet manifold, gasket replace 25102 Apply oil to fixing screws-Moc Refit exhaust manifold Remove engine hood Refit preheater covers (large) Drain coolant-Wco 7/16, Mdv Remove air cleaner-Wco 10, Pcl Refit muffler flange screws Refit preheater pipe Remove battery lead-Wco 7/16, SCs Remove distributor cap and ignition leads-SCs Refit muffler suspension bolt Posn distributor gear hose Remove distributor-Trh, 786053 Start-stop engine, check for leaks Remove carb-Wco 13, Pcl, Ppn, SCs Remove valve covers-Sdhl 10, Trh, Pcl, Pfl Remove inlet manifold-Sdh 12, Trh Exhaust manifold Clean inlet manifold and valve covers-washing facilities, Ck Muffler gasket Refit inlet manifold-Sdh 13, Trh, Tebs, Ttg. Atmosit Exhaust gasket Change valve cover gasket Refit valve covers Refit carb Exhaust manifold, replace 25118 Refit distributor Refit distributor cap and ign leads See 25118 (5) plus remove-install air cleaner Fill with coolant-Mfc Reconnect battery cable-Vaseline, Wco 7/16 Start engine Inlet manifold, replace 5 25120 Adjust ign-strobe lamp, Trh, 786053, SCs Removal, see 25170 (5) Stop engine Installation, see 25172 (5) Refit air cleaner Remove gen stay from inlet manifold-Wco 1/2, Was 1/2 Refit engine hood Remove carb from inlet manifold-Wco 1/2 Spares: Transfer studs-Wco 1/2, Was 1/2 Inlet manifold gasket Fit carb to inlet manifold Valve cover gasket Fit gen stay to inlet manifold Tighten gen stay on inlet manifold Exhaust manifold, all gaskets 25110 Inlet manifold replace Inlet manifold gasket Undo muffler suspension bolts-Wco 9/16 Remove preheater pipe Remove preheater covers-Wco 7/16, Was 7/16 Inlet manifold, replace 25120 Remove exhaust manifold—Wco 1/2, Was 1/2 See Operation No 25102 (7-) plus transfer of: Clean mating surfaces on block-Ck 2 studs-stad remover, Tah Clean mating surfaces on exhaust manifold

Temperature transmitter-Wco 1/2

Thermostat—Was 13

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Refit exhaust manifold

Refit preheater covers

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			73-01-02	1	25120	
	7-	25120	Inlet manifold instal	1	7-	2517
Plug at thermostat excl inlet m	anifold-Was 17		Remove engine hood	d		
Spares:			Drain coolantWco	7/16, Mdv		
Inlet manifold			Remove air cleaner-			
Inlet manifold gasket			Disconnect battery			
Valve cover gasket			Remove distr cap an	the state of the s	Cs 5	
			Remove distr-Trh,			
Inlet manifold tightening (incl	remove- 7-	25122	Remove carb—Wco		h Dal Dfl	
install air cleaner)			Remove valve covers Remove inlet manifo			
Remove air cleaner-Wco 10, F	Pcl		Clean inlet manifold			facilities C
Tighten all bolts and nuts-Ttg		6062	- Clour mice manner	and varve dov	vuoining	ruomitios, o
Fit air cleaner						
			Inlet manifold instal	I	5	25172
Inlet would like work to be a	:	05445	Fit inlet manifold to	engine-Wco	7/16 Sdh 7/	16 Tebl Tr
Inlet manifold replace (engine	in stand) 7—	25145	Fit gen stay at gen-			
See Operation No 25147, plus	transfer of		Fit choke cable and			SCs
2 studs-stud remover, Tah			Fit fuel and vacuum			
Temperature transmitter-Wco	1/2		Fit air cleaner and p		-Was 7/16, SC	Cs
Thermostat—Was 13			Start-stop engine, ch	eck for leaks		
Plug at thermostat excl inlet m	nanifold—Was 17		Check operation of	choke control		
Spares:			Spares:	1		
Inlet manifold			Gaskets			
Inlet manifold gasket						
Valve cover gasket						
* 11	H-X		Inlet manifold instal	1	7	25172
Inlet manifold, gasket replace	(engine 7–	25147	Fit inlet manifold—S	Sdh 13, Trh, T	ebs, Tta, Atm	nosit
in stand)	(eligine 7—	20147	Fit valve covers (nev			
4			Fit carb-Wco 13, Po			
Remove air cleaner-Wco 10, F			Fit distributor-Trh,			
Remove distr cap and ign leads	s—SCs 5		Fit distributor cap a	nd ign leads—	SCs 5	
Remove distr-Trh, 786053	60 F		Fill with coolant—W			
Remove carb—Wco 13, Pcl, Pp Remove valve covers—Sdhl 10,	and the second s		Connect battery cab	les-Vaseline,	Wco 7/16	
Remove inlet manifold—Sdh 1			Start engine	= 1 =00		
Clean inlet manifold and valve		cilities Ck	Adjust ign—strobe la	imp, 1rn, 786	053, SGs	
Refit inlet manifold-Sdh 13,			Stop engine Fit air cleaner—Wco	10 Pol		
Replace valve cover gaskets	, , , , , , , , , , , , , , , , , , , ,		Fit engine hood	10,10		
Refit valve covers						
Refit carb			Spares:			
Refit distr			Inlet manifold gaske	t		
Refit distr cap and ign leads			Valve cover gaskets			
Refit air cleaner						
Spares:			Exhaust manifold, s	urface	5-6	25177
Inlet manifold gasket			grinding (manifold o			
Valve cover gaskets						
	*		Grind manifold—gri			
Inlet manifold some		25470	- Blow clean manifold	1—Cay		
Inlet manifold remove	5–	25170				
Remove air cleaner and prehea			Inlet manifold, surfa	ace	5	25181
Remove adjustment stay at ger			grinding (manifold o			
Remove rubber boot and chok	e cable—Ppn, Wadj	6, SCs			aal	
Remove fuel pipe-Wadj 8			Grind inlet manifold		ieei	
Remove inlet manifold—Wco 7	7/16, Sdh 7/16, Tel	ol, Tbr,	Wash-dry inlet mani	TOIC		
Remove vacuum pipe	0.1					
Clean mating surfaces on block	<−Ck					

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facilities, Cag

Wash and blow clean inlet manifold and carb-washing

Benair Work - Standard Times SAAB 95/96

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ime		Secondary time		Effecti	delcode			Schedule time	Lost time allow- ance	Secondary time	Effective time	Modelcode	r. No
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							on	99 descriptio					

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Date Edition Replaces page Page 25204 73-01-02 Exhaust system, rear muffler and 7-25204 Exhaust system, front muffler 5-6 25212 intermediate pipe replace replace Jack up and lower RH side-jack, trestle Check up and lower RH side-jack, trestle Remove-install RH rear wheel—Scs, Tanr, sdh 3/4 Remove flange nuts, Wco 9/16, Was 9/16 Collect and replace gas welding equipment Remove front muffler bracket-Wco 9/16 Remove rear muffler bracket nuts 1)—gas welding equipment, H Remove front muffler clamp-Wco 1/2, Was 1/2 Remove centre suspension point-Was 7/16 Remove pipe from front muffler-H Remove pipe from front muffler-Wco 1/2, Was 1/2, H Fit front muffler Fit bolts and washers to new pipe clamp Fit 4 new rubber pads Fit bolts and washers to new clamps Fit pipe to front muffler Fit new pipe in front muffler Fit front pipe clamp Fit intermediate pipe to centre suspension point Start-stop engine Fit rear muffler Check for leaks, adjust Fit front pipe clamp Spares: Start-stop engine See 25222 Check for leaks-adjust 1) the times are for the 95 Exhaust system, front muffler 7-25212 Spares: See 25222 Remove-install engine hood-Ppn Jack up and lower front of car-Lj, Ltr Exhaust system, intermediate pipe 7-25206 Disconnect front muffler from brackets and cyl head-Wco replace 1/2, Wco 15, Trh, Tebl, Sdh 15 Remove bulb from RH headlamp Jack up and lower RH side,-jack, trestle Remove front intermediate pipe clamp-Was 1/2, H Remove-install RH rear wheel, SCs, Tanr, Sdh 3/4 Uncouple intermediate pipe from front muffler Remove rear pipe clamp-Wco 1/2, Was 1/2, H Uncouple muffler from engine compartment Remove centre pipe suspension point-Was 7/16 Transfer fixing clamps to new muffler-SCs Remove front pipe clamp-Wco 1/2, Was 1/2, H Replace gasket to cyl head Fit new rubber pads to pipe Posn new muffler in engine compartment Fit bolts and washers to new pipe clamps Fit pipe to front muffler Fit sealing sleeves in muffler pipe Fit bolts and washers to new pipe clamp Fit pipe to rear muffler Fit intermediate pipe to front muffler Fit pipe to centre suspension point Fit front muffler to brackets and cyl head Fit rear clamp Refit bulb to RH headlamp Fit front clamp Start-stop engine Start-stop engine Check for leaks, adjust Check for leaks, adjust Spares: Front muffler See 25222 Gasket Clamp Exhaust system, rear muffler replace 5-25210 Check up and lower RH side-jack, trestle Remove-install RH rear wheel, -SCs, Tanr, Sdh 3/4 Exhaust system, front muffler and 5-6 25216 Collect and replace gas welding equipment intermediate pipe replace Remove rear muffler bracket nuts 1) -gas welding equipment, Jack up and lower RH side-jack, trestles SCch, Remove-install RH rear wheel-SCs, Tanr, Sdh 3/4 Remove rear muffler from pipe-Wco 1/2, Was 1/2, H Remove flange nuts-Wco 9/16, Was 9/16 Fit new rubber pads to rear muffler Fit rear muffler on pipe Remove front muffler suspension point-Wco 9/16 Remove intermediate pipe suspension point—Was 7/16 Fit nuts for rear muffler bracket Remove rear muffler from pipe-Wco 1/2, Was 1/2, H Fit rear muffler clamp Fit new rubber pads to pipe Start-stop engine Fit bolts and washers to new pipe clamps Check for leaks, adjust Fit pipe to rear muffler 1)The times are for the 95 Fit centre fixing nuts Fit rear pipe clamp Spares: Fit front muffler See 25222 Fit pipe to front muffler Fit front pipe clamp Start-stop engine Check for leaks, adjust Spares:

See 25222

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			73-01-02	1	25216
Exhaust system, front muffler mediate pipe replace	and inter- 7-	25216	Fit front muffler		bracket
Jack up and lower front of car	L i _L +e		Fit rear muffler		
Jack up and lower RH side			Fit front pipe cla		
Remove-install RH rear wheel-	-SCs, Tanr, Sdh 3/4		Start-stop engine Check for leaks,		
Remove-install engine hood-P	pn		Officer for leaks,		
Remove intermediate pipe susp		16	1)The times are	for the 95	
Remove bulb from RH headlar					
Disconnect front muffler from	brackets and cyl head	d-Wco 1/2,	Spares: Front muffler		
Wco 15, Trh, Tebl, Sdh 15	I-U	1.0	Intermediate pip	ne	
Collect, light and put away we equipment, welding goggles	iding equipment—gas	welding	Rear muffler		
Cut off LH and RH muffler pi	ne from muffler		Clamp		
Remove LH and RH muffler p	ipe from engine comp	artment	Gasket		
Remove intermediate pipe fror	n rear muffler-Wco 1	/2,	Rubber pad		
Was 1/2, H					
Fit bolts and washers to new p	ipe clamps		Exhaust system	complete replac	ce 7- 25222
Fit new rubber pads to pipe Fit intermediate pipe into rear			- 1		Je /- 25222
Fit centre fixing nut	murrier		Remove-install e		
Fit rear pipe clamp			Jack up and low		-LJ, Ltr
Transfer fixing clamps to new	front muffler				-SCs, Tanr, Sdh 3/4
Change gasket to cyl head			Remove-install b		
Fit new muffler to engine com					ons and brackets-Wco 1/2,
Fit sealing sleeves to muffler pi			Wco 15, Trh, Tel		
Fit intermediate pipe to front i Fit front muffler to brackets as	Tuttier				lding equipment—gas weldir
Fit bulb to RH headlamp	id Cyr riedd		equipment, weld		1)
Start-stop engine			Cut off rear muf		
Check for leaks, adjust			Cut off RH muff		
Spares:					ear muffler (95 only)
Front muffler			Knock clear the	rear muffler 1) –	-H, SCcs
Gasket			Undo the centre	The second secon	ipe bracket
Clamp			Discard old exha		
Rubber pad			Remove pipes from		
Intermediate pipe			Place front muff Transfer fixing c		
		**************************************	Replace gasket	amps and soan	ng sicoros
Exhaust system complete repla	ce (rear 5-6	25221	Fit muffler to br	ackets and cyl	head
wheels off)			Fit preheater pla		
See 25222 (5-6) excl:			Fit new rubber p		
Jack up and remove-install rear	wheels		Fit bolts and wa		
Start-stop engine			Fit intermediate Fit intermediate		
			Fit rubber pads		iamp
Expand wetons and		05004	Fit rear muffler		
Exhaust system, replace comple (car jacked up, rear wheels off)	ete 7–	25221	Fit rear pipe clar		
			Start-stop engine		
See 25222 (7-) excl:	wheele		Check for leaks,	adjust clamp	
Jack up and remove-install rear Start-stop engine	wneels		1) _{the times are f}	or the 95	
			Spares: Front muffler		
Exhaust system complete repla	ce 5-6	25222	Rear muffler		
Jack up and lower RH side-Lj,	Ltr		Gaskets		
Remove-install RH rear wheels-	-SCs, Tanr, Sdh 3/4		Clamp		
Collect and return gas welding a	equipment—gas weldi	ng	Rubber pad		
equipment	-		Intermediate pip	oe	
Remove nuts from rear muffler					
Remove flange nuts—Wco 9/16					
Remove front muffler suspension Remove nuts of intermediate p	on point—Wco 9/16	Was 7/10			
bromove rigrs of infermediate b	ipe suspension point-	-was //16			
Release and lift clear exhaust or	/stem				
Release and lift clear exhaust sy Fit 4 new rubber pads	/stem		3		

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Exhaust system, rear muffler r (rear wheels off)	eplace	5—	25241
See 25210 excl: Jacking, remove-install wheels	and start-s	top engine	
Exhaust system, rear muffler a mediate pipe replace (rear whe		5–	25243
See 25204 excl: Jacking, remove-install wheels	and start-s	top engine	
Exhaust system, intermediate replace (rear wheel off)	pipe	5–	25245
See 25206 excl: Jacking, remove-install wheels	and start-s	top engine	
Exhaust system, change to twi system	n pipe	5–6	25246
Jack up and lower RH side—L Remove-install RH rear wheel- Collect and put away gas weld equipment	-SCs, Tanr		
Remove nuts at rear muffler b Remove flange nuts—Wco 9/16 Remove front muffler suspens	6, Was 9/16	6	quipment
Remove intermediate pipe sus Lift clear exhaust system Fit 4 new rubber pads		int nut-W	as 7 /16
Fit bolts and washers to 4 new Fit front muffler Fit intermediate pipe to centre			
Fit rear muffler Fit front pipes clamps Start-stop engine			
Check for leaks, adjust Spares:			
Front muffler, Intermediate pipe			
Rear muffler Gasket Set of clamp rings			
Exhaust system Suspension kit			

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Oper. No	Modelcode	Effective time	Secondary	Lost time allow- ance	Schedule time	Oper. No		delcode	Effecti time		Secondar time			ıle
	Ţ	I.		ance	Į.		1/1		I	- 1		ance		
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26108	9-	62	5	7	74									
26111	7–8	17	1	2	20									
26111	9-	13	1	1	15				VI.					
26114	7–8	65	2	7	74									
26114	9–	58	2	6	66									
26118	9–	5	1	1	7									
26134	7–	30	4	3	37									
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26141	7–8	28	1	3	32									
26141	9–	22	1	2	25	To this sh	neet	belong 3	sheet	s o	f repair	work	descr i	ptic
26143	7–8	34	2	4	40									
26144	7-	112	9	20	141									
26145	7-	68	9	8	85									
26146	9-	58	6	6	70									
26147	9-	38	6	4	48									
26148	7	6	1	1	8									
26149	7-	6		1	7									
26151	7-	40	3	4	47									
26153	7-	7	2	1	10									
26155	0-	19	2	2	23									
26159	0-	8	1	1	10									
26169	7 – 8	16	2	2	20									
26170	7-	18	4	2	24									
26172	7–8	40	5	5	50									
26172	9 –	35	5	4	44									
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26189	7–	2	2		4									

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			73-01-	02	1	26108	V4
RADIATOR replace Remove-install engine hood—Propen coolant draining screw—Vermove front panel—Was 7/16, Remove radiator—Pcl, Wco 1/2 Transfer shield plates—SCcs Fit new draining hose Fit new bottom radiator hose Fit draining screw Fit radiator Fit front panel Fill with coolant Start-stop engine, check for lea Check operation of hood lock Spares:	Vco 7/16, Mdv , SCcs, Wco 1/2, Ppn , Was 1/2, SCs	26108	Remov Remov Install I Refit h Install I Refit fr Spares: Hose Clip	e radiator e RH horn e hoses w hoses with orn radiator ront panel	n intermediate	as 1/2, SCs /as 1/2 rite pipes—SCs pipes to pump	
Radiator Draining hose			Remove	e front pa e radiator	ngine hood—S nel (not cable —Wco 1/2, Wa n—Wco 1/2, W	e)—Wco 7/16, S as 1/2, SCs	Ccs, Wco 1/2
RADIATOR replace Remove-install engine hood—Proposition coolant—Wco 7/16, Mdv Remove front panel (not hood Wco 1/2) Remove radiator—SCs, Wco 1/2 Remove expansion tank hose from the replacement of the	lock cable)—Wco 7/1 2, Was 1/2 rom radiator—SCs, Ck		Remove Connec Refit he Install r	e hose fro it hose to orn radiator ront panel	m pump—SCs pump		
Install radiator Refit front panel Fill with coolant—Wco 7/16, M Start-stop engine, check for lea Spares: Radiator complete			Remove Install e Spares:	e expansion	oansion tank r on tank—Scs` tank	eplace 9—	26118
COOLANT HOSES, bottom ho (9) (radiator or engine out) Remove RH horn—Wco 1/2, Wa Remove hoses with intermediat Transfer pipes to new hoses—SC Connect hose to pump Refit RH horn Spares: Hose Clip	as 1/2 te pipes—SCs	26111	Rémove Take of Sdh 13, Disconr	move-install er install er if gen and , Wco 12, nect 2 hos dh 3/8, H 2 hoses be	all gen) not congine hood—S place on whe Was 13 es between pu	Cs el housing—Trh ump and pipe—	n 3/8, Tebs,
COOLANT HOSES, bottom hoblace (radiator or engine out) See 26111 (7-8), excl transfer Spares: Hose Clip		26111	COOLA (14) rep Remove H, SCs,	olace (not e coolant crowbar	coolant) distribution to	block rear 7– ube–Tthn 1/4,	26136 Tebl, Sdh 3 /
COOLANT HOSES, bottom ho place (incl remove-install radiat coolant Remove-install engine hood—S0	or) not	26114		oolant dis	oses on tube tribution tube		

Wco 1/2

Remove front panel (not hood lock cable)-Wco 7/16, SCcs,

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Date Edition Page Replaces page **V4** 73-01-02 26141 **COOLANT HOSES, bottom radiator** 26141 7-8 COOLANT HOSES, bottom radiator 7-26145 hoses and hose from pump to tube hoses replace (9), coolant distribution replace (9+10) in conj with coolant pump replace tube hoses replace (7+14), nipple-tube hose replace (10) (radiator off) Slacken clip and remove hose from radiator-Pnu, SCs, SCssh Disconnect-connect earth (ground) cable at battery Slacken clip for narrow hose (nipple-tube)—SCs Remove RH horn-Wco 1/2, Was 1/2 Remove end plate with hoses Remove bottom radiator hoses with inter-Replace the two thick hoses (incl cleaning mediate tube-SCs connections)-SCs, Sk Transfer intermediate tube to new hoses-SCs Replace narrow hose (incl cleaning connections)-Fit hoses with intermediate tube to pump-SCs SCs, Ck Refit horn Grease inside of hoses-Vaseline Remove gen and bracket (incl leads from gen)-Position end plate and connect hoses to radiator Tanr, Sdh 12-1/2, Wco 1/2, Wadj and tube Remove coolant distribution tube-Trh, Sdh 10, Tighten clips-SCs Sdhl 9/16, H. Tebl, Mcb, SCcs, SCs Replace rear hoses on tube Spares: Replace front thick hose on tube Bottom radiator hoses (2 off), radiator hose, Replace hose from nipple to tube (nipple-tube), clips if nec. Refit coolant distribution tube-Vaseline, SCs Refit bracket and gen (incl lead to gen) **COOLANT HOSES, bottom radiator** 26141 Spares: hose and pump-tube hose replace (9+10) Hoses in conj with coolant pump replace Clips Slacken clip and remove hose from radiator-Pnu, SCs, SCssh COOLANT HOSES, hoses 1+7+10+14 9-26146 Slacken clip on narrow hose (nipple-tube) - SCs Remove end plate with hoses replace (no coolant) Replace thick hose (incl cleaning connections)-Radiator hoses replace, see 26147 SCs. Ck Add the following: Replace narrow hoses (incl cleaning connections)-Remove-install gen with bracket (posn above SCs, Ck stay)-Trh, Tebm, Wco 1/2, Sdh 1/2,-11/16 Grease hoses internally-Vaseline Position end plate and connect hoses to radiator and tube 26147 COOLANT HOSES, hoses 1+7+10+14 9-Tighten clips replace, gen off (no coolant) Spares: Remove coolant distribution tube-Trh, Sdh 10, Bottom radiator hose, radiator hose (nipple-tube), Sdhl 9/16, H, Tebl, Mcb, SCcs, SCs clips if nec Replace rear hoses on tube Replace front thick hose on tube Replace hose from nipple to tube, 2 off (hoses 1+10) COOLANT HOSES, hose 4+5+6+12 7-8 26143 Refit coolant distribution tube-Vaseline, SCs replace (air cleaner off, no coolant) Spares: Replace hoses 5+6+11-SCs Hoses Replace hoses 7-SCs, Vaseline Clips Spares: Hoses Clips 26148 COOLANT HOSES, hoses 2-3-4-7-6-8-11-12-13-15 replace 1st (air cleaner off) **COOLANT HOSES, bottom radiator** 7-26144 Remove hose-SCs hoses replace (9), coolant distribution Install hose tube hoses replace (7+14), nipple-tube hose replace (10) (incl remove-install Spares: radiator, no coolant) Hose Clips if nec Coolant hoses replace, see 26145 Add the following COOLANT HOSES, hose 2-3-4- 7- 26149 Remove-install engine hood 6-8-11-12-13-15 replace others Remove-install front panel each (air cleaner off) no coolant Remove-install radiator Remove hose-SCs

Install hose

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Repair Work Description SAAB 95/96

Fit drain screw—Wco 7/16, Mco 17/16 and 18/16 the Sure type of the sure ty	Replaces page	Date	Edition	Page	**************************************
Habitation of the color of the		73-01-02	1	26149	V4
Habitation of the color of the					
ARDIATOR, flush and clean 7— 26151 Drive car to and from washing area 2-rain coolant. Wco 7/16, Wco 11 Washington and the system with hot water selfit drain screws—Wco 7/16, Wco 1/2, Was 1/2 Fit drain screws—Wco 7/16, Wco 1/2, Ppn Remove rorate and strong washing area 2-rain coolant. Wco 7/16, Wco 11 Washington and the screws are selfit drain screws—Wco 7/16, Wco 1/2, Was 1/2 Fit drain screws—Wco 7/16, Wco 1/2, Ppn Remove roses—Sc 5 Bremove hoses—Sc 5 Fit drain screws—Wco 7/16, Mco 1/2, Was 1/2 Fit drain screws—Wco 7/16, Mco 1/2, Ppn Fill wcolant 2-rain screws, fill with coolant 2-rain screws—Wco 7/16, Mco 2-rain screws—Wco 7/16,		RADIATOR remov	vo.	7_	26170
Open coolant drain screws—Weo 7/16, Mdv Remove front panel—Was 7/16, SCcs, Wco 1/2, Ppn Remove radiator—Pel, Wco 1/2, Was 1/2 Part of the screws—Weo 7/16, Mdv Remove front panel—Was 7/16, SCcs, Wco 1/2, Ppn Remove radiator—Pel, Wco 1/2, Was 1/2 RADIATOR install 7—8 26177 RADIATOR install 8—9 26177 RADIATOR install 7—8 26177 RADIATOR install 8—9 26177 RADIATO				,-	20170
RADIATOR, flush and clean 7— 26151 Drive car to and from washing area brain coolant—Wco 7/16, Wco 11 Flush system with hot water Radit drain screws Flush radiator screws Flush radiator spainst direction of flow Flush coolant Start-stop engine, check for leaks Refit chars Refit chars screws, fill with coolant Start-stop engine, check for leaks Refit chars Refit chars Remove install coolant system tester—coolant system tester Pump up pressure Pump up pressure Pump up pressure Pump up pressure Pump up flush replace (3) (incl remove-install gen, not coolant) Remove install gen from/to bracket (posn above stay)—17th, Tebm, Wco 1/2, Sdh 1/2,—11/16 Replace hose—SCs, SCssh Spares: Hose Clip COOLANT HOSE, vertical hose from 0— 26159 Spares: Hose Clip Spares: Hose COOLANT HOSE, vertical hose from 0— 26159 Spares: Hose Clip Spares: Hose Clip Spares: Hose Clips if nec COOLANT HOSE, branching for 7—8 26169 attrocated choke—SCs, Vaseline Refit hoses to thermostat Spares: Hose COOLANT HOSEs, branching for 7—8 26169 attrocated choke—SCs, Vaseline Refit hoses to thermostat Spares: Hose COOLANT HOSEs, branching for 7—8 26169 attrocated choke—SCs, Vaseline Refit hoses to thermostat Spares: Hose COOLANT HOSEs, branching for 7—8 26169 attrocated choke—SCs, Vaseline Refit hose to thermostat Spares: Hose COOLANT HOSEs, branching for 7—8 26169 attrocated choke—SCs, Vaseline Refit hose to thermostat Spares: Hose COOLANT HOSEs, branching for 7—8 26169 attrocated choke—SCs, Vaseline Refit hose to thermostat Spares: Hose Coolant Hoses (2) at automatic choke—SCs, Vaseline Refit hose to thermostat Remove hoses (2) at automatic choke—SCs, Vaseline Refit hose to thermostat Hose Hose Hose Hose Coolant Hoses Hose Hose	Clips it nec				
Remove radiator—Pcl, Wco 1/2, Was 1/2 Provise art to and from washing area Drain coolent—Wco 7/16, Wco 11 Plush system with hot water Refit drain screws with hot water Remove hoses—Store Plush engine until warm during break Drain coolant Remove hoses—Store Plush cooling system against direction of flow Refit hoses RADIATOR, pressure testing, checking hoses 7—26153 Remove-install coolant system tester—coolant System tester Pump up pressure Check all hoses—M1 COOLANT HOSE, vertical hose from 0—26155 Pump and plata replace (3) (incl remove- install gen, from/to bracket (poss above stay)—Th, Tebrn, Wco 1/2, Sdn 1/2,—11/16 Replace hose—Store Shares: Hose Clip COOLANT HOSE, vertical hose from 0—26159 Pump and plata replace (2) Igen off or angine outh not coolant Remove radiator—Pcl, Wco 1/2, Was 1/2 RADIATOR install 7—8 26197. Fit drain screws—Wco 7/16 Install radiator—Pcl, Wco 1/2, Was 1/2 Refit and install rediator—Pcl, Wco 1/2, Was 1/2 Refit drain screws—Wco 7/16 Install radiator—Pcl, Wco 1/2, Was 1/2 Refit drain screws—Wco 7/16 Install radiator—Pcl, Wco 1/2, Was 1/2 Refit drain screws—Wco 7/16 Install radiator—Pcl, Wco 1/2, Was 1/2 Refit drain screws—Wco 7/16 Install radiator—Pcl, Wco 1/2, Was 1/2 Refit drain screws—Wco 7/16 Install radiator—Pcl, Wco 1/2, Was 1/2 Refit drain screws—Wco 7/16 Install radiator—Pcl, Wco 1/2, Was 1/2 Refit drain screws—Wco 7/16, Scc, Wco 1/2, Ppn Fill with coolant. Refit and install rediator—Pcl, Wco 1/2, Was 1/2 Refit drain screws—Wco 7/16 Install radiator—Pcl, Wco 1/2, Was 1/2 Refit drain screws—Wco 7/16, Scc, Wco 1/2, Was 1/2 Refit drain screws—Wco 7/16, Scc, Wco 1/2, Was 1/2 Refit drain screws—Wco 7/16, Scc, Wco 1/2, Was 1/2 Refit drain screws—Wco 7/16, Scc, Wco 1/2, Was 1/2 Refit drain screws—Wco 7/16, Scc, Wco 1/2, Was 1/2 Refit drain screws—Wco 7/16, Scc, Wco 1/2, Was 1/2 Refit drain screws—Wco 7/16 Install radiator—Pcl, Wco 7/16 Install radiator—Pcl, Wco 7/16 Install radiator—Pcl, Wco 7/16 Install radiator—Pcl, Wco 7/16		Open coolant drair	screws-Wco 7	7/16, Mdv	
Drive car to and from washing area Drain coolant—Wco 7/16, Wco 172, Was 1/2 Fit drain screws—Wco 7/16, Wco 172, Was 1/2 Fit drain screws—Wco 7/16, SCos, Wco 1/2, Was 1/2 Fit drain screws—Wco 7/16 Install radiator—Pcl, Wco 1/2, Was 1/2 Fit drain screws—Wco 7/16 Install radiator—Pcl, Wco 1/2, Was 1/2 Fit drain screws—Wco 7/16 Install radiator—Pcl, Wco 1/2, Was 1/2 Fit drain screws—Wco 7/16 Install radiator—Pcl, Wco 1/2, Was 1/2 Fit drain screws—Wco 7/16 Install radiator—Pcl, Wco 1/2, Was 1/2 Fit drain screws—Wco 7/16 Install radiator—Pcl, Wco 1/2, Was 1/2 Fit drain screws—Wco 7/16 Install radiator—Pcl, Wco 1/2, Was 1/2 Fit drain screws—Wco 7/16 Install radiator—Pcl, Wco 1/2, Was 1/2 Fit drain screws—Wco 7/16 Install radiator—Pcl, Wco 1/2, Was 1/2 Fit drain screws—Wco 7/16 Install radiator—Pcl, Wco 1/2, Was 1/2 Fit drain screws—Wco 7/16 Install radiator—Pcl, Wco 1/2, Was 1/2 Fit drain screws—Wco 7/16 Install radiator—Pcl, Wco 1/2, Was 1/2 Fit drain screws—Wco 7/16 Install radiator—Pcl, Wco 1/2, Was 1/2 Fit drain screws—Wco 7/16 Install radiator—Pcl, Wco 1/2, Was 1/2 Fit drain screws—Wco 7/16 Install radiator—Pcl, Wco 1/2, Was 1/2 Fit drain screws—Wco 7/16 Install radiator—Pcl, Wco 1/2, Was 1/2 Fit drain screws—Wco 7/16 Install radiator—Pcl, Wco 1/2, Was 1/2 Fit drain screws—Wco 7/16 Install radiator—Pcl, Wco 1/2, Was 1/2 Fit drain screws—Wco 7/16 Install radiator—Pcl, Wco 1/2, Was 1/2 Fit drain screws—Wco 7/16 Install radiator—Pcl, Wco 1/2, Was 1/2 Fit drain screws—Wco 7/16 Install radiator—Pcl, Wco 1/2, Was 1/2 Fit drain screws—Wco 7/16 Install radiator—Pcl, Wco 1/2, Was 1/2 Fit drain screws—Wco 7/16 Install radiator—Pcl, Wco 7/16 Install radiator—Pcl, Wco 1/2, Was 1/2 Fit drain screws—Wco 7/16 Install radiator—Pcl, Wco 1/2, Was 1/2 Fit drain screws—Wco 7/16 Install radiator—Pcl, Wco 1/2, Wco 1/2 Install radiator—Pcl, Wco 7/16 Install radiator—Pcl, Wco 1/2, Wco 1/2 Install radiator—Pcl, Wco 1/2 Install radiator—Pcl, Wco 1/2 Install radiator—Pcl, Wco 1/2 I	PADIATOR flush and clean 7— 26151	Remove front pane	el-Was 7 /16, S	Ccs, Wco 1/2	Ppn
Prain coolant—Woo 7/16, Wco 11 Elish system with hot water Refit drain screws Fill system with solvent—coalic acid Run engine until warm during break Prain coolant Remove hoses—SCs 5 Flush cooling system against direction of flow Refit hoses RADIATOR, pressure testing, checking hoses RADIATOR, pressure REMOVE hose—Install coolant system tester—coolant System tester RUMP up pressure Check all hoses—M1 COOLANT HOSE, vertical hose from 0— 26155 pump end plate replace (3) (incl remove- install gen, not coolant) Remove install gen from/to bracket (posn above stay)—Trh, Tabm, Wco 1/2, Sdh 1/2,—11/16 Replace hose—SCs, SCssh Spares: Hose CIDip COOLANT HOSE, vertical hose from 0— 26159 pump end plate replace (2) Igen off or engine out) not coolant Remove vertical hose—SCss Install hose—SCss Install vertical hose—SCs Spares: Hose CIDips if nec COOLANT HOSEs, branching for 7—8 26169 air cleaner off, not coolant Disconnect hose at thermostat—SCs Remove hoses (2) at automatic choke—SCs, Vaseline Refit hose to thermostat Spares: Spares: Hose COOLANT HOSEs, branching for 7—8 26169 air cleaner off, not coolant Disconnect hose at thermostat—SCs Remove hoses (2) at automatic choke—SCs, Vaseline Refit hose to thermostat Spares:	HADIATON, Husil and Glean 7— 20131	Remove radiator-I	Pcl, Wco 1/2, W	Vas 1/2	
Prain coolant—Woo 7/16, Wco 11 Elish system with hot water Refit drain screws Fill system with solvent—coalic acid Run engine until warm during break Prain coolant Remove hoses—SCs 5 Flush cooling system against direction of flow Refit hoses RADIATOR, pressure testing, checking hoses RADIATOR, pressure REMOVE hose—Install coolant system tester—coolant System tester RUMP up pressure Check all hoses—M1 COOLANT HOSE, vertical hose from 0— 26155 pump end plate replace (3) (incl remove- install gen, not coolant) Remove install gen from/to bracket (posn above stay)—Trh, Tabm, Wco 1/2, Sdh 1/2,—11/16 Replace hose—SCs, SCssh Spares: Hose CIDip COOLANT HOSE, vertical hose from 0— 26159 pump end plate replace (2) Igen off or engine out) not coolant Remove vertical hose—SCss Install hose—SCss Install vertical hose—SCs Spares: Hose CIDips if nec COOLANT HOSEs, branching for 7—8 26169 air cleaner off, not coolant Disconnect hose at thermostat—SCs Remove hoses (2) at automatic choke—SCs, Vaseline Refit hose to thermostat Spares: Spares: Hose COOLANT HOSEs, branching for 7—8 26169 air cleaner off, not coolant Disconnect hose at thermostat—SCs Remove hoses (2) at automatic choke—SCs, Vaseline Refit hose to thermostat Spares:	Drive car to and from washing area				
Fill system with hot water Reflit drain screws Fill system with solvent—oxalic acid Fill drain screws Fill system with solvent—oxalic acid Fill system with solvent—oxalic acid Fill system with solvent—oxalic acid Fill drain screws—Woo 7/16 Install radiator—Pcl, Woo 1/2, Was 1/2 Fit front penel—Was 7/16, SCcs, Wco 1/2, Ppn Fill with coolant Reflit engine hood Start-stop engine, check for leaks RADIATOR, pressure testing, checking hoses 7—26153 Remove-install coolant system tester—coolant system tester Pump up pressure Check all hoses—M1 COOLANT HOSE, vertical hose from 0— 26155 pump end plate replace (3) (incl remove- install gen, not coolant) Remove-install gen from/to bracket (posn above stay)—Th, Tebm, Wco 1/2, Sdn 1/2,—11/16 Replace hose—SCs, SCssh Spares: Clip COOLANT HOSE, vertical hose from 0— 26159 pump end plate replace (2) (gen off or engine out) not coolant Remove vertical hose—SCs Spares: COOLANT HOSE, vertical hose from 0— 26159 pump end plate replace (2) (gen off or engine out) not coolant Remove vertical hose—SCs Spares: COOLANT HOSE, vertical hose from 0— 26159 pump end plate replace (2) (gen off or engine out) not coolant Remove vertical hose—SCs Spares: COOLANT HOSE, vertical hose from 0— 26159 pump end plate replace (2) (gen off or engine out) not coolant Remove vertical hose—SCs Spares: Hose Clip COOLANT HOSEs, branching for 7—8 26169 attriction serve—Wco 7/16 Install hoses (2) at automatic choke—SCs Remove hoses (2) at automatic choke—SCs, Vaseline Reflit hose to thermostat Spares: Spares: COOLANT HOSES, branching for 7—8 26169 attriction serve—Wco 7/16 Install hoses (2) at automatic choke—SCs, Vaseline Reflit hose to thermostat Spares: COOLANT HOSEs, branching for 7—8 26169 attriction serve—Wco 7/16 Install radiator—Pcl, Wco 7/16 Install radiator—Pcl, Wco 7/16 Install radiator—SCs Remove hoses (2) at automatic choke—SCs, Vaseline Reflit hose to thermostat Spares:		DADIATOR			
Fill system with solvent—oxalic acid Run engine until warm during break Drain coolant Remove hoses—SCs 5 Reift drain screws, fill with coolant Start-stop engine, check for leaks RADIATOR, pressure testing, checking hoses 7— '26153 Remove-install coolant system tester—coolant system tester Pump up pressure CCOOLANT HOSE, vertical hose from 0— 26155 Popume end plate replace (3) (incl remove-install gen, not coolant) Remove-install gen from/to bracket (posn above stay)—Th.T, Pebm, Woo 1/2, Sdh 1/2,—11/16 Replace hose—SCs, SCssh Spares: Hose Clip COOLANT HOSE, vertical hose from 0— 26159 pump end plate replace (2) Igen off or engine out) not coolant Remove vertical hose—SCsh Install vertical hose—SCsh Ristall vertical hose—SCsh Ristall vertical hose—SCs Remove vertical hose—SCs Remove hoses—SCs) Spares: Hose Clip COOLANT HOSE, vertical hose from 0— 26159 pump end plate replace (2) Igen off or engine out) not coolant Remove vertical hose—SCsh Install vertical hose—SCsh Ristall vertical hose—SCs Remove hoses—SCs (2) at automatic choke—SCs, Vaseline Refit hoses (2) at automatic choke—SCs, Vaseline Refit negine hood Start-stop engine, check for leaks Check operation of hood lock Refit angine hood Start-stop engine, check for leaks Check operation of hood lock Refit engine hood Start-stop engine, check for leaks Check operation of hood lock Refit engine hood Start-stop engine, check for leaks Check operation of hood lock Refit engine hood Start-stop engine, check for leaks Check operation of hood lock Refit engine hood Start-stop engine, check for leaks Check operation of hood lock Refit engine hood Start-stop engine, check for leaks Check operation of hood lock Refit engine hood Start-stop engine, check for leaks Check operation of hood lock Refit engine hood Start-stop engine, check for leaks Check operation of hood lock Refit engine hood Start-stop engine, check for leaks Check operation of hood lock Refit engine hood Start-stop engine, check for leaks COOLANT HOSE, pump-tump of hood for leaks COOLANT HOSE, pump-tump	Flush system with hot water	RADIATOR Install		7–8	26172
Filt front panel—Was 7/16, SCcs, Wco 1/2, Ppn Fill with coolant Remove hoses—SCs 5 Flush addition against direction of flow Flush radiator against direction of flow Refit chairs screws, fill with coolant Start-stop engine, check for leaks RADIATOR, pressure testing, checking hoses 7— 26153 Remove-install coolant system tester—coolant system tester—coolant system tester Pump up pressure Check all hoses—M1 COOLANT HOSE, vertical hose from 0— 26155 pump end plate replace (3) (incl remove-install gen, not coolant) Remove-install gen from/to bracket (posn above stay)—Trh, Tebm, Wco 1/2, Sdh 1/2,—11/16 Replace hose—SCs, SCssh Soares: Hose Clip COOLANT HOSE, vertical hose from 0— 26159 pump end plate replace (2) Igen off or engine out) not coolant Remove vertical hose—SCsh install coolant Remove vertical hose—SCsh install vertical hose—SCsh install coolant (radiator)—Wco 7/16, Mdv Fill with coolant (radiator)—Wco 7/16 COOLANT HOSE, pump and tube—Th 3/8, Tebs, Sdh 13, Wco 12, Wco 7/16 COOLANT HOSE, pump and tube—Th 3/8, Tebs, Sdh 13, Wco 12, Wco 7/16 COOLANT HOSE, pump and tube—Th 3/8, Teb	Refit drain screws				
Fill with coolant Remove hose—SCs 5 Flush cooling system against direction of flow Flush radiator against direction of flow Refit chain screws, fill with coolant Start-stop engine, check for leaks RADIATOR, pressure testing, checking hoses 7 – '26153 Remove-install coolant system tester Pump up pressure Check all hoses—M1 COOLANT HOSE, vertical hose from 0 – 26155 pump end plate replace (3) (find remove-install gen, not coolant) Remove-install gen, not coolant) Remove-install gen from/to bracket (posn shove stay)—Trh, Tebm, Wco 1/2, Sdh 1/2,—11/16 Replace hose—SCs, SCssh Spares: Hose Clip COOLANT HOSE, vertical hose from 0 – 26159 pump and plate replace (2) (gen off or engine out) not coolant Remove vertical hose—SCsh Install vertical hose—SCsh Install vertical hose—SCsh Install vertical choke (2 short) replace (5) air cleaner off, not coolant Remove hoses (2) at automatic choke—SCs, Vaseline Refit hoses to thermostat Spares: Spares: Hose COOLANT HOSEs, branching for 7—8 26169 puttomatic choke (2 short) replace (5) air cleaner off, not coolant Remove hoses (2) at automatic choke—SCs, Vaseline Refit hose to thermostat Spares: Spares: Hose COOLANT HOSES, branching for 7—8 26169 puttomatic choke (2 short) replace (5) air cleaner off, not coolant Remove hoses (2) at automatic choke—SCs, Vaseline Refit hose to thermostat Spares: Hose COOLANT HOSES, branching for 7—8 26169 puttomatic choke (2) at automatic choke—SCs, Vaseline Refit hose to thermostat	Fill system with solvent—oxalic acid				
Remove hoses—SCs 5 Flush radiator against direction of flow Flush radiator against direction of flow Refit chairs screws, fill with coolant Start-stop engine, check for leaks RADIATOR, pressure testing, checking hoses 7—26153 Remove-install coolant system tester—coolant system tester Pump up pressure Check all hoses—M1 COOLANT HOSE, vertical hose from 0—26155 pump end plate replace (3) (incl remove- install gen, not coolant) Remove-install gen from/to bracket (posn above stay)—Trh, Tebm, Wco 1/2, Sdh 1/2,—11/16 Replace hose—SCs, SCssh Spares: Hose Clip COOLANT HOSE, vertical hose from 0—26159 pump end plate replace (2) Igen off or engine out) not coolant Remove vertical hose—SCsh install vertical hose—SCsh install vertical hose—SCsh install vertical hose—SCsh install vertical hose—SCs Clips if nec COOLANT HOSES, branching for 7—8 26169 puttomatic choke (2 short) replace (5) air cleaner off, not coolant COOLANT HOSES, branching for 7—8 26169 puttomatic choke (2 short) replace (5) air cleaner off, not coolant COOLANT HOSES, branching for 7—8 26169 puttomatic choke (2 short) replace (5) air cleaner off, not coolant COOLANT HOSES, branching for 7—8 26169 puttomatic choke (2 short) replace (5) air cleaner off, not coolant COOLANT HOSES, branching for 7—8 26169 puttomatic choke (2 short) replace (5) air cleaner off, not coolant COOLANT HOSES, branching for 7—8 26169 puttomatic choke (2 short) replace (5) air cleaner off, not coolant COOLANT HOSES, branching for 7—8 26169 puttomatic choke (2 short) replace (5) air cleaner off, not coolant COOLANT HOSES, branching for 7—8 26169 puttomatic choke (2 short) replace (5) air cleaner off, not coolant COOLANT HOSES, branching for 7—8 26169 puttomatic choke (2 short) replace (5) air cleaner off, not coolant COOLANT HOSES, branching for 7—8 26169 puttomatic choke (2 short) replace (5) are cleaner off, not coolant COOLANT HOSES, branching for 7—8 26169 puttomatic choke (2 short) replace (5) are cleaner off, not coolant COOLANT HOSES, branching for 7—8 26169 puttomatic choke			as 7/16, SCcs, V	Nco 1/2, Ppn	
Flush cooling system against direction of flow Relit hoses Refit drain screws, fill with coolant Start-stop engine, check for leaks RADIATOR, pressure testing, checking hoses 7— 26153 Remove-install coolant system tester—coolant system tester—coolant system tester Pump up pressure Check all hoses—M1 COOLANT HOSE, vertical hose from 0— 26155 Replace hose—SCs, SCssh Spares: Hose Clip COOLANT HOSE, vertical hose from 0— 26159 pump end plate replace (2) (jincl remove-install gen from/to bracket (posn above stay)—Trh, Tehm, Weo 1/2, Sdh 1/2,—11/16 Replace hose—SCs, SCssh Spares: Hose Clip COOLANT HOSE, vertical hose from 0— 26159 pump and plate replace (2) (gen off or angine out) not coolant Remove vertical hose—SCs Hose Clip COOLANT HOSE, vertical hose from 0— 26159 pump and plate replace (2) (gen off or angine out) not coolant Remove vertical hose—SCs Hose Clips if nec COOLANT HOSES, branching for 7—8 26169 automatic choke (2 short) replace (5) air cleaner off, not coolant COOLANT HOSES, branching for 7—8 26169 automatic choke (2 short) replace (5) air cleaner off, not coolant COOLANT HOSES, branching for 7—8 26169 automatic choke (2) at automatic choke—SCs, Vaseline Refit hoses (2) at automatic choke—SCs, Vaseline Refit hose to thermostat Spares: COOLANT HOSES, branching for 7—8 26169 automatic choke (2) at automatic choke—SCs, Vaseline Refit hose to thermostat Spares:		The state of the s			
Check operation of hood lock RADIATOR, pressure testing, checking hoses 7—°26153 REMOVE-install coolant system tester—coolant system tester—coolant system tester—Pump up pressure Check all hoses—M1 COOLANT HOSE, vertical hose from 0— 26155 pump end plate replace (3) (find remove-install gen, not coolant) Remove-install gen, not coolant) Remove-install gen from/to bracket (posn above stay)—Trh, Tebm, Wco 1/2, Sdh 1/2,—11/16 Replace hose—SCs, SCssh Spares: Hose Clip COOLANT HOSE, vertical hose from 0— 26159 pump end plate replace (2) Igen off or engine out) not coolant Remove vertical hose—SCs Spares: Hose Clips COOLANT HOSE, vertical hose from 0— 26159 pump end plate replace (2) Igen off or engine out) not coolant Remove vertical hose—SCs Spares: Hose Clips if nee COOLANT HOSES, branching for 7—8 26169 automatic choke (2 short) replace (5) air cleaner off, not coolant Disconnect hose at thermostat—SCs Remove hoses (2) at automatic choke—SCs, Vaseline Refit hoses to thermostat Spares:			C - 10 *		
RADIATOR install 9— 26172 RADIATOR, pressure testing, checking hoses 7— 26163 Remove-install coolant system tester—coolant system tester Pump up pressure Check all hoses—M1 COOLANT HOSE, vertical hose from 0— 26155 pump end plate replace (3) (incl remove-install gen, not coolant) Remove-install gen from/to bracket (posnabove stay)—Trh, Tebm, Wco 1/2, Sdh 1/2,—11/16 Replace hose—SCs, SCssh Spares: Hose CIDIP COOLANT HOSE, vertical hose from 0— 26159 pump and plate replace (2) (gen off or engine out), not coolant Remove vertical hose—SCs Spares: Hose CIDIP COOLANT HOSE, vertical hose from 0— 26159 pump and plate replace (2) (gen off or engine out), not coolant Remove vertical hose—SCs Spares: Hose Clips COOLANT HOSE, branching for 7—8 26169 automatic choke (2 short) replace (5) air cleaner off, not coolant COOLANT HOSEs, branching for 7—8 26169 automatic choke (2 short) replace (5) air cleaner off, not coolant Disconnect hose at thermostat—SCs Remove hoses (2) at automatic choke—SCs, Vaseline Refit hose to thermostat Spares:		Chock operation of	heck for leaks		
RADIATOR, pressure testing, checking hoses 7— 26153 RADIATOR, pressure testing, checking hoses 7— 26153 Remove-install coolant system tester—coolant syste			HOOD FOCK		
RADIATOR, pressure testing, checking hoses 7 – 26153 Remove-install coolant system tester coolant system tester pump up pressure Check all hoses—M1 COOLANT HOSE, vertical hose from 0— 26155 pump up pressure light engine of the coolant showers stay)—Trh, Tebm, Weo 1/2, Sdh 1/2,—11/16 Replace hose—SCs, SCssh Spares: Hose Clip COOLANT HOSE, vertical hose from 0— 26159 pump end plate replace (2) (gen off or engine out) not coolant pump end plate replace (2) (gen off or engine out) not coolant pump end plate replace (2) (gen off or engine out) not coolant pump end plate replace (2) (gen off or engine out) not coolant pump end plate replace (2) (gen off or engine out) not coolant pump end plate replace (2) (gen off or engine out) not coolant pump end plate replace (2) (gen off or engine out) not coolant pump end plate replace (2) (gen off or engine out) not coolant pump end plate replace (2) (gen off or engine out) not coolant pump end plate replace (3) (end to the coolant pump end plate replace (2) (gen off or engine out) not coolant pump end plate replace (2) (gen off or engine out) not coolant pump end plate replace (2) (gen off or engine out) not coolant pump end plate replace (2) (gen off or engine out) not coolant pump end plate replace (2) (gen off or engine out) not coolant pump end plate replace (2) (gen off or engine out) not coolant pump end plate replace (2) (gen off or engine out) not coolant pump end plate replace (2) (gen off or engine out) not coolant pump end plate replace (2) (gen off or engine out) not coolant pump end plate replace (2) (gen off or engine out) not coolant pump end plate replace (2) (gen off or engine out) not coolant pump end plate replace (2) (gen off or engine out) not coolant pump end plate replace (2) (gen off or engine out) not coolant pump end plate replace (2) (gen off or engine out) not coolant pump end plate replace (2) (gen off or engine out) not coolant pump end plate replace (2) (gen off or engine out) not coolant pump end plate replace (2) (gen off or engine out) not					
Fit drain screw—Wco 7/16 Install radiator—SCs, Wco 1/2, Was 1/2 Remove-install coolant system tester—coolant system tester Pump up pressure Check all hoses—M1 COOLANT HOSE, vertical hose from 0— 26155 pump end plate replace (3) (incl remove- install gen, not coolant) Remove-install gen from/to bracket (posn above stay)—Trh, Tebm, Wco 1/2, Sdh 1/2,—11/16 Replace hose—SCs, SCssh Spares: Hose Clip COOLANT HOSE, vertical hose from 0— 26159 pump end plate replace (2) (gen off or engine out) not coolant Remove vertical hose—SCs Install radiator—SCs, Wco 1/2, Was 1/2 Fill with coolant—Mfc Refit tengine hood Start-stop engine, check for leaks COOLANT drain-fill and check 7— 26181 for leaks (in conj with hoses replace) Drain coolant (radiator)—Wco 7/16, Mdv Fill with coolant, vent and fit cap—Mfc, Wco 7/16 Start-stop engine, check for leaks COOLANT HOSE, vertical hose from 0— 26159 pump end plate replace (2) (gen off or engine out) not coolant Remove vertical hose—SCssh Install radiator—SCs, Wco 1/2, Was 1/2 Refit tengine hood Start-stop engine, check for leaks COOLANT Hoses, pump-tube 7— 26183 (2 short) replace (gen off or engine out), not coolant Remove Vertical hose—SCs Spares: Hose Clips if nee COOLANT HOSES, branching for 7—8 26169 attomatic choke (2 short) replace (5) air cleaner off, not coolant Disconnect hose at thermostat—SCs Remove hoses (2) at automatic choke—SCs, Vaseline Refit hose to thermostat Spares:		RADIATOR install		9 _	26172
Install rediator—SCs, Wco 1/2, Was 1/2 Refit front panel—Wco 7/16, SCcs, Wco 1/2 Fill with coolant—Mfc Refit engine hood Start-stop engine, check for leaks COOLANT HOSE, vertical hose from 0— 26155 pump end plate replace (3) (incl remove- install gen, not coolant) Remove-install gen from/to bracket (posn above stay)—Trh, Tebm, Wco 1/2, Sdh 1/2,—11/16 Replace hose—SCs, SCssh Spares: Hose CIDip COOLANT HOSE, vertical hose from 0— 26159 pump end plate replace (2) (gen off or engine out) not coolant Remove-vertical hose—SCs Clips if nec COOLANT HOSEs, branching for 7—8 26169 automatic choke (2 short) replace (5) air cleaner off, not coolant Disconnect hose at thermostat—SCs Remove hoses (2) at automatic choke—SCs, Vaseline Refit front panel—Wco 7/16, SCcs, Wco 1/2 Fill with coolant—Mfc Refit engine hood Start-stop engine, check for leaks COOLANT drain-fill and check 7— 26181 for leaks (in conj with hoses replace) Drain coolant (radiator)—Wco 7/16, Mdv Fill with coolant, Fill and check 7— 26181 for leaks (in conj with hoses replace) Drain coolant (radiator)—Wco 7/16, Mdv Fill with coolant, Fill and check 7— 26181 for leaks (in conj with hoses replace) Drain coolant (radiator)—Wco 7/16, Mdv Fill with coolant, Wco 7/16 Start-stop engine, check for leaks COOLANT HOSES, pump-tube 7— 26183 (2 short) replace (gen off or engine out), not coolant Remove 2 hoses between pump and tube Trh 3/8, Tebs, Sdh 13, Wco 12, Was 13 Fit 2 hoses between pump and tube Trh 3/8, Tebs, Sdh 13, Wco 12, Was 13 Fit 2 hoses between pump and tube COOLANT fill and vent 7— 26189 Fill with Coolant incl venting—Mfc, Wco 7/16 COOLANT fill and vent 7— 26189 Fill with coolant with coolant incl venting—Mfc, Wco 7/16				3_	20172
Remove-install coolant system tester—coolant system tester—coolant system tester Pump up pressure Check all hoses—M1 COOLANT HOSE, vertical hose from 0— 26155 pump end plate replace (3) (incl remove- install gen, not coolant) Remove-install gen from/to bracket (posn sebove stay)—Trh, Tebm, Wco 1/2, Sdh 1/2,—11/16 Replace hose—SCs, SCssh Spares: Hose Clip COOLANT HOSE, vertical hose from 0— 26159 pump end plate replace (2) (gen off or engine out) not coolant Remove vertical hose—SCssh Install vertical hose—SCssh Install vertical hose—SCs Clips if nec COOLANT HOSES, branching for 7—8 26169 automatic choke (2 short) replace (5) air cleaner off, not coolant Disconnect hose at thermostat—SCs Remove hoses (2) at automatic choke—SCs, Vaseline Refit front panel—Wco 7/16, SCcs, Wco 1/2 Fill with coolant—Wcc Refit engine hood Start-stop engine, check for leaks COOLANT drain-fill and check 7— 26181 for leaks (in conj with hoses replace) Drain coolant, (radiator)—Wco 7/16, Mdv Fill with coolant, vent and fit cap—Mfc, Wco 7/16 Start-stop engine, check for leaks COOLANT HOSES, pump-tube 7— 26183 (2 short) replace (gen off or engine out), not coolant Remove 2 hoses between pump and tube— Trh 3/8, Tebs, Sdh 13, Wco 12, Was 13 Fit 2 hoses between pump and tube Spares: Hose Clip COOLANT HOSES, branching for 7—8 26169 automatic choke (2 short) replace (5) air cleaner off, not coolant Disconnect hose at thermostat—SCs Remove hoses (2) at automatic choke—SCs, Vaseline Refit engine hood Start-stop engine, check for leaks COOLANT HOSES, pump-tube 7— 26183 (2 short) replace (gen off or engine out), not coolant Remove 2 hoses between pump and tube— Trh 3/8, Tebs, Sdh 13, Wco 12, Was 13 Fit 2 hoses between pump and tube Trh 3/8, Tebs, Sdh 13, Wco 12, Was 13 Fit 2 hoses between pump and tube Trh 3/8, Tebs, Sdh 13, Wco 12, Was 13 Fit 2 hoses between pump and tube Toolant Hoses—Clip and the pump and tube— Trh 3/8, Tebs, Sdh 13, Wco 12, Was 13 Fit 2 hoses between pump and tube— Trh 3/8, Tebs, Sdh 13, Wco 12, Wco 12, Wco 12,	RADIATOR pressure testing checking hoses 7- 326153				
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Fit 2 hoses between pump and tube Spares: Hose Clip COOLANT HOSES, branching for 7–8 26169 automatic choke (2 short) replace (5) air cleaner off, not coolant Disconnect hose at thermostat—SCs Remove hoses (2) at automatic choke—SCs, Vaseline Refit hose to thermostat Spares: Hose COOLANT fill and vent 7– 26189 Fill with Coolant incl venting—Mfc, Wco 7/16	COOLANT HOSE vertical hose from 0- 26159				
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Install hoses (2) at automatic choke—SCs, Vaseline Refit hose to thermostat Spares:					
Refit hose to thermostat Spares:				31	
Spares:	Refit hose to thermostat				
	Spares: Hoses and clips				

