

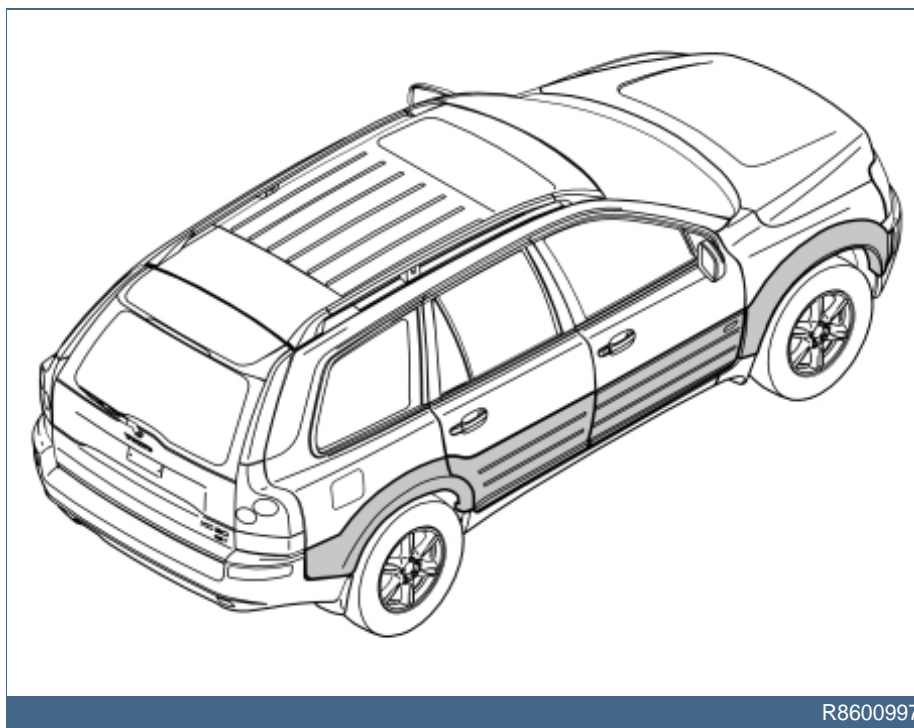


XC90

Section	Group	Weight(Kg/Pounds)	Year	Month
8	86		2004	05

XC90 2004, XC90 2005, XC90 2006

Replaces issue: 2004 03



Installation instructions, accessories - Side panel

Volvo Car Corporation Göteborg, Sweden



Required tools



A0000162



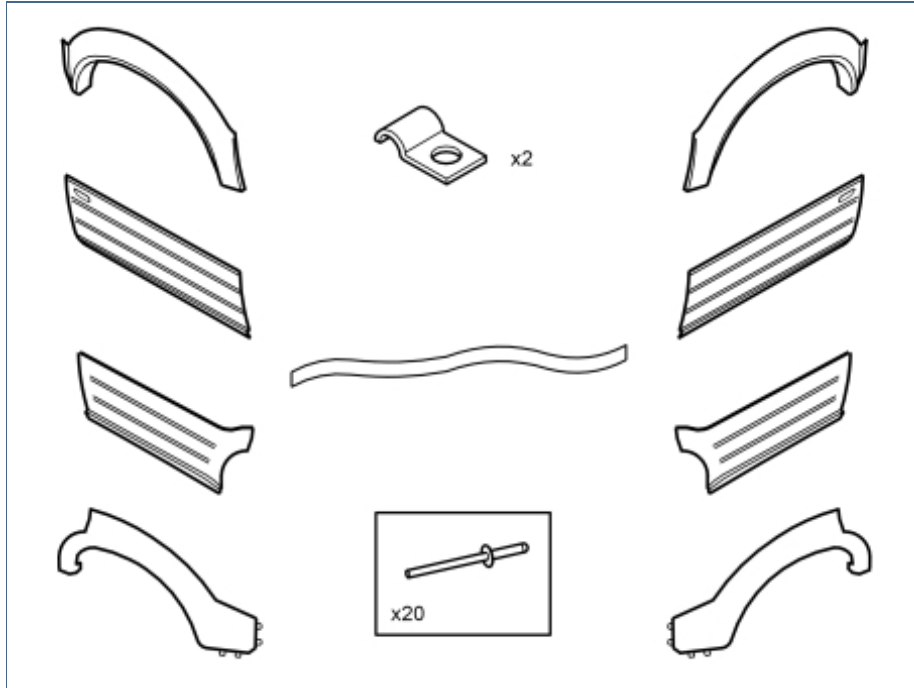
A0000163



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R8600996

Any comments on this publication? Please contact your nearest dealer. Thank you!

