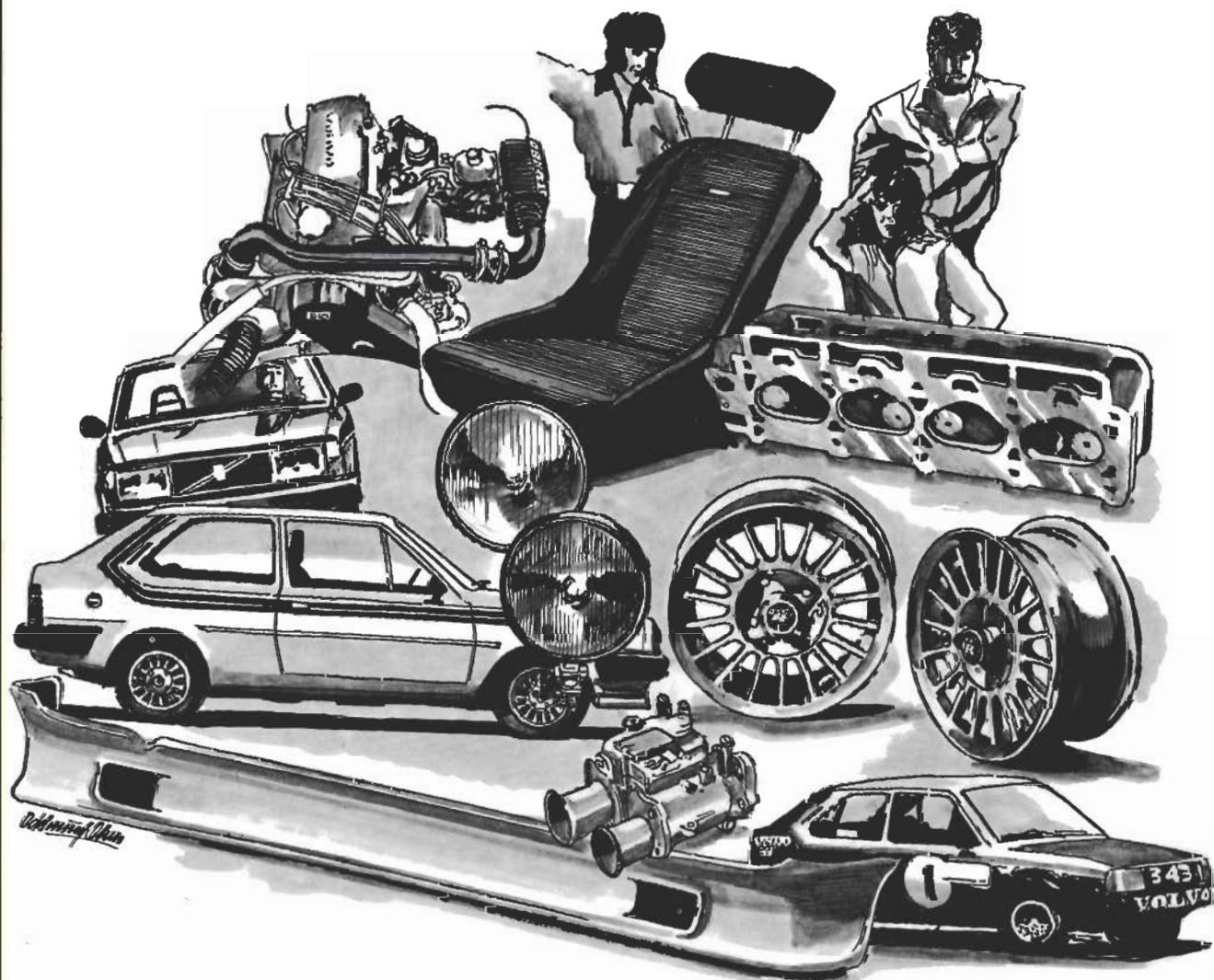


Katalog Catalogue



Edition 2

VOLVO **IR SPORT**

Utrustning för sport och tävling.
Equipment for the car enthusiast.

Förord / Introduction

Prislista / Price list

140/160

240/260

340

Textil / Clothing

ASP-material

Utställningsmaterial / Exhibitions material

Klassningshandlingar / Homologation papers

Rundskrivelser / Circular letters

Teknisk information / Technical information



PREFACE

Volvo R Sport was formed in 1978 by Volvo Car Corporation in Gothenburg, Sweden.

It was a new name for the "Volvo Competition Service" that actively campaigned the 544 and 122 models in European rally circles during the mid-sixties.

Since 1978 Volvo R Sport with our Volvo R Team has successfully campaigned the 340-models in European rallycross circles.

Volvo R Sport is responsible for the marketing and distribution of a wide range of popular performance parts and GT accessories. We also offer advise and service to Volvo subsidiaries around the world.

Today several markets use our range of tuning kits and equipment when marketing "action models" with sporty appeal. R-Sport provides you with the tools to reach a younger target group.

The present Edition 2 of the R-Sport catalogue has an ambition to offer you more help in your marketing planning. For further assistance do not hesitate to contact us:

Volvo Car Corporation
Volvo R Sport

S-405 08 GOTHENBURG
SWEDEN

Telex: 21104 VOLSPOR S



GUARANTEE

GUARANTEE

Volvo R Sport parts and equipment are warranted from 12 months from the date of purchase and/or installation. The warranty covers the repair or replacement of any item or component found defective because of workmanship or material.

This warranty, however, does not apply to any vehicle used in competition race type events.

The routines for claims are the same as for any other Volvo original spare part.



INSTRUCTIONS

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IMPORTANT CATALOGUE INSTRUCTIONS

To make your use of this catalogue easier and faster we would like to mention a few practical details.

- Each model series (140, 240 etc) has it's own flap, Within each flap the basic format of AB Volvo, Parts Division's parts catalogues is followed. Consequently, you will find engine parts in the beginning, and body parts towards the end.
- The previous Amazon-section has been discontinued.
- Under flap "Technical information" we will collect all parts that are of interest for competition drivers only.
- The right hand column of each catalogue page now is used to give specifications, technical advise and measurements. In some cases you will find the measurement for the equivalent standard part in parenthesis "()".
- Volvo R Sport is using a "discount per part number" rather than a "discount per market" price system. In the price list you will find the FOB gross price in Swedish Kronor plus a Discount Code (presently from 31 to 37). The Discount Code Key, which is found under the same flap, translates each code into discount percentages.
- RS or RSVP in the price column means that the part is a standard part from AB Volvo, Parts Division or Volvo Penta's parts department, that the price is to be found in their price lists and that it should normally be ordered from them.
- QD means that the part number is included in our Quantity Discount List which you can find under flap 3.

As time passes, some parts are going to be replaced or excluded, and new ones added. New catalogue pages will then be issued. Please insert them in your catalogue immediately to ensure that it is up-to-date at all times.



INSTRUCTIONS

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ORDER ROUTINES

All your orders of R-Sport articles should be sent to our distribution center in Gothenburg, from where you will be supplied.

Our address is:

Volvo Car Corporation
 Volvo R Sport
 S-405 08 GOTHENBURG
 SWEDEN

Order telephone: Gothenburg 59 66 53
 Area code 031

Telex: 21104 VOLSPOR S

All orders should be marked with your district number and with your order number.

To enable us to meet all requirements regarding delivery times, it will help us, if you clearly mark whether the order is a "Normal" or "Emergency" order.

Handling times:Normal orderEmergency orderR-Sport

Order handling
 Picking & Packing
 Invoicing

2 days

1 day

Transport dept 7240

Export documents
 Transport booking
 Shipping

3-8 days

1-2 days



INSTRUCTIONS

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Handling times are normally 2-3 days for emergency orders, and 5-10 days for normal orders. The handling time only covers our internal handling time in working days. It does not include free Saturdays, Sundays and public holidays. Also, it is only approximative - in actual fact the handling time can be somewhat longer or shorter, depending on prevailing work load. It also does not include waiting time for means of conveyance, licences, letters of credit, legalization etc.

An order handling charge is debited each invoice. It amounts for the moment (1981) to SEK 25.- / order.

ORDER INFORMATION

An order confirmation is normally sent by telex. In our confirmation you will be informed about any deviations from your original order. On the packing slip, which goes with each shipment, you will also be informed, if a part is back ordered. Any questions concerning parts availability, specifications or prices may be mailed or telephoned to Volvo Car Corporation, Volvo R Sport, S-405 08 Gothenburg, (031) 59 66 53. Hours - Monday through Friday 9.00-12.00 and 13.00 - 17.00.

BACK ORDER INFORMATION

To give you a total picture of your outstanding orders, we are sending you, once a month, a list of those part numbers, which are back ordered. Back orders are being delivered immediately after stock is refilled.





DISCOUNT CODE KEY

PAGE

<u>CODE</u>	<u>%</u>
31	40
32	20
33	30
34	45
35	30
36	10
37	40

PRISLISTA A - TURBOSATS

PRICE LIST A - TURBO KIT

<u>Detalj nr</u> <u>Part no</u>	<u>Pris exkl moms</u> <u>Price</u>	<u>RK</u> <u>DC</u>
120265-4	RS	
190071-1	RS	
191026-4	RS	
191172-6	RS	
191701-2	RS	
192055-2	RS	
210107-9	RS	
273591-8	RS	
273596-7	RS	
281334-3	RS	
418360-4	RS	
418411-5	RS	
419401-5	RS	
420423-6	RS	
420475-6	RS	
460944-2	RS	
463392-1	RS	
463587-6	RS	
463846-6	RS	
466327-4	RS	
666407-2	RS	
679754-2	RS	
680642-6	RS	
684576-2	RS	
824589-6	RS	
925093-7	RS	
940101-9	RS	
940113-4	RS	
940142-3	RS	
941686-8	RS	

<u>Detalj nr</u> <u>Part no</u>	<u>Pris exkl moms</u> <u>Price</u>	<u>RK</u> <u>DC</u>
941907-8	RS	
942001-9	RS	
943473-9	RS	
943478-8	RS	
943480-4	RS	
943727-8	RS	
945409-1	RS	
945651-8	RS	
946036-1	RS	
946173-2	RS	
946440-5	RS	
946451-2	RS	
946472-8	RS	
947065-9	RS	
947331-5	RS	
947541-9	RS	
947624-3	RS	
947687-0	RS	
948040-1	RS	
948611-8	RS	
948645-7	RS	
948702-6	RS	
948958-4	RS	
949012-9	RS	
949659-7	RS	
949676-1	RS	
949677-9	RS	
949701-7	RS	
949861-9	RS	
953241-7	RS	

<u>Detalj nr</u> <u>Part no</u>	<u>Pris exkl moms</u> <u>Price</u>	<u>RK</u> <u>DC</u>
955137-5	RS	
955294-4	RS	
955295-1	RS	
955303-3	RS	
955304-1	RS	
955306-6	RS	
955317-3	RS	
955782-8	RS	
955826-3	RS	
956970-8	RS	
956984-9	RS	
957179-5	RS	
960139-4	RS	
960141-0	RS	
960632-8	RS	
963564-0	RS	
965175-3	RS	
965406-2	RS	
966378-2	1.50	37
1206468-9	RS	
1213943-2	RS	
1219230-8	RS	
1228272-9	RS	
1255568-6	RS	
1266014-8	RS	
1266286-2	RS	
1266458-7	RS	
1266500-6	RS	
1266519-6	RS	
1269041-8	RS	

<u>Detalj nr</u> <u>Part no</u>	<u>Pris exkl moms</u> <u>Price</u>	<u>RK</u> <u>DC</u>
1276215-9	RS	
1276438-7	RS	
1276472-6	RS	
1276582-2	RS	
1276676-2	RS	
1276680-4	RS	
1276689-5	RS	
1276832-1	RS	
1276841-2	RS	
1276842-0	RS	
1304149-6	RS	
1304204-9	RS	
1304205-6	RS	
1304869-9	RS	
1306088-4	RS	
1306152-8	RS	
1306156-9	RS	
1306157-7	RS	
1306158-5	RS	
1306162-7	RS	
1306184-1	RS	
1306187-4	RS	
1306190-8	RS	
1306191-6	RS	
1306192-4	RS	
1306193-2	RS	
1306228-6	RS	
1306482-9	RS	
1306579-2	RS	
1306580-0	RS	

Detalj nr	Pris exkl moms	RK
<u>Part no</u>	<u>Price</u>	<u>DC</u>
1306609-7	RS	
1306647-7	RS	
1306707-9	RS	
1306852-3	RS	
1306867-1	RS	
1306910-9	RS	
1317067-5	RS	
1317695-3	RS	
1326221-7	RS	
1326222-5	RS	
1326586-3	RS	
1326588-9	85.-	33
1326589-7	14.-	32
1326808-1	RS	
1586597-5	RS	
8360000-7	6.400.-	33
8360001-5	135.-	31
8360003-1	350.-	37
8360005-6	30.-	37
8360006-4	20.-	33
8360008-0	76.-	33
8360009-8	28.-	33
8360010-6	78.-	33
8360011-4	880.-	37
8360016-3	4.-	32
8360017-1	48.-	37
8360018-9	800.-	37
8360020-5	270.-	33
8360021-3	35.-	33
8360022-1	4.300.-	33

<u>Detalj nr</u> <u>Part no</u>	<u>Pris exkl moms</u> <u>Price</u>	<u>RK</u> <u>DC</u>
8360025-4	4.-	33
8360026-2	44.-	32
8360027-0	8.-	32
8360028-8	45.-	37
8360029-6	210.-	37
8360030-4	48.-	32
8360031-2	80.-	37
8360032-0	RS	
8360035-3	12.-	31
8360039-5	18.-	37
8360041-1	32.-	31
8360042-9	24.-	32
8360043-7	65.-	31
8360051-0	12.-	31



TABLE OF CONTENTS

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A	Engine
B	Fuel and exhaust systems
C	Electrical equipment and instruments
D	Power train
E	Suspension and brakes
F	Body and safety
G	Miscellaneous equipment



INFORMATION ON TUNING

EXPORT

810701

FLAP

SECTION

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A

1

HIGHEST PERMISSIBLE OUTPUT IN TUNED STANDARD CARS

Type	Highest permissible output (hp DIN) and max torque (kpm)	Special conditions
PV 444 PV 544 PV 544	76 / 11,5 100 / 15,5 110 / 16,0	None None Disc brakes, front wheels
PV 210	82 / 15,5	With B18 front axle crossmember and B20A standard engine
Amazon Amazon	100 / 15,5 150 / 20,0	None Disc brakes, front wheels
142, 144 142, 144 145 model years 1969-	140 / 19,6 180 / 22,0	None Special brake pads ¹⁾ , shock absorbers ²⁾ , springs ³⁾ and extra hard bushings ⁴⁾
164	200 / 28,0	Ventilated discs, front, special brake pads ¹⁾ , type VR tyres
1800	140 / 19,6	None
340 B14 340 B19	100 / 13,0 140 / 17,3	None. Top speed 160 km/h None. Top speed 180 km/h
P242/244 262/264	200 / 22,0 220 / 28,0	Shock absorbers ⁵⁾ , brakes ⁶⁾ , tyres ⁷⁾ Shock absorbers ⁵⁾ , brakes ⁶⁾ , tyres ⁸⁾



INFORMATION ON TUNING

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- 1) Brake pads with the following part nos for Girling-brakes: front 272644, rear 272567, or front 275894 and rear 275895. (Please note that these two variants must not be mixed.)

For ATE-brakes: front part no 272568 and rear part no 272569.

- 2) Shock absorbers deCarbon front: Volvo part no 552189 or 552191
rear: Volvo part no 552190 or 552192

- 3) Springs front: part no 552105, 552106*) or 552134
rear: part no 552136 or 552128

*) When this spring is mounted, stabilizer part no 552172 also must be mounted.

- 4) Heavy duty bushing for support arm part no 552140

- 5) Shock absorbers front part no 552195, rear 552196, or
front part no 552197, rear 552198

- 6) P240 c. 200 hp, brake pads

Girling


ATE

front part no 272566
rear part no 272674

front part no 272530
rear part no 272675

- 7) Tyres of at least HR-type

- 8) Tyres of VR-type


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		FLAP	SECTION	PAGE
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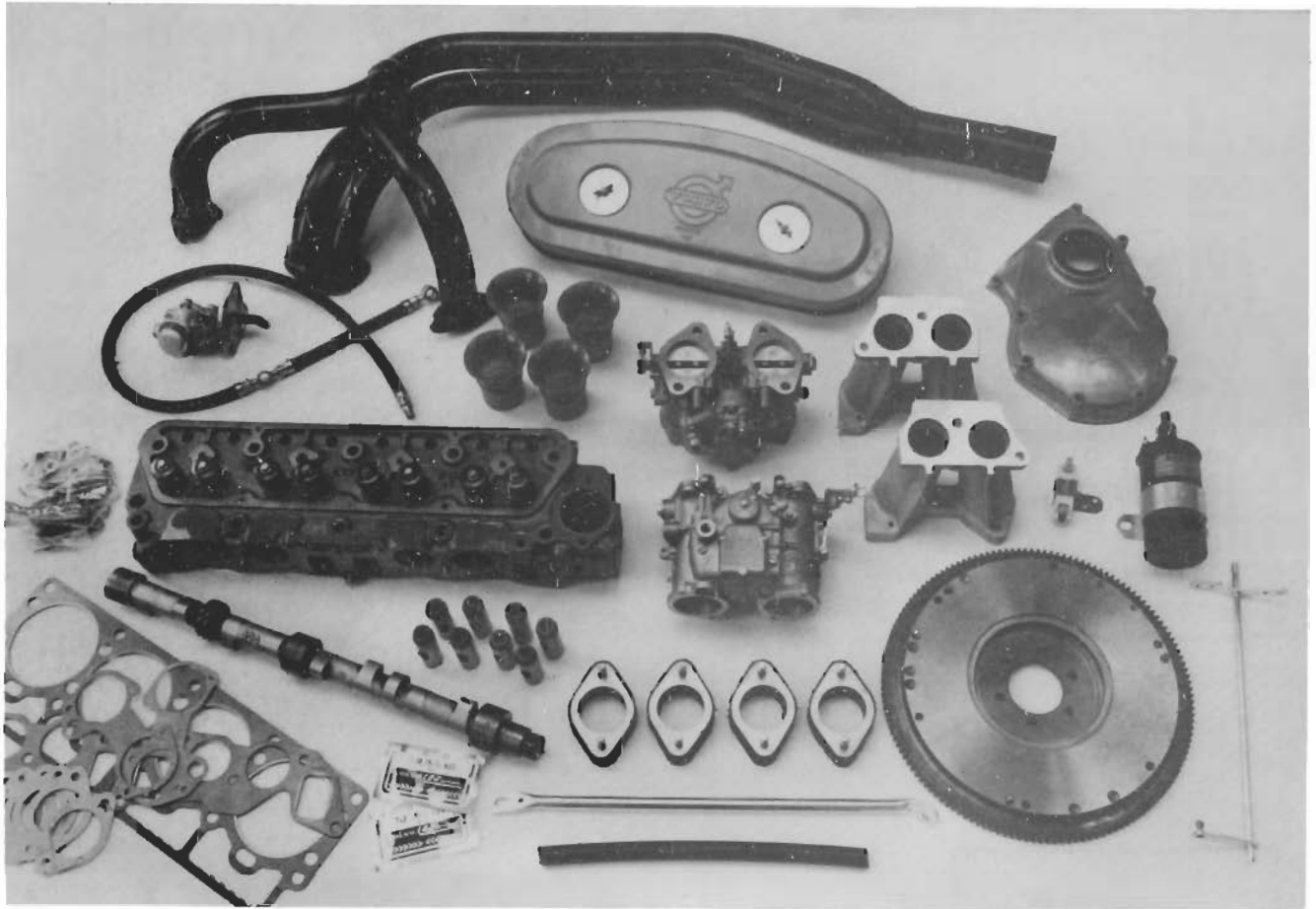
Below is a table of the different tuning alternatives recommended by us. The equipment is dealt with in full detail under section A "Engine Parts" in this catalogue.