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per, No	Modelcode	Effective	Secondary time	Lost time allow- ance	Schedule time	Oper. No	Mo	delcode	Effectiv	/8		Lost time allow- ance	Schedule time
6201	7-	23	8	3	34								
26202	7 - 8	89	13	10	111								
26202	9–	96	13	11	119								
26209	7-	13	2	2	17								
6210	7-	181	16	20	217								
26211	7-	55	9	6	70								
26212	7–	7	1	1	9								
26213	7-	82	10	9	101								
6214	7–	6	1	1	8								
26216	7–8	60	5	7	72								
6216	9–	55	5	6	66								
6227	7–	10	2	1	13								
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6297	7–	41	4	5	50								
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	FAN BEARING replace (timin gear cover off)	g 7-	26201	Apply oil to bolt Posn gaskets and	pump
	Remove hoses from coolant put Arrange press Press out fan bearing—hydrauli Wipe clean and apply loctite—L Press bearing into timing gear of Press fan hub onto bearing shall Check measurements—slide gau Position and lock washer—H Tidy up after pressing Refit hoses to coolant pump	c press, mandrel Loctite cover—Assembly to ft	ool 786219	Refit pump and I Clean and fit new SCs, Ck, emery o Refit vertical hos Refit bracket and Tah Reconnect leads Refit water pipe Reconnect earth Fill with coolant	v thick'hose (cloth se to nipple—S d gen—Trh 3/8 to ign coil and clips—SCcs (ground) lead
	Spares: Fan bearing, plug			Start-stop engine Refit engine hoo Spares:	
	COOLANT PUMP replace	7-8	26202	Collant pump, Gaskets Clips	
	Drain coolant—Wco 7/16, Mdv Remove engine hood—SCs Disconnect earth (ground) cabl	le from battery—W	/co 1/2	Hose (thick)	
	Disconnect lead from ign coil a Remove gen with bracket from on wheel housing—Trh 3/8, Sd	timing gear cover		gear cover off)	
	Remove thick hose (end plate- Tebl, Ck, Ppo, Wadj Remove clip on both water pip Remove pump bolts and take o	es-SCcs		Remove pump b Take off pump, Posn gaskets and Refit pump bolt	clean mating I pump
	Tebf, Tebl, SCs Remove gaskets and clean mati		, 5411 10,	Spares: Pump _s	
	Apply oil to bolts—Moc Position pump and gaskets Refit pump and bolts			Gaskets	
	Clean and fit new thick hose (e cloth, SCs, Vaseline			FAN BEARING Remove engine I	
	Refit gen with bracket—Trh 3/ Reconnect leads to ign coil and Refit water pipe clips—SCcs	l No1 cyl		Drain coolant—N Disconnect earth	//dv, Wco 7/16 n (ground) cab
den	Reconnect earth (ground) cable Fill with coolant and vent—Wo Start-stop engine, check for lea	o 7/16, Mfc	1/2	Remove front pa Remove rad—Pcl Remove gen—Wo	I, Wco 1/2, Wa co 12 and 13
t-Kundendienstabteilung - Nyköping - Sweden-Schweden	Refit engine hood Spares:			Remove hoses fr Remove fan and Remove balance	pulley-Was 'shaft pulley-
g - Swed	Coolant pump, Gaskets Clips	*		Remove sump be Remove timing of Take off timing	gear cover bol
Nyköpin	Hose (thick)	<u> </u>		Place rag over su Scrape off gaske	mp
teilung -	COOLANT PUMP replace Drain coolant—Wco 7/16, Mdv	9–	26202	Remove rag Scrape off gaske Scrape off gaske	
stab	Remove engine hood—Scs			Remove balance	shaft seal-to
dien	Disconnect earth (ground) cabl		/co 1/2	Wash timing gear	
uapu	Disconnect lead from ign coil a			See 26201 (7-) Fit sump gasket-	
t-Kur	Remove gen with bracket from			Apply sealing co	

on wheel housing-Trh 3/8, Tebs, Wco 1/2, Sdh 1/2,

11/16, M1

Remove bracket from timing gear cover Remove vertical hose from nipple-SCssh

Remove thick hose (end plate-tube)-Trh 3/8, Sdh 10, Tebl,

Sdh 9/16, H, Scs, Ck, Ppo

Remove clip on both water pipes-SCcs

Remove pump bolts and take off pump-Trh 3/8, Sdh 10,

Tebf, Tebl, SCs

Remove gaskets and clean mating surfaces-Ck

(end plate-tube)-Vaseline,

/8, Tebs, Wco 1/2, Sdh 11/16,

Page 26201

V4

nd No 1 cyl

d-Wco 1/2

/co 7/16, Mfc

eaks-exhaust hose

ming

re, Sdh 10, Tebl.

surfaces-Ck, SCs

26210 7-

26209

7-

ble-Wco 7/16, SCs

16, SCcs, Wco 1/2, Ppn

Vas 1/2

cl, SCs

12

-Was 17

10, Tebl, Trh

lts-Sdh 13, Tbr

nediate plate-Ck

-Ck

g gear cover-Ck

ool 786214, H

ning facilities

replace (timing gear cover off)

Apply sealing compound and posn gasket—sealing compound Apply sealing compound and posn timing gear cover gasket

sealing compound

Fit balance shaft seal-tool 786215, H Posn timing gear cover-tool 786214

Start sump bolts

Start timing gear cover bolts

Tighten boits-Sdh 13, Tbr

Torque-tighten timing gear cover bolts-Sdh 13, Ttg

Fit balance shaft pulley

Disconnect leads from ign coil and cyl No 1-SCs

Remove gen and bracket (incl disconnect leads from gen)-

Saab Car Division	Replaces page	Date 73-01-02	Edition 1	Page 26210	V4
Fit pulley and fan Fit hoses to collant pump Fit gen and fan belt Fit drain plug to rad Fit rad Fit front panel Fill with coolant Reconnect earth (ground) cab Start engine, check for leaks, o Refit engine hood Spares: Fan bearing Plug Timing gear cover gasket Sealing ring Sump gasket		Tanr, Sdh 1/2, 11/ Remove vertical he Remove thick hose Sdhl 9/16, H, SCs, Remove clips on b Remove pump bol Tebf, Tebl Remove gasket and Oil bolts—Moc Posn pump and ga Refit pump bolts Clean and fit new cloth, Vaseline, SC Refit vertical hose Refit bracket and Sdh 1/2, 11/16, 12 Reconnect leads to Refit clips to wate Reconnect earth (g	ose from nipple- e (end plate—tub Ck, Ppo oth water pipes- ts and take off p d clean mating s skets thick hose (end s to nipple—SCs gen (incl connec 2, Wco 1/2, Wad o ign coil and cy r pipes—SCcs	2, Wadj, M1 —SCssh pe)—Trh 3/8, —SCcs pump—Trh 3/ urfaces—Ck plate—tube)— et leads to ger j, Tah I No 1	/8, Sdh 10, -Ck, emery
COOLANT PUMP replace (power unit out) NB. For this operation the power bench or the like		Spares: Pump Gaskets Clips Hose (thick)	,		
Sre Remove vertical hose from nip Remove thick hose (end plate- Ck Remove clips on both water p	tube)—Wadj, SCs, Sdhl 9/16, H ipes—SCcs	FAN BELT adjust	1/2, Was 1/2	7– 2, SCs	26214
Remove engine mounting plate Remove pump bolts and take of Tebs, Sdh 10, Trh 3/8 Clean mating surfaces—Ck Oil bolts—Moc Posn pump and gaskets Refit pump bolts Refit engine mounting plate Clean and fit new thick hose (c) Ck, Vaseline, SCs Refit vertical hose to nipple Refit bracket and gen Refit clips on both water pipe Spares: Pump Gaskets Clips Hose (thick) FAN BELT replace Slacken gen—Wco 1/2, Was 1/3 Remove fan belt Fit fan belt Tighten fan belt—Wco 1/2, Was Spares: Fan belt COOLANT PUMP replace (front panel and rad off)	off pump—Tanr, Sre, Tebl, . end plate—tube)—emery cloth,	FAN BLADES rep (incl remove-install Remove-install eng Drain coolant—Mo Remove front pan Remove upper hos Remove fan blades Fit fan blades Slacken gen, fit be 13 Refit upper rad ho Refit front panel Fill with coolant— Start—stop engine Spares: Fan blades	I front panel) gine hood—SCs lv, Wco 7/16 el (not hood loo se from rad—SCs s—Trh 3/8, Sdh It and tighten ge ese to rad Wco 7/16, Mfc	s 13 (12) en—Trh 3/8, :	26216 Sdh 13 , Wco
FAN BELT replace Slacken gen-Wco 1/2, Was 1/3 Remove fan belt	7– 26212	FAN BLADES (in install front panel) See 26216 (7–8)		9–	26216
Fit fan belt Tighten fan belt—Wco 1/2, Wa Spares: Fan belt COOLANT PUMP replace	7- 26213	FAN BLADES rep Remove fan blade Fit fan blades Slacken gen, fit be Tebs, Wco 13	s—Trh 3/8, Sdh		26227 Sdh 13,
(front panel and rad off) Disconnect earth (ground) cab	le from battery—Wco 1/2	Spares:			

	Replaces page		73-01-02	Edition 1	Page 26250	V4
COOLANT PUMP recond (off	7-	26250				
Arrange press Dismantle pump—hydraulic pr Clean and check pulley and pr Assemble pump—hydraulic pr 786220	ress, mandrel ump housing—wash	ning facilities				
Spares: Repair kit 						
THERMOSTAT replace (excl	coolant) 7–	26297				
Remove engine hood—SCs			11.			
Remove air cleaner-Wco 10,						
Disconnect fuel line from cark		SC 2				
Remove coolant hoses from the Remove reg valve and carb fix						
Turn carb out of pos						
Remove thermostat cover—Tr		3				
Remove gasket and thermosta Clean mating surfaces—Ck	tCk					
Blow dry—Cag						
Posn thermostat and gasket, fi	t cover					
Posn new carb gaskets Fit carb and reg valve						
Fit coolant hoses to thermost	at hsq					
Fit fuel line and carb						
Fit air cleaner						
Fit engine hood						
Spares: Thermostat						
Gaskets						
Clips if nec			_			
THERMOSTAT replace	7–	26298				
Remove-install engine hood-l	Ppn					
Drain coolant-Mdv, Wco 7/10	6					
Remove air cleaner-Wco, 10,						
Disconnect fuel line from cark Remove coolant hoses from the		¢				
Remove reg valve and carb fix						
Turn carb out of posn	-					
Remove thermostat—Trh 3/8, Remove gasket and thermosta						
Clean mating surfaces—Ck						
Blow dry—Cag						
Posn thermostat and gasket, f Posn new carb gaskets	it cover					
Fit carb and reg valve						
Fit coolant hoses to fit cover			W			
Fit fuel line and carb						
Fit air cleaner Fill with coolant						
Start-stop engine, check for le	eaks					
Spares:						
Thermostat						
Carb gasket			Taura -			
Cover gasket Rubber gasket if nec						
- gustet ii net			-4			

aab Car Div		F	Replaces page	в		Date		Edition		Page		-11-29-1-
						Jan. 197	73	1		26202 -	26298	2-stroke
oer, No	Modelcode	Effective time	Secondary time	Lost time allow- ance	Schedule time	Oper, No	Mo	delcode	Effectiv	e Secondary time	Lost time allow- ance	Schedule time
5202	5 – 6	42	7	5	54							
5204	5–6	87	15	10	112							
5212	5 – 6	6	1	1	8							
5214	5 – 6	5	1	1	7							
6216	5 – 6	17	1	2	20							
6250	5–6	44	12	6	62							
5273	5-	13	8	2	23							
5297	5	12	2	1	15	İ						
5297	6	20	2	2	24							
5298	5	20	5	3	28							
6298	6	28	5	3	36							
this sr	neet belong	Sheets	or repair	WOLK	desemptio							

SAAB-SCANIA Saab Car Division

Repair Work Description SAAB 95/96

	Replaces page		73-01-02	Edition 1	Page 26202	2-stroke
COOLANT PUMP replace	5–6	26202	Pump impeller Gaskets		120202	
			Gaskets			
Drain coolant—Wco 7/16, Mdv Remove fan belt—Wco 1/2, Sd						
Remove fan blades and pulley-			THERMOSTA	T check (off)	5-	_ 2627
Remove upper and lower cools	ant hoses—Pcl		Place thermost	at and thermom	eter in can-1	Thermometer
Remove coolant pump-Sdh 1,		/2	can with water			
Clean coolant pump (ext)—clean Refit collant pump—sealing co				ing flame—gas we	The second secon	nent
Refit lower and upper coolant				il thermostat op il thermostat is t		
Refit fan blades and pulley			Shut off weldi		,	
Refit fan belt-Wco 1/2, Sdh 1			Remove wire			
Fill with coolant and vent—Wo Start-stop engine, check for lea						
	THE EXTIGUEST HOSE		THERMOSTA	T replace (excl c	oolant) 5	2629
Spares: Coolant pump						
Gaskets	-74		Disconnect ign	coolant hose—P	cl	
Clips if nec				ostat hsg and the		h 1/2, Tbr, T
			Ck	-		
COOLANT PUMP recond (inc	re- 5-6	26204	Clean mating s	urfaces—Ck at, apply sealing	compound	egalina comp
move-install)				lug, clean duct	compound—:	caming comp
Remove-install pump see 2620	2 (5-6)		Fit thermostat	hsg and hose		
Recond pump (off) see 2625			Reconnect ign	leads		
		7	Spares:			
FAN BELT replace	5.6	26212	Thermostat			
	5–6	20212	Gaskets Clip if pec			
Loosen gen-Wco 1/2, Was 1/2			Clip if nec			
Check belt and pulleys (replac Adjust belt and tighten gen	e perti—SCs					
- Injust work and righton gon			_ THERMOSTA	T replace (excl c	oolant) 6	2629
			Remove-instal	air cleaner—SCs	, Wco 7/16	
FAN BELT adjust	5–6	26214	Remove-instal	thermostat, see	26297 (5)	
Loosen gen-Wco 1/2, Was 1/2			Spares:			
Adjust belt and tighten gen-W	co, L2, Was 1/2		Thermostat			
			Gaskets Clip if nec			
FAN BLADES replace	5–6	26216				
Remove-install engine hood—S						
Slacken fan belt-Wco 1/2, Wa	s 1/2		THERMOSTA		5	2629
Remove fan blades-Was 7/16 Fit fan blades			Drain coolant-			
Tighten gen			Disconnect igr	leads coolant hose—P	cl	
Spares:				ostat hsg and the		h 1/2, Tbr. T
Fan blades			Ck			
			Clean mating s		nomp our d	coaling com-
COOLANT PUMP recond (off	F 6	26250		at, apply sealing lug, clean duct	compound—	scarriy comp
	5—6	26250	Fit thermostat	hsg and hose		
Fit puller—784135 Remove flanged wheel and pul	ler_Wes 7/16 CC	ech 8	Reconnect ign			
Remove hanged wheel and pul Remove end cover and locking		3311 0		, fill with coolan ne, check for lea		
Remove bearing-shaft-Press,	784030			no, check for lea	13	
Remove impeller–784115, Wa	dj 6		Spares: Thermostat			
Check components Clean housing			Gasket			
Fit shaft seal and locking ring-	-784138		-			
Fit seal and impeller						
Fit flanged wheel			THERMOSTA	I replace	6	2629
Check impeller position, adjus	t-slide gauge, feel	er gauge	Remove-instal		****	
Spares:		0 0	Remove-instal	l thermostat, see	26298 (5)	
Pump brg Pump seal						

SAAB

Metodbeskrivningar (ackordsmeddelanden)

Repair Work Descriptions

Methodenbeschreibungen

Blektriskt system, Instrument
Electrical system, Instruments
Elektrisches System, Instrumente

SAAB-SCANIA

Saab Car Division

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Repair Work — Standard Times SAAB 95/90

		Replaces pag	je		Date		Edition	P	age		
					Jan. 1973		1		31102 -		
No Modelc	ode Effective	e Secondary time	Lost time allow- ance	Schedule time	Oper. No	Mo	delcode	Effective time	Secondar time	Lost time allow- ance	Schedule time
2 5-	20	5	3	28							
5 5-	10	3	1	14							
7 5-	17	7	2	26							
3 5-6	9	2	1	12							
3 7-	12	2	1	15							
1 5-	24	8	3	35							
3 5-	15	4	2	21							
1 5-	12	2	1	15							
5-											

31118

31121

Saab Car Division

Replaces page Date Edition Page 73-01-02 31102 Battery repalce (incl test measurement) 5-31102 Wash and blow battery-Exhaust hose Test start Disconnect-connect cables-Wco 7/16, knife, vaseline Remove battery holder Lift battery out of car **BATTERY** replace Brush threads Place new battery in car Disconnect-connect cables from/to battery-Wco 1/2, Cwb, Clean battery holder Vaseline Install battery holder Remove battery holder and lift out battery Blow, dry battery holder Clean battery holder Measure electrolyte voltage—Electrolyte and cell testers Clean-blow battery tray-Cwb Test start Place new battery in car-Cwb, Cag Refit battery holder Check electrolyte level-Distilled water Battery cables: earth (ground) 5-31106 Check operation (run starter motor) cable replace Disconnect cable from battery pole-Wco 7/16 **BATTERY** remove-install Disconnect cable from body and engine-Was 9/16, SCs, Was 7/16 See 31118 (5-), excl check electrolyte level and run Clean contact surface on body-Knife starter motor Connect new cable to body and engine Clean, grease and connect cable to battery-Vaseline Spares: Earth (ground) cable Battery shelf, clean and paint 5-31107 (battery out) Clean threabs Scrape, blow, wash battery tray-Csp, Cwb, Ck, thinners, exhaust hose Paint trag-enamel paint, brush Clean brush Battery cables: starter motor cable 31108 replace Disconnect cable from battery pole-Wco 7/11 Disconnect cable from starter motor-Wco 9/16, SCs Connect cable to body Clean, grease and connect cable to body-Knife, vaseline Connect cable to starter motor Test start Spares: Starter motor cable Battery cables: starter motor cable 31108 replace Disconnect cable from battery pole—Wco 7/16 Disconnect cable from starter motor-Wadj Disconnect cable from clutch housing and remove Clean, grease and connect cable to battery pole Test start Spares: Starter motor cable BATTERY check (test measurement, 31114 clean and grease terminals and pole bolts) Check electrolyte S.G. and cell voltage—Hydrometer and cell

Vaseline

Brush threads

Remove-install battery

Disconnect-connect cables from/to battery—Wco 7/16, knife

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		F	Replaces pag	8		Date		Edition		Pa	5-		
		*				Jan. 1973		1		3	32102 - 3	2271	
Oper, No	Modelcode	Effective	Secondary time	Lost time allow- ance	Schedule time	Oper. No	Мо	delcode	Effecti time		Secondary time		Schedule tîme
32102	5-6	20	6	3	29								
32102	7–	25	5	3	33								
32112	5-6	113	10	12	135								
32112	7–	185	16	20	221								
32129	5-6	18	4	2	24								
32130	5-6	91	6	10	107	v.							
32130	7–	159	12	17	188								
32132	7-	93	13	11	117								
32134	7-	68	9	9	85								
32136	5-6	42	6	5	53								
32145	7-	10	3	1	14								
32147	7-	3			3								
32163	7-	24	3	3	30								
32170	5–6	10	3	1	14								
32170	7–	10	4	1	15								
32172	56	12	4	2	18								
32172	7–	16	5	2	23								
32174	5-6	15	4	2	21								
32176	5-6	23	3	3	29								
32183	7-	14	2	2	18								
32202	5 - 6	24	7	3	34								
32204	5 – 6	10	2	1	13								
32204	7–	8	2	1	11								
32210	5-6	8	5	1	14								
	56	17	1	2	20								

Spares: Brush set

Date Replaces page Edition Page 73-01-02 1 32102 **GENERATOR** replace (excl measure 5-6 32102 charging) Disconnect battery cable-Wco 7/16 Disconnect leads from gen-Wads 6 Remove gen from car-Wco 1/2, Was 1/2 Posn and install new gen in car, adjust fan belt Reconnect lead to gen Clean and grease battery cable and reconnect-Cwb, Vaseline Start engine and check operation of charge indicator lamp Spares: Generator ALTERNATOR replace (remove-install) 7-32102 Remove see 32170 (7-) Install see 32172 (7-) Spares: Generator complete GENERATOR recond (excl com-5-6 32112 mutator turning) Disconnect battery cable—Wco 7/16 Disconnect leads from gen-Wadj Remove gen from car-Wco 1/2, Was 1/2 Clean gen externally (wipe-brush)-Wire brush Dismantle, clean and check all parts-SCs, Ppn, H, Was 3/4 Replace all worn and faulty parts Assemble gen-Special grease Ft Iv 22 Check and test gen (test bench) Posn and install gen in car, adjust fan belt Connect leads to gen Clean and grease battery cable and connect-Knife Check charging-Voltmeter/ammeter Spares: Generator carbon brush set, 2 ball bearing ALTERNATOR recond incl testing 7-32112 (incl remove-install) Disconnect-connect earth (ground) cable from/to battery-Wco 1/2 Remove gen from car-Trh, Sdh 1/2, Was 1/2, Wco 1/2, Wadj Recond see 32130 (7-) Install gen in car Start-stop engine, check charging Spares: Ball bearings, brush set **GENERATOR** brushes replace 5-6 32129 (generator out) Clean gen ext-Cwb, rag Remove protective cover-SCs Lift up brushes-SCs Remove screws Remove rear end plate Clean brush holder, check Remove old brushes, fit new-SCs Fit rear end plate Fit screw in rear cover Lift up brush springs Fit protective strip

Saab Car Division

Date Edition Page Replaces page 73-01-02 32130 ALTERNATOR dismantle, clean and **GENERATOR** recond (out) 32134 5 - 632130 (commutator turning) assemble (out) Dismantle, clean and check and assemble gen Remove pulley-Tah, Sdh 22, Ppn, locking Check rotor and windings fork, pulley Check gen charging Remove drive end frame-SCs 10 Remove rotor from drive end frame-Press, mandrel Remove ball bearing from drive end frame-SCs , H 3 ALTERNATOR recond incl test (out) 7-32130 Remove ball bearing from rotor-Puller Remove heat sink fixing nuts-Wco 10 Remove pulley-Tah, Sdh 22, Ppn, locking fork, puller Remove brush holder plate-SCs Remove drive end frame-SCs Wash all parts-Kerosene bath Remove rotor from drive end frame-Press, mandrel Blow clean all parts-Cag Remove ball bearing from drive end frame-SCs , H Refit heat sink fixing nuts-Wco 10 Remove ball bearing from rotor-Puller Refit brush holder plate Remove heat sink fixing nuts-Wco10 "Suspend" brushes (to install rotor)—Steel wire Remove brush holder plate-Scs Grease bearings (open package if new bearings)-Unsolder all rectifier leads-Solder gun, Pfl Special grease Extract stator winding Fit ball bearing to drive end frame-SCs Remove charging rectifier mounting plate-SCs Fit rotor to drive end frame-Press Wash all parts-Kerosene bath Fit ball bearing to rotor-Press, tubular mandrel Blow clean all parts-Cag Fit drive end frame Test rotor-Ohmmeter Fit pulley Test stator winding-Ohmmeter Test all rectifiers-Battery, test lamp Spares: Bearings Mount rotor in lathe-lathe Clean slip rings-emery cloth Remove rotor from lathe Blow clean rotor-Cag **ALTERNATOR**, charging rectifier 7-32145 Remove brushes from brush holder plate-solder gun, SCs, Ppn replace 1st (extra to "recond") Refit brushes to brush holder plate Remove rectifier from heat sink/slip ring Refit charging rectifier mounting plate bearing-Press with mandrel Refit stator winding and reconnect rectifier leads-solder gun, Pfl Shrink fixing hole in heat sink-Press with mandrel Refit heat sink-solder gun, Pfl, Wco 10 Install rectifier in heat sink/slip ring bearings-Check rectifiers (after soldering)-Battery, test lamp Press with mandrel Refit brush holder plate "Suspend" brushes (to install rotor)—Steel wire Spares: Rectifier Open bearing package and grease bearings—Special grease Fit ball bearing to drive end frame-SCs 5 Fit rotor to drive end frame-Press Fit ball bearing to rotor-Press, tubular mandrel Fit drive end frame ALTERNATOR, charging rectifier 7-32147 Fit pulley replace others each Remove-install gen from/on test bench, test run-Gen test Remove rectifier from heat sink/slip ring bench bearing-Press with mandrel Spares: Shrink fixing hole in heat sink-Press with mandrel Ball bearings Install rectifier in heat sink/slip ring bearings-Brush set Press with mandrel ALTERNATOR dismantle, clean and ALTERNATOR, dress slip rings and 7-7-32132 32163 assemble (incl remove-install) replace brushes (extra to dismantle, clean and assemble) Disconnect-connect earth (ground) cable from battery -Wco 1/2 Remove brushes from brush holder plate-Remove alternator—Trh, Sdh 1/2, Was 1/2, Wco 1/2, Wadj Solder gun, SCs, Pfl Dismantle, clean and assemble see 32134 (7-) Fit brushes to brush holder plate Refit alternator Mount rotor in lathe-lathe Start-stop engine, check charging Dress slip rings-emery cloth Remove rotor from lathe Spares: Blow clean rotor **Ball** bearings Spares: Saab-Scania - Service Brush set

Saab Car Division Date Edition Replaces page Page 73-01-02 32170 **CHARGING REGULATOR replace** 32204 **GENERATOR** remove 5-6 32170 (remove-install) Remove gen-Wadj, SCs, Wco 1/2, Was 1/2 Remove-install charging regulator-SCcs Clean gen externally Start-test Spares: **ALTERNATOR** remove 32170 Charging regulator Disconnect earth (ground) cable from battery-Wco 1/2 Disconnect leads from gen-Wadi CHARGING REGULATOR (AC) 7-32204 Remove fixing bolts-Trh, Sdh 1/2, Was 1/2, Wco 1/2 replace (remove-install) Remove drive belt Lift out gen and wipe clean Disconnect-connect battery earth (ground) cable-Was 1/2 Remove charging reg-SCcssh **GENERATOR** install (excl measure 32172 5-6 Open pack and install new reg charging) Start-test Install generator-Was 1/2, Wco 1/2, SCs, Wadj Spares: Charging reg **ALTERNATOR** install 7-32172 CHARGING REGULATOR operation 32210 5-6 Position alternator and drive belt check in car (idling voltage and gen voltage) Position fixing bolts-Trh, Sdh 1/2, Was 1/2, Wco 1/2 Disconnect B+ from reg and insulate-SCs, electrical tape Connect leads to alternator-Wadj Connect voltmeter to reg-Voltmeter Connect earth (ground) cable to battery-Wco 1/2 Start engine Start-stop engine, check charging Check voltages at reg Stop engine Disconnect connection DF from gen-Wadj Connect voltmeter and control lead to gen-Control lead GENERATOR test (charging) in car 32174 5-6 Start engine Check voltages at gen Check charging-SCs, Wadj, voltmeter/ammeter Stop engine Disconnect voltmeter and lead from gen Connect DF to gen **GENERATOR**, commutator turning 5-6 32176 Remove insulation, connect B+ to regulator and slotting (rotor out) Turning and slotting 32271 **CHARGING REGULATOR adjust on** 5-6 test bench (reg out) ALTERNATOR, bench testing (extra 7-32183 Test and adjust on test bench to "dismantle") Mount alternator on test bench and connect leads-Gen test bench and accessories Test run Remove gen from bench **CHARGING REGULATOR replace** 5-6 32202 (incl adjustment on bench) Disconnect battery cable-Wco 7/16, SCs Remove charging regulator from car-SCs 5, SCcs Test and adjust charging regulator on test bench-SCs, Test bench, special tools Refit charging reg to car Clean, grease and connect battery cable Start engine and check charge indicator lamp Spares: Charging regulator

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						Jan. 1973	1		33104 - 3	3197
per. No	Modelcode	Effective	Secondary time	Lost time allow- ance	Schedule time		odelcode	Effectiv	e Secondary time	
33104	7–	94	12	11	117					
33110	7-	35	5	4	44					
33118	7–	27	6	3	36					
33123	7-	19	1	2	22					
33126	5–	23	3	3	29					
33128	7–	67	10	8	85					
33132	5-	3	3	1	7					
33167	5-	11	3	1	15					
33170	7-	13	6	2	21					
33172	7-	13	6	2	21					
33179	7-	9	2	1	12					
33181	5-	8	2	1	11					
33197	5-	3	1		4					
Γο this s	sheet belong	2 sheets	of repair	work	description					

	Replaces page		73-01-02	Edition 1	Page 33104	ľ
STARTER MOTOR dismantle	. 7-	- 33104	STARTER MOTOR	dismantle	7_	3312
check, clean, assemble and tes		33104	clean, check, assemb			3312
(incl remove-install)	e Signer		run (motor off)	1		
	9.		Remove solonoid T	rh Sdh 1/2 CO	's Wadi L	
Disconnect-connect earth (gro	ind) cable		Remove solenoid—T Through screws and			
from/to battery—Wco 1/2	and Cable		SCs, vice	COMMUNICION CI	.G II GIII C	
Disconnect cables from starter	motor-Wco 9/	16	Remove shaft end c	ap and shims—S	Cs	
Remove LH engine mounting			Remove brush hold			
Trh, Tebl, Sdh 9/16			Remove gauging lev			10
Raise engine in car-Lj, wood I	olock		Remove sleeve, reta			L.
Remove starter motor fixing b		m 9/16	Sdh 9/16, H, SCs			
Remove starter motor from ca			Wipe and check pini			
Wipe clean starter motor exter	nally-Rag, Cag		Wipe and check com			
Dismantle, check, clean assemb	ole and test		Wipe and blow st		facilitie	
run, see 33128 (7–)			Wash and blow both Check brushes, bear			
Position starter motor in car			Dress and blow clea			
Fit fixing bolt and nut Lower engine on jack			Electrically check ro			
Fit LH engine mounting nut			Oil rotor shaft and f			
Connect cables to starter motor	r ·		Fit retaining ring an			
Check operation			Position rotor in sta		nousing	
			- Fit brush holder pla		3	
		125	Check brush spring	pressure—Spring		
STARTER MOTOR, solenoid	7	- 33110	Fit commutator end	frame and thro		
replace (incl remove-install)			Fit shaft end cap wi			
Starter motor remove, see 331	70 (7-1		Fit engaging lever pi	vot screw		
Solenoid replace, see 33179 (7			Fit solenoid			
Starter motor install, see 3317			Mount starter motor			
			Connect starter mot	or, run and che	CK	
STARTER MOTOR replace	7	- 33118	STARTER MOTOR	test run on ben	ich / 5-	3313
(remove-install)	12		(motor off)	3,,,20,,		
Starter motor remove, see 331	70 (7—)		Mount motor on be	nch and occase	t Tost hand	
Starter motor install, see 3317			Test run	non and connect	- rest bench	
	-		Remove motor			
STARTER MATER			-			-
STARTER MOTOR, brushes r (motor dismantled)	eplace 7	- 33123	074577			
			STARTER MOTOR		g 5—	3316
Unsolder brushes-Solder gun.	SCs		replace (motor dism	antled)		
Solder brushes			Remove bushing fro	m pinion		
Spares:			Blow clean			
Brush set			Fit bushing to pinio			
		-	Scrape—dress bushir	ng		
STARTER MOTOR	tou	20400	Spares:			
STARTER MOTOR, commuta turning and slottning (rotor ou	tor 5—	33126	Bushing			
	U		-			
Arrange lathe, cutters etc.						
Mount rotor in lathe and adjus	cutter		STARTER MOTOR	ramova	-	224
Turn and dress commutator			STANTEN WOTOF	i cinove	7–	3317
Remove from lathe						
Change chuck, tailstock Mount rotor in "slotting machi	no!!		Disconnect earth (g			as 1/2
Slot commutator	ile.		Disconnect cables for			1
Remove rotor and blow clean			Remove LH engine			9/16
Check rotor			Raise engine in car-	-LJ, Wood block	ad must let a	110
	- Wang to the Land		Remove starter mot		nd nut—Wsm 9	/16
			Wipe clean starter mot		_Ran Can	
			Tripo cicali starter II	iotor externally	—nay, cag	
			3/4			

	Replaces page		I Data		
			73-01-02	Edition 1	Page 33172
TARTER MOTOR install	7-	33172			
osition starter motor in car it fixing bolt and nut—Wsm 9 ower engine on jack it LH engine mounting nut— onnect cables to starter moto onnect earth (ground) cable t heck operation	Trh, Tebl, Sdh 9/1 or-Wco 9/16				
FARTER MOTOR, solenoid in notor off)	replace 7—	33179			
emove solenoid—Trh, Sdh 1/2 stall solenoid	2, SCs, H, Wadj				
pares: plenoid complete					*
TARTER MOTOR, rotor bu	shings 5	33181			
emove bushing from commu it bushing to commutator en est bushing with rotor emove bushing from pinion h it bushing to pinion hsg est bushing with rotor	d frame				
pares: ushing (commutator end frar ushing (pinion housing)	me)				
TARTER MOTOR, brush spr	rings 5	33197			
eplace brush springs					
pares: rush springs					
XI					

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Repair Work - Standard Times SAAB 95/96

			Replaces pag	е		Date			Edition		Page			
							1973		1			02 - 3		V4
Oper. No	Modelcode	Effective	Secondary time	Lost time allow- ance	Schedule time	Oper.	No	Mo	delcode	Effect	ive Sec	ondary e	Lost time allow- ance	Schedule time
34002	5-	10	3	1	14									
34010	5	32	4	4	40									
34010	6-	52	4	6	62									
34104	5-	4	2	1	7									
34106	5-	. 8	3	1	12									
34108	5-	12	4	2	18									
34202	7-	30	8	4	42									
34206	7–	33	8	4	45									
34208	7-	103	9	12	132									
34210	7-	38	10	5	53									
34217	7-	6	2	1	9									
34220	7-	12	2	1	15									
34236	7-	76	10	9	95									
34270	7-	11	6	2	19									
34272	7–	17	5	2	24									
34276	7–	24	7	3	34									
To this s	heet belong	2 sheets	of repair	work	description									

Saab Car Division

Date Edition Page Replaces page 73-01-02 34002 V4 IGNITION AND STARTER SWITCH, 34002 DISTRIBUTOR, breaker points replace 7-34202 switch replace Remove-install air cleaner-Was 10 Disconnect earth (ground) cable from battery-Wco 1/2 Remove cap, vacuum hose and rotor-SCs 5 Remove switch-M1, SCcs Clean capand leads Note connections and disconnect leads from switch-Pen, paper Remove points—SCs 5, Ppn Connect leads to new switch-Note of connections Open pack Lubricate distributor-Special grease, Moc, SCs 3 Install switch-M1, spot of grease, SCcs Connect earth (ground) cable to battery-Wco 1/2 Install points—SCs 5 Connect starter cable—Starter cable Check operation Connect dwell-angle tester and calibrate-Dwell angle tester IGNITION AND STARTER SWITCH, 34010 Switch on ignition lock cyl replace (incl door lock cyl) Adjust dwell angle and check Disconnect starter cable Remove door trim-SCs (SCcs) Refit distributor cap and rotor Remove door handle—SCcssh Clean at ignition setting marks Remove door lock cyl-H, drift Connect strobe-Strobe lamp Fit new door lock cylinder Start engine, switch on dipped headlights Refit door handle-SCcssh Reduce idling speed-SCs 5 Refit door trim-(SCcs) Slacken distributor, clamp, set ignition Remove ignition and starter switch lock timing-Trh, 786053 cylinder-Mpd, B Ø 9 Tighten distributor cap clamp, check Refit new ignition and starter switch lock cylinder Connect vacuum hose, check ignition Wipe clean timing at higher engine speed Check operation Adjust idling speed Disconnect stroboscope and dwell angle tester Stop engine and switch off dipped headlights **IGNITION AND STARTER SWITCH,** 34010 lock cyl replace (incl door lock cylinders) Spares: Breaker point set See 34010, 5 **DISTRIBUTOR** replace (dwell angle 34206 **IGNITION COIL replace** 5-34104 tester, strobe) Remove coil-SCcs 2 Wipe clean strap and attachment point Remove-install air cleaner-Was 10 Open pack, fit coil Remove cap and vacuum hose-SCs 5 Test start Set No. 1 piston to TDC Remove distributor-Trh, 786053 Spares: Clean ignition leads and fit new cap Ignition coil Install distributor Remove rotor Lubricate distributor-Special grease, Moc, SCs 3 Connect starter cable-Starter cable IGNITION COIL test in car 34106 Connect dwell angle tester and calibrate-Disconnect leads to coil Dwell angle tester Connect measuring equipment and test coil-Switch on ignition SCs 5, 3 measuring equipment Adjust dwell angle and check Remove measuring equipment and test coil Disconnect starter cable Connect leads to coil Refit distributor cap and rotor Clean at ignition setting marks Connect stroboscope-Stroboscope lamp IGNITION COIL test in car (incl replace) 5-34108 Start engine, switch on dipped headlights Reduce idling speed-SCs 5 Disconnect leads to coil Set ignition timing-Trh, 786053 Connect measuring equipment and test coil-Tighten distributor cap clamp, check Measuring equipment Connect vacuum hose, check ignition timing at Disconnect measuring equipment higher engine speed Disconnect other leads to coil Adjust idling speed Remove coil from wheel house-SCcs 3, SCs 5, 3 Disconnect stroboscope and dwell angle tester Fit new coil to wheel house Stop engine and switch off dipped headlights Connect leads to coil Test start Snares: Distributor Spares:

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Coil

Saab Car Division						
	Replaces page		73-01-02	Edition 1	Page 34208 V4	
DISTRIBUTOR recond (incl r install) (strobe) Remove see 34270, 7— Recond see 34236, 7— Install see 34272, 7—	emove- 7-	34208	Fit ball hold Fit breaker Fit capacito Fit vacuum Fit and coar	der plate and retaining r chamber se adjust breaker p	springs oints	
DISTRIBUTOR adjust (testing in synchrograph incl remove-in (strobe) Remove see 34270, 7— Remove rotor Visual check, breaker points Remove-install distributor from adjust dwell angle—SCs 5, Testinstall distributor in car, see 3 Lubricate distributor—Special	nstall m/to bench, t bench 4272, 7—	34210	DISTRIBUT (distributor Mount distr (e.g. ELMO Check distri Remove dist Lubricate di Clean and fi Clean cap ar	out) ibutor on test bencl Elektro check) butor in test bench tributor from test b istributor—Oil can,	7— 34236 h—Test bench , adjust dwell ang ench grease Ftv 14	
DISTRIBUTOR, breaker poin (cap off) not adjust Remove breaker points—SCs 5 Open pack Lubricate—Special grease Fit points—SCs 5		34217	Spares: Bushing Breaker poil Repair kits		7-	34270
DISTRIBUTOR, cap and/or ig leads replace Remove-install air cleaner—Wa Remove vacuum hose, ignition Remove ignition leads from ca Wipe clean ignition leads or ca Fit ignition leads to cap Install cap, ignition leads and	s 10 leads and cap—SC p	34220 Cs 5	Remove cap Set No. 1 pi Remove dis Clean distrib Clean cap ar		53 erosene bath	
Test start engine Spares: Distributor cap, Ignition leads			(Dwell angle Position dist Fit distribut Clean at ign	FOR install (strobe) already set on ben tributor and fit lock or cap ition setting marks bboscope—Strobosco	ch) king screw	34272
DISTRIBUTOR recond (distribut) Remove rotor Remove breaker points Remove vacuum chamber Remove capacitor—SCs 5, 3 Remove retaining springs and Remove ball holder Remove locking pin and pinio Remove shaft Remove breaker cam and spring	breaker plate n–Drift, H, puller ngs–Ppn	34236	Start engine Reduce idlir Set ignition Fix distribu Connect vac at higher spe Fit air clean Adjust idling Remove stro	, switch on dipped of ng speed—SCs 5 timing itor, check—Trh 780 uum hose, check ig eed er—Was 10 g speed	headlights 6053 nition timing	
Remove lubricating felt and lo Remove weights—SCs 5, 3 Remove bushing—Drift, H Wipe distributor hsg internally Fit bushing—Press Clean and check parts—Kerose Fit weights Fit breaker cam and springs Fit shaft Fit pinion and lock pin—Piece	ene bath	ift	(dwell angle See 34202 (OR, ignition setting tester, strobe) 7-) install breaker poin		34276

Repair Work - Standard Times SAAB 95/96

		R	eplaces page	Э		Date		Edition		Page			
						Jan. 1973	3	1		34	406 - 3	4473	
Oper. No	Modelcode	Effective	Secondary	Lost time allow- ance	Schedule time	Oper. No	Mod	delcode	Effectiv time	e Si	econdary me	Lost time allow- ance	Schedule time
34406	5–6	8	_2	1	11								
34406	7–8	12	1	1	14								
34406	9-	18	2 ,	2	22								
34408	*5-6	16	4	2	22								
34408	7–8	22	.4	3	29								
34408	9 –	29	4	3	36								
34473	5 – 6	10	3	1	14								
34473	7-	13	3	2	18								
												1	
To this s	heet belong	1 sheets	of renair	work	description								

	Saab Car Division								
		Replaces pag	je		73-01-0	n2	Edition 1	Page 344	ne .
	SPARK PLUGS, replace 3		5–6	34406			rk plug tester	1 344	00
	Blow clean at plugs—Cag Remove plugs—Sspp, Tebl, Tth Check and adj spark gap on ne Spark plug tool Clean sealing surface on cyl he Fit new spark plugs	w plugs—			SPARK PI (plugs out Clean spar Adjust spa	LUGS cl) k plugs- irk gap-	ean and adjust -Spark plug to Spark plug to rk plug tester	ol	34473
	SPARK PLUGS replace (all)		7–8	34406	-				
The second second second	Blow clean around and remove plugs—Wspp, Cag Check and adj spark gap on ne Spark plug tool Clean sealing surface on cyl he Fit spark plugs	w plugs—			_				
	SPARK PLUGS replace (all)		9–	34406					
Contract Con	Blow clean around and remove plugs—Cag, Wspp, Trh, Sspp Check and adj spark gap on ne Spark plug tool Clean sealing surfaces on cyl he Fit spark plugs	w plugs—							
	SPARK PLUGS clean and adj	3	5–6	34408					
The second secon	Blow clean at plugs—Cag Remove plugs—Sspp, Tebl, Tth Clean spark plugs—Spark plug Check and adjust spark gap—S Test spark plugs in tester—Spa Clean sealing surface on cyl he Fit spark plugs	tool park plug to rk plug teste							
	SPARK PLUGS clean and adj	(all)	7–8	34408				*	
Sweden-Schweden	Blow clean around and remove spark plugs—Cag, Wspp Clean spark plugs—Ck, Cwb Check and adjust spark gap—S		ol						
ı	Test spark plugs in tester—Spar Clean sealing surface on cyl he Fit spark plugs */ Time change 26.5.70 Increa for arranging tools	rk plug teste ad	er	1	_				
abteilung	SPARK PLUGS, clean and adj	(all)	9—	34408					
Service Department-Rungengienstabteilung - Nykoping	Blow clean around and remove plugs—Cag, Wspp, Trh, Sspp Clean spark plugs—Ck, Cwb Check and adjust spark gap—Spart Test spark plugs in tester—Spart Clean sealing surfaces on cyl he Fit spark plugs	park plug to							
- Service I	SPARK PLUGS clean and adj.	(plugs out)	5–6	34473					

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Clean spark plugs—Spark plug tool Adjust spark gap—Spark plug tool

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		F	Replaces pag	е		Date Jan. 19	973	Edition 1		35102 - 3	35190	
Oper, No	Modelcode	Effective time	Secondary time	Lost time allow- ance	Schedule time	Oper. No		delcode	Effective time	Secondar		Schedule time
35102	5–8	8	5	1	14	35190		5-6	10	1	1	12
35102	9-0	10	5	2	17	35190		7-	4	1	1	6
35102	1-	13	5	2	20							
35104	5-	3			3	To this	sheet	belong 3	sheets	of repair	work	descriptio
35110	5-8	24	5	3	32							
35110	9–0	15	5	2	22							
35110	1-	18	5	2	25							
35111	9–	7	5	1	13							
35114	5–8	39	5	4	48							
35114	9–0	20	5	3	28							
35114	1-	23	5	3	31							
35118	P5-	6	1	1	8							
35118	H5 -	5	1	1	7							
35122	5-	6	1	1	8							
35126	P5-	19	1	2	22							
35126	H5-	22	1	2	25							
35 134	5-8	32	1	3	36							
35134	9-	10	1	1	12							
35136	5-8	16	1	2	19							
35136	9-	5	1	1	7							
35 13.7	5-	5	1	1	7							
35138	5-	6	2	1	9							
35142	5 - 9	6	2	1	9							
35142	0-	6	2	1	9							
35 182	6-8	3	1	1	5							
35182	9-	6	1	1	8							
35 183	5-	6	3	1	10							
35185	5-	8	3	1	12							

Saab Car Division			Repair work	Description	SAAD 33	/ 90
	Replaces page	5	73-01-02	Edition 1	Page 35102	
HEADLAMPS align Checking and adjustment of he alignment—SCcs, Marchal Reg		35102	HEADLAMPS, ir incl alignment See 35114, Saab	nserts, replace 2,	1- 35114	
HEADLAMPS align See 35102, Saab 99, 9–0	9-0	35102	TAIL LIGHT, rep Remove glass-rim Remove bulb and	-SCcs		35118
HEADLAMPS align See 35102, Saab 99, 9–0	1–	35102	Install bulb Wipe glass clean Refit glass and rir Check operation	n		
HEADLAMPS, bulb replace Open pack Remove-install bulb Check operation	, 5 –	35104	TAIL LIGHT, repglass—rim See 35118, Saab		H5—	35118
HEADLAMPS, insert replace 1	, 5–8	35110	NUMBER—PLAT bulb and/or glass Remove glass and		e 5–	35122
Remove headlamp from front Remove insert from ring and re Remove bulb and other parts f Open packs of new insert and l Fit bulb and other parts to inse Fit ring and retaining ring to in Fit headlamp to front panel—S	etaining ring—SCs from insert bulb ert nsert—SCs		Clean contact sur Replace glass or b Refit glass Check operation Spares: Gasket	faces		
Check operation Adjustment of headlamp align Saab 95/96, 5–8–SCcs	ment, see 35102,		TAIL LIGHT rep			35126
HEADLAMPS, insert replace 1 ncl align both See 35110, Saab 99, 9–0	, 9–0	35110	Check operation TAIL LIGHT rep complete			35126
			Remove-install gla	ass and reflector		
HEADLAMPS, insert replace 1 incl align both See 35110, Saab 99, 1–	, 1–	35110	HEADLAMPS, in excl alignment		5–8	35134
HEADLAMPS, alignment, trin	n 9–	35111	HEADLAMPS, in trim frames off, e	serts, replace 2,	9–	35134
See 35102, Saab 99, 9—0 excl trim frames	remove-install		See 35136, Saab			
HEADLAMPS, inserts, replace incl alignment	2, 5–8	35114	HEADLAMPS, in excl alignment	nsert, replace 1,	5–8	35136
See 35110, Saab 95/96, 5–8			See 35110, Saab	95/96, 5–8 excl	alignment	
HEADLAMPS, inserts, replace incl alignment	2, 9–0	35114	HEADLAMPS, in frame off, excl al		im 9–	35136
See 35114, Saab 99, 9-0			See 35124, Saab	99, 9—		
			Talks .			

	Replaces page	Date	Edition	Page	
-		73-01-02	1	35137	_
AUXILIARY HEADLAMPS lign, each, in conj with head lignment Depends on make and type— nake and type	llamp				
VARNING LAMP, bulb repl	ace 5— 35138				
regardless of position)					
Remove-install earth (ground rom/to battery—Wco 7/16, s Remove-install warning lamp Remove-install bulb from/in Check operation	SCs				
		_			
	*				
	*				
		2			

Saab Car Division Date Edition Replaces page Page 73-01-02 35142 35142 INTERIOR LIGHTING, lamp hsg 7- 35190 **HEADLAMPS**, switch replace 5-9 replace (remove-install) Remove switch from instrument panel-Ppo Transfer leads-Ppn, SCs Remove lamp hsg-SCs Open pack and install new lamp hsg Install new switch Check operation Check operation **HEADLAMPS**, switch replace 35142 Disconnect earth (ground) cable from battery-Wco 1/2 Remove switch from instrument panel-SCs Transfer leads to new switch Install switch Connect earth (ground) cable—Wco 1/2 Check operation HEADLIGHT FLASHER CONTROL 6-8 35182 RELAY, replace Remove relay-SCcs Open pack and fit new relay Check operation **HEADLIGHT RELAY replace** 9-35182 Disconnect earth (ground) cable from battery-Wco 1/2 Remove relay from bulk head-SCcs Transfer leads to relay Install relay on bulk head-SCcs Connect earth (ground) cable to battery—Wco 1/2 Check operation 35183 INTERIOR LIGHTING, door switch 5replace, each Remove switch-SCs Pull lead out of hole (frequency 1/2)-Ppn Clean oxide from switch mounting-Round file Apply Vaseline to switch-Vaseline Install switch Check operation INTERIOR LIGHTING, door switch 35185 clean, each Remove switch—SCs Pull lead out of hole (frequency 1/2)-Ppn Clean oxide from switch mounting-Round file Clean switch-Cwb, Ck Apply Vaseline to switch-Vaseline Install switch Check operation INTERIOR LIGHTING, lamp hsg 5-6 35190 replace (remove-install) Remove lamp hsg-SCs, SCcs Open pack and install new lamp hsg Check operation Saab-Scania -

ab Car Div	vision	Repair W	TOTA										
Replaces page						Jan. 1973 1				36102 - 36216			
	The state of	Ing	To	Tr	In-varia	Oper. No		1	Efforti				hadula
er, No	Modelcode	Effective time	Secondary time	time allow- ance	Schedule time	Oper, No	IVIO	delcode	time	time	ondary L ti al al ar	me ti	hedule me
102	5-	1		1	2								
106	5-	5	1	1	7								
108	5–7	13	2	_2	17								
108	8-	9	1	1	1 1								
124	5 - 8	10	1	1	12								
124	9 –	16	1	2	19								
202	5-6	3	1		4								
202	7-	4	1	1	6								
206	5-6	4	1	1	6								
216	7-	14	1	2	17								
7 (1113-31	heet belong	Zanecia	от терап	WOTK	description								

36108

Saab Car Division Replaces page Date Edition Page 73-01-02 36102 **DIRECTION INDICATOR SWITCH** FLASHER UNIT replace (plug-in) 36102 8-5replace Remove-install flasher unit Check operation Disconnect-connect earth (ground) cable Spares: from/to battery-Wco 1/2 Flasher unit Remove cover-SCcs Disconnect leads from switch-Scs PARKING AND FLASHER LIGHT Transfer knob 5-36106 Connect leads to switch replace bulb glass Refit cover Remove glass,-Sccs Check operation Replace glass, or bulb Install glass Spares: Check operation Switch Spares: Glass, gasket, bulb **DIRECTION INDICATOR SWITCH** 36108 5-7 replace (LH position) (incl removeinstall steering wheel) Place protective covers on seats Collect and place required tools on RH seat Disconnect leads (connector below instrument panel) Remove horn button-SCs Disconnect horn lead-Ppn Remove nut-Tthn, Sdh 15/16 Remove horn ring Mark wheel position, remove wheel Remove switch fixing screws-SCs Disconnect switch leads-SCcs Remove switch, knob and plastic cover-SCs Take new switch and measure clearance between projection return yoke If nec adjust clearance (file off switch mountings or insert shims)-Feeler gauge 0.20-0.60 Check clearance, adjust if nec Connect leads to switch Install switch and plastic cover Install steering wheel, horn ring, spring washer and nut Tighten nut Connect horn lead and install horn button Connect leads (connector below instrument panel) Refit knob Check operation, direction indicators, switch and horn Wipe clean components involved, remove tools and seat covers Spares: Switch

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Spares:

Horn RH (low pitch)

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Saab Car Division Date Edition Page Replaces page 73-01-02 1 36124 FLASHING/PARKING LIGHT 5-8 36124 replace Open-close engine hood Remove glass-SCcs Remove bulb holder-Ppo, SCs Install bulb holder Install glass Check operation Spares: Flashing light front complete FLASHING/PARKING LIGHT 36124 replace complete 1st Remove fixing screws-Was 7/16 Disconnect leads Take out hsq Transfer rubber cover Install hsg in fender and connect leads Check operation Spares: Flashing/parking light HORNS replace, each 5-6 36202 Replace horn-Wco 9/16 Spares: Horn low pitch Horn high pitch HORN, replace LH 36202 Remove LH horn-Trh, Sdh 1/2, Was 1/2 Install LH horn Check operation Horn LH (high pitch) HORNS adjust (in car) 2 5-6 36206 Adjust horns (both) **HORN replace RH** 7-36216 Remove RH horn-Was 1/2, Trh, Tebs, Sdh 1/2 Install RH horn Check operation

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Oper, No	Modelcode	Effective	Secondary time	Lost time allow- ance	Schedule time	Oper, No		lelcode	Effective	Secondary		Schedule time
36301	5-	2			2	36408		9 –	5	1	1	7
36302	5–6	13	4	2	19	36430	*:	8	7	1	1	9
36302	7–	17	5	2	24	36430		9–	7	1	1	9
36306	5–6	6	1	1	8							
36306	5-9	6	1	1	8	To this s	sheet	belong	3 sheets	of repair	work	descriptio
36306	0-	4	1	1	6							
36310	56	57	6	6	69							
36310	7-	53	9	6	68							
36313	8-	3	1	1	5							
36321	5-	3	1	1	5							
36321	0-	5	1	1	7							
36323	8-	16	1	2	19							
36336	8-	8	1	1	10							
36340	5-7	8	2	1	11							
36340	8-	9	1	1	11							
36342	5-6	45	4	5	54							
36342	7-	39	8	5	52							
36344	5-7	13	3	2	18							
36346	5-6	10	2	1	13							
36360	5-	66	6	7	79							
36362	5-	72	7	8	87							
36370	5 - 6	7	6	1	14							
36370	7-	8	7	2	17							
36372	5 - 6	5	4	1	10							
36372	7-	9	5	1	15							
36402	5-8	5	1	1	7							
36408	5-7	2	1	1	4							
36408	8	5	1	1	7							

	Saab Car Division			nepair work	Description	(OAAD J	3/30
Ī		Replaces page		Date 72 01 02	Edition	Page	AT THE
	WINDSHIELD WIPERS, wiper blades replace each	5—	36301	73-01-02 WINDSHIELD V	1 VIPERS, motor c remove-install)	36301 slean 5–6	3631ő
	See 36301, SAAB 99		4	-	behind instrumer	nt panel-	
	WINDSHIELD WIPERS, motor replace complete (SWF)	r 5–6	36302		s rom bulkhead—S ernally—SCcs 3, \		16
	Disconnect arm behind instrum Wadj 4, Was 10 Disconnect leads Remove motor from bulkhead Clean motor externally—SCcs 3			Visually check a Dress commutat Assemble motor Install motor on	or check contact ga bulkhead-Ppn,		c
	Install new motor on bulkhead Connect leads Connect arm behind instrumen Check operation			feeler gauge, great Connect leads Connect arm (be Check operation	hind instrument	panel)	
	Spares: Windshield wipers motor comp	lete			VIPERS, dismant		36310
	WINDSHIELD WIPER motor (complete replace (remove-insta	II)	36302	Motor remove-ir	aii) istall see 36302 (e, clean and assem		(7–)
	Remove motor—SCcs 3, Trh, S Clean motor externally Install motor Check operation	dh 10, Tebs, H3,	SCs 5	WINDSHIELD W	VASHER, nozzle ace	in 8–	36313
	WINDSHIELD WIPERS, rubbe section replace	r 5–6	36306	Remove nozzle—Sinstall nozzle—Si			
	Remove wiper blades from car			Nozzle		ATOM IN	
0	Remove rubber section from w Fit new rubber section to wipe Fit wiper blades to car		SCs 3	WINDSHIELD W		5–	36321
	Spares: Rubber section				of both wiper arm	ns-Wadj 4	
nweden	WINDSHIELD WIPERS, rubbe section replace, each	r 5–9	36306	WINDSHIELD Warms position ad	/IPERS, both wip just	per 0-	36321
Sweden-Schweden	Remove blade from arm—SCs Remove rubber section from bl			See 36321, SAA	B 99		
1	Fit new rubber section to blade Fit blade to arm			engine hood repl		in 8–	36323
ung - Nyk	WINDSHIELD WIPERS, rubbe section replace, each	r 0–	36306	Remove tubing wit			
ienstabteil	See 36306, SAAB 99			Spares: Tubing Clips			
ent-Kundend					/ASHER, electric bottle lid) replace		36336
Saab-Scania - Service Department-Kundendienstabteilung - Nyköping				Remove lid from Remove motor for Wipe lid clean Open pack and for Fit lid to bottle Check operation	rom Iid-Wadj 4, i	Ppn	
b-Scan				Spares:			
Saa				Motor			