Publication no: MA30730138, Issue: 2004-05

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INTRODUCTION

- **NOTE! Read through the entire text before carrying out any work.**
- The front page gives the date of this edition and the edition it replaces
- The second page shows the tools needed for the installation and the contents of the installation kit
- The illustrations display the procedure in order of operation. The order of operation is repeated in the text section
- Cut out the text page in order to follow the illustrations and text at the same time.

Side panel

Note!

Install the side panel in the same way on both sides of the car.



1

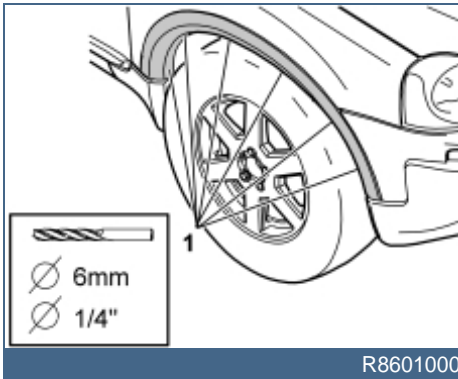
Preparations

- Wash and degrease the car.

Note!

It is important that the surfaces on which the side panels will be mounted are completely free of tar and other road dirt.

2A



Preparations

Remove the front wheel arch extension (secured by three hooks at the bottom, tape at the top, five clips and six rivets):

Illustration A

- Drill out the six rivets (1) holding the front wheel arch extension to the edge of the wheel arch. Use a **6 mm (1/4")** diameter drill bit.
- Remove the remains of the rivets.

2B

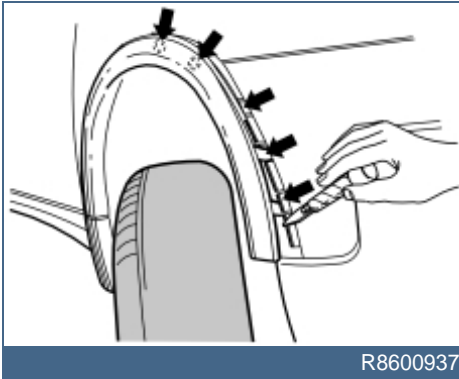


Illustration B

- Carefully pry off the front lower edge of the wheel arch extension. Use a plastic weatherstrip tool.

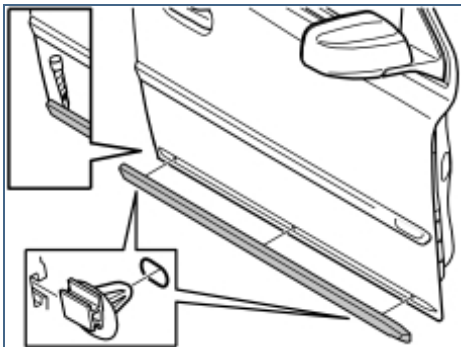
Note!

Do not damage the paint work.

- Fold out the front lower edge of the wheel arch extension to expose the first mounting clip
- Insert the weatherstrip tool at the side of the clip, between the panel and the wheel arch extension. Twist the weatherstrip tool to pull the clip away from the edge of the wheel arch or so that it breaks
- Then continue in the same way until all five clips have released
- Remove the wing extension. Place the wing extension to one side. This will not be reused.



3



R8400929

Preparations

Removing the lower trim strip on the front door:

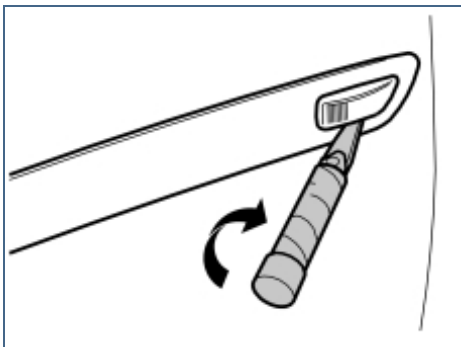
- Use the weatherstrip tool to pry the rear edge of the trim strip until the tape comes away at the bottom and top edges.

