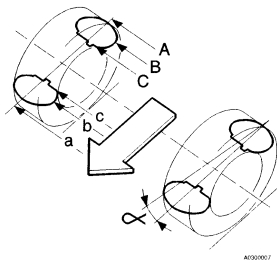


Group 6 Front suspension and steering

Group 60 Wheel alignment

Turning diameter, measured on tire	meter	11.5
measured on bumper	meter	12.3
Turns of steering wheel		2.9

Angle (* can be adjusted)	Check and setting values	Max difference be- tween right and left-hand side
Front		
Camber	$0^{\circ} \pm 1^{\circ}$	1°
Can be adjusted $\pm 1^{\circ}$ using a conversion kit. See Workshop Manual and SM.		
Caster	$3^{\circ} 20' \pm 1^{\circ}$	1°
Toe-in*	$20' \pm 6'$	$6'$
Wheel deflection		
Inner wheel	$39.9^{\circ} \pm 1.6^{\circ}$	
Outer wheel	$34.8^{\circ} \pm 0.9^{\circ}$	
Rear		
Camber	$- 1^{\circ} \pm 30'$	
Toe-in*	$4' \pm 10'$	
Thrust angle *	$0^{\circ} \pm 15'$	



Conversion table for Toe-in from degrees to mm (inches)

	A-a	B - b	C - c
16" wheel	3.6 ± 1.0 mm (0.14" ± 0.04")	2.9 ± 0.9 mm (0.11" ± 0.04")	2.5 ± 0.8 mm (0.10" ± 0.03")
17" wheel	3.6 ± 1.0 mm (0.14" ± 0.04")	2.9 ± 0.9 mm (0.11" ± 0.04")	2.7 ± 0.8 mm (0.11" ± 0.03")
18" wheel	3.6 ± 1.0 mm (0.14" ± 0.04")	2.9 ± 0.9 mm (0.11" ± 0.04")	2.7 ± 0.8 mm (0.11" ± 0.03")

Group 61 Front suspension

Tightening torques	Nm	Dim.
Ball joint - Spring strut	50	M 10
Ball joint - Control arm, step 1	18	M 8
stage 2	120°	
Control arm - Sub-frame, stage 1	65	M 12
stage 2	120°	
Anti-roll bar - Sub-frame	50	M 10
Anti-roll bar - Link	50	M 10
Link - Spring strut	50	M 10
Spring strut - Body	25	M 8
Shock absorber - Steering knuckle, stage 1	65	M 12
stage 2	90°	
Front wheel hub - Steering knuckle, stage 1	20	M 12
stage 2	45	
stage 3	60°	
Front wheel hub - Front wheel hub, stage 1	120	M 22
stage 2	60°	

Tightening torques	Nm	Dim.
Screw cap - Shock absorber	70	M 14
Shock absorber - Upper bearing	70	M 14

Group 64 Steering

Steering gear		
Make		CAM GEAR
Turns lock to lock		3.0
Gear ratios		16.8:1
Clearance between pre-tensioning piston and cover	mm	0.05 - 0.12
Friction torque , measured at input shaft	Nm	0.6 - 1.8
Power steering balance check:		
pump pressure at specified steering shaft torque	MPa	1.2
torque on steering shaft	Nm	3.4 - 4.0
largest permitted difference between left and right	Nm	0.7
Lubricant , type	Grease, Volvo no	11 61 001
amount	grams	100
Hydraulic fluid oil , Automatic transmission fluid	type	F, G, Dexron II D/E
or servo oil	Volvo no.	11 61 317
amount	liters	0.8
Power steering pump		
Maximum pressure	MPa	8.3

Tightening torque, steering	Nm	Dim.
Steering wheel - Steering column, upper	40	M 12
Airbag unit - Steering wheel	10	M 6
Steering shaft, lower - Steering column, steering gear	20	M 8
Steering column - Bracket	50	M 10
Steering gear - sub-frame	50	M 10
Steering gear - Mounting, center	80	M 12
Track rod -Outer ball joint	70	M 14
Tie rod ball joint - Steering arm	70	M 12

Tightening torque, steering	Nm	Dim.
Bracket - Sub-frame	25	M 8
Limiter, steering gear - Sub-frame	50	M10
Limiter - Bracket, power steering pipe ...	25	M 8
Mounting, center - Sub-frame	50	M 10
Stay, steering column - Stay, A-post	25	M 8
Collision protection system, power steering pump - Front mounting plate	25	M 8

Group 65 Rear suspension

Tightening torques 2WD	Nm	Dim.
Rear axle link - Body, stage 1	105	M 14
stage 2	90°	
Bracket - Body, stage 1	65	M 12
stage 2	60°	
Rear axle link - Trailing arm, stage 1	65	M 12
stage 2	120°	
Bushing housing - Transverse arm, stage 1	50	M 10
stage 2	120°	
Bushing - Transverse arm	80	M 12
Shock absorber - Lower mounting	80	M 12
Shock absorber - Upper bearing	40	M 10
Shock absorber (Nivomat) - Upper bearing	40	M 12
Shock absorber (Nivomat) - Upper bearing, step 1	20	M 10
stage 2	90°	
Spring mounting - spring seat	40	M 10
Rear wheel hub - Stub axle, stage 1	120	M 22
stage 2	35°	
Stub axle - Endplate, stage 1	35	M 10
stage 2	60°	
Upper bearing - Body	25	M 8
Anti-roll bar - Tie plate, left, stage 1	50	M 10
stage 2	90°	

Tightening torques 2WD	Nm	Dim.
Washer, upper spring mounting - Body ..	50	M 10
Wheel - Hub	110	M 12
Anti-roll bar - Transverse arm, left, stage 1	65	M 12
stage 2	90°	
Anti-roll bar - Transverse arm, right, stage 1	65	M 12
stage 2	90°	
Anti-roll bar - Transverse arm, right	50	M 10