Spares: Pump

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	Replaces page		Date	Edition	Page	
			73-01-02	1	36340	
WINDSHIELD WIPER, switch	replace 5-7	36340	WINDSHIELD WIF	The state of the s	WF) 5–6	36346
Remove switch from instrume Remove switch from washer put Fit switch to washer pump Fit switch to instrument panel Check operation	ump—Wadj 4	s 3	Remove cover and Clean Lubricate rotor beavisually check brushes Check operation	rotor—SCs 5 arings—Special (
Switch						
WINDSHIELD WIPERS, switc (steering column) replace	h 8–	36340	bushing with spind	le replace LH (ı	remove-install)	36360
Remove cover—SCcs 1			Remove wiper arm		Om Battery V	CO 1/2
Disconnect leads from switch-	-SCs 2		Remove top fixing			
Connect leads to new switch			Remove flasher uni		warning light	
Refit cover			Remove fuel gauge Remove spindle from		. 2	
Check operation			SCs 3, file, H 3, dri		·5 2,	
Spares:			Remove lead throu	gh bushing from		
Switch			bulkhead-Trh, Tet			
			Remove spindle fro Grease spindle and			ale
WINDSHIELD WIPERS, moto	r clean 5–6	36342	Refit bushing	busing—Greas	JC	
and adjust (motor out)			Refit spindle to bu	shing		
See 36310 (5-6)			Refit top fixing nu	t of bushing		
Excl.			Refit link arms Refit fuel gauge			
Remove-install arm behind inst Disconnect-connect leads	trument panei		Refit warning lamp	and flasher		
Remove-install motor from/on	bulkhead		Reconnect earth (g		battery	
Check operation			Check operation			
			Refit wiper arm Wipe instrument pa	nel clean		
WINDSHIELD WIPERS, moto	r clean 7—	36342		iner clean		
and adjust (Lucas) (motor out		00012	Spares: Bushing with spind	la.		
Wash, blow clean and dry mot	or externally					
Kerosene bath	or externally		WINDSHIELD WIF	PERS lead-thro	ugh 5—	36362
Unsolder self-parking lead—So			bushing with spind			
Remove brush end frame—SCs	5		install) RH			
Remove brushes—Ppn Remove motor cover and roto	r		Remove fresh air d	uct-SCcssh 2,	SCcs 2	
Remove gear hsg end frame an			Remove wiper arm	-Wco 1/4		
plate-Wadj 4, SCs 2			Remove top fixing			
Remove final gearing pinion—S			Remove glove pock Remove ashtray	tet IId and box-	-Sucssn 2	
Wipe clean, inspect and lubrical parts—Special grease	ate all		Remove link arm	25		
Refit final gearing pinion			Remove spindle an		2,	
Refit rotor and motor cover			SCs 3, H 3, drift, fi		Teb Tabl	
Refit brushes and brush end fr			Remove bushing fr Tuj, Sdhl 9/16, Wc		irn, rebi,	
Adjust rotor end float—SCs 3, Fit gear hsg end frame	wadj 4		Remove spindle from		g/alt clean spind	dle
Solder on self-parking lead			Grease spindle and	bushing-Great		
			Start fixing nut on			
WINDSHIELD WASHERS, pu	mp 5–7	36344	intake—Assistant, V Refit bushing to bu			
(mech) replace			Refit top nut to bu			
Disconnect-connect earth (gro	und) cable		Refit spindle to bu	shing		
from/to battery—Wco 1/2			Refit glove pocket			
Remove windshield wiper con	trol from		Refit link arm and Check operation	asilidy		
instrument panel—SCs 2, Ppo Remove pump from control—I	Ppn Wco 11/16		Refit wiper arm			
Fit new pump to control	p.,,		Refit fresh air duct			
Fit control to instrument pane	el		Wipe instrument pa	anel clean		
Check operation			Spares:			
Spares:			Bushing with spind	le		

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WINDSHIELD WIPERS, motor r Remove motor Clean motor externally	emove 7–	36370	Remove switch- Install new swit Check operation Spares: Switch	çh	eplace 8	36430
WINDSHIELD WIPERS, motor i	nstall 5–6	36372	SWILCH			
Install motor on bulkhead–SCcs Connect leads Refit arm under instrument pane		0	Remove steering	ING SWITCH reg column cover-	-SCs	- 36430
Check operation Spares: Windshield wiper motor complet	е		Remove brake w Fit new brake war Refit brake war Refit steering co	varning switch varning switch ning switch olumn cover	11/10	
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Fold mat clear Remove footswitch—SCcs Fit new footswitch	3-0	30402				
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STOP LIGHT SWITCH replace (hydraulic)	5–7	36408				
Remove stop light switch—Wadj & Fit new stop light switch Check operation	3					
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Remove fixing nuts and switch— Disconnect leads from switch Connect leads to new switch Install switch, fit fixing nuts Check operation	Nco 11/16					
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Remove-install linkage system, see 36603, Saab 95/96 Dismantle and assemble, see 366, Saab 99 HEADLAMP WIPERS, relay replace, each 1— 36605 Remove relay—SCcs Open pack and fit new relay—SCcs Check operation HEADLAMP WASHERS, nozzle replace, 1 36606 each	Remove-install linkage system, see 36603, Saab 95/96 Dismantle and assemble, see 366, Saab 99 HEADLAMP WIPERS, relay replace, each 1— 36605 Remove relay—SCcs Open pack and fit new relay—SCcs Check operation HEADLAMP WASHERS, nozzle replace, 1 36606 each		36604			
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Remove relay—SCcs Open pack and fit new relay—SCcs Check operation HEADLAMP WASHERS, nozzle replace, 1 36606 each	Remove relay—SCcs Open pack and fit new relay—SCcs Check operation HEADLAMP WASHERS, nozzle replace, 1 36606 each	Dismantle and assemble, see 366, Saab 99				
Open pack and fit new relay—SCcs Check operation HEADLAMP WASHERS, nozzle replace, 1 36606 each	Open pack and fit new relay—SCcs Check operation HEADLAMP WASHERS, nozzle replace, 1 36606 each	HEADLAMP WIPERS, relay replace, each 1-	36605			
Check operation HEADLAMP WASHERS, nozzle replace, 1 36606 each	Check operation HEADLAMP WASHERS, nozzle replace, 1 36606 each					
each	each					
each each	each					
See 36608, Saab 99	See 36608, Saab 99		36606			
		ee 36608, Saab 99				

Saab-Scania - Service Department-Kundendienstabteilung - Nykōping - Sweden-Schweder

Repair Work - Standard Times SAAB 95/96

Saab Car Di	vision					-	WOIK			mes 3F	MD.	00,00
			Replaces pag	Date	Date Edition Jan. 1973 1			Page 38104 - 38198				
Oper, No	Modelcode	Effective	Secondary	Lost time allow- ance	Schedule time	Oper. No		delcode	Effectiv			Schedule time
	3	A.	I.	ance	1		ı		,	1	ance	L
38104	5-9	18	3	2	23	38164		5-	11	2	1	14
38104	0-	8	1	1	10	38165		5-	94	5	10	109
38108	5-9	18	6	2	24	38167		5-	39	3	4	46
38108	0-	22	5	3	30	38169		5-	28	3	3	34
38114	7–9	7	1	1	9	38170		5-	3	2	1	6
38114	0-	9	1	1	11	38175		5-6	9	5	1	15
38124	5-	9	2	1	12	38184		5-	4	3	1	8
38133	5-6	111	3	11	125	38186		5-	6	3	1	10
38133	7	101	3	10	114	38188		5-9	12	4	2	18
38133	8-9	94	3	10	107	38188		0-	16	4	2	22
38133	0-	72	2	7	81	38198		5-9	5	3	1	9
38134	0-	4	2	1	7	38198		0-	6	4	1	11
38136	5-6	27	4	3	34							
38139	0-	11	1	1	13	To this	sheet	belong	4 sheets	of repair	r work	description
38155	5–6	38	3	4	45							
38155	7	34	3	4	41							
38155	8-9	31	3	3	37							
38155	0-	19	2	2	23							
38157	5–6	72	3	8	83							
38157	7	67	3	7	77							
38157	8-9	62	3	7	72							
3 8 1 57	0-	52	2	5	59							
38160	5 - 6	16	7	2	25							
38161	5-7	40	3	4	47							
38161	8-9	35	3	4	42							
38161	0-	33	2	4	39							
38162	5-9	10	2	1	13							
38162	0-	14	2	2	18							
38163	5-	4	2	1	7							

Saab Car Division			поран потк			
	Replaces page		73-01-02	Edition 1	Page 38104	
FUEL SYSTEM replace Disconnect-connect earth (grouf from battery—Wco 7/16, SCs Remove flasher unit Remove fuel gauge from instruction Disconnect leads from fuel gauge Fit gasket to new fuel gauge	ment panel-SCs	38104	Spares: Clock, electric INSTRUMENT P (steering column Remove instrume SAAB 95–96, 5– Install instrument	stand removed) ent panel, see 381 -6 t panel, see 3815	155,	38133
Connect leads Install fuel gauge on instrumen Install flasher unit Check operation of flashers Spares: Fuel gauge	t panel		INSTRUMENT P (steering column Remove instrume SAAB 95–96, 7	ANEL remove-in stand removed) ent panel, see 381	155,	38133
FUEL GAUGE replace (removinstall) combined instrument of See 38104, SAAB 99		38104	Install instrument INSTRUMENT P (steering column	ANEL remove-in		38133
SPEEDOMETER replace Disconnect battery cable—Wco		38108	Remove instrume SAAB 95–96, 8– Install instrument SAAB 95–96, 8–	ent panel, see 381 -9 t panel, see 3815		
Disconnect speedometer drive Remove speedometer Transfer and install new gasket Install new speedometer Connect drive cable Clean, grease and connect batt cable—Ck, Vaseline Check speedometer operation			INSTRUMENT P (steering column Remove instrume SAAB 95–96, 0- Install instrumen SAAB 95–96, 0-	stand removed) ent panel, see 38° - t panel, see 3815	155,	38133
Spares: Speedometer and odometer			GLOVE POCKET	et, remove handle		38134
SPEEDOMETER replace Remove fresh air nozzle—SCcs	0-	38108	Fit handle—Wco Wipe handle and close lid—Cleanin	glove pocket lid,		
Remove speedometer Open pack and transfer shield Install speedometer Refit fresh air nozzle—SCcs Check operation—Lj, Ltr TEMPERATURE GAUGE (ele			TEMPERATURE replace (not test) Drain coolant—W Disconnect-connectrom/to battery—	co 7/16 ect earth (ground		38136
TEMPERATURE GAUGE (elector) Remove temp gauge Install temp gauge Check operation Spares: Temp gauge	oc) 7–9	38114	Remove insulatin Remove defrostel Remove temp gat Shut off coolant Remove temp gat Remove grommer Remove temp gat Fit new temp gat Refit in reverse o	g material on bu r hose uge from instrum tap uge transmitter—' t from bulkhead- uge from car uge	ent panel-SCs Wco 9/16	
TEMPERATURE GAUGE rep (remove-install), combined install) See 38114, SAAB 99		38114	Fill with coolant Spares: Temp gauge			
CLOCK replace Remove ashtray Remove clock, disconnect lead	5-	38124	COMBINED INS replace (remove-i	nstall) init	0- 38139	
Remove clock, disconnect lead Transfer gasket Install clock, connect lead Refit ashtray			Remove combine Open pack and tr Fit combined ins Refit flasher unit Check operation	ansfer shield trument		

Saab Car Division						
	Replaces page		73-01-02	Edition 1	Page 38155	
INSTRUMENT PANEL remove (steering column stand remove		38155	INSTRUMENT PAN steering column star	the second of the second secon	I 5–6	38157
Remove ashtray Remove glove pocket and lid— Remove heater control wires— Remove panel screws and nuts— Sdh 1/2, Trh, Tebl Withdraw (tilt forward) instr p Disconnect leads from clock Disconnect leads from temp ga Disconnect leads from main be Disconnect leads from flasher v Disconnect leads from fuel gau Remove windscreen wiper com Remove defroster fan controls— Remove defroster hose Remove instr panel (The disconnected leads must k	SCs, Ppn -Wco 7/16, SCcs 3, anel g lamp uge am warning lamp le from speedomete warning lights ge trols-Ppo -Ppo		Position panel in car Connect leads to clo Connect leads to ter Connect leads to ter Connect leads to the Connect leads and d Connect leads to ma Connect leads to fue Install windscreen w Install defroster fan Install defroster hos Install panel screws SCcs 3, Sdh 1/2, Tri Install plove pocket Install glove pocket Install ashtray Check operation	ock—Circuit diag sher warning lan mp gauge arging lamp rive cable to spo in beam warning el gauge viper control—Plo control—Ppo l—Ppo e and nuts—Wco n, Tebl	mps eedometer—P ng lamp po 7/16,	po
INSTRUMENT PANEL remove (steering column stand remove	e 7	38155	INSTRUMENT PAN steering column) See 38157—T (B4—cincl connect lead to	6) excl install ch	noke control,	38157
See 38155—T (B4—6) excl Disconnect choke control, incl lead from oil pressure warning			INSTRUMENT PAN	IEL install (exc	I 8–9	38157
INSTRUMENT PANEL remove (steering column stand remove See 38155—T (B4—6) excl disc clock, choke and windscreen w disconnect choke control, incl and instrument lighting control	d) connect leads from riper controls, incl disconnect	38155	See 38157—T (B4—install choke and wi connect leads to oil instrument lighting of the steering column)	ndscreen wiper pressure warnin control	controls, incl g lamp and in	
INSTRUMENT PANEL remove (steering column stand remove) Remove knobs from control ar Remove control panel—SCcs Remove switches for warning from instrument lighting—Ppn (or possible for the particular of the part	d) ms lashers and pssibly special tool) e stay—SCcs LH side— RH side— le	38155	Enter car with instru Install control arms- Install LH end cover Connect electrical le Install switch for wa instrument lighting- Connect speedomete Install RH defroster Offer up and positio Start screw at centre Start RH side screws Start LH side screws Tighten LH side screws Tighten RH side screw Tighten screw at cer Install control panel Fit control knobs, co	-Was, Wco 7/16 -SCcs rads rrning flashers and -Ppn (or special er drive cable hose at panel n n panel e stay-SCcs s and nuts-SCcs ews and nuts-Sc ews and nuts-Si ews and nuts	nd tool) ozzle s, Wco 7/16 s, Wco 7/16 Ccs, Wco 7/16	1 to 1
Discard instrument panel			TEMP GAUGE TES Drain coolant—Wco Remove temp gauge Heat water and chec welding equipment to Install temp gauge—S Fill with coolant—M	7/16, Mdv —Wco 7/16, Wc k temp gauge— thermometer Sealing compou	Gas	38160

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

Saab Car Division

Saab Car Division					- P-2	
	Replaces page		73-01-02	Edition 1	Page 38161	
INSTRUMENTS AND CONTR	ROLS, 5–7	38161	GLOVE POCKE	T I ID replace	0-	38161
transfer all (instr panel off)	1020, 0-7	30101			(6/	30101
Remove-install clock			See 38162, SAA transfer handle	B 95–96, 5–9	at .	
Remove-install charging lamp			- I ditate Hariate			
Remove-install direction ind rp	otr lights					
Remove-install temp gauge			GLOVE POCKE	T LID remove-	install 5—	38163
Remove-install speedometer Remove-install main beam war	ning light		Remove Iid-SCo			
Remove-install oil pressure war			Install lid—SCcss			
(not 2-stroke)			Check operation	and wipe clea	n-Cleaning pape	
Remove-install fuel gauge Remove-install extra switches						
Remove-install side defroster h	nses_Adhesive		GLOVE POCKE	T replace	5-	38164
Remove-install heater control-		/16	Remove Iid—SCo	essh		
.Remove-install plates—SCs			Remove glove po			
Remove-install rubber plugs—S			Fit six clips to gl			
Remove-install end plate—SCcs	2		Install glove poc			
			Install lid			
INSTRUMENTS AND CONTR	ROLS, 8-9	38161	Spares:			
transfer all (instr panel off)			Glove pocket			
See 38161-T (B4-7) excl rem			Clips			
and 1 direction indicator rptr I	ight					
			SAFETY PADD	ING replace (st	eerina 5-	38165
INSTRUMENT AND CONTRO	OLS. 0-	38161	column stand ren		.coming 0	00100
transfer all (instr panel off)	,	55.5.	Cut holes for sid	e defrester noz	zla (new	
Remove glove pocket and lid-	SCcssh		safety padding)		ZIE (HEW	
Remove combined instrument	3000011		Cut edge clean-			
Remove speedometer			Remove ashtray			
Remove ashtray	-d li-bai 00-		Remove glove po			
Remove switches for blower ar Remove fresh air nozzle mount	ting plates—SCcs				-Wco 7/16, SCcs	3.
Remove clock for blanking pla-			Sdh 1/2, Tebl			" "
Remove centre stay—Was 7/16			Withdraw (tilt fo		nent panel	
Remove rubber pads Remove heater control legend	platas CCs /vasy)		Remove trim stri			
Remove RH end cover—SCcs	plates—SUS (rear)		Remove clips—So Withdraw safety			
Install RH end cover	F		Clean panel-Ck	paramy on		
Install heater control legend pla	ates		Apply adhesive a		fety padding-Ad	hesive
Install rubber pads—Ppn			Refit trim strip—			
Install centre stay—Was 7/16 Install clock for blanking plate			Adjust safety pace	uaing eage—Uk		
Install fresh air nozzle mountin	g plates-SCcs		Cut hole for rear	view mirror (u	p to 67)-Scissor	s
Install switches for blower and	lighting		Position and inst	all panel screw	s and nuts	
Install ashtray Install speedometer			Connect heater of Install glove pool		'pn ·	
Install combined instrument			Install glove poci	Not allu IIU		
Install glove pocket and lid—SC	Cossh			// *		
						5
CLOVE DOOKET LIE			SAFETY PADDI	ING replace (in	strument 5—	38167
GLOVE POCKET LID replace (not painting)	5–9	38162	panel out)			
			Remove trim stri			
Remove lid—SCcssh Transfer hinges—H, pipe			Remove clips—SO Withdraw safety			
Transfer radio panel			Clean panel—Ck	padding-OK		
Transfer lock			Cut holes for side		zleCk	
Install lid			Cut edge clean—S			
Check operation, wipe clean			Apply adhesive a Refit trim strip	nd position saf	ety padding—Adł	nesive
Spares:			Adjust safety page	ddina edae—Ck		
Glove pocket lid			Fit clips	g odge ok		
			Cut hole for rear	view mirror (u	p to 67)	

SPEEDOMETER remove

Remove fresh air nozzle-SCcs

Repair Work Description SAAB 95/96

Saab Car Division Page Date Edition Replaces page 73-01-02 1 38169 SAFETY PADDING install (instrument 5-38169 Remove speedometer panel out) Remove shield from speedometer Cut holes for side defroster nozzle-Ck Cut edge clean-Scissors Apply adhesive and position safety padding-Adhesive Refit trim strip-Ppn Adjust safety padding edge-Ck Fit clips Cut hole for rear view mirror-Scissors **GLOVE POCKET LOCK replace** 38170 5-Remove lock-SCcs Install lock Check operation, wipe clean Spares: Lock Key **TEMPERATURE GAUGE test** 38175 5-6 (gauge out) Heat water and check temp gauge-Gas welding equipment, tin can, thermometer **CLOCK** remove 5-38184 Remove ashtray Remove clock, connect leads **CLOCK** install 5-38186 Install gasket and clock, connect leads Refit ashtray SPEEDOMETER install 5-9 38188 Install gasket Install speedometer Connect drive cable-Lj, Ltr Clean, grease and connect battery cable-Knife, Vaseline, Wco 7/16 Check operation of speedometer SPEEDOMETER install 0-38188 Fit shield to speedometer Install speedometer Install fresh air nozzle-SCcs Check operation-Lj, Ltr **SPEEDOMETER** remove 5-9 38198 Disconnect battery cable-Wco 7/16 Disconnect drive cable-SCs Remove speedometer

38198

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CAAR QE/QE

per, No	Modelcode		leplaces page			Jan. 1973		Edition 1			7003	70	
er, No	Modelcode						10	1 1	17	Page 38202 - 38232			
		Effective	Secondary time	Lost time allow- ance	Schedule time	Oper, No		delcode	Effective time				
3202	7–	13	2	2	17					E			
3208	5-	18	4	2	24								
3210	5-	20	7	3	30								
3212	5-	37	5	4	46								
3214	0-	45	8	5	58								
230	6-	11	4	2	17								
3232	5-	23	4	3	30								
11-7	oood 17	م المحاد	of most	words	docariation								
this s	neet belong	1 sheets	of repair	work	description								
						-							

Edition

73-01-02

Saab Car Division

Date Replaces page **OIL PRESSURE TRANSMITTER** 38202 replace in car Remove oil pressure transmitter-Trh, Tebs, Sdh 1 1/16 Install oil pressure transmitter Check operation Spares: Oil pressure transmitter SPEEDOMETER DRIVE CABLE 5-38208 replace Disconnect drive cable from speedometer-Ppo Pull out inner wire Clean and remove drive cable from gearbox-Remove bottom section of inner wire-Ppn Oil and install new wire Connect cable to gearbox Connect cable to speedometer Jack up and lower fron of car-Li Psc. Ppn Check operation Check operation Spares: Flexible shaft SPEEDOMETER DRIVE CABLE clean 5-38210 and lubricate Remove-install cable, see 38208, SAAB 95-96, 5-Clean and lubricate cable-Trich, lint-free rag vice SPEEDOMETER DRIVE CABLE 38212 replace (complete) Remove bulkhead insulating material clip-Ppn Remove defroster pipes Disconnect cable from speedometer-Ppo Withdraw inner wire Remove radiator insulating material Clean and remove cable from gearbox-Ppo, Cag Remove grommets from mounting and bulkhead-SCs Remove cable Install cable Install grommets in mounting and bulkhead Lubricate and install inner wire Connect cable to gearbox Connect cable to speedometer Refit bulkhead insulating material and defroster pipes Refit radiator insulating material (-64 only)

SPEEDOMETER DRIVE CABLE nut 0-38214

Page

38202

Remove pressure nozzle-SCcs Remove speedometer Drill one 2 mm diam hole in earth (ground) lead connection tag-Mpd, drill diam 2 Cut off and fit suitable length of special wire to hole Psc, Ppn Install speedometer Fit wire to drive cable nut and seal-Special pliers, Psc, Ppn Remove speedometer drive cable from gearbox-Ppo, Cag Drill one 2 mm diam hole in bottom drive cable nut-Mpd, drill diam 2 Drill one 2 mm diam hole in spring on gearbox (near nut)-Mpd, drill diam 2 Remove any swarf-Cag Cut off and fit suitable length of special wire to hole in nut-Psc, Ppn Connect speedometer drive cable to gearbox-Ppo Fit wire to hole in spring and seal-Special wire,

COOLANT TEMP TRANSMITTER 38230 (electrical) replace in car

Drain coolant-Wco 7/16 Remove coolant temp transmitter-Ppn, Trh 3/8, Tebs, Sdh 13 Install coolant temp transmitter Fill with coolant-Water can Check operation

Spares:

Coolant temp transmitter

SPEEDOMETER DRIVE, pinion 38232 in gearbox replace

Clean and remove cable from gearbox-Cag, Ppo Remove speedometer pinion guide sleeve-Tah, Sdh 33 Remove pinion from shaft-sleeve-H, drift 2 mm Clean and check parts Install and shim up new pinion—Measuring tool B

Install guide sleeve and drive cable to gearbox Raise-lower front of car, check operation-Li

Spares: Pinion **Shims** Gasket Locking pin

Raise-lower front of car-Lj Check operation Spares: Speedometer cable

Service Department-Kundendienstabteilung

SAAB

Metodbeskrivningar (ackordsmeddelanden)

Repair Work Descriptions

Methodenbeschreibungen

4

Kraftöverföring, Bakaxel Transmission, Rear axle Kraftübertragung, Hinterachse

SAAB-SCANIA
Saab Car Division

Service Department

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			opidoss pag			Jan. 1973	1		41103 -	41175	V4
per. No	Modelcode	Effective	Secondary time	Lost time allow- ance	Schedule time		lodelcode	Effecti time	Seconda time		Schedule
11103	7-	82	13	10	105						
11105	7-	29	10	4	43						
11107	7–	13	4	2	20						
11111	7–	8	4	1	13						
11115	7-	37	4	4	45						
11119	7–	11	29	2	17						
41120	7-0	305	27	34	369						
41120	1-	315	1	3 5	380						
41123	7-	3	13	1	5						
41125	7-	70	5	8	91						
41127	7-	31	3	4	40						
41129	7-	4	7	1	8						
41171	7-	16	6	2	25						
41175	7–	22		3	31						
To this she	eet belong	2 sheets	of repair	work	description						

Saab Car Division

Repair Work Description SAAB 95/96

Remove engine-to-gearbox bolts-Was 15

Check release brg and unpack new bearing

Separate engine and gearbox

Date Replaces page Edition Page 41103 **V4** 73-01-02 Clutch: release brg and clutch shaft 41119 Clutch: housing replace (power unit 41103 out) seal replace (power unit separated) See 41103 (5-6) add remove-install shield plates Release brg and clutch shaft seal replace, see 41119 2-stroke Spares: Clutch housing, clutch shaft, seal, drive shaft seal Clutch: pressure plate assy and release brg7-0 41120 replace (incl remove-install power unit) Clutch, pressure plate assy and clutch 7-41105 Remove power unit, see 20174 (7–8) disc replace (power unit separated) Remove LH engine mtg bracket—Tanr, Sdh 13, Was 13 Remove pressure plate assy fixing screws-Tanr, Sdh 13 Fit bracket and mount power unit in stand—Tanr, Sdh 13 Remove disc and pressure plate assy Separate power unit-Tanr, Sdh 15, Was 15, SCcs, Ppo Wash pressure plate assy-cleaning area, Cag Pressure plate assy and disc replace, see 41105 (V4) Wash flywheel-brush and cleaning agent Assemble power unit Wash friction surfaces on flywheel and pressure plate—Trich Remove power unit from stand, remove mounting bracket Check disc, pressure plate assy and release bearing for wear Install LH mounting bracket Remove-install release plate and lubricate levers-SCs, grease Check release brg, unpack new brg if nec-Ck Dresspressure plate, flywheel and clutch disc-dressing cloth, Remove-install release brg-SCs, grease Install power unit in car, see 20176 (7-8) Posn disc and pressure plate assy on flywheel-784064 Fit fixing screws and torque-tighten—Ttg Spares: Pressure plate, assy, disc, release brg Check dimensions-steel rule, slide gauge Spares: pressure plate assy, clutch disc 1- 41120 Clutch: pressure plate assy, disc and release brg replace (incl remove-install power unit) Clutch: pressure plate assy and/or disc 41107 remove-install, excl cleanind and dressing (power unit Remove power unit, see 20174 (7-) separated) Remove LH engine mtg bracket-Tanr, Sdh 13, Was 13 Fit bracket and mount power unit in stand-Tanr, Sdh 13 Remove pressure plate assy fixing screws-Tanr, Sdh 13 Separate power unit-Tanr, Sdh 15, Was 15 Remove disc and pressure plate assy Pressure plate assy and/or disc replace, see 41105 (7-) Blow clean disc, flywheel and pressure plate assy-Cag Assemble power unit Posn disc and pressure plate assy on flywheel-784064 Remove power unit from stand, remove mounting bracket Fit fixing screws and torque-tighten-Tanr, Sdh 13, SCs, Ttg Install LH mounting bracket Check dimensions-steel rule, slide gauge Check release brg, unpack new brg if nec-Ck Remove-install release brg-SCs Install power unit in car, see 20176 (7-) 41111 Clutch: clutch shaft seal replace (release brg off) Spares: Pressure plate assy, disc, release brg Clutch shaft seal replace, see 41111 (5-6) 41123 Clutch: release brg free movement ad-41115 Clutch operation: release-fork shaft replace (power unit out) Adjust, free movement-Wco 1/2, Wadj Remove starter motor-Wsm 9/16 Remove shield plates-Ppo, SCcs 41125 Clutch: Pressure plate assy, and Remove gearbox complete from engine-Was 9/16 release brg replace (power unit out) Remove release bearing-Ppn Remove release-fork shaft return springs-Ppo Remove LH engine mtg bracket-Tanr, Sdh 13, Was 13 Remove release-fork shaft roll pins-H, drift Fit bracket and mount power unit in stand-Tanr, Sdh 13 Remove shaft and fork Separate power unit-Tanr, Sdh 15, Was 15, Loctite Posn shaft and fork (incl shaft greasing)-grease Pressure plate assy and/or disc replace, see 41105 (7-) Refit 3 roll pins Assembly power unit Refit release fork shaft return springs Remove power unit from stand, remove mtg bracket Reflit release brgs Install LH mounting bracket Clean mating surface-rag Check release brg, unpack new brg if nec Refit gearbox complete to engine Remove-install release brg-SCs, grease Refit shield plates-Loctite Refit starter motor Wipe clean inside clutch hsg 7- 41127 Clutch: release brg replace (power unit out) Spares: Release fork shaft complete Remove starter motor-Wco 9/16 Remove shield plates-SCcs, Ppo

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	Hepiaces page			1	The state of the s	1/4
10000			73-01-02		41127	V4
emove release brg and win it release brg—SCs, grease ssembly engine and gearb	oe clean inside clutch hs	41127 sg—SCs, rag				
efit engine to gearbox bo efit shield plates—SCcs, P efit starter motor—Wco 9	po, Loctite					
pares: Release brg						
lutch: release plate replace nit separated)	e (power 7–	41129				
Inpack release plate—Ck lemove-install release plate rease, SCs rheck dimensions—steel ru		sing—				
pares: Release plate						
lutch: disc facing replace	(disc out) 7–	41171				
isc facings replace, see 41	171 2-stroke					
lutch: pressure plate assy	recond 7—	41175				
/ash pressure plate assy–c lock up–SCs	leaning area, Cag					
emove release plate—SCs, lount assy in press and co temove release lever spring	mpress-Press					
lemove release levers laise press						
emove springs (6) leasure free length of spri						
leasure spring force—sprin						
irease release lever contac osn springs (6) osn assy in press and com						
lefit release lever springs— lefit release levers						
aise press lefit release plate			- 2 -			
pares: springs, release leve	rs, release plate					

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						Jan. 1973	3 1		41215 - 43234	
per, No	Modelcode	Effective	Secondary time	Lost time allow- ance	Schedule time	Oper. No	Modelcode	Effective	Secondary Lost time allow-	Schedule time
41215	5-	9	5	1	15					
41225	5-	6	3	1	10					
41227	5-	5	1	1	7					
41231	5-	18	5	2	25					
41239	5–	3	1	1	5					
41240	5 - 8	28	5	3	36					
41240	9-	25	6	3	34					
41244	5-	9	3	1	13					
41246	5-	10	3	1	14					
43208	5-	28	1	3	32					
43214	5	16	3	2	21					
13215	5-	8	1	1	10					
13234	5-	24	3	3	30					
Γο this s	heet belong	2 sheets	of repair	work	description					

SAAB-SCANIA Saab Car Division		Repair Work	. = 0001111110		-, -
	Replaces page	73-01-02	Edition 1	Page 41215	
Clutch operation: slave cyl reco	ond 5— 41215	Clutch operation (remove-install	on: master cyl ro) incl bleeding	eplace 9–	41240
Dismantle slave cyl—Pcb, SCs, V Clean and check all parts—clean Assembly slave cyl—grease Spares: repair kit		Disconnect pus Remove retain Install cyl and Reconnect hos	ing bolts, remov refit retaining b e to cyl	il—Ppn, lead lam e cyl—784470	p
Clutch operation: bleeding the	system 5- 41225	Reconnect pus Fill and bleed s brake fluid		16, cooling syste	m tester,
Top up clutch reservoir—brake Open bleed nipple on slave cyl a Wco 7/16, plastic hose, vessel		Spares: master	cyl complete		
Pump out air using cooling syst tester Tighten nipple, remove hose, re		Clutch operat (remove-install	ion: slave cyl re _l) incl bleeding	place 5–	41244
Clutch operation: slave cyl repla (remove-install) excl bleeding		Remove slave of Install slave cy Reconnect hos	l .	I—Wadj 6	
See 412144 (5—) excl bleeding Spares: slave cyl complete		Bleed system Fill with fluid Wipe clean	(twice)		
		Spares: slave co	yl complete		
Clutch operation: master cyl re (cyl out)	cond 5— 41231	Clutch operati	on: pressure hos	se replace, 5—	4124
Clean master cyl externally—Ca Dismantle master cyl—SCs Dismantle piston components Clean and check dismantled par Assemble piston components—I Assemble master cyl	rts-washing facilities	incl bleeding Disconnect ho Drain fluid—W	se from slave cy co 7/16 se from master o to master cyl	I–Wadj 6	
Spares: repair kit		Bleed system			
Clutch operation: pressure hose replace excl bleeding	5 41239	Fill with fluid Wipe clean Spares: hose	(twice)		
See 41247 (5-) excl bleeding					
Spares: hose					
Clutch operation: master cyl re (remove-install) incl bleeding	place 5-8 41240				
Disconnect hose from master control Drain fluid—Wco 1/2	yl–Wco 7/16				
Remove rubber mat—Was 1/2 Remove split pin from clutch p Remove master cyl	edalPsc				
Install master cyl Refit split pin to clutch pedal	i liberium				
Refit rubber mat Reconnect hose to master cyl					

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Reconnect hose to master cyl

Bleed system

Saab Car Division Date Edition Page Replaces page 73-01-02 1 43208 Gearbox operation: Gearshift UJ replace 5-43208 Remove UJ-Wco 5/16, H, drift Install UJ-Wco 5/16 Spares: Gearshift UJ Gearbox operation: twist stop and 43214 gear positions (steering column stand) adjust Place tools in car Slacken twist stop holding screws (1st gear)-Trh, Sinh 3/16, Slacken the twist stop stop screw (reverse gear) Measure gear lever play-roller Slacken steering column stand bolts-Wco 1/2 Adjust steering column stand posn, measure, adjust Tighten bolts Check gear positions Align twist stop with lock cyl and tighten stop screw Tighten holding screws (1st gear) Slacken stop screw (reverse gear) Tighten holding screws finally Tighten stop screw finally Check operation Remove tools from car and clean controls-rag Gearbox operation: gear posn (steering 43215 column stand) adjust Measure gear level play-roller Slacken steering column stand bolts-Wco 1/2 Adjust steering column stand posn, measure, adjust Tighten bolts Check gear posn Gearbox operation: gear lever hsg dis-43234 mantle, grease and assemble Remove steering wheel-Trh, Sdh 15/16, SCs Remove windshield wiper control (1968-)-SCcs 1 Remove locking screw from steering column stand-Trh, 3/16 "Extract" gear lever-SCs Remove nut and lever-Wsp 38 Remove knob hsg, twist stop, spring and plastic brg Grease and assemble all parts to lever-grease Posn housing and rubber ball on gearshift rod Fit nut "Engage" gear lever Check gear posn Refit locking screw Refit windshield wiper control (1968-) Refit steering wheel Wipe clean steering wheel and gear lever-rag

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per. No	Modelcode	Effective	Secondary	Lost time allow- ance	Schedule time	Jan. 1973 Oper. No		1 delcode	Effect		7101 - Secondar time		Sche
7101	5-	33	8	4	45								
7103	5-	14	5	2	21								
47105	5-	5		1	6								
7111	5-	5	1	1	7								
47113	5-	211	23	23	257								
17117	5-	176	21	20	217								
17121	5-	12	1	1	14								
17132	5-6	232	25	26	283								
47132	7-	285	25	31	341								
17137	5-	432	34	47	513								
47144	5-	16	4	2	22								
47153	5-	75	10	8	93								
47155	5-	14	4	2	20								
47156	5-	71	12	8	91								
47157	5-	11	3	1	15								
47:158	5-	53	10	6	69								
47170	5-6	102	21	12	135								
47170	7-	111	21	13	145								
17172	5-6	130	19	15	164								
47172	7-	174	19	19	212								
47173	5-	288	26	31	345								
47175	5-	169	29	20	218								
47179	5-	15	2	2	19								
47181	5-	15	2	2	19								
47183	5-	8		1	9								
47193	5-	66	9	8	83								
47198	5-	32	7	4	43								

Replace	es page	V	73-01-02	Edition 1	Page 47101
earbox: freewheel complete replace	5	47101			
remove-install)					
lemove inner UJs/drivers—Was 11/16 emove clutch hsg from gearbox—Wa					
ebm, SCs					
emove freewheel complete-879030 it new freewheel complete					
lash, blow, dry clutch hsg-Cleaning	area				
lean mating surface (to gearbox) oply sealing compound and fit clute	h hsa to a	earbox—seal-			
ng compound					
eplace sealing rings and refit inner U ide gauge, grease, H, SCch	Js/drivers	–7840 33, –30,	100		
pares: freewheel complete, drive sha	ft seals				
earbox: freewheel recond	E	47102			
reewheel out)	5-	47103			
heck (recond) freewheel—879030 /ash hub, arrange parts, apply oil—cle	eaning are	a Moc			
pares: plunger, spring, hub	ourning area	u, moo			
earbox: selector rods replace	5-	47105			
end cover off) emove selector rods from end cover-	-Weo 0/1	6 SCc			
it selector rods to end cover	-wco 9/ 1	0, 303			
pares: selector rods					
earbox: primary shaft gear brg	5-	47111			
eplace (gearbox dismantled)			E-allan		
Inpack new bearing	1007 704	000			
him up primary shaft end cover—784	4237, 784	062			
pares: ball bearing, shims if nec					
iearbox: remove-install layshaft	5	47113			
countershaft) and primary shaft					
emove-install layshaft, see 47117 (5					
lemove complete freewheel and need lemove primary shaft nut—H, SCch,					
emove primary shaft complete-784					
lemove primary shaft rear bearing Vash and check layshaft and compon	ents—clear	ning area			
oil and fit primary shaft, rear bearing					
-114, –109 orque-tighten and lock primary shaf	t nut—Tta				
lefit complete freewheel and needle					

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Saab Car Division Date Edition Replaces page 73-01-02 1 Gearbox: layshaft (countershaft) 5-47117 Gearbox: replace (remove-install) remove-install complete (incl remove-install power unit) Remove power unit, see 20174 (5-6) Arrange work area Remove inner UJs/drivers-Was 11/16, Wadj, H, drift Drain gearbox oil-Trh 3/8, vessel Remove clutch hsg from gearbox-Was 1/2, Sdh 1/2, Trh, SCs Remove starter motor-Wsm Blow clean round gearbox cover and remove—Cag, Sdh 7/16, Remove engine/clutch hsg fixing bolts-Trh 3/8, Sdh 9/16 Release and lift away gearbox with clutch hsg Mount gearbox in fixture-784100, Trh 3/8, Sdh 1/2, Tebm Wash, blow and dry gearbox-cleaning area, Cag Remove speedometer pinion-Trh 1/2, Sdh 33 Unpack new gearbox (when replacing gearbox) Measure crownwheel backlash-784062, 784097, marking dye or alternatively replace clutch shaft seal (incl remove-install Remove diff and oil deflector-Trh 3/8, Sdh 9/16, Hp release bearings) -784220, H, Psc Measure and note pinion shaft position-784062, 784146 Fit gearbox complete to engine Remove end cover and selectors-Trh 3/8, Sdh 1/2, H, drift, Fit starter motor Fill gearbox with oil 784069 Remove layshaft nut and friction brake-784094/786132, Install power unit in car, see 20176 (5-6) Trh 1/2, H, SCch Pack old gearbox Remove layshaft complete and front brg-784125, 786136 Spares: gearbox, gearbox oil, clutch shaft seal, flange seal Wash, blow and dry clutch housing,-cleaning area Wash, check layshaft and parts-cleaning area Remove retaining ring from bearing and key from gear-H, Gearbox: replace (remove-install) drift, Pcsh complete (incl remove-install power unit) Fit front bearing and shaft in housing-784109, 786134 Align, gear, fit key, friction wheel, washer and nut-H, drift Remove power unit, see 20174 (7-) Fit layshaft bearing retaining ring Drain gearbox oil-Trh 3/8, vessel Tighten and lock layshaft nut-Ttg Remove starter motor-Wsm Clean end cover (incl shims) Remove plate at flywheel-Ppo, SCcs Check clearance between laygear (countershaft gear) and Remove fixing bolts-Trh 3/8, Sdh 15 primary shaft bearing Release and lift away gearbox with clutch hsg Posn selectors Wash, blow and dry gearbox with clutch hsg-cleaning area, Posn new gasket on end cover Cag Fit end cover and torque-tighten bolts-Tanr, Sdh 1/2, Ttg Unpack new gearbox (when replacing gearbox) Adjust selectors-Wco 9/16, SCs or alternatively replace clutch shaft seal (incl remove-install Blow clean and check diff bearings release bearings)-784220, H, Psc Fit oil deflector and install diff-Ttg, Sdh 9/16 Offer up gearbox with clutch hsg to engine Measure crownwheel backlash Fit fixing bolts Apply sealing compound and fit speedometer pinion Fit plate at flywheel Remove gearbox from fixture Fit starter motor Apply sealing compound and fit cover Fit gearbox with oil Check gear posn Install power unit in car, see 20176 (7-) Remove driveshaft seals, fit new-784033, -030, slide gauge, Pack old gearbox grease, H Spares: gearbox, gearbox oil, clutch shaft seal, flange seal Clean mating surface (to gearbox) Apply sealing compound and fit clutch hsg to gearbox Fit inner UJs/drivers Arrange work area (clean fixture) Spares: end cover gasket, locking strips, driveshaft seals Gearbox: clutch hsg replace 47121 (clutch shaft out) Remove return spring and roll pins from release torque shaft -H, drift Remove shaft and fork Posn shaft and fork in new clutch hsg-grease, H Fit roll pins Transfer inspection cover-SCcs Transfer plugs-Trh 3/8, Was 7/16

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Fit release-fork shaft return springs-Ppo

Spares: clutch housing, roll pins

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Gearbox: recond (excl diff, freewheel 5— and lapping synch rings)

Recond includes: dismantel, check, assemble + replace all gearbox (not disc) bearings and shafts or gears as necessary Dismantle, check, assemble, see 47173 (5—)

Remove clutch shaft and freewheel lock—Was 1/2, Pcb Remove clutch shaft bearing from shaft—Hp

Fit clutch shaft bearing from shaft

Fit clutch shaft and freewheel lock to had

Remove primary shaft bearing from shaft—Pcsh, press

Unpack new primary shaft bearing

Oil and fit new bearing to shaft-784107

Remove layshaft rear brg from layshaft-Press

Unpack new layshaft bearing

Oil and fit new layshaft bearing

Remove key and pinion shaft front brg from shaft—Psc, press, 784123

Oil and fit new bearing and key to shaft—H, press Shimming at end cover for layshaft—784237, 784062

Shimming at end cover for pinion shaft

Shimming at end cover for pirmary shaft

Measure and note pinion shaft posn, calculate backlash—784062, 784146

Remove end cover, pinion shaft, nut and rear $brg-2 \times 784115$, 786052

Posn shims, fit brg, nut and torque-tighten—2 x

Fit end cover and torque-tighten bolts—2 x

Measure pinion shaft posn and note backlash—2 x Clean any new parts

Spares: end cover gasket, speedometer pinion gasket, drive shaft seal, clutch shaft seal, friction wheel, clutch shaft bearing, locking strip, layshaft front and rear bearings, primary shaft front and rear brgs, pinion shaft front and rear brgs, synch rings, also shafts, gears, needle brgs and shims as necessary.

Gearbox: cover remove-install (power- 5- 47144 unit out)

Clean around and remove gearbox cover—Cag Clean mating surfaces and wash cover—Ck, cleaning area, Cag Apply sealing compound and fit cover—sealing compound Check gear posn

Gearbox: fit new gaskets (incl remove- 5- 47153 install clutch hsg)

Remove inner UJs/drivers—Was 11/16, 1/2, Wadj Remove clutch has from gearbox—Was 1/2, Sdb 1/2

Remove clutch hsg from gearbox—Was 1/2, Sdh 1/2, Tebm,

Tbr, SCs Blow clean round gearbox cover and remove—Cag, Sdh 7/16,

Remove speedometer pinion-Tah, Sdh 33

Remove end cover-Tbr, Sdh 1/2, H, drift, 784069

Clean mating surfaces to cover, end cover and clutch hsg-Ck

Clean mating surface on cover

Clean mating surface on clutch hsg

Wash, blow and dry clutch hsg-cleaning area

Wash and blow cover

Clean end cover (incl shims)

Posn new gasket on end cover

Fit end cover and torque-tighten bolts-Tanr, Sdh 1/2, Ttg

Adjust selector rods-Wco 9/16, SCs

Apply sealing compound and refit speedometer pinion—sealing compound

Apply sealing compound and refit cover Check gear posn

Fit new driveshaft seals—784033, —30, H, slide gauge, grease Apply sealing compound and fit clutch hsg to gearbox

Refit inner UJs/drivers

Spares: end cover gasket, speedometer pinion gasket, drive shaft seals

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Saab Car Division Replaces page Date 73-01-02 Gearbox: main shaft front bearing 47155 5and/or shaft replace (main shaft out) Remove main shaft brg from shaft-Pcsh, press Unpack new bearing Oil and fit new bearing to shaft-784107, Moc Spares: main shaft, bearing Gearbox: end cover replace (incl 47156 remove-install top cover) (power unit out) Drain gearbox oil and clean gearbox externally-Trh 3/8, Cag Blow clean round top cover and remove—Cag, Sdh 7/16, Tbr Remove end cover-Tbr, Sdh 1/2, Hp, SCs Clean mating surfaces for end cover and top cover-Ck Locate poppet balls in selector forks-784069, drift Press new sealing shroud into new cover-hp Clean shims—cleaning area Posn new gasket on end cover Shimming at end cover for layshaft-784237, 784062, screw vice Shimming end cover for pinion shaft Shimming at end cover for primary shaft Remove selector rods from end cover—Wco 9/16, SCs Fit selector rods to new end cover Fit end cover and torque-tighten bolts-Tanr, Sdh 1/2, Ttg Adjust selector rods-Wco 9/16, SCs Apply sealing compound and fit top cover-sealing compound Check gear posn Fill gearbox with oil Spares: end cover, end cover gasket, shims if nec. Gearbox: layshaft, reverse pinion 5-47157 and/or rear brg replace Remove layshaft rear brg from layshaft-Press Unpack new brg-SCs Oil and fit new brg to layshaft Shimming at end cover for layshaft-784237, 784062 Spares: layshaft, reverse pinion, bearing Gearbox: end cover replace (incl 5-47158 remove-install top cover) (power unit out) Drain gearbox oil-Trh 3/8, vessel Clean gearbox externally—Cag Blow clean round gearbox top cover and remove-Cag, Sdh 7/16, Tbr, Hp Remove end cover-Tbr, Sdh 1/2, Hp Clean mating surfaces of end and top covers-Ck, cleaning Locate poppet balls in selector forks-784069 (2) Posn new gasket on end cover Fit end cover and torque-tighten bolts Apply sealing compound and fit top cover-sealing compound Check gear posn-drift

Gearbox: remove complete (incl 47170 remove power unit)

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Remove power unit, see 20174 (5-6) Drain gearbox oil-Trh 3/8 Remove starter motor-Wsm Remove engine/clutch hsq fixing bolts-Trh 3/8, Sdh 9/16 Free and lift away gearbox with clutch hsg Wash gearbox complete-cleaning area

Fill gearbox with oil Saab-Scania - Service

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			73-01-02	1	47170
Gearbox: remove complete (incremove power unit) Remove power unit, see 20174 Drain gearbox oil—Trh 3/8, ves Remove starter motor—Wsm Remove plate at flywheel—Ppo Remove fixing bolts—Trh 3/8, Free and lift awah gearbox wit Wash gearbox complete—cleans Gearbox: install complete (inclinstall power unit) Remove-install release brg and 784220, H Clean mating surface between grag Fill up and assemble gearbox c Sdh 9/16 Fit starter motor—Wsm Fill gearbox with oil—Trh 3/8,	(7–) isel , Sdh 15 h clutch hsg ing area 5–6 replace clutch brg ingearbox complete accomplete to engine— Wadj, EP 80	and engine—	Remove primary serious Remove layshaft for Remove gearbox layshaft for Clean mating surfactions and clean mating surfactions and clean mating surfactions and clean mating surfactions and clean mating and clean mating and fit gearbox has to Wash, blow and clean and fit pinion oil and fit pinion oil and fit pinion oil and fit primare 109 Remove retaining drift, Posh Fit layshaft 784' Align gear, fit key Fit retaining ring Check synchroniz	shaft rear brg— front brg—h, dr er nsg from fixture aces to cover, e ace on cover ating surface of ry gearbox hsg- ofixture neck all remove neck all shafts a shaft, rear brg it front bearing y shaft, rear brg ring from bear 109, 784124 r, friction whee for layshaft bear er posn	784121 ift end cover and clutch hsg—Cleaning area and components—cleaning and nut—784122, Moc —786134 g and nut—784114, —104, and and key from gear—H, l washer and nut—H, drift aring
Install power unit, see 20176 (Spares: clutch shaft seal, oil Gearbox: install complete (inclinstall power unit) Remove-install release brg and 784220, H Clean mating surface—Rag Offer up gearbox with engine t Fit fixing bolts—Was 15	7 – replace clutch brg :	47172 seal—	—feeler gauge Posn new gasket o Refit oil thrower Posn selector fork	ncl shims) arings are presse between laygear on end cover as and torque-tight aft posn ds,—SCs, Wco S	d in—Hp and primary shaft bearing en bolts—Tanr, Sdh 1/2, Ttg
Fit plate at flywheel—Ppo, SCo Fit starter motor—Wco 14 Fill gearbox with oil—EP 80, T Install power unit in car, see 20 Spares: clutch shaft seal, oil Gearbox: dismantle, check and assemble (excl diff and rear wh	rh 3/8, Wadj 0176 (7—) 5—	47173	Blow clean and che Posn oil deflector Measure crownwh Apply sealing concompound Remove gearbox Apply sealing cor Check gear posn-Remove old/insta	neck diff with k and fit diff—To neel backlash npound and fit from fixture npound and fit drift Il new drivesha	earings tg, Sdh 9/16 speedometer pinion—sealin
Arrange work area Remove inner UJs/drivers—Was Remove clutch hsg from gearbo Blow clean round gearbox cove Tbr, Hp Mount gearbox in fixture—784 Remove speedometer pinion— Measure crownwheel backlash— Remove diff and oil deflector— Measure and note pinion shaft Remove needle begings and fr	s 11/16, Was 1/2, Wox—Was 1/2, Sdh 1 er and remove—Cag 100, Trh 3/8, Sdh Frh 1/2, Sdh 33 -784062, 784097, -Trh 3/8, Sdh 9/16 posn—784062, 784	/2, Tbr, SCs ,, Sdh 7/16, 1/2, Tebm marking dye , Hp 1146	Refit inner UJs/d Arrange work are	npound and fit rivers a (clean fixture	clutch hsg to gearbox) gasket, driveshaft seals

Remove needle bearings and freewheel complete-879030 Remove end cover and selector rods-Trh 3/8, Sdh 1/2, H, drift 784069 Remove layshaft nut and friction wheel-784094/786142,

Thr, H, SCch Remove primary shaft and nut-H, SCch, Tah, Sdh 1 1/16 Remove pinion shaft nut-H, SCch, Tah, Sdh 1 1/16

Remove layshaft complete-784125, 786136

Remove pirmary shaft complete-784104

Remove pinion shaft rear brg-784115, 786052, Wadj, Trh 3/8, Sdh 9/16

Remove primary shaft complete-784121

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Edition Replaces page Date Page 73-01-02 1 47175 Fit clutch bearing and freewheel lock to housing Gearbox: dismantle, check and collect 47175 parts for exchange gearbox Unpack new bearing Arrange work area Spares: clutch shaft, bearing Remove inner UJs/drivers-Was 11/16, Was 1/2, Wadj Remove clutch hsg from gearbox-Was 1/2, Sdh 1/2, Tebl, 47183 Tbr, drift, H, Hp Gearbox: lapping synch rings with 5-Blow clean round gearbox cover and remove-Cag, Sdh 7/16, carborundum, each Tebl, Tbr, Was 1/2 Unpack synch ring, arrange carborundum in container Mount gearbox in fixture-784100 Lap synch ring, (incl washing, blowing)—Carborundum Remove speedometer pinion-Tah, Sdh 33 Measure crownwheel backlash-784062, -097, marking dye Remove diff-Sdh 9/16, Tah, Tbr, Hp Gearbox: layshaft friction wheel 5-47193 Measure pinion shaft posn-784062, -146 replace (extra to remove-install gearbox) Remove needle bearings and freewheel complete-879030 Remove end cover and selector rods-Sdh 1/2, Tbr, drift, Remove inner UJs/drivers Remove clutch housing from gearbox-Tbr, Tebl, sdh 1/2, Hk 784069 Remove layshaft nut, gear and friction washer-784094, Was 1/2, H, Hp, drift 786132, Trh, H, SCch Remove diff-Tbr, Tah, Sdh 9/16, Hp Remove primary shaft nut-Sdh 1 1/16, 786132, Trh, H Blow clean around gearbox cover and remove-Cag, Tbr, Remove pinion shaft nut-Sdh 1 1/4, 786132, Trh, H Tebl, Sdh 7/16, Was 1/2 Remove layshaft complete-784125, 78136 Remove layshaft nut, washer and friction wheel-784094/ Remove primary shaft complete-784104 786132, Trh 1/2, H, SCch Remove pinion shaft rear brg-784115, 786052, Wadj, Trh Align wheel, fit wheel, washer and nut-H, drift 3/8, Sdh 9/16 Torque-tighten and lock layshaft nut-Ttg Remove pinion shaft complete-784121 Fit diff Remove primary shaft rear bearing from housing-H, drift Clean mating surfaces, wash cover-cleaning area, Cag Remove layshaft front bearing from housing-H, drift Apply sealing compound and fit cover-sealing compound After discussion with foreman (secondary time) gearbox is Check gear posn-drift found to be not worth repairing; all parts are then collected Wash, blow, dry clutch housing together for despatch to exchange gearbox reconditioning Clean mating surface (to gearbox) Fit pinion shaft, rear brg and nut-784 122 Apply sealing compound and fit clutch hsg to gearbox Fit layshaft front bearing-786134 Change both driveshaft seals-784033, -30, slide gauge, Fit primary shaft, brg and nut-784114, -106, -109 grease, H Posn layshaft gear and fit layshaft-H, drift, 784109, -124, SCs Fit inner UJs/drivers Align gear, fit key, friction wheel, washers and nut-H, drift Spares: locking strips, friction wheel, driveshaft seals Fit shaft bearing locking ring Fit end cover Fit complete free wheel and needle bearing Gearbox: cover and/or selector 5-47198 Fit diff to gearbox lever shaft replace (power unit out) Fit speedometer pinion Remove gearbox from fixture Clean around gearbox cover and remove-Cag Fit cover Drill for selector lever spigot and pin-Mpd, drill bit Fit clutch hsg to gearbox Drive out spigot and pin-Psc, SCs Fit inner UJs/drivers Remove shaft and sleeve from cover Arrange work area (clean fixture) Clean mating surfaces and wash cover-cleaning area, Cag Clean mating surfaces on gearbox housing Fit roll pin to selector lever-hp Gearbox: cover and/or selector lever 5-47179 Posn shaft and selector lever in cover, rivet pin shaft replace (cover off) Fit plastic plug and sleeve Drill for selector lever spigot and pin-power drill, drill bit Fit spigot for selector lever and rivet-H Apply sealing compound and fit cover-sealing compound Drive out spigot and pin-Psc, SCs Remove shaft and sleeve from cover Check gear posn Fit roll pin to selector lever fork-Hp Spares: cover, selector lever shaft Posn shaft and selector lever in cover, rivet pin Fit plastic plug and sleeve Fit spigot for selector lever and rivet-H Spares: cover, selector lever shaft Gearbox: clutch shaft and/or bearing 5-47181 replace (clutch housing off)

Remove clutch shaft and freewheel lock-Pcb, Wco 1/2, Pcsh

Remove bearing from shaft-H, drift

Fit new bearing to shaft

Repair Work - Standard Times SAAB 95/96

	vision		Replaces pag	е		Date	Edition		Page	
						Jan. 1973	1		47311 - 47345	
Oper, No	Modelcode	Effective time	Secondary time	Lost time allow- ance	Schedule time	Oper, No	Modelcode	Effective time	ve Secondary Lost time time allow- ance	Schedule time
47311	5-	23		2	25					
47312	5-	228	18	25	271					
47313	5-	149	6	16	171					
47314	5-6	301	26	33	360					
47314	7-	354	26	38	418					
47315	5-	46	3	5	54					
47316	5→	69	12	8	89					
47317	5-	17	3	2	22					
47319	5-	73	1	7	81					
47321	5-	5		1	6					
47329	5-	26	1	3	30					
47331	5-	86	6	9	101					
47333	5-	31	1	3	35					
47335	5-	65	2	7	74					
	5-	21	3	2	26					

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Date Edition Replaces page Page 73-01-02 47311 1 Gearbox: backlash adjust (crownwheel) 47311

at gearbox before 10000 km (diff off)

Remove diff 2 x-Trh 3/8, Sdh 9/16, Hp Re-shim and fit diff 2 x-Ttg Check backlash 2 x

Spares: shims as nec

Gearbox: rear pinion shaft brg replace 47312 (gearbox complete off)

Arrange work area

Remove inner UJs/drivers-Was 11/16, Was 1/2, Wadj, H, drift Remove clutch hsg from gearbox-Was 1/2, Sdh 1/2, Tbr, SCs Blow clean round gearbox cover and remove-Cag, Sdh 7/16,

Mount gearbox in fixture-784100, Trh 3/8, Sdh 1/2, Tebm Remove speedometer pinion-Trh 1/2, Sdh 33 Measure crownwheel backlash-784062, 784097, marking dye,

Remove diff-Trh 3/8, Sdh 9/16, Hp

Measure and note pinion shaft posn-784062, 784146 Remove end cover-Trh 3/8, Sdh 1/2, H, drift, 784069 Remove pinion shaft nut and rear bearing-H, SCch, Tah, Sdh 1 1/16, 784115, 786052

Clean mating surfaces to cover, end cover and clutch housing—Ck Clean mating surface on cover

Wash, blow and dry clutch housing-cleaning area

Unpack new bearing

Fit bearing and nut

Clean end cover (incl shims)

Posn new gasket on end cover

Shim-up end cover at pinion shaft-784237,-062

Fit end cover and torque-tighten bolts-Tanr, Sdh 1/2, Ttg

Adjust selector rods-SCs, Wco 9/16

Measure pinion shaft posn, backlash

Remove end cover, nut and bearing 2 x

Posn shims, fit bearing and nut 2 x

Fit end cover, 2 x

Measure pinion shaft posn and note backlash 2 x

Fit diff

Measure crownwheel backlash

Apply sealing compound and fit speedometer pinion-sealing compound

Remove gearbox from fixture

Apply sealing compound and fit cover

Check gear posn-drift

Clean mating surface

Fit new driveshaft seals-784033, -30, H, slide gauge, grease Apply sealing compound and assembly clutch hsg to gearbox