Note!

Do not damage the paint work.

- Push the trim strip to one side to expose the first clip
- Remove the clip in the same way as for the clips on the wheel arch extension
- Pry the trim strip off working forwards. Remove the last clip in the same way as previously
- Place the trim strip to one side. This will not be reused.

4A



R8400931

Preparations

Remove the upper trim strip on the front door:

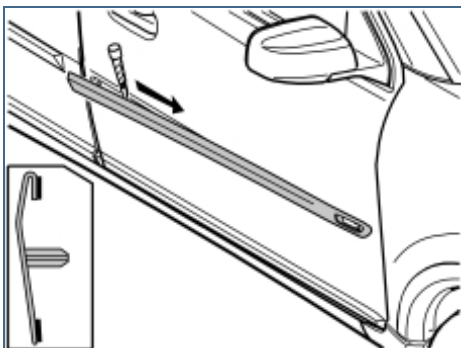
Illustration A

- Remove the parking lamp. Carefully pry off the bottom edge. The parking lamp has a cut out on its lower edge to make prying it off easier
- Disconnect the connector from the parking lamp.

Note!

Ensure that the connector does not fall into the door.

4B



R8400930

Illustration B

- Use the weatherstrip tool to pry the rear edge of the trim strip until the tape comes away at the bottom and top edges.

Note!

Do not damage the paint work.

- Continue to pry off the trim strip working forwards until it has detached completely
- Place the trim strip to one side. This will not be reused.

5

Preparations

Remove the lower trim strip on the rear door:



- Carry out the same procedure as for the front door (step 3), but start at the front of the trim strip and work backwards
- Place the trim strip to one side. This will not be reused.

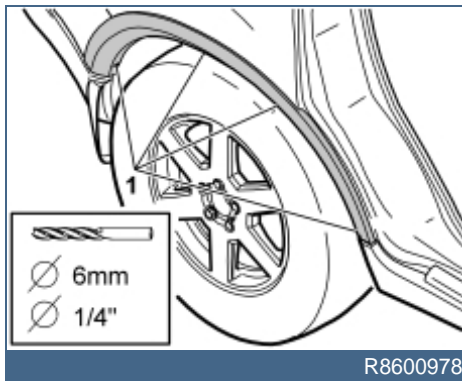
6

Preparations

Removing the upper trim strip on the rear door:

- Carry out the same procedure as for the front door (step 4), but start at the front of the trim strip and work backwards
- Place the trim strip to one side. This will not be reused.

7A



Preparations

Removing the rear wheel arch extension (secured by two hooks at the rear bottom edge, tape at the top, six clips and four rivets):

Illustration A

- Drill out the four rivets (1) holding the wheel arch extension to the edge of the wheel arch. Use a **6 mm (1/4")** diameter drill bit.
- Remove the remains of the rivets.

7B

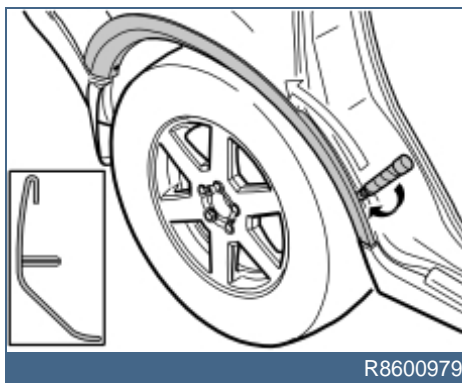


Illustration B

- Carefully pry off the front lower edge of the wheel arch extension. Use a plastic weatherstrip tool.

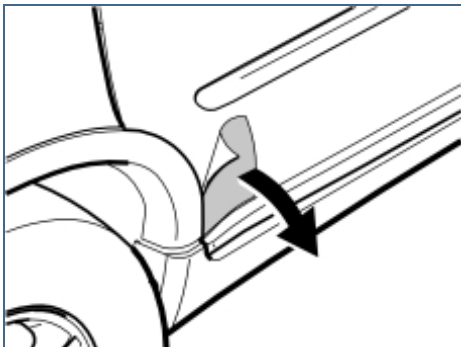
Note!

