



XC90

Section	Group	Weight(Kg/Pounds)	Year	Month
8	82	N/A	2005	02

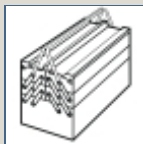
XC90 2003, XC90 2004, XC90 2005, XC90 2006

Installation instructions, accessories - Service kit, Body kit

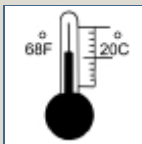
Volvo Car Corporation Göteborg, Sweden



Required tools



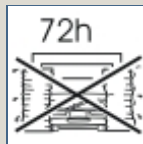
A0000162



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Any comments on this publication? Please contact your nearest retailer. Thank You!

Publ.no:

Issue:

Kit no:

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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.

Service kit, Body kit

Warning!

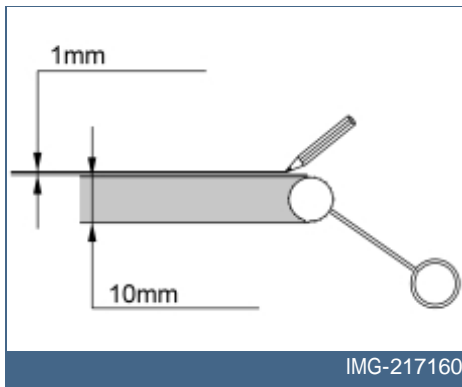
PUR adhesive can cause respiratory difficulties similar to asthma. Vapours with isocyanate content from non-hardened primer or adhesive can cause allergy in respiratory tracts. Persons with the allergy will react to very low contents. The risk remains as long as the material has not fully hardened. Ensure good ventilation. Use a fresh air mask. Never touch the adhesive surface with fingers. Use protective gloves.

Note!

The PUR adhesive kit must be ordered separately. P/N 1161694



1



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Installing the rear wings' panels

Note!

The temperature of the car must be at least **20° C (68° F)** when installing the side panels.

Two people must help each other to align and secure the side panels.

For cleaning and washing the bodywork, see the normal Installation Instructions 30730138.

Mark the body for the outer contours of the panels before priming in accordance with steps 14 and 15 B in the normal Installation Instructions 30730138.

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.

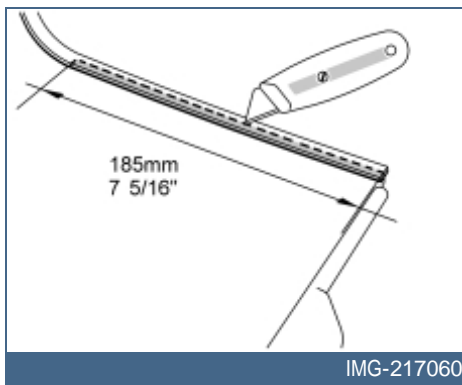
Take the primer (part no. 1161727) and cotton buds from the kit.

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.
- Allow the primer to harden for 15 minutes.

2A



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Illustration A

Preparatory work, rear wings' panels

Applies to cars where the rear section of the side panel's tape is not rubbed away

- Cut away the marked section of the tape to a length of **185 mm (7 5/16 ")**. Make sure the knife is sharp and thin. Half of the width of the tape must be cut away so that the intermediate space A (Illustration B) between the two tape surfaces is uncovered. This is so that any excess PUR adhesive can be collected here. Make sure that the tape residue is removed.



2B

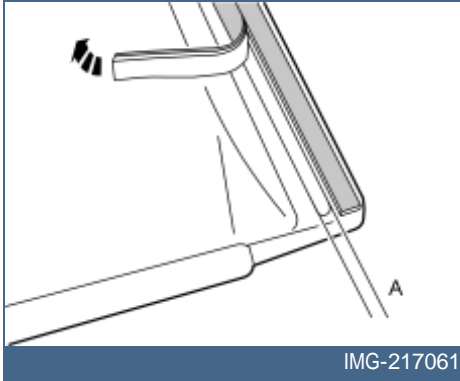
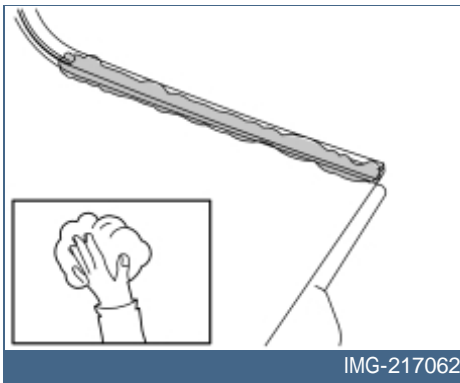


Illustration B

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3

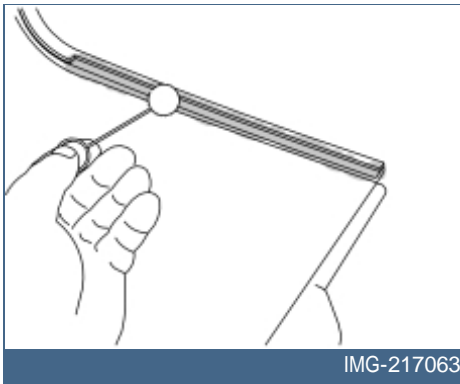


Applies to cars where the rear section of the side panel's tape is not rubbed away

- Clean the surface where the tape is removed from using Cleaner H (P/N 1161436).
- Wipe dry.