TUNING KITS 140-SERIES

EXECUTION		OUTPUT	APPLICATION
PART NO	DESCRIPTION		
552861 552470	Tuning kit Special I	103 kW DIN* 140 hp DIN	Sporty driving
not available as a complete kit	Special III 2,0	125 kW DIN* 170 hp DIN	Rally driving
not available as a complete kit	Special III 2,2	132 kW DIN* 180 hp DIN	Rallycross and racing

* With Volvo Rally Exhaust Kit

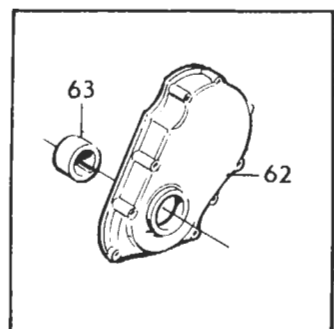
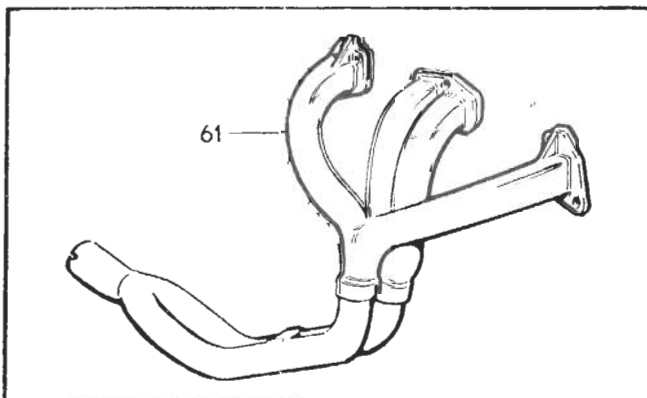
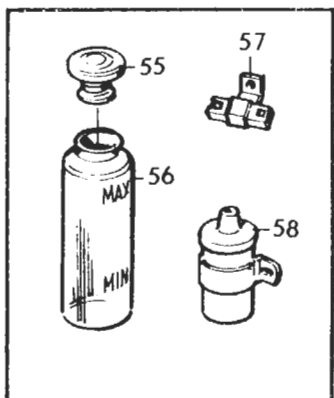
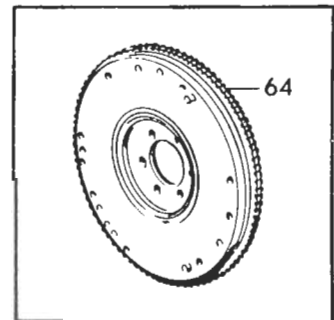
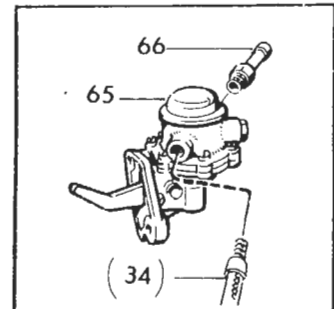
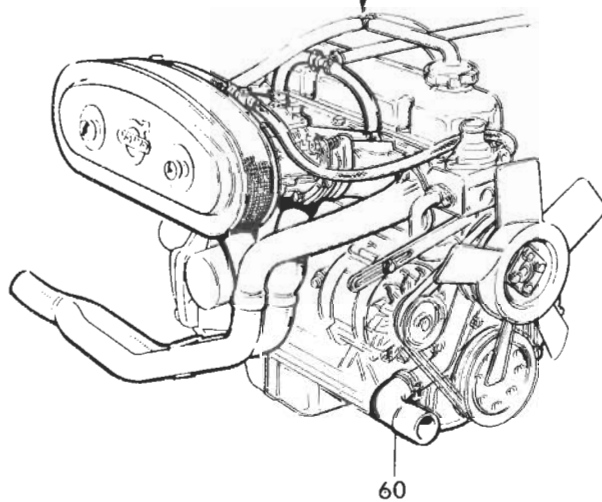
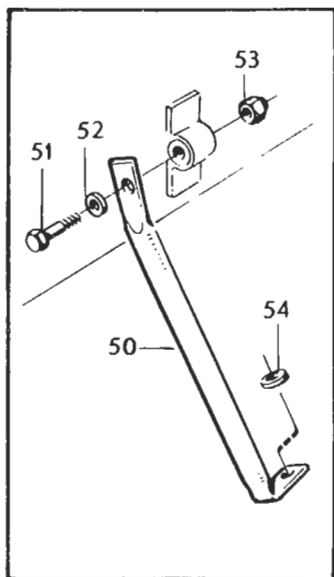
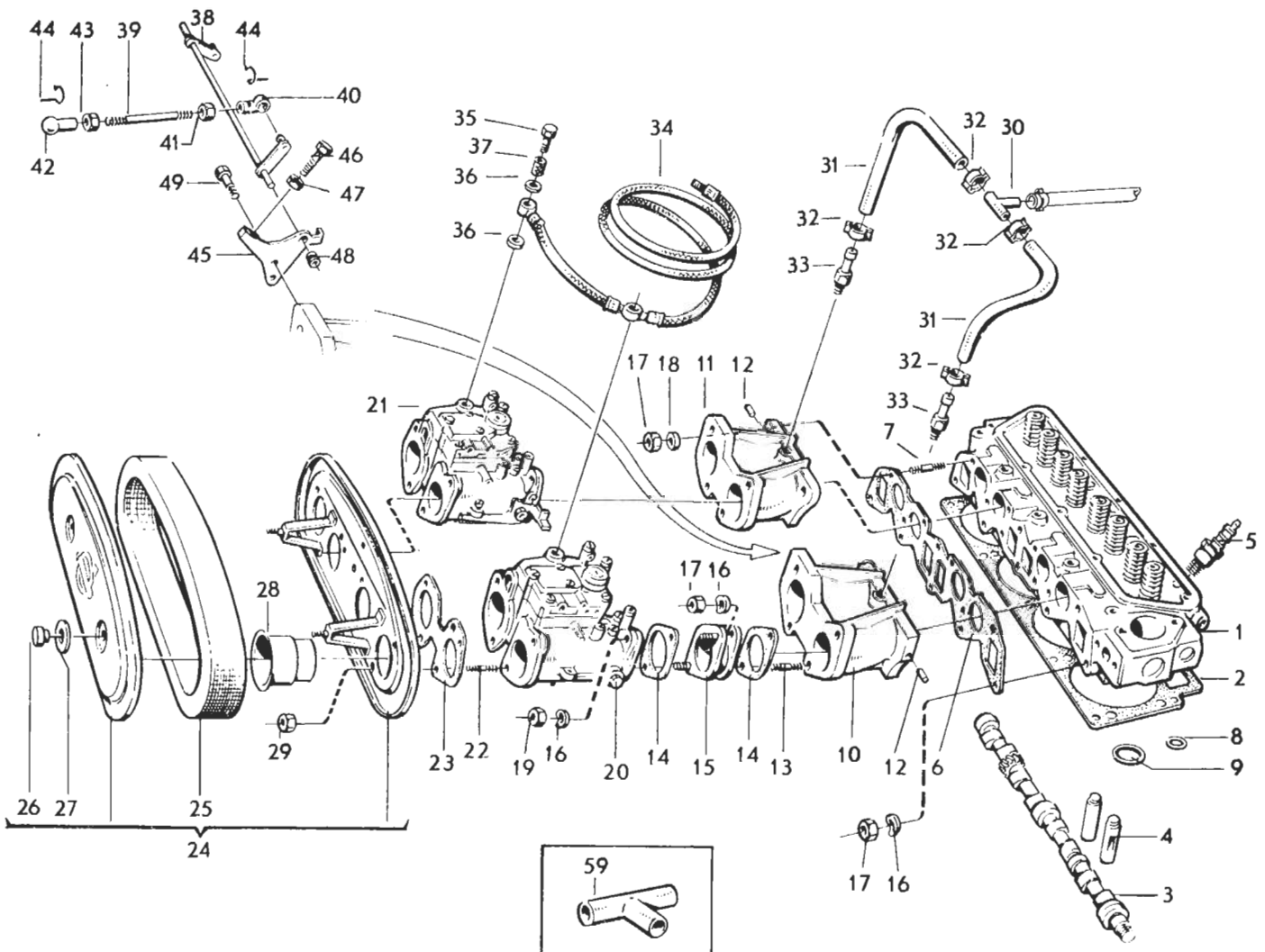
	TUNING KIT B20 SPECIAL I	EXPORT	810701	
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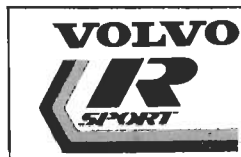


Tuning kit B20 Special I is designed for left-hand driven P140's,

This kit complies with the European emission control regulations in effect from model year 1971.

Technical data: Maximum output: 140 hp DIN at 6.000 rpm (103 kW at 100 r/s)
Torque: 19.6 kpm DIN at 4.500 rpm (192 Nm at 75 r/s)
Compression: 10,5:1







TUNING KIT B20 SPECIAL I

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Pos	Qty	Part No	Description	Specification
		552861-7	Tuning kit B20 Special I, compl up to and inclusive of '73 model	
		552470-7	Tuning kit B20 Special I compl '74 model	
1	1	552441-8 ✓	x Cylinder head, compl	For parts included in the kit, see section A "Cylinder head"
2	1	824855-1	x Cylinder head gasket	Thickness 1,2 mm
3	1	552460-8	x Camshaft "F" (hard chrome)	Suitable for normal as well as rally driving. Lift 11.3 mm. Duration 300°.
4	8	552466-5	x Valve tappet	Wizemann manufactured for maximum durability
5	1	273528-0	x Spark plug kit Bosch W240T35 (W4B2)	For hard-driving W275T (W3A) should be used.
6	1	419764-6	x Gasket	
7	9	953243-3	x Stud (cylinder head-induction manifold)	
8	1	418655-7	x Sealing ring	
9	1	418657-3	x Sealing ring	
10	1	419883-4	x Inlet manifold, front	
11	1	419884-2	x Inlet manifold, rear	
12	2	422635-3	x Plug for induction manifold	
13	8	953461-1	x Stud (induction manifold-rubber flange)	
14	8	819769-1	x Gasket	
15	4	824643-1	x Rubber flange for carburetor	
16	21	941907-8	x Washer	
17	17	955826-3	x Nut	
18	4	419401-5	x Washer for 953243 - exhaust manifold	
19	8	955847-9	x Nut for stud-rubber flange	
20	1	552630-6	x Carburetor, front	Solex 45 ADDHE twin choke carburetor of aluminium alloy.
21	1	552629-8	x Carburetor, rear	

	TUNING KIT B20 SPECIAL I	EXPORT		810701
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Pos	Qty	Part No	Description	Specification
22	8	953032-0	x Stud (carburetor-air filter)	
23	2	419906-3	x Gasket (air filter-carburetor)	
24	1	684036-7	x Air filter, compl	Air filter with a very large inlet area for the lowest possible loss of power. The filter insert is easy to clean.
25	1	552620-7	xx Filter insert	
26	2	552621-5	xx Nut	
27	2	552622-3	xx Washer	
28	4	824708-2	xx Air intake	
29	8	946035-3	xx Nut	
30	1	419446-0	x T-union for servo hose	
31	0,3 m	947908-0	x Hose (0,15 + 0,15 m) for servo	
32	4	942928-3	x Clip for 947908-0 hose	
33	2	947043-6	x Nipple for servo	
34	1	825856-8	x Fuel hose	
35	2	825857-6	x Banjo screw for fuel hose	
36	4	957173-8	x Gasket for banjo screw	
37	2	825858-4	x Strainer for fuel hose	
38	1	684899-8	x Shaft for throttle control, upper, 67-72	
38	1	552431-9	x Shaft for throttle control, upper, 73-74	
39	1	943936-5	x Control shaft	
40	1	959088-6	x Ball socket	
41	1	955780-2	x Nut for ball socket 959088	
42	1	942837-6	x Ball socket	
43	1	942836-8	x Nut for ball socket 942837	
44	2	959093-6	x Locking clamp for ball socket 959088 and 942837 respectively	

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Pos	Qty	Part No	Description	Specification
45	1	1206551-2	x Bracket for throttle control	
46	1	955273-8	x Bolt	
47	1	955781-0	x Nut	
48	1	666143-3	x Bushing	
49	2	955512-9	x Screw for 1206551	
50	1	460047-4	x Stay for air filter	
51	1	955536-8	x Bolt for stay in air filter	
52	1	940097-9	x Washer	
53	1	950354-1	x Nut	
54	1	960142-8	x Washer	
55	1	673336-4	x Pressure cap	
56	1	676558-0	x Expansion tank	
57	1	241612-1	x Resistor	
58	1	826490-5	x Ignition coil	
59	1	552551-4	x T-union for crankcase ventilation	
60	1	273279-0	x Radiator hose kit, lower	
61	1	419381-9	x Exhaust manifold	Tuned sheet steel manifold for optimum torque in the low and medium RPM range.
62	1	418693-8	x Timing gear cover with neoprene seal	
63	1	418264-8	x Hub for belt pulley	
64	1	419392-6	x Lightened flywheel (6 bolt) '73	
64	1	552833-6	x Lightened flywheel (8 bolt) '74	
65	1	831092-2	x Fuel pump	Mechanical high-efficiency pump with screw connection of fuel hose
66	1	946600-4	x Nipple for fuel pump	

	SPECIAL III TUNING 2.0 LITRES	EXPORT		810701
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Below the tuning parts are listed that have to replace the equivalent parts in Tuning kit Special I (part no 552861 and 552470) when building a B20 engine Special III 2.0 litres, 170 hp DIN, torque 22.5 kpm at 4.500-5.000 RPM, for advanced Rally driving.


These parts are not available as a complete kit.

We recommend that the following brake and suspension parts are installed on cars with this engine specification:

- Brake pads Ferodo 2441
- Shock absorbers type Rally (front part no 552189-3, rear part no 552190-1) or type Sport (front part no 552191-9, rear part no 552192-7)
- Progressive rate front spring 552105, progressive rate front spring long 552106^{*)} or short spring, front, Rally, part no 552134 and progressive rate spring, rear, 552136, or short spring, rear, Rally, part no 552128
- *) When the spring 552106 is used, stabilizer part no 552172 and rear spring 552136 also must be installed.
- Reinforced rubber bushing for support arm, rear, part no 552140

For best performance the inlet manifolds (419883 and 419884) should be polished.

Qty	Part No	Description	Specification
1	552432-7	Cylinder head "Special III" 2.0 litres	For parts included, see Section A "Cylinder heads" (Replaces 552464, 552448 from Feb 1978)
1	824855-1	Cylinder head gasket	Thickness 1,2 mm
4	552498-6	Spark plug Bosch W3A (W275T1)	
8	552841-9	Valve tappet, lightened	57 grammes (85 grammes)
1	552430-1	Camshaft "R" or Camshaft "S" 552445	Rally, Rallycross Rally, Track Racing, Rallycross
4	552453-3	Forged piston compl, standard dimension	"Mahle" piston for tough competition driving (B20-73)
4	552455-8	x Piston ring kit	
4	552457-4	x Piston bolt	
8	552458-2	x Locking ring for 552457	
1	875375-8	Timing gear kit, steel	Necessary for durability
8	430121-4	Push rod	
1	552847-6	Baffled oil sump	Necessary to avoid bearing breakdown in Rally and Racing
2	552004-4	Electrical fuel pump	Two pumps connected in parallel to be installed horizontally near the fuel tank, preferably in the luggage com- partment
1	1155255-1	Carburetor jet kit	With choke tube 40 mm
1	552909-4	Oil cooler	13-vane air cooled, complete with thermostat

	SPECIAL III TUNING 2.0 LITRES	EXPORT	810701	
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For the power train we recommend:

Qty	Part No	Description	Specification
1	552145-5	"RAC" clutch, extra reinforced	
1	552146-3	Disc	To be used for "RAC" clutch
1	672122-9	Clutch release bearing	



SPECIAL III TUNING 2.2 LITRES

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Below we have listed the tuning parts that should replace the equivalent parts of Tuning kit Special I (part no 552861 and 552470) when building a B20 engine Special III 2.2 litres, 180 hp DIN, torque 24.0 kpm at 4.500-5.000 RPM which is meant for competition use only; Rallycross and Track Racing.


These parts are not available as a complete kit.

We recommend that the following brake and suspension parts are installed on cars with this engine specification:

- Brake pads Ferodo 2441
- Shock absorbers type Rally (front part no 552189-3, rear part no 552190-1) or type Sport (front part no 552191-2, rear part no 552192-7)
- Progressive rate front spring 552105, progressive rate front spring long 552106^{*)} or short spring, front, Rally, part no 552134 and progressive rate spring, rear 552136, or short spring, rear, Rally, part no 552128
- *) When the spring 552106 is used, stabilizer part no 552172 and rear spring 552136 also must be installed.
- Reinforced rubber bushing for support arm, rear, part no 552140

For best performance the inlet manifolds (419883 and 419884) should be polished.