Do not damage the paint work.

- Fold out the front lower edge of the wheel arch extension to expose the first mounting clip
- Insert the weatherstrip tool at the side of the clip, between the panel and the wheel arch extension. Twist the weatherstrip tool to pull the clip away from the edge of the wheel arch or so that it breaks
- Then continue in the same way until all six clips have released
- Pull the two mounting hooks at the rear edge of the wheel arch extension off from their mountings
- Remove the wing extension. Place the wing extension to one side. This will not be reused.



8

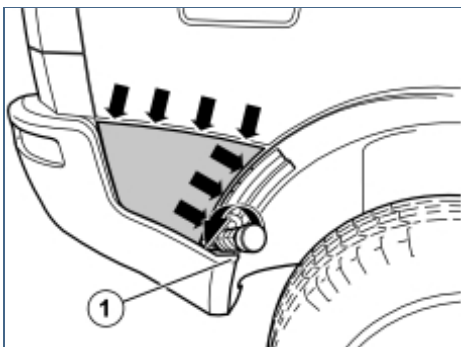


R8601039

Preparations

- Remove the stone-chip protection at the rear edge of the rear door.

9

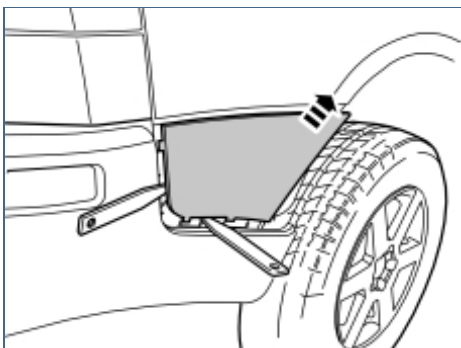


R8401238

Preparations

- Grip the bumper shell at point (1) and pull it out slightly so that the weatherstrip tool can be inserted in the opening formed.
- Position and turn the weatherstrip tool in the lower edge of each mounting hook (approx. in front of the three arrows) so that they release from the catch in the body.
- Carefully pull the bumper shell end with the small painted panel in the top edge from the body starting from the front. It is held in place by four clips.

10

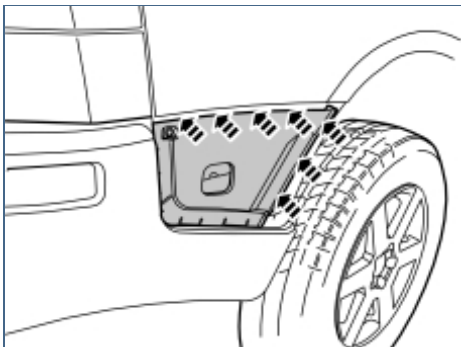


R8401235

Preparations

- Bend the small painted panel loose from the bumper shell end and then pull it off at an angle upwards. It is held in place by ten mounting hooks along its periphery. Lay it aside. It will not be used again.

11



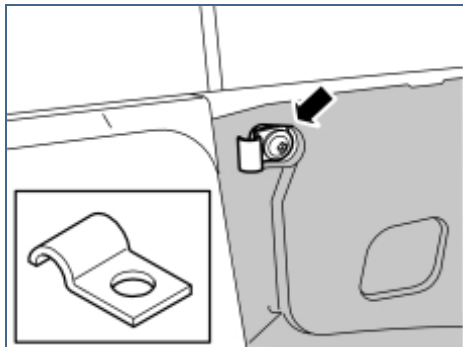
R8401234

Preparations

- Press the bumper shell end into the catches in the body. Make sure that all seven mounting hooks engage.



12

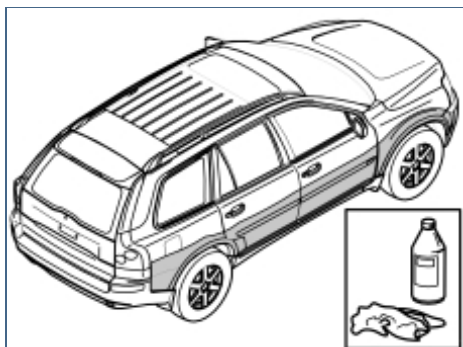


R8401236

Preparations

- Remove the screw and washer from the rear edge of the bumper shell end.
- Take the clamp from the kit and tighten it with the screw and washer as illustrated. The clamp should fix the bumper shell end against the body.