Fit inner UJs/drivers

Arrange work area (clean fixture)

Spares: End cover gasket, driveshaft seals, ball bearing, locking strips, shims as nec

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47317

47319

47321

47329

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Replaces page Date Edition Page 47313 73-01-02 Remove gearbox from fixture 47313 Gearbox: crownwheel and pinion replace 5-Wash, blow and dry clutch hsg-cleaning area, Cag (extra to dismantle gearbox) (47173) Clean mating surfaces on clutch hsg and gearbox-Ck Remove crownwheel from removed diff hsg-SCch, Was 1/2, H Remove driveshaft seals, fit new-784030, -33, H, slide Clean new crownwheel and pinion shaft to remove preservagauge grease tive-Ck, cleaning area Apply sealing compound and assemble clutch hsg to gearbox Fit crownwheel, pinion and shaft to diff housing-Ttg, Ppo, Fit inner UJs/drivers Arrange work area (clean fixture) Remove keys and bearings from old pinion shaft-Psc, Press, 784123 Oil and fit bearings, keys, to pinion shaft Pinion: front bearing and/or 4th speed Fit pinion shaft to gearbox (included in basic operation) gear set replace (extra to dismantle, check . . .) Check dimensions of end cover (pinion shaft)-784237, Remove keys 784062 Remove roller bearing and gears-784123, press Assemble gearbox and measure pinion shaft posn (included in Clean gear set/unpack new bearing-Ck, SCs basic operation) Fit bearing and gears Remove end cover, nut and bearing 2 x-784115, 786052 Fit keys Re-shim and fit bearing and nut 2 x-784122, assorted shims Fit end cover 2 x-Ttg Measure pinion shaft posn 2 x-784062, 784146 Gearbox: rear pinion shaft brg replace Fit diff and measure backlash (included in basic operation) (gearbox dismantled) Remove diff 2 x-Trh, Sdh 9/16, Hp Re-shim and fit diff 2 x -Ttg Unpack new bearing-SCs Measure backlash at four points Shim-up end cover at pinion shaft-784237, 784062 Remove end cover, nut and bearing 2 x-784115, 768052 Posn shims, fit bearing and nut 2 x-784122 Diff: remove-install (incl remove-5-6 47314 Fit end cover install power unit) Measure pinion shaft posn, note backlash 2 x-Ttg Remove-install gearbox complete, see 47132 (5-6) Spares: ball bearing, shims as nec, washer Remove-install diff complete, see 47316 (5-) Gearbox: rear pinion shaft 5-Diff: remove-install (incl remove-47314 bearing replace in conj with pinion shaft replace install power unit) (gear box) dismantled Remove-install gearbox complete, see 47132 (7–) Unpack new bearing-SCs Remove-install diff complete, see 47316 (5-) Shim-up end cover-784237, 784062 Spares: ball bearing, shims as nec Diff: bearings replace (diff out) 47315 Remove both side bearings-Extractor 5-Diff: gears and pinions replace Unpack new bearings (diff out) Fit both bearings-Press, arbor Determine shim combination Remove locking on 4 retaining bolts-SCch, H, Tah, Sdh 1/2 Fit diff and check backlash (included in basic operation) Remove 4 retaining bolts-Was 1/2 Remove diff 2 x-Trh, Sdh 9/16, Hp Remove shaft, pinions and gears Re-shim and fit diff 2 x-Ttg Wash and blow housing with bearings and crownwheel-Check backlash at four points 2 x-784062, -097 cleaning area Visually check all parts Spares: ball bearings, LH and RH, shims as nec Fit gears, pinions and shaft Fit locking strips and 4 retaining bolts-Ttg Clean pinions and gears to remove preservative—Ck Diff: remove-install (gearbox 47316 complete off) Spares: diff pinions, diff gears, locking strips Remove inner UJs/drivers-Was 11/16, 1/2, Wadj, H, drift Remove clutch housing from gearbox—Was 1/2, Tbr, Sdh 1/2, Mount gearbox in fixture-784100, Trh 3/8, Tebm, Sdh 1//2

Measure crownwheel backlash-784062, -97, marking dye compound

Remove speedometer pinion-Trh 1/2, Sdh 33

Apply sealing compound and fit speedometer pinion—sealing

Remove diff-Trh 3/8, Sdh 9/16, Hp Blow clean and check diff with bearing-Cag

Fit diff to gearbox-Ttg Measure crownwheel backlash -

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	Replaces page	73-01-02	Edition	Page 47331		
	<u> </u>	73-01-02	1	4/331		
Diff: housing replace (diff out	5- 47331					
Remove both side bearings—E Remove four crownwheel boli						
Remove shaft, pinions and gea						
Remove crownwheel-H, SCch	n, Tah, Sdh 1/2					
Check removed parts Wash and blow new housing—	cleaning area					
Fit crownwheel, diff pinions a),				
Shd 1/2 Fit both bearings—Press, drift						
Determine shim combination						
Fit diff and measure backlash Remove diff 2 x—Trh, Sdh 9/)				
Re-shim and refit diff 2 x-Tt	g					
Check backlash at 4 points 2 :	x-784062, -097					
Spares: diff housing, locking s	trip, shims as nec	_				
Diff: housing replace (in conj	with 5– 47333					
crownwheel and pinion replace						
Remove diff bearing—Extract						
Wash, blow and visually check cleaning area	bearings and diff pinions—					
Clean new housing						
Fit both diff bearings						
Spares: diff housing						
Gearbox: crownwheel and pin	ion 5– 47335					
replace (in conj with gearbox						
Remove crownwheel from ren	moved diff housing—SCch, W	as				
1/2, H Clean new crownwheel and pi	nion shaft to remove preserv	vative				
-SCs, cleaning area						
Fit crownwheel, diff pinions a Sdh 1/2	and gears and shaft—Itg, Ppo	0,				
Fit diff and measure backlash) .				
Remove diff 2 x—Trh 3/8, Sd Re-shim and refit diff 2 x—Tt						
Check backlash at 4 points-7						
Diff: bearings replace (in conj crownwheel and pinion replace						
Remove both side bearings-e	xtractor					8
Unpack new bearings Fit both bearings—Press, drift						
Spares: bearings, shims as nec						

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

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Oper, No	Modelcode	Effective	Secondar	y Lost time allow- ance	Schedule time	Oper. No	Modelcode	Effective time			Schedule time	
47521	5	31	8	4	43	47575	5	5		1	6	
47521	6-	24	5	3	32	47575	6-	13	1	1	15	
47522	5	44	8	5	57	47576	5	32	10	4	46	
47523	5-	4	4	1	9	47576	6	36	9	5	50	
47524	5	54	12	7	73	47576	7–	38	11	5	54	
47524	6-	48	9	6	63	47577	5-	41	8	5	54	
47525	5-	11	4	2	17	47578	5	70	14	8	92	
47527	5	63	8	7	78	47578	6	76	14	9	99	
47527	6-	48	5	5	58	47578	7–	78	14	9	101	
47534	5	106	12	12	130	47579	5	140	25	17	182	
47534	6-	96	9	10	116	47579	6	147	25	17	189	
47535	6-	8	3	1	12	47579	7–	150	27	18	195	
47539	6-	7	1	1	9	47580	5	64	10	7	81	
47541	5-	50	10	6	66	47580	6	72	10	8	90	
47543	5-	101	12	11	124	47580	7–	76	12	9	97	
47549	5	9	2	1	12	47581	6-	11	1	1	13	
47549	6-	17	2	2	21	47582	5	68	14	8	90	
47553	6-	15	3	2	20	47582	6	75	14	9	98	
47555	6-	4	1	1	6	47582	7-	78	14	9	103	
47556	6-	15	5	2	22	47583	6-	19	1	2	22	
47558	6-	27	5	3	35	47584	5	134	16	15	165	
47559	6-	6	4	1	11	47584	6	147	16	16	179	
47561	6-	12	4	2	18	47584	7-	153	18	17	188	
47569	5-	5		1	6	47586	5	61	12	7	80	
47571	5	20	4	2	26	47586	6	68	12	8	88	
47573	5-	17	4	2	23	47586	7-	71	14	9	94	
47574	5	36	14	5	55	47588	5	124	14	14	152	
47574	6	39	14	5	58	47588	6	137	14	15	166	
47574	7-	40	14	5	59	47588	7–	143	16	16	175	
						To this s	heet belong	6 sheets	of repair	work	descripti	

To be inserted in the file for REPAIR WORK DESCRIPTION

Saab Car Division Date Edition Replaces page Page 73-01-02 47521 47521 Universal joint, inner: remove-install, Grease new sealing ring-grease dismantle, clean, check and assemble (incl Fit new sealing ring-H, 784030-033, slide gauge sealing ring replace) 1 side (front axle assembly Spares: sealing ring lowered or off) Remove spring Remove centre bolt and UJ-Sdh 11/16, Was 1/2 Wadj 47524 Universal joint, inner: remove-install 5 Mount tool in vice-Special tool 784068 dismantle, clean, check and assemble Posn UJ on tool (incl sealing ring replace) 1 side Remove UJ-half retaining bolts-Sdh 11/16, Trh, SCs Raise and lower front of car-Ltr, Lj Separate UJ-halves Remove-install wheel-SCs, Tanr, Sdh 3/4, Tah Clean all parts-knife Free steering knuckle (tilt outwards) Clean retaining bolt threads Recond 1 UJ, see 47521 (5) Assemble UJ-g halves Fit shaft to UJ Tighten retaining bolts Oil splines-Moc Wipe clean and stick on flat washer-sealing compound Refit steering knuckle-H, Sdh 3/4, Trh, Tah Replace sealing ring in clutch hsg-SCs, grease, H.784030, Slide gauge Fit UJ to gearbox and tighten 47524 Universal joint, inner: remove-install Fit spring clean and grease inner driver (incl sealing Spares: rubber ring, spring, felt ring, outer driver, ring replace) 1 side O-ring, flat washer, sealing ring, driveshaft (if nec) Raise and lower front of car-Lj, Ltr inner cover (if nec) outer (if nec). Remove-install wheel Clean around rubber boot Remove clip—Psc 47521 Universal joint, inner: remove-install, Free steering knuckle (tilt outwards)—Tah, Trh, Sdh 3/4, clean and grease inner driver (incl sealing ring H, SCch replace) 1 side (front axle assembly lowered or off) Knock driver free-H, drift Wipe rubber boot and drivershaft Extract driver from gearbox Knock driver free-H, drift Wipe rubber boot and driver shaft Extract driver from gearbox Clean driver—cleaning area Clean driver-cleaning area, Cag Replace sealing ring and put in grease—Saab special grease Replace stuffing box and put in grease—Saab special grease Put grease in driver—Saab special grease Put grease in driver Fit driver to gearbox Fit driver to gearbox Fit driveshaft to driver Refit steering knuckle Spares: sealing ring Spares: locking strips, metal straps, clip Universal joint, inner: sealing ring 5 47522 in clutch hsg replace 1 Raise/lower front of car-Lj, Ltr Remove-install wheel-Tanr, Sdh 3/4, SCs Free steering knuckle at upper ball joint-SCch, H, Sdh 3/4, Tah, Trh Remove spring Remove retaining bolt and UJ Remove sealing ring from gearbox-SCs Grease new sealing ring-grease Fit new sealing ring-H, 784030-033, slide gauge Clean and apply adhesive to central screw washersealing compound Fit UJ to gearbox Fit spring Grease splines

Service

Universal joint, inner, sealing ring in clutch hsg replace (inner UJ off)

Fit inner driveshaft to inner UJ

Top up with oil-transmission oil Spares: sealing ring, locking washer

Fit upper ball joint Check oil level

> 5-47523

Remove sealing ring from gearbox-SCs

Spares: rubber boot complete

Repair Work Description SAAB 95/96

	Saab Car Division			nepali Work L	rescription	
Ì	V	Replaces page	1	Date	Edition	
				73-01-02	1	
	Universal joint, inner: sealing riclutch housing replace, per side assembly lowered or off) Remove spring—Was 1/2, Was Remove UJ Clean and remove sealing ring—Grease new sealing ring—grease Fit new sealing ring—H, 78403 Clean and apply adhesive to flat Fit UJ to gearbox Fit spring	47525	Universal joint, our clean, check, assem (replace UJ comple assembly off) Remove upper UJ Press outer UJ from Remove seals from Remove outer UJ Clean all parts (wa NB. On cleaning, defit new seals—H, definition of the seals—	rubber boot m steering kn steering kn from inner s sh and blow lismantle ou		
	Universal joint, inner: remove-idismantle, clean check and assessealing ring replace) 2 sides (frollowered or off) Recond 2, see 47521 (5)	emble (incl	47527	Grease outer UJ-S Fit outer UJ to ste Fit lock ring and sl Fit clip to outer be Wipe boot-rag Spares: sealing ring (outer UJ complet	Saab special ering knuck haft to UJ— pot—Psc, Pp gs, lock ring,	
	Transfer tool to opposite side					
	Universal joint, inner: remove-iclean and grease inner driver (ireplace) 2 sides (front axle asseor off)	ncl sealing ring	47527	Universal joint, ou check, assemble ar 2 sides (front axle See 47541 doublin	nd grease (re assembly of	
	See 47521 (6) doubling operat applicable Transfer tools to opposite side		re	Universal joint, ou and 47543 for rep rubber boot, per si	lacement of	
	Universal joint, inner: remove-i dismantle, clean check and asse sealing ring replace) 2 sides		47534	Remove outer rub Unpack and clean Fit rubber boot to	new shaft ar	
	For 1 side see 47524 (5)			Spares: rubber boo	ot complete,	
Schweden	Universal joint, inner: remove-i clean and grease inner driver (irring replace) 2 sides See 47524 (6-) doubling operations applies blooming to the company of the company	install, 6— ncl sealing	47534	Universal joint, ou and 47543 for rep and rubber boot, p Remove-install, gre special grease Remove outer rub	lacement of per side ease, needle	
eden	where applicable Transfer tools to opposite side			Remove inner rub		
Service Department-Kundendlenstabtellung - Nyköping - Sweden-Schweden	Universal joint, inner: (needle l type) needles in inner UJ beari install, wash and grease, per be	ng remove-	47535	Clean new driveshaft Fit and clip inner rubber be Fit and clip outer rubber be Spares: rubber boot comple		
ienstabteilt	Clean (wash, blow, dry) caps a Fit needles to caps, fill with gr					
t-Kundend	Universal joint, inner: rubber b		47539			
- Service Departmen	Remove-install needle bearing Remove inner boot—Psc, SCs Wipe driveshaft—rag Fit (stretch over)new boot Fit clip to inner boot—Psc, Ppr					
	(1021 - 100					

Page 47525 47541 5tle, ease front axle

> t clip-Psc knuckle-Press nuckle-drift, H, SCs shaft-H, 784202 v dry)-cleaning area, Cag iter UJ and visually check. grease cle-Press -Нр, 784161 00

, metal strap, clip

47543 tle, clean, 5eplace UJ complete)

allowances where applicable

o 47541 5 47549 f driveshaft and

om shaft-Psc and rubber boot Ppo

, inner driveshaft complete

o 47541 6-47549 f driveshaft

e roller bearing caps—Saab

om shaft-Psc om shaft-Psc t-Psc, Ppn

e, inner driveshaft complete

Edition

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Universal joint, inner: needle bearing 6— 47553 caps remove-install, clean and grease per side	Universal joint check and asse
(front axle assembly lowered or off) Remove and clean (wash, blow, dry) caps and needles— cleaning area, Cag Fit needles to caps, fill with grease Refit caps	Mount tool in Position UJ or Remove UJ-ha Separate UJ-ha Clean all parts
Universal joint, inner: needle bearing 6— 47555 caps replace, per side (front axle assembly lowered or off)	Clean retaining Assemble UJ-h Tighten retaining Spares: rubber
Remove-install caps Unpack new caps Grease caps—Saab special grease Spares: needle bearing caps	Universal joint and 47543 for
Universal joint, inner: filling inner 6— 47556 driver with grease, 1 side (in car)	Remove bearing Wash and visua Grease bearing
Raise and lower front of car—Lj, Ltr Remove clip and take off rubber boot—Psc, Ppn Fit grease injector to grease gun—grease injector Fill driver with grease, insert injector at several points,	Spares: bearing
wipe off excess—Saab special grease, rag Remove grease injector, wipe off Check and refit rubber boot, clip and boot, wipe off—Psc, Ppn, rag	Front axle asse 1 side Raise front of Remove wheel
Universal joint, inner: filling inner 6— 47558 driver with grease, 2 sides See 47556 (6—) doubling operation allowances where applicable Transfer tools and walk round to other side	Remove brake Remove backp Suspend backp Free upper bal Free lower bal Remove steeri Scrape clean b
Universal joint, inner: sleeve remove- 6— 47559 install (replace) 1 (inner driver off)	Brush clean fix Clean (dress) k Clean steering Wash and blov
Remove sleeve from inner driver—drift, 839115, Press Turn sleeve 90 ⁰ Fit sleeve to inner driver	A-
Universal joint, inner: sleeve 6— 47561 remove-install (replace) 2 (inner driver off)	
See 47559 (6-) doubling operation allowance where applicable	
Spares: sleeve if nec	-
Universal joint, outer: extra to 47541 5— 47569 and 47543 for replacement of outer rubber boot, per side	
Remove outer rubber boot clip—Psc Remove rubber boot Fit new rubber boot Fit rubber boot clip—Psc, Ppo	
Spares: rubber boot complete	

iversal joint, inner: dismantle, clean 47571 eck and assemble, each, (UJ off)

Page

47553

ount tool in vice-special tool 784068, vice sition UJ on tool move UJ-half retaining bots-Sdk 11/16, Trh, SCs

parate UJ-halves ean all parts-Ck, slide gauge

ean retaining bolt threads semble UJ-halves hten retaining bolts

ares: rubber ring, felt ring, outer driver, driveshaft (if nec) ner cover (if nec), outer cover (if nec)

47573 iversal joint, outer: extra to 47541 d 47543 for remove-install, clean and ase (replace) bearing

move bearing from steering knuckle-press sh and visually check bearing-cleaning area, Cag ease bearing-Saab special grease bearing to steering knuckle-784075-030, Press

47574 ont axle assembly complete: remove ide

ise front of car-Lj, Ltr move wheel-Tanr, Sdh 3/4, SCs move brake drum-Tanr, Sdh 33, Psc, 784002, Mcb move backplate-Wco 1/2, Sdh 1/2, Tanr, Sre spend backplate-hook ee upper ball joint—Tah, Sdh 3/4, Trh 1/2, H, SCch ee lower ball joint—Tanr, Sdh 11/16, Sre, Wco 5/8 move steering knuckle from car-H rape clean backplate and mating surfaces—Ck, Cwb ush clean fixing bolt threads—Cwb ean (dress) ball joint shank-emery cloth ean steering knuckle and shaft—Ck, Cwb, Cag ash and blow steering knuckle-cleaning area

Front axle assembly complete: remove 1 6 47574

Raise front of car—Lj, Ltr
Remove wheel—Tanr, Sdh 3/4, SCs
Clean around rubber boot (inner UJ)—Cag
Remove clip—Psc, SCs
Remove brake drum—Tanr, Sdh 33, Ppn, Mcb, 784002
Remove backplate—Wco 1/2, Sdh 1/2, Sre, Tanr
Suspend backplate—hook
Free upper ball joints (2 bolts)—Tah, Trh, Sdh, H, SCch
Free lower ball joint—Tanr, Sdh 11/16, Sre, Wco 5/8

Separate inner UJ and fit protective cover—783846, 732373 Remove steering knuckle from car—H Scrape clean steering knuckle—Ck, Cwb, Cag Brush clean fixing bolt threads—Cwb Clean (dress) ball joint shank—emery cloth

Wash and blow steering knuckle-Cag, cleaning area

Front axle assembly complete: 1 side 7- 47574

Raise front of car—Lj, Ltr
Remove wheel—Tanr, Sdh 3/4, SCs
Clean around rubber boot (inner UJ)—Cag
Remove clip—Psc, SCs
Remove brake pads—Psc
Remove and suspend brake housing—H, SCch, Was 11/16,

Remove and suspend brake housing—H, SCch, Was 11/16 hook

Remove split pip and put. Pse Sdb 22. Tapr

Remove split pin and nut—Psc, Sdh 33, Tanr Fit extractor—784002, Sdh 3/4, Tanr Remove hub and brake disc—Sdh 3/4, Tah, Mcb, H, Remove extractor

Free lower ball joint—Tanr, Sdh 11/16, Sre, Wco 5/8 Free upper ball joint (2 bolts)—Tah, Trh 1/2, Sdh 3/4, SCch, H

Separate inner UJ and fit protective cover—783846, 732373 Remove steering knuckle from car—H Scrape clean steering knuckle—Ck, Cwb, Cag Brush clean fixing bolt threads—Cwb Clean (dress) ball joint shank—emery cloth Wash and blow steering knuckle—cleaning area, Cag

Universal joint, outer: rubber boot replace 5 47575 (fit over driveshaft, not replacement of grease in outer UJ) per side (front axle assembly off)

Remove outer boot from shaft Fit and clip new boot

Spares: rubber boot complete

Universal joint, outer: rubber boot replace 6— 47575 (fit over driveshaft, not replacement of grease in outer UJ) per side (front axle assembly off)

Remove-install, grease, needle bearing caps—Saab special grease

Remove inner rubber boot from shaft—Psc Remove outer rubber boot from shaft—Psc Fit outer rubber boot over shaft, fit clip—Psc, Ppn Fit inner rubber boot over shaft, fit clip—Psc, Ppn Wipe off rubber boot and hands—rag

Spares: rubber boot complete

Front axle assembly complete: install 1 side

Grease inner driveshaft splines—grease
Posn steering knuckle in car
Mount steering knuckle at lower ball joint—Trh, Sdh 11/16,
Wco 5/8, Sre

47576

Fit driveshaft to inner ball joint (assistant)

Fit steering knuckle at upper ball joint and lock bolt-

Trh 1/2, Sdh 3/4, Tah, H

Fit backplate—Trh, Sdh 1/2, Wco 1/2, Tebs Fit brake drum—Tanr, Sdh 33, Psc, Mcb, Ttg Adjust brake shoes

Fit wheel—Tanr, Sdh 3/4, Tah Lower front of car—Lj

Spares: locking strip, nut

Front axle assembly complete: 6 47576 install 1 side

Posn steering knuckle in car Mount steering knuckle at lower ball joint—Trh, Sdh 11/16, Wco 5/8, Sre

Remove protective cover and posn driveshaft in driver Fit steering knuckle at upper ball joint and lock bolt— Trh 1/2, Sdh 3/4, Tah, H

Fit backplate—Trh, Sdh 1/2, Wco 1/2, Tebs
Fit brake drum—Tanr, Sdh 33, Psc, Mcb, Ttg
Adjust brake shoes
Fit wheel—Tanr, Tah, Sdh 3/4
Lower front of car—Lj

Fit clip to inner boot—Ppn, Psc, SCs

Spares: locking strip, nut

Front axle assembly complete: install 7— 47576 1 side

Posn steering knuckle in car Remove protective cover and posn driveshaft in driver Fit bolt to lower ball joint—Sdh 11/16, Trh, Sre, Wco 5/8 Fit steering knuckle at upper ball joint and lock bolt—Sdh 3/4, Trh 1/2, Tah, H

Fit hub and brake disc-Sdh 33, Tah, Mcb, Ttg

Fit nut and split pin-Psc, H

Fit brake housing-H, Ppo, Trh, Sdh 11/16, Tebm

Wash brake disc-Trich Fit brake pads-Psc, SCs

Fit rubber boot to inner UJ-Ppn, Pcs, SCs

Fit wheel-Tanr, Tah, Sdh 3/4

Lower front of car-Lj

Spares: locking strip and nut

Service Department-Kundendienstabteilung - Nyköping - Sweden-Schwed

Repair Work Description SAAB 95/96

			70 01 00	Edition	Page
			73-01-02		47577
Universal joint, outer: rubber b replace (incl replacing grease in (front axle assembly off)		47577	install 2 sides		7 47580
Remove clip from outer UJ rule Remove outer UJ from steering			See 4/5/6 co where applica	de 7— doubling ope ble	eration allowances
Remove UJ from driveshaft—7. Wash outer UJ—cleaning area, Wash driveshaft—cleaning area Grease outer UJ—Saab special greplace boot—Psc, Ppo	8 4202 , Hf Cag			t, inner: rubber boo ing knuckle tilted o	
Fit driveshaft to UJ-784161 Fit outer UJ to steering knuckl Fit boot to steering knuckle-P			Remove clip Remove boot Unpack new l	, wipe hands-Ck	
Spares: rubber boot, clip	sc, i po		Fit new boot Posn and fit o	over crosspiece—SC lip—Psc, Ppn	Os .
Front axle assembly complete: remove 2 sides	5	47578	Front axle ass	sembly complete:	5 47582
See 47574 code 5 doubling operapplicable	eration allowance	es where	See 47574 an	d 47576 code 5	
Transfer tools to opposite side			Front axle ass	sembly complete:	6 47582
Front axle assembly complete: remove 2 sides	6	47578	See 47574 an	d 47576 code 6	
See 47574 code 6 doubling operapplicable Transfer tools to opposite side	eration allowance	es where	Front axle as	sembly complete:	7 47582
Event cule count le count le	7	47570	See 47574 an	d 47575 code 7—	
Front axle assembly complete: remove 2 sides		47578		t, inner: rubber	6- 47583
See 47574 code 7— doubling o where applicable Transfer tools to opposite side	peration allowar	nces	tilted outward		
Universal joint, outer: remove-	install 5—	47579	Unpack new I	, wipe hands—Ck boot	
front axle assembly complete, install, clean and grease outer l replace outer rubber boot 1 sid	JJ and bearing,		Fit new boot Posn and fit o	over crosspiece elipPsc, Ppn	
Remove-install front axle assen Dismantle, clean, grease outer	nbly complete, s UJ, see 47541		Front axle co	mplete: remove-	5 47584
Remove-install bearing, clean a see 47573 Replace outer rubber boot, see		ce)	allowances wi	d 47576 code 5 do here applicable s to opposite side	ubling operation
Front axle assembly complete: 2 sides	install 5	47580	Front axle as	sembly complete:	6 47584
See 47576 code 5 doubling op where applicable Transfer tools to opposite side	eration allowance	es	See 47574 an allowances w	d 47576 code 6 do here applicable s to opposite side	ubling operation
Front axle assembly complete: 2 sides	install 6	47580	-	sembly complete:	7- 47584
See 47576 code 6 doubling op where applicable Transfer tools to opposite side	eration allowanc	es	See 47574 an	d 47576 code 7– c here applicable	loubling operation
			ranster tool	s to opposite side	

	Replaces pa	ge		Date	Edition	Page
				73-01-02	1	47586
t axle assembly complete Il 1 side (wheel off)	remove-	5	47586			
move, see 47574 (5) tall, see 47576 (5)				_		
nt axle assembly complete all 1 side (wheel off)	: remove-	6	47586			
move, see 47574 (6) tall, see 47576 (6)			8855			
nt axle assembly complete ove-install 1 side (wheel of		7–	47586			
move, see 47574 (7—) tall, see 47576 (7—)						
nt axle assembly complete ove-install 2 sides (wheels		5	47588			
move-install 1 side see 4758 ansfer tools to opposite side				_		
ont axle assembly complete nove-install 2 sides (wheels		6	47588			
r remove-install 1 side see 4 ansfer tools to opposite side				_		
ont axle assembly complete nove-install 2 sies (wheels o		7–	47588			4
or remove-install see 47586 (ansfer tools to opposite side						

Repair Work - Standard Times SAAB 95/96

		eplaces page			Date		Edition				
					Jan. 197	3	1		47702 - 4	17776	
Modelcode	Effective time	Secondary time	Lost time allow- ance	Schedule time	Oper. No	Мо	delcode				Schedule time
5-	44	4	5	53							
5-	44	8	5	57							
5-	304	13	32	349							
5–	7	1	1	9							
5-	20	2	2	24							
5–	31	3	3	37							
5–	6	2	1	9							
5-	16	2	2	20							
5-	23	2	3	28							
5-	21	2	2	25							
5–	34	3	4	41							
5-	37	3	4	44							
5-	90	8	10	108							
5-	98	11	11	120							
eet belong :	2 sheets	of repair	work	description							
	5- 5- 5- 5- 5- 5- 5- 5- 5- 5- 5- 5- 5- 5	5- 44 5- 304 5- 7 5- 20 5- 31 5- 6 5- 16 5- 23 5- 21 5- 34 5- 37 5- 90 5- 98	time time 5- 44 4 5- 44 8 5- 304 13 5- 7 1 5- 20 2 5- 31 3 5- 6 2 5- 16 2 5- 23 2 5- 21 2 5- 34 3 5- 37 3 5- 90 8 5- 98 11	5- 44 4 5 5- 44 8 5 5- 304 13 32 5- 7 1 1 5- 20 2 2 5- 31 3 3 5- 6 2 1 5- 16 2 2 5- 23 2 3 5- 21 2 2 5- 34 3 4 5- 37 3 4 5- 90 8 10 5- 98 11 11	5- 44 4 5 53 5- 44 8 5 57 5- 304 13 32 349 5- 7 1 1 9 5- 20 2 2 24 5- 31 3 37 5- 6 2 1 9 5- 16 2 2 20 5- 23 2 3 28 5- 21 2 25 5- 34 3 4 41 5- 37 3 4 44 5- 90 8 10 108 5- 98 11 11 120	time time time allowance time allowance 5- 44 4 5 53 5- 44 8 5 57 5- 304 13 32 349 5- 7 1 1 9 5- 2 2 24 5- 31 3 37 5- 6 2 1 9 5- 16 2 2 20 5- 23 2 3 28 5- 21 2 25 5- 34 3 4 41 5- 37 3 4 44 5- 90 8 10 108	time time time allow ance time allow ance time allow ance 5- 44 4 5 53 5- 44 8 5 57 5- 304 13 32 349 5- 7 1 1 9 5- 20 2 24 5- 31 3 37 5- 6 2 1 9 5- 16 2 2 20 5- 23 2 3 28 5- 21 2 25 5- 34 3 4 41 5- 37 3 4 44 5- 90 8 10 108 5- 98 11 11 120	time time time allow-lance time allow-lance 5- 44 4 5 53 5- 44 8 5 57 5- 304 13 32 349 5- 7 1 1 9 5- 20 2 24 5- 31 3 37 5- 6 2 1 9 5- 16 2 2 20 5- 23 2 3 28 5- 21 2 25 5- 34 3 4 41 5- 37 3 4 44 5- 90 8 10 108 5- 98 11 11 120	5- 44 4 5 53 5- 44 8 5 57 5- 304 13 32 349 5- 7 1 1 9 5- 20 2 2 24 5- 31 3 37 37 5- 6 2 1 9 5- 16 2 2 20 5- 23 2 3 28 5- 21 2 25 5- 34 3 4 41 5- 37 3 4 44 5- 90 8 10 108 5- 98 11 11 120	5- 44 4 5 53 5- 44 8 5 57 5- 304 13 32 349 5- 7 1 1 9 5- 20 2 2 24 5- 31 3 37 37 5- 6 2 1 9 5- 16 2 2 20 5- 23 2 3 28 5- 21 2 2 25 5- 34 3 4 41 5- 37 3 4 44 5- 90 8 10 108 5- 98 11 11 120	5- 44 4 5 53 5- 44 8 5 57 5- 304 13 32 349 5- 7 1 1 9 5- 20 2 2 24 5- 31 3 3 37 5- 6 2 1 9 5- 16 2 2 20 5- 23 2 3 28 5- 21 2 2 25 5- 34 3 4 41 5- 37 3 4 44 5- 90 8 10 108 5- 98 11 11 120

Replaces page Date Edition Page 73-01-02 47702 1

47702 Rear axle tube: centre bearing rubber 5bush replace (axle off)

Rear axle to and from vice-assistant Remove bolt through centre bearing bracket-Tanr, Sdh 1 1/8 Remove bush-Wco 20, Wadj, 784073

Fit new bush Refit bracket-Trh 1/2, Sdh 1 1/8

Spares: bush

Rear axle: side link and/or bearing replace 5-47704

Jack up rear of car-Lj, Ltr

Raise seat cushion and move seat forward

Remove side link nuts (in car)-Tanr, Sdh 11/16, Sre

Remove wheel-Tanr, Sdh 3/4, SCs

Remove side link from axle-Tanr, Sdh 9/16, Wco 9/16, Sre, H, drift

Remove bearing from side link-Tanr, Sdh 9/16, Wco 9/16, Sre, H, drift

Press out bushes (2)-press, 784076

Clean bearing surfaces-emery cloth

Press in bushes (2)

Fit bearing to side link 40[±] 20-Trh 3/8, Sdh 9/16, Wco 9/16 Install side link and start bolts-Trh 3/8, Sdh 9/16, Wco 9/16 Tighten side link nuts (in car)-Tanr, Sre, Sdh 11/16,

Was 11/16

Replace seat cushion and seat

Refit wheel

Lower rear of car

Tighten side link and axle-Trh 3/8, Sdh 9/16, Wco 9/16, undercar board

Spares: bushes, nuts, link

Rear axle: rear axle tube replace 5-47706

Raise and lower rear of car-Lj, Ltr Remove-install wheels-Tanr, Sdh 3/4, SCs

Faulty rear axle to and from vice

New rear axle tube to and from vice

Remove rear seat cushion

Remove rear muffler and pipe-Wco 7/16

Disconnect brake hoses from body-Wco 9/16, Wadj

Remove stop straps (at rear attachment points)-

Sdh 1/2, Trh, Tebl

Remove oil springs

Suspend axle on stop straps-Sdh 1/2, Trh, Tebl

Remove shock absorbers from axle-Wco 11/16

Remove brake line clips-Psc

Remove brake line from axle-SCch, H

Sdh 1/2, Trh

Remove stop straps-Sdh 1/2, Trh, Teb!

Remove rear axle from car

Clean and transfer all parts-special tool, 784002,

784129, 784076

Bleed braking system

Adjust road and parking brakes

Spares: rear axle, clip, nut

Rear axle: checking total toe-in of those wheels with Saab tool

5-47724

Roll car forward

Posn measuring tool and adjust-784001, chalk

Roll car forward

Posn measuring tool and take measurement

Note result-pen

Rear axle: checking total toe-in 47726 (track check) 1 side

Check and adjust tyre pressure (not spare)

Collect instrument-VLC Uniflex, HPA uni-Lux or similar

Mount instrument on wheel rim edge

Collect jack, raise rear of car-Lj

Compensate for rim skew

Lower rear of car, remove jack

Connect transformer to instruments and mains

Set up measuring scale in front of car-measuring scale

Check toe-in

Remove instrument and scales

Note reading-pen

Rear axle: checking total toe-in 47728 (track check) 2 sides

See 47726 code 5—doubling operation allowances where applicable

47730 Rear axle: checking wheelbase

Remove hub caps-Scs

Collect measuring equipment, set front wheels dead ahead-784001

Measure wheelbase LH side, note-pen, measuring tape

Measure wheelbase RH side, note

Put away equipment

Refit hub caps

Rear axle: checking camber, 1 side 5-

Check and adjust tyre pressure (not spare)

Collect instrument-VLC Uniflex, HPA Uni-Lux or similar

Mount instrument on wheel rim edge

Collect jack, raise rear of car-Lj

Compensate for rim skew

Lower rear of car, remove jack

Read off and note camber-pen

Put away measuring equipment

Remove support under axle (95 only)-Was 9/16

Remove centre bearing attachment of axle-Wco 1/2,

Remove body attachments of side links-Sdh 11/16, Was

Refit in reverse order-784073

Page

47734

Edition

73-01-02

Wco 7/16, Stu 9/16 Refit wheels-Tanr, Sdh 3/4

Lower rear of car

Spares: clip, nut

Saab Car Division Date Replaces page Rear axle: checking camber, 2 sides 47734 See 47732 code 5—doubling operation allowances where applicable Rear axle: checking toe-in (track) and 47736 5camber, 1 side See 47726 code 5-Read off and note camber Rear axle: checking toe-in (track) 5-47738 and camber, 2 sides See 47726 code 5-doubling operation allowances where applicable Read off and note camber Rear axle: checking tce-in (track), 47740 camber and total toe-in for both wheels (2 sides) See 47738 code 5-Read off and note toe-in Rear axle: remove 47774 5-Jack up rear of car-Lj, Ltr Remove wheel-Tanr, Sdh 3/4, SCs Remove rear seat cushion Remove rear muffler and pipe-Wco 7/16 Disconnect brake hoses from body-Wco 9/16, Wadj Remove stop straps (at rear attachment points)-Sdh 1/2, Trh, Tebl Remove oil springs Suspend axle on stop straps-Sdh 1/2, Trh, Tebl Remove shock absorbers from axle-Wco 11/16 Remove brake line clips-Psc Remove brake line from axle-SCch, H Remove support under axle (95 only)-Was 9/16 Remove centre bearing attachment of axle-Wco 1/2, Sdh 1/2, Trh Remove body attachments of side links-Sdh 11/16, Tah Remove stop straps-Sdh 1/2, Trh, Tebl Remove rear axle from car Rear axle: install 47776 5-Position rear axle in car-Lj Suspend axle on stop straps-Sdh 3/4, Tebl, Trh Fit centre bearing attachment-Sdh 1/2, Trh, Wco 1/2 Fit side links (nuts inside car)-Sdh 11/16, Tah Free stop straps Fit springs and stop straps Tighten centre bearing bolt-Sdh 1 1/8, Tah Tighten side link bolts at axle-Wco 9/16, Was 9/16

Fit support under axle (95 only)-Was 9/16

Reconnect brake hose to body-Wco 9/16, Wadj Reconnect brake lines to hose-Wco 9/16, Wadj Reconnect handbrake cable to axle and backplate-Psc

Check brake fluid, bleed and adjust brakes-Wco 1/4,

Refit muffler and pipe-Wco 7/16 Refit shock absorbers-Wco 11/16

Refit handbrake cable clips-SCs, Psc

Posn rear seat cushion

SAAB

Metodbeskrivningar (ackordsmeddelanden)

Repair Work Descriptions

Methodenbeschreibungen

5

Bromsar Brakes Bremsen

SAAB-SCANIA

Saab Car Division

Service Department NYKÖPING SWEDEN Copyright Saab-Scania

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			replaces pag			Jan. 1973		.1		1	51002	- 5	1033		
Oper, No	Modelcode	Effective	Secondary	Lost time allow- ance	Schedule time		Mod	elcode	Effect		Secon			Sche	du
51002	50	14	1	1	16										
51002	1-	16	2	2	20										
51003	5-0	9	1	1	11										
51003	1-	12	2	1	15										
51004	5-6	57	5	6	68										
51004	7–0	32	1	3	36										
51004	1-	34	2	4	40										
51005	5–6	37	5	4	46										
51005	7–0	11	1	1	13										
51005	1–	14	2	2	18										
51007	5-6	7	1	1	9										
51007	7–	4	1	1	6										
51009	5-7	13	1	1	15										
51011	5-	10	1	1	12										
51021	5-	13	3	2	18										
51023	5-	15	4	2	21										
51025 51027 51029 51031 51033	5-	15	3	2	20										
51027	5-	17	4	2	23										
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51033	5-	3		1	Λ										

	Replaces page		73-01-02	Edition 1	Page 51002	
Foot- and handbrake adjust Extend lift arms, raise car—Lc	5-0	51002	Lining thickness, c incl brakes adj (wh	heck front an eels off)	d rear 1—	51005
Adj foot-and handbrake, see 5° Lower car, retract lift arms	1003 (5-0)	<u> </u>	Check front wheel Check rear lining the for leaks—MI, SCs	nickness, chec	ck rear wheel c	ylinder
Foot-and handbrake adjust Extend lift arms, raise car—Lc	1-	51002	Adj brake shoes, ch Adj handbrake cab			
Adj foot- and handbrake, see 5 Lower car, retract lift arms	1003 (1—)		Extra for checking		5–6	51007
Foot- and handbrake adjust (ca	ar raised) 5–1	51003	Clean and inspect p Spray antirust fluid Clean and inspect p	on pipes-A	ntirust fluid	
Adj rear brake shoes—Wsp 5/10 Check pedal position Adj handbrake cable—Stu 9/16			Spray antirust fluid Clean and inspect p Check level in mass	oipes in engin	e compartmenteservoir, top up	t o if nec
Foot- and handbrake adjust (ca	ar raise) 1—	51003	Extra for checking	brake lines	7-	51007
Adj rear brake shoes—Wsp 5/10 Check pedal posn Adj handbrake cable—Trh 3/8,			Inspect hoses at fr Clean and inspect Spray antirust flui Clean and inspect	pipes and hos d on pipes—A pipes in engin	ntirust fluid e compartmen	t–MI, Rag
Lining thickness check front a	nd rear, 5–6	51004	Check level in mas Disc brake fluid if		eservoir, top u	o if nec—
Extend lift arms, raise car, rem Check lining thickness, adj bra Refit 4 wheels, lower car, retra	kes, see 51005 (5-	–6)	Braking system, ch in passanger compo remove and install	artment floor		51011
Lining thickness check front a incl brakes adjust Extend lift arms, raise car, rem	ove 4 wheels	51004	Remove mats and Clean and inspect MI, Cag, Rag Spray antirust flui Refit masonite par	pipes in passe d on and arou	nger compartn ınd pipes—Ant	
Check lining thickness, adj bra Refit 4 wheels, lower car, retra		-) 	Braking system, pr			51011
Lining thickness, check front a incl brakes adjust (wheels off)	and rear 5–6	51005	pedal force Collect pressure te			car—
Back off rear brake shoes—Wsp Remove drums—SCs, Ppo, Psc, 784002		/4,	pressure testing ap Maintain 100 kg p Remove apparatus	ressure on pe		te
Clean—Vacuum cleaner Inspect rear brakes Inspect front brakes—MI Refit drums—Tah, 784036			Bleeding at 2 whee	els, manual pu	umping 5—	5102
Adjust rear brakes, check peda Adjust handbrake cable—Stu 9 Move tool trolley to opposite s	/16		Fill reservoir with Lower hood, raise Brush and blow cle Bleed at first whee	car ean at bleed n		
Lining thickness, check front a incl brakes adjust (wheels off)	and rear 7–0	51005	Move vessel to oth Bleed—Wsp 1/4 (re Remove vessel	er wheel, con ear wheel)		
Check front wheel pad thickne Check rear lining thickness, ch leaks–MI, SCs Adj brake shoes, check pedal p	eck rear wheel cy	linderfor	Lower car, raise he Top up brake fluid Check pedal pressu	l, refit cap, w	ipe clean	100 - 1 - 100 - 10

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

51031

51033

Edition Date Page Replaces page 73-01-02 51023 Bleeding at 2 wheels, manual pumping 51023 Bleeding at all wheels or changing 5-(on axle stands) brake fluid (on axle stand) Fill reservoir with brake fluid See bleeding at 2 wheels, 51027 (5-) and Brush and blow clean at bleed nipples-Undercar board, Brush and blow clean at 2 more nipples Cwb, Cag Remove vessel to third wheel Bleed at first wheel Bleed at third wheel Move vessel to other wheel, connect Move vessel to fourth wheel Bleed Bleed at fourth wheel Remove vessel Top up brake fluid, refit cap, wipe clean Check pedal pressure 5-Bleeding, extra for changing brake nipples, each Remove nipple Bleeding at 2 wheels with bleeding 51025 5-Fit new nipple equipment (on lift) Fill apparatus brake fluid if nec-Disc brake fluid Fill apparatus with air-Cag Remove reservoir cap, fit nipple cap to pressure hose Fill reservoir with brake fluid, fit nipple cap to reservoir Lower hood, raise car Brush and blow clean at bleed nipples-Cwb, Cag Subject system to pressure—Bleeding apparatus Bleed at first wheel-Wco 7/16 (for front wheel) Move vessel to other wheel, connect-Wsp 1/4 (for rear wheel) Bleed-Vessel with hose for excess fluid Remove vessel Lower car, raise hood Remove pressure hood from reservoir Check level, refit cap, wipe clean Top up brake fluid, refit cap, wipe clean Check pedal pressure Bleeding at 2 wheels with bleeding 5-51027 apparatus (on axle astands) Fill apparatus with brake fluid if nec-Disc brake fluid Fill apparatus with air-Cag Remove reservoir cap, fit nipple cap to pressure hose Fill reservoir with brake fluid, fit nipple cap to reservoir Brush and blow clean at bleed nipples-Undercar board, Cwb, Cag Subject system to pressure—Bleeding apparatus Bleed at first wheel Move vessel to other wheel, connect Bleed Remove vessel Remove pressure hose from reservoir

Check level, refit cap, wipe clean

Bleeding at all wheels or changing

Remove vessel to third wheel

See bleeding at 2 wheels, 51025 (5-) and Brush and blow clean at 2 more nipples

5-

51029

Check pedal pressure

brake fluid (on lift)

Bleed at third wheel Move vessel to fourth wheel Bleed at fourth wheel

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			73-01-02	1	51102	
Brake shoes, front replace 2 sid Extend lift arms, raise car, remo Replace brake shoes, see 51103 Refit wheels, lower car, retract	ove 2 wheels—Lc	51102	Brake shoes, rear install) both sides Remove 2 wheels Replace shoes, see	(car raised)		
Brake shoes, front replace 2 sid (wheels off) Back off brakes—SCs Remove drums—SCs, Psc, Tanr 784002, H Check wheel cylinder operation Remove shoes—SCs, Ppo Clean back plate and shoes—Cw Fit shoes Dress linings and drums—Emery Refit drums—Ttg Move tools to opposite side Press brake pedal, adj, check br	, Sdh 33, L 1/8, 3 n, check for leaks /b, Vacuum cleand y cloth		Brake shoes, rear in (on inspection) Back off shoes—William Remove drums—Signature 3/4 784002 Remove shoes—Signature 5/10 Clean backplates a Slacken adjusters, Handbrake linkage Wheel cylinder op Fit shoes Dress linings and compared to the shoes of	eplace 2 sides sp 5/16 Cs, Ppo, Ppn, H, cs, Ppo and shoes—Cwb, clean and lubrice clean and lubrice eration, check for	Vacuum clean ate—Wsp, Cwb cate—Ćwb, Mo or leaks	/8, er, Cag , Moc
Spares: Brake shoes compl, spli	t pins		Refit drums÷Tah Adjust shoes, chec Move tools to opp	k pedal and whe		
Brake shoes, front replace 2 sid (drums off)	es 5-6	51105	Spares: Brake shoe	es compl, split pi	ns	
Remove shoes—SCs, Ppo Clean backplate and shoes—Cw Check wheel cylinder operation Fit shoes Dress linings and drums—Emery	n, check for leaks	er, Cag	Brake shoes, rear (wheels off) Back off shoes—W	/sp 5/16	5-0	5111
Move tools to opposite side Spares: Brake shoes compl, spli Brake shoes, remove and install per side (drum off)	-	51107	3/4 784002 Remove shoes—SC Clean backplates a Slacken adjusters, Handbrake linkage Wheel cylinder op	Cs, Ppo and shoes—Cwb, clean and lubric e, clean and lubr	Vacuum clean ate—Wsp, Cwb icate—Cwb, M	er, Cag o, Moc
Remove shoes—SCs, Ppo Clean backplate and shoes—Cw Check wheel cylinder operation Fit shoes		er, Cag	Fit shoes Dress lining and d Refit drums—Tah Adjust shoes, cheo Move tools to opp Adjust handbrake	ck pedal and whe		
Brake shoes, rear replace (remoinstall) both sides	ove- 5–0	51110	Check brake fluid Spares: Brake sho		ins	
Extend lift arms, raise car, rem Replace brake shoes, see 51115 Refit 2 wheels, lower car, retra	5 (5—0)		Brake shoes, rear (wheels off)	replace 2 sides	1–	511
Brake shoes, rear replace (remoinstall) both sides	ove- 1-	51110	Brake shoes, rear	replace, see 5112	22 (5-0)-Wsp	5/16
Extend lift arms, raise car, rem Replace brake shoes, see 5111 Refit 2 wheels, lower car, retra	5 (1—)		Brake shoes, rear (drums off) Remove shoes—So	Cs, Ppo	5-	511
Brake shoes, rear replace (remoinstall) both sides (car raised) Remove 2 wheels		51111	Clean back plates Slacken adjusters Handbrake linkag Wheel cylinder op Fit shoes Dress linings and	clean and lubrice, clean and lubrice, clean and lubriceration, check for	ate-Wsp, Cwl icate-Cwb, M	o, Moc

Repla	ces page		Date	Edition	Page
			73-01-02	1	51119
Brake shoes, rear remove and install each side (drums off)	5-	51119		b "	
Remove shoes—SCs, Ppo Clean backplates and shoes—Cwb, V Slacken adjusters, clean and lubricat Handbrake linkage, clean and lubrica Wheel cylinder operation, check for Fit shoes	e–Wsp, Cwl ate– C wb, M	o, Moc			
Brake shoes, rear, adjuster screw (in packplate) replace per side (shoes of	5— f)	51121			
Remove adjuster screw—Wsp, Rust s Grease and fit adjuster screw	olvent				
Brake shoes, replace all	5-6	51130			
Extend lift arms, raise car, remove 4 Brake shoes, front replace, see 51103 Brake shoes, rear replace, see 51115 Refit 4 wheels, lower car, retract lift	3 (5–6) (5–0)	76.23			
Brake shoes, replace all (wheels off)	5–6	51131			
Front shoes replace, see 51102 (5–6 Excl fluid level check Rear shoes replace, see 51122 (5–0)			*		
Brake shoes, replace all (drums off)	5-6	51133			
Front shoes replace, see 51109 (5\(\xi\)6 Rear shoes replace, see 51131 (5\(-\)))				
Brake linings replace (riveting) on emoved shoes, per pair	5–	51271		**************************************	*
Remove linings from 2 shoesH, Dri Clean shoesCwb Rivet linings.to 2 shoesSC, Drift	ft				
Spares: Brake lining set, rivets as nec					
Brake linings, eccentric branding, irst pair of shoes	5-	51289			
Adj machine (to correct drum diame Change shoes in machine twice Grind lining twice Clean machine	eter)				
Brake linings, eccentric grinding per additional pair	5-	51291			
Change shoes in machine twice Grind lining twice Clean machine)					

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Oper. No Modelcode time Effective time Secondary time 51501 5-6 17 5 51502 5-6 47 5 51503 5-6 34 5 51505 5-6 5 2 51511 5-0 19 5 51513 7- 13 5 51514 5-0 48 4 51514 5-0 48 4 51515 5-0 44 4 51515 1- 46 4 51517 5-0 35 4 51519 7- 29 4 51521 5- 5 3 51530 5-6 90 5 51531 5-6 70 5	ab Car Divis	sion		Replaces pag	10		Date	711 774	OI K	Edition	uaru r	Page			30,00
51501 5-6 17 5 51502 5-6 47 5 51503 5-6 34 5 51505 5-6 5 2 51511 5-0 19 5 51511 1- 22 5 51513 7- 13 5 51514 5-0 48 4 51514 1- 51 4 51515 5-0 44 4 51515 1- 46 4 51517 1- 38 4 51517 1- 38 4 51521 5- 5 3 51530 5-6 90 5 51531 5-6 70 5				Replaces pag	je		Jan.	1973		1			1501 -	51579	
51502 5-6 47 5 51503 5-6 34 5 51505 5-6 5 2 51505 5-6 5 2 51511 5-0 19 5 51511 1- 22 5 51513 7- 13 5 51514 5-0 48 4 51514 1- 51 4 51515 5-0 44 4 51515 1- 46 4 51517 5-0 35 4 51517 1- 38 4 51519 7- 29 4 51521 5- 5 3 51530 5-6 90 5 51531 5-6 70 5	er, No	Modelcode	Effective	e Secondary time	Lost time allow- ance	Schedule time	Oper.	No	Mod	delcode	Effecti	ve	Secondary ime	Lost time allow- ance	Schedule time
51503 5-6 34 5 51505 5-6 5 2 51511 5-0 19 5 51511 1- 22 5 51513 7- 13 5 51514 5-0 48 4 51514 1- 51 4 51515 5-0 44 4 51515 1- 46 4 51517 5-0 35 4 51517 1- 38 4 51519 7- 29 4 51521 5- 5 3 51530 5-6 90 5 51531 5-6 70 5	501	5-6	17	5	2	24									
51505 5-6 5 2 51511 5-0 19 5 51511 1- 22 5 51513 7- 13 5 51514 5-0 48 4 51514 1- 51 4 51515 5-0 44 4 51515 1- 46 4 51517 5-0 35 4 51517 1- 38 4 51519 7- 29 4 51521 5- 5 3 51530 5-6 90 5 51531 5-6 70 5	502	5-6	47	5	5	57									
51511 5-0 19 5 51511 1- 22 5 51513 7- 13 5 51514 5-0 48 4 51514 1- 51 4 51515 5-0 44 4 51515 1- 46 4 51517 5-0 35 4 51517 1- 38 4 51519 7- 29 4 51521 5- 5 3 51530 5-6 90 5 51531 5-6 70 5	503	5-6	34	5	4	43									
51511 1- 22 5 51513 7- 13 5 51514 5-0 48 4 51514 1- 51 4 51515 5-0 44 4 51515 1- 46 4 51517 5-0 35 4 51517 1- 38 4 51519 7- 29 4 51521 5- 5 3 51530 5-6 90 5 51531 5-6 70 5	505	5-6	5	2	1	8									
51513 7- 13 5 51514 5-0 48 4 51514 1- 51 4 51515 5-0 44 4 51515 1- 46 4 51517 5-0 35 4 51517 1- 38 4 51519 7- 29 4 51521 5- 5 3 51530 5-6 90 5 51531 5-6 70 5	511	5-0	19	5	2	26									
51514 5-0 48 4 51514 1- 51 4 51515 5-0 44 4 51515 1- 46 4 51517 5-0 35 4 51517 1- 38 4 51519 7- 29 4 51521 5- 5 3 51530 5-6 90 5 51531 5-6 70 5	511	1-	22	5	3	30									
51514 1- 51 4 51515 5-0 44 4 51515 1- 46 4 51517 5-0 35 4 51517 1- 38 4 51519 7- 29 4 51521 5- 5 3 51530 5-6 90 5 51531 5-6 70 5	513	7-	13	5	2	20									
51515 5-0 44 4 51515 1- 46 4 51517 5-0 35 4 51517 1- 38 4 51519 7- 29 4 51521 5- 5 3 51530 5-6 90 5 51531 5-6 70 5	514	5-0	48	4	5	57									
51515 1- 46 4 51517 5-0 35 4 51517 1- 38 4 51519 7- 29 4 51521 5- 5 3 51530 5-6 90 5 51531 5-6 70 5	514	1-	51	4	6	61									
51517 5-0 35 4 51517 1- 38 4 51519 7- 29 4 51521 5- 5 3 51530 5-6 90 5 51531 5-6 70 5	51 5	5-0	44	4	5	53									
51517 1- 38 4 51519 7- 29 4 51521 5- 5 3 51530 5-6 90 5 51531 5-6 70 5	515	1-	46	4	5	55									
51519 7- 29 4 51521 5- 5 3 51530 5-6 90 5 51531 5-6 70 5	517	5 - 0	35	4	4	43									
51521 5- 5 3 51530 5-6 90 5 51531 5-6 70 5	517	1-	38	4	4.	46									
51530 5-6 90 5 51531 5-6 70 5	519	7-	29	4	3	36									
51531 5 – 6 70 5	521	5-	5	3	1	9									
	530	5 - 6	90	5	10	105									
E4577	531	5-6	70	5	8	83									
3 3 3	573	5-	17		2	19									
51579 5- 18 2	579	5~	18	2	2	22									
belong 2 sheets of repai				1											

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			73-01-		1	51501	
Brake drums, front remove-inst 1 side (wheel off)	tall 5–6	51501	Refit 2 wl	heels, low	er car, retract	lift arms	-
Back off brake adjusters—SCs Remove drum—SCs, Psc, Tanr, 784002, H		3/4	both sides	V	emove-install	1-	51514
Blow clean and check—Vacuun Refit drum—Ttg Press brake pedal, adj, check ————————————————————————————————————	1 cleaner		Remove-ii	nstall brak	ise car, remove ke drums, see 5 er car, retract l	1517 (1—)	
Brake drums, front remove-inst both sides	tall 5–6	51502	Brake dru both sides		emove-install ed)	5-0	51515
Extend lift arms, raise car, rem Remove-install brake drums, se Refit 2 wheels, lower car, retra	e 51503 (5-6)	0	Remove 2 Remove-ii Refit 2 wl	nstall bral	ke drums, see 5	1517 (5—)	
Brake drums, front remove-inst 2 sides (wheels off)	tall 5–6	51503	Brake dru sides (car	A STATE OF THE STA	emove-install b	ooth 1—	51515
Back off brake adjusters—Scs Remove drums—SCs, Psc, Tanr 784002, H Blow clean and chek—Vacuum		3/4	Remove 2 Remove-ii Refit 2 w	nstall bral	ke drums, see 5	1517 (1—)	
Refit drums—Ttg Move tools to other side Press brake pedal, adj, check			Brake dru (wheels o		emove-install 2	? sides 5-0	51517
Brake drums, front replace (drueach Wash new drum to remove pres		51505 /ashing	Blow clea Refit drui Adj shoes	Irums—SC n and che ns—Tah , check pe	s, Psc, H, Tanr ck—Vacuum cl edal and wheel		4, 78400
facilities, Cag Spares: Brake drum			Adj handl	orake—Sti	u 9/16		·
Brake drums, remove-install 1 (wheel off)	side 5–0	51511	Brake dru (wheels o	ff)	emove-install 2	2 sides 1–	51517
Back off adjusters—Wsp 5/16 Remove drum—SCs, Psc, H, Ta Blow clean and check—Vacuun Refit drum—Tah		4002	1	ıms, rear ı	emove-install 2	2 sides 7—	51519
Adj shoes, check pedal and who Adj handbrake—Stu 9/16	eel rotation	v	Back off Remove o	Irums-SC	p 5/16 Cs, Psc, H, Tanr eck—Vacuum c	, Sdh 1 1/8, 3/	4, 78400
Brake drums, rear remove-insta side (wheel off)	III 1 1—	51511	Refit dru Move too	ms-Tah		, 000	
See 51516 (5-0)			Brake dru	ıms, rear ı	replace each (d	rum and 5—	51521
Brake drums, rear remove-insta 1 side (on inspection)	ıll 7	51513	bearing o	ff) / drum to		vative, dry—Wa	
Back off adjusters—Wsp 5/16 Remove drum—SCs, Psc, H, Ta Blow clean and check—Vacuur Refit drum—Tah		/4 784002	Transfer		cb		
Brake drums, rear remove-insta	ill 5–0	51514					

both sides

Extend lift arms, raise car, remove 2 wheels-Lc Remove-install brake drums, see 51517 (5-0)

aab Car Division	Replaces page		Date	Edition	I Page
	Replaces page		73-01-02	1	Page 51530
rake drums, remove-install all	5–6	51530	70 01 02	7	101000
xtend lift arms, raise car, rem emove-install brake drums, se efit 4 wheels, lower car, retra	ove 4 wheels e 51531 (5–6)		_		
rake drums, remove-install all vheels off)	5–6	51531			
rake drums, front remove-inst ove tools to rear wheels rake drums, remove-install, se		-6)	_		
rake drums, turning, addition ich (drum off, bearing off if n		51573			
it drum on spindle it vibration damper to drum pply cutter urn with coarse cutter (feed 0 djust for fine cutter urn with fine cutter (feed 0.1 emove vibration damper emove drum from spindle and lipe drum clean—Rag eplace cutter 1/20 (throw-aw	25 mm, speed 150	0)			
ake drums, turning first (dru aring off if nec) eplace cutter holder if nec—V t drum on spindle t vibration damper to drum oply cutter urn with coarse cutter (feed 0	Vsp	51579 0)			
djust for fine cutter urn with fine cutter (feed 0.1 emove vibration damper emove drum from spindle an lipe drum clean—Rag eplace cutter 1/20 (throw-aw	25 mm, speed 150	0)			

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

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		ľ	repraces pag	•		Jan. 1973		1			1614 -	52130	
Oper, No	Modelcode	Effective	Secondary	Lost time allow- ance	Schedule time	Oper. No	Mo	delcode	Effectiv		Secondar time	Lost time allow-	Schedule time
		1	1	ance	ŀ		l.		I			ance	
51614	7-	10	5	2	17								
51616	7-	11	3	1	15								
51617	7-	11	4	2	17	-							
51618	7–	21	5	3	29								
51619	7-	23	4	3	30								
51620	7–	42	5	5	52						10		
51659	7-	6	3	1	10								
51671	7-	58	1	6	65								
51677	7–	10	3	1	14								
51679	7-	10		1	11								
51681	7–	6	1	1	8								
					**								
51710	7-	47	4	5	56								
51711	7–	43	4	5	52								
51713	7–	34	4	4	42								
51721	7–	9	2	1	12								
52102	5-0	59	7	7	73								
52102	1-	34	7	4	45								
52130	5 - 8	37	5	4	46								
52130	9-	24	6	3	33	A .							