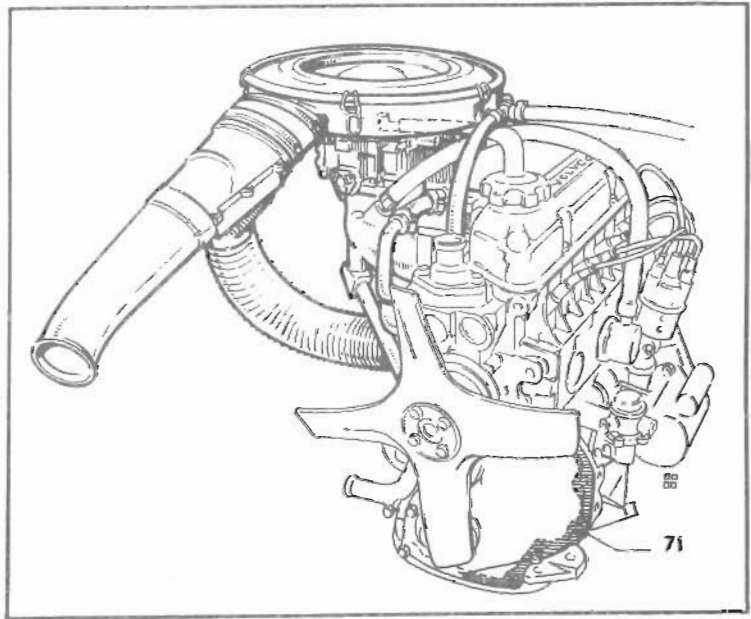
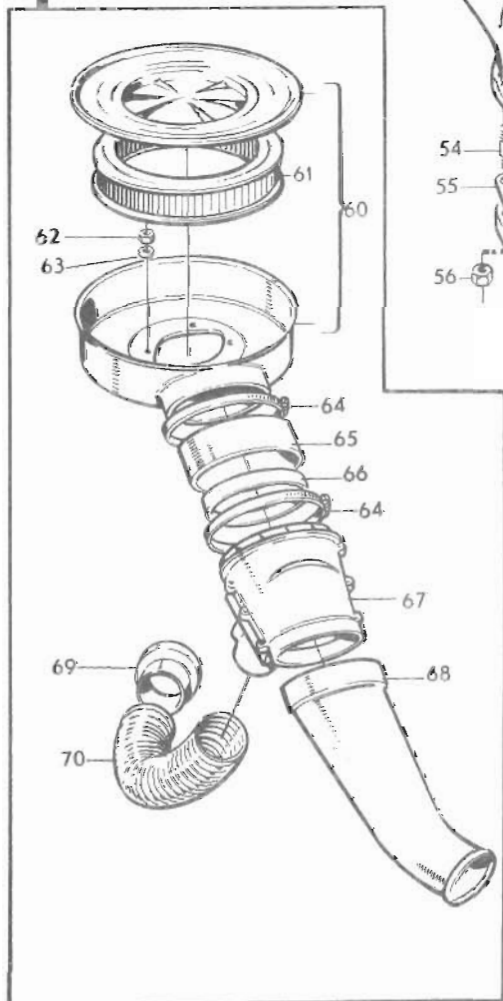
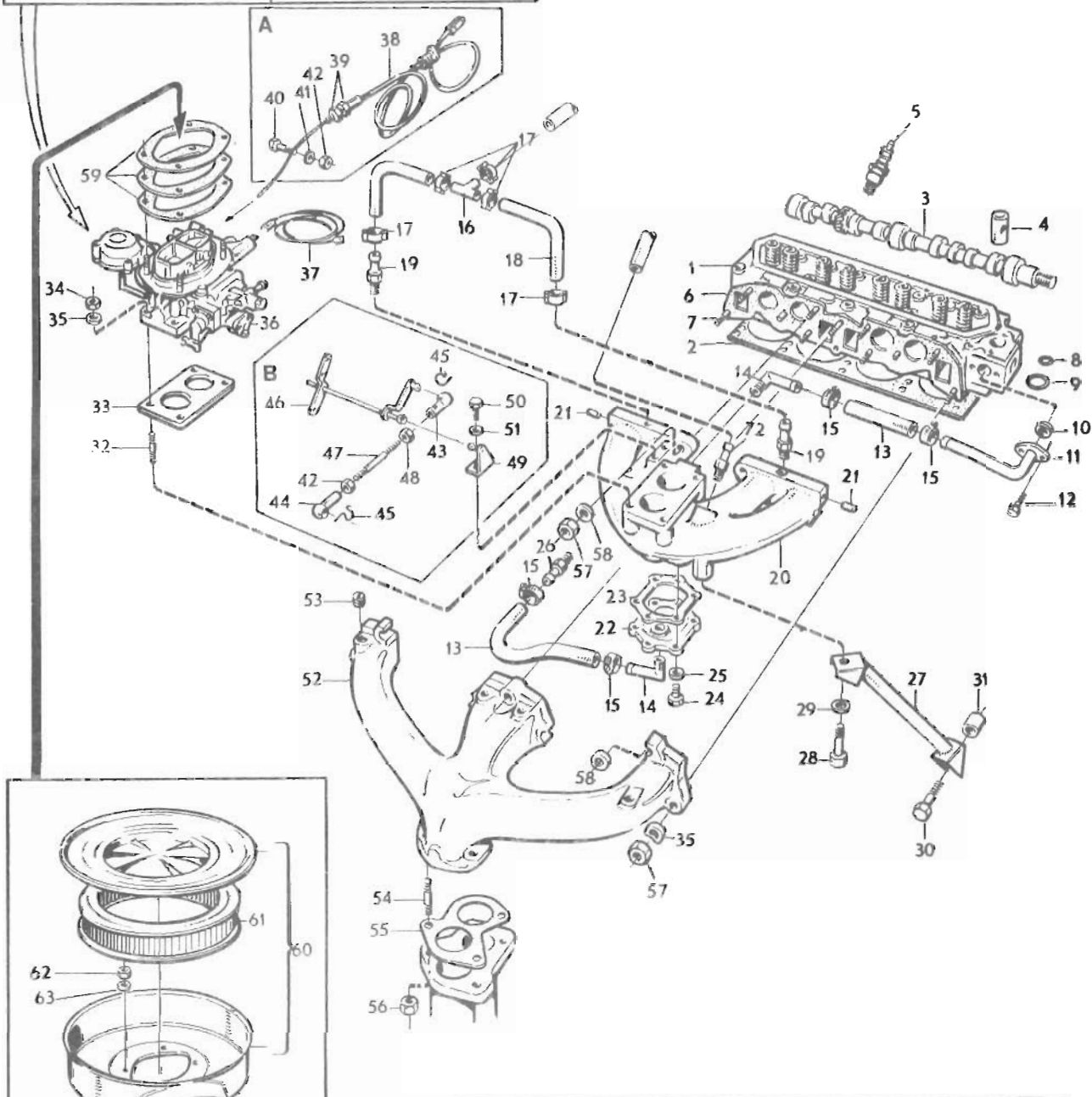
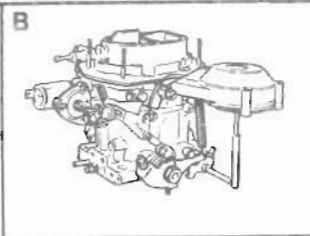
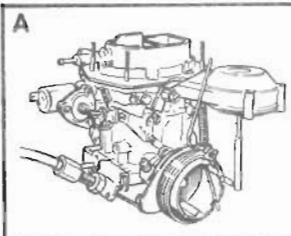
Qty	Part No	Description	Specification
1	552424-4	Cylinder head "Special III" 2.2 litres	For parts included, see Section A "Cylinder heads" (Replaces 552469, 552449 from Feb 1978)
1	552836-9	Cylinder head gasket	1.3 mm, Turbo gasket with an extra steel ring
1	552430-1	Camshaft "R" or Camshaft "S" 552445	Rally, Rallycross Rally, Track Racing, Rallycross
4	552498-6	Spark plug Bosch W3A (W275T1)	
8	552841-9	Valve tappet, lightened	57 grammes (85 grammes)
2	552004-4	Electrical fuel pump	Two pumps connected in parallel to be installed horizontally near the fuel tank, preferably in the luggage compartment
4	552451-7	Forged piston, compl 93 mm	For model year 1973 and older "Mahle" piston for competition driving under extreme conditions
4	552452-5	x Piston ring kit	
4	552457-4	x Piston bolt 22 mm	
8	552458-2	x Locking ring	


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Qty	Part No	Description	Specification
4	552450-9	Forged piston, compl 93 mm	For B20 1974 - "Mahle" piston for tough competition driving
4	552435-0	x Piston ring kit	
4	552433-5	x Piston bolt 24 mm	
8	552434-3	x Locking ring	
1	875375-8	Timing gear kit, steel	Necessary for strength
8	430121-4	Push rod	
1	552847-6	Baffled oil sump	Necessary to avoid bearing breakdown in Rally and Racing
1	1155255-1	Carburetor jet kit	With choke tube 40 mm
1	552919-3	Oil cooler	19-vane air cooled, compl with thermo- stat Necessary especially in the summer for Rally and Track Racing

For the power train we recommend:


1	552145-5	"RAC" clutch	
1	552146-3	Disc	To be used for "RAC" clutch
1	672122-1	Clutch release bearing	



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GT-kit B20 is not available as a complete kit any more. However, we still supply spare parts as listed below.

Pos	Qty	Part No	Description	Specification
1	1	552441-8	x Cylinder head	For parts included, see section A "B20 Cylinder Heads"
2	1	824855-1	x Cylinder head gasket	Thickness 1.2 mm
3	1	552422-8	x Camshaft "K"	Wizemann for maximum durability
4	8	552466-5	x Valve tappet	Wizemann for maximum durability
5	1	273536-3	x Spark plug W5A (W225T1)	
6	1	419764-6	x Manifold gasket	Also standard for B20E
7	9	953243-3	x Stud	
8	1	418655-7	x Sealing ring	
9	1	418657-3	x Sealing ring	
10	1	418445-3	x Rubber gasket	
11	1	552565-4	x Inlet pipe, preheating	
12	1	940100-1	x Screw	
13	1	946050-2	x Hose, preheating	
14	2	418421-4	x Elbow nipple, inlet manifold	
15	4	943473-9	x Clip	
16	1	419446-0	x T-union	
17	5	943470-5	x Clip	
18	0.4 m	947908-0	x Hose for servo (17.5 + 17.5 cm)	
19	2	947043-6	x Nipple	
20	1	552555-5	x Inlet manifold	Preheated inlet manifold, aluminium, for Solex register carburetor
21	2	422635-3	x Plug for inlet manifold	
22	1	552556-3	x Inlet manifold cover	
23	1	552557-1	x Gasket for cover	
24	6	955513-7	x Screw	
25	6	955893-3	x Washer	

	SPARE PARTS for .GT - KIT B20	EXPORT		810701
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Pos	Qty	Part No	Description	Specification
26	1	552563-9	x Nipple, pulley	
27	1	552560-5	x Stay	
28	1	956584-7	x Screw	
29	1	940097-9	x Washer	
30	1	940134-0	x Screw	
31	1	460561-4	x Spacer ring	
32	4	953238-3	x Stud	
33	1	552566-2	x Insulating flange	
34	4	955826-3	x Nut	
35	9	941907-8	x Washer	
36	1	552554-8	x Carburetor	Solex 40 EIES register carburetor with two 40 mm throttles. An excellent allround carburetor for both city and fast highway driving. See section B - CARBURETORS.
37	1	552571-2	x El. cable for valve, idling jet	
38	1	552567-0	x Wire	For 240 only
39	2	955782-8	x Nut for wire control	For 240 only
40	1	955243-1	x Bolt for wirelock	For 240 only
41	1	955946-9	x Lock washer	For 240 only
42	1	955780-2	x Nut	
43	1	942837-6	x Ball socket, left	For 140 only
44	1	959088-6	x Ball socket, right	For 140 only
45	2	959093-6	x Locking clamp	For 140 only
46	1	552564-7	x Control shaft	For 140 only
47	1	943314-5	x Push rod	For 140 only
48	1	942836-8	x Nut	For 140 only
49	1	552559-7	x Bracket for throttle control	For 140 only
50	2	955511-1	x Screw	For 140 only
51	2	941906-0	x Washer	For 140 only
52	1	460894-9	x Exhaust pipe, cast	Also standard for B20E



SPARE PARTS for
GT-KIT B20

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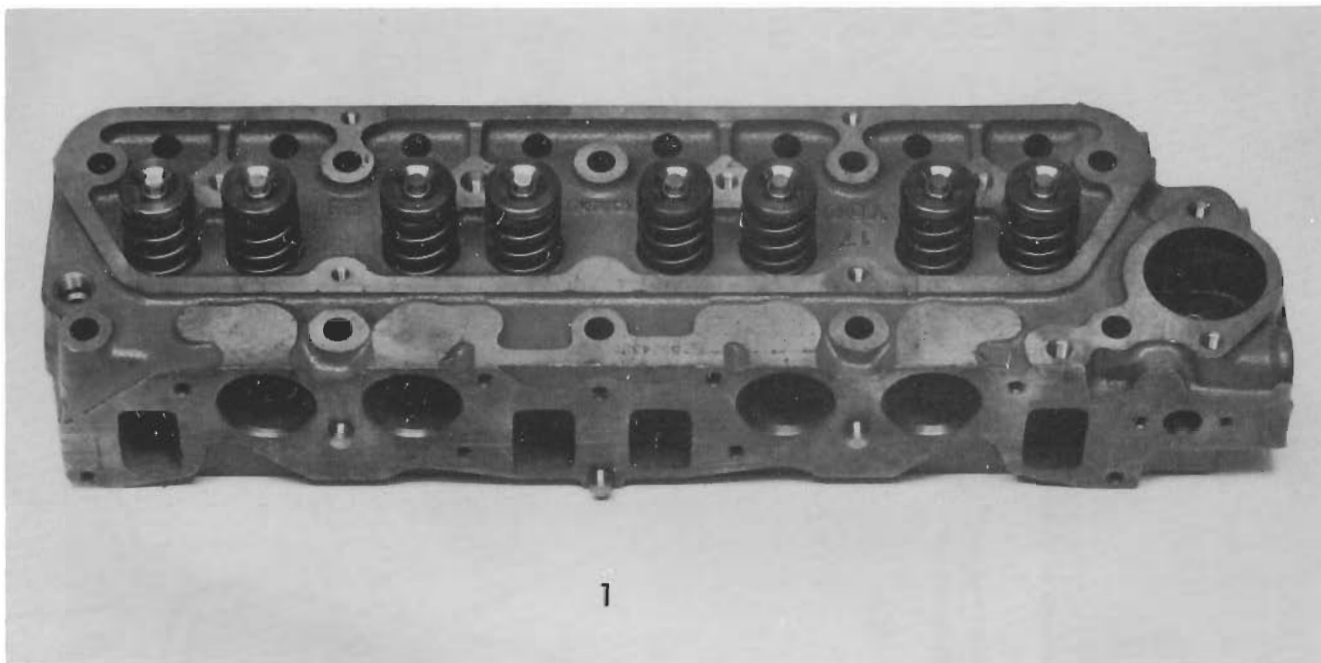
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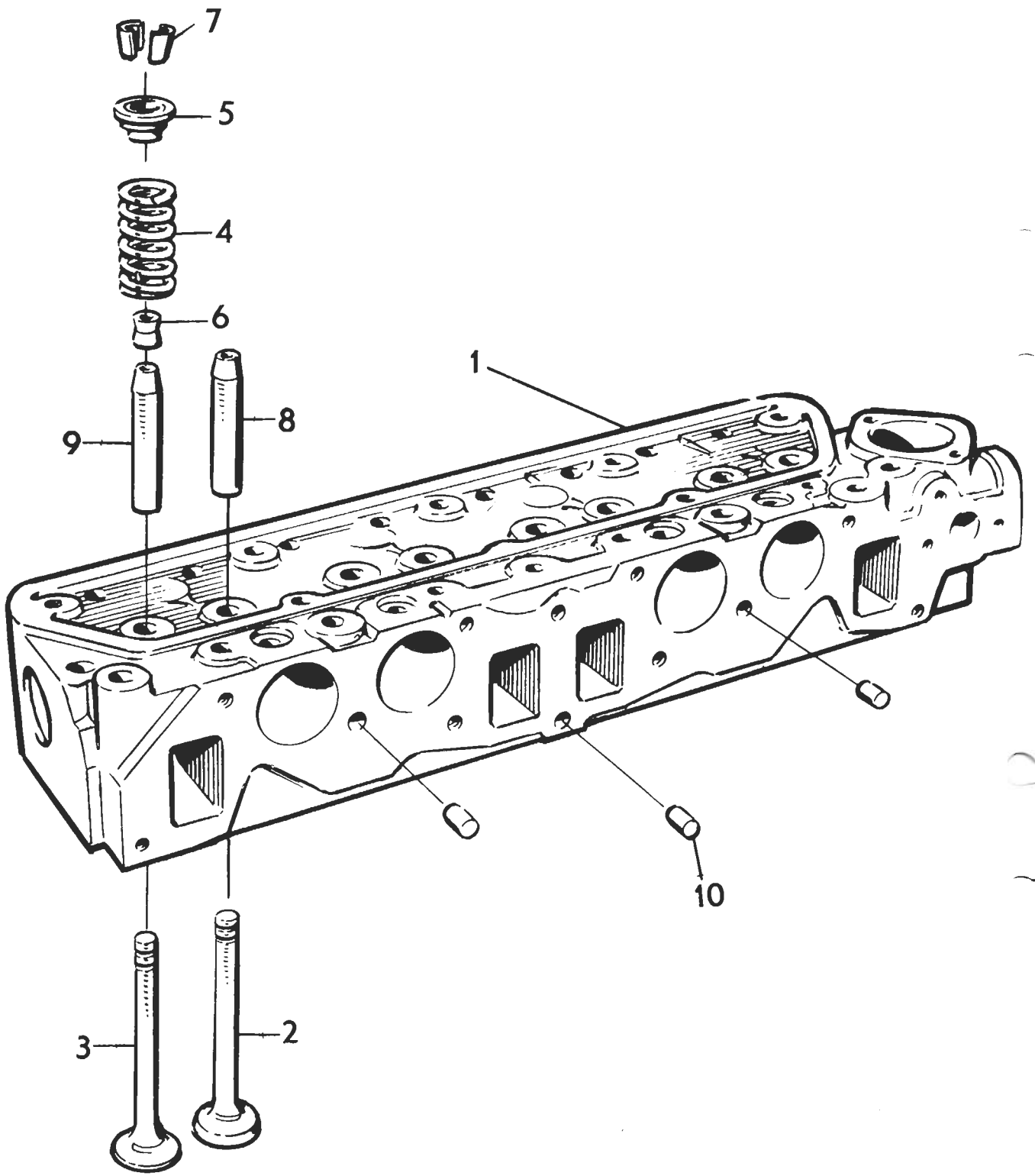
Pos	Qty	Part No	Description	Specification
53	4	191026-4	x Plug	
54	3	953259-9	x Stud	
55	1	671822-5	x Gasket	
56	3	191894-5	x Nut	
57	9	955826-3	x Nut for stud 953243, cylinder head - exhaust/inlet manifold	
58	4	419401-5	x Washer for stud 953243, cylinder head - inlet manifold	
59	3	552569-6	x Gasket for air filter	
60	1	552552-2	x Air filter	Sound absorptive air filter with extra low fall of pressure (effect loss)
61	1	552570-4	xx Air filter insert	Exchangeable paper insert for dust separation
62	4	963104-5	x Nut	
63	4	940090-4	x Washer	
64	2	552561-3	x Hose clip	
65	1	552562-1	x Hose,	
66	1	552572-0	x Collar for air mixer	
67	1	552568-8	x Air mixer	Thermostatically controlled - keeps automatically air temperature between 15 and 30° C for best possible driveability and fuel consumption. Reduces sound level in the car without "stealing" engine power.
	1	552575-3	xx Return spring	
68	1	552573-8	x Inlet hose, air mixer	
69	1	462735-2	x Reducer sleeve	
70	1	949121-8	x AI-hose, air mixer	
71	1	418272-1	x Gasket for timing gear casing	
72	1	460082-1	x Nipple for crankcase ventilation	

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Shim kit (part no 552439-2) is included in all cylinder heads.