13



R8504390

Preparations

- Wash the entire surface of where the new decor panels and wing extensions shall sit. Use cleaner H (part no. 1161436).
- Wipe dry

14

Marking the primer surface on the bodywork

- Remove the side panel components from the packaging
- Check how the mounting tape is positioned on the components. This determines where the primer must be applied and where the markings must be made
- Clean the backing tape using a moist cloth. Use a mixture of 30% windscreen washer fluid and 70% water.

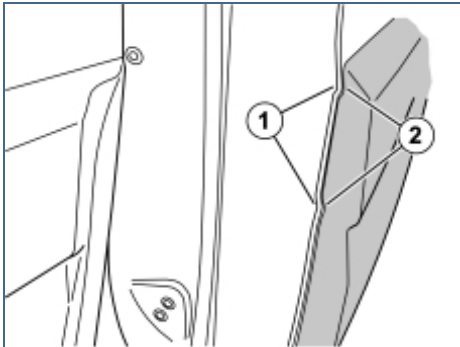
Note!

There must not be any dirt or grease on the backing tape on the panel. This could contaminate the bodywork when making markings in the next step.

- Wipe dry



15A



R8401208

Marking the primer surface on the bodywork

Test mount the panels according to points 19-22.

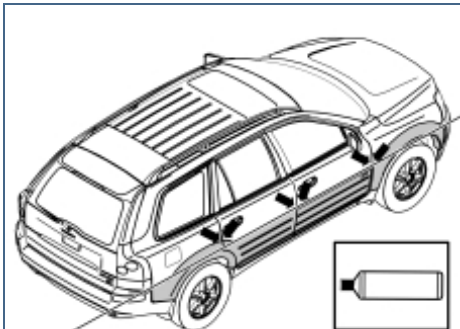
Illustration A

- Check that the embossings (1) in the rear edge of the front door and the corresponding rear door are in the centre of the cut out (2) in the relevant side panel (both door panels should end up at the same height horizontally).

Note!

Leave the backing tape for the mounting tape in place. Ensure that the panels are aligned horizontally.

15B

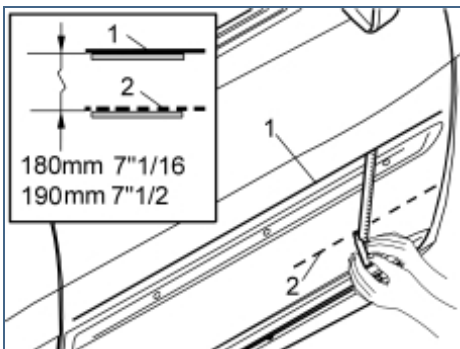


R8401210

Illustration B

- Mark the outer contours of the panels using a Whiteboard pen. Refer to the information under point A.

16



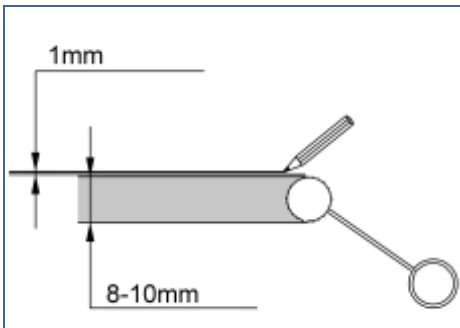
R8601075

Marking the primer surface on the bodywork

Marking the centre panel tape

- Measure from the upper marking (1) and mark out a line (2) for the centre panel tape. On the front door, the distance between the lower limits of the markings must be 180 mm (7 1/16"). On the rear door, the corresponding distance must be 190 mm (7 1/2").

17



R8401209

Installing the side panel

Applying primer to the bodywork

Caution!

The side panels must be installed at the earliest 15 minutes, and at the latest 3 hours, after applying the primer.

- Take the primer (part no. 1161727) and cotton buds from the kit.

Note!

The primer must be applied to the whole car in one operation. Any spillage must be wiped up immediately.