Saab Car Division	Repair Work Description OAAB 33/30
Replaces page	Date Edition Page
Brake discs, remove hubs (with disc fitted) each (pads out) Clean at brake housing fixing bolts—Cwb Bend back locking tabs—H, SCch Remove brake housing fixing bolts—Tanr, Ppn Sdh 5/8 Suspend brake housing—Hook Remove split pin and hub nut—Psc, Tanr, Sdh 33, H Pull off hub—784002, Tanr, Sdh 1 1/8, 3/4	73-01-02 1 51614 Transfer vibration damper Machine away worn edges Apply cutter Turn with coarse cutter Adjust for fine cutter Turn with fine cutter Turn cutter holder and machine outer surface Remove disc and vibration damper Replace cutter 1/20 (throw-away cutter with carbide tip)
Brake discs, fit hubs, each (not 7— 51516 fit pads) Fit hub to axle—Tah, Sdh 33, Psc, Ttg Posn brake housing, fit and lock bolts—Tanr, Ppn, Sdh 5/8, H, SCch, Tebs Spares: Locking tap, split pin	(Secondary time for walking to lathe, 1 per disc) Brake discs, grinding and dressing first 7— 51677 side (for outer side with wheel off, for inner side with brake housing off) Grind away worn and rusty edges—Rotary grinding machine
Brake discs, Remove-install 1 hub 7— 51617 (brake housing off) Remove hub with disc from drive shaft—Psc, Tanr, Sdh 33, 1 1/8, 3/4, 784002, H Fit hub with disc—Ttg	Finish off by hand—Emery cloth Brake discs, grinding and dressing addi- 7— 51679 tional side each (for outer side with wheel off, for inner side with brake housing off) Grind away worn and rusty edges—Rotary grinding machine
Brake discs, remove-install 1 hub 7— 51618 (pads out) Remove, see 51614 (7—) Install, see 51616 (7—)	Brake discs, backing plates remove- 7— 51681 install each (hub off) Remove backing plate—Trh, Tebl, Sdh 11 Install backing plate
Brake discs, remove-install 2 hubs 7— 51619 (brake housing off) Remove-install, see 51617 (7—)	Histali Dacking place
Brake discs, remove-install 2 hubs 7— 51620 (pads out) Remove, see 51614, twice Install, see 51616, twice Move tools to other side	
Brake discs, replace each 7— 51659 (remove-install disc from/on hub) (hub off) Remove disc from hub—Tanr, Sdh 1/2 Wash hub and new brake disc—Cleaning area Fit disc to hub Spares: Brake disc	
Brake discs, machine each both sides 7— 51671 (disc off) Replace cutter holder if nec Mount disc on spindle—Wsp Centre disc and machine away worn edges Fit vibration damper Apply cutter Turn with coarse cutter (feed rate max, speed 150) Adjust for fine cutter Turn with fine cutter (feed rate min, speed 150)	

Saab Car Division Date Edition Replaces page Page 73-01-02 51710 51710 Brake pads replace 7-Spares: Repair kit Extend lift arms, raise car, remove 2 wheels-Lc Replace brake pads, see 51713 (7-) Master cylinder recond (cylinder off) 52102 Refit 2 wheels, lower car, retract lift arms Recon see Saab 99, 52149 (9) Brake pads replace (car raised) 51711 Master cylinder replace (remove-5-8 52130 Remove 2 wheels, replace brake pads, see 51713 (7-) install) excl bleeding Refit 2 wheels Blow clean at master cylinder-Cag Back off and disconnect unions and fitting bolts-Wco 7/16, 51713 Brake pads replace (wheels off) 7-Ppn, Tebs, Tuj, Sdh 1/2 Disconnect pipes from cylinder-Wco 7/16, Clean around brake reservoir cap, check fluid level Remove master cylinder from car If nec draw off small amount brake fluid-Pump Wash master cylinder externally-Cleaning area, Cag Remove split pins and spring clips-Ppo Posn cylinder and unions in car Remove pads-Ppo Fit fitting bolts Clean exposed parts of brake pistons—Brake fluid, rag Fill with brake fluid-Brake fluid Press pistons back into brake cylinders—Ate-tool Tighten pipes at cylinder Blow clean brake housings, lubricate hinge pins and work Adjust pedal free movement-Wco 5/8, Wadj 6 support brackets for free movement—Cag, H, Lubricant Wash brake discs to remove any lubricant-Trich Spares: Master cylinder Unpack and fit new damping shims Install pads-Ppo Pump out pistons with brake pedal Master cylinder replace (remove-52130 Reset brake warning switch install) excl bleeding Check brake fluid level, refit cap Blow clean at master cylinder and brake pipes-Cag Top up brake fluid if nec, wipe-Disc brake fluid Disconnect both pipes and plug master cylinder-Wco 7/16, Spares: Brake pad set, LH and RH damping shims Separate master cylinder from servo cylinder-Wco 13 Wash master cylinder ext-Cleaning area Brake pads, remove install per side (wheel 7-51721 Mount master cylinder on servo cylinder Remove plugs, connect pipes-Ppn, SCs Fill with brake fluid-Brake fluid Remove split pins and spring clip-Ppo Pump up the brake fluid, tighten unions Remove pads-Ppo Blow clean brake housing, lubricate at hinge pin and work Spares: Master cylinder support brackets for free movement-Cag, H, Lubricant Wash disc to remove any lubricant-Trich Install pads—Ppo Pump out pads with brake pedal Master cylinder recond (cylinder off) 52102

Arrange work bench and vesse with brake fluid Remove rubber boot and retaining plate-784199, H Remove circlips-Drift Remove nylon bushing, rubber seal and steel ring Remove pistons and cover-SCs, Was Remove non-return valves Dress cylinder bore-Mpd, polishing stone, dressing cloth Rinse and blow clean cylinder-Brake fluid, Vessel, Cag Clean by-pass port Wipe clean non-return valves Replace seals and install non-return valves Replace seal and fit cover, torque-tighten-Ttg Separate pistons Open pack Replace seals and washers (inner and outer)

Assemble pistons

Grind outer piston

Apply fluid to piston and seals, install-Brake fluid

Fit inner retainer

Fit outer rubber ring, nylon bush, circlip

Fit circlip and rubber boot

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per. No	Modelcode	Effectiv time	e Secondar time	y Lost time allow- ance	Schedule time	Oper. No	Mo	delcode	Effect	tive	Seconda time	time allow ance	Schedule
2204	5-	6	2	1	9								
52206	5-	11	2	1	14								
52208	5-	19	3	2	24								
52210	P5-7	76	3	8	87								
52210	H5~7	81	3	8	92								
52210	P0 -	58	2	6	66						*,		
52210	P8-9, H8-	53	2	6	61								
52216	5-9, HO-	17	1	2	20	J.							
52216	P0-	23	1	2	26								
52218	5-	18	2	2	22								
52219	5-	12	1	1	14								
52220	5-9, HO-	29	1	3	33								
52220	P0-	34	1	4	39								
52223	5-7	62	3	7	72	l l							
52223	8-	27	1	3	31								
52224	5-	36	2	4	42								
52230	5-6	11	2	1	14								
52232	5 - 6	22		2	24								
52240	5-	9	1	1	11								
52241	5-	5	1	1	7								
52242	5→	18	1	2	21								

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		_	-	73-01-02	1	52204	
Brake pipes, short at master cy replace, each	linder	5-	52204	Brake pipes, inne	er long replace be	oth P8–9, H8–	52210
Disconnect pipe and plug hole- Remove plug and connect pipe Wipe hands—Rag		6, plug		Remove LH seat Remove seat cus Fold back mats a Expose brake pip	hion—Seat prote and remove bask oes at bulkhead—	et -SCcs, SCs	
Brake pipes, LH long in engine compartment replace		5–	52206	Remove sill prote Replace both bra Fit insulating ma defroster pipe—D	ake pipes, see 523 sterial, steering co Drift, SCs, SCcs	223 (8–)	tector an
Disconnect pipe from coupling Disconnect pipe from hose—Wo Remove pipe from car Vipe hands—Rag Posn pipe and start unions		16		Refit sill protect Refit basket and Refit seat cushio Refit seat	replace mats	- (h	
Fighten pipe Spray antirust fluid on pipe—A	intirust flu	uid		Brake hoses, rear	replace 1 side	5-9, H0-	52216
Brake pipe RH long in engine ompartment replace		5—	52208	Remove seat cus Disconnect pipe Remove nut from	from hose–Wad n hose–Wco 9/1	6	
Disconnect pipe from coupling Plastic plug Disconnect pipe from hose—W		hole-W	/co 7/16,	Remove hose from Clean—Cag, Cwb Fit hose to rear		o 9/16	
ree pipe from bulk head—SCs Remove pipe from car, wipe ha lug new pipe, posn in car	ands-Rag			Fit nut Connect pipe to Check hose posn			
Remove plugs and start unions Tighten pipe Clip pipe to bulkhead Vipe hands				Brake hoses, real		wheel PO-	52216
Spray antirust fluid on pipe—A	intirust fli	uid		Replace hose, se	e 5221 6 (5–9, H	10—)	
Brake pipes, inner long, replace Remove mats and masonite pa Remove rear seat cushion		P5-7	52210	Brake hoses, fro	nt replace 1 side	5	52218
Replace both brake pipes, see ! Refit masonite panels and mat Refit seat cushion		-7)		Clean at unions- Cut off brake ho Disconnect one	se-Psc	nakalata Waa 1	E
rake pipes, inner long, replac	e both	H5-7	52210	Disconnect one life in the property of the pro	hose-half from w	heel house-Wa	
Brake pipes replace, see 522 10 n addition, remove-install spa				Spares: Brake ho			
Brake pipes, inner long, replac	e both	P0-	52210	Brake hoses, from cylinder off) Clean at union—		wheel 5–	52219
Remove LH seat Remove seat cushion Fold back mats and remove ba	sket			Remove hose—W Install hose	/adj, Wćo		
Expose brake pipes at bulkhea Remove sill protectors—SCcssh Replace both brake pipes, see	, SCcs			Spares: Brake ho			
Fit insulating material, steering and defroster pipe—Drift, SCs, Refit sill protectors	column t		tector	Brake hoses, real		5-9 H0-	52220
Refit basket and replace mats Refit seat cushion Refit seat				Brake hoses repl	ace, see 52210 (8	J−9, ⊓U−)	

52241

52242

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Remove pipe-Wsp

Fit pipe Brake pipes at front wheels (between 5-6 52232

wheel cylinders), replace 2 sides (wheels off, excl bleeding)

See 52230 (5-6) doubling the time allowances, adding time for going to other side

Brake pipes at rear wheels, replace 1 side (wheel off)

52240

Clean at unions-Cwb Remove pipe-Wco 9/16, 7/16 (Psc) Fit pipe

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oper. No	Modelcode	Effective	Secondary time	Lost time allow- ance	Schedule time		odelcode	Effect			Schedule time
52310	5-6	18	3	2	23	54104	9–	53	7	6	66
52311	5–6	18		2	20	54118	9-0	15	2	2	19
52313	5-6	17	8	3	28	54120	9-	6	1	1	8
52315	5-6	14		1	15	54122	9-	9	1	1	11
52320	5-	17	3	2	22						
2321	5-	34	3	4	41	To this sheet	belong:	3 sheet	s of repair	work	description
2323	5-	19	4	2	25						
2325	5-	39	4	4	47						
2351	7–	9	3	1	13						
2353	7–	19	3	2	24						
2354	7-	67	6	7	80						
2355	7–	54	6	6	66						
2357	7-	18	3	2	23						
2359	7–	36	3	4	43						
2360	7-	83	6	9	98						
2361	7–	70	6	8	84						
2381	7-	21	3	2	26						
2383	7–	41	3	4	48						
2385	7-	3	1	1	5						
2387	7-	6	1	1	8						
2391	7-	9	5	1	15						
52393	7-	19	5	2	26						
2477	5–7	8	2	1	11						
2477	8-	13	2	2	17						
2479	5-7	14	2	2	18	1					
2479	8-	20	2	2	24						
										1	

Clean back of backplate-Cwb Remove bleed nipple-Wsp 1/4

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			73-01-02	1	52310	
Wheel cylinders, front replace (shoes off) Front cylinder:		52310	Disconnect pipe Remove wheel cy Unpack and insta Connect pipe to	ylinder—H, SCs all wheel cylinder		
Remove piston, wipe and chec	k (decide on repla	acement)—Ppo,	Refit bleed nippl			
Remove nipple—Wco 7/16 Disconnect pipe from cylinder	Was 7/16 (Pan)		Spares: Wheel cy	linder		
Remove fixing bolts-Trh, Teb	s, Sdh 1/2, 11/32					
Remove cylinder from backpla Hp, SCs Unpack cylinder, prepare for i		an)—	Wheel cylinders, sides (shoes off)	rear replace both	5—	52321
Posn cylinder on backplate, fit Connect pipe to cylinder			See 52320 (5)	twice		
Fit nipple			_		-	
Rear cylinder: Remove piston, wipe and chec MI	k (decide on repla	acement)—Ppo,	Wheel cylinders, (shoes off)	rear recond 1 sid	e 5–	52323
Disconnect pipe from cylinder Disconnect hose from cylinder	-Wco 15		Remove dust exc MI, Mdv			neckPpo
Remove fixing bolts—Trh, Teb Remove cylinder from backpla Hp, SCs Unscrew cylinder from hose			Remove piston so Dress, wipe and of Fit polishing stor	check pistons—Dr ne to drill—Polish	essing cloth ing stone, Mpa	d
Unpack cylinder, prepare for i Screw cylinder on to hose	nstallation		Polish cylinder, v Arrange workber Fit piston seals a	nch, open pack		rake
Fit fixing bolts—Trh Tighten hose in cylinder—Wco	15		fluid Open bleed nipp	le		
Connect pipe to cylinder Spares: Wheel cylinder			Fit pistons Close nipple			
opures: wheel cymider		-	Spares: Repair ki	it		
Wheel cylinders, front replace each (shoes off)	others 5–6	52313	Wheel cylinders,	rear recond both	5-	52325
See 52310 (5-6)		f	sides (shoes off)	oo /= \		
			Recond, see 523 Move to other sid			
Wheel cylinders, front, recond (shoes off)	first 5–6	52313)			
Remove piston, wipe and chec Ppo, Mdv, MI	k (decide on repla	acement)—	Brake housings, i brake hose) and	remove-install (no suspend 1	ot 7–	52351
Wash backplate—Cleaning ager Fit polishing stone to drill—M		9	Clean at bolt hea Bend back locking			
Polish cylinder, wipe and chec Remove seals from piston			Remove brake he	ousing fixing bolt	s—Tanr, Trh,	Tebs, Sdh
Dress, wipe and check piston-	Dressing cloth		5/8, Sre Suspend brake h	ousing-hook		
Arrange workbench Open pack, fit seals and gasket	ts to piston-Brake	e fluid	Posn brake housi	ing, fit and lock b	olts	
Open bleed nipple, fit piston,			Spares: Locking	tabs		
Spares: Repair packet			Duoles havening	omava install In-	t huales 7	E22E2
Miles I will be a second		F0000	hose) and suspen	emove-install (no nd 2	t brake 7-	52353
Wheel cylinders, front recond each (shoes off)		52320	See 52351 (7-), time for moving	doubling time all to other side	lowances and	adding
Recond wheel cylinder, see 52 Move to next wheel	313 (5-6)		*			
Wheel cylinders, rear replace 1	side 5—	52320		remove-install (no suspend both side ce		52354
(shoes off) Remove dust excluders and pi	etane wine and ah	nack_Dno		, raise car, remove		
MI		еск-гро,		nd suspend brake ls, lower car, retr		o2355 (7-
Clean back of backplate-Cwb						

incl pads replace (wheels off excl bleeding)

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Date Edition Replaces page Page 73-01-02 52355 52355 Brake housings, remove-install (not Clean around brake reservoir cap, chek fluid level brake hose) and suspend 2 incl pads replace If nec draw off small amount of brake fluid-Pump (wheels off) Remove split pins and spring clips-Ppo Remove pads-Ppo Clean around brake reservoir cap, check fluid level Clean exposed parts of brake pistons-Brake fluid, rag If nec draw off small amount brake fluid-Pump Press pistons back into brake cylinders—Ate-tool Remove split pins and spring clips-Ppo Blow clean brake housings, lubricate hinge pins and work Remove pads-Ppo support brackets for free movement—Cag, H, lubricant Clean exposed parts of brake pistons-Brake fluid, rag Clean at brake housing fixing bolts-Cwb Press pistons back into brake cylinders-Ate-tool Disconnect hose from brake cylinder-Wco 15 Blow clean brake housings, lubricate hinge pins and work Bend back fixing bolt locking tabs-H, SCch support brackets for free movement-Cag, H, Lubricant Remove brake housing fixing bolts-Tanr, Trh, Tebs, Cleanat brake housing fixing bolts-Cwb Sdh 5/8, Sre Bend back locking tabs-H, SCch Unscrew housing from hose Remove brake housing fixing bolts-Tanr, Trh, Tebs, Sdh Plug hose and cylinder 5/8, Sre Move tool trolley to other side Suspend brake housing-Hook Remove plugs from hose and cylinder Move tool trolley to other side Replace seal and screw brake housing on to hose Wash brake discs to remove any lubricant-Trich Fit brake housing to steering knuckle, lock bolts Posn brake housing, fit and lock bolts Tighten hose Unpck pads, fit new damping shims Wipe up brake fluid, clean hands Install pads-Ppo Wash brake discs to remove any lubricant-Trich Pump out pistons with brake pedal Unpack pads, fit new damping shims Reset brake warning switch Install pads-Ppo Check brake fluid level, refit cap Pump out pistons with brake pedal Top up brake fluid if nec, wipe-Disc brake fluid Reset brake warning switch Spares: Pad set, LH and RH damping shims, brake housing Check brake fluid level, refit cap locking tabs Top up brake fluid if nec, wipe-Disc brake fluid Spares: Brake pad set, damping shims, brake housing locking tabs, brake hose seal Brake housings, remove-install 1 compl 52357 (pads out excl bleeding) Clean at bolt heads and brake hose-Cwb 52381 Brake housings, hinge pin, support Disconnect hose at wheel cylinder-Wco 15 bracket and brake cylinder remove-install Bend back fixing bolt locking tabs-H, SCch (replace)1 (brake housing remove compl) Remove brake housing fixing bolts—Tanr, Trh, Tebs, Remove hinge pin, free support bracket from mounting-Sdh 5/8, Sre SCs, H Unscrew housing from hose Remove brake cylinder from support bracket-SCs, Ppn Plug hose and cylinder-Plugs Clean mounting and support bracket-SCs, Cwb, Cag Remove plugs from hose and cylinder Dress mating surfaces between support bracket and Replace seal and screw brake housing on to hose mounting-Vice, Emery cloth Fit brake housing to steering knuckle, lock bolts Fit brake cylinder Tighten hose Fit support bracket to mounting-SCs, Ppo, Lubricant Wipe up brake fluid, clean hands Debuct time for cleaning brake housing and working free Spares: Locking tabs for brake housing and seal for support bracket, included in pads remove-install brake hose Spares: Hinge pin circlip Brake housings, remove-install 2 compl 52359 52383 Brake housings, hinge pin, support (pads out excl bleeding) bracket and brake cylinder remove-install See 52357 (7-) doubling time allowances where applicable (replace) 2 (brake housing off) Add transfer of tool trolley from one side to the other twice See 52381 (7-), doubling all time allowances Brake housing, remove-install 2 incl 52360 Brake cylinder, remove-install (replace) 52385 pads replace (excl bleeding) 1 (brake housing removed compl) Extend lift arms, raise car, remove front wheels-Lc Remove brake cylinder from support bracket-SCs, Ppn Remove-install and suspend brake housing, see Clean brake cylinder ext (or unpcak new)-Cwb 52361 (7-) Fit brake cylinder Refit front wheels, lower car, retract lift arms Brake housings, remove-install 2 compl 52361 Saab-Scar

	I Dealessa		I Date	I mark an	T D-	
	Replaces page		73-01-02	Edition	Page 52387	
Brake cylinder, remove-install 1 (brake housing removed cor See 52385 (7–), doubling all	npl)	52387	SCs, Psc Disconnect peda and take out serv	I from push ro	d, remove fixi	
Brake cylinder, piston seals re (brake cylinder off) Press out piston with brake pe housing) Remove piston seal—SCs Remove dust excluder with re Wash and check brake cylinde	edal (before removi		Posn and install s Refit insulation a Refit master cyli Remove plugs, co Connect vacuum Pump up brake f Fill with brake fl	and steering conder to servo onnect brake phose to servo luid, tighten phose brake	cylinder pipes—Ppn cylinder ipe connection	
Vessel Lubricate piston and cylinder Fit piston seal Fit piston to cylinder—78406 Fit dust excluder and retainer Spares: Set of seals	0		Brake servo, filte install and blow of Remove-install filter-	clean Iter-MI, SCs,		
Brake cylinder, piston seals re (brake cylinder off) See 52385 (7—), doubling all Pedal stand, remove (steering	time allowances	52393 52477	Brake servo, non replace Remove-install at Remove non-return va	ir cleaner—Wo		- # 541
Remove split pins—SCs, Psc Remove clutch pedal and retu Unscrew master sylinder push Wco 5/8 Remove shaft and brake peda	rod at adjuster nut	:2 times	Brake servo, vacu Remove-install ai Remove vacuum	um hose repla	o 10, Wco 11	- 541
Pedal stand, remove (steering stand out)	column 8-	52477	Fit vacuum hose Spares: Vacuum			
See 52477 (5–7) remove ped stop light and brake warning :						2
Pedal stand install (steering co	olumn 5–7	52479				
Fit brake pedal and shaft Screw together master cylind Fit clutch pedal Fit split pins Adj brake pedal free moveme		ter nut				

stand out)

Pedal stand install (steering column

stop light and brake warning switches

Vacuum cylinder, replace

Wco 7/16, Plugs

See 52479 (5-7) install pedal stand, in addition install

Blow clean at master cylinder and brake pipes-Cag Disconnect both brake lights and plug master cylinder-

Remove master cylinder from servo cylinder-Wco 13 Remove vacuum hoser from servo cylinder-SCs

Fold back insulation, remove steering column protector-

8-

52479

54104

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13 15 56 66 61 64 90 100 95 98 36 45	Secondary time 4 5 4 5 4 5 4 5 3	1 2 6 7 7 9 11 10 10	14 17 66 78 72 76 103 116 109 113	Oper. No	Mode	lcode	Effective	55102 - B Secondar time		nedule ne
15 56 66 61 64 90 100 95 98 36	5 4 5 4 5	2 6 7 7 7 9 11 10	17 66 78 72 76 103 116 109							
56 66 61 64 90 100 95 98 36	5 4 5 4 5	6 7 7 7 9 11 10	66 78 72 76 103 116 109							
66 61 64 90 100 95 98 36	5 4 5 4 5	7 7 7 9 11 10	78 72 76 103 116 109							
61 64 90 100 95 98 36	4 5 4 5 4 5	7 7 9 11 10	72 76 103 116 109							
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90 100 95 98 36	4 5 4 5	9 11 10 10	103 116 109							
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95 98 36	4 5	10 10	109							
98 36	5	10								
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sh	62 64 16 45	62 3 64 4 16 2 45 7	62 3 7 64 4 7 16 2 2 45 7 5	62 3 7 72 64 4 7 75 16 2 2 20 45 7 5 57	62 3 7 72 64 4 7 75 16 2 2 20	62 3 7 72 64 4 7 75 16 2 2 20 45 7 5 57	62 3 7 72 64 4 7 75 16 2 2 20 45 7 5 57	62 3 7 72 64 4 7 75 16 2 2 20 45 7 5 57	62 3 7 72 64 4 7 75 16 2 2 20 45 7 5 57	62 3 7 72 64 4 7 75 16 2 2 20 45 7 5 57

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	- 	-	73-01-02	1	551	02	
Remove-install 2 rear wheels (incl lower car on lift)	raise- 5-	55102	Handbrake cabl (wheels off)	es, replace boti	n sides	P0-	55111
Extend lift arms, raise car—Lc Remove-install 2 rear wheels—Tar Lower car, retract lift arms	nr, collar sleeve,	Tah	See 55109 (P0-applicable	-), doubling tin	ne allowan	ces whe	re
Remove-install 2 wheels (incl jack rear of car up and down) Jack up rear of car—Lj, Ltr Remove-install rear wheels—Tanr,		55104	Handbrake cabl (wheels off) See 55109 (H5- applicable			H5–0 ances wh	5511 1
Lower rear of car	condi dicorc, i	· · ·					
Handbrake cable, replace compl	P5-9	55109	Handbrake cabl (wheels off)	es, replace botl	n sides	H1-	55111
one side (wheel off) Remove RH seat			See 55109 (H1- applicable	-), doubling tir	ne allowar	ices whe	re
Remove rear seat cushion and bac Remove rear mat and masonite pa Remove nut from cable inner—St	anel u		Handbrake cabl	es, lubricate in	ner, 1 side	P5-9	55113
Remove inner from lever (at back Psc, H Push cable inner backwards Remove cable clip—Psc Remove cable from rear axle tube			Remove RH sea Remove rear flo Remove inner f H, Psc, Underca	oor mat and ma rom handbrake	sonite pan		Stu 9 /16
Remove cable from car Grease cable inner—Grease Posn cable in car			Pull out inner Wipe clean and Grease inner—G				
Posh cable in car Posn cable on rear axle Connect cable inner to handbrake Fit backrest and seat cushion	e lever		"Pull" inner—A Push inner back Connect inner t	ssistant wards (inside c			
Fit masonite panels and mat Fit clip on rear axle			Fit masonite pa Fit rear seat cus	nel and mat hion			
Connect cable inner at wheel Adj rear wheel brakes Adj handbrake Refit RH seat			Connect inner t Adj rear sheel b Adj handbrake Install seat		t wneei		
Spares: Cable			-				
Handbrake cable, repalce compl	P0	55109	Handbrake cabl (wheel off)	es, lubricate in	ner, 1 side	P0-	5511
side (wheel off)		55105	See 55113 (P5-	-9)			
Cable replace, see 55109 (P5-9)			Handbrake cabl	es, lubricate in	ner,	H5-0	5511
landbrake cable, replace compleside (wheel off)	H5-0	55109	1 side (wheel of See 55113 (P5-		remove-ir	nstall spe	are whee
Cable replace, see 55109 (P5–9) In addition, remove-install spare v	wheel		Handbrake cabl		ner,	н1—	5511
Handbrake cable, replace compl 1 side (wheel off)	H1-	55109	Lubricate inner	, see 55113 (P			
Cable replace, see 55109 (P5–9) In addition, remove-install spare v	wheel						
Handbrake cables, replace both si (wheels off)	des P5-9	55111					

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applicable

See 55109 (P5-9), doubling time allowances where

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Handbrake cables, lubricate in both sides (wheels off)	ner P5-9	55115			1.0	
See 55113 (P5-9), doubling to applicable	ime allowances wh	ere				
Handbrake cables, lubricate in sides (wheels off)	ner both PO-	55115				
See 55113 (P0-), doubling tin	ne allowances wher	re				
Handbrake cables, lubricate in both sides (wheels off)	ner H5–0	55115	it.			
See 55113 (H5-0), doubling t	ime allowances wh	ere				
Handbrake cables, lubricate in both sides (wheels off)	ner H1–	55115				
See 55113 (H1-), doubling tine applicable	me allowances whe	re				
Handbrake, pawl or pawl rod i replace	n lever 5–	55120				
Slide back LH seat Remove rubber boot Remove split pin and pin—Psc Remove release button—Wco 1 Remove pawl and pawl rod—P Posn pawl and pawl rod Fit release button Fit pin and split pin—SCs, Drif Fit rubber boot Slide LH seat forward	10 pn					V
Spares: Pawl rod, pawl			-			
Handbrake, lever replace (reminstall)	ove- 5-	55122				
Remove LH seat Remove rubber boot Remove adjuster nuts—Stu 9/ 3/8, Tebm, Sdh 9/16 Remove circlip and pin—Pcsh	16, Ppo (Trh					
Remove lever from car—Drift Remove pin and split pin—Ppr Remove release button, pawl r Remove-install grip—Adhesive	od and pawl-Wco	10				
Posn pawl rod and pawl Fit release button Fit pin and split pin—SCs Posn lever in car and guide in	cable inners–Ppn					
Fit pin and circlip Fit adjuster nuts (not finally) Raise rear of car, adj rear when cables, lower car—Lj, Wsp, Stu Refit rubber boot		brake				
Refit LH seat Spares: Lever						

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SAAB

Metodbeskrivningar (ackordsmeddelanden)

Repair Work Descriptions

Methodenbeschreibungen

Framvagn, Styrinrättning Front assembly, Steering Vorderwagen, Lenkung

SAAB-SCANIA

Saab Car Division

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)124 5-	5	3	1	9							
)125 5-	2			2							
)126 5-	16	4	2	22							
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)130 5-	27	5	3	35							
)132 5-	38	6	4	48							
)134 5–	54	7	6	67							
)138 5–	67	7	7	81							
)160 5-	5		1	6							

60112

60104 Front wheel alignment (camber/caster 5and toe-in): check and adjust one side with rim-mounted instrument

Measurement see 60102 (5--)

Replace washers in front and rear bearings, 1 side-Trh (or 899576), Tebs, Sdh 9/16, Mcb

Measure and note values for 1 side

Measure toe-in

Write report

Adjust toe-in-under cardboard, Wco 7/8, Ppo (Wco 7/16)

Check, re-adjust and re-check if nec

Note values

60108 Front wheel alignment (camber/caster and toe-in): check and adjust both sides with rim-mounted instrument

Measurement, see 60102 (5-)

Replace washers in front and rear bearings, both sides-Trh (or 899576), Tebs, Sdh 9/16, Mcb

Measure and note values for both sides

Measure toe-in

Adjust toe-in-under cardboard, Wco 7/8, Ppo (Wco 7/16)

Check, re-adjust and re-check if nec

Note values

60110 Front wheel alignmnet (camber/caster and toe-in): checking with rim-mounted instrument, and toe-in adjust

Checking, see 60102 (5-)

Adjust toe-in, under cardboard, Wco 7/8, Ppo (Wco 7/16)

Check if nec re-adjust and re-check toe-in

Note values

60114 caster): checking with hub-mounting instrument, and adjust one side

Checking, see 60112 (5-)

Replace washers in front and rear bearings, 1 side-Trh (or 899576) Tebs, Sdh 9/16, Mcb

Re-check, note values

60118 5-Front wheel alignment (camber and caster): checking with hub-mounting instrument, adjust both sides

Checking, see 60112 (5-)

Replace washers in front and rear bearings, both sides-Trh, (or 899576) Tebs, Sdh 9/16, Mcb

Re-check, note values

60124 5-Toe-in check (Saab tool)

Roll car forward

Posn measuring tool and adjust at rear edge-784001, chalk

Roll car forward

Posn measuring tool at front edge and read off

60125 5-Front wheel alignment, checking KPI during camber/caster check

Read off KPI one side Read off KPI other side

Check that value obtained is correct

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		73-02	-02	1	60126	
oe-in check and adjust (Saa	ab tool) 5—	60126				
oll car forward	ib (001)	00120				
osn measuring tool and adj	ust rear edge-784001, ch	alk				
oll car forward		12, 11 km 1				
osn measuring tool at front djust tie-rod both sides—W		er card-				
oard, M1	60 770, 7710, (1 po), undo	i dard				
oll car to and from	M 1 0					
leasure at rear edge—78400 oll car forward	1. chalk					
osn measuring tool at front	edge and read off					
*						
ront wheel alignmet: measing angle (in conj with check		60127				
fter toe-in check:						
heck LH and RH turning a	ngle					
		20400				
ront wheel alignment (cam nd toe-in) check with hub-		60130				
heck camber/caster, see 60						
heck toe-in, see 60124 (5-						
2						
ront wheel alignment (cam		60132				
nd toe-in) check with hub- ool and toe-in adjust	mounted instrument and	Saab				
	110 (F)					
heck camber/caster, see 60 heck toe-in, see 60126 (5-						
ront wheel alignment (cam		60134				
nd toe-in) check with hub- ool, and adjust 1 side and t		Saab				
heck camber/caster and ad heck and adjust toe-in, see						
e-adjust toe-in and check						
*	*				47	
ront wheel alignment (cam		60138				
nd toe-in) check with hub- aab tool, and adjust both s						
ab tool, and adjust both s	ides and toe-in					
hook comban/costan and	livet both sides CO11C) (F.)				
heck camber/caster and ad heck and adjust toe-in, see		(0-1				
e-adjust toe-in and check	William II					
ront wheel alignment: pos		60160				
ar on work area for wheel						
love car to wheel alignmen ar in posn—floor area or ga						
	ls .					
al in posit—floor area of ga lign car and stand on plate to up/down far away from work area	98					

Repair Work — Standard Times SAAB 95/96

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63102	5	48	8	6	62	63145		5-	5		1	6
63102	6-	59	11	7	77	63150		5-	32	7	4	43
63103	5	41	6	5	52	63151		5-	25	5	3	33
63103	6-	52	9	6	67	63152		5-	29	6	4	39
63111	5	25	5	3	33	63153		5-	23	4	3	30
63111	6-	36	9	5	50	63154		5-	61	7	7	75
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63117	5-	10	3	1	14	To this s	heet	be long	4 sheets	of repair	r work	descripti
63128	5	68	10	8	86							
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63131	5-	17	5	2	24							
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63133	5-	11	2	1	14							
63134	5	52	9	6	67							
63134	6-	63	11	7	81							
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63137	5	44	7	5	56							
63137	6-	55	9	6	70							
63139	5	134	23	16	173							
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		4	73-01-02	1	63101	
Ball joint (removed) tighten, e	ach 5-	63101	Ball joint, uppe	r: tighten 1 side (wheel 5—	63111
Fit ball joint to vice			6	20 1 11		
Remove rubber boot—SCs			Undo locking—		A Tub	
Wipe away grease Undo locking—drift, H, SCch				oolt-Tah, Sdh 3/ g arm from ball jo		
Adjust ball joint—drift, H			Clean ball joint	y arm from ban je	JIII—CWD	
Lock ball joint—drift, H			Remove rubber	hoot_SCc 3		
Refit rubber boot			Wipe off grease	D001-3033		
			Undo locking—	trift A H SCah		
Spares: Rubber boot, ring, loc	k washer		Adjust ball join			
			Lock ball joint-			
-0		The second	Refit rubber bo			
Ball joints: tighten upper and I	ower, 5	63102	Refit steering a			
1 side (wheel off)			Posn centre shar			
Jack up front of car-Lj, Ltr			Fit fixing bolt a			
Remove wheel—SCs 10, Shhd	3/4 Tanr		Lock fixing bol			
Remove fixing bolt (lower ball		. Wco 5/8	Lubricate ball jo			
Undo locking (upper ball joint						
Remove fixing bolt—Tah, Sdh			Spares: Rubber	boot, lock washe	r, ring	
Lift and suspend steering knud	Activities of the second secon					
Remove steering arm—H			B.III.			00111
Clean upper ball joint—Cwb			Ball joint upper	: tighten 1 side	6–	63111
Remove rubber boot, wipe aw	ay grease—SCs		(wheel off)			
Undo locking-drift, SCch, H			Ball joint, uppe	r: tighten one side	e, see 63111 (5)	
Adjust ball joint-drift, H			Clean at inner L			
Lock ball joint,-drift, H			Remove clip at	rubber boot-783	846,731762	
Refit rubber boot—SCs			Separate UJ and	fit protective co	ver-Psc, Ppn	
Clean lower ball joint			Remove cover a	nd fit driveshaft	into inner UJ	
Remove rubber boot, wipe aw	ay grease		Refit rubber bo	ot and clip		
Undo locking			Spares: Ball join	t rubber boot, lo	ck washer ring	metal strap
Adjust ball joint			clip		ok washor, ring,	motar ot ap,
Lock ball joint						
Refit rubber boot			N N			
Posn steering knuckle on ball j			Ball joint upper	: tighten 1 side	5	63112
Fit fixing bolt (upper ball join	t)					
Lock fixing bolt Fit fixing bolt (lower ball joint	. 1			lding jack up/low	er car and remov	/e-install
Lubricate ball joints—grease gu			wheel			
Fit wheel—Ttg	111					
Lower car			Ball joint upper	tighten 1 side	6-	63112
Spares: Rubber boots, rings, lo	ck washers		See 63111 (6) a	dding jack up/lov	ver car and remo	ve-install
-		-	wheel			
Poll joints timbton		00400	4			
Ball joints, tighten upper and I 1 side (See 63102 (5) adding:	ower, 6–	63102	Dall teles 1	or desirable features of	(£) F	00440
1 side (See 63102 (9) adding:			Ball joint, lower	: 1 side (wheel of	f) 5—	63113
Clean at inner UJ rubber boot			See 63114 excl	jack up/lower car	r and remove-ins	tall wheel
Remove clip at rubber boot						
Separate UJ and fit protective		1761				
Remove cover and fit drivesha			Ball joint, lower	: 1 side	5	63114
Refit rubber boot and clip—Ps	c, Ppn		Domaya install	lower hall is int	00 62122	
Spares: Ball joint rubber boot	s rings lock washe	ers metal		lower ball joint, s nt (removed), see		
straps, clips	s, rings, rock was to	as, motor	- I igitten bali joli	it (removed), see	03101	
Ball joints, tighten upper and I	ower. 5	63103				
1 side (wheel off)						
and the second s		-0				
See 63102 excl jack up/lower	car and remove-inst	all wheel				
N. C.			, = ,			
Ball joints, tighten upper and I	ower 6-	63103				
1 side (wheel off)		30.00				

See 63102 excl jack up/lower car and remove install wheel

	Replaces page	73-01-02	1	63117			
Ball joints: tighten, each (front axle 5— 63117 assembly off) Clean ball joint—Cwb Remove rubber boot, wipe off grease—SCs Undo locking—drift, SCch, H Adjust ball joint—drift, H Lock ball joint, drift, H Refit rubber boot—SCs Lubricate ball joint—grease gun Ball joints: upper and lower replace, 5 63128 1 side Jack up front of car—Ltr, Lj Remove wheel—Tanr, Shhd 3/4, SCs Remove fixing bolt (lower ball joint)—Was 11/16, Wco·5/8 Undo locking (upper ball joint)—SCch, H3 Remove fixing bolts (2)—Tah, Trh, Shhd 3/4 Lift and suspend steering knuckle—hook Remove steering arm—H		Ball joint, lower: replace 1 side 5— 63132 Jack up front of car—Ltr, Lc Remove wheel—SCs 10, Shhd 3/4, Tanr Clean at lower ball joint and fixing bolts—Cwb, Ck Slacken fixing bolt (1)—Was 11/16, Wco 5/8 Remove fixing bolts (2)—Was 9/16, Wco 5/8 Withdraw ball joint from control arm Remove fixing bolt (1) Knock out ball joint—H Clean control arm mounting surfaces—Cwb Knock ball joint up into steering knuckle—H Posn and fit ball joint to control arm—Was 9/16, Wco 5/8 Tighten fixing bolts in steering knuckle Lubricate ball joint—grease gun Refit wheel Lower front of car—Ttg Spares: ball joint Ball joints, replace each (front axle 5— 63133					
Compress spring—Trh, Tebs, spring—Trh, spr	lts—Was 9/16, Wco 5/8 olts II joint) 2—Was 9/16, Wco 5/8	Remove ball Fit new ball Lubricate ne	ng bolts—Was 9/16, joint joint w ball joint—grease				
Withdraw ball joint from cont Fit new ball joint to control al Fit fixing bolts (upper ball join Lock fixing bolts Refit fixing bolts for lower ba Lubricate ball joints—grease go Refit wheel—Ttg Lower car Sapres: Ball joints	m nt) Il joint	Jack up fron Remove whe Release lock Remove fixi Compress sp Remove stee	ing—SCch, H ng bolts (2)—Shhd : ring—Trh, Tebs, spr ring arm—H	ing compressor 7			
Ball joints: upper and lower re 1 side Ball joints: upper and lower re adding: Clean at inner UJ rubber boot Remove clip at rubber boot Separate UJ and fit protective Remove cover and fit drivesha Refit rubber boot and clip—Ps Spares: Ball joints	place 1 side, see 63128 (5) cover—783846, 731762 ft into inner UJ	Remove ball Fit new ball Remove spri Refit steerin Posn centre Fit fixing bo	joint to control arn ng compressor g arm driveshaft in UJ olts and lock washer bolts III joint—grease gun Ttg	n	, wco 5/6		
Ball joints: upper and lower re 1 side (wheel off) See 63128 (5) excl jack up/lowheel		Ball joint, u Clean at inn Remove clip Separate UJ Remove cov	oper: replace 1 side oper: replace 1 side er UJ rubber boot at rubber boot and fit protective of er and fit driveshaft boot and clip	cover783846, 73			

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	Replaces page		73-01-02	Edition 1	Page 63135			
			73-01-02		03133			
Ball joints: rubber boots replace (front axle assembly off)	ce each 5—	63135	Spares: Steering	g arm, lockwash	ers, split pin			
Clean ball joint—Cwb Remove rubber boot, wipe off Fit new rubber boot	grease—SCs			le, steering arm de assembly off		63141		
Lubricate ball joint-grease gui Spares: rubber boot, ring	n		Clean tie rod e Remove split p Remove nut-V	in-Psc				
Ball joint, upper: replace 1 side 5 63137 (wheel off)			Remove tie-rod end—Was 18, 784004 Remove steering arm from ball joint—H Posn new steering arm					
See 63135 (5) excl jack up/lov	wer car and remov	e-install wheel	Refit tie-rod er	nds ·				
Ball joint, upper: replace 1 side	e 6—	63137	Spares: steering	g arm, split pin				
(wheel off) See 63135 (6-) excl jack up/lowheel	ower car and remo	ove-install		le: extra to 631 n, check, grease	39 for 5— and assemble upp	63143 er UJ		
Steering knuckle: replace incl replace 5— 63139 bearings and sealing rings, and clean and grease, 1 side			Remove balls from UJ–SCs, Hp Remove ball cage and driver Wash and blow dry all parts–cleaning area, Cag Check all parts					
Remove-install front axle asser Remove nut with seal from ste	mbly complete, seering knuckle—H	ee 475 82	Grease parts—S	Saab special grea all cage and balls				
Remove outer UJ rubber boot Remove (press) outer UJ from Remove bearings from steering Remove seals from steering kn	steering knuckle g knuckle nuckle and nut—H		replacement of	le: extra to 631 outer UJ rubbe		6314		
Remove protective shield (7—) Separate outer UJ from inner Clean (wash, blow) all parts, v faulty parts—cleaning area, Ca	driveshaft—H, 784 isually check and		See 47569— Ball joint rubb	er boots: lower :	replace 5—	6315		
Clean new steering knuckle Fit new seals—H, drift Grease bearings and outer UJ-	-Saah special grea	92	1 side	lower ball joint				
Fit protective shield (7-) -W Press bearing into steering knu	co 7/16 uckle-Press 78407		Replace rubber	boot, see 6313	5			
Assemble outer UJ to steering knuckle (press) Fit nut with seal to steering knuckle—H, drift Fit new circlip and fit shaft to UJ—Hp, 784161			Ball joint rubb 1 side (wheel o	er boots: lower (off)	replace 5—	6315		
Refit outer UJ rubber boot cli Spares: steering knuckle, sealin clip		earings if nec,	See 63132 and install wheel	63135 excl jack	k up/lower car and	remove-		
Steering knuckle, steering arm	replace 5-	63140	Ball joint rubb 1 side	er boots: upper	replace 5—	6315		
1 side Raise-lower car, remove-install			Clean at ball jo		wheel			
Clean at bolts and tie-rod end- Remove split pin—Psc Remove nut—Was 11/16	–Cwb, penetratin	g oil		g—SCch, Hf bolts—Tah, Sdh ng arm from ball				
Remove tie-rod end—Was 18, Release locking of upper ball j	joint-H, SCch		Remove rubbe Wipe—rag	r boot-SCs	== a1, z, ;}			
Remove upper ball joint bolt- Remove steering arm—H Suspend front axle assembly of		h #	Fit rubber boo Fit steering arr Fit bolts and le	n to ball joint				
Posn new steering arm Refit bolts with lock washers	n, willo-nook		Lock bolts Lubricate ball	joints— grease g		16. D		
Bend up locking tabs Refit tie-rod end Refit split pin-Psc, Ppn			Hemove-instal	Inner UJ rubbe	r boot clip (6—)—F	sc, Ppn		

Ball joint rubber boots: upper 5— 63153 replace 1 side (wheel off) See 63152 excl jack up/lower car and remove-install wheel Ball joint rubber boots: upper and 5— 63154 lower replace 1 side See 63150 and 63152 Ball joint rubber boots: upper and 5— 63155 lower replace 1 side (wheel off) See 63154 excl jack up/lower car and remove-install wheel Steering knuckle: brake disc protective 7— 63160 shield replace (front axle assembly not off) per side Raise-lower front of car—Ltr, Lj Ramove install wheel—Tanr, Sdh 3/4, Scs Remove and suspend brake housing—H, SCch, Was 11/16, hook Remove protectill wheel—Tanr, Sch 3/3, Tanr Fit puller—784002, Sdh 3/4, Tanr Remove wheel hub and brake disc—Tah, Mcb, H Remove protective shield—Wco 7/16 Clean mating surface for shield—Cwb, Cag, rag Fit new protective shield, locking plates, split pin Steering knuckle: protective shield, locking plates, split pin Steering knuckle: protective shield 7— 63161 for brake disc—Trotective shield—Wco 7/16 Clean mating surface for shield—Cwb, Cag, rag Fit new protective shield—Wco 7/16 Clean mating surface for shield—Cwb, Cag, rag Fit new protective shield—Wco 7/16 Clean mating surface for shield—Cwb, Cag, rag Fit new protective shield—Wco 7/16 Clean mating surface for shield—Cwb, Cag, rag Fit new protective shield—Wco 7/16 Clean mating surface for shield—Cwb, Cag, rag Fit new protective shield—Wco 7/16 Clean mating surface for shield—Cwb, Cag, rag Fit new protective shield—Wco 7/16 Clean mating surface for shield—Cwb, Cag, rag Fit new protective shield—Wco 7/16 Clean mating surface for shield—Cwb, Cag, rag		Replaces page		73-01-02	Edition 1	Page 63153	
Sall joint rubber boots: upper and 5— 63154 See 63150 and 63152 Sall joint rubber boots: upper and 5— 63155 Ower replace 1 side (wheel off) See 63154 excl jack up/lower car and remove-install wheel Steering knuckle: brake disc protective 7— 63160 Anise-lower front of car—Ltr, Lj Remove-install wheel—Tanr, Sdh 3/4, SCs Remove brake pads—Psc Remove and suspend brake housing—H, SCch, Was 11/16, hook Remove shigh pin and nut—Psc, Sdh 33, Tanr it puller—784002, Sdh 3/4, Tanr Remove wheel hub and brake disc—Tah, Mcb, H Remove protective shield—Wco 7/16 Izean matting surface for shield—Cwb, Cag, rag it new protective shield it hub and brake disc—Tig it nut and split pin it brake housing—Ppo Wash brake disc—Trich it brake pads Spares: Protective shield, locking plates, split pin Steering knuckle: protective shield 7— 63161 Or brake disc replace (brake disc off) Remove protective shield—Wco 7/16		5-	63153				
sall joint rubber boots: upper and 5— 63155 sall joint rubber boots: upper and 5— 63155 see 63154 excl jack up/lower car and remove-install wheel teering knuckle: brake disc protective 7— 63160 sided replace (front axle assembly not off) per side stalse-lower front of car—Ltr, Lj temove-install wheel—Tanr, Sdh 3/4, SCs temove brake pads—Psc temove pads—Psc temove split pin and nut—Psc, Sdh 33, Tanr it puller—784002, Sdh 3/4, Tanr temove wheel hub and brake disc—Tah, Mcb, H temove puller temove puller temove puller temove protective shield—Wco 7/16 telean mating surface for shield—Cwb, Cag, rag it new protective shield it hub and brake disc—Ttg it nut and split pin it brake housing—Ppo Asab brake disc—Tich it brake pads pares: Protective shield, locking plates, split pin teering knuckle: protective shield 7— 63161 or brake disc replace (brake disc off) teerove protective shield—Wco 7/16 teenove protective shield—Cwb, Cag, rag	ee 63152 excl jack up/lower	car and remove-ins	tall wheel				
Sall joint rubber boots: upper and 5— 63155 ower replace 1 side (wheel off) See 63154 excl jack up/lower car and remove-install wheel Steering knuckle: brake disc protective 7— 63160 hield replace (front axle assembly not off) per side daise-lower front of car—Ltr, Lj Remove-install wheel—Tanr, Sdh 3/4, SCs Remove brake pads—Psc Remove brake pads—Psc Remove split pin and nut-Psc, Sdh 33, Tanr Fit puller—784002, Sdh 3/4, Tanr Remove wheel hub and brake disc—Tah, Mcb, H Remove puller Remove protective shield—Wco 7/16 Remove protective shield—Cwb, Cag, rag it new protective shield—Tip it hub and brake disc—Ttg it nut and split pin it brake housing—Ppo Vash brake disc—Trich it brake pads Spares: Protective shield, locking plates, split pin Remove protective shield—Wco 7/16		and 5–	63154				
Steering knuckle: brake disc protective 7— 63160 hield replace (front axle assembly not off) per side Raise-lower front of car—Ltr, Lj Remove-install wheel—Tanr, Sdh 3/4, SCs Remove brake pads—Psc Remove split pin and nut—Psc, Sdh 33, Tanr Eit puller—784002, Sdh 3/4, Tanr Remove wheel hub and brake disc—Tah, Mcb, H Remove puller Remove protective shield—Wco 7/16 Remove protective shield—Cwb, Cag, rag Eit new protective shield—Iti pit Eit brake housing—Ppo Vash brake disc—Trich Eit brake pads Remove protective shield, locking plates, split pin Remove protective shield—Wco 7/16 Remove protective shield—Remove prot	ee 63150 and 63152						
Steering knuckle: brake disc protective 7— 63160 shield replace (front axle assembly not off) per side Raise-lower front of car—Ltr, Lj Remove-install wheel—Tanr, Sdh 3/4, SCs Remove brake pads—Psc Remove and suspend brake housing—H, SCch, Was 11/16, hook Remove split pin and nut—Psc, Sdh 33, Tanr Fit puller—784002, Sdh 3/4, Tanr Remove wheel hub and brake disc—Tah, Mcb, H Remove puller Remove protective shield—Wco 7/16 Clean mating surface for shield—Cwb, Cag, rag Fit new protective shield Fit hub and brake disc—Ttg Fit nut and split pin Fit brake housing—Ppo Wash brake disc—Trich Fit brake pads Spares: Protective shield, locking plates, split pin Steering knuckle: protective shield Fit protective shield—Wco 7/16 Remove protective shield—Wco 7/16 Remove protective shield—Wco 7/16 Remove protective shield—Wco 7/16 Clean mating surface for shield—Cwb, Cag, rag			63155				
Asise-lower front of car—Ltr, Lj Remove-install wheel—Tanr, Sdh 3/4, SCs Remove brake pads—Psc Remove and suspend brake housing—H, SCch, Was 11/16, hook Remove split pin and nut—Psc, Sdh 33, Tanr Fit puller—784002, Sdh 3/4, Tanr Remove wheel hub and brake disc—Tah, Mcb, H Remove protective shield—Wco 7/16 Clean mating surface for shield—Cwb, Cag, rag Fit new protective shield Fit nut and split pin Fit trake housing—Ppo Wash brake disc—Trich Fit brake pads Spares: Protective shield, locking plates, split pin Steering knuckle: protective shield—Wco 7/16 Clean mating surface (brake disc off) Remove protective shield—Wco 7/16 Clean mating surface for shield—Cwb, Cag, rag	ee 63154 excl jack up/lower	car and remove-ins	tall wheel				
Remove-install wheel—Tanr, Sdh 3/4, SCs Remove brake pads—Psc Remove and suspend brake housing—H, SCch, Was 11/16, hook Remove split pin and nut—Psc, Sdh 33, Tanr Fit puller—784002, Sdh 3/4, Tanr Remove wheel hub and brake disc—Tah, Mcb, H Remove puller Remove protective shield—Wco 7/16 Clean mating surface for shield—Cwb, Cag, rag Fit new protective shield Fit hub and brake disc—Ttg Fit nut and split pin Fit brake housing—Ppo Wash brake disc—Trich Fit brake pads Spares: Protective shield, locking plates, split pin Steering knuckle: protective shield For brake disc replace (brake disc off) Remove protective shield—Wco 7/16 Clean mating surface for shield—Cwb, Cag, rag							
Remove split pin and nut—Psc, Sdh 33, Tanr Fit puller—784002, Sdh 3/4, Tanr Remove wheel hub and brake disc—Tah, Mcb, H Remove puller Remove protective shield—Wco 7/16 Clean mating surface for shield—Cwb, Cag, rag Fit new protective shield Fit hub and brake disc—Ttg Fit nut and split pin Fit brake housing—Ppo Wash brake disc—Trich Fit brake pads Spares: Protective shield, locking plates, split pin Steering knuckle: protective shield For brake disc replace (brake disc off) Remove protective shield—Wco 7/16 Clean mating surface for shield—Cwb, Cag, rag	lemove-install wheel-Tanr, So						
Remove puller Remove protective shield—Wco 7/16 Clean mating surface for shield—Cwb, Cag, rag Fit new protective shield Fit hub and brake disc—Ttg Fit nut and split pin Fit brake housing—Ppo Wash brake disc—Trich Fit brake pads Spares: Protective shield, locking plates, split pin Steering knuckle: protective shield 7— 63161 For brake disc replace (brake disc off) Remove protective shield—Wco 7/16 Clean mating surface for shield—Cwb, Cag, rag	emove split pin and nut—Psc, it puller—784002, Sdh 3/4, T	, Sdh 33, Tanr anr	as 11/16, hoo	k			
Clean mating surface for shield—Cwb, Cag, rag Fit new protective shield Fit hub and brake disc—Ttg Fit nut and split pin Fit brake housing—Ppo Wash brake disc—Trich Fit brake pads Spares: Protective shield, locking plates, split pin Steering knuckle: protective shield For brake disc replace (brake disc off) Remove protective shield—Wco 7/16 Clean mating surface for shield—Cwb, Cag, rag	lemove puller						
Fit hub and brake disc—Ttg Fit nut and split pin Fit brake housing—Ppo Wash brake disc—Trich Fit brake pads Spares: Protective shield, locking plates, split pin Steering knuckle: protective shield 7— 63161 for brake disc replace (brake disc off) Remove protective shield—Wco 7/16 Clean mating surface for shield—Cwb, Cag, rag							
Fit nut and split pin Fit brake housing—Ppo Wash brake disc—Trich Fit brake pads Spares: Protective shield, locking plates, split pin Steering knuckle: protective shield 7— 63161 For brake disc replace (brake disc off) Remove protective shield—Wco 7/16 Clean mating surface for shield—Cwb, Cag, rag							
Wash brake disc—Trich Fit brake pads Spares: Protective shield, locking plates, split pin Steering knuckle: protective shield 7— 63161 for brake disc replace (brake disc off) Remove protective shield—Wco 7/16 Clean mating surface for shield—Cwb, Cag, rag	it nut and split pin						
Spares: Protective shield, locking plates, split pin Steering knuckle: protective shield 7— 63161 for brake disc replace (brake disc off) Remove protective shield—Wco 7/16 Clean mating surface for shield—Cwb, Cag, rag	ash brake disc—Trich						
Steering knuckle: protective shield 7— 63161 for brake disc replace (brake disc off) Remove protective shield—Wco 7/16 Clean mating surface for shield—Cwb, Cag, rag							
or brake disc replace (brake disc off) Remove protective shield—Wco 7/16 Clean mating surface for shield—Cwb, Cag, rag	pares: Protective shield, locki	ng plates, split pin					
Clean mating surface for shield—Cwb, Cag, rag			63161				
	emove protective shield—Wcc lean mating surface for shield	o 7 /16					