Pos	Qty	Part No	Description	Specification
	1	552441-8	Special I	Designed for carburetor engines. Large but not polished channels. Radiused seats, modified valves 44/35. Production combustion chambers and valve spring seats retained. Compression ratio 10.5:1 with a 1.2 mm cylinder head gasket.
	1	552421-8	Special I b	As 552441-8 but with double valve springs.
1	1	552432-7	Special III 2.0 litres	Large, forged channels and radiused seats. Valve diam. 46/38 mm, double valve springs with aluminium washers and modified valves. Production combustion chambers retained. Compression 11.2:1.
1	1	552424-4	Special III 2.2 litres	As 552432-7 but with copying milled and polished combustion chambers. Combustion chamber volume 39 cm ³ . Compression 11.2:1. Note: Delivery time 3-4 weeks.





B20 CYLINDER HEADS

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Pos	Qty		Part No	Description	Specification
	552421-8	552441-8			
1	1	1		Cylinder head	
2	4	4	552816-1	x Valve, inlet	Modified, diam. 44 mm
3	4	4	552817-9	x Valve, exhaust	Modified, diam. 35 mm
4	-	8	418737-3	x Valve spring	Production, yellow marking
5	-	8	460181-1	x Valve spring washer	Production
6	8	8	419702-6	x Valve seal	Production
7	16	16	419643-2	x Valve lock	Production
8	4	4	552828-6	x Valve guide, inlet	Shortened, tapered
9	4	4	552818-7	x Valve guide, exhaust	Shortened
10	3	3	950586-8	x Guide pin	

Pos	Qty		Part No	Description	Specification
	552424-4 552432-7	552421-8			
1	1	-		Cylinder head	
2	4	-	552813-8	x Valve, inlet	Modified, diam. 46 mm
3	4	-	552815-3	x Valve, exhaust	Modified, diam. 38 mm
4	8	8	552436-8	x Valve spring, outer	
4	8	8	552437-6	x Valve spring, inner	
5	8	8	552438-4	x Valve spring washer	Dural, anodized
6	8	-	419702-6	x Valve seal	Production
7	16	-	419643-2	x Valve lock	Production
8	4	-	552828-6	x Valve guide, inlet	Shortened, tapered
9	4	-	552818-7	x Valve guide, exhaust	Shortened
10	3	-	950586-8	x Guide pin	

	CYLINDER HEAD PARTS B20 (BEFORE FEB 1978)	EXPORT		810701
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Spare parts list for cylinder heads "Stages I to IV" and "Special II", earlier than Feb 1978.

Complete cylinder heads in these versions are no longer available, as they are completely replaced by our cylinder heads Special I-III. Spare parts for these cylinder heads are, however, still available as per the table below.

Qty	Description	Stage I	Stage II	Stage II	Stage III 2.0	Special 1E	Special 1F	Special II
1	Cylinder head	419882	552447	552842	552448	552425	552444	552423
4	Valve, inlet	419766	552848	552848	552823	552816	552816	552816
4	Valve, exhaust	419735	552849	552849	552824	552817	552817	552817
8	Valve spring	418737	418737	418737	418737	418737	418737	418737
8	Valve spring washer	460181	460181	460181	460181	460181	460181	460181
8	Valve seal	419702	419702	419702	419702	419702	419702	419702
16	Valve lock	419643	419643	419643	419643	419643	419643	419643
4	Valve guide, inlet	419652	552828	552828	552828	552828	552828	552828
4	Valve guide, exhaust	419653	552818	419653	552818	552818	552818	552818
3	Guide pin	950586	950586	950586	950586	950586	950586	950586
1	Shim kit		552439		552439			

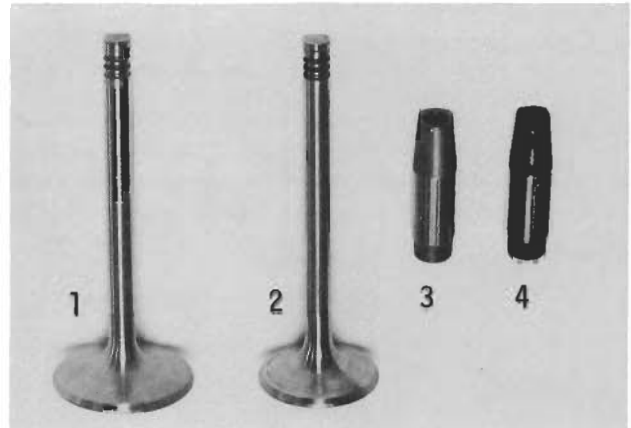
Qty	Description	Stage III	Stage IV	Stage IV	Special II
1	Cylinder head	552464	552449	552469	552443
4	Valve, inlet	552823	552823	552823	552816
4	Valve, exhaust	552824	552824	552824	552817
8	Valve spring	418737	418737	418737	418737
8	Valve spring washer	460181	460181	460181	460181
8	Valve seal	419702	419702	419702	419702
16	Valve lock	419643	419643	419643	419643
4	Valve guide, inlet	552828	552828	552828	552828
4	Valve guide, exhaust	419653	552818	419653	552818
3	Guide pin	950586	950586	950586	950586
1	Shim kit		552439		



VALVES

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For information on application for valves and valve guides mentioned here, see table below



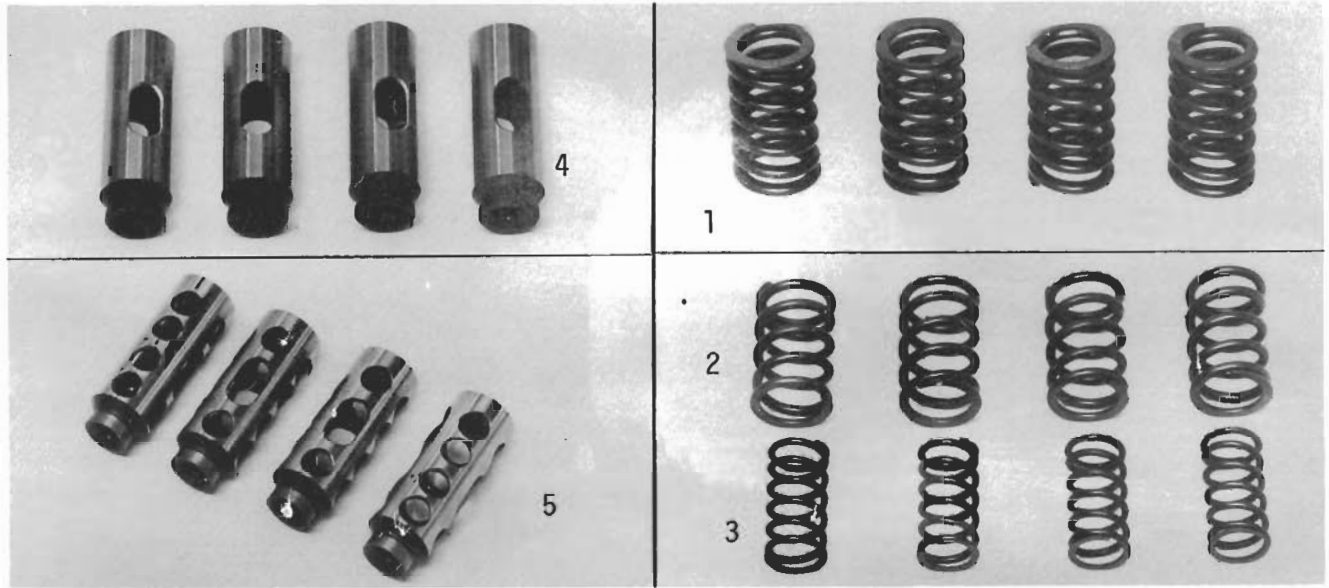
Pos	Qty	Part No	Description	Specification
1	4	419766-1	Valve, inlet	44 mm, production valve
1	4	552813-8	Valve, inlet	46 mm, modified
1	4	552816-1	Valve, inlet	44 mm, modified
1	4	552823-7	Valve, inlet	45 mm, ground and polished
1	4	552834-4	Valve, inlet	45 mm, production valve
1	4	552848-4	Valve, inlet	44 mm, ground and polished
2	4	419735-6	Valve, exhaust	35 mm, production valve
2	4	552815-3	Valve, exhaust	38 mm, modified
2	4	552817-9	Valve, exhaust	35 mm, modified
2	4	552824-5	Valve, exhaust	38 mm, ground and polished
2	4	552835-1	Valve, exhaust	38 mm, production
2	4	552849-2	Valve, exhaust	35 mm, ground and polished
3	4	419652-3	Valve guide, inlet	Production
3	4	552828-6	Valve guide, inlet	Shortened, tapered
4	4	419653-1	Valve guide, exhaust	Production
4	4	552818-7	Valve guide, exhaust	Shortened

PART NO	ENGINE	VALVE DIAM.		GUIDE	APPLICATION
		INLET	EXHAUST		
419766	B20	44		419652	For modified old B20 cylinder heads and "Stage I" heads
419735	B20		35	419653	
552848	B20	44		552828	"Stage II" heads
552849	B20		35	419653	
552834	B20	45		419652	For renovation of production heads or "Stage I" heads with heavily worn valve seats
552835	B20		38	419653	
552823	B20	45		552828	For "Stage III" and "Stage IV" heads and renovation of "Stage II" heads with heavily worn valve seats
552824	B20		38	419653	
552816	B20	44		552828	For "Special I" and "Special II" cylinder heads
552817	B20		35	552818	
552813	B20	46		552828	For "Special III 2.0" and "Special III 2.2" cylinder heads
552815	B20		38	552818	




VALVE SPRING
VALVE TAPPET and
CYLINDER HEAD GASKET

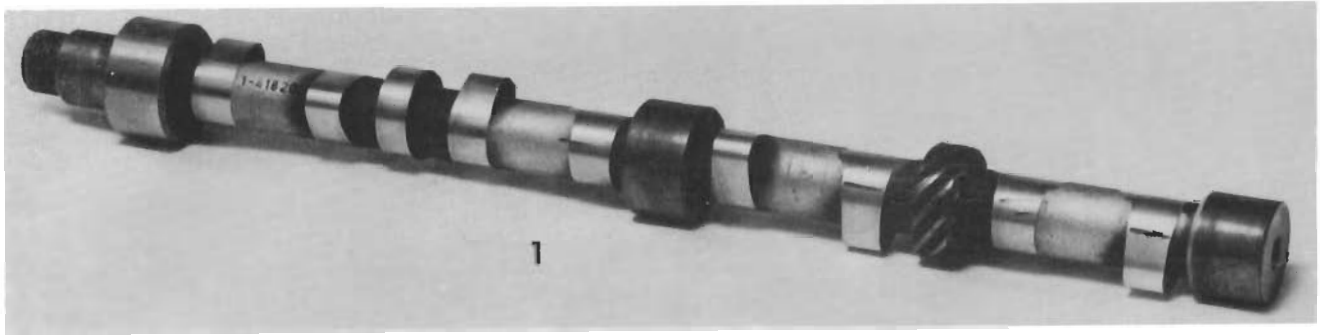
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Pos	Qty	Part No	Description	Specification
1	8	418737-3	Valve spring	Production spring. Yellow marking.
2	8	552436-8	Valve spring, outer	Standard in "Special III 2.0" and "Special III 2.2" cylinder heads
3	8	552437-6	Valve spring, inner	Standard in "Special III 2.0" and "Special III 2.2" cylinder heads
	8	460181-1	Valve spring washer	Production washer for valve spring 418737
	8	552438-4	Valve spring washer	Anodized dural washer for "Special III" 2.0 and 2.2 cylinder heads
	8	419702-6	Valve seal	Standard on all cylinder heads
	16	419643-2	Valve lock	Standard on all cylinder heads
4	8	552466-5	Valve tappet	Wizemann. Standard in GT Kit and Tuning Kit "Special I". Must be used when any R-Sport camshaft is used.
5	8	552841-9	Valve tappet, lightened	Wizemann. Recommended for "Special III" 2.0 and 2.2. 57 grammes (85 grammes).
	3	950586-8	Guide pin	
	1	552832-8	Shim kit for valve spring B20	Is used to adjust production valve spring (418737) according to table below
	1	552439-2	Shim kit (Special)	For "Special II" cylinder heads with valve spring 418737 according to table below
	8	430121-4	Push rod	
	1	824855-1	Cylinder head gasket	1.2 mm
	1	552836-9	Cylinder head gasket	Turbo gasket for pistons up to a diameter of 93.0 mm

Camshaft	Length mm (Installed height)
K	39.5 ± 0.1
F, R	40.5 ± 0.1
S, U	41.5 ± 0.1

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Together with these camshafts, Volvo R Sport's valve tappets (Part No 552466-5 or 552841-9) must be installed.

Pos	Qty	Part No	Description	Specification
1	1	552422-8	Camshaft "K"	Standard camshaft in GT-kit B20. Made of Wizemann blank. Suitable for single or twin carburetor engines with moderately increased output. Gives better low-end torque than production camshaft for injection engines.
1	1	552430-1	Camshaft "R"	The best camshaft for Rally and Rallycross on curved, slow tracks, where a good torque at low RPM is necessary. Maximum output at 6.000-6.200 RPM. Must be used on engines with twin-choke carburetors only. Also suitable for normal driving.
1	1	552460-8	Camshaft "F"	Basic camshaft in tuning kit B20. Suitable for normal as well as rally driving, where maximum performance is not needed. Hard chromium-plated for longer life.
1	1	552445-9	Camshaft "S"	Designed for Rally, Track Racing and Rallycross. Different from the "R"-camshaft mainly because it is "keener" at high RPM. Maximum output at 6.500-7.000 RPM gives 8-10 hp more than camshaft "R" but slightly lower torque at low RPM.
1	1	552446-7	Camshaft "U"	Designed mainly for Track Racing but can also be used on Rallycross engines with a displacement of more than 2.3 litres. Maximum output at 7.000 RPM. Hard chromium-plated for longer life.

VALVE TIMING

Type	Valve lift	Inlet opens before TDC	Inlet closes after BDC	Exhaust opens before BDC	Exhaust closes after TDC	Tappet play Inl/Exh	Duration
K	10.8 mm	27°	70°	70°	27°	0.45/0.50 mm	277°
F	11.3 mm	30°	81°	81°	39°	0.40/0.45 mm	300°
R	11.6 mm	42°	65°	64°	44°	0.40/0.45 mm	287°
S	12.9 mm	49°	71°	71°	49°	0.50/0.50 mm	300°
U*)	12.9 mm	54°	78°	78°	54°	0.50/0.50 mm	312°

*) "Full race"



PISTONS, PISTON RINGS,
PISTON PINS and TIMING GEARS

EXPORT

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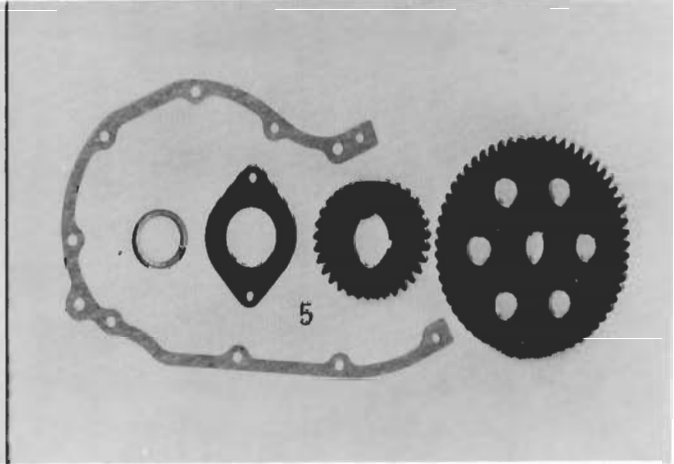
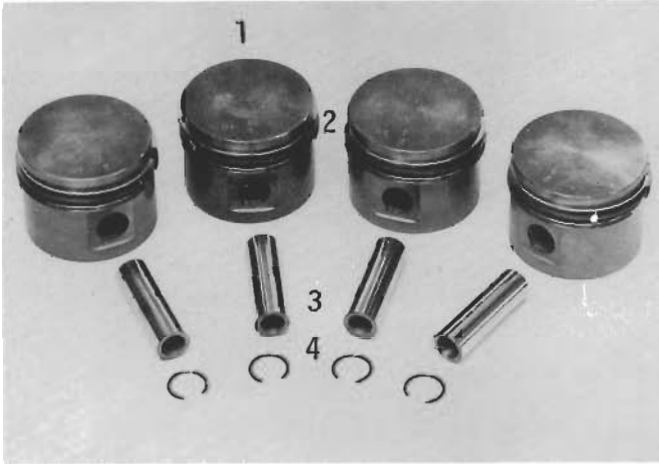
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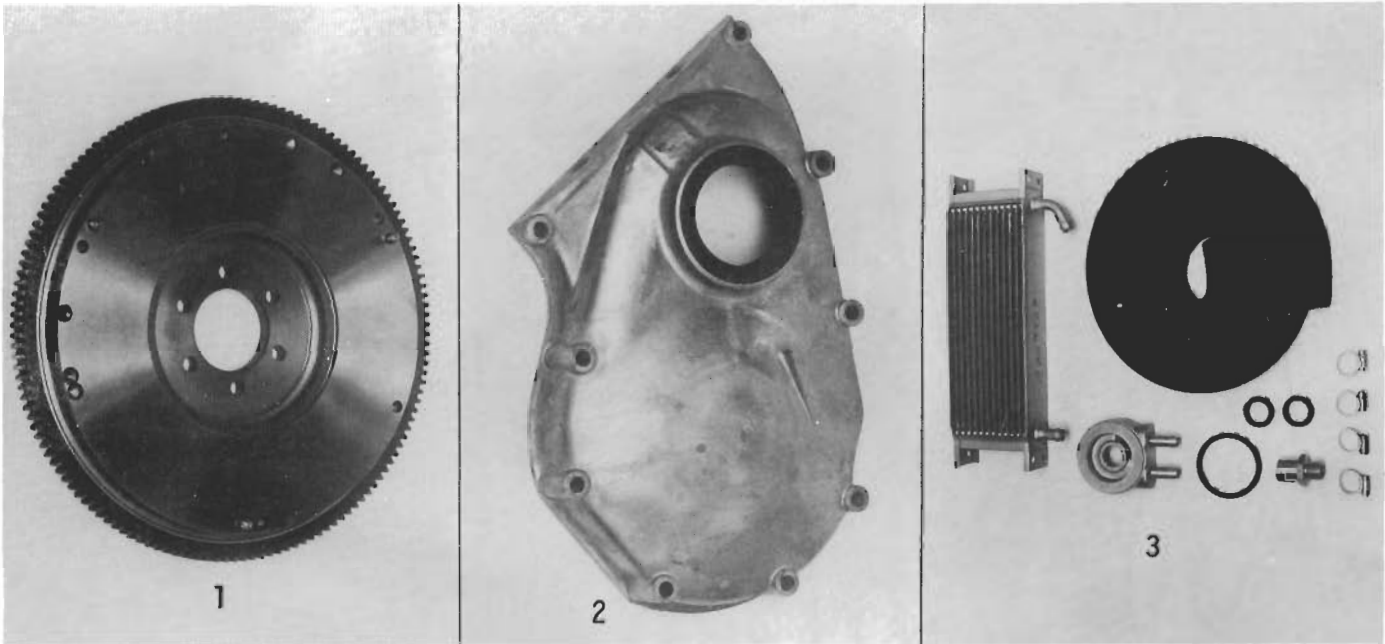