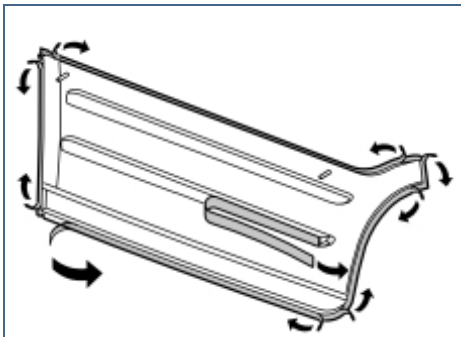
- Apply the primer inside the outer contours of the panels. It is important that nothing goes outside the markings, particularly on the upper sides of the panels, where there should be a space of approximately 1 mm between the primer and



the marking.

- Apply the primer immediately below the markings for the central mounting tape for the panel
- Allow the primer to harden for 15 minutes.

18



R8601002

Installing the side panel

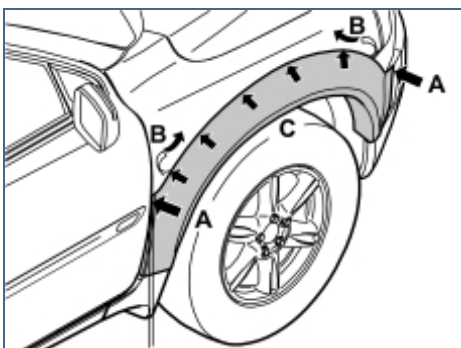
Applies to all components

- Remove the backing tape at each corner of the panel.

Applies to the door panels

- Remove the backing tape from the middle of the panel.

19A



R8401064

Installing the side panel

Securing the front wing side panel

Illustration A

Carried out by two people, one at the front and one at the rear of the side panel:

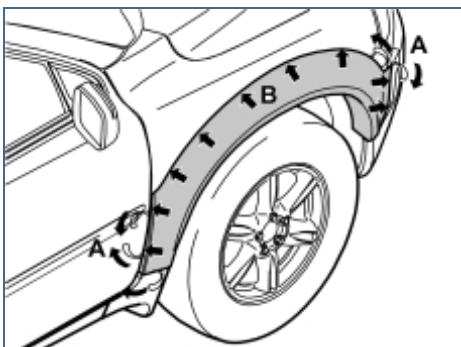
- Carefully insert the panel locating pins in the holes in the edges of the wing
- Move the panel as close as possible to the wing without the tape on the corners securing. Adjust the panel. There must be parallel vertical play between the panel and the rear edge of the front wing
- Press the panel into place at the upper corners (A). Carefully remove the upper backing tape (B) by pulling it off from both sides at the same time.

Note!

Ensure that the backing tape does not come off the reverse of the panel as the panel may lie firmly against the front wing.

- Press the upper section of the side panel (C) into place on the front wing so that it is firmly secure.

19B



R8401065

Illustration B

- Remove the backing tape on the sides (A) of the panel.

Note!

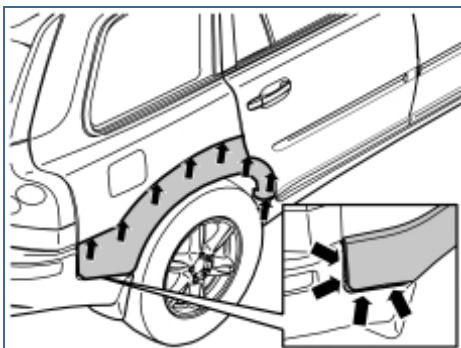
Ensure that the backing tape does not come off on the reverse of the panel.

- Press the panel into place on the front wing at every point that there is tape (C)
- Apply a pressure of **1-2 kg/cm² (14-28 lbf/in²)** around the entire panel so that



the tape sticks firmly.

20



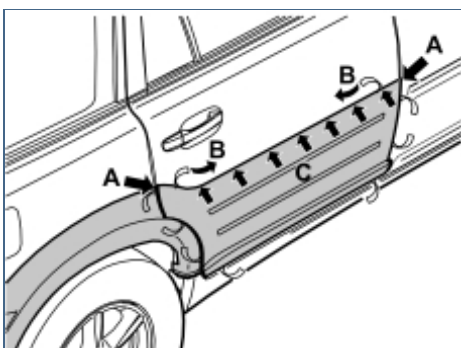
R8401237

Installing the side panel Securing the rear wing side panel

Carried out by two people, one at the front and one at the rear of the side panel:

- Insert the four mounting hooks in the rear edge of the side panel in the corresponding recess in the bumper shell end.
- Bend the panel in toward the rear wing while making sure that each side panel locating pin fits in the corresponding hole in the edge of the wheel arch.
- Follow the same procedure for the front wing. The front edge of this panel, however, will not need adjustment as the position is fixed against the door sill.