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4

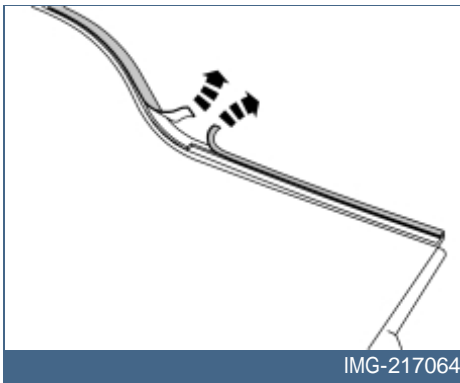


Applies to all models

- Take the primer (part no. 1161727) and cotton buds from the kit.
- Apply the primer on the cleaned surface of the side panel.
- Allow the primer to harden for 15 minutes.

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5

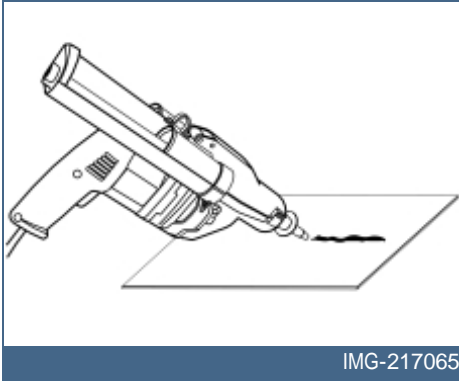


- Fold up the ends of the protective film (**NOTE: Do not remove the protective film yet**) so that it can be easily pulled off after the side panel has been positioned using the guide pins. Detach and fold up the protective film for the long pieces of tape at both ends.

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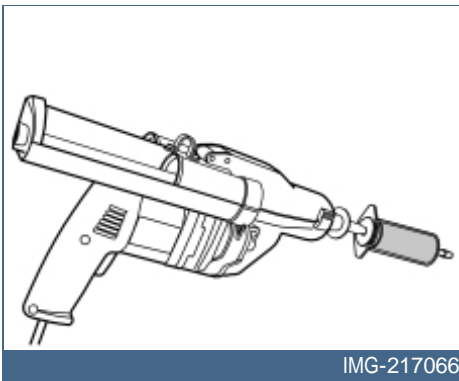
6



Applies when using mixing injector gun P/N 1161394 (220 V) or 1161395 (110 V).

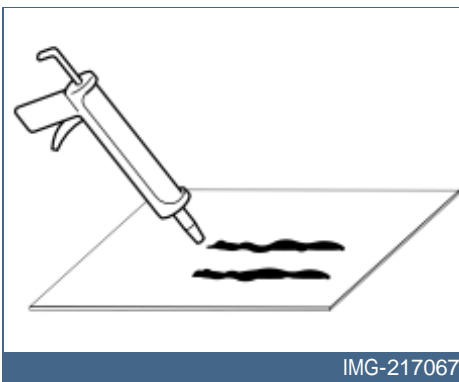
- Take the mixing injector gun P/N 1161394 (220 V) or 1161395 (110 V) and install both tubes of PUR adhesive P/N 1161698 and 1161699 from the kit.
- Run out a 100 mm (4 ") long bead on a piece of cardboard and discard it. This is to ensure that the contents of both tubes have mixed thoroughly.

7



- Take the small syringe from the kit and fill it with the mixed PUR adhesive.

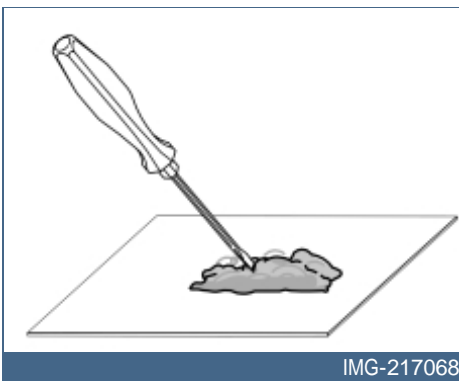
8



Applies to manual mixing of the PUR adhesive

- Take the PUR adhesive from the accompanying kit P/N 1161694 and press out an equal quantity of P/N 1161698 and 1161699 on a plate of glass or similar using a syringe.

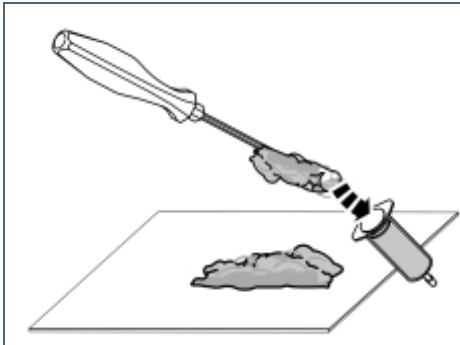
9



- Mix thoroughly for 1-2 minutes.