Pos	Qty	Part No	Description	Specification
1	4	552453-3	Piston, standard dimension (88.9 mm), forged	"Mahle" piston for standard cylinder diameter. Piston play minimum 0.08 mm. Should be used on all competition engines "Special II" and "Special III". Has a much better strength than production piston.
2	4	552455-8	x Piston ring kit	B20 up to and inclusive of -73 year model.
3	4	552457-4	x Piston pin	
4	4	552458-2	x Locking ring	
1	4	552451-7	Piston, compl, 93 mm, 2.2 litres, forged	"Mahle" piston for 2.2 litres engines. Suitable for Rallycross and Racing.
2	4	552452-5	x Piston ring kit	Also when a bigger cylinder capacity is required of the B20 engine.
3	4	552457-4	x Piston pin	Cylinder capacity with these pistons is 2175 cm ³ .
4	4	552458-2	x Locking ring	B20 up to and inclusive of -73 year model.
1	4	552450-9	Piston, 93 mm, 2.2 litres, forged	Piston pin diameter 24 mm. Designed for B20 1974 engines. Can also be used for rebored B21 engines.
2	4	552452-5	x Piston ring kit	
3	4	552433-5	x Piston pin 24 mm	From 1974 year model
4	4	552434-3	x Locking ring	
2	4	552456-6	Piston ring kit for piston 552454 with overdim. 0.03"	Piston 552454 is no longer available
5	1	875375-8	Timing gear kit, steel	Much better strength than production timing gears. Must be used on "Special III 2.0" and "Special III 2.2".

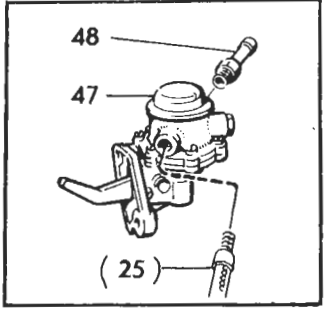
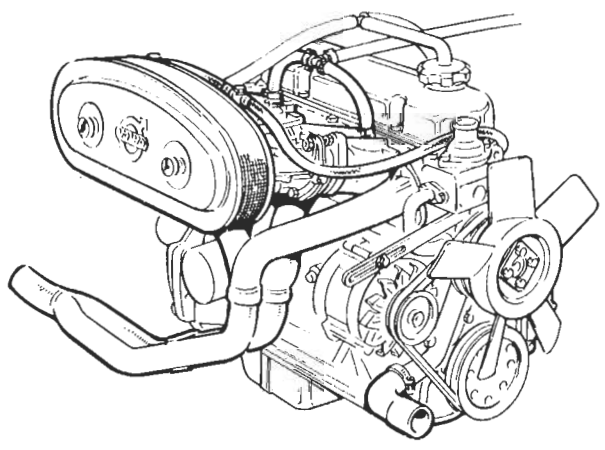
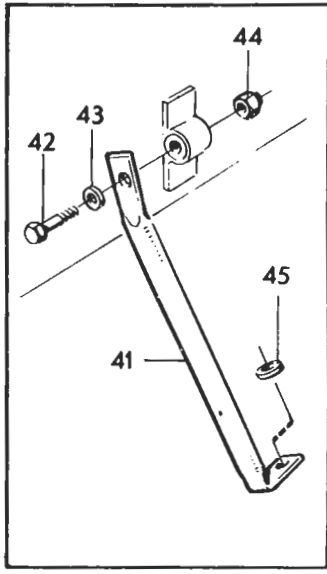
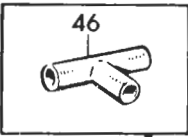
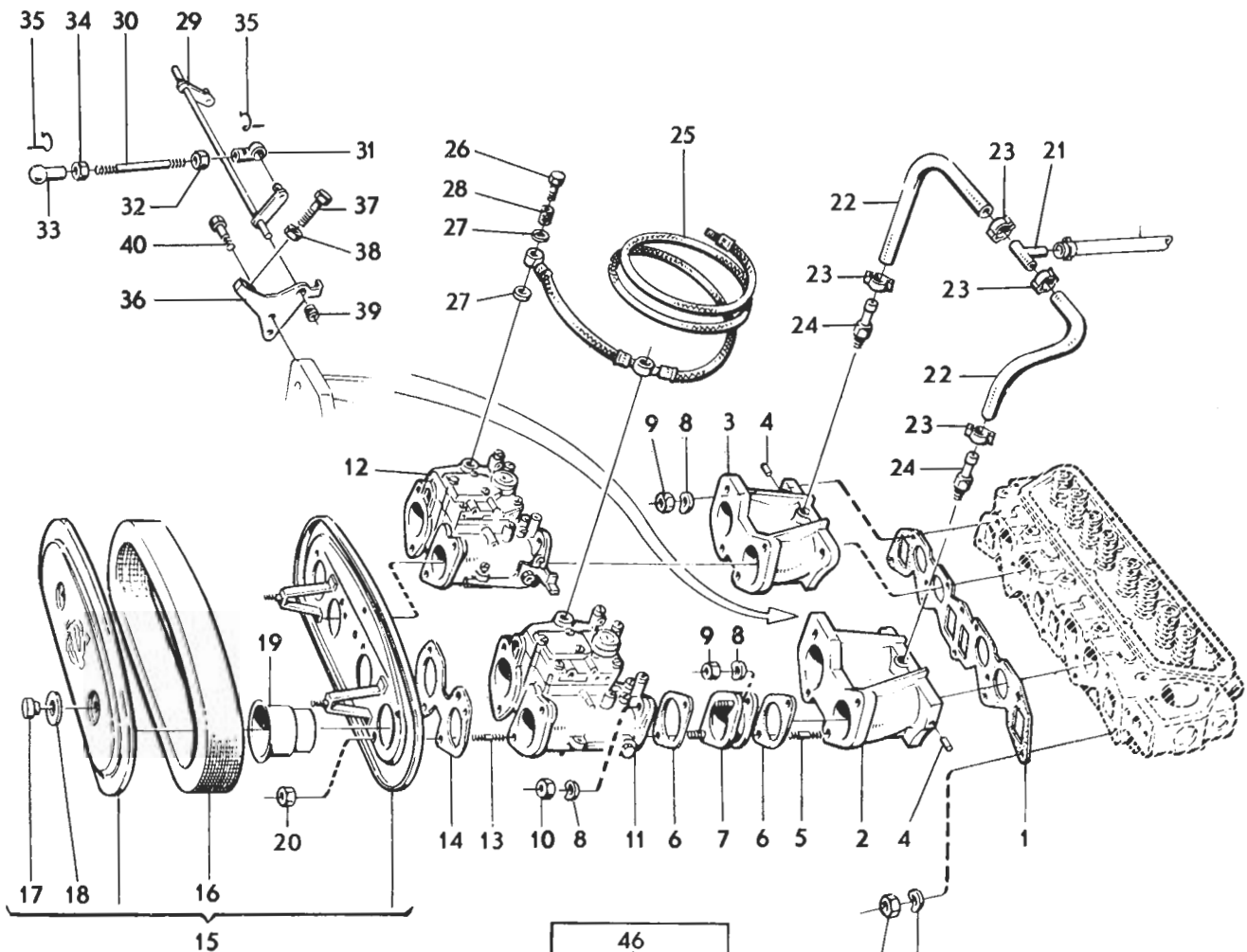
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FLYWHEELS and OIL COOLERS



Pos	Qty	Part No	Description	Specification
1	1	419392-6	Lightened steel flywheel (6 bolt)	For B20 up to and inclusive of 1973 models
1	1	552833-6	Lightened steel flywheel (8 bolt)	For B20 from year model 1974
2	1	418693-8	Timing gear cover	Including neoprene seal
2	1	552847-6	Baffled oil sump	
3	1	552909-4	13 vane oil cooler, complete with adapter and hoses	Necessary in the summer for Rally as well as Track Racing
		552907-8	x Adapter with thermostat	
		552918-5	x O-ring	
3	1	552919-3	19 vane oil cooler, complete with adapter and hoses	Thermostat controlled to ensure correct oil temperature in all driving conditions
	1	552907-8	x Adapter with thermostat	
	1	552918-5	x O-ring	





CARBURETOR KIT - SOLEX 45 ADDHE

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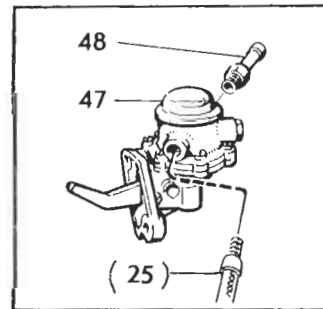
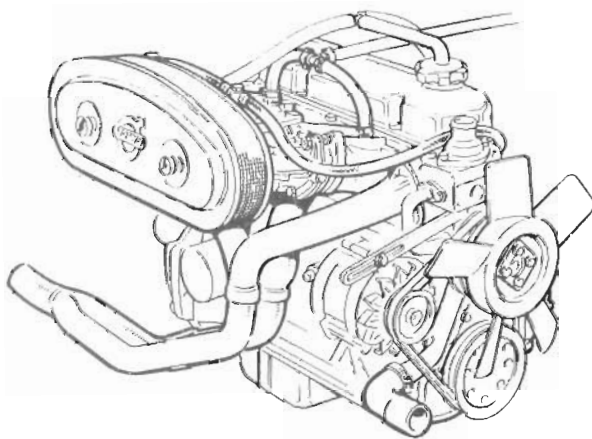
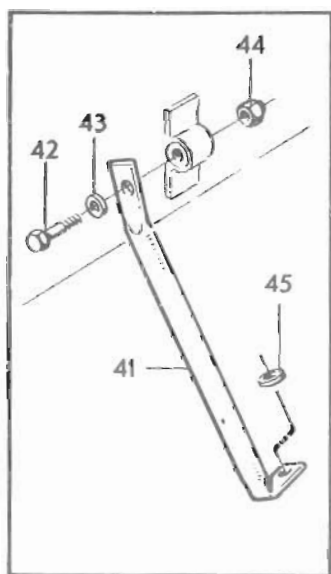
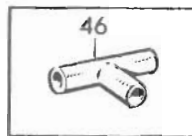
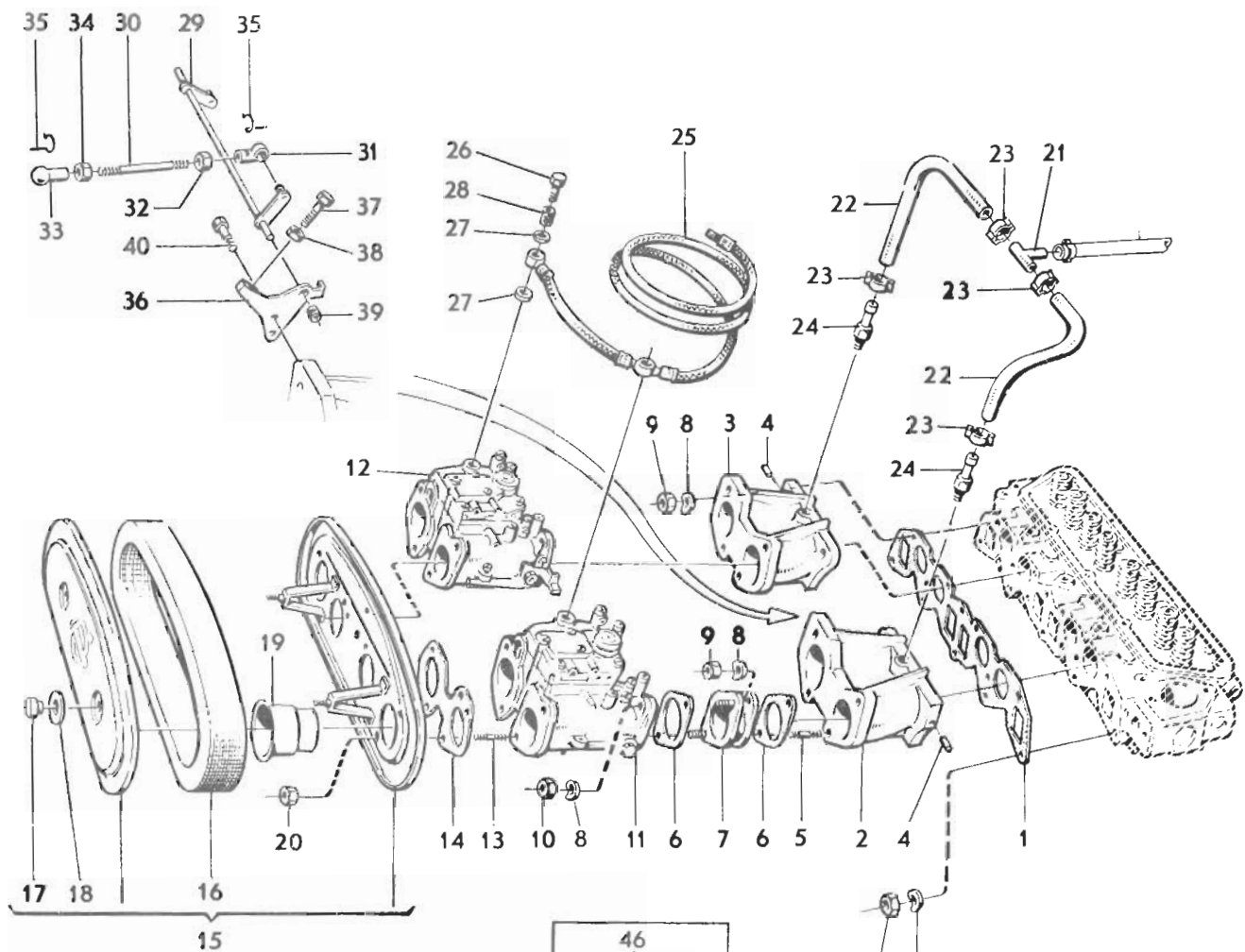
B


1

The main components of this kit are special cast aluminium inlet manifolds, two twin choke aluminium alloy carburetors SOLEX 45 ADDHE with throttle spindles running on ball bearings, jets within easy reach from above and control levers of a new design for easy and lasting synchronization, an air filter with a very large inlet area for the lowest possible loss of power. The air filter insert is washable. There are also a mechanical high capacity fuel pump and other details necessary for mounting of the kit into a car.

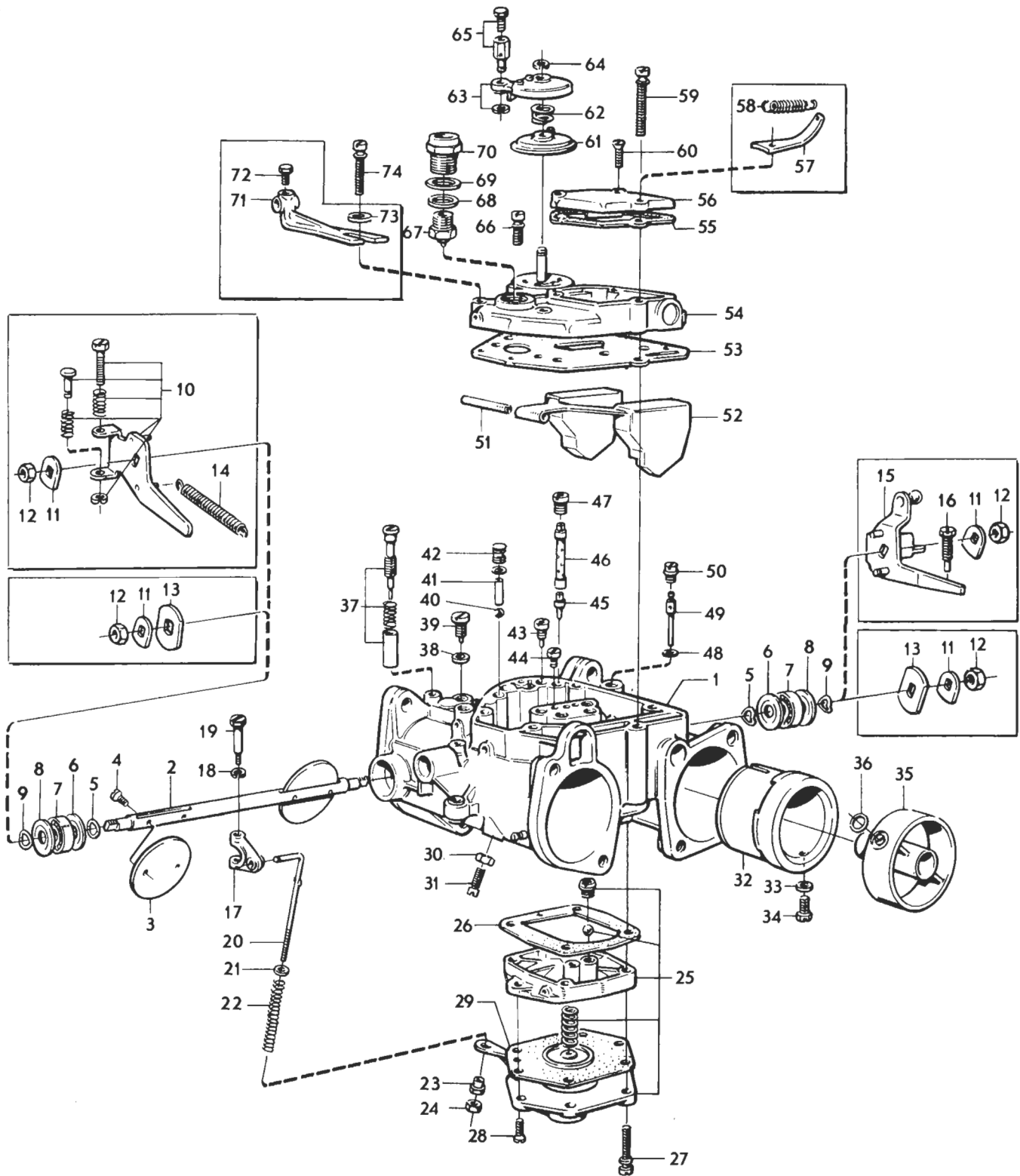
The kit is designed for the 140-series with B20 engine up to and inclusive of 1970 year model and is suitable for those who for one reason or another do not wish to buy a complete tuning kit. At a reasonable price this kit gives a good power increase and is a suitable basis for further tuning. We recommend, however, that this kit is combined with an "F" camshaft (part no 552460-8) and a Rally Exhaust Kit.