Repair Work - Standard Times SAAB 95/96

Saab Car Div			N			Repair Wo	ork —	- Stand	ard I	Pag		AD ,	33,30	
			Replaces pag	le		Jan. 1973		1			63208 -	64180		
Oper, No	Modelcode	Effective time	Secondary	Lost time allow- ance	Schedule time			delcode	Effecti time		Secondary time		Schedul	9
	d	1	ŀ	ance	I.		, i		ļ	i		ance	1	
63208	5-	68	7	8	83									
63209	5-	58	6	6	70									
63212	5	193	11	20	224									
63212	6-	204	13	22	239									
63213	5	183	11	19	213									
63213	6-	194	13	21	228									
63214	5	381	11	39	431									
63214	6-	403	13	42	458									
63215	5	366	11	38	415									
63215	6-	388	13	40	441									
63216	5-	95	11	11	117	31								
63217	5-	69	9	8	86	To this she	eet	belong 3	sheet	s o	f repair	work	descrip	tio
63218	5-	190	13	20	223		15							
63219	5-	139	11	15	165									
						1								
64101	5-7	6	1	1	8									
64101	8-9	5	1	1	7									
64101	0-	13	1	1	15									
64103	5-	7	1	1	9									
64104	5-7	7	1	1	9									
64104	8-9	6	1	1	8									
64104	0-	14	1	2	17									
64121	5-	15	1	2	18									
64123	5-	27	3	3	33									
64125	5-	44	5	5	54									
64174	5-	35	4	4	43									
64176	5-	49	5	5	59									
64178	5-	11	2	1	14									
64180	5–	16	2	2	20									

To be inserted in the file for REPAIR WORK DESCRIPTION

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			73-01-02	1		
Control arm, lower: replace 1 s Raise front of car—Lj, Ltr Remove wheel—Shhd 3/4, Tah	, SCs	63208	Fit shock absorb Fit wheel Lower front of c Spares: upper and	ar	9	
Clean at ball joint fixing bolts-		141 44/40	A			
Remove shock absorber lower Remove 1 fixing bolt—Wco 11,	/16, Was 5/8		Control arms, up	per and lower,	6-	63212
Remove lower control arm—Sh		eps, I an				- 14 J
Clean lower control arm—Cwb, Remove ball joint—Was 9/16, V					replace 1 side, see	63212 (5
Remove clamp—Shhd 15/16, T			Clean at inner U.	J rubber boot		
Press out bushing—tool 784134			Remove clip	Ela munato salus s	to al 702046	2 721762
Clean clamp-emery cloth			Remove cover ar		over-tool 783846	0, 731702
Refit bushing and clamp			Refit rubber boo			
Refit lower ball joint			-			
Refit control arm	14					
Refit lower ball joint fixing bo Refit shock absorber lower att			Control arms, up		5	63213
Refit wheel	acimient point		replace 1 side (w	heel off)		
Lower front of car			Control arms, up	per and lower,	replace 1 side, see	63212 (5
Consequent and arms bushings			excl raise-lower of			
Spares: control arm, bushings			-			
Control arm, lower: replace 1 : (wheel off)	side 5–	63209	Control arms, up		6-	6321
			Control arms, un	per and lower.	replace 1 side, see	
Control arm, lower: replace 1 s		—)			nd remove-install	
excl raise-lower car and remove	a-install wheel		-			
Control arms, upper and lower 1 side	replace 5	63212	Control arms, up)		6321
Raise front of car-Jack, axle s	stands			per and lower,	replace 1 side, see)
Remove wheel-SCs 10, Shhd			63213 adding: Clean at inner U	Lrubbar boot		
Clean at ball joint fixing bolts-	-steel wire brush		Remove clip	J Tubber boot		
Release locking—Hc 3, drift 5	7/4 T-6 T-6			fit protective of	cover-tool 78384	6, 731762
Remove 2 fixing bolts—Shhd 3 Remove lower ball joint fixing		Was 5/8	Remove cover ar	nd fit driveshaf	t into inner UJ	
Remove shock absorber lower			Refit rubber boo	ot and clip—Psc	, Ppn	
Free and suspend steering knu		1100 117 10		-1/		
Fit tool and compress spring-			0-4-1		replace 5	6321
Cut away rubber bumpers-SC	ch, Hc 3		Control arms, up	per and lower:	replace 5	0321
Remove spring from car						
Remove tool from spring				pper and lower:	replace 1 side, see	9
Remove steering arm—Hc 3 Remove lower and upper ball	ioints-Mac 0/16	Weo 5/8	63212 (5)			
Remove upper and lower cont						
2 x Tebl, Was 9/16			Control arms, up	per and lower:	replace 6-	6321
Clean upper and lower control		brush, knife	both sides			
Remove clamps—Shhd 15/15,			Control arms ur	oner and lower	replace both side	s see
Press out bushings—tool 78413	33, 784134		63214 (5)	per and lower	replace both side	3, 300
Clean clamps—emery cloth Refit bushings and clamps			Clean at inner U	J rubber boot		
Refit lower control arm			Remove clip			
Refit upper control arm					cover-tool 78384	6, 731762
Refit upper ball joint			Remove cover a			
Refit lower ball joint			Refit rubber boo	ot and clip—Pso	, εμπ	
Refit tool to spring				¥1)		1
Posn spring in car			Control arms, up	per and lower	replace 5	6321
Refit rubber bumpers Extend spring			both sides (whee			
Posn steering knuckle on lower	r ball joint				replace both side	ċ
Fit steering arm			see 63214 (5)	oper and lower	replace both side	3,
Engage shaft in UJ			See 032 14 (0)		The state of the s	
Fit and lock fixing bolt (upper						
Fit fixing bolt (lower ball join						

	Replaces page	Date	7	Edition	Page	
and the second second		73–01–	02	1	63215	
Control arms, upper and lower both sides (wheels off)	r: replace 6— 632	Control ar sides	m, upper	: replace both	5—	63218
Control arms, upper and lower (wheels off), see 63215 (5)	replace both sides:	Control ar Move tools		: replace, see r side	63216 (5–)	
Clean at inner UJ rubber boot		-	_			
Remove clip						2004
Separate UJ and fit protective				replace 2 sic		63219
Remove cover and fit drivesha		(power un	it out, ca	r on axle star	ia)	
Refit rubber boot and clip—Ps	c, rpn			e, see 63217	(5—)	
		Move tool:	s to othe	r side		
Control arm, upper: replace 1	side 5- 632	16				
Raise-lower front of car-Lj, L	tr .	Steering w	heel pos	ition adjust	5–7	6410
Remove-install wheel (1)—SCs						
Fit tool and compress spring-					4 (5-7) excl repl	ace
Cut away rubber bumpers-H,	SCch	and unpac	K new st	eering wheel		
Remove spring from car			K			
Remove spring attachment poi Sdh 9/16, Wco 5/8, H, drift	nt from control arm—I anr,	Steering w	heel pos	ition adjust	8–9	6410
Remove 4 control arm bearing	fixing holts and remove	See steerin	a wheel	replace 64104	1 (8–9) excl repla	ace
control arm—Trh 3/8, Sdh 9/1				eering wheel	r to of exerrepre	
Clean control arm—Cwb						
Remove bearings from control						
Press out bushings-Press, 784		Steering w	heel pos	ition adjust	0-	6410
Clean bushing surfaces—emery Fit bushings and bearings—Ter	cloth	See steerir	na wheel	replace, 6410	4 (0-) excl repla	ce and
Posn and install upper control	arm	unpack ne				
"Straighten up" steering knucl				*****		_
point					a la gara	0410
Posn spring				and: steering	5 g column out	6410
Fit rubber bumpers Extend spring, remove tool			·		g column out	
				ushing—SCs		
Spares: Bushings, control arm,	nuts			ng-SCs, H ing in rubber l	hushing	
				Cs, H, vice	ousimig	
Control arm, upper: replace 1	side (power 5- 632	F2. 1				
unit out, car on axle stand)	sido (potror o					_
Remove-install wheel (1)—Tan	r Sdh 3/4 SCs Tah	Charmina	hool so-	laca	57	6410
Fit tool and compress spring—		Steering w				
Cut away bumpers—H, SCch		Collect an			on right-hand sea	
Remove spring from car			t electric	cal leads (con	nector under instr	ument pa
Remove spring attachment po	int from control arm—Tanr,	nel) Remove h	orn butt	on		
Sdh 9/16, Wco 5/8, H, drift		B.				
Remove the 4 control arm bea —Tanr, Sre, Sdh 9616	ring bolts (engine compartm	CILLI		Sdh 15/16		
Remove upper control arm fro	ım car	Remove h				
Clean control arm—Cwb	Tr out			take off whee		
Remove bearings from control	arm-Sdh 15/16, Tah			pack new whe		
Press out bushings-Press, 784				orn ring, was	ner and nut	
Clean bushing surfaces—emery		Connect h				
Fit bushings and bearings—tem Posn upper control arm	iplate (70), soap solution	Connect				
Refit the 4 control arm bearin	as fixina bolts (engine	Check hor				
compartment)	a	Wipe affe				
"Straighten up" steering knuc		t Spares: W	heel			
point-H, drift, Tanr, Sddh 9/	16, Wco 5/8, 9/16	- Opares: VV				
Posn spring						
Fit rubber bumpers—Ppn						

Saah-Scania - Service Department-Kundendienstabteilung - Nykôping - S

Extend spring, remove tool

Spares: Bushings, control arm, nuts

	Replaces page		Date	Edition	Page	
			73-01-02	1	64104	
teering wheel replace	8-9	64104		ng column stand g column stand	bolts-Wco 1/2	
lemove safety pad lemove nut-Tah, Sdh 15/16 lark wheel posn-SCs	and Hone seat		Steering colum	nn stand (comple	ete): 5—	6417
lemove wheel leplace wheel and unpack new lount wheel, fit nut lefit safety pad	wheel		Fit steering co	ng column stanc lumn stand bolts lumn bolt—Tah	s 1/2, Wco 1/2	
/ipe clean pares: wheel			Assemble gears Adjust gear po Fit locking pin Assemble coup	Н	716	
teering wheel replace	0-	64104	Connect leads	to ignition lock to relay (incl fit	new rapid connec	tor)—Pclg
lemove four screws under who lemove nut and washer in hub lark wheel posn—pen lemove wheel	eel and horn butto		Check	ose wheel—Trh, Sdh (ground) lead—\		
leplace wheel and unpack new lount wheel on column lefit washer and nut	v wheel		Steering colum	ın stand, lower	5-	6417
it horn button and screws heck horn operation lipe clean pares: wheel			Remove locking	ds from ignition ng pin—drift, H	lock bolts-Wco 1/2	
teering column replace: (steer	ing 5—	64121	Lower steering	g column stand		
olumn stand out)	ing 5—	04121	Steering colun	nn stand, raise	5-	641
temove steering column from temove lead from steering col it lead to steering column it steering column to stand adjust direction indicator trip			Adjust gear po	teering column s osn-Wco 1/2 n-H to ignition lock		
teering column stand (comple emove (power unit out)	ete) 5—	64123	Herri Heater II	Ose		
ee steering column stand rem onnect earth (ground) lead an earbox						
teering column stand, (compl tall (power unit out)	ete): in 5—	64125				
ee steering column stand insta earshift UJ to gearbox and co						
teering column stand (comple emove	ete): 5—	64174				
Disconnect earth (ground) lead Remove steering wheel—Trh, S Remove heater hose						
ternove neater nose lemove steering column bolt– lemove gearshift UJ–Wco 5/1 Disconnect leads from ignition	6	2				
Disconnect leads from relay eparate coupling Remove headlamp control						

Repair Work - Standard Times SAAB 95/96

Saab Car Div			Replaces pag	е		Date		Edition		Pa	ge		
						Jan. 1973		1			64201 -		
Oper, No	Modelcode	Effective	e Secondary time	Lost time allow- ance	Schedule time	Oper, No	Mo	delcode	Effecti	ive	Secondar time	y Lost time allow- ance	Schedule time
			7	,									
64201	5-	27	10	4	41	4							
64203	5-	34	4	4	42								
64205	5-	26	6	3	35								
64207	5-8	46	6	5	57								
64207	9–	45	8	5	58								
64210	5-	41	5	5	51								
64211	5-	53	11	6	70								
64212	5-	24	4	3	31								
64213	5-	18	3	2	23								
64214	5-	96	6	10	112								
64215	5=	20		2	22								
64217	5-	33	4	4	41								
64218	5 - 8	127	15	14	156	To this sh	eet	belong a	4 sheet	S (of repai	work	descrip
64218	9–	172	18	19	209								
64219	5-	66	4	7	77								
64221	5-	12	5	2	19								
64223	5-	6	4	1	11								
64238	5-	58	6	6	70								
64275	5-8	91	11	10	112								
64275	9–	74	13	9	96								
64310	5-	34	6	4	44								
64313	5-	13	4	2	19								
64315	5-	13	6	2	21								
64317	5-	26	4	3	33								
64321	5-	21	8	3	32								
64325	5-	40	8	5	53								
64348	5-	56	6	6	68								
64381	5-	26	6	3	35								

Grease and assemble and shim ball joint LH-grease

Grease and assemble and shim ball joint RH

Lock LH and RH ball joints

Fit rubber boots

Repair Work Description SAAB 95/96

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Date Edition Replaces page Page 73-01-02 64201 Fit tie-rod end(s) 64201 Steering gear, remove (power unit Remove steering gear from vice out, front of car on axle stands) Arrange work area Remove front wheels both sides—Tanr, Shhd 3/4, SCs Spares: locking tabs, rubber boots if nec, clips Clean at tie-rod end and separate tie-rod end from RH steering arm-Tebs, Psc, 899540 Move tools to other side Steering gear (locking pin type): 64207 Clean at tie-rod end and separate tie-rod end from LH inner ball joints adjust (steering gear out) steering arm Remove the steering column clamping screw and separate-Mount steering gear in vice Wco 1/2, Was 1/2, MI Remove tie-rod end(s) and locknuts-Wadi, Wco 7/8 Detach insulating material on bulkhead Remove rubber boots-Psc, SCs Disconnect speedometer cable from steering gear Wipe clean inner ball joints and wipe hands-rag Remove steering gear fixing bolts—Tanr, Sre, Sdh 9/16 Connect power drill, fit drill to power drill-Mpd, drill Remove steering gear from car 4.75 mm Clean steering gear to remove grease and grit (rough cleaning)-Place rags around ball joints, centre punch and drill out lock-Csp ing pins on both sides-SCcp, H, rags Wash steering gear-cleaning area Separate ball joints LH and RH-784071, 783962 Wash and visually check ball joint parts-cleaning area Grease and assemble ball joints incl adjust-grease Steering gear: axial and radial play ad-64203 Cover ball joints with rags, centre punch and drill for locking just in car (car on axle stands) (excl lubrication) pins-rags, SCcp, Mpd, drill 4.75 mm Clean at adjusting screws-Cag, Cwb Fit locking pins and lock them by centre punching-SCcp, H Remove speedometer cable-Ppo Fit rubber boots Slacken lock nut-Wsp Fit tie-rod end(s) Slacken adjust screws for radial play-Wco 5/8 Remove steering gear from vice Remove bearing (cover)-Was 7/16 Arrange work area Shim and refit cover Spares: locking tabs, rubber boots if nec, clips Adjust radial play and fit locknut Refit speedometer cable 64210 5-Steering gear: axial and radial play adjust in car 64205 Steering gear install (power unit out, front of car on axle stands) Raise-lower front of car-Lj, Ltr Clean (wash, blow, dry) at steering gear bearing and adjust Posn steering gear in engine compartment, fit fixing boltsscrews Tanr, Sre, Sdh 9/16, Was 9/16 Disconnect speedometer cable from gearbox-Ppo Fit rubber grommet in bulkhead-SCs, MI Remove radial play adjuster nut-Wco 1 1/4 Install steering column and fit clamping screw-Wco 1/2, Slacken radial play adjuster screw until spring tension Was 1/2 ceases-Wadj 6 Attach bulkhead insulating material Check axial play (lift steering wheel) Connect speedometer cable to steering gear Remove bearing (cover)—Was 7/16 Connect tie-rod end to LH steering arm-Ttg, Sdh 11/16, Psc Shim and refit bearing Move tolls to other side Adjust pinion radial play Connect tie-rod end to RH steering arm Assemble in reverse order Lubricate steering gear and tie-rod ends-grease gun Lubricate steering gear Fit wheels both sides-Tanr, Shhd 3/4 Spares: shims Spares: split pins, nut (taper pin) Department-Kundendienstabteilung Steering gear: remove-install (replace) 64211 Steering gear (locking tab type): 64207 (power unit out, front of car on axle stands) inner ball joints adjust (steering gear out) Steering gear remove, see 64201 (5-) Mount steering gear in vice Steering gear install, see 64205 (5-) Remove tie-rod end(s) and locknuts-Wadj, Wco 7/8 Remove rubber boots-Psc, SCs Wipe clean inner ball joints and wipe hands-rags 64212 Steering gear: radial play adjust in car Remove ball joint locking tabs-H, SCch Separate inner ball joint and remove locking tab RH-784071 Raise, lower front of car-Lj, Ltr Clean at adjuster screw-Cag Separate inner ball joint and remove locking tab LH Slacken locknut-Wsp Wash and visually check ball joint parts-cleaning area Adjust radial play and tighten locknut-Wco 11/16, Wsp

Lubricate steering gear-grease gun

Saab Car Division

-Csp

Wash steering gear-cleaning area

Date Replaces page Edition Page 73-01-02 64213 Remove LH tie-rod end from new steering gear, where ap-64213 Steering gear: radial play adjust in 5plicable-Wco 7/8, Wadj car (front of car on axle stands, excl lubrication) Posn steering gear in engine compartment Clean at adjuster screw-Cag, Cwb Install steering gear fixing bolts Slacken locknut-Wsp Fit rubber grommet in bulkhead Adjust radial play and tighten locknut—Wco 5/8, Wsp Install steering column and fit clamping screw Attach bulkhead insulating material Refit freewheel control 64214 Steering gear: rubber boots replace, Refit gearshift UJ both sides Refit slave cylinder Refit speedometer cable Raise-lower front of car-Lj, Ltr Remove-install wheels (2)-Tanr, Sdh 3/4, SCas Reinstate throttle linkage Remove tie rod end-Wco 7/8, Tanr, Sdh 11/16, Psc Fit LH tie-rod end to tie-rod and steering arm-Ttg, Sdh Remove clip and boot 2 x -Psc, SCcs, MI 11/16, Psc Move tools to other side Clean both sides—Cag Fit tie-rod end RH to steering arm Fit new boot-SCcs Lubricate steering gear at tie-rod ends-grease gun Refit tie rod end 2 x Lubricate steering gear-grease gun Adjust toe-in-784001, Wco 7/8, Ppo Adjust toe-in-784001. Wco 7/8, Ppo Adjust steering wheel posn, see 64101 (5-7.) Move tools to other side Spares: split pins, nuts (taper pin) Steering gear: rubber boot replace 64215 9_ 64218 Steering gear remove-install (replace) (tie-rod end off) (incl remove-install brake servos) Remove clip and boot Steering gear remove-install see 64218 (5-8) Clean In addition vacuum cylinder remove-install, see 54104 Fit new boot 64219 5-Steering gear: rubber boots replace, 64217 Steering gear: rubber boot replace, 2 sides (wheels off, excl lubrication and toe-in adjust) 1 side (wheel off, excl lubrication and toe-in adjust) Rubber boots replace, 2 sides, see 64217 (5-) Remove tie-rod end-Psc, Was 11/16, Wco 7/8, 784004 Remove clip and boot—SCs, Psc Clean threads-Cwb, Ck 5-64221 Steering gear: axial and radial play Fit new boot adjust (steering gear out) Fit tie rod end Mount steering gear in vice Spares: boot complete Release spring tension for radial play-Trh 1/2, Sdhl 1/4, Wco 11/16 Adjust axial play-grease, Wco 7/16, Hp 64218 Steering gear: remove install (replace) 5-8 Adjust radial play-welding pliers Remove-install engine hood-SCs Tighten locknut Raise-lower front of car-Lj, Ltr Remove steering gear from vice Remove-install wheel-Tanr, Shhd 3/4, SCs Lubricate steering gear-grease gun Clean at tie-rod end, slacken locknut and remove LH tie-rod end from steering arm and tie rod-Wco 7/8, Cwb, Tanr, Sdh 11/16, Tebs, 899540, Psc, H, drift 5-64223 Steering gear: radial play adjust Move tools to other side (steering gear out) Clean at tie-rod end and remove RH tie-rod end from Mount steering gear in vice Slacken locknut-Trh 1/2, Sdhl 1/4, Wco 11/16 Remove slave cylinder from clutch hsg-Wco 1/2 Adjust radial play-welding pliers Remove gearshift UJ from gearbox—Wco 5/16 Tighten locknut Remove freewheel control from clutch hsg Remove steering gear from vice Remove speedometer cable from gearbox-Ppo Lubricate steering gear-grease gun Separate throttle linkage and change posn of spring-SCs Remove steering column clamping screw and separate-Wco 1/2, Was 1/2, MI Detach bulkhead insulating material Remove steering gear fixing bolts-Wco 9/16, Trh 3/8, Tebs, Sdh 9/16 Remove steering gear from car Clean steering gear to remove grease and grit (rough cleaning)

Saab Car Division Replaces page Date Edition Page 73-01-02 64238 64238 Remove steering gear from vice Steering gear: rubber boot replace, 5-Place small components in washing basket 1 side Place washing basket in washing machine and start-washing Raise-lower front of car-Lj, Ltr machine Remove-install wheel-Tanr, Shhd 3/4, SCas While washing machine is running, wash rack and steering Remove tie-rod end-Wco 7/8, Tanr, Sdh 11/16, Psc gear housing by hand-cleaning area Remove clip and boot-Psc, SCcs, MI Stop washing machine and take out basket Clean-Cag Visually check all parts Fit new boot-SCcs Replace piston bushing (not rack bushings)-H, drift Fit tie rod end Mount steering gear hsg in vice Lubricate steering gear-grease gun Posn spacer sleeve Adjust toe-in-784001, Wco 7/8, Ppo Grease and insert rack-grease Grease and install pinion, incl axial play adjust 1 -Wco 7/16 Grease and install piston, spring and nut Steering gear (locking tab type) 5-8 64275 Adjust radial play-welding pliers recond (steering gear out) Grease and assemble ball joints, incl adjust Cover ball joints with rags, centre punch and drill for locking Mount steering gear in vice Remove tie-rod (end(s) and locknuts-Wadj, Wco 7/8 pins-rags, SCcp, Mpd, drill 4.75 mm Remove rubber boots-Psc, SCs Fit locking pins and lock them by centre punching-H, SCcp Wipe clean inner ball joints and wipe hands-rags Fit rubber boots-SCcs Remove ball joint locking tabs-H, SCch Fit tie-rod end(s) Separate inner ball joint and remove locking tab RH-784071 Remove steering gear from vice Separate inner ball joint and remove locking tab LH 64310 5-Remove adjuster screw and spring for radial play-Trh 1/2, Tie-rod end, replace 1 side Sdhl 1/4, Wco 11/16 Raise-lower front of car-Lj, Ltr Remove pinion-Wco 7/16, Hp Remove install wheel-SCs 10, Tanr, Sdh 3/4 Remove rack and spacer sleeve Remove tie-rod end-784004, Psc, Was 11/16, Wadj 8 Remove piston Clean-Cwb Remove steering gear from vice Install tie-rod end Place small components in washing basket Adjust toe-in Place washing basket in washing machine and start-washing Lubricate tie-rod end-grease gun While washing machine is running, wash rack and steering Spares: tie-rod end, split pin gear housing by hand-cleaning area Stop washing machine and take out basket Visually check all parts Tie-rod end, replace 1 side (wheel 5-64313 Replace piston bushing (not rack bushings)-H, drift off, excl lubricating and toe-in adjust) Mount steering gear hsg .in vice Remove tie-rod end-Psc, Was 11/16, Wco 7/8, 784004 Posn spacer sleeve Clean threads-Cwb, Ck Grease and insert rack-grease Install tie-rod end Grease and install pinion, incl axial play adjust-Wco 7/16 Grease and install piston, spring and nut Adjust radial play—welding pliers Tie-rod end: rubber boot replace 1 side 64315 5-Install ball joint nut and locking tab LH (wheel off) Grease, assemble and shim ball joint LH Arrange work area Clean tie-rod end-Cwb Remove split pin-Psc Spares: locking pins, pinion bushing, rubber bots if nec, clips Remove nut-Was 11/16 Remove tie-rod end from steering arm-Was 18, 784004 Clean-Cwb Steering gear, locking pin type 9-64275 Remove locking and rubber boot-SCs 3 (recond) (steering gear out) Clean hands Mount steering gear in vice Fit rubber boot and locking Remove tie-rod end(s) and locknuts-Wadj, Wco 7/8 Fit nut and split pin Remove rubber boots-Psc, SCs Lubricate tie-rod end-grease gun Wipe clean inner ball joints and wipe hands-rags

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Remove rubber boots—Psc, SCs
Wipe clean inner ball joints and wipe hands—rags
Connect power drill, fit drill to power drill—Mpd, drill
4.75 mm
Drill out locking pips both sides

Drill out locking pins both sides
Separate ball joints both sides—784071, 783962

Remove adjuster screw and spring for radial play—Trh, 1/2,

Sdh 1 1/4, Wco 11/16

Remove pinion—Wco 7/16, Hp Remove rack and spacer sleeve

Remove piston

Tie-rod ends: replace 2 side (wheel off, excl lubricating and toe-in adjust)

Spares: locking ring, rubber boot

5-

64317

Tie roed-ends 2, see 64313

Saab Car Division Replaces page Date Edition Page 73-01-02 1 64321 Tie-rod ends: replace 1 side (excl toe-64321 in adjust) Raise-lower front of car-Lj, Ltr Remove-install wheel-Tanr, Sdh 3/4, SCs Remove tie-rod end-784004, Psc, Was 11/16, Wco 7/8 Clean threads-Cwb, Ck, lead lamp Install tie-rod end Lubricate tie-rod end-grease gun Spares: tie-rod end, split pin Tie-rod ends: replace 2 sides (excl 64325 toe-in adjust) Tie-rod end replace, see 64321 (5-) Tie-rod ends: replace both sides 5-64346 Raise-lower front of car-Lj, Ltr Remove-install 2 wheels-SCs 10, Tanr, Sdh 3/4 Remove tie-rod end-784004, Psc, Was 11/16, Wadj 8 Clean both sides—Cwb Install tie-rod end 2 x Adjust toe-in Lubricate tie-rod end 2 x-grease gun Spares: tie-rod ends, split pin Tie-rod ends: rubber boots replace 64381 2 sides (wheels off) Rubber boots replace 2 sides, see 64315 (5-)

SAAB

Metodbeskrivningar (ackordsmeddelanden)

Repair Work Descriptions

Methodenbeschreibungen

SAAB-SCANIA
Saab Car Division

Service Department NYKÖPING SWEDEN

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Repair Work - Standard Times SAAB 95/96

Saab Car Div	vision									imes SA		
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Oper, No.	Modelcode	Effective	Secondary	Lost time allow- ance	Schedule time	Oper. No		elcode	Effective			Schedule time
73102	5-	127	6	13	146	76124	1	H5 -	87	6	9	102
73104	5-	67	6	7	80	76141	í	P5 ~	16	4	2	22
73105	5-	56	6	6	68	76141		H5 -	37	3	4	44
73115	5-	112	6	12	130	76145	ſ	P5 -	31	4	4	39
73170	5-	35	6	4	45	76145	1	H5 -	74	3	8	85
73172	5-	35	6	4	45	76147	5	5-	22	2	2	26
73174	5-	65	6	7	78	76183	f	P5 -	53	4	6	63
73176	5-	67	6	7	80	76183	1	H5 -	96	5	10	111
73201	5-	10	1	1	12	77101	Ę	5 –	4	1	1	6
73202	5-	22	3	3	28	77104	Ę	5-	42	4	5	51
73203	5-	11	3	1	15	77108		5~	41	8	5	54
73204	5-	18	2	2	22	77110		ō -	6	1	1	8
73206	5-	38	3	4	45	77112	į	ō -	15	1	2	18
73212	5-	30	2	3	35	77115	Ę	5-	15	5	2	22
73215	5-	22	3	3	28	77122		ō-	27	1	3	31
73270	5-	18	3	2	23	77123	Ę	5-	18	4	2	24
73272	5-	23	3	3	29	77125	Ę	5-	36	4	4	44
73274	5-	11	3	1	15	77128	Ę	ő-	21	6	3	30
73276	5-	14	3	2	19	77130	Ę	5-	24	4	3	31
						77131	5	5-	29	8	4	41
76102	5-	18	5	2	25	77143	Ę	5-	72	6	8	86
76104	P5-	22	6	3	31	77145		5-	3			3
76104	H5-	47	6	5	58	77148	5	5-	28	3	3	34
76106	P5-	70	7	8	85	77150	Ę	5-	81	6	9	96
76106	H5-	121	8	13	142	77172	Ę	5-	3	1	1	5
76111	5-	11	2	1	14	77174	Ę	5-	14	1	2	17
76122	5-	32	5	4	41	77175	Ę	5-	14	3	2	19
76124	P5-	37	6	4	47	77176	5	5 -	14	1	2	17 Cor

-Scanja - Service Department-Kundendjenstabteilung - Ny

Spares: rubber bumpers

	Saab Car Division				nopuli wor			. 0,,		3,00
Ī		Replaces pa	ige		Date		Edition	Pag		
	N-1/2-1-1-1-1-1-1-1-1-1-1-1-1-1-1-1-1-1-1				73-01-02		1	73	102	
	Coil springs (front): replace be	oth sides	5-	73102	Stop straps, re	place	each (wheels	off)	5	73201
	See 73104 (5-) doubling all tollower car	ime allowar	nces except	raise-	See 73204 (5-	-) exc	d raise-lower	car, rei	nove-inst	all wheels
	Coil springs (front): replace 1	side	5-	73104	Coil springs (re		replace 1 side		5-	73202
	Jack up front of car	co.			Jack up rear of Remove wheel Remove shock	-SC				
	Remove wheel—Sdh 3/4, Tah, Fit tool to spring—special too Compress spring—special tool	1 784081	h		Remove stop s	trap-				
	Cut away rubber bumper-SC		"		Fit spring Jack up axle—					
	Remove spring Remove tool from spring—spe	cial tool 78	4081		Fit stop strap					
	Fit tool to new spring	*			Fit shock abso	rber				
	Lift off spring Fit rubber bumper—Ppo				Lower rear of	car				
	Remove tool				Torque-tighter	n whe	el-Ttg			
	Fit wheel Lower car, torque-tighten who	eel nuts-Tt	g		Spares: Coil sp	oring				
	Spares: Spring, rubber bumpe	r			Coil springs (re	ear):	replace, per si	de	5-	73203
	Coil envinge (front), vanlage w	nu sido	5-	73105	(wheel off)					
	Coil springs (front): replace po (wheel off)				See 73202 (5- wheels	-) ex	ol raise-lower	rear of	car, remo	ove-install
	See 73104 (5-) excl raise-low wheel	er front of	car, remov	e-install	Stop straps, re	nlace	1 side		5-	73204
	Coil spring (front): replace bo	th sides	5-	73115	Jack up car					
	(wheel off) See 73102 (5-) except raise-li				Remove whee Remove stop s Raise axle—Lj	strap-				
	See 73102 (5-7 except raise-in	Ovver car, re	illove-ilista		Fit stop strap					
	Coil springs (front): remove 1	side	5-	73170	Lower car Torque-tighter	مطيد م	ol Tta		6	
	See 73174 (5—) halving all tin lower car	ne allowanc	es except r	aise-	Spares: Stop s		ei – i tg			
den	Coil spring (front): install 1 si	de	5-	73172	Coil springs (r	ear):r	eplace both s	ides	5-	73206
schwe	See 73176 (5-) halving all tin				See 73202 (5-				except ja	acking
 Nyköping - Sweden-Schweden 	lower car									7708
NS - BI	Coil spring (front): remove bo	oth sides	5-	73174	Stop straps: re			V (5-	73212
yköpir	Jack up front of car	THE STATE OF		, , , , ,	See 73204 (5-	-) do	ubling all ope	rations	except ja	acking
	Remove wheel—Sdh 3/4, Tah Fit tool to spring—special too	1 784081			Coil springs (r	ear):	remove both	sides	5-	73270
abteil	Compress spring—special tool Cut away rubber bumper—SC		h		Jack up rear o		CHO/A T	, - T		
lienst	Remove spring		4004		Remove whee Remove shock				11/16	
Scania - Service Department-Kundendienstabteilung	Remove tool from spring-spe	ecial tool 78	4081		Remove stop		-SdhI 1/2, Tr	h, Teb	ľ.	
ment-K	Coil spring (front): install bot	h sides	5—	73176	2.					
eparti	Fit tool to new spring—specia Lift off spring	l tool 7840	81, Trh							
ice E	Fit rubber bumper-Ppo									
Serv	Extend spring—special tool 78 Fit wheel—Sdh 3/4, Tah	34082, Trh								
ania -	Lower, car, torque-tighten wh	neel nuts-T	tg							
Š										

Date Edition Page Replaces page 73-01-02 73272 Coil springs (rear): install both sides 5-73272 Spares: Shock absorber Install spring Jack up axle-jack Shock absorbers: front replace 2 5-76122 Fit stop straps-Sdh 1/2, Trh, Tebl Fit shock absorbers-Was 11/16 Raise-lower front of car-Lj, Ltr Fit wheels-Sdh 3/4, Tah Remove-install two wheels-SCs, Tanr, Shhd 3/4, Tah Lower car Replace shock absorbers, see 76111 (5-) Torque-tighten wheels-torque gauge Spares: coil springs 76124 P5-Shock absorbers: rear replace 2 Raise-lower rear of car-Lj, Ltr Coil springs (rear): remove 1 side 73274 5-Replace shock absorbers, see 76145 (P5-) See 73270 (5-) halving all time allowances except raiselower car 76124 Shock absorbers (lever type): rear H5replace 2 sides Coil springs (rear): install 1 side 73276 Raise-lower front of car-Lj, Ltr Remove-install two wheels-SCs, Tanr, Shhd 3/4, Tah See 73272 (5-) halving all time allowances except raise-Replace shock absorbers, see 76145 (H5-) lower car Shock absorbers: rear replace 1 P5-76141 76102 Shock absorbers: front replace 1 (car jacked up) Raise-lower front of car-Lj, Ltr Open trunk lid Remove-install wheel-SCs, Tanr, Shhd 3/4, Tah Remove top nuts and rubber bushing-Wco 9/16, Wadj Replace shock absorber, see 76111 (5-)-SCs, Was 11/16 Remove bottom nut-Was 9/16 Release shock absorber and take out rubber bushings—SCs Unpack and check shock absorber P5-76104 Shock absorbers: rear replace 1 Fit rubber bushings and position shock absorber Raise-lower rear of car-Lj, Ltr Fit bottom nut Replace shock absorber, see 76141-Wco 9/16, Wadj, Tah Fit top nuts 9/16, SCs Spares: Shock absorber 76104 Shock absorbers (lever type): rear H5-H5-76141 Shock absorbers (lever type): rear replace 1 side replace 1 (wheel off) Raise-lower rear of car-Lj, Ltr Clean and oil fixing bolt threads-Cwb, Moc Remove-install wheel-SCs, Tanr, Wadj 3/4, Tah Remove link arm from rear axle-Wco 11/16, SCs Replace shock absorber, see 76141 (H5-) Remove mounting plate and shock absorber Remove rubber bushing and sleeve Remove shock absorber from mounting plate-Trh, Tebs, P5-Shock absorbers: replace all 76106 Sdh 5/8 Raise-lower car-Lj, Ltr Check shock absorber Remove-install both front wheels-SCs, Tanr, Shhd 3/4, Tah Clean removed parts-Cwb Replace all shock absorbers, see 76183 (P5-)-Wco 9/16, Fit shock absorber to plate Wadj, SCs, Was 9/16, Was 11/16 Posn rubber bushing and sleeves for plate Fit shock absorber Fit link arm to axle 76106 Shock absorbers: replace all H5-Spares: Shock absorber Raise-lower car-Lj, Ltr Remove-install all wheels Replace shock absorbers, see 76183 (H5-) 76145 P5-Shock absorbers: rear replace 2 (car jacked up) Replace shock absorbers, see 76141 (P5-) Shock absorbers: replace front 1 5-76111 (wheel off) Remove bottom nut-Was 11/16 76145 H5-Shock absorbers (lever type): rear Remove top nut-Was 11/16 replace 2 (wheels off) Release shock absorber See 76141 (H5-) Remove rubber bushings-SCs Unpack, check absorber

Fit rubber bushings

Posn shock absorber, fit nuts

0 = 3	Replaces page	1	73-01-02	Edition 1	Page 76147	Ė.
Shock absorbers: front replace (wheels off) See 76111 (5-)	2 5–	76147	Wheels: remove-i See 77112 (5—) raise-lower car		5 – e allowances ex	77122 cept
Shock absorbers: replace all (ca jacked up, front wheels off) Front shock absorbers replace,		76183	Wheel balancing: See 77130 (5-)		sked up 5-	77123
Rear shock absorbers replace, s			Wheel balancing:		icked up 5-	77125
Shock absorbers: replace all (w	heels off) H5-	76183	See 77104 (5-)	excl jacking up		
Front shock absorbers replace, Rear shock absorbers replace,			Wheels: change 2 (summer/winter)		d 5—	77128
Wheels: remove-install each (ca jacked up)	r 5	77101	See 77112 (5)	incl cleaning ren	noved wheel	
See 77110 (5–) excl jack up ca	ar	-	Wheel balancing: remove-install	1 wheel incl	5-	77130
Wheel balancing: 2 wheels incl remove-install	5-	77104	Raise-lower rear Remove-install 1 Clean 1 wheel-0	wheel-SCs, Ta	nr, Sdh 3/4, Te	bl
Raise-lower rear of car—Lj, Ltr Remove-install two wheels—SC Clean 2 wheels—Cwb	s, Tanr, Sdh 3/4, T		Balance wheel, so and accessories		wheel balancing	g machine
Wheel balancing, see 77175 (5- machine and accessories	-), twice—wheel ba	niancing	Wheels: change v			77131
Wheels: change wheel supplied (summer/winter) all	5-	77108	See 77108 (5—)	excl jack up car		
See 77122 (5-) incl cleaning r	emoved wheels		Wheel balancing:	: 4 wheels (car ja	acked up) 5-	77143
			See 77150 (5—)	excl jacking up		
Wheel: remove-install 1 Slacken wheel bolts Jack up car and support on on		77110 tand	Wheel balancing:	: extra cleaning o	of wheel 5—	77145
Remove wheel—SCs, Sdh 3/4, Install wheel	Tanr		Removal of colle	ected grease		
Lower car Torque-tighten wheel bolts—T	tg		Wheel balancing	: 2 wheels (whee	els off) 5—	77148
Wheels: remove-install 2 (front	or rear) 5-	77112	See 77104 (5-)	excl jacking and	l remove-install	wheels
Slacken wheel bolts both sides Jack up car (front or rear)—jac	k, axle stands	77112	Wheel balancing	: 4 wheels, incl	5-	77150
Remove wheel on one side—SC Install wheel Remove wheel on other side	s, San 3/4, Tanr		Raise-lower car- Remove-install 4	wheels-SCs, T	anr, Sdh 3/4, T	ebl
Install wheel Lower car Torque-tighten wheel bolts—T	tg		Clean 4 wheels— Balance wheels, balancing machin	see 77175 (5-)		eel
Wheels: change 2 wheels suppl (summer/winter) (front or real		77115	Wheels: remove1		5	77172
See 77128 (5-) excl jack up c			Slacken wheel be Jack up car and Bemove wheel-			c, axle sta

Saab-Scania - Service Department-Kundendienstabteilung - Nyköping -

Repair Work Description SAAB 95/96

Saab Car Division			Repair Work I	Jesci iption	JAAD J	3/ 30
	Replaces page		73-01-02	Edition 1	Page 77174	
Wheels: remove all See 77188 (5–) doubling all ti raise-lower car	5 – me allowances exc	77174	Tires: replace each install wheels) (ca	n (incl remove-	5-	77204
Wheel balancing: 1 wheel, (who Clean wheel—Cwb Mount wheel on spindle—whee accessories Mount and fix spindle—(Tibo I	I balancing machi		Tires: replace 4 (in wheels) See 77202 (5-)	ncl remove-insta	II 5—	77206
HPA Automatic) Balance outside and inside Take off spindle, take off whee			Tires: replace 1 (v See 77202 (5-) e car		5— II wheel and re	77210 aise-lower
Wheels: install all See 77182 (5—) doubling all ti raise-lower car	5– me allowances exc	77176	Tires install 1 (wh Mount rim on stal Install valve—Ppo		5—	77212
Wheel balancing: 4 wheels (wh See 77150 (5—) excl jacking ar		77179 wheels	Brush soap solution Fit tire on rim—confit tire clamp Inflate and fit value Remove tire clam	ompressed air op ve core—(Make:		
Wheel: install 1 Fit wheel—Sdh 3/4, Tanr Lower car—jack Torque-tighten wheel bolts—T	5– tg	77180	Tires: replace (car	raised)	5-	77241
Wheels: install 2 (front or rear) Install wheel—Sdh 3/4, Tanr Lower car—jack Torque-tighten wheel bolts—T		77182	See 77206 (5—) ex Tires: replace 2 (ca See 77204 (5—)		5	77243
Wheels: remove 2 (front or rea Slacken wheel bolts, both side Jack up car, (front or rear)—ja	r) 5—	77188	Tires: replace 4 (ca	ar raised)	5-	77245
Remove wheels, both sides—SG Tires: replace 1 (incl remove-in		77202	Tires: replace 2 (w See 77202 (5) ex		5– emove-install	77247 wheels
wheel) Raise-lower car—Lj, Ltr Remove-install wheel—SCs, Ta Clean wheel—Cwbm bench bru Remove valve core Mount wheel on stand—compr Free tire from rim (both sides) Remove tire from rim Remove valve—Ppo Install valve Brush soap solution on rim Fit tire to rim Fit tire clamp Inflate and fit valve core	sh essed air operated	tire remover	Tires: replace 4 (w See 77206 (5—) ex		5— emove-install v	77249 wheels

Saab-Scania - Service Department-Kundendienstabteilung - Nyköping - Sweden-Schweden Remove tire clamp Inflate tire, remove w Remove wheel from stand

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			Replaces page	•		Jan. 1	973	1			7470	- 7724	2	
					1				T- co					
per. No	Modelcode	Effectiv	e Secondary time	Lost time allow- ance	Schedule time	Oper, No	Mo	delcode	Effecti	ve Se tin	condar ne	Lost time allow- ance	Schedi	116
Cont.														
77179	5-	57	5	6	68									
77180	5-	3	1	1	5									
77182	5-	8	1	1	10									
77188	5–	7	1	1	9									
77202	5-	31	4	4	.39									
77204	5-	56	4	6	66									
77206	5-	111	6	12	129									
77210	5-	21	3	2	26									
77212	5-	11	1	1	13									
77241	5-	25	4	3	32									
77243	5-	49	4	5	58									
77245	5-	98	6	10	114									
77247	5-	41	3	4	48									
77249	5-	82	5	9	96									
To this sh	neet belong	4 sheets	of repair	work	description									

Repair Work — Standard Times SAAB 95/96

			Replaces pa	ge		Date Jan. 1973	5	Edition 1				
per, No	Modelcode	Effective	Secondar time	y Lost	Schedule time	Oper. No		delcode	Effect			
		time	time	y Lost time allow- ance	time				time	time	time allow- ance	Lime
77401	5-	19	4	2	25							
77404	5	137	23	16	176							
77404	6	144	23	17	184							
77404	7-	147	25	17	189							
77405	5-	3	1		4							
77408	5	275	23	30	328							
77408	6	289	23	31	343							
77408	7-	294	25	32	351							
77416	5-0	47	7	5	59							
77416	1-	50	7	6	63							
77423	5-	4	2	1	7							
77428	5-0	84	7	9	100							
77428	1-	86	7	9	102							
77437	5-	8	7	1	16							
77439	5-	15	6	2	23							
77449	5-	5		1	6							
77451	5-0	36	7	4	47							
77451	1-	39	7	5	51							
77453	5-0	69	7	8	84	ľ						
77453	1-	72	7	8	87							
77455	5⊶	39	4	4	47							

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Rear wheel bearings, replace (drum off) Remove bearing and clean hu Install brg and grease hub—78	b–H, drift	77401	Front wheel (incl replace See 77404 (7	bearings: grease in 7—) doubl	replace 2 outer UJ) ing time a	sides	7–	77408
Clean brake drum Front wheel bearings: replace (incl replace grease in outer L. Remove-install front axle asset 47582 (5) Remove nut with seal from st 784020 Remove outer UJ rubber book Remove (press) outer UJ from Remove bearing from steering Remove seals from steering Remove seals from steering k Separate outer UJ from inner Clean (wash, blow) all parts, faulty parts—cleaning area, Ca Grease bearings and outer UJ Install seal in steering knuckle Press bearing into steering knuckle Press bearing into steering knuckle Fit nut with seal to steering k Fit new circlip and fit shaft to Refit outer UJ rubber boot cleans.	1 side 5 J) embly complete, see eering knuckle—H, dest clip—Psc in steering knuckle—pg knuckle nuckle and nut—H, destricted and repart of the shaft—H, 78420 Journally check and repart of the shaft—H, 784075—g knuckle—Press 784075—g knuckle—H, drift o UJ—Hp, 784161	77404 Prift, press Prift 02 place	Rear wheel b Jack up rear Remove whe Back off bral Remove drur Blow clean a Remove bear Install bearin Fit drum—Ta Adjust brake Adjust handl Fit wheel Lower rear o Spares: Ball b Rear wheel b	of car el ke shoes— m— , P nd check- ing and gre ah shoes, ch orake—Stu f car oearings, s	eplace 1 s Wsp 5/16 sc, H, Tar -vacuum lean hub ase hub neck pedal u 9/16 sealing rin	nr, Sdh cleaner, -H, driff 784032, travel a	SCs t, press , 033, H, (grease
Rear wheel bearings, replace (incl replace grease in outer L	1 side 6 JJ)	77404	See 77423 (S	er side 99)		ides	5-0	77423
Front wheel bearings, replace (incl replace grease in outer L Replace bearing, see 77404 (§	IJ)	77404	See 77416 (8 Move tools t	o other si	de		nces wher	e applicable
Rear wheel bearings: sealing r	ings replace 5—	77405	See 77415 (*) Move tool to	other sid	le			
Rear wheel bearings: sealing reach (drum off) Remove sealing ring—SCs Fit new sealing ring—Hp Wipe hands and drum Spares: Sealing ring Front wheel bearings: replace (incl replace grease in outer Use Move tools to other side Front wheel bearings: replace (incl replace grease in outer Use See 77404 (6) doubling time Move tools to other side	2 sides 5	77408	Front wheel ring replace, Remove ring Remove seal Wash ring—c Fit seal to ring to st	per side (from ster from ring leaning ar ng-Press,	brake dru ering knud g—H, drift rea drift	ı <mark>m/disc</mark> ckle–H,		77437
(incl replace grease in outer L See 77404 (5), doubling time Move tools to other side	JJ) allowances where ap	oplicable	Spares: Seali Front wheel ring replace,	ng ring bearings: per side	outer sea		5-	77439
Front wheel bearings: replace (incl replace grease in outer USee 77404 (6) doubling time Move tools to other side	JJ)	77408 plicable	Remove dru Remove nut Remove seal Wash nut—cl Fit seal to note Fit nut to st	and seal to from but leaning ar ut—Press,	from steer t–H, drift ea–Cab drift	ring knu		

Replaces page Date Edition Page 73-01-02 77449 Front wheel bearings: extra to bearings 77449 replace, for outer UJ rubber boot replace See 47569 Rear wheel bearings replace 1 side 5-0 77451 (wheel off) See 77416 (5-0) excl raise-lower car and remove-install wheel Rear wheel bearings: replace 1 side 77451 See 77416 (1) excl raise-lower car and remove-install wheel Rear wheel bearings: replace 2 sides 5-0 77453 (wheels off) See 77428 (5-0) excl raise-lower car and remove-install wheels Rear wheel bearings: replace 2 sides 77453 (wheels off) See 77438 (1-) excl raise-lower car and remove-install wheels Rear wheel bearings: replace 2 sides 77455 (drums off) See 77401 (5-) doubling time allowances where applicable

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Metodbeskrivningar (ackordsmeddelanden)

Repair Work Descriptions

Methodenbeschreibungen

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Kaross, Värme- och ventilationssystem Body, Heating and ventilation system Karosserie, Heiz- und Klimaanlage

SAAB-SCANIA
Saab Car Division

Service Department NYKÖPING SWEDEN

Repair Work — Standard Times SAAB 95/96

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Oper, No	Modelcode	Effective time	Secondary time	Lost time allow- ance	Schedule time	Oper. No		delcode	Effective			Schedule time
81103	8-	13	1	1	15	82203		5-	5	1	1	7
81114	5 - 9	33	1	3	37	82204		5-8	21	2	2	25
81114	0-	33	1	3	37	82204		9-	10	2	1	13
81116	5-9	45	5	5	55	82206		5-8	14	1	2	17
81116	0-	50	5	6	61	82206		9-	14	1	2	17
81118	5-9	57	5	6	68	82207		5-	7	1	1	9
81118	0-	69	5	7	81	82209		5-	5	4	1	10
81119	7-	7	1	1	9							
81120	5–9	66	6	7	79	To this s	heet	belong	6 sheets	of repair	work	descripti
81120	0-	78	6	8	92							
81121	5-	9		1	10							
81122	5 - 9	45	5	5	55							
81122	0-	50	5	6	61							
81124	5-9	62	6	7	75							
81124	0-	73	6	8	87							
81126	5 – 9	54	5	6	65					5%	No.	
81126	0-	65	5	7	7.7							
81129	5-	134	16	15	165							
81131	5-	244	18	26	290							
81133	5-	246	19	27	292							
81135	5-	361	22	38	421							
81137	5-	149	18	17	184							
81139	5-	261	21	28	310							
81141	5-	136	18	15	169							
81143	7-	4		1	5							
81145	H5-	4		1	5							
81147	1-	8		1	9							
81149	2-	2		1	3							

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			73-01-02	1	81103	
Floor, inner: remove-install cov plate at seat runner Remove-install seat runner and		81103 Cs, Wco 7/16	Floor, inner: fro remove-install pa	arts to expose flo		81118
Adjust seat runner			<u> </u>	r		-
Floor, inner: front part, remove parts to expose floor	e-install 5–9	81114	leads for alternat			81119
Clean hands Remove-install seats			Disconnect-conn			ery-Wco 1/
Remove-install rubber mat Remove-install front floor mat Remove-install rear floor mat Remove-install protection for fi Jack car (front)—Lj, Ltr	ittings		Floor, inner: fro sections, remove Clean hands Remove-install s			81120
Floor, inner: front part, remove parts to expose floor	e-install 0—	81114	Remove-install r Remove-install f Remove-install r Remove-install s	ront floor mat	cs)	
See 81114 (5-9)			Remove-install b	ackrest (SCcs)		
Floor, inner: front and middle s remove-install parts to expose f		81116	Sre, Sdh 5/8, Wa Remove-install e	xhaust pipe brac eat cushion supp	ket—Was 7/16 oort	ing oil, Tanı
Clean hands Remove-install seats Remove-install rubber mat Remove-install front floor mat Remove-install rear floor mat Remove-install seat cushion—(S	(Cool		Remove-install r Remove-install li Was 11/16	ear wheel—Tanr, ink arm at floor- protection for fit	Shhd 3/4, Tah -Tah, Sdh 11/1	6, Sre,
Remove-install seat belt at floor Sre, Sdh 5/8, Was 5/8 Remove-install exhaust pipe bra Remove-install protection for fi Jack car (front)—Lj, Ltr	r—Cwb, penetra acket—Was 7/16			nt, centre and re -install parts to e		81120
Floor, inner: front and middle stremove-install parts to expose f		81116	Floor, inner: ren Wheel	nove link arm and	d rear 5—	81121
See 81116 (5–9)			Remove link arn Free link arm fro			1/16, Sre
Floor, inner: front and rear sect remove-install parts to expose f Clean hands		81118		loor s—Tarn, Sdh 11/ Fanr, Shhd 3/4, T		/16
Remove-install seats Remove-install rubber mat Remove-install front floor mat			Floor, inner: cer	ntre section, remo	ove- 5–9	81122
Remove-install rear floor mat	Caal		See 81116 (5-9)		
Remove-install seat cushion—(S Remove-install backrest (SCcs)	(CCS)		-			
Remove-install seat cushion sup			Floor, inner: cer	ntre section, rem	ove- 0-	81122
Jack up car (front and rear)—Lj Remove-install rear wheel—Tan		ac .	install parts to e			
Remove-install rear wheel–Tan Remove-install link arm at floo Was 11/16	r–Tah, Sdh 11/		See 81116 (0-)			
Remove-install protection for f	ittings					

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Chisel away seat runner bracket from floor and free floor