10A

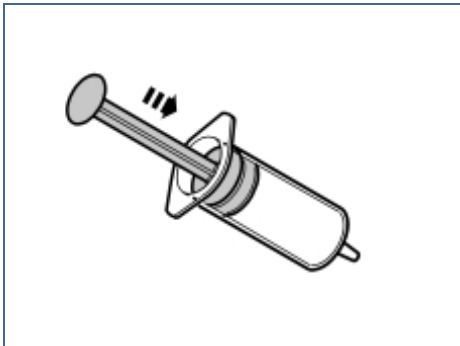


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Illustration A

- Fill the mixture in the syringe from the kit. Avoid getting air into it as this makes it difficult to apply an even bead to the panel.

10B

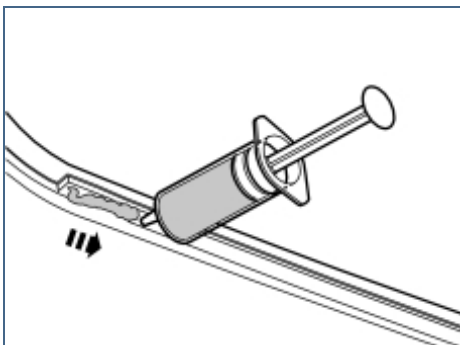


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Illustration B

- Install the plunger into the syringe.

11A

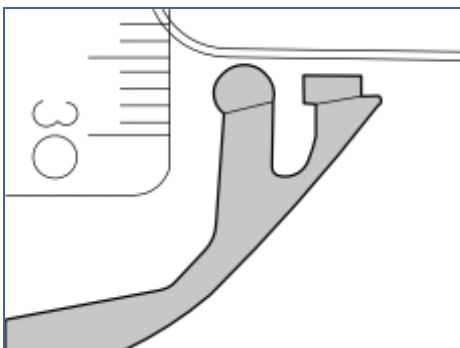


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Illustration A

- Now take the syringe and carefully apply an even bead of PUR adhesive on the primed surface starting inwards on the panel and out. Apply an even bead \varnothing 3.5 mm (25/64 "). The bead of PUR adhesive must not be higher than the level of the tape (Illustration B). Apply the bead of adhesive in one sequence without a break.

11B

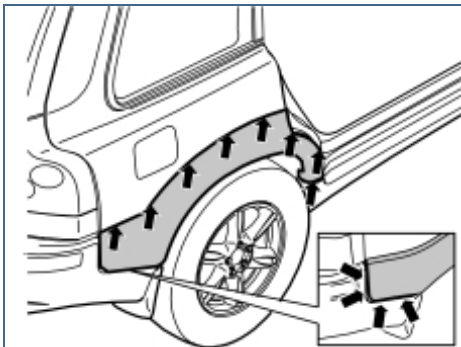


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Illustration B

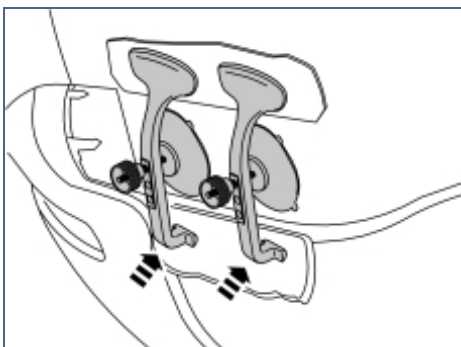


12A



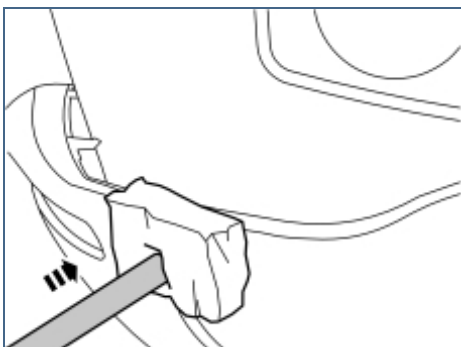
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12B



IMG-217076

12C



IMG-217077

Illustration A

Note!

This procedure should be carried out by two people, one at the front and one at the back of the side panel:

Securing the rear wing 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.
- Move the panel as close as possible to the wing without the tape in the corners sticking.
- Pull away the protective film by carefully pulling the upturned ends.

Note!

Ensure that the protective film does not come off on the reverse of the panel as the panel may be firmly attached to the front wing.

- Press in the upper section of the side panel against the rear wing at all points where there is tape and PUR adhesive.
- Apply a pressure of **1-2 kg/cm² (14-28 lbf/in²)** around the entire panel so that the tape sticks firmly.
- Apply a constant pressure against the section of the panel bonded with PUR adhesive, using a piece of styrofoam and suction clamp kit P/N 9512841 Illustration B, or if this is not available, a pole with a fixed object as in Illustration C. Place a piece of cardboard between the paintwork and tensioning yoke to protect the paintwork as in Illustration B. Apply the force at right-angles so that the panel is not displaced. The rear section of the panel must be pressurised in this way for 4-5 hours.
- Remove the tensioning tools after the adhesive has hardened.

Illustration B