Pos	Qty	Part No	Description	Specification
		552615-7	Carburetor kit, complete	
1	1	419764-6	x Gasket for exhaust manifold	
2	1	419883-4	x Inlet manifold, front	
3	1	419884-2	x Inlet manifold, rear	
4	2	422635-3	x Plug for inlet manifold	
5	8	953461-1	x Stud (inlet manifold-rubber flange)	
6	8	819769-1	x Gasket for carburetor	
7	4	824643-1	x Rubber flange for carburetor	
8	16	941907-8	x Washer	
9	8	955826-3	x Nut for 953461	
10	8	955847-9	x Nut for stud - rubber flange	
11	1	552630-6	x Carburetor, front	See Section B - CARBURETORS
12	1	552629-8	x Carburetor, rear	
13	8	953032-0	x Stud (carburetor-air filter)	
14	2	419906-3	x Gasket (air filter-carburetor)	
15	1	684036-7	x Air filter, complete	
16	1	552620-7	xx Air filter, insert	
17	2	552621-5	xx Nut	
18	2	552622-3	xx Washer	
19	4	824708-2	x Air intake	
20	8	946035-3	x Nut	



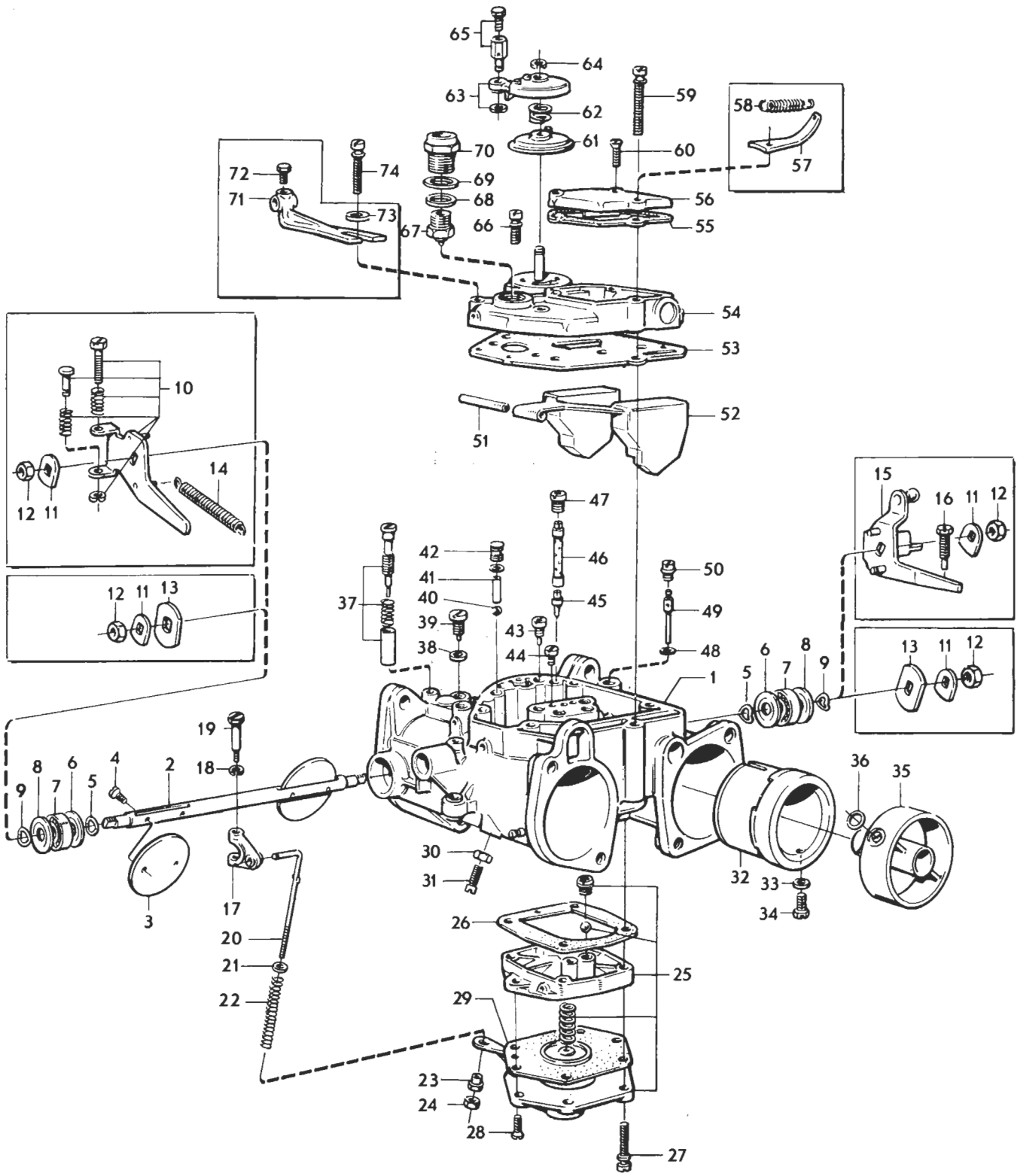
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Pos	Qty	Part No	Description	Specification
21	1	419446-0	x T-union for servo hose	
22	0.3 m	947908-0	x Hose for servo 0.15 + 0.15	
23	4	942928-3	x Clip for 947908-0 hose	
24	2	947043-6	x Nipple for servo	
25	1	825856-8	x Fuel hose	
26	2	825857-6	x Banjo screw for fuel hose	
27	4	957173-8	x Gasket for banjo screw	
28	2	825858-4	x Strainer for fuel hose	
29	1	684899-8	x Shaft for throttle control, upper, 67-72	
29	1	552431-9	x Shaft for throttle control, upper, 73-74	
30	1	943936-5	x Control shaft	
31	1	959088-6	x Ball socket	
32	1	955780-2	x Nut for ball socket 959088	
33	1	942837-6	x Ball socket	
34	1	942836-8	x Nut for ball socket 942837	
35	2	959093-6	x Locking clamp for ball socket 959088 and 942837 respectively	
36	1	1206551-2	x Bracket for throttle control	
37	1	955273-9	x Bolt for 1206551	
38	1	955781-0	x Nut for 955273	
39	1	666143-3	x Bushing for 1206551	
40	2	955512-9	x Screw for 1206551, to tighten to inlet manifold	
41	1	460047-4	x Stay for air filter	
42	1	955536-8	x Bolt for stay in air filter	
43	1	940097-9	x Washer for 460047 stay for air filter	
44	1	950354-1	x Nut for 955536	
45	1	960142-8	x Washer against engine pad	
46	1	552551-4	x T-union for crankcase ventilation	
47	1	831092-2	x Fuel pump	
48	1	946600-4	x Nipple for fuel pump	



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Pos	Qty	Part NO	Description	Specification
		552630-6	Carburetor front, complete	SOLEX 45 ADDHE for B20 engine.
		552629-8	Carburetor rear, complete	NOTE! QTY PER CARBURETOR
1	1		x Carburetor house	Not available as spare part
2	1	1155235-3	x Throttle spindle	
3	2	1155236-1	x Butterfly	
4	4	1155237-9	x Screw for butterfly	
5	2	1155238-7	x Spring washer	
6	2	1155239-5	x Washer	
7	2	1155240-3	x Ball bearing	
8	2	1155241-1	x Washer	
9	2	1155242-9	x Spring washer	
10	1	1155168-6	x Lever for throttle spindle, complete with synchronization screw and springs	Front carburetor only
11	2	1155215-5	x Locking washer	
12	2	1155199-1	x Nut for throttle spindle	
13	1	1155214-8	x Washer	
14	1	1155206-4	x Return spring	
15	1	1155173-6	x Lever for throttle spindle	Rear carburetor only
16	1	1155187-6	x Idling adjustment screw	Rear carburetor only
17	1	1155167-8	x Intermediate lever for accelerator pump	
18	1	1155209-8	x Spring washer	
19	1	1155095-1	x Screw	
20	1	1155176-9	x Pull rod	
21	1	1155216-3	x Washer	
22	1	1155202-3	x Spring	
23	1	1155066-2	x Nut	
24	1	1155068-8	x Lock nut	
25	1	1155146-2	x Accelerator pump, complete	
26	1	1155059-7	x Gasket for accelerator pump	
27	1	1155190-0	x Screw	
28	2	1155244-5	x Screw	

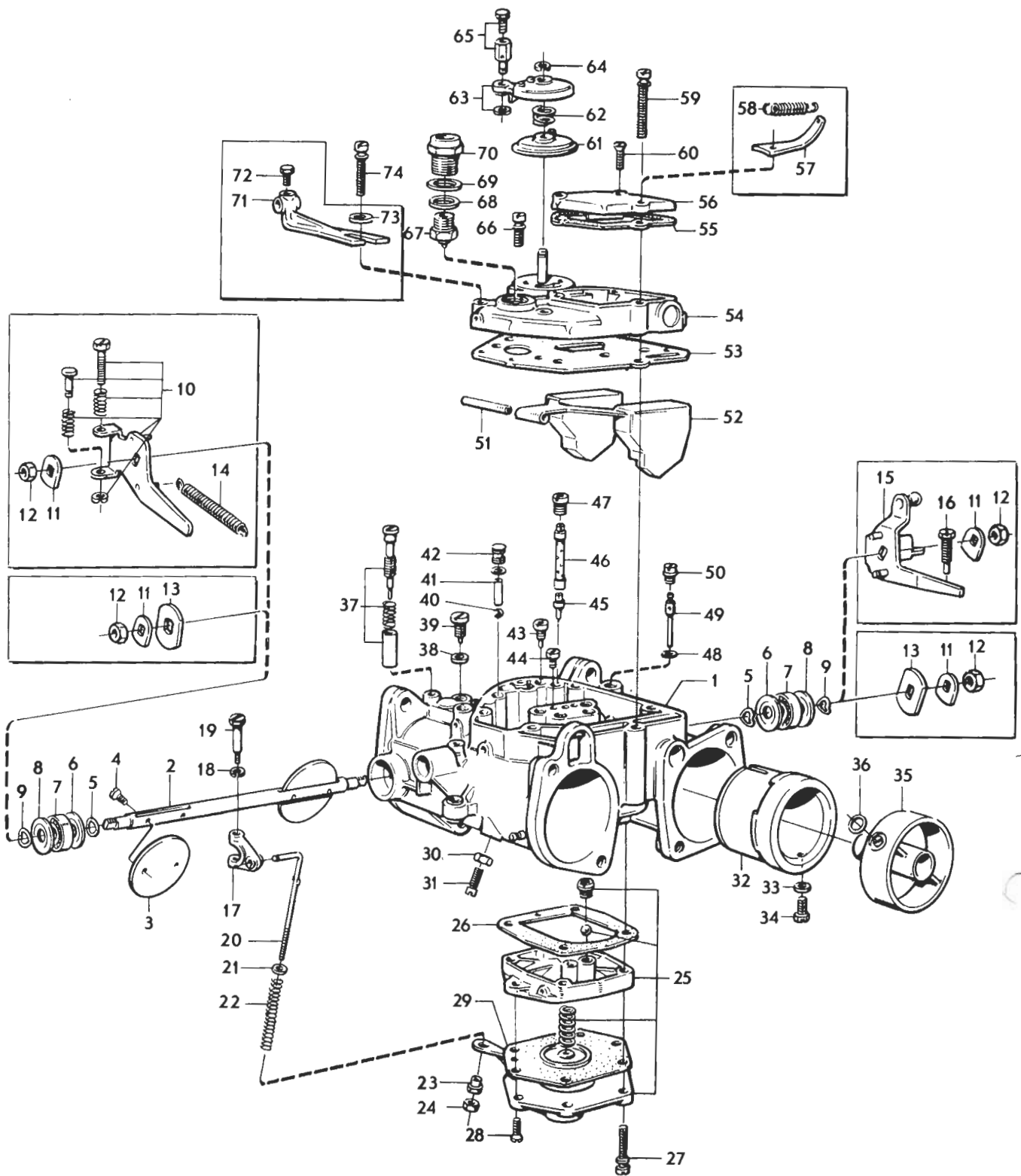




SPARE PARTS for
CARBURETOR SOLEX 45 ADDHE

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Pos	Qty	Part No	Description	Specification
29	1	1155243-7	x Diaphragm	
30	2	1155198-3	x Nut	
31	2	1155189-2	x Screw	
32	2	1155040-7	x Choke tube 36	
33	2	1155093-6	x Washer	
34	2	1155042-3	x Screw	
35	2	1155092-8	x Diffusor	
36	2	1155161-1	x Sealing ring for diffusor	
37	1	1155229-6	x Volume control screw, complete	
38	2	1155154-6	x Gasket	
39	2	1155179-3	x Screwed plug	
40	2	1155054-8	x Ball	
41	2	1155085-2	x Ballast	
42	2	1155086-0	x Grub with sealing ring	
43	2	1155130-6	x Idle jet 62	
44	2	1155125-6	x Air jet	
45	2	1155124-9	x Main jet 190	
46	2	1155133-0	x Emulsion tube	
47	2	1155127-2	x Air jet 220	
48	2	1155089-4	x Sealing washer for accelerator jet	
49	2	1155136-3	x Accelerator jet	
50	2	1155194-2	x Grub for accelerator jet	
51	1	1155046-4	x Float toggle spindle	
52	1	1155022-5	x Float assembly	
53	1	1155162-9	x Gasket for float chamber cover	
54	1	1155141-3	x Float chamber cover	
55	1	1155160-3	x Gasket for cover	
56	1	1155149-6	x Cover	
57	1	1155060-5	x Yoke for return spring for starter carburetor	Front carburetor only
58	1	1155075-3	x Return spring	Front carburetor only
59	1	1155193-4	x Screw (long)	
60	2	1155191-8	x Screw	





SPARE PARTS for
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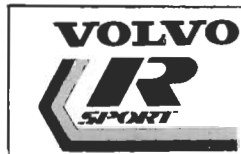
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Pos	Qty	Part No	Description	Specification
61	1	1155152-0	x Starter valve	
62	1	1155016-7	x Starter valve spring	
63	1	1155018-3	x Starter cover	
64	1	1155065-4	x Locking ring	
65	1	1155064-7	x Bracket	
66	1	1155182-7	x Screw (short)	
67	1	1155049-8	x Float valve 1.8	
68	1	1155047-2	x Gasket for float valve	
69	1	1155245-2	x Washer	
70	1	1155246-0	x Seat for fuel inlet	
71	1	1155153-8	x Starter cable clamp	Only rear carburetor
72	1	1155021-4	x Cable fixing screw	Only rear carburetor
73	1	1155212-2	x Washer	Only rear carburetor
74	4	1155192-6	x Screw	



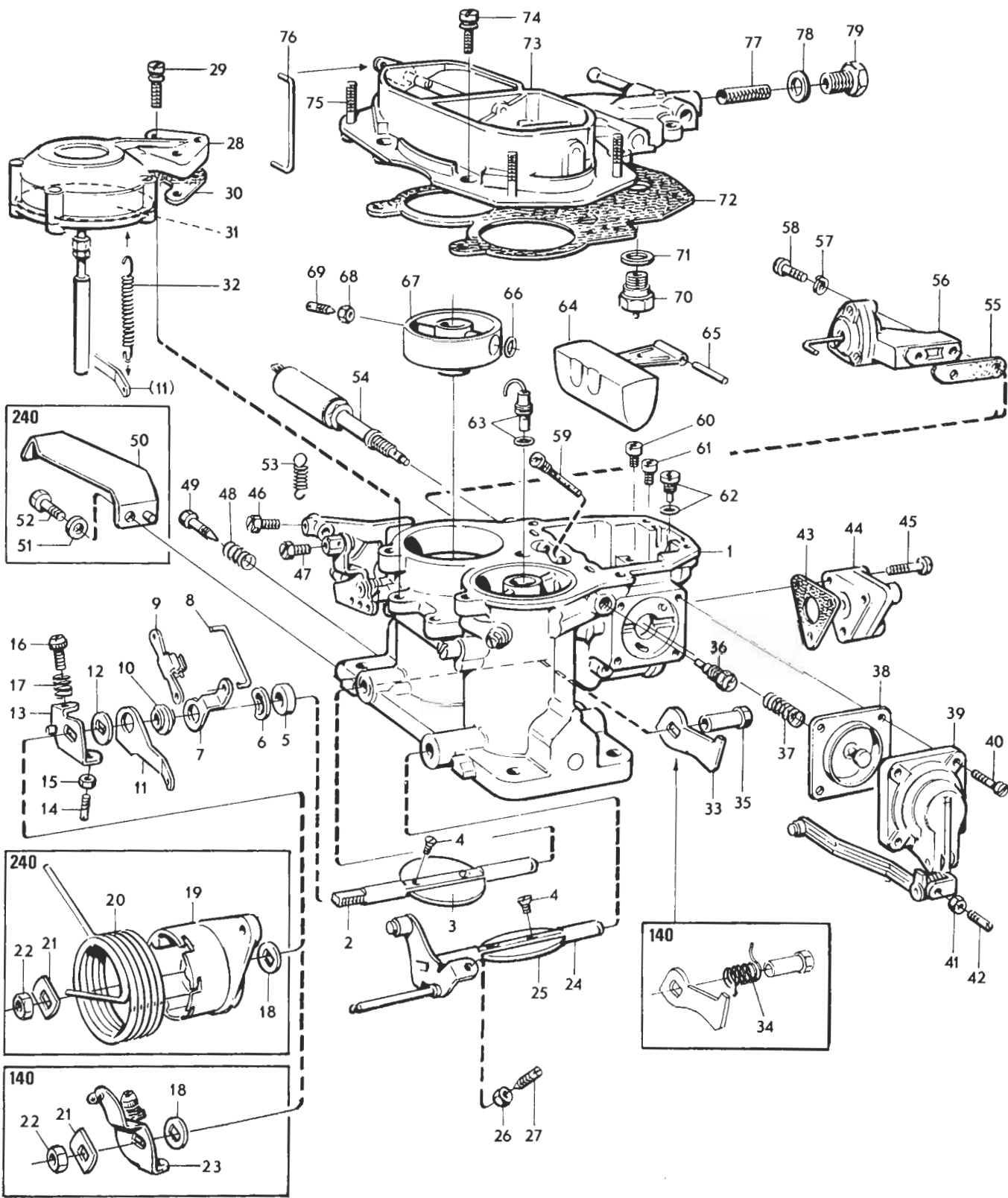
JET SET SOLEX 45 ADDHE

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Pos	Qty	Part No	Description	Specification
	4	1155249-4	Main jet 150	See table below
	4	1155251-0	Air jet 125	" " "
	1	1155255-1	Jet set	" " "
	4	552609-0	x Choke tube 40	
	4	1155252-8	x Main jet 195	
	4	1155253-6	x Air jet 200	
	1	1155285-8	Jet set	" " "
	4	552609-0	x Choke tube 40	
	4	1155250-2	x Main jet 155	
	4	1155254-4	x Air jet 120	