21A



R8401067

Installing the side panel Securing the side panel for the rear door Illustration A

Carried out by two people, one at the front and one at the rear of the side panel:

- Carefully insert the panel locating pins in the holes in the door
- Move the panel as close as possible to the door without the tape on the corners securing. Ensure that the rear upper corner of the panel follows the same line as the side panel for the rear wing (there is little clearance between the locating pins and the holes in the side of the door)
- Press the panel into place at the upper corners (A). Carefully remove the upper backing tape (B) by pulling it off from both sides at the same time.

Note!

Ensure that the backing tape does not come off on the reverse of the panel as the panel may be firmly attached to the door.

- Press the upper section of the panel (C) into place on the door. Press the panel so that it is firmly secured.

Illustration B

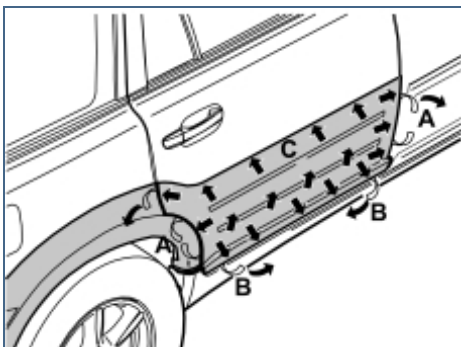
- Remove the backing tape on the sides (A) and lower edge (B) of the panel.

Note!

Ensure that the backing tape does not come off on the reverse of the panel.

- Press the panel into place on the door at every point where there is tape (C)
- Apply a pressure of **1-2 kg/cm² (14-28 lbf/in²)** around the entire panel so that the tape sticks firmly.

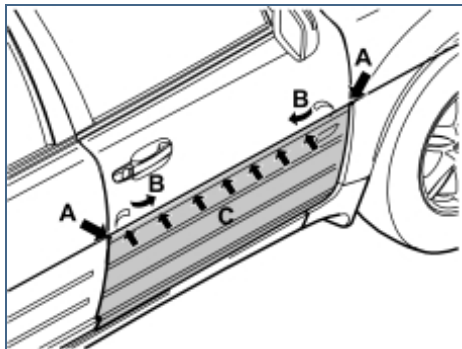
21B



R8401068



22A

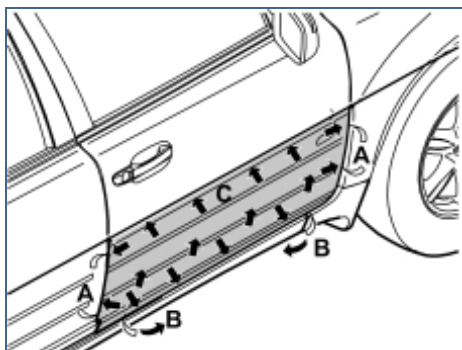


R8601024

Installing the side panel Securing the front door side panel Illustration A Illustration B

- Carry out the same procedure as for the rear door. Ensure that the rear edge of the panel is parallel with the rear edge of the door. In addition, adjust the height of the panel so that the top is in line with the panels for the rear door and the front wing.

22B



R8601025

Finishing work

- Remove the Whiteboard ink from the car. Use a rag.

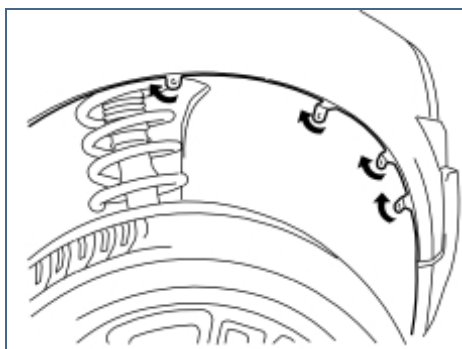
23

Finishing work

- Reconnect the connector to the lamp
- Press the parking lamp into the hole in the side panel. Ensure that the parking lamp clips into place correctly.