Chisel away the floor metal section below the front cross-

Grind away welds from seat runner bracket and remove metal

sections-Hch

member-Hch

strip-Mrg, Hch

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Edition Replaces page Date Page 73-01-02 81124 Floor, inner: centre and rear sections, 5-9 81124 corresponds to the pressing of the floor section-Hch remove-install parts to expose floor Remove paint from edges of floor section-Mrg Posn and align floor section-H Clean hands Arrange welding equipment—ESAB A10—150 Remove-install seats Tack floor section in posn-setting 2-4-5 Remove-install rubber mat Weld floor section at sill-25 mm interrupted weld Remove-install front floor mat Weld floor section at cross-member Remove-install rear floor mat Weld floor section at front edge Remove-install seat cushion—(SCcs) Weld floor section at joint towards middle .of floor Remove-install backrest—(SCcs) Weld seat runner bracket Remove-install seat cushion support Remove-install seat belt at floor-Cwb, penetrating oil, Tanr, Knock together metal edges at join (from below)-H Clean the new floor section and joins all round-Cwb, Sre, Sddh 5/8, Was 5/8 Remove-install exhaust pipe bracket-Was 7/16 Clean at joins under car and at rear edge of wheel house-Jack car (rear)—Lj, Ltr Cwb, Csp Remove-install rear wheel-Tanr, Shhd 3/4, Tah Place paper on floor Remove-install link arm at floor-Tanr, Sdh 11/16, Sre, Was Mix primer-Herberts reactive primer 11/16 Apply primer to joins-brush Remove-install protection for fittings Drill hole in sill ends-low speed Mpd, taper sheet metal drill Drill hole in top of front cross-member Floor, inner: centre and rear sections, 0-81124 Fill container with anti-rust fluid-Tectyl 140 B remove-install parts to expose floor Fit spraygun to container See 81124 (5-9) Spray anti-rust fluid into sill-Tectyl 140 B Fit hose and pipe to spraygun Spray anti-rust fluid in front cross-member-Tectyl 140 B Floor, inner: rear sections, remove-5-9 81126 Remove hose and pipe install parts to expose floor Fill container with anti-rust fluid-Tectyl 122 A Change container on spraygun Clean hands Seal joins inside car-Fabi plastic putty, brush Remove-install seats Spray anti-rust fluid in the joins under the floor, on the new Remove-install rubber mat floor sections and on the rear edge of the wheelhouse-Tectyl Remove-install front floor mat 122 A Remove-install rear floor mat Remove spraygun from container Remove-install seat cushion—(SCcs) Clean spraygun-white spirit Remove-install backrest—(SCcs) Fit rubber plugs to sill ends-SCs Remove-install seat cushion support Spray paint on any parts of the floor not covered by the Jack up car (rear)-Lj, Ltr insulating mats-aerosol can Remove-install rear wheel-Tanr, Shhd 3/4, Tah Fit insulating mat to floor Remove-install link arm at floor-Tanr, Sdh 11/16, Sre, Was Fit wheelhouse insulation at bottom edge—Tikafast, brush Remove paper from floor Remove-install protection for fittings Spares: Front floor section, insulating mat, rubber plugs 81126 Floor, inner: rear section, remove**n**_ install parts to expose floor 5-81131 Floor, inner: front and centre section replace See 81126 (5-9) Free wheelhouse insulation at bottom edge-Hch, masking Floor, inner: front section replace 5— 81129 Remove insulating mats-Hch Mark out cutting point against centre line on floor-spare part, Free wheel house insulation at bottom edge-Hch, masking scriber tape Mark posn of exhaust pipe bracket-tape measure, scriber Remove insulation mat-Hch Drill away spot welds from front and rear edges of front Mark out cutting point against centre line on floor-spare cross-member-Ck, Mpd, 7 mm drill part, scriber Chisel groove for saw blade-Hch Chisel groove for saw blade-Hch Saw in scribed mark towards centre line of floor-Mms Saw in scribed mark towards centre line of floor-Mms Saw at front (at wheelhouse) saw at front Saw at front of and behind front cross-member Saw at cross-member Saw at rear cross-member Saw at sill Saw at sill Chisel away seat runner bracket from floor and free floor

section-Hch

strip-Mrg, Mms

sheet metal file, Cwb, Mrg

Grind away welds from seat runner bracket and remove metal

Remove paint and rust from edge of the sawn hole-Hch,

Modify forward-facing edge of cross-member so that it

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aab-Scania - Service Department-Kundendienstabteilung - Nykoping - Sweden-Schweden	Adjust (straighten) chisel edges Remove underbody compound members—Hch Remove paint and rust from edsheet metal file, Mrg Chisel slots for floor section at at wheelhouse)—Hch Remove and adjust seat belt nut Remove paint from the edges of Posn and align floor sections (of section must be bent lengthwise the floor and sill come on top of tape measure Arrange welding equipment—E. Tack floor sections at sill—25 in Weld floor sections at cross-me Weld floor sections at cross-me Weld floor sections at join town Weld at join between floor sections and the floor sections at join town Weld at join between floor section above but must be welded from Weld on seat belt nut Knock together metal edges at Clean the new floor sections and vacuum cleaner Clean at joins under car and at Cwb, Csp Place paper on floor Mix primer—Herberts reactive of Apply primer to joins—brush Drill hole in sill ends—low speed Drill hole in top of front cross-Fill container with anti-rust flufits spraygun to container Spray anti-rust fluid into sill—T Fit hose and pipe to spraygun Spray anti-rust fluid in front or Remove hose and pipe Fill container with anti-rust flu Change container on spraygun Spray anti-rust fluid in front or Remove hose and pipe Fill container with anti-rust fluid container spraygun Spray anti-rust fluid in the join floor sections and on the rear end Remove spraygun from container container spraygun—white spirit Fit rubber plugs to sill ends—SC Spray paint on any parts of the insulating mats—aerosol can Fit insulating mats—aerosol ca	5— 81131 s—H, backing from bottom of floor at cro lige of the sawn holes—Hch, the corners of the holes (not it—Hch, Mrg, vice of the floor sections—Mrg on installation the centre e so that the edges meeting of the old floor)—H, Lj, SAB A10—150 etting 2—4—5 nm interrupted weld mbers e (at wheelhouse) ards centre of floor ions or seat runner n edges are not accessible fro n below) join (from below)—H id joins all round—Cwb, rear edge of wheelhouse— orimer d, Mpd, taper sheet metal dri member id—Tectyl 140 B Tectyl 140 B T	Mix primer Drill hole in sill Fill container w Fit spraygun to Spray anti-rust Fit hose and pix Remove hose an Change contain Remove spraygu Clean spraygun Fit rubber plug Remove paper f Spares: Floor se mats, rubber plug Remove insulat Mark out cuttin part, scriber Mark posn of ex Mark out posn of the set square p sill, then move teg of the set sq fixing holes and centre lines. Th inside face of th Drill away spot Ck, Mpd, 7 mm Chisel groove fo Saw in scribed r Saw at front of Saw at front of Saw at rear cros Saw at sill Saw and chisel a Chisel away tee Remove metal s Chisel away the member—Hch Remove metal s Chisel away the member—Hch Remove metal s Chisel slots for (not at wheelho Grind away wel remove metal s Chisel slots for (not at wheelho Grind away wel remove metal st Chisel slots for (not at wheelho Grind away wel remove metal st Chisel slots for (not at wheelho Grind away wel remove metal st Chisel slots for (not at wheelho Grind away wel remove metal st Chisel slots for (not at wheelho Grind away wel remove metal st Chisel slots for (not at wheelho Grind away wel remove metal st Chisel slots for (not at wheelho Grind away wel remove metal st Chisel slots for (not at wheelho Grind away wel remove metal st Chisel slots for (not at wheelho Grind away wel remove metal st Chisel slots for (not at wheelho Grind away wel remove metal st Chisel slots for (not at wheelho Grind away wel remove metal st Chisel slots for (not at wheelho Grind away wel remove metal st Chisel slots for (not at wheelho Grind away wel remove metal st Chisel slots for (not at wheelho Grind away wel remove metal st Chisel slots for (not at wheelho Grind away wel remove metal st Chisel slots for (not at wheelho Grind away wel remove metal st Chisel slots for (not at wheelho Grind away wel remove metal st chisel slots for (not at wheelho Grind away wel remove metal st chisel slots for	ith confluince to the confluince of the confluence of the confluen	ds anti-rust fluid ntainer d into sill o spraygun oipe on spraygun from container sill ends on floor on front, floor centre and reace sulation at bot mats—Heh oint against cent ust pipe bracke ink arm fixing llel with and up set square alone e comes onto t e edge coincide mark off the se ill). Set square, lds from front ll ew blade—Heh k towards cent eelhouse) l behind front ember ongled partition nner mounting of at tunnel for or metal section y compound fr h o under rear cro or section at th)—Heh from seat runne —Mrg, Heh cor section at th)—Heh irom seat runne my, Heh cor section at th)—heh irom seat runne or section at th)—heh	section rear, insulating The section rear, insulating The section rear, insulating The section rear, insulating The section edge—Hch, masking The sect	e er
Saan	Place paper on floor						

	Replaces page	1					
		73-01-02	1	81137			
angled partition—Csp, Cwb Place paper on floor Mix primer—Herberts reactive p Apply primer to joins—brush Drill hole in sill ends—low speed Drill hole in top of front cross-lill container with anti-rust flu Fit spraygun to container Spray anti-rust fluid into sill—T Fit hose and pipe to spraygun Spray anti-rust fluid in front cr Spray anti-rust fluid into spring Remove hose and pipe Fill container with anti-rust flu	SAB A10—150 Itting 2—4—5 Inm interrupted weld Imbers Is (at wheelhouse) Intition (full weld at link arm Iteld) Indicated centre of floor Iteldors	cross-members—H Remove paint and sheet metal file, C Chisel slot for floo Remove and resto Remove paint fro Posn and align flo must be bent leng come on top of th Arrange welding e Tack floor section Weld on seat runn (Some parts of th from above but m Weld on seat belt Knock together m Clean the new flo vacuum clenaer Clean at joins und Place paper on flo Mix primer—Herb Apply primer to jo Drill hole in sill er drill Drill hole in top o Fill container with Fit spraygun to co	dy compound fich I rust from edge wb, Mrg or section at the re seat belt nut m edges of floo or section (on i thwise so that t le old floor)—H quipment—ESA in posn—settin lat sill—25 mm lat cross-memb lat front cross- lat join toward front section ler mounting br le floor section e lust be welded f nut letal edges at jo or section and j er car—Cwb, Cs or erts reactive pri pins—brush lat cross-me lat international low speed, of front cross-me latirust fluid- ontainer	e of the sawn hole—Hch, e corners of hole—Hch —Hch, Mrg, vice r section—Mrg nstallation the floor sectio the edges at the floor or sill , Lj, tape measure AB A10—150 ag 2—4—5 interrupted weld ter member s centre of floor acket edges are not accessible from below) ins (from below) oins all round—Cwb, sp mer Mpd, taper sheet metal ember —Tectyl 140 B			
Fill container with anti-rust flu Fit spraygun to container Spray anti-rust fluid into sill—T Fit hose and pipe to spraygun Spray anti-rust fluid in front cr. Spray anti-rust fluid into spring Remove hose and pipe Fill container with anti-rust flu Change container on spraygun Seal joins inside car—Fabi plast Spray anti-rust fluid in the join floor sections and on the rear enthe rear of the angled partition-Remove spraygun—white spirit Fit rubber plugs to sill ends—SC	id—Tectyl 140 B fectyl 140 B oss-member—Tectyl 140 B recess—Tectyl 140 B id—Tectyl 122 A ic putty, brush s under the floor, on the new dge of the wheelhouse and on —Tectyl 122 A er	Place paper on floor Mix primer—Herberts reactive primer Apply primer to joins—brush Drill hole in sill ends—low speed, Mpd, taper sheet metal					
Spray paint on any parts of the insulating mats—aerosol can Fit insulating mat to floor Fit wheelhouse insulation at bo Remove paper from floor Spares: Floor section front, floor mats, rubber plugs floor section	ttom edge—Tikafast, brush or section centre, insulating , rear	Remove spraygun Clean spraygun—v Fit rubber plugs t Spray paint on an insulating mat—ae Fit insulating mat Remove paper fro	from container white spirit o sill ends—SCs y parts of the fi rrosol can to floor m floor				
Floor, inner: centre section repl Remove insulating mat—Hch Mark out cutting point against opart, scriber Mark posn of exhaust pipe brac Drill away spot welds from rear—Ck, Mpd, 7 mm drill Chisel groove for saw blade—Hc Saw in scribed mark towards ce Saw at front cross-member Saw at rear cross-member Saw at sill Free floor section Chisel away the floor metal sec- member—Hch	centre line on floor—spare ket—tape measure, scriber edges of front cross-member h ntre line of floor—Mms	scriber Mark posn of exha Mark out posn of set square parallel then move the set leg of the set squa fixing holes and o	y mats—Hch point against ce aust pipe bracke link arm fixing with and up ag square along the re comes onto the ne edge coincid mark off the se	ntre line on floor—spare pare et—tape measure, scriber hole (posn one leg of the ainst the inside of the sill he sill so that the other the reinforced part at the es with one of the hole et square corner on the			

Remove spraygun from container

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Date Edition Replaces page Page 73-01-02 81141 5-81139 Clean spraygun—white spirit Fit rubber plugs to sill ends-SCs Drill away spot welds from front and rear cross-members-Ck, Spray paint on any parts of the floor not covered by the Mpd, 7 mm drill insulating mats-aerosol can Drill away spot welds at rear cross-member Fit insulating mat to floor Chisel groove for sawblade—Hch Remove paper from floor Saw in scribed mark towards centre of floor-Mms Saw at front cross-member Spares: Floor section, middle, floor section, rear, Saw at rear cross-member insulating mats, rubber plugs Saw at sill Saw and chisel at angled partition—Mms, Hch Free floor sections Floor, inner: rear section replace 5-81141 Remove metal strip at tunnel for link arm-Hch Chisel away the floor metal section below the front cross-Remove insulating mat-Hch Mark out cutting point against centre line on floor-spare member-Hch Remove underbody compound from bottom of floor at cross-members-Hch Mark out posn of link arm fixing hole (posn one leg of the Remove metal strip under rear cross-member-Hch set square parallel with and up against the inside of the sill. Chisel slots for floor section at the corners of the holes then move the set square along the sill so that the other leg Adjust (straighten) chiselled edges-H, backing of the set square comes on to the reinforced part at the fixing holes and one edge coincides with one of the hole centre Remove paint and rust from edge of the sawn holes-Hch, lines. Then mark off the set square corner on the inside face sheet metal file, Cwb, Mrg Remove and adjust seat belt nut—Hch, Mrg, vice of the sill)-set square, scriber Chisel groove for sawblade-Hch Remove paint from the edges of the floor sections-Mrg Saw in scribed mark towards centre of floor-Mms Position and align floor sections (on installation the centre section must be bent lengthwise so that the edges meeting the Saw at cross-member (on medel 95 approx 10 mm behind floor and sill come on top of the old floor. The rear floor cross-member) section is fitted in accordance with the marking made on the Saw at sill Saw and chisel at angled partition—Mms, Hch sill. Check also the dimension to the link arm on the other Free floor section side)-H, Lj, set square, tape measure Apply Cool-Heat to brake pipes Remove metal strip at tunnel for link arm-Hch Arrange welding equipment—ESAB A10—150 Chisel slots for floor section in the rear corners of the sawn Tack floor sections in posn-setting 2-4-5 hole-Hch Weld floor sections at sill-25 mm interrupted weld Modify the rear edge of the cross-member so that it corre-Weld floor sections at cross-members sponds with the pressing of the floor section Weld floor section to angled partition (full weld at link arm Remove paint and rust from edge of the sawn hole-Hch, panel otherwise interrupted weld) sheet metal file, Cwb, Mrg Cut away approx. 10 mm of the front edge of the spare Weld floor sections at join towards centre of floor floor section (only on Model 95)-Mms Weld on seat runner mounting bracket (Some parts of the floor section edges are not accessible Remove paint from the edges of the floor sections-Mrg from above but must be welded from below) Posn and align floor section (align the floor section in Weld on seat belt nut accordance with the mark on the sill, check also the Remove Cool-Heat from brake pipes-rag dimension to the link arm on the other side)—set square, Knock together metal edges at join (from below)—H tape measure, H Clean the new floor sections and joins all round—Cwb, Apply Cool-Heat to brake pipes vacuum cleaner Arrange welding equipment—ESAB A10-150 Clean at joins under car, and at the rear of the angled Tack floor section in posn-setting 2-4-5 partition—Csp, Cwb Weld floor section at sill-25 mm interrupted weld Place paper on floor Weld floor section at cross-member Mix primer—Herberts reactive primer Weld floor section to angled partition Apply primer to joins-brush (Full weld at link arm panel, otherwise interrupted weld) Drill hole in sill ends—low speed, Mpd, taper sheet metal drill Weld floor section at join towards centre of floor Drill hole in top of cross-member Remove Cool-Heat from brake pipes-rag Fill container with anti-rust fluid—Tectyl 140 B Fit spraygun to container Knock together metal edges at join (from below)-H Clean the new floor section and joins all round-Cwb, Spray anti-rust fluid into sill—Tectyl 140 B vacuum cleaner Fit hose and pipe to spraygun Clean at joins under car, and at the rear of the angled Spray anti-rust fluid in front cross-member—Tectyl 140 B partition-Csp, Cwb Spray anti-rust fluid into spring recess—Tectyl 140 B Place paper on floor Remove hose and pipe Mix primer-Herberts reactive primer Fill container with anti-rust fluid-Tectyl 122 A Apply primer to joins-brush Change container on spraygun Drill hole in sill ends-low speed, Mpd, sheet metal drill Seal joins inside car-Fabi plastic putty, brush Fill container with anti-rust fluid-Tectyl 140 B Spray anti-rust fluid into the joins under the floor, on to the Fit spraygun to container new floor sections and on the rear of the angled partition-Spray anti-rust fluid into sill-Tectyl 140 B Tectyl 122 A Fit hose and pipe to spraygun

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			73-01-02		81143	
Fit hose and pipe to spraygun Spray anti-rust fluid in front cr	5– oss-member–Tec	81141 tyl 140 B	Spares: Cable co			
Remove hose and pipe Fill container with anti-rust flu	id-Tectyl 122 A		Hood lock repla	ce (remove-instal	II) 5–8	82206
Change container on spraygun Seal joins inside car—Fabi plast Spray anti-rust fluid into the jo new floor section and on the re Tectyl 122 A	ic putty, brush oins under the floo		Remove-install (Remove lock (a	engine hood—SCs nd inner wire) fro I inner wire) at fr	s om front panel–	
Remove spraygun from contain Clean spraygun—white spirit Fit rubber plugs to sill ends—Si			Spares: Lock			
Spray paint on any parts of the insulating mat Fit insulating mat to floor		d by the	(incl remove-ins	ace (remove-insta tall centre grille)		82206
Remove paper from floor Spares: Floor section, rear insu	lating mats, rubbe	er plugs	Remove-install and Remove centre Remove lock—S		5	
Floor, inner: remove-install sea	t 7–	81143	Install lock Install centre gr Check operation	ille		
Clean seat belt bolt (under car) Remove-install seat belt at floo			Spares: Lock			
Floor, inner: remove-install spa wheel		81145	from front pane	rom bulkhead-P		82207
Remove-install spare wheel and	l guard		- Spares: Cable co	mplete		
Floor, inner: remove-install flo		81147	Hood lock: was	h and lubricate (d	off) 5	82209
Floor, inner: remove-install hea		81149	- Wash, blow clea Cag, Vaseline	n and grease hoo	d lock-washing	facilities,
seat lead Disconnect-connect heated sea	t lead					
			·			
Hood lock replace (remove-inst	tall) 5—	82203				
Remove lock—SCcs, Ppn Install lock						
Spares: Lock						
Hood lock cable (and hood loc replace	:k) 5–8	82204	*	*		
Remove-install engine hood—S Remove inner wire (at lock) from Remove cable from car—Wco 3 Install cable in car Install inner wire (and lock) or Check operation	om front panel—2 8/4, Ppo, MI	SCcs				
Sparas: Cable complete						
Hood lock cable: replace	9–	82204	a a a a a a a a a a a a a a a a a a a			

Remove cable from car-SCs, SCcs, Ppn, Wco 3/4, Ppo, MI

Repair Work - Standard Times SAAB 95/96

Saab Car Division					Repair Work — Standard Times CAAD 30/30						
			Replaces page	9		Jan. 197	Edition	P	82304 -	83154	
Oper, No.	Modelcode	Effective time	Secondary time	Lost time allow- ance	Schedule time	Oper, No	Modelcode	Effective			Schedule time
82304	9-	17	1	2	20	83114	5-9	20	1	2	23
.82306	56	34	2	4	40	83114	9-	5	1	1	7
82306	7-8	40	2	4	46	83115	5-	11	2	1	14
82306	9-	34	2	4	40	83121	5-	15	5	2	22
82312	5-8	43	2	5	50	83123	5-0	187	20	21	228
82312	9-	6	1	1	8	83123	1-	200	20	22	242
						83125	5-8	241	20	26	287
82550	5-	21	4	3	28	83125	9–0	248	20	27	295
82551	5-	14	3	2	19	83125	1-	261	20	28	309
82570	5-	17	2	2	21	83127	5-0	208	18	23	249
82574	5-	33	4	4	41	83127	1-	228	25	25	278
82588	5-	32	2	3	37	83128	5 - 8	311	24	34	369
82590	5-	64	4	7	75	83128	9-0	319	24	34	377
82592	5-	199	11	21	231	83128	1-	332	24	36	392
						83129	5-8	261	18	28	307
82642	5-	6	1	1	8	83129	9-0	268	18	29	315
82670	5-	37	5	4	46	83129	1-	28.1	18	30	329
82674	5-	64	7	7	78	83130	5-0	258	24	28	310
82688	5-	71	5	8	84	83130	1-	270	24	29	323
82690	5-	121	7	13	141	83132	5-	49	5	5	59
82692	5-	362	14	38	414	83134	5-	98	11	11	120
						83136	1-	15	1	2	18
83104	5–8	202	14	22	238	83141	5-	11	2	1	14
83104	9–0	209	14	22	245	83142	5-0	276	23	30	329
83104	1-	229	21	25	275	83142	1-	296	30	33	359
83106	5-	38	4	4	46	83152	5-	38	4	4	46
83108	5-	65	11	8	84	83154	5-8	329	23	35	387
83110	5-	16	2	2	20	83154	9–0	336	23	36	395
83112	5-	5	1	1	7					C	Cont.

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	l <u> </u>		1-02	1	82304	
Front panel: centre grille and s grilles replace Remove centre grille—SCcs	ide 9– 8	Remo Install	ve centre gril l centre grille		9—	82312
Remove headlamp rims—SCcs		Remo	ve-install bac	lge		
Remove side grilles, twice		Spare	s: Centre grill	le Badge		
Install side grilles, twice		- Oparot	or contro grin	o, Budgo		
Install headlamp rims Install centre grille						
Remove-install badge				strip replace 1	5—	82550
Spares: Centre grille, Side grille	LH, Side grille RH, I	Remo		of car—Lj, Ltr eel—SCs, Tanr, —SCs, Pop	Sdh 3/4, Tah	
Front panel: remove-install co		Fit cli	ps to new str m strip			
Remove-install engine hood—S				iderseal-unders	eal, brush	
Remove hood lock and radiato		Clean	brush			
Remove radiator upper suspen Remove stay fixing bolts—Wco Remove leads for headlamps a	7/16, SCcs	Spares	s: Trim strip,	clip		
Remove leads for fleadiamps al Remove front panel Posn front panel		7/16 Front (whee		strip replace 1	5-	8255
Fit fixing bolts		Con Of	2550 (5 \)	vol inclains and	ramava install	wheel
Connect hood lock and radiate Refit radiator suspension	or blind wires	See 82	2000 (D—), e	xcl jacking and	remove-mstall v	wneel
Refit strip		Front	fender: remo	ove 1	5-	82570
Refit stay		la allo v				
Fit leads	The Later Control of the Control of		up front of ca	ir, Lj, Lu inr, Sdh 3/4, SC	e 10	
Check operation of headlamps				Ccs, SCac, Was		
Check operation of hood lock	and radiator pilled	Titlino 1		20,000,110		
Front panel: remove-install cor	mplete 9– 8	,2000	fenders: inst		5-	8257
Remove-install engine hood—S Remove stay bracket—Wco 7/1 Remove wheel housing bracke	16, SCcs	Install		r—SCcs, SCac, V r, Sdh 3/4, Tah	Vas 7/16	
Remove wheel housing bracke Remove headlamp rims—SCcs Remove clips behind headlamp						
Remove upper radiator mount	ings-Wco 1/2		fenders: rem	ove 2	5-	82588
Remove hand lack wire and as	able attachments—SCo	os, Pfl Jack u	p front of ca	ar-Lj, Ltr		
	ff front			-SCs 10, Tanr, S	6dh 3/4	
Remove headlamp leads, lift o				CC CC W	The state of the s	
Remove headlamp leads, lift of Position front, arrange sealing		Remo	ve 2 fenders-	-Sucs, Suac, W	as 7/16	
Remove headlamp leads, lift of Position front, arrange sealing Refit bracket in wheel house		Remo	ve 2 fenders-	-SCcs, SCac, vv	as 7/16	
Remove headlamp leads, lift of Position front, arrange sealing Refit bracket in wheel house Refit hood lock wire Refit clips behind headlamps			re 2 fenders-		as 7/16 5-	82590
Remove headlamp leads, lift of Position front, arrange sealing Refit bracket in wheel house Refit hood lock wire Refit clips behind headlamps Refit headlamp rims	strips	Front	fenders: inst	all 2	5-	
Remove headlamp leads, lift of Position front, arrange sealing Refit bracket in wheel house Refit hood lock wire Refit clips behind headlamps Refit headlamp rims Refit upper radiator mounting	strips	Front	fenders: inst	all 2 r, twice—SCcs, s	5 – SCac, Was 7/16	
Remove headlamp leads, lift of Position front, arrange sealing Refit bracket in wheel house Refit hood lock wire Refit clips behind headlamps Refit headlamp rims Refit upper radiator mounting Refit stay bracket	strips	Front Install Install	fenders: inst I front fende I wheels—Tar	all 2 r, twice—SCcs, s rr, Sdh 3/4, Tah	5 – SCac, Was 7/16	
Remove headlamp leads, lift of Position front, arrange sealing Refit bracket in wheel house Refit hood lock wire Refit clips behind headlamps Refit headlamp rims Refit upper radiator mounting Refit stay bracket	strips	Front Install Install	fenders: inst	all 2 r, twice—SCcs, s rr, Sdh 3/4, Tah	5 – SCac, Was 7/16	
Remove headlamp leads, lift of Position front, arrange sealing Refit bracket in wheel house Refit hood lock wire Refit clips behind headlamps Refit headlamp rims Refit upper radiator mounting Refit stay bracket	strips	Front Install Install	fenders: inst I front fende I wheels—Tar	all 2 r, twice—SCcs, s rr, Sdh 3/4, Tah	5 – SCac, Was 7/16	
Remove headlamp leads, lift of Position front, arrange sealing Refit bracket in wheel house Refit hood lock wire Refit clips behind headlamps Refit headlamp rims Refit upper radiator mounting Refit stay bracket	strips	Front Install Install	fenders: inst I front fende I wheels—Tar	all 2 r, twice—SCcs, s rr, Sdh 3/4, Tah	5 – SCac, Was 7/16	
Remove headlamp leads, lift of Position front, arrange sealing Refit bracket in wheel house Refit hood lock wire Refit clips behind headlamps Refit headlamp rims Refit upper radiator mounting Refit stay bracket Refit hood lock cable to stay Check operation of hood lock Front panel: centre grille replacemove-install engine hood—S	strips bolts ce 5–8 8	Front Install Install Lower	fenders: inst I front fende I wheels—Tar	all 2 r, twice—SCcs, s rr, Sdh 3/4, Tah	5 – SCac, Was 7/16	
Remove headlamp leads, lift of Position front, arrange sealing Refit bracket in wheel house Refit hood lock wire Refit clips behind headlamps Refit headlamp rims Refit upper radiator mounting Refit stay bracket Refit hood lock cable to stay Check operation of hood lock Front panel: centre grille replatemove-install engine hood—Semove radiator screen plates-	strips bolts ce 5–8 8 Cs –SCcssh	Front Install Install Lower	fenders: inst I front fende I wheels—Tar	all 2 r, twice—SCcs, s rr, Sdh 3/4, Tah	5 – SCac, Was 7/16	
Remove headlamp leads, lift of Position front, arrange sealing Refit bracket in wheel house Refit hood lock wire Refit clips behind headlamps Refit headlamp rims Refit upper radiator mounting Refit stay bracket Refit hood lock cable to stay Check operation of hood lock Remove-install engine hood—Şemove radiator screen plates-Slacken fixing stay—Wco 7/16, Blacken front and radiator models.	bolts ce 5–8 8 Cs –SCcssh , SCcs	Front Install Install Lower	fenders: inst I front fende I wheels—Tar	all 2 r, twice—SCcs, s rr, Sdh 3/4, Tah	5 – SCac, Was 7/16	
Remove headlamp leads, lift or Position front, arrange sealing Refit bracket in wheel house Refit hood lock wire Refit headlamp rims Refit headlamp rims Refit upper radiator mounting Refit stay bracket Refit hood lock cable to stay Check operation of hood lock Remove-install engine hood—Semove radiator screen plates-Glacken fixing stay—Wco 7/16, SCcs	bolts ce 5–8 8 Cs –SCcssh , SCcs	Front Install Install Lower	fenders: inst I front fende I wheels—Tar	all 2 r, twice—SCcs, s rr, Sdh 3/4, Tah	5 – SCac, Was 7/16	
Remove headlamp leads, lift of Position front, arrange sealing Refit bracket in wheel house Refit hood lock wire Refit clips behind headlamps Refit headlamp rims Refit upper radiator mounting Refit stay bracket Refit hood lock cable to stay Check operation of hood lock Remove-install engine hood—Şemove radiator screen plates-Slacken fixing stay—Wco 7/16, Blacken front and radiator models.	ce 5–8 8 CS -SCcssh , SCcs unting straps—Wco 1/	Front Install Install Lower	fenders: inst I front fende I wheels—Tar	all 2 r, twice—SCcs, s rr, Sdh 3/4, Tah	5 – SCac, Was 7/16	
Remove headlamp leads, lift or Position front, arrange sealing Refit bracket in wheel house Refit hood lock wire Refit clips behind headlamps Refit headlamp rims Refit upper radiator mounting Refit stay bracket Refit hood lock cable to stay Check operation of hood lock Remove-install engine hood—Semove radiator screen plates-blacken fixing stay—Wco 7/16, Slacken front and radiator more 7/16, SCcs Remove-install badge—Ppn, SC Remove-install page—Ppn, SC Remove	ce 5–8 8 CS -SCcssh , SCcs unting straps—Wco 1/	Front Install Install Lower	fenders: inst I front fende I wheels—Tar	all 2 r, twice—SCcs, s rr, Sdh 3/4, Tah	5 – SCac, Was 7/16	
Remove headlamp leads, lift or Position front, arrange sealing Refit bracket in wheel house Refit hood lock wire Refit hood lock wire Refit headlamp rims Refit headlamp rims Refit upper radiator mounting Refit stay bracket Refit hood lock cable to stay Check operation of hood lock Remove-install engine hood—Semove radiator screen plates-blacken fixing stay—Wco 7/16, Slacken front and radiator mot 7/16, SCcs Remove-install badge—Ppn, SC Remove-install badge—Ppn, SC Remove-install badge—Ppn, SC	ce 5–8 8 CS -SCcssh , SCcs unting straps—Wco 1/	Front Install Install Lower	fenders: inst I front fende I wheels—Tar	all 2 r, twice—SCcs, s rr, Sdh 3/4, Tah	5 – SCac, Was 7/16	
Remove headlamp leads, lift or Position front, arrange sealing Refit bracket in wheel house Refit hood lock wire Refit clips behind headlamps Refit headlamp rims Refit upper radiator mounting Refit stay bracket Refit hood lock cable to stay Check operation of hood lock Remove-install engine hood—Seacken fixing stay—Wco 7/16, Slacken front and radiator mot 7/16, SCcs Remove-install badge—Ppn, SC Fit grille Fit radiator mounting strips, for	ce 5–8 8 CS -SCcssh , SCcs unting straps—Wco 1/	Front Install Install Lower	fenders: inst I front fende I wheels—Tar	all 2 r, twice—SCcs, s rr, Sdh 3/4, Tah	5 – SCac, Was 7/16	

Saab Car Division

- 1	Saab Car Division								
		Replaces page		73-01-02	Edition 1	Page 82592			
	Front fenders: remove-install be (incl cleaning, anti-rust treatme painting mating surfaces of fenders)	ent and	82592	Rear fenders: remov (incl cleaning, antiru painting fenders and	ist treatment ai	5— nd	82692		
	Raise-lower front of car—Lj, Lt Remove-install 2 wheels—Tanr, Remove front fender, twice—So	Sdh 3/4, SCs, Tah		Raise-lower rear of o Remove-install 2 wh Remove rear light gl	eels-SCs, Tani		n		
	Scrape clean mating surfaces at Ck, round file	edge of fender and		Remove rear fender. Trh, SCcs	s, twice—SCs, C	ck, Sdh 1/2, T	ebl, Tuj,		
	Dress paint surfaces—dressing c Apply primer—brush Treat other surfaces with rust p		anti-rust oil	Scrape clean mating Dress paint surfaces Apply primer—brush	-dressing cloth				
	Paint enamelled surfaces—brush Clean old beading and rubber so Cwb, Psc		new-	Treat other surfaces Paint enamelled surf Clean old beading a	with rust preve aces—brush, pa	aint			
	Suspend fender on all fixing bo Posn beading strip and tighten a	all fixing bolts		Cwb, Psc Suspend fenders on		ig sa ips or car	t Hevv—		
	Apply underseal to fender/bod underseal Clean paint surfaces where nece		olts—	Posn beading strip a Connect lights, chec Apply underseal to	k operation		olte		
	Clean brushes			Refit rear light glass Clean paint surfaces			orts		
	Rear fender: mudflaps replace	1 5-	82642	Clean brushes Door, replace		5–8	83104		
	Remove mudflap · Install mudflap			Remove locking but			00104		
	Spares: Mudflap			Remove armrest—SO Remove window ha Remove inside hand	ndle—SCs, drift				
	Rear fender: mudflaps replace	each 5-	82643	Remove door lining Remove paper over	(safety paddin holes				
	See 82642 (5-)			Remove door windo Remove window wi	nding mechanis	smWas 7 /16,	SCcssh		
Ì	Rear fender: remove 1	5—	82670	Remove operating bracket—SCcs Remove door handle—SCcssh, SCcs Remove door lock, SCcs, SCs					
	Raise rear of car—Lj, Ltr Remove wheel—SCs, Tanr, Sdh Remove rear fender—SCs, Ck, S		, Trh, SCcs	Remove armrest nuts—SCs Remove outer and inner weatherstrips at window—SCs Remove top and rear seal and foam plastic strip from					
	The state of the s			window frame—SCs Remove draught ex	, Ppn	i piastic strip	.,,		
weden	Rear fender: install 1 Install rear fender—Trh, Tuj, To	5- ehl Sdh 1/2 SCcs	82674	Remove bottom we	atherstrip				
len-Sch	oil Install wheel—Tanr, Sdh 3/4, T		, arren asc	Remove door stop-	drift, H, SCcss	h, Wadj			
- Swed	Lower rear of car Clean brush			Slacken nuts on hin Support door at rea	ges-Wco 1 1/4				
yköping				Remove nuts and re Posn new door on h	move door—Tr inges and fit n	h, Tebs, Sdh 1 uts (do not be	15/16 nd up		
n- Bun	Rear fenders: remove 2 Jack up rear of car—Lj, Ltr	5—	82688	locking tabs) Fit door stop					
stabteil	Remove 2 wheels—SCs, Tanr, S Remove rear fender, twice—SC		bl, Tuj,	Fit cardboard panel Fit guide rails Fit (stick) foam pla		window frame	_Tikafast		
dendien	Trh, SCcs		1	brush Fit draught exclude		WINGOW Harne	- Tikarast,		
ent-Kun	Rear fenders: install 2	5—	82690	Fit top and rear we	atherstrip to w		H, drift		
epartm	Install rear fender, twice—Trh, antirust oil		2, SCcs 4,	Fit armrest nuts—S Fit door lock	Cs				
rvice D	Install 2 wheels—Tanr, Sdh 3/4 Lower rear of car	, Tah		Fit door handle Fit operating brack	et				
ila - Se				Fit window windin Fit door window					
ap-Scan				Fit outer weatherst Fit bottom weather		-SCs			
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Saab-Scania - Service Department-Kundendienstabteilung - Nyköping - Sweden-Schweden

Remove paper over holes

Repair Work Description SAAB 95/96

Saab Car Division

Edition Date Replaces page Page 73-01-02 83104 5-8 83104 Remove door stop-drift, H, SCcssh, Wadj Fit new doorstop Adjust door at hinges and striker plate-Trh, Tebs, Sdh 15/16, Lubricate door stop-Vaseline SCch, H, Wco 1 1/4 Fit paper over holes-Tikafast, brush Bend up locking tabs at hinged nuts Fit door lining (safety padding) Place paper under door Fit inside handle Brush antirust fluid on bottom of door and at joins between Fit window handle door panel and bottom of door (both inside the door and Fit armrest on the underside)-Tectyl 140 B and 122 A, brush Fit locking button Remove paper and wipe bottom edge of door dry-rag Wipe hands clean Fit splashguard to door-SCcs Doors: hinges replace 1 5-83108 Fit paper over holes-Tikafast, brush Fit door lining (safety padding) Remove locking button Fit inside handle Remove armrest-SCcs Fit window handle Remove window handle-SCs, drift, H, (SCcs) Fit armrest Remove inside handle-SCs, drift, H, (SCcs) Fit bushing and locking button-H Remove door lining (safety padding)—SCs Clean door window inside and out-methylated spirit, rag Remove paper over holes damped with water Bend back hinge locking tabs-SCch, H Remove door stop arm-drift, H Spares: Insulating cardboard Slacken nut-Wco 1 1/4 Support door-Lj, block of wood Remove hinge nuts-Trh, Tebs, Sdh 15/16 Door: replace 9-0 83104 Remove hinge from body-SCcs, H, chisel See 83104 (5-8) Dismantle hinge and investigate wear-vice, H, drift Delete: Assemble hinge-H Remove-install bottom weatherstrip Fit new nut and new rubber plug to hinge pin (only when replacing hinge pin) Remove (unhook) weatherstrip Lubricate hinge-Moc Fit clip to weatherstrip Fit hinge to body Fit weatherstrip-Hp Fit hinge nut Remove-install reflector (1970 only)-Csp, Tikafast, brush Fit door stop arm-H Check tightness of door lock bolts-SCcs Spares: Insulating cardboard, Clip for weatherstrip Adjust door-Trh, Tebs, Sdh 15/16, Wco 1 1/4, SCcs, H Bend up locking tab at nut Fit paper over holes-Tikafast, brush Door: replace 83104 Fit door lining (safety padding) See 83104 (5-8) Fit inside handle Delete: Fit window handle Remove-install bottom weatherstrip Fit armrest Add: Fit locking button Remove (unhook) weatherstrip Spares: Nuts, rubber plug Fit clip to weatherstrip Fit weatherstrip-Hp Remove-install reflector-Csp, Tikafast, brush 83110 Weatherstrip in door opening, replace Remove guard strip—SCs Posn and clamp template-SP 102, Pw Remove end cover on instrument panel-SCcs Drill holes to template-Mpd, 3.5 or 4.5 mm drill Remove weatherstrip-SCcs Remove template Unpack new weatherstrip Drill out holes-Mpd, 8.3 mm drill Fit new weatherstrip-SCcs, Tikafast, brush Deburr holes (inside door)—pin grinding machine Refit end cover Fit bushings—Hp Fit guard strip—assistant (Trh + Sdh 10 as backing) (The holes for the guard strip should be drilled before Door: adjust at striker plate 83112 painting) Check tightness of door lock fixing screws-SCcs Spares: Insulating cardboard, bushing, clip for weatherstrip Adjust door at striker plate-SCcs, H Door stop complete: replace 83106 5-Weatherstrip on door (mounted in 5-9 83114 rail), replace Remove locking button Remove armrest-SCcs Remove weatherstrip Remove window handle-SCs, drift, H, (SCcs) Adjust (align) metal rail—SCs Remove inside handle-SCs, drift, H, (SCcs) Fit weatherstrip-SCs Remove door lining (safety padding)-SCs

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Weatherstrip on door (fitted with clips), replace Remove (unhook) weatherstrip Remove clip—Psc Unpack weatherstrip Fit new weatherstrip—Hp	9–	83114	Remove coolant-	join-Mpd, steel r panel join-sold -Csp, can with li and as much of	scraper lering iron, flux, solder d the door panel. as is to be
Door stop complete replace (doo lining off) Remove doorstop—drift, H, SCc Fit new doorstop Lubricate doorstop—Vaseline		83115	licence plate) File and grind fill Place paper unde Apply antirust fle door panel between	in and adjacent ser—flat file, orbindoor uid to, and seal, ten the door	surfaces—Csp (20 cm of a tal grinder the join on the inside of the el and the door bottom, tide the door and under-
Doors: hinges replace each (door Remove hinge from body—SCcs Dismantle hinge and investigate Assemble hinge—H Fit new nut and new rubber plureplacing hinge pin) Lubricate hinge—Moc Fit hinge to body	. H, chisel wear–vice, H, c		neath)—Tectyl 14 Remove paper an Wipe hands clean	40 B and 122 A, d wipe bottom e ue insulating mat to door—SCcs protection from stand	brush
Spares: Nuts, rubber plug			Doors: bottom of (door off)	uter panel replac	e 1– 83123
Doors: bottom outer panel repla (door off)	ice 50	83123		o, assistant (Trh,	ove-install guard strip and Sdh 10 as backing)
Fit bracket to stand Cover door window Undo bottom end of window ra masking tape Remove splash guard (screwed of Posn and clamp template—temp Cut door panel at door ends—Mit Change saw blade Cut door panel—Mms, (140 mm) Change saw blade Remove template Grind away flanges on door pan Melt away brazing at bottom co Free door panel section—Mwe, if Grind away paint from outside of Grind clean edges of inner part— Remove insulating mat at saw of Adjust (align)edges—H, backing Countersink door panel edges—Of Hazet 1932—2 Grind away primer at bottom ed join on outside of outer panel— Posn and align outer panel—H, if Apply coolant to door panel—Co Arrange welding equipment—ES Spot weld door panel join at 30 Bend over edges of outer panel— Weld outer panel join at door e	only)—SCcs late SP 102, ms, (long blade) long blade) el short sides—I rners of door p dof door panel—I Mrg, knife ut—Csp Countersinking Mrg W ool-Heat AB A10—150 mm spacing—I Hazet 1944, b nd panels (on in	Mrg anel—Mwe Nrg pliers mer and at	Arrange work be Fit bracket to do Fit bracket to sta Cover door wind Undo bottom en SCcs, masking ta Remove weather Posn and clamp t Cut door panel— Change saw blade Cut door panel— Change saw blade Remove template Grind away flang Bend out door panel— Posn and clamp t Cut inner panel a rail—Mms, (long Remove template Posn inner panel Posn and align ou Scribe on door e Remove outer ar Cut alongside scr for lap joint—Ppi	oor off) nch or and ow d of window rail pe strip from door emplate—templa t door ends—Mm e Mms, (140 mm le e es on door panel anel section at sa emplate—templa t template or at blade) e —H atter and inner pa nd panels—scribe d inner panels iber mark on door	and move to one side— te SP 102, Pw s, (long blade) ong blade) short sides—Mrg w cut te SP 102,Pw top of weatherstrip fixing nels—H, r
door panel bottom corners—2-3 Weld at bottom join between ou approx 10 mm long)—2-3-4 Fully weld outer panel join ends Grind welds at door end panels	iter and inner p 	anel (2 welds	—Mrg Grind welds at or Remove insulatir Adjust (align) ed	utside of outer pa ng mat at saw cut	

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Replaces page Date Edition Page 73-01-02 1 83125 5-8 83125 Door, bottom outer panel and inner 83125 1panel, replace (door off) Countersink door panel edges—Countersinking pliers Hazet 1932-2 Op. No. 83125 (5-8) Grind away primer at bottom edge, the entire inner edge, Delete: end panels and in the bottom corners of the spare part (in Remove bottom weatherstrip the panel)-Mrg Add: Grind away primer at bottom edge, bottom corners and at the Remove splashguard—SCcs join on the outside of the spare part (outer panel)—Mrg Remove (unhook) weatherstrip Posn inner panel-H Remove clip from door-Psc Posn and align outer and inner panels-H,Pw Fit clip to weatherstrip Apply coolant to door panel-Cool-Heat Fit weatherstrip-Hp Arrange welding equipment—ESAB A 10—150 Remove-install guard strip and bushings-SCs, Hp, assistant Spot weld door panel join at 30 mm spot spacing-II-10-10-(Trh, Sdh 10 as backing) 0.8 P Spares: Bushing for guard strip Spot weld inner panel join at 30 mm spot spacing-II-10-10-0.8 P Fully weld inner panel join at door end panels-II-3-4 83127 Doors: outer panel replace (door off) 5-0 Bend over edges of outer panel—Hazet 1944, backing Weld outer panel join at door end panels (on inside) and at Arrange work bench door panel bottom corners-II-3-4 Fit bracket to door Weld at bottom join between outer and inner panel (2 welds Fit bracket to stand approx 10 mm long)-II-3-4 Cover door window Fully weld outer panel join ends-II-3-4 Remove splash guard (screwed only)-SCcs Grind welds on inner panel and door end panels Remove outer door handle-SCcs, SCcssh Grind welds at outside of outer panel-Mrg Remove outer rear view mirror-SCcs Clean door panel join-Mpd, steel scraper Saw approx. 15 mm below crease at top edge of door panel— Seal (solder) door panel join-soldering iron, flux, solder Remove coolant-Csp, can with lid Grind away front and rear folded edge and bottom corner Grind solder join and as much of the door panel as is to be Free door panel section filled-Mrg Grind away welds and remove metal strips from door edges-Adjust (align) door panel at join, H, backing grinding wheel Mix filler-Csp, piece of glass Align (adjust) door edges-H, backing Fill door panel join and adjacent surfaces-Csp (20 cm of a Grind clean door edges (both sides)-Mrg, grinding wheel licence plate) Grind away paint at join-Mrg File and grind filler-flat file, orbitol grinder Saw off top part of spare part-Mms Place paper under door Grind away paint from top edge of spare part-Mrg Apply antirust fluid to, and seal, the join on the inside of the Cut holes (about 25) in top edge of spare part—punching door panel between the door panel and the door bottom, and pliers on the door bottom (both inside the door and underneath) Posn spare part (lap joint at top edge)—tape measure,Pw and upper joint of inner panel-Tectyl 140 B and 122 A, brush Arrange welding equipment—ESAB A10—150 Remove paper and wipe bottom edge of door Plug weld upper edge of door panel (in cut holes)-2-10-Wipe hands clean 10-0.8P, aligning tool Turn back and glue insulating mat-Tikafast, brush Bend over edges of door panel-Hazet 1944, H, backing Fit splash guard-SCcs Weld door panel at end panels at bottom corners-2-3-4 Fit bottom end of window rail-SCcs Weld door panel at bottom edge (2 welds approx. 10 mm Remove window protection long) - 2 - 3 - 4Remove bracket from stand Grind welds-Mrg, grinding wheel Remove bracket from door Arrange solder filling equipment Solder-fill join at top edge of door panel-solder filling Spares: Inner weatherstrip, splashguard Adjust (align) door panel outer edges (folded edges)-H, backing Doors: bottom outer panel and inner 9-0 83125 Check door in car (mount door on hinges without nuts, panel, replace (door off) close door) Op. No. 83125 (5-8) Adjust if nec folded edge and check door in car-H, backing Delete: Clean surface to be filled-thinner Remove bottom weatherstrip Mix filler-Csp, piece of glass Add: Fill door panel join and adjacent surfaces-Esp (20 cm of Remove splashquard—SCcs a licence plate) Remove (unhook) weatherstrip File and grind filler-flat file, orbital grinder, hand grinding Remove clip from door-Psc

Place paper under door

Saab-Scania - Service Department-Kundendienstabteilung - Nyköp

Fit clip to weatherstrip

Fit weatherstrip-Hp

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			73-01-02	1	83127		
Apply antirust fluid inside door upper join—Tectyl 140 B, brush Apply antirust fluid to bottom and to underside of door Remove paper and wipe bottom Wipe hands clean Fit splashguard to door— SCcs Fit insulating mats Fit outer door handle—SCcs, S Fit outer rear view mirror—SCc Remove window protection Remove bracket from stand Remove bracket from door	n edge of door pan n edge of door Cossh		Remove template Grind away welds and remove metal strips from door edgerinding wheel Align (adjust) door edges—H, backing Saw away top edge of spare part—Mms Posn and align outer and inner panels—H, Pw Scribe on door end panels—scriber Remove outer and inner panels Cut alongside scriber mark on door end panel and leave metal for lap joint—Ppn Grind away paint from inside door and from door end panels—Mrg Grind clean door edges Grind away paint at join Grind away paint from upper edge of spare part (at weld				
Doors: outer panel replace (door off) Op. No. 83127 (5–0) adding: Remove guard strip—SCs Posn and clamp template—SP 1 Mpd, 3.5 or 4.5 mm drill Remove template Drill out holes—Mpd, 8.3 mm d Deburr holes (inside door)—pin Fit bushings—Hp Fit guard strip—assistant (Trh +	rill grinding machine	1	Mrg Cut holes (approx pliers Posn and align out edge of outer part) Arrange welding ed Plug weld upper ed 10—0.8P, aligning Spot weld inner part Fully weld inner part Bend over edges of	er and inner pan —H, Pw, tape m quipment—ESAI lge of door pane tool anel join at 30 m anel join at doo f outer panel—H t end panels and int between out m long)—2—3—	of spare part—punching lels (lap joint at upper leasure B A10–150 el (in cut holes)–2–10– el spacing r end panels–2–3–4 lazet 1944, backing d bottom corners–2–3–4 er and inner panels (2		
Bushings for guard strip			Arrange solder filli	ng equipment			
Doors: bottom outer panel and inner panel, replace Op. Nos. 83125 (5–8) + 83174	5–8 + 83176	83128	backing Check door in car close door)	r panel outer ed	r panel ges (folded edges)—H, hinges without nuts, k door in car—H, backing		
Doors: bottom outer panel and panel, replace Op. Nos. 83125 (9–0) + 83174		83128	Clean surface to be Mix filler—Csp, pic Fill door panel join licence plate)	e filled—thinner ece of glass n and adjacent s	urfaces—Csp (20 cm of a		
Doors: bottom outer panel and inner panel, replace Op. Nos. 83125 (1) + 83174	1 + 83176	83128	paper Place paper under Apply antirust flui upper join and on brush	door d inside door or inner panel upp	n edges of outer panel and er join—Tectyl 140 B,		
Doors: bottom outer panel and panel, replace (door off)	inner 5–8	83129		om of door (bot sh	ge of outer panel (inside h inside and outside)— dge of door		
Arrange work bench Fit bracket to door Fit bracket to stand Cover door window Remove outer door handle—SC Remove outer rear view mirror- Remove weatherstrip from doo Saw approx. 15 mm below crea Mms Grind away front and rear foldomrg Free door panel section Posn and clamp template—SP 1	-SCcs r ise at top edge of ed edge and botto		Fit splashguard to Fit insulating mats Fit new weatherst Fit outer door har Fit outer rear view Remove window premove bracket fir Remove bracket fir Spares: Splashguar	rip—Hp rip—Hp dle—SCcs, SCcs mirror—SCcs rrotection rom door rom stand	sh		

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Posn and clamp template-SP 102, Pw

Cut inner section at template-Mms (long blade)

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Name of the second	Replaces page		Date		Edition	Page	
			73-01	-02	1	83129	
Doors: bottom outer and inner replace (door off)	r panel, 9-0	83129		door stop a	arm—drift, H 1/4		
Op. No 83129 (5-8)					lock of wood		
Delete:					emove door—Tr body—SCcs, H		15/16
Remove bottom weatherstrip					d investigate we		н
Add:				e hinge-H	a mvostigate we	, ur vice, uriit	
Remove splashguard—SCcs Remove (unhook) weatherstrip					ew rubber plug	to hinge pin (only when
Remove clip from door—Psc			The second second	hinge pins			
Fit clip to weatherstrip				e hinge-M	oc		
Fir weatherstrip—Hp				e to body or and fit n	uto		
			The second secon	or stop arm			
Dearen hastern automatic land		00100			door lock bolts	-SCcs	
Doors: bottom outer and inner replace (door off)	r panel, 1—	83129			Tebs, Sdh 15/16		SCcs, H
				locking tal			
Op. No. 83129 (5–8)					s—Tikafast, bru	sh	
Delete: Remove bottom weatherstrip			Fit door		ety padding)		
Add:				e nanute ow handle			
Remove splashguard—SCcs			Fit armr				
Remove (unhook) weatherstrip	p		The second secon	ing button			
Remove clip from door-Psc			Spares: I	Nuts, rubbe	er plug		
Fit clip to weatherstrip			- Spares. I	vats, rabbe			
Fit weatherstrip—Hp Remove-install guard strip and	huchings_SCe I	In accietant					
(Trh, Sdh 10 as backing)	businings—50s, i	ip, assistant	Guard st	rip, replace	9	1	83136
			Remove	quard strip	from door-SC	Cs	
				clip and er			
Doors: bottom outer panel, rep	place 5-0	83130		trim strip			
Op. Nos. 83123 (5-0) + 83174	4 + 83176		Fit clip	and end pie	eces to trim stri	p T-b + Cdb 10	at booking)
-			Fit guar	a strip to a	oor—assistant (11n + 5un 10	at backing/
Doors: bottom outer panel, rep	place 1-	83130					
		03130			echanism repla	ce 5-	83141
Op. Nos. 83123 (1–) +83174	+83176		(door lin	ning off)			
					inding mechani		, SCcssh
Door adjust complete	5—	83132			winding mechai		
Remove locking button			Fit new	window w	inding mechanis	sm	
Remove armrest—SCcs							
Remove window handle—SCs,	drift, H (SCcs)		Doors: o	outer panel	replace	5-0	83142
Remove inside handle—SCs, dr				-	-0) + 83174 +	83176	
Remove door lining (safety page	dding)—SCs		Op. 1405	5. 03127 (5	0) (00174)	33170	
Remove paper over holes Bend back hinge locking tabs—	SCah ⊔						
Adjust door at hinge and strike		bs. Sdh 15/16	Doors: o	outer panel	replace	1-	83142
Wco 1 1/4, SCcs, H	. p.a.co 1111, 16	- 3, Juli 10, 10,	On Nos	83127 (1	_) + 83174 + 8	3176	
Bend up locking tabs at hinge			- Op. 1408	00127 (1	, , 33174 10		****
Fit paper over holes—Tikafast,							
Fit door lining (safety padding	1)		Window	winding m	echanism, repla	ace 5—	83152
된 Fit inside handle 로 Fit window handle			Remove	locking bu	utton		
Fit armrest			11	armrest—S			
Fit locking button	72				andle—Scs, drif		
Check tightness of door lock f	ixing bolts-SCc	3			dle-SCs, drift,		
¥					g (safety paddir	ng)—SUs	
Door hings we less 2 /ste	V	00404	Remove	paper ove	r notes rinding mechan	ism-Was 7/16	, SCcssh
Door: hinges replace 2 (the san	ne door) 5–	83134	Lubrica	te window	winding mecha	nism-grease	
Remove locking button			Fit wine	dow windir	ng mechanism		
Remove armrest—SCcs	1.16. 11.160		Fit pape	er over hole	es-Tikafast, bru	ush	
Remove window handle—SCs, Remove inside handle—SCs, dr			The second secon		fety padding)		
Remove inside handle—50s, dr			To the second desired to	de handle			
Remove paper over holes	danig/=00s		The second secon	dow handle			
g Bend back hinge locking tabs-	-SCch, H		Fit arm	rest king button			
w		at the same of the	FILLOCI	any Dutton			1000

Repair Work - Standard Times SAAB 95/96

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						Jan. 1973	1		83154 -	85262	
per, No	Modelcode	Effective	Secondary time	Lost time allow- ance	Schedule time	Oper. No	Modelcode	Effective	Secondar time	Lost time allow- ance	Schedule time
Cont.			No. of the last of			05.405	-	45			00
83154	1-	349	23	37	409	85105	5–	17	1	2	20
83156	5-	4	1	1	6	85170	5-	6	1	1	8
83174	5-	21	6	3	30	85172	5-	11	1	1	13
83176	5-	50	7	6	63	85182	P5-6	6	2	1	9
83182	5-	8	1	1	10	85182	P7-	19	2	2	23
83184	5-	19	2	2	23	85182	H5-	8	3	1	12
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83208	P5 - -	41	4	5	50	85184	P7-	86	7	9	102
83208 -	H5-	129	4	13	146	85184	H5	23	3	3	29
83402	5-	4	1	1	6	85221	5-	12	3	2	17
33403	5	11	4	2	17	85228	5-	50	4	5	59
B3404	5-6	14	4	2	20	85236	5-	25	3	3	31
33404	7-	18	4	2	24	85238	5-	16		2	18
33406	5-	49	6	6	61	85240	5-	28	2	3	33
33408	5-6	25	4	3	32	85242	P5-6	38	3	4	45
83408	7	29	4	3	36	85242	P7-	55	4	6	65
33410	5-	11	3	1	15	85244	P5 - 6	43	3	5	51
B 3411	5-	22	4	3	29	85244	P7-	60	4	6	70
33412	P5-	9	1	1	11	85246	P5-	126	5	13	144
33417	5-	22	4	3	29	85248	P5-	138	6	14	1 58
33418	P5-	29	1	3	33	85250	H5-	143	7	15	165
33418	H5-	15	4	2	21	85252	H5 -	20	3	2	25
33420	5-	6	2	1	9	85254	H5 -	15	3	2	20
33422	P5-	5	1	1	7	85256	H5-	35	4	4	43
33422	H5-	9	1	1	11	85258	H5-	42	4	5	51
33424	H5-	12	2	1	15	85260	H5 -	12	3	2	17
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		73-01-02	1	83154	
Doors: outer panel and inner panel, 5- replace	–8 83154	Remove door lir Remove paper o		ding)—SCs	
Op. Nos. 83129 (5–8) + 83174 + 83176					
		Door lining, inst	all	5—	83184
Doors: outer panel and inner panel, 9- replace	–0 83154	Fit paper over h Fit door lining (safety padding)		
Op. Nos. 83129 (9-0) + 83174 + 83176		Fit inside handle Fit window hand	lle–SCs, drift, l		
Doors: outer panel and inner panel, 1- replace	- 83154	Fit armrest—SCo Fit locking butto		u c	
Op. Nos. 83129 (1—) +83174 +83176		Trunk lid: weath	erstrip replace	P5-	83208
		Open trunk lid-			
Rear view mirror, complete or glass, 5-replace	– 83156	Remove weather Posn fender guar Clean mounting Apply adhesive-	d or similar to p surface on lid—		fe
Remove rear view mirror—SCcs		Fit weatherstrip			
Open pack Fit new rear view mirror		Remove fender			
Clean, adjust roughly Alternatively:		Close lid-key			
Remove glass at rim Jnpack		Rear door: weat	herstrip replace	H5	83208
Fit glass and rim		Open rear door-	kev		
Clean, adjust roughly		Remove metal ra			
		Remove weather	strip from door	r opening and do	
Door: remove 5	- 83174	Bend back meta			
Remove locking button		Posn weatherstri			n top ea
Remove armrest—SCcs		Fit weatherstrip			door–
Remove window handle—SCs, drift, H, (SCc	es)	bradawl, SCcs			
Remove inside handle—SCs, drift, H, (SCcs)		Close rear door-	-key		
Remove door lining (safety padding)—SCs		Window handle	or incido door b	andle 5	9240
Remove paper over holes Remove door stop arm—drift, H		replace	of inside door in	andle, 5-	83402
Bend back hinge nut locking tabs-SCch, H			. handla ou doos	عادا السماء	1001
Unscrew hinge nuts-Wco 1 1/4		Unpack new har		r handle—H, drif	i, (SCCS)
Support door at rear edge—Lj, block of woo		Fit handle			
Remove nuts and remove door—Trh, Tebs, S	Sdh 15/16	Check operation) <u></u>		
Door: install 5-	_ 83176	Door handle, ou	ter, replace	5—	83403
Posn door on hinges and fit nuts (do not be tabs)—Lj, block of wood, Trh, Tebs, Sdh 15		Op. No. 83404	5–6) excl remo	ove-install lining	
Fit door stop arm—H Check tightness of door lock screws—SCcs		Door handle, ou	ter replace	5–6	83404
Adjust door—Trh, Tebs, Sdh 15/16, Wco 1	1/4, SCcs, H	Remove door lir		corner—SCs	
Bend up tabs at hinge nuts		Remove outer d			
Fit paper over holes—Tikafast, brush Fit door lining (safety padding)		Knock out pin a	nd free pushbut	tton and spring-	H, drift
Fit inside handle—SCs, drift, H (SCcs)		Wipe parts clean	-rag		
Fit window handle SCs, drift, H, (SCcs)		Unpack handle	ultton over or l	nin to handle	
Fit armrest—SCcs		Fit spring, pushli Lubricate pushb			
Fit locking button		Fit outer door h			
Door lining romeye	02400	Check operation	–door key		
Door lining remove 5- Remove locking button	– 83182		(2-1-1)- 1 -		
Remove arm rest—SCcs		Door handle, ou	ter replace	7-	83404
Remove window handle—SCs, drift, H, (SCc		Op. No. 83404 (n remove-install	locking
Remove inside handle—SCs, drift, H, (SCcs)		button and safet	y padding		