CHOKE TUBE DIMENSION	PART NO	MAIN JET	PART NO	AIR JET	PART NO	SPECIFICATION	APPLICATION
36	1155040	150	1155249	125	1155251	Standard combination in carburetors 552629 and 552630	Standard setting in "Special I" Normal driving and Rally
40	552609	155	1155250	120	1155254	Available as a kit, part no 1155285	Suitable for "Special III" (rally engines with a high maximum-output

2	1155262-7	Idling jet 57	For a leaner mixture and thereby lower fuel consumption at speeds below 100 km/h.
2	1155266-8	Idling jet 67	To be used in very low temperatures when mixture otherwise is to lean.
2	1155267-6	Idling jet 72	
2	1155134-8	Acceleration jet	To be installed instead of standard jet when mixture is to lean when accelerating, above all when large (> 36) choke tubes have been installed.
2	1155268-4	Acceleration jet 55	





SPARE PARTS for
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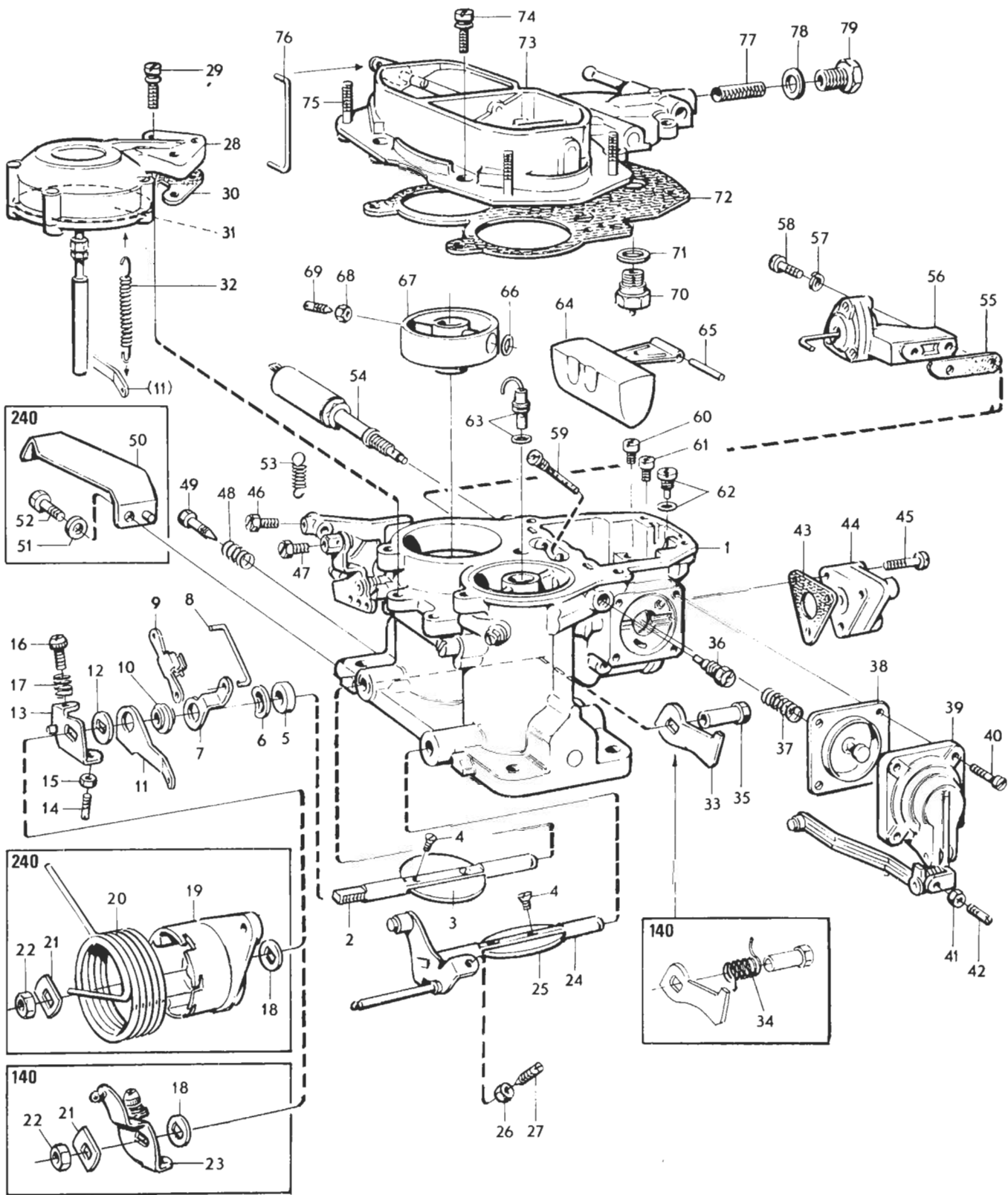
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Pos	Qty	Part No	Description	Specification
		552554-8	Carburetor, complete	SOLEX 40 EIES designed for B20 engines, Standard in GT-kit 552550. NOTE! QUANTITY PER CARBURETOR
1	1		x Carburetor house	Not available as spare part
2	1	1155257-7	x Throttle spindle	
3	1	1155259-3	x Butterfly	
4	4	1155261-9	x Screw for butterfly	
5	1	1155150-4	x Washer for blow-by	
6	1	1155213-0	x Washer	
7	1	1155165-2	x Lever for throttle spindle	
8	1	1155174-4	x Pull rod for high-speed idle running	
9	1	1155225-4	x Securing plate	
10	1	1155217-1	x Spacing sleeve	
11	1	1155166-0	x Lever, middle, for throttle spindle	
12	1	1155207-2	x Washer	
13	1	1155170-2	x Lever	
14	1	1155184-3	x Screw for lever	
15	1	1155197-5	x Nut for lever	
16	1	1155188-4	x Screw for lever	
17	1	1155006-8	x Spring for lever	
18	1	1155211-4	x Washer for lever	
19	1	1155233-8	x Pulley	For 240 only
20	1	1155234-6	x Return spring	For 240 only
21	1	1155083-7	x Washer	
22	1	1155195-9	x Nut for throttle spindle	
23	1	1155256-9	x Lever	For 140 only
24	1	1155258-5	x Throttle spindle	
25	1	1155259-3	x Butterfly	
26	1	1155196-7	x Nut	
27	1	1155180-1	x Screw for lever (on throttle spindle)	
28	1	1155145-4	x Vacuum valve for 2nd stage	
29	3	1155186-8	x Screw	
30	1	1155158-7	x Washer	





SPARE PARTS for
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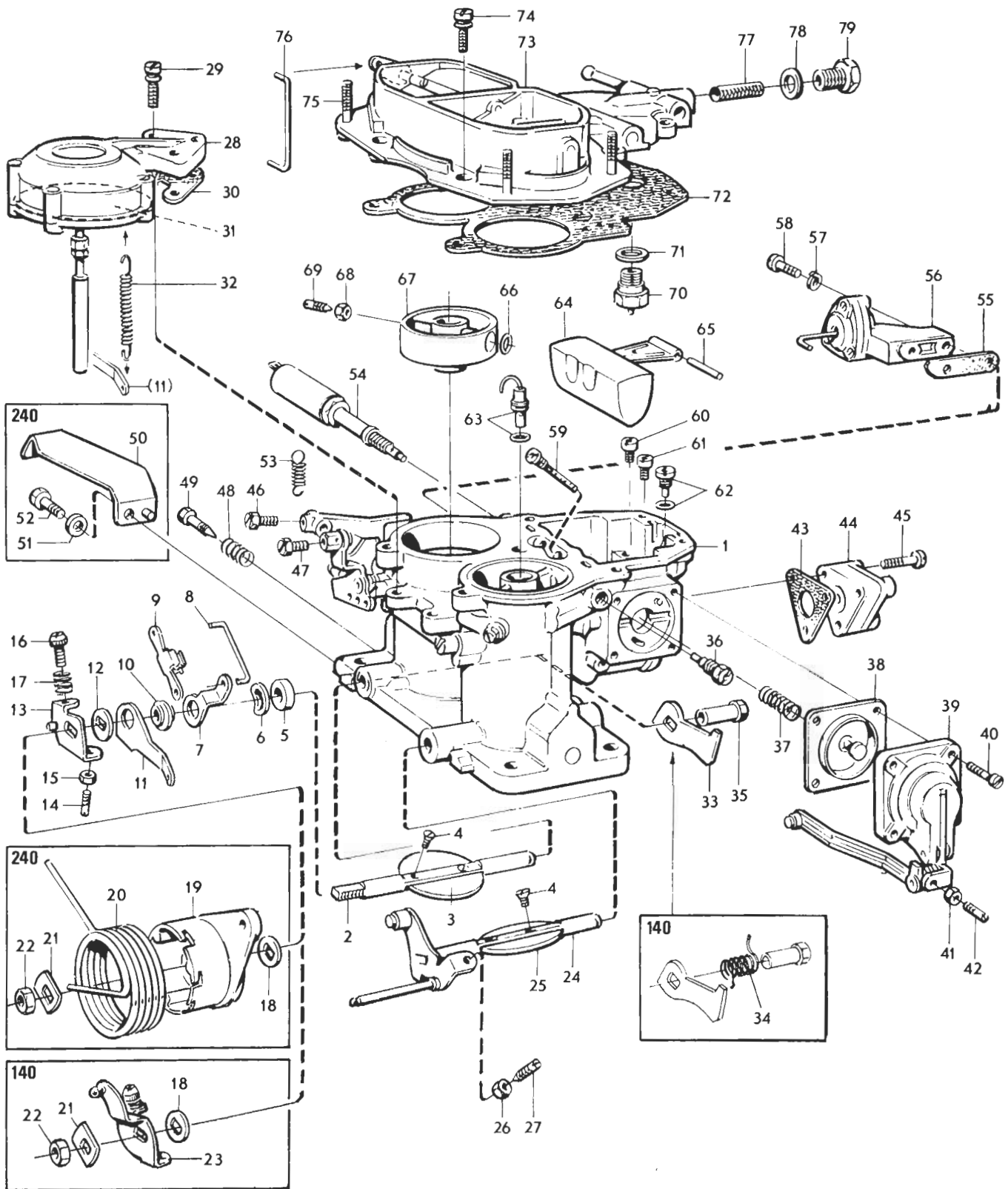
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Pos	Qty	Part No	Description	Specification
31	1	1155264-3	x Diaphragm	
32	1	1155205-6	x Spring	
33	1	1155169-4	x Lifter for accelerator pump	
34	1	1155204-9	x Return spring	For 140 only
35	1	1155196-7	x Nut	
36	1	1155128-0	x Part Load jet 2nd stage	
37	1	1155201-5	x Return spring for accelerator pump	
38	1	1155164-5	x Diaphragm for accelerator pump	
39	1	1155148-8	x Accelerator pump cover, compl	
40	4	1155185-0	x Screw	
41	1	1155197-5	x Nut	
42	1	1155184-3	x Screw	
43	1	1155163-7	x Gasket for enrichening valve	
44	1	1155144-7	x Enrichening valve, compl	
45	3	1155232-0	x Screw	
46	1	1155263-5	x Screw	
47	1	1155064-7	x Screw	
48	1	1155006-8	x Locking spring	
49	1	1155183-5	x Adjusting screw for idling	
50	1	1155227-0	x Bracket for control wire	For 240 only
51	1	1155210-6	x Washer	For 240 only
52	1	1155178-5	x Screw	For 240 only
53	1	1155203-1	x Return spring for choke throttle	
54	1	1155231-2	x Idling jet with valve	
55	1	1155157-9	x Gasket for choke adjusting valve	
56	1	1155147-0	x Choke adjusting valve	
57	2	1155209-8	x Washer	
58	2	1155181-9	x Screw	
59	2	1155230-4	x Emulsion tube with air jet	
60	1	1155122-3	x Main jet 2nd stage	
61	1	1155104-1	x Main jet 1st stage	
62	1	1155087-8	x Valve, complete, for acceleration jet	





SPARE PARTS for
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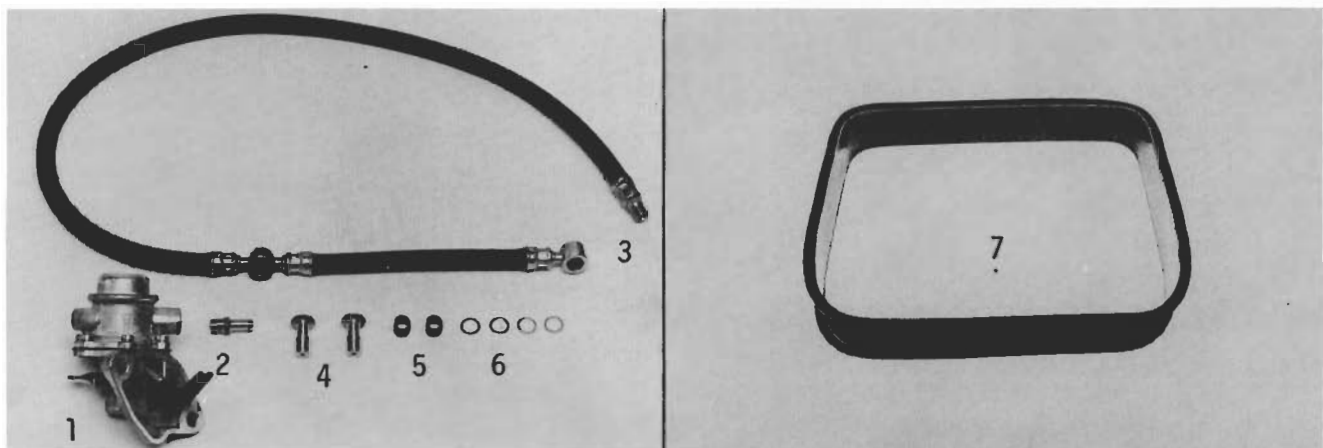
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Pos	Qty	Part No	Description	Specification
63	1	1155135-5	x Acceleration jet incl seal ring	
64	1	1155137-1	x Float	
65	1	1155224-7	x Float toggle spindle	
66	2	1155161-1	x Seal ring	
67	2	1155140-5	x Diffusor	
68	2	1155036-5	x Nut	
69	2	1155177-7	x Screw	
70	1	1155049-8	x Needle valve	
71	1	1155047-2	x Gasket	
72	1	1155159-5	x Gasket for carburetor cover	
73	1	1155142-1	x Carburetor cover, compl	
74	6	1155186-8	x Screw	
75	4	1155265-0	x Stud	
76	1	1155175-1	x Pull rod for choke throttle	
77	1	1155218-9	x Strainer	
78	1	1155047-2	x Gasket	
79	1	1155222-1	x Plug for fuel filter	



FUEL SYSTEM

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Pos	Qty	Part No	Description	Specification
1	1	831092-2	Fuel pump	Production pump from Penta
	1	552004-4	Electrical fuel pump	Capacity 125 litres/hour, pressure 0.28 kp/cm ² . On rallycross and racing cars we recommend that two pumps are connected in parallel. Eliminates the risk of "vapor lock" in high temperatures.
2	1	946600-4	Nipple for fuel pump	
3	1	825856-8	Fuel hose	
4	2	825857-6	Banjo screw for fuel hose	
5	2	825858-4	Strainer for fuel hose	
6	4	957173-8	Gasket for banjo screw for fuel hose	
7	1	552221-4	Spacer frame for tank	Reduces the risk of destroying the tank when driving on rough roads.