24

25A



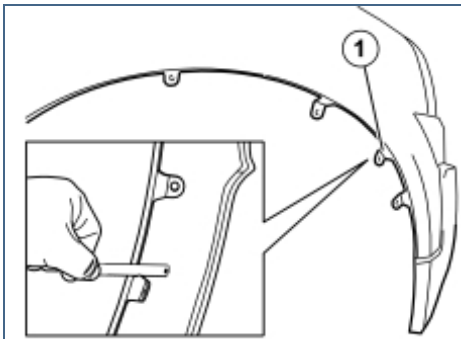
R8601028

Finishing work

- Fold in the mounting lugs on the front wing side panel so that the holes in the mounting lugs align with the holes in the wing liner.
- Applies to cars missing a hole in the inner wing for the mounting lug for the panel**
- Certain cars do not have holes for the mounting lug (1) on the left and right-hand sides. In these cases the holes must be carefully cut. Use a knife or a hacksaw blade
 - Fold the mounting lug in (the second mounting lug in the front edge of the panel counted from underneath) and saw off at the crack which forms



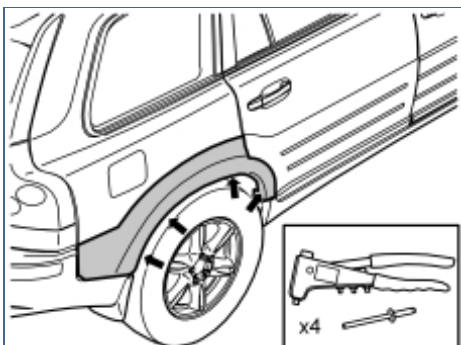
25B



R8401212

- Smooth off the edges using a file
- Repeat the operation on the other panel.

26A



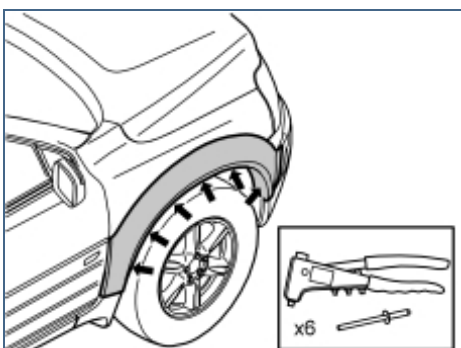
R8600994

Finishing work

Illustration A shows the rear wheel
Illustration B shows the front wheel

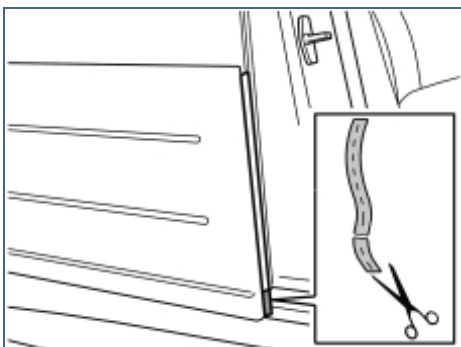
- Rivet the edges of the wheel arch extensions to the wing liner along the edges of the wheel arches. Do this on both the front and rear wheels. Use the rivets from the kit.

26B



R8401069

27A



R8600998

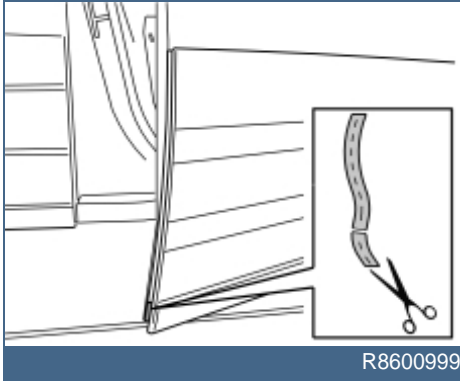
Finishing work

Illustration A shows the front edge of the rear door
Illustration B shows the rear edge of the front door

- If there is a visible gap between the black painted lower section of the side panel and the front edge of the rear door or the rear edge of the front door: cut the supplied tape to the same length as the lower gap. Apply the tape.



27B



28

Finishing work

- The car must be kept dry and at a temperature of at least 15°C (59°F) for 2 hours
- Do not wash the car for 72 hours after installing the side panel.