Saab Car Division

Repair Work Description SAAB 95/96

Edition Replaces page Page 73-01-02 83406 Door lock replace (excl adjust door at 83406 5-Door lock replace (excl adjust door 83411 striker plate) at striker plate) (safety padding off) Remove locking button Remove outer door handle-SCcssh, SCcs Remove armrest-SCcs Remove door lock, operating bracket and link-SCcs Remove window handle-SCs, drift, H, (SCcs) Remove operating link from door lock and fit to new Remove inside handle-SCs, drift, H, (SCcs) door lock-H, SCch, drift, centre punch Remove door lining (safety padding)—SCs Fit door lock, operating bracket and link Remove paper over holes Fit outer door handle Remove outer door handle-SCcssh, SCcs Check clearance between arm on pushbutton and door lock Remove door lock, operating bracket and link-SCcs Spares: Rivet, washer Remove operating link from door lock and fit to new door lock-H, SCch, drift, centre punch Fit door lock, operating bracket and link Trunk lid: locking mechanism replace P5-83412 Fit outer door handle Check clearance between arm on pushbutton and door lock Open trunk lid-key Fit paper over holes-Tikafast, brush Turn back mat Fit door lining (safety padding) Lift up plate Fit inside handle Remove locking mechanism—SCs Fit window handle Fit new locking mechanism Fit armrest Check operation Fit locking button Fit plate Reposition mat Spares: Rivets, washers Close trunk lid-key Door lock, lock cyl replace 83408 5-6 Door lock: lock cylinder replace 5-83417 Remove door lining at top rear corner-SCs (door lining off) Remove outer door handle-SCcssh, SCcs Op. No. 83408 (5-6) excl remove-install door lining Knock out pin and free pushbutton and spring-H, drift Remove sleeve-SCs Remove lock cylinder from pushbutton-drift, door key Trunk lid: lock cylinder replace P5-83418 Wipe parts clean-rag Unpack lock cylinder Open trunk lid-key Fit new lock cyl to pushbutton Turn back mat Refit sleeve Lift up plate Refit spring, pushbutton, arm and pin to handle Remove locking mechanism-SCcs Lubricate pushbutton at spring-Moc Remove knob-SCs Fit outer door handle Dismantle housing spring and sleeve—SCs Check operation-door key Remove lock cylinder from sleeve-key, wire picklock Refit door lining Wipe parts clean Unpack lock cylinder Fit new lock cylinder to sleeve Door lock: lock cyl replace 7-83408 Assemble sleeve, spring and housing Op. No. 83408 (5-6) in addition remove-install locking Lubricate parts-Moc Fit knob button and safety padding Refit lock mechanism and lubricate-Moc Check operation-key Fit plate Striker plate, replace 5-83410 Reposition mat Slacken striker plate screws-SCcs Close trunk lid-key Remove inside fixing bolt(s) Turn striker plate to one side Pack of inside screw in threaded plate and retain with steel Rear door: lock cylinder replace H5-83418 wire-steel wire Open rear door-key (only up to 1967 inclusive) Remove inner and outer handles-drift, H, assistant Remove external fixing bolt(s) Remove lock cylinder from handle-drift, key Take off striker plate Unpack new lock cylinder Posn and fit striker plate Lubricate bottom end of lock cylinder and fit handle-grease Lubricate striker plate-Vaseline Adjust striker plate-SCcs, H Fit inner and outer handles Check operation-key Saab-Scania - Service Close rear door-key

	Replaces page		Date	Edition	Page	
			73-01-02		83420	
Lock sylinders for doors and truid: blow clean and lubricate all Blow clean and lubricate the located trunk lid—Cag, Valvoline 80	k cylinders of	83420 the doors	Headlining: install Unpack and arran Transfer wire ribs Apply adhesive to Hang up headlinir	ge headlining front pillars, a	P7— dhesive, brush	85184
Trunk lid: adjust at catch Open trunk lid—key Check tightness of locking mech Adjust lid at catch—Wco 1/2 Close trunk lid	P5 nanism fixing s		Apply adhesive ro Fit headlining to the Fold and glue edge Fit headlining und Check and adjust Heat headlining (the Clean brush	ound edge of roo front pillars es of headlining der rear window headlining—scis	sors	
Rear door: adjust at striker Open rear door—key Check tightness of door lock fix Adjust rear door at striker—SCo Close rear door			Headlining: install Unpack and arran Install headlining- Stretch wire spira Heat headlining (t	ge headlining -tool, 784096 Is—2 assembly h		85184
Rear door: adjust at balance spr Remove linings and ventilation I Adjust rear door at balance spri Refit linings Door lining: remove-install	noles—SCs		Front seat: cushio conj with seat frant Remove staples—Seamove spring from Install spring in custaple cushion constalls	me replace SCs, Ppn om cushion covushion covus		85221
See Op. No. 85170 and 85172	•		Front seat: seat fr	ame replace	5-	85228
Door lining: remove Remove armrest—SCcs Remove window handle—SCs, d Remove inside door handle Remove lining—SCs	5– rift, H	85170	Collect and posns Collect and posns Remove backrest Remove cushion of Remove interlay— Remove springs—	seat on bench from seat—Wcc cover -SCs, Hp		
Door lining: install Install door lining Fit window handle—SCs, drift, l Fit inside door handle Fit armrest—SCcs Check operation	5–	85172	Remove button Remove rails fron Remove backrest Fit rails to seat fr Fit springs Fit interlay Fit seat cushion Fit button	latch ame	Cs, Wco 7/16	
Spares: Door lining			Fit backrest to se Fit backrest latch Put away seat Remove screen fr	–steel wire wit	h eyelet, Ppn	
Headlining: remove Remove headlining—knife Fold and put away headlining	P7	- 85182	Front seat: cushic			85236
Headlining: remove Unhook wire spirals—2 assembly Remove headlining—tool, 78409		- 85182	Collect and posin Collect and posin Remove cushion Remove spring fr Fit spring to cush Fit cushion cover	seat on bench cover—SCs, Ppr om cushion covi ion cover	ı.	

aab-Scania - Service Department-Kundendienstabteilung - Nyköping - Sweden-

CAAR CANIA

nair Work Description SAAR 95/96

Saab Car Division	s page		Date	I Edition	Page
Портабо			73-01-02	1	85238
Front seat: backrest cover replace	5	85238	Remove spring ass	-	00238
Collect and posn screen on bench			Remove interlay		
Collect and posn seat on bench			Put away rear panel Collect rear panel	eı	
Remove backrest cover			Posn interlay		
Fit backrest cover			Posn spring assemb	alv	
Put away seat					-*) assemble, tool, Hp
Remove screen from bench			Posn sacking inter		, assemble, tool, mp
					me-bradawl, Psc, locking v
Front seat: backrest frame replace	5	85240	Posn plastic foam	interlay	
		03240	Posn seat cushion		
Collect and posn screen on bench					sacking inerlay and one ed
Collect and posn seat on bench	7/40			n must be tied	d simultaneously to the wi
Remove backrest from seat cushion—V Remove backrest cover	vco //16		frame)		
			Fit staples—stapler		
Remove padding—knife Fit padding—adhesive			Put away seat Remove screen fro	m hench	
Fit backrest cover			nemove screen fro	ATT DEFICIT	
Fit backrest to seat cushion					
Put away seat				*) Made o	f 12 mm diameter steel
Remove screen from bench				230 mm lo	
		000.00			Closed by welding
Rear seat: seat cushion replace	P5-6	85242			
Collect and posn screen on bench				Comment	E man door and wald.
Collect and posn seat on bench					5 mm deep and weld up
Remove staples—SCs, Ppn					then fill the bottom of the the body putty.
Remove cushion cover				groove wit	ar body putty.
Remove plastic foam interlay					
Fit plastic foam interlay			6		
Fit cushion cover			Rear seat: plywoo	d panel on	P5- 85248
Fit staples—stapler			back of backrest,		
Put away seat Remove screen from bench					dition remove-install knob
Themove screen morn bench			2 masking patches		
Rear seat: seat cushion replace	P7-	85242	-		
See Op. No. 8 5242 (5–6) in addition (undo and t	ie on			
cushion cover and tacking interlay to v					
Psc, locking wire					
Rear seat: backrest cover, replace	P5-6	85244			
See Op. No. 85242 (P7—) in addition	remove-in	stall			
plastic strip			-		
Rear seat: backrest cover replace	P7	85244			
See Op. No. 8 5242 (P5—6) in addition	untin and	tio on			
backrest cover and tacking interlay at					
remove-install plastic strip	riumo				
		-	-		
Rear seat: plywood panel of back of seat cushion replace	P5-	85246			
Collect and posn screen on bench					
Collect and posn seat on bench					
Remove staples—SCs, Ppn					
Remove cushion cover					
Remove plastic foam interlay					
Remove staples for sacking interlay—S	Cs, Psc				
Take off sacking interlay					
Remove clinchers for spring assembly-	SCc				

Remove cushion cover
Remove plastic foam interlay
Remove staples for sacking interlay—SCs, Psc
Take off sacking interlay
Remove clinchers for spring assembly—SCs

85260

85262

Saab Car Division	Repair Work I	Descriptio	n SAAB 95/9
Replaces page	Date	Edition	Page
	73-01-02	1	85250
Rear seat: plywood panel on back of H5— 85250 seat cushion or backrest, replace Collect and posn screen on bench Collect and place seat cushion or backrest on bench Remove freight floor panel—Tanr, sleeve with SCcs Remove plastic strip (backrest only) Remove staples—SCs, Ppn Free seat cushion cover or backrest cover Remove plastic foam interlay Remove staples for sacking interlay—SCs, Ppn, Psc Take off sacking interlay Remove clinchers for spring assembly—SCs Remove spring assembly	Free backrest cover Remove plastic for Remove nuts—SC: Put away rear panel Fit nuts—Hp Fit plastic foam of Posn backrest cover Fit staples—staple Fit interlay to rear Fit freight floor put away seat cust Remove screen from	am cushion s el ushion er or seat cush r r panel—staple anel	nion cover er
Remove interlay Remove nut—SCs Remove metal strip (backrest only)—SCs Put away rear panel	Jump seat: freight		eplace H5– 8
Collect rear panel Fit metal strip (backrest only)—Hp Fit nuts—Hp Posn interlay Posn spring assembly	Rear seat: backres	lace	
Post spring assembly Post spring assembly clinchers—Assemble, tool (see Op. No. 85246 (P5—), Hp Post sacking interlay Tie and staple interlay—bradawl, Psc, locking wire, stapler Post plastic foam interlay Post seat cushion cover or backrest cover Fit staples—stapler Fit plastic strip (backrest only) Fit freight floor panel Put away seat cushion or backrest Remove screen from bench	Remove freight flo Remove plastic str Remove staples—S Free backrest cove Remove plastic fo Fit plastic foam in Posn backrest cove Fit staples—staple Fit plastic strip (b	seat cushion o por panel—Tar rip (backrest o GCs, Ppn er or seat cush am interlay aterlay er or seat cush r ackrest only)	r backrest on bench or, sleeve with SCcs only) ion cover
Rear seat: freight floor panei of H5— 85252 backrest, replace	Fit freight floor part of Put away seat cust Remove screen from	nion or backre	est
Collect and posn screen on bench Collect and posn seat cushion on bench Remove freight floor panel—Tanr, sleeve with SCcs Install freight floor panel Put away seat cushion Remove screen from bench			
Rear seat: freight floor panel on H5— 85254 backrest, replace			
See Op. No. 85252 (H5)			e
Jump seat: seat cushion cover or H5— 85256 backrest cover, replace	•		
See Op. No. 85262 (H5—) excl remove-install plastic strip and plastic foam interlay			
Jump seat: plywood rear panel, replace H5— 85258			
Collect and posn screen on bench Collect and place seat cushion or backrest on bench			

Saab-Scania - Service Department-Kundendienstabteilung - Nyköping - Sweden-Schweden Remove freight floor panel—Tanr, sleeve with SCcs Remove interlay from rear panel—SCs, Ppn Remove staples-SCs, Ppn

		F	Replaces page	Э		Date		Edition		Pag	-		
						Jan. 1973	3	1			403 -		
per. No	Modelcode	Effective	Secondary time	Lost time allow- ance	Schedule time	Oper, No	Mod	delcode	Effecti time	ve	Seconda time	time allov ance	Schedu time v-
35403	5-	15	2	2	19								
85404	5-	49	5	5	59								
85406	5-	7	1	1	9								
35419	5-	55	2	6	63								
85421	5-	10	2	-1	13								
85423	5-	5	1	1	7								
85425	5-	27	1	3	31								
85427	5-	34	1	4	39								
85429	5-	17	1	2	20								
85452	5-	63	5	7	75								
85481	5-	14	1	2	17								
86102	H5 - 8	30	3	3	36								
86102	H5 - 8	55	3	6	64								
86102	H9 –	13	2	2	17								
86104	H5 -	22	2	2	26								
86106	5-	12	2	1	15								
86118	5-	24	2	3	29								
86127	9–1	6	1	1	8								
86171	5-	13		1	14								

Lift out fresh air heater

Repair Work Description SAAB 95/96

85423

85425

85427

85429

Saab Car Division Date Edition Page Replaces page 73-01-02 1 85403 Fresh air heater: install (power unit out) 5-85403 Fresh air heater: fresh air duct replace (fresh air heater out) Posn fresh air heater Install control cable—SCcs Remove fresh air duct from rear cover-SCcs Align fresh air heater Fit fresh air duct to rear cover Fit bolts at bulkhead-SCcs Fit windshield washer bottle bolt-SCcs Connect lead Fresh air heater: front cover replace 5-Posn inner part of heater (fresh air heater out) Fit nuts-Trh, Tebl, Sdh 7/16 Remove hoses (2)-Pcl Fit heater control cable-SCcs Remove fan motor-SCcs Disconnect thermostat coil Remove covers—SCcs Fresh air heater: heat exchanger replace 5-Remove heater tap-SCcs Drain coolant (open tap on engine block only)-Wco 7/16 Remove gasket Remove fan motor-SCcs Assemble in reverse order Release clips holding cardboard to bulkhead-Ppn Turn back floor mat and cardboard on bulkhead Remove nuts for fresh air heater housing-Was 7/16, Wadj 6 Fresh air heater: front and rear covers 5-Remove coolant hoses-Pcl replace (fresh air heater out) Remove housing Remove hoses (2)-Pcl Remove heat exchanger Remove fan motor-SCcs Install parts removed above Disconnect thermostat coil Start engine, check hose connection, vent heat exchanger Remove draincock Separate covers—SCcs Remove heater tap-SCcs Fresh air heater: fan motor replace 85406 Remove gasket Remove fan motor-SCcs Remove fresh air duct-Sccs Fit fan motor Remove rubber gasket Check operation Assemble in reverse order Fresh air heater: front cover replace 85419 Fresh air heater: rear cover and fresh 5-(power unit out) air duct replace (fresh air heater out) Remove clips holding cardboard to bulkhead-Ppn Disconnect thermostat coil Fold back cardboard and mats Remove draincock-Wco 7/16 Remove nuts (2)-Trh, Tebl, Sdh 7/16 Separate covers—SCcs Disconnect lead Remove gasket Remove hoses-Pcl Remove rubber gasket Remove draincock Install gasket Remove front cover bolts-SCcs Assemble covers Separate covers Install draincock Disconnect thermostat coil Install rubber gasket Remove heat exchanger Install fresh air duct-SCcs Disconnect control cable-SCcs Install thermostat coil Lift off front cover Remove fan motor-SCcs Remove heater tap-SCcs Remove gasket Assemble in reverse order Fresh air heater: remove (power unit 85421 Disconnect heater control cable-SCcs Remove nuts-Tah, Tebl, Sdh 7/16 Free inner part of fresh air heater Remove bolt (1) for windshield washer bottle-SCcs Remove bolts at bulkhead-SCcs Disconnect lead Free fresh air heater Disconnect cables-SCcs

Saab Car Division Replaces page Date Edition Page 73-01-02 85482 Fresh air heater: heater tap replace 5-85452 Bumpers: corners replace, each (not 86106 rear of station wagon) Drain coolant (open tap on engine block only)-Wco 7/16, Mdv Remove corner-Trh, Sdh 1/2, Wco 1/2 Remove fan motor 1 SCcs Fit corner Release clips holding cardboard to bulkhead-Ppn Turn back floor mat and cardboard on bulkhead Remove nuts for fresh air heater housing-Was 7/16, Wadj 6 86118 Bumpers: centre panel replace (not 5-Remove hoses-Ppn rear of station wagon) Separate fresh air heater housing-SCcs Remove corners LH and RH-Trh, Tebs, Sdh 1/2, Wco 1/2 Remove heat exchanger Free centre panel and posn new Remove heater tap-SCcs, Ppn Fit corners LH and RH Fit new tap Refit parts removed above Fill with coolant-Mfc 86127 Bumpers: rubber buffer replace Start engine, check hose connections and vent heat exchanger (corners off) Remove rubber buffer-SCs Fresh air heater: fresh air duct replace 85481 Install rubber buffer-Ppn Remove windshield washer bottle bolts-SCcs Remove bolt to rear cover-SCcs Bumpers: outer panel replace (corner 5-86171 Remove bolt to bulkhead-SCcssh off) (not rear of station wagon) Take out fresh air duct Install in reverse order Remove bolts-Was 9/16, Trh, Sdh 9/16 Free panel and posn new Install bolts **Bumpers: rear corner replace** H5-8 86102 Remove corner retaining bolts and nuts-Trh, Sdh 9/16, SCcs, Wco 10 Separate leads and pull through corner Remove corner, fit new Pull leads through corner and connect-Ck, Ppn, insulating Fit retaining bolts and nuts Bumpers: rear corner replace, H H5-8 86102 Remove corner retaining bolts and nuts-Trh, Sdh 9/16, SCcs, Wco 10 Separate leads at join Pull leads out of LH or RH corner Disconnect lead from license plate lighting Pull leads through LH or RH corner, and connect license

plate lighting-Ck, Ppn, insulating tape

Connect leads at join

Fit corner and retaining bolts and nuts

Bumpers: rear corner replace, each H9-86102

Remove corner retaining bolts and nuts-Trh, Sdh 9/16, SCcs, Wco 10

Remove corner, fit new

Fit retaining bolts and nuts

Bumper: outer panel replace, rear H5-86104

Remove corner retaining bolts and nuts—Trh, Sdh 9/16 Remove bumper panel and fit new

Fit retaining bolts and nuts Saab-Scania - Service

SAAB

Metodbeskrivningar (ackordsmeddelanden)

Repair Work Descriptions

Methodenbeschreibungen

SAAB-SCANIA

Saab Car Division

Service Department NYKÖPING SWEDEN Copyright Saab-Scania

9

Tillbehör Accessories Zubehör

92107 92109	5-7 5- H5-	Effective time	Secondary time		Schedule time	Jan. 1973 Oper. No		Edition 1 elcode	Effective	92107 - 9 Secondary	dule
92107 92109	5–7 5–	17 18	time 2	lance	1 10		1		Effective		dule
92107 - 92109 92113	5-	18		2	21						
			6								
92113	H5-			2	26						
		73	3	8	84						
92120	H5-	28	2	3	33						
92120	P5	20	2	2	24	0					
92122	9–	14	1	2	17						
92135	5-	1	1		2						
92141	5-	1		1	2						
92158	5-	19	4	2	25						
92204	5-	15	1	2	18						
92220	5-	29	5	3	37				ď		
92244	5-	10		1	11				,		
92245	P5-	18		2	20						
92246	P5-	28		3	31						
To this shee	t boloss	1 shoots	of panain	work	decorintion						

Bend in tabs

Wash stone guard-petrol, (gasoline), rag

Rep	laces page		Date	Edition	Page	
		*	730102	1	92107	
Sill protectors: install new both side	es 5-7	92107	Spares: Stone gu	ıard		
Remove rubber strip at sill—SCcssh Wipe sill Pack sill protectors Fit sill protectors Apply adhesive and install rubber s Spares: Sill protectors		10	Ski holder: fit n Unpack ski hold Assemble ski ho Fit ski holder to	er Ider–SCs, Wco		92204
Grab handle: install new on glove pocket lid Measure and mark out for holes in a pencil, H, centre punch Pilot drill 2 holes—power drill, 0,5 a Change drill and drill out holes to complete the pencil of the pencil and drill out holes to complete the pencil and beneat the pencil and benea	nm drill		Caravan mirrors Unpack 2 mirror Assemble mirror Mark and centre punch Drill holes for 2 Fit mirror mour Fit mirrors to m Wipe clean, adju	rs punch posn in mirrors—power ntings to fender ountings—SCs set posn roughly	r drill, drill s–SCcs	92220
Mesh screen: install new Measure up for brackets and drill h in accordance with instructions—ru Mpd, 3 mm drill, 5.5 mm drill, SCs	ler, slide gaug	je, scriber,	Seat covers, from Unpack Fit cover to seat		5–	92244
Baggage rack (Saab original): install new See 92120, Saab 99	P5—	92120	Seat covers, rear	: install new	P5-	92245
Baggage rack (Saab original): install new See 92120, Saab 99	H5-	92120	Fit cover to seat custinstall backrest Install cover to I Install backrest Install backrest Install seat cush	cushion		
Headrests with cushions: install new, per pair Unpack headrests and cushions—Ck Assemble headrests and cushions Install headrests and cushions in ca		92122	Seat covers, from See 92244, Saab			92246
Exhaust pipe extension Unpack exhaust pipe extension—Cl Fit exhaust pipe extension—SCs	5–	92135				
Wheel trims: install 4 new	5-	92141				
Fender guards (stone guards) ″shor iit new both sides	t" 5–	92158				
Bend up spring strip—SCs Treat with rust preventive—rust pr Fit strip to stone guard Line up and drill—electric drill, 2 m Fit screw—SCs		sh				

						1 1000					72400	07.400	
						Jan. 1973		1			93106 -		
Oper, No	Modelcode	Effective time	Secondary	Lost time allow- ance	Schedule time	Oper, No	Mod	ielcode	Effecti	ve	Secondar time	y Lost time allow- ance	Schedule time
93106	5-	20	5	3	28								
93114	5-	114	14	13	141								
93116	5-8	95	11	11	117								
93117	7	65	4	7	76								
93118	5-	66	7	7	80								
93120	5-	90	10	10	110								
93122	5-	152	10	16	178				2				
93130	5-8	180	11	19	210								
93131	5-	14	3	2	19								
93132	8-	15	2	2	19								
93136	5-	14	6	2	22								
93146	8-	33	6	4	43								
93148	5-	187	15	20	222								
93152	5-	75	5	8	88								
93159	9-	87	13	10	110								
93162	9–	63	13	8	84								
93164	9–	99	13	11	123								
93165	9-	78	13	9	100								
93167	5-	20	1	2	23								
93169	5-	5	1	1	7								
93172	5-7	24	4	3	31								
93174	9-	54	13	7	74								
93178	5-	16	6	2	24								
93182	P5-	113	7	12	132								
93182	H5 - 8	121	7	13	141								
Γο this sh	neet belong	5 sheets	of repair	work	description								

93117

93118

Saab Car Division Date Replaces page Edition Page 73-01-02 93106 Cigarette lighter: install new 5-93106 Separate earth (ground) lead from lighting block, tape up block-Psc, insulating tape Centre punch panel-H, centre punch Connect earth (ground) lead to headlamp both sides-Pclg Remove ashtray Drill 2 holes for relay fixing screws-power drill, drill Screw lighter apart Connect supply lead to starter motor-Pclg-Wco 13 Drill hole in panel-power drill, sheet metal drill Posn supply lead from starter motor to relay-insulating tape Fit lighter-Wco 9/16, Wadj 4 Connect supply lead to relay-Pclg Make up and posn lead, fuse to lighter Make up and connect relay earth (ground) lead-SCs, Pclg Connect lead to fuse-Pclg Make up and connect leads from relay to LH headlamp Connect lead to lighter Connect RH dipped headlamp lead to relay Check operation Posn RH dipped headlamp lead and connect to headlamp Fit ashtray Install relay Make up and posn dipped headlamp lead from headlamp Spares: cigarette lighter, leads and connectors switch to relay Connect dipped headlamp lead to relay 93114 Radio (blue spot): install complete 5-Remove-install headlamp switch and connect leads-tester, (transfer, excl remove) Check operation Install antenna, see 93178 Install headlamp-lighting setting equipment Install suppressor kit, see 93131 Remove any articles in glove pocket Spares: dipped headlamp unit, various leads and Remove glove pocket and Iid-SCcssh connectors Remove plate from glove pocket lid-SCcs Remove basket Remove basket locking rings-SCcs Windshield washer control at Remove door strip at cardboard-SCs steering wheel: install new (extra to washer motor install Remove rivets for cardboard-H, SCch, SCs new) Free and put away cardboard Disconnect-connect earth (ground) cable from/to battery-Install cardboard with loudspeaker, using basket locking de-Wco 1/2 vices-SCcs Remove mechanical washer pump-SCs, Ppn Install rivets for cardboard-Ppo Remove steering wheel-Trh, Sdh 15/16 Install door strip-Hp Remove blanking plate for control-SCcs Install basket Make up and install leads to wiper motor-steel wire, Pclg Mark up and centre punch for holes in front panel-H, SCcp, Make up and install leads to washer motor marker pen Connect leads to wiper motor Drill 1 hole 4.5 mm dia.-power drill, 4.5 mm drill Connect leads to control at steering wheel-SCs Fit front panel (at upper edge)-Wadj Install control at steering wheel Modify (cut out at bottom right and corner) glove pocket-Check operation and adjust shears Refit steering wheel Fit glove pocket and lid-SCcssh, SCcs (assistant if nec) Tape up leads-insulating tape Adjust glove pocket lid-Hp, block of wood, SCcssh Move headlamp switch to panel-Pfl Install radio in front panel using front nuts-Trh, Tebs, Fit rubber plug in steering wheel bearing Sdhl 9/16 Clean mat Install stay at back of radio (or bracket)-Wco 10 Drill 1 hole 5 mm in dia. in bulkhead for stay-power drill, Spares: switch, cover, button, rubber plug, various leads and 5 mm drill, flashlamp, goggles connectors Fit stay to bulkhead-Trh, Tebl, Sdh 10 Fit antenna cable to radio Heated seat cushion, driver's seat: Connect loudspeaker cable to radio install new Connect supply cable to radio and to lock--Ppn Remove headrest Fit trim-Trh, Tebs, Sdhl 9/16 Remove seat Fit knobs-SCs if nec Arrange work bench Check operation Place protective cover on workbench Replace articles in glove pocket Remove seat cover and backrest cover (not completely)-SCs Unpack heated cushions Apply adhesive to heated cushions and plastic foam padding-93116 Halogen dipped light units: install 5-8 Tikafast, brush new (with relay)

Disconnect-connect earth (ground) cable from/to battery-Wco 1/2 Remove headlamps from front panel twice Remove units from rims, twice Fit units to rims, twice Fit headlamps in front panel, twice Install bulbs, twice

Refit seat cover and backrest cover Twist together the two stripped lead ends on the heated cushions and fit a joining sleeve-Pclg, electrical box Cut off any flat pin connectors and fit new; install these in a housing, plug the jointing socket into systoflex and bind

Install heated cushions (on pre-1968 cars glue a piece of

plastic foam between thermostat and seat cover)

Wipe off adhesive from hands

Saab Car Division

5- 93118

electrical tape around the join between systoflex and housing—electrical tape

Thread the lead under the springs in the seat

Tie together the leads at the rear edge of the seat and check that the backrest reclines without subjecting leads to strain electrical tape

Remove protective cover from workbench

Disconnect earth (ground) cable from battery—Wco 1/2 Thread two leads through rubber bushing and run them along the bulkhead and under the door mat—SCs, yellow and black leads

Cut off leads, strip ends, fit two non-insulated flat pin socket connectors and install these in the housing—Pclg

Refit seat

Refit headrest

Connect housings

Cut off leads and strip ends

Fit branching connector to yellow and ring to black lead Fit black lead to one screw on the relay and yellow lead to windshield wiper fuse—SCcs, Ppn

Connect earth (ground) cable to battery

Spares: heated cushions, electrical leads, connectors, connector housings

Heated seat cushion: passenger seat, 5— 93120 install new

Remove headrest

Remove seat

Arrange work bench

Place protective cover on workbench

Remove seat cover and backrest cover (not completely)—SCs Unpack heated cushions

Apply adhesive to heated cushions and plastic foam padding—Tikafast, brush

Install heated cushions (on pre-1968 cars glue a piece of plastic foam between thermostat and seat cover)

Wipe off adhesive from hands

Refit seat cover and backrest cover

Twist together the two stripped lead ends on the heated cushions and fit a joining sleeve—Pclg, electrical box

Cut off any flat pin connectors and fit new; install these in a housing, plug the jointing socket into systoflex and bind electrical tape around the join between systoflex and housing—

electrical tape

Thread the lead under the springs in the seat

Tie together the leads at the rear edge of the seat and check that the backrest reclines without subjecting leads to strain electrical tape

Prepare the following leads: yellow 100+150+150+2000 mm,

black: 150+2000 mm-Pclg, yellow and black lead

Strip lead ends (not at jointing sleeve)

Fit connectors to leads as follows:

yellow 100 mm, 2 flat pin sockets

yellow 150 mm, 1 flat pin socket

yellow 150 mm, 1 branching connector

yellow 2000 mm, 1 branching connector

black: 150 mm, 1 flat pin socket + 1 ring

black 2000 mm, 1 branching connector

Unpack switch and remove nut

Assemble leads, fuse holder, switch and indicator lamp as follows:

yellow 2000 mm to lampholder

vellow 100 mm to lampholder and switch

yellow 150 mm (with flat pin socket) to switch and in fuse holder—SCs

vellow 150 mm to fuse holder

black 2000 mm to indicator lamp housing

black 150 mm to indicator lamp housing

Assemble bulb, holder and housing

Disconnect earth (ground) cable from battery-Wco 1/2

Arrange power drill and conical sheet metal drill-Mpd,

conical sheet metal drill

Drill hole in instrument panel for indicator lamp and switch, drill holes 25 mm to left of and in line with the middle of the LH side of the ashtray, distance between holes 20 mm.

Install indicator lamp and switch-Ppo

Install lead from fuse holder on ignition lock terminal 54—flasher

Connect lead with ring to ashtray fixing screw

Run leads along bulkhead and under floor mat

Cut off leads, strip ends, fit 2 non-insulated flat pin sockets and install these in a housing

Refit seat

Refit backrest

Connect housing

Connect earth (ground) cable to battery

Spares: heated cushions, electrical leads, jointing housing, fuse holder, switch, indicator lamp

93122

Tase Holder, Switch, Harocco, Jan.

Heated seat cushions, both seats: 5install new

Op. Nos 93118 and 93120 where applicable

Halogen lamps: install new 5–8 93130

Disconnect-connect earth (ground) cable from/to battery— Wco 1/2

Remove-install engine hood

Remove fender panels-SCcssh

Remove headlamps from front panel twice

Remove units from rims, twice

Fit units to rims, twice

Fit headlamps in front panel, twice

Install bulbs, twice

Separate earth (ground) lead from lighting block, tape up

block, Psc, insulating tape

Connect earth (ground) lead to headlamp both sides—Pclg Drill 2 holes for relay fixing screws—power drill, drill

Connect supply lead to starter motor—Pclg, Wco 13

Posn supply lead from starter motor to relay—insulating tape Connect supply lead to relay—Pclg

Make up and connect relay earth (ground) lead—Scs, Pclg Make up and connect leads from relay to LH headlamp

Connect RH dipped headlamp lead to relay

Posn RH dipped headlamp lead and connect to headlamp Install relay

Unpack, separate main beam headlamps—SCs

Fit bulbs

Prepare and install supply leads to headlamps—SCs

Prepare and install earth (ground) leads to headlamps

Assemble headlamps

Posn fixing parts, install headlamps, Trh, Tebs, Sdh 17 Connect main beam lead to relay

Connect earth (ground) leads to parking lights

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Saab Car Division

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		73-01-02	1	93130	

5-8 93130

Make up and posn dipped headlamp lead from headlamp switch to relay

Connect dipped headlamp lead to relay

Remove-install headlamp switch and connect leads—tester, Pfl Prepare and posn main beam lead from fuse to relay

Connect to relay

Connect to fuse

Check operation

Refit fender panels

Roughly adjust main beam headlamps, wipe clean—Was 14, rag Fit padded covers

Adjust headlamp settings, all 4 headlamps—headlamp fitting equipment

Spares: headlamps (Bosch, Marchal etc.) holders, bulbs, padded covers, twin relay, dipped headlamp unit various leads and connectors

Suppressor kit: install new

5- 93131

Unpack suppressor kit-Ck

Disconnect earth (ground) cable from battery-Wco 1/2

Fit capacitor to gen-SCs, SCcs, Wco 10

Fit capacitor to ignition coil—SCcs

Refit earth (ground) cables to battery-Wco 1/2

Check operation (start-stop engine and test radio)—exhaust hose

Clock, install new

8- 93132

Find and detach lead from harness-SCs

Remove ashtray

Remove blanking plate-Ppn

Unpack, fit bulb

Install clock, connect lead

Refit ashtray

Check operation

Spares: clock complete

Switch panel, install new (in conj with extra headlamps, install new)

5-

93136

Remove knockouts from panel-H, Sdh, drift

Enlarge hole for indicator lamp-round file, vice

Fit indicator lamp to panel

Make up cables for indicator lamp and install-Pclg

Install panel in car (excl drill holes)-SCcs

Windshield wiper delay relay, install 8— 93146 new

Disconnect earth (ground) cable from battery—Wco 1/2

Unpack, check, arrange

Read circuit diagram

Mark up and centre punch coil relay on bottom edge of panel—pencil, H, centre punch

Drill 2 holes 3 mm dia.-Mpd, 3 mm drill

Fit connectors to earth (ground) leads (yellow/black)—Pclg connectors

Install relay (incl earth (ground) leads)-SCcs

Install supply leads from relay at ignition lock (red)—Pclg, connector

Install lead from relay at wiper motor supply—Pclg, connectors, joining device

Connect earth (ground) cable to battery—Wco 1/2 Check operation

Radio (Blaupunkt): install complete 5- 93148

Install antenna, see 93178

Install suppressor kit, see 93131

Unpack installation kit-Ck

Check and mark up cardboard for loudspeaker—marker pen, loudspeaker

Remove cardboard, see 93114 lines 6–10–SCcs, Scs, H, SCch

Remove sheet metal holder from cardboard—SCs, Psc Make holes in cardboard for fixing parts and loudspeaker leads—template, bradawl, SCcs

Fit fixing parts to cardboard and loudspeaker to fixing parts—SCs, SCcs

Connect loudspeaker leads to loudspeaker with connector—SCs

Install cardboard complete with loudspeaker, see 93114 lines 11–14–SCcs, Ppo, Hp

Remove any articles in glove pocket

Remove glove pocket and lid, and plate from lid-SCcssh, SCcs

Adjust front plate-metal shears, file

Install front plate including drill holes, see 93114 lines 15–17

—H, centre punch, power drill, 4.5 mm drill, Wadj, pencil

Measure up and mark where glove pocket must be cut awayinstallation instructions, ruler pencil

Cut away glove pocket-shears, Ck

Mark up for holes in end panel in glove pocket—end panel,

Drill 4 holes 3.5 mm dia in glove pocket—power drill, 3.5 mm

Install end panel in glove pocket—H, Wadj, assistant
Seal at end panel with masking tape—wide black masking

tape
Modify (cut out at bottom right hand corner) glove pocket—
shears

Adjust glove pocket lid—Hp, block of wood, SCcssh Unpack radio—Ck

Fit bracket to back of radio*)—SCs, Wco 5/16

Install part of fuse holder on supply lead-SCs

Install radio on front panel using front nuts—Trh, Tebs, Sdhl 9/16

Install stay at back of radio (or bracket)-Wco 10

Drill 1 hole 5 mm in dia. in bulkhead for stay-power drill,

5 mm drill, flashlamp, goggles

Fit stay to bulkhead—Trh, Tebl, Sdh 10

Fit antenna cable to radio

Connect loudspeaker cable to radio

Connect supply cable to radio and to lock-Ppn

Fit trim-Trh, Tebl, Sdhl 9/16

Fit knobs and felt strip

Check operation

Replace articles in glove pocket

*)only Flensburg and Automatic

Nykoping - Sweden-Schweden

Date Replaces page Edition Page 73-01-02 93152 Connect 1 extra lead to right hand extra headlamp and run

Compressed-air horns (install new) incl relay

93152 5-

Unpack horns

Remove original bracket

Posn, mark and drill hole for horns-power drill Install 2 horns

Mark and drill holes for compressor

Install compressor

Posn and install hose

Mark and drill holes for relay

Install relay

Run leads from compressor to relay, from relay to battery, from relay to switch, from switch to original horn

Spares: Compressed-air horns, relay

Extra headlamps: 1 pair with relay (long range) install new

93159 9-

See 93126, 9- and the following remark

Connect 1 extra lead to right hand extra headlamp and run lead to left hand extra headlamp and connect it there

93162 Extra headlamps, 1 with relay (long 9range) install new

Install mounting brackets (behind bumper)-Trh, Sdh 9/16 Fit holder to bracket-Was 1/2

Mark up centre punch for switch in panel-H, centre punch Drill 1 hole 8.5 mm dia for switch-Mpd, 8.5 mm drill Disconnect earth (ground) cable from battery-Wco 1/2 Unpack wiring set and arrange

Mark up for relay and centre punch-H, centre punch Drill 2 holes 3 mm dia for relay-Mpd, 3 mm drill Install relay-SCs

Connect to standard lighting relay-Ppn

Connect to car battery-Wco 1/2

Run lead into passenger compartment and up to hole in panel Connect lead to switch and install switch on panel-SCs, Pclg, Ppn

Run lead to holder on mounting bracket

Unpack headlamp and fit the holder-Wco 11/16, Trh, Tebl, Sdh 1/2, Wco 1/2

Connect lead to headlamp and (where applicable) install bulb-Pcgl, SCs, SCcs

Mark up and centre punch for hood stop-H, centre punch Drill 1 hole 6.5 mm dia for hood stop-Mpd, 6.5 mm drill Install hood stop-Was 10, Was 7/16

Connect earth (ground) cable to battery-Wco 1/2 Check operation

Adjust headlamps, see Saab 99-Trh, Tebl, Sdh 1/2, Wco 1/2, Wco 11/16

Fit lamp guard

93164 Extra headlamp: 1+1 (1 with relay 9and 1 without relay) (long range and cornering), install new

See 93162, 93174, 9-

93165 Extra headlamp, 1 pair without relay (cornering): install new

See 93174, 9- and the following remark

lead to left hand extra headlamp and connect it there.

Wiring set with relay for extra headlamp: making up, each

93167

Measure and cut 55 cm of 4 mm² wire and strip approx 7 mm at both ends—wire 4 mm², 2.5 mm², 1 mm² Fit an M8 ring at one end and connect the other end to 30/51 on relay-connectors, ruler, Pclg, Systoflex Measure and cut 175 cm 2.5 mm² wire and strip approx 7 mm at both ends

Connect one end to 87 on relay

Measure and cut 110 cm 1 mm² and strip approx 7 mm at both ends

Connect wire to 85 on relay

Measure and cut 15 cm*) 1 mm² wire and strip approx 7 mm at both ends

Connect one end to 86 on relay and a quick connect branching connector at the other end

Measure and cut 10 cm 1 mm² wire and strip approx 7 mm at both ends

Connect one end to switch and an M10 ring to other end Thread systoflex over the first two wires

*) For 5-7 models this wire must be longer, approx 50 cm

93169 Wiring set without relay for extra 5headlamps: making up, each

Measure and cut 300 cm 4 mm² wire and strip approx 7 mm at both ends-4 mm² wire, ruler, Pclg, connectors, electrical

Measure and cut 125 cm of 4 mm² wire, strip approx 7 mm at both ends and fit a quick-connect branching connector to one end

Bind together the wires at approx 25 cm intervals with tape

93172 5-7 Windshield washer motor install new (replace lid)

Fit motor lid to washer bottle instead of existing lid-Ppn Prepare and install lead from switch to washer motor-Pclg Prepare and install earth (ground) lead to motor Prepare and install lead from switch to fuse box Re-connect wear hoses, cover bulkhead bushing-insulating

Remove-install switch from strip to instrument panel-Pfl Check operation

Spares: Windshield washer motor, various leads and connectors

Service

Page

93174

Edition

Saab Car Division Replaces page Extra headlamps: 1 without relay 9-93174 (cornering), install new Install mounting brackets (behind bumper)-Trh, Sdh 9/16 Fit holder to bracket-Was 1/2 Mark up centre punch for switch in panel—H, centre punch Drill 1 hole 8.5 mm dia for switch-Mpd, 8.5 mm drill Disconnect earth (ground) cable from battery—Wco 1/2 Unpack wiring set and arrange (extra time if made up) Connect short lead to fuse box Run both leads into passenger compartment and up to hole in panel Connect both leads to switch-SCs, Ppo Install switch in hole in panel-Ppn Run long lead down to holder in mounting bracket Unpack headlamp and fit the holder-Wco 11/16, Trh, Tebl, Sdh 1/1, Wco 1/2 Connect lead to headlamp and (where applicable) install bulb-Pclg, SCs, SCcs Mark up and centre punch for hood stop-H, centre punch Drill 1 hole 6.5 mm dia for hood stop-Mpd, 6.5 mm drill Install hood stop-Was 10, Was 7/16 Connect earth (ground) cable to battery-Wco 1/2 Check operation Adjust headlamps, see Saab 99-Trh, Tebl, Sdh 1/2, Wco 1/2, Wco 11/16 Fit lamp guard Antenna, install new 93178 5-Unpack antenna Remove nut and washers from antenna mounting Mark up and centre punch for antenna mounting-H, centre punch

Drill a 2.5 mm dia hole for antenna mounting-power drill, 2.5 mm hole cutter

Remove swarf-rag

Extract metal disc from antenna mounting hole-magnet Centre punch for antenna lead hole-H, centre punch Drill a 10 mm dia hole for antenna lead-power drill, 10 mm dia drill

Run lead through hole and install antenna-Wco 7/8, Wadj Adjust antenna length and slope-ruler

Seal round antenna cable in passenger compartment* - body putty, flashlamp

*= glove pocket out

Reversing lamps, 2 round, and gear lever switch: install new

P5--93182

Remove mats and masonite panels

Remove rear seat cushion and seat-Hp

Open trunk, remove trunk floor-SCcs

Unpack lamps

Posn lead from bulkhead to rear of car-steel wire

Make up and install lead to lamp No. 2-Pclg

Drill holes for and install 2 bushings in wheel house-power

drill, 8.5 mm drill, H, centre punch

Drill holes for and install 2 bushings in wheel house-power

drill, 3mm drill, template 794 A1

Drill holes for and install 2 bushings in fenders-power drill,

8.5 mm drill

Saab-

Install 2 lamps-SCcs, SCs

Install gear lever switch-SCs

Install lead from fuse box to switch

Check operation and adjust switch posn Install trunk floor-Hp

Install rear seat and cushion

Install masonite panels, mats and arrange

Spares: Reversing lamps, switch with leads, various connectors

Reversing lamps, 2 round, and gear

H5-8 93182

lever switch: install new

Remove mats and masonite panels Remove spare wheel

Open rear door, fold up child seat

Unpack lamps

Date

73-01-02

Install lead from bulkhead to rear of car-steel wire

Remove glass of both lamps-SCs 3

Mark, drill holes for 2 fixing bolts, 2 lamps-3 mm drill,

measuring tool S

Drill holes for and install bushing in rear panel-8.5 mm drill, SCs

Drill holes for and install bushings in mounting panel-8.5

mm drill,H, centre punch

Make up and install leads to lamp No. 2-Pclg

Install 2 lamp housings-SCcs

Install bulbs and glass-SCs

Install gear lever switch

Posn and connect the lead from fusebox to switch

Check operation, adjust switch posn

Install masonite panels and mats, arrange passenger

compartment

Install spare wheel

Spares: Reversing lamps, switch with leads, various

connectors

vision	F	Replaces page	9		Date	Edition	Pa	ge		
					Jan. 1973	1		93211 -	93266	
Modelcode	Effective	Secondary time	Lost time allow- ance	Schedule time	Oper, No	Modelcode	Effective	Secondary time	Lost time allow- ance	Schedule time
7–	11	6	2	19						
7–	4		1	5						
7	454	11	47	512						
8	411	11	42	464						
9–	381	11	39	431						
0	389	16	41	446						
5–6	34	6	4	44						
7–8	30	6	4	40	1					
9-	54	8	6	68						
7–	16	6	2	24						
7–	26	3	3	32						
0-	33	4	4 -	41						
7-	5	1	1	7						
			1							
	7- 7- 7 8 9- 0- 5-6 7-8 9- 7- 0- 0-	Modelcode Effective	Modelcode Effective time Secondary time 7- 11 6 7- 4 1 8 411 11 9- 381 11 0- 389 16 5-6 34 6 7-8 30 6 9- 54 8 7- 16 6 7- 26 3 0- 33 4	Modelcode Effective Secondary Lost time allow-lance 1	Modelcode Effective Secondary Lost time allowance Schedule time Secondary Lost time allowance Schedule tim	Modelcode Effective Secondary Lost time allowal ance Coper. No The secondary Lost time allowal ance Coper. No The secondary Lost time allowal ance Coper. No The secondary C	Modelcode Effective Secondary Lost Schedule Sime Secondary Lost Sime Secondary S	Modelcode Effective Secondary Lost time Schedule time Lost time Schedule time Schedule time Schedule time Secondary Lost time Schedule	Modelcode Effective Secondary Lost time Lime L	Modelcode Effective Secondary Lost time Seco

Saab Car Division

Date Edition Page Replaces page 73-01-02 93211 Cut away 2 ribbs in air outlet-metal shears Parking heater: Eberspächer BN2S, 7-93211 Fix cover plate, drill 4th hole-SCcs, 6 mm drill adjust fuel quantity (in conj with install Release fuel pipes in floor-SCcs new, annual inspection etc.) Saw off and deburr fuel pipes-hacksaw blade, file Fit new fuel pipes in wheelhouse-SCcs Pump up fuel in hose Connect fuel lines and clip to floor-SCcs Pump fuel for 2 minutes-25 ml measuring beaker + clock Install exhaust pipe-SCs, 3.5 mm drill, Wadj 4, SCs Read off measuring beaker and adjust regulator screw-Wco 7 Install exhaust cover-SCcs Pump fuel for 2 minutes Install wheel and lower car Read off measuring beaker and make final adjustment to Connect hoses to exhaust pipe—SCs regulator screw Remove defroster hoses and clips-Ppn Bend wiring harnesses clear Drill 2 pilot holes for hole cutter in bulkhead-8 mm drill Parking heater: Eberspächer BN2S, 93215 Drill 4 fixing holes for air ducts-7 mm drill raise-lower assembly Cut holes LH and RH in bulkhead, deburr holes-75 mm Release and raise assembly hole cutter with cylindrical spigot, Ppn Lower assembly and lock Cut away bulkhead insulating material-knife Install air ducts LH and RH-assistant, Was 7/16, SCs, Wadj 6 Install LH and RH inner ring and blips-Ppn 93244 Parking heater, Eberspächer BN2S, 7 Adjust fresh air control install new Drill hole in bulkhead for timer leads-8 mm drill Install timer and defroster hoses-3.5 mm drill, SCcs See 93244 (8) adding: Install fuel hose clip in heater cover—SCcs Remove and reshape washer bottle holder-SCcs Install unit to air ducts Drill 2 holes in holder and wheel house-5.0 mm drill, Adjust exhaust pipe posn and exhaust cones-SCs 2.5 mm drill, centre punch Adjust mounting bracket posn-Wco 7/16 Fit holder to wheelhouse-SCcs Connect combustion chamber inlet pipes-Hp, SCs Connect hose to washer lid Connect fuel hose to pipes Drill hole for washer hose in bulkhead-8 mm drill Fit 6 air pipe fixing screws to unit-3 mm drill, SCs Connect washer hose to control Connect leads and fix-SCs, SCcs, Wco 9/16 Centre punch bulkhead for 6 holes-centre punch, H, template Seal bulkhead bushings-sealing putty Drill 2 centering holes in bulkhead insulating material Connect earth (ground) cable to battery Cut holes in LH and RH insulating material with hole cutter Install air cleaner Spares: Parking heater Blow away swarf from engine compartment-compressedair gun Remove front mat and clean 93244 Parking heater, Eberspächer BN2S, 8 Write guarantee card and install instructions for use install new Install drainscrew, fill with coolant Final-tighten fuel pipe connections on unit-Wco 12, Wco 17 See 93244 (9-), adding Test start Remove throttle control-SCcs, Psc Vent fuel system, clean nozzle-SCs, Wco 12 Install bracket and throttle control-SCcs, Wadj 4, Wco 7/16 Test run, check operation, check for leaks Spares: Parking heater 93244 Parking heater, Eberspächer BN2S: 9_ install new Open coolant drain tap-Wco 7/16 Disconnect earth (ground) cable from battery-Wco 1/2 Unpack heater Remove air cleaner-Was 10, Wco 7/16 Disconnect hoses to element-SCs Disconnect water distr pipe-Was 3/8, lever Install new water distr pipe-Hp Measure, cut and install hoses to element-metal shears Jack up front of car, remove LH front wheel-Lj, Ltr, Sdh 3/4, Tanr, SCs Posn cover plate, drill 3 fixing holes-power drill, 3.5 mm drill, SCcs Drill 2 holes for fuel pipe clips-2.5 mm drill

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Parking heater, Eberspächer BL2ZW,

Replaces page

93244

Edition Date Page 73-01-02 93244 Install switch-SCs Tape up lead-electrical tape, Ck Connect pipes and install hose clips Install drain tap Fill with coolant-Mfc Check operation, check for leaks Spares: Engine heater 93254 Engine heater, Calix plug-in: 7-8 install new Remove-install engine hood—SCs Disconnect earth (ground) cable, open drain tap in block-Wco 15, Was 11 Disconnect coolant hose, bend away fuel pipe-Pcl Centre punch and drill holes in plug (3 drills)-power drill, centre punch 4, 3, 5, 8 mm drills Extract plug-SCs Remove 1 timing chain cover bolt-Was 13 Install heater coil in block-Was 13 Connect coolant hose Drill 2 holes and install switch in wheelhouse-power drill,

Spares: Engine heater

Connect earth (ground) cable and fit radiator cap

install new
See 93254, Saab 95/96, 7—8 adding the following

93254

9-

See 93254, Saab 95/96, 7—8 adding the following Remove windshield washer bottle and air cleaner—Wco 10, Pcl

Disconnect fuel hose complete with filter—SCssh, SCs
Fit a clip to plug-in heater fixing bolt—Trh, Psc
Shorten hose between filter and pump by 9 cm—ruler, Psc
Replace the other hose with a hose 40 cm long—SCs, ruler
Psc, petrol (gasoline)

Connect fuel hoses to both clips and ensure that the curve in the hose between the pump and the filter does not cause any kinks to form—SCs, SCssh, petrol (gasoline)
Install air cleaner and washer bottle—Wco 10, Pcl

Parking heater, Eberspächer BN2S: 7— 93260 adjust fuel quantity

Remove cover on unit
Remove nipple—Wco 12, SCs
Pump up fuel

Tape up leads-insulating tape

Engine heater, Calix plug-in:

Fit drain tap to block

Fill with coolant

Check for leaks

Check operation

Pump fuel for 2 minutes—25 ml measuring beaker
Read off measuring in beaker and adjust regulator screw—
Wco 7

Pump fuel for 2 minutes

Read off measuring beaker and make final adjustment to regulator screw
Install nipple

Test start, install cover

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Extract plug-drift

Slacken hose clips, remove pipes—Pcl, SCcs Drill hole in plug—Mpd, 8 mm drill

Mount heater on engine block—Was 1/2 Drill hole for switch—Mpd, 3.5 mm drill

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		73-01-02	1	93262
arking heater, Eberspächer BN nnual inspection	2S: 7- 932	62		
Remove glowplug-Wadj 4, SCs	, Trh, Sdh 13/16			
lean glowplug-Cwb, Cag		THE COLUMN		
nstall glowplug Remove fuel filter				
Clean fuel filter—Cag				
nstall fuel filter				
Remove fuel jet—SCs, Wadj 6 Clean, fuel jet—Cag				
nstall fuel jet				
Check electrical connections, cl Start heater—check operation	ean fuses–Ck, Cwb, Va	seline		
during test running, check for	leaks on the fuel and co	oolant		
noses and check tightness of fu				
Parking heater, Eberspächer BL	2ZW: 0- 932	62		
nnual inspection				
Remove glowplug-Ppn, Wco 7,	/8			
Check glowplug, adjust or repla	ce if nec-rag, wire gaug	je		
Install glowplug—Wco 7/8 Replace fuel filter—SCs, rag				
Check fuel hoses and tighten cl	ips-SCs, MI			
Clean, polish and lubricate fuse	s-Ppn, rag Vaseline			
Check, electrical connections, a Check coolant hoses and tighte		MI		
Check air hoses and tighten clip				
Test start heater, check operati				
Parking heater, Eberspächer BN glowplug replace	12S: 7– 932	660		
Remove glowplug–Wadj 4, SCs	, Trh, Sdh 13/16			Park to
Install glowplug				
Check operation				
Spares: Glowplug				
Parking heater, Eberspächer BL glowplug replace	.2ZW: 0- 932	66		
	/0			
Remove glowplug—Ppn, Wco 7, Install new glowplug—Wco 7/8	/δ			
Check operation				

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Saab Car Div	Repair Work — Standard Times SAAB 95/96											
		ĮF	Replaces page			Jan. 1973	East	Edition		Page 93318 - 95202		
per. No.	Modelcode	Effective	Secondary	Lost	Schedule time		Modelco	1 de Effe	ctive			
		Effective time	time	Lost time allow- ance	time			time	!	Secondary	allow- ance	time
3318	5–	164	14	18	196							
93320	5-	50	8	6	64							
93326	5-	31	4	4	39							
93326	7–	20	5	3	28							
95202	P5 -	235	11	25	271							
95202	H5-	250	11	26	287							
o this s	heet belong	1 sheets	of repair	work	description							

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Repair Work Description

Replaces page Date Edition Page 93318 73-01-02 1 Radio (Blaupunkt): transfer complets Remove engine heater, lead and switch-Was 13, SCcs 2 93318 Install new heater-Was 13 Remove radio, see 93320 Install coolant hose Install antenna, see 93178 Install switch Install suppressor kit, see 93131 Tape up lead-insulating tape Install radio, see 93114 Fill with coolant Connect earth (ground) cable to battery, refit radiator Check operation Radio: remove for transfer 5-93320 Check for leaks Remove earth (ground) cable from battery-Wco 1/2 Spares: Engine heater Remove all leads from radio and lead from radio to lockflasher, Ppn Remove rear stay from bulkhead-Trh, Tebl, Sdh 10 Towing ball with socket: install new P5-95202 Remove rear stay from radio-Wco 10 Remove knobs-SCs if nec Remove spare wheel etc from rear floor Remove trim-Trh, Tebl, Sdhl 9/16 Remove bitumenized paper from rear floor Remove front nuts-Trh, Tebl, Sdhl 9/16 Unpack and arrange parts-Psc Raise-lower rear of car-Lj, Ltr Take out radio, put on one side Remove bumper bolts-Trh, Sdh 1/2, Sdh 9/16 Remove any articles from glove pocket Remove glove pocket, lid and front panel-Wadj, SCcssh Install inner rear curved support Posn towbar and mark up-SCs Remove basket Collect welding equipment and light-welding equipment Remove basket locking rings-SCcs with accessories Remove door strip at cardboard-SCs Heat underseal, scrape off-Csp Remove rivets for cardboard-H, SCch, SCs Extinguish welding equipment, put away Free and put away cardboard with loudspeaker Clean scraper Install cardboard, using basket locking devices—SCcs Drill holes for and install all bolts-power drill, 8.2 mm Install rivets for cardboard-Ppo Install door strip-Hp drill, goggles Tighten all bolts-Trh, Tebl, Sdh 1/2, Wco 1/2 Install basket Remove rear light glasses-SCcs Install panel in glove pocket lid-SCcs Run leads from rear, stop and direction indicator lights-Install glove pocket and lid-SCcssh electrical pliers Adjust glove pocket lid-Hp, block of wood, SCcssh Remove-install backrest Replace articles in glove pocket Run lead from fusebox to rear of car-steel wire Reconnect earth (ground) cable to battery-Wco 1/2 Tape up lead, fit clips-insulating tape, 4 mm drill, SCcs Collect removed parts, place in cardboard box Make up earth (ground) lead Connect all leads to socket-SCs Fit socket to towbar-SCs, Wadj 4 93326 Engine heater: Calix plug-in, replace 5 - 6Connect current supply lead to fusebox Check for vóltage at socket-test lamp Remove coolant drain tap-Wco 7/16, Mdv Vacuum-clen rear floor-vacuum cleaner Slacken hose clip, move pipes-Pcl, SCcs Lay bitumenized paper Remove heater, lead and switch-Was 1/2, SCs Install spare wheel etc. in rear space Install new heater, lead and switch Tape up lead Spares: Towing attachment, socket (7-pole), towing ball Connect pipes, fit hose clips cover, various leads and connectors Install drain tap Fill with coolant-Mfc Check operation, check for leaks H5-95202 Towing ball with socket: install new Spares: Engine heater See 95202 (P5-) Spares: Towing attachment, socket (7-pole), towing ball cover, various leads and connectors 93326 Engien heater: Calix plug-in, replace

Disconnect earth (ground) cable from battery-Wco 15 Open drain tap in block-Was 11 Disconnect coolant hose-Pcl

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