EXHAUST SYSTEM

FLAP

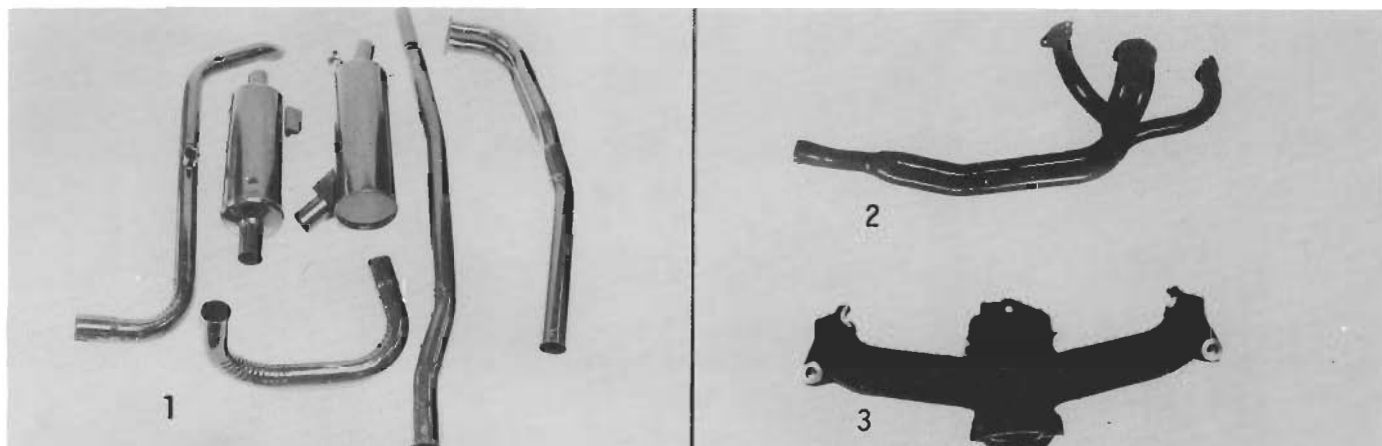
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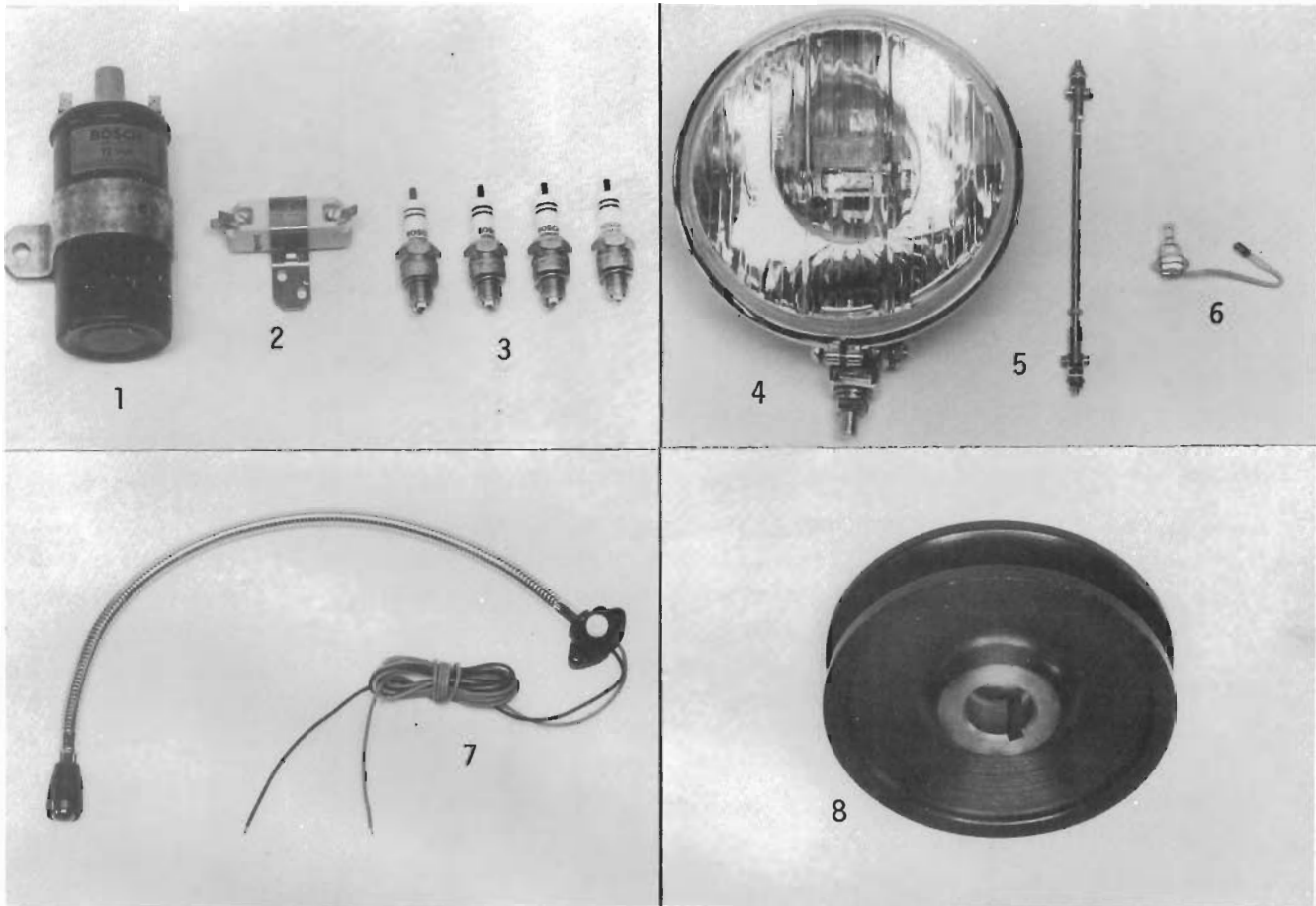
VOLVO RALLY EXHAUST KITS are designed to give the least possible loss of power.

With a VOLVO RALLY EXHAUST KIT the engine breathes better. These kits offer an increase in power of 5 to 9 hp DIN, depending on car model, and are designed for normal as well as competition driving.

The VOLVO RALLY EXHAUST KITS are as easy to fit as production exhaust kits - mounting details are included.

Pos	Qty	Part No	Description	Specification
1	1	552298-2	Rally exhaust kit, compl. Up to 1973 models	
	1	552287-3	x Front pipe, front part	
	1	552288-3	x Front pipe, rear part	
	1	552282-6	x Front silencer	
	1	552283-4	x Intermediary pipe	
	1	552284-2	x Rear silencer	
	1	552285-9	x Exhaust pipe	
	1	552317-0	x Mounting kit	
1	1	552289-1	Rally exhaust kit, compl. 1974 model	
	1	552287-5	x Front pipe, front part	
	1	552288-3	x Front pipe, rear part	
	1	552282-6	x Front silencer	
	1	552291-7	x Intermediary pipe	
	1	552292-5	x Rear silencer	
	1	552293-3	x Exhaust pipe	
	1	552294-1	x Mounting kit	
2	1	419381-9	Exhaust manifold	Tuned sheet steel manifold for optimum torque in the low and medium RPM range. 2 inch end diameter.
3	1	460894-9	Cast exhaust manifold	Gives higher output than 419381. 2 inch end diameter

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Pos	Qty	Part No	Description	Specification
1	1	826490-5	Ignition coil	
2	1	241612-1	Resistor	
3	1	273528-0	Spark plug Bosch W4B2 (W240T35) 1)	For "Special I" engines
3	1	273536-3	Spark plug Bosch W5A (W225T9) 1)	For B20 GT-kit and tuned B20 engines up to about 130 hp
3	1	552029-1	Spark plug Bosch W3AS (W280SIS) 1)	For "Special III" engines
3	4	552498-8	Spark plug Bosch W3A (W275T1) 1)	For "Special III" engines
4	1	552028-3	Spotlight, Bosch 180 mm, without bulb	For Rally and normal driving
5	1	552031-7	Stay for spotlight 552028	Necessary for Rally driving and recommended for normal driving to avoid fluttering light
6	1	552030-9	Bulb 100 W	
7	1	283651-8	Map reading lamp	Necessary for Rally driving and recommended for normal driving
8	1	552884-9	Pulley for alternator	Diameter 86 mm

1) Old type number




GT INSTRUMENT PANEL PARTS

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These instrument panels are discontinued. The following spare parts are, however, still available.

Qty	Part No	Description
1	552701-5	Instrument panel, P140 km/h (model years '67-'70)
1	552721-3	Instrument panel, P140 km/h (model years '71-'72)
1	552703-1	Instrument panel, P140 miles p.h. (model years '67-'70)
1	552723-9	Instrument panel, P140 miles p.h. (model years '71-'72)
1	552702-3	Instrument panel, P164 km/h (model years '67-'70)
1	552722-1	Instrument panel, P164 km/h (model years '71-'72)
1	552704-9	Instrument panel, P164 miles p.h. (model years '67-'70)
1	552724-7	Instrument panel, P164 miles p.h. (model years '71-'72)

552701-5	552702-3	552703-1	552704-9	552721-3	552722-1	552723-9	552724-7	Part No	Description
1		1		1		1		552705-6	Revolution counter, P140
	1		1		1		1	552706-4	Revolution counter, P164
1	1	1	1	1	1	1	1	552711-4	Rheostat for instrument lights
		1	1			1	1	552715-5	Speedometer, miles p.h.
1	1	1	1					552712-2	Tank level unit ('67-'70)
				1	1	1	1	552716-3	Tank level unit ('71-'72)
1	1	1	1	1	1	1	1	16218-0	Angle coupling for oil pressure gauge

	TRANSMISSION	EXPORT	810701	
		FLAP	SECTION	PAGE
		140	D	1

Production gearboxes often have relatively long steps between the different speeds. This is not accepted in a tuned competition car since it frequently means that the engine does not work in the right RPM range.

For this reason the following parts which are needed to convert a needle-bearing as well as a non-needle bearing M40 gearbox to a close-ratio gearbox M40.

If the production gearbox to be converted is not of the needle-bearing type, the parts in both tables B and C have to be used.

To convert a M40 gearbox of needle-bearing type, only the parts in table C are needed.

Information on application and ratio for M40 is given in the table A below.

Table A: Close-ratio M40 gearbox of needle-bearing type for B20 (2.0-2.2 litres)

TYPE	PART NO	R A T I O				APPLICATION
		1st	2nd	3rd	4th	
M40		2.62:1	1.67:1	1.24:1	1:1	Rally and Track Racing with Special I and Special II engines
Compared with normal ratios						
up to incl '72		3.13:1	1.99:1	1.36:1	1:1	
from '73		3.41:1	1.99:1	1.36:1	1:1	



GEARBOX PARTS M40

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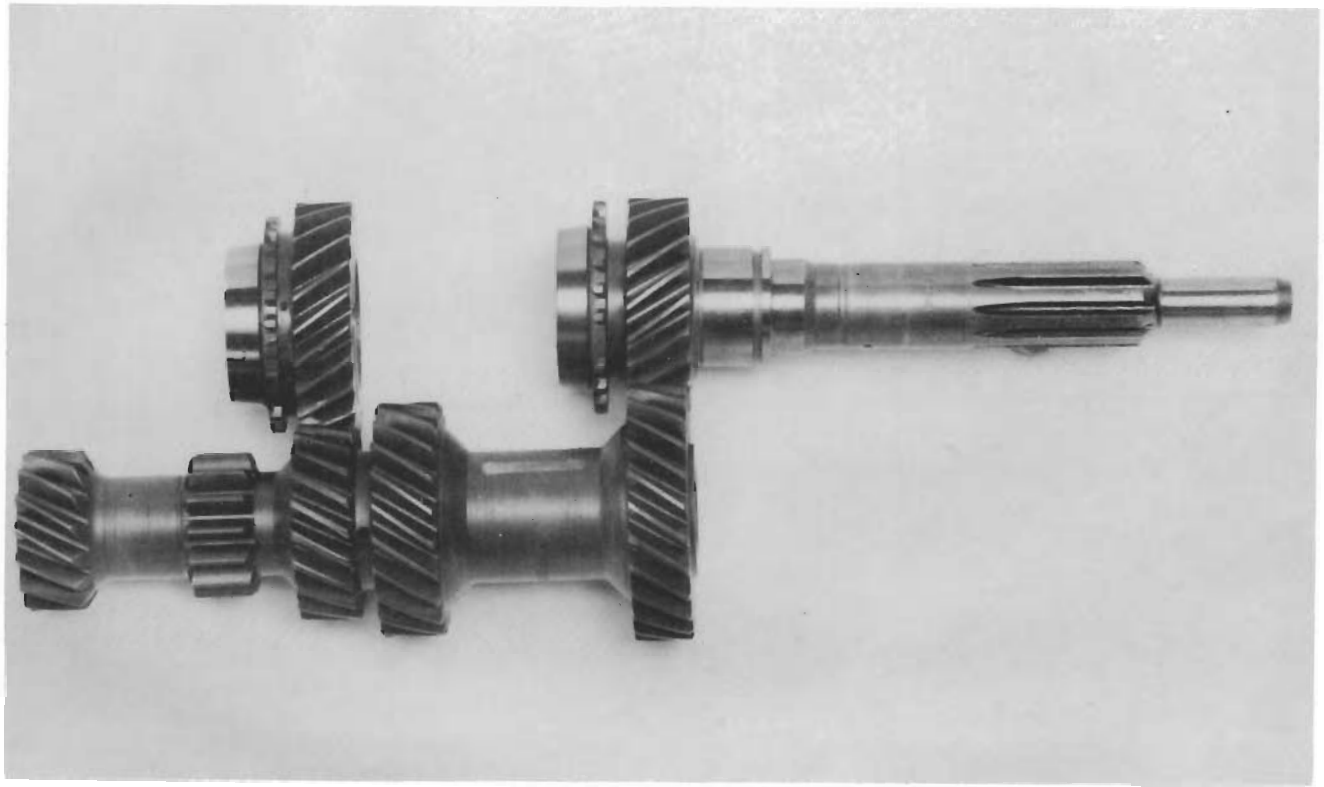



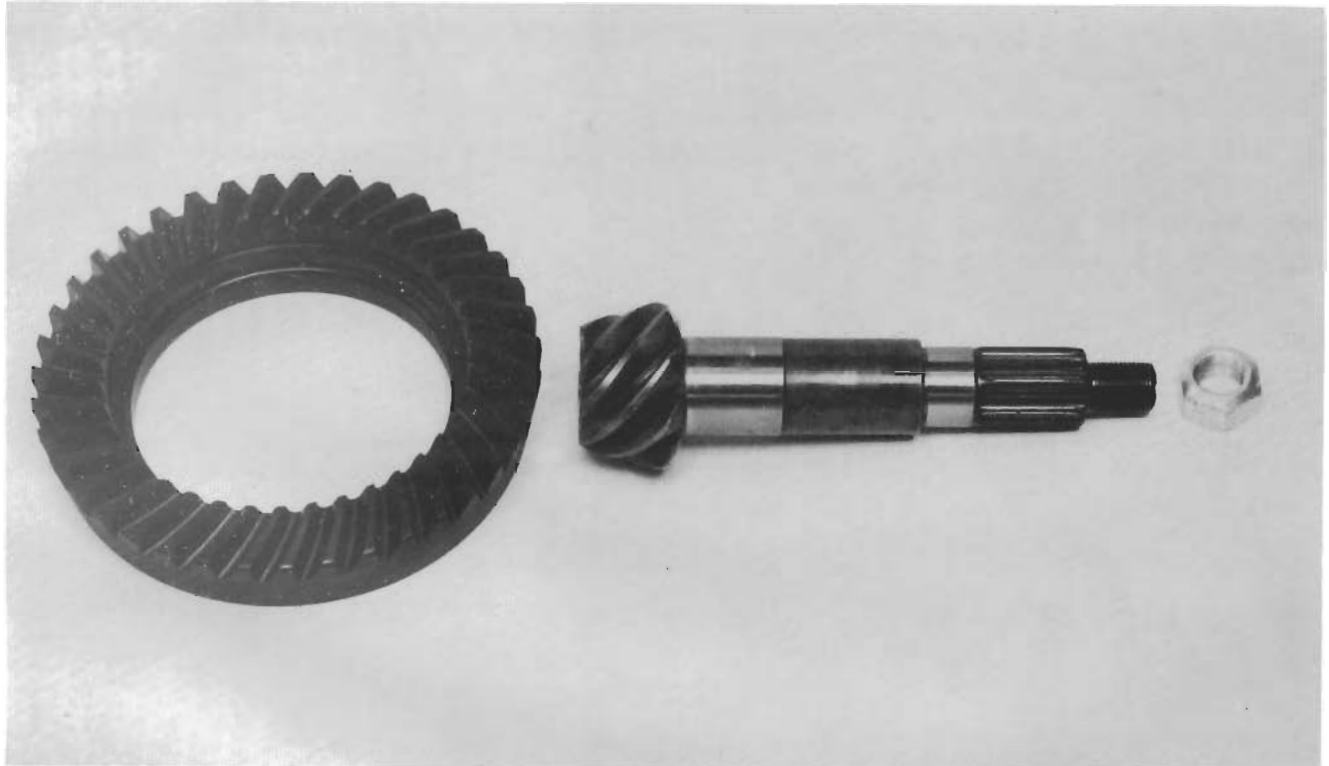
Table B: To convert a non-needle-bearing M40 gearbox to a needle-bearing type

Qty	Part No	Description	Note
1	380217-0	1st speed gear	Production part
1	380218-8	2nd speed gear	Production part
2	181330-2	Needle bearing	Production part
1	181331-0	Needle bearing	Production part

Table C: To convert a needle-bearing type M40 gearbox to a close-ratio gearbox

TYPE	PART NO			
	GEAR CLUSTER	1st speed gear	3rd speed gear	INPUT SHAFT
M40 model years 67-70	380422-6		380423-4	380382-2
M40 model years 71-72	380824-3		380423-4	380382-2
M40 model years 73-	380824-3	380217-0	380423-4	380382-2

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FINAL GEARS		140	D	3



Rear axle ratios


To get the maximum power delivered at the wheel and thereby the best possible acceleration, the production rear axle ratio must be numerically raised in relation to the production ratio. This also means, however, that the top speed of the car is reduced at a given maximum motor speed, which has to be taken into consideration. Our general recommendation is:

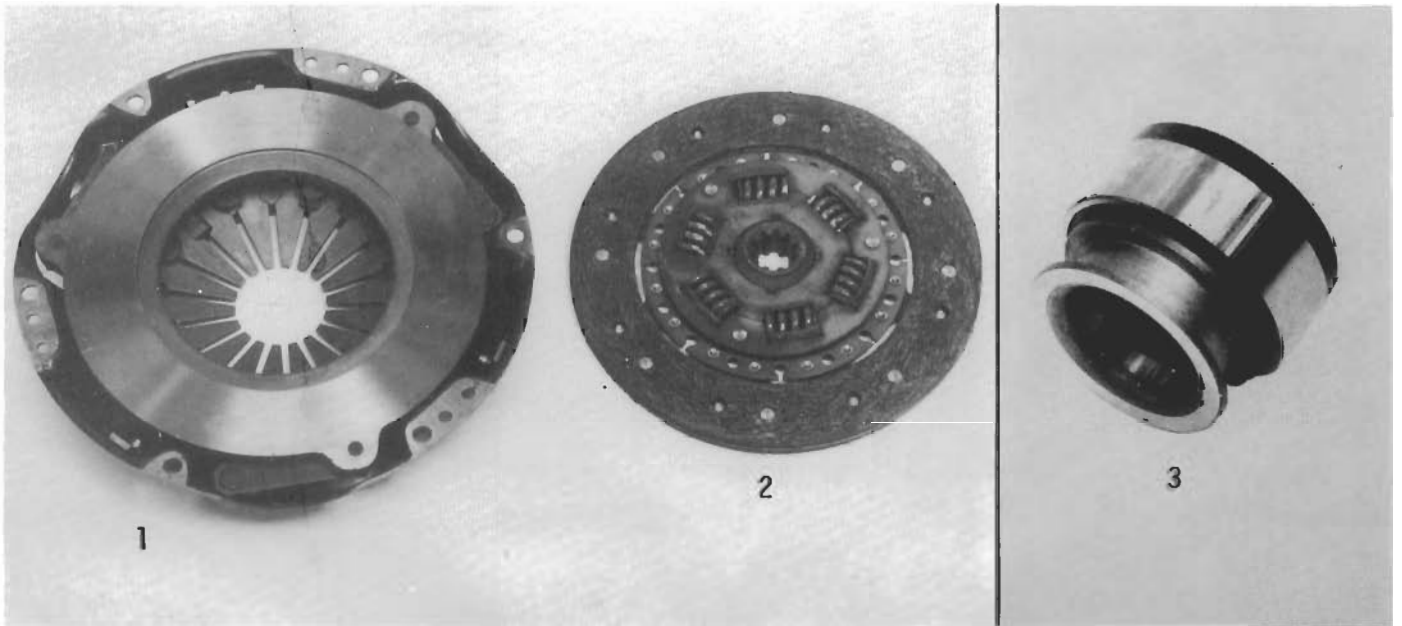
Rally: Either final gear 5.38:1 or 4.88:1 for standard as well as special class. As a rule 5.38:1 is the most suitable.

Rallycross: 5.38:1 or 4.88:1, depending mainly on the engine displacement and the wheel dimension. A 2 litres engine and 15" tyres require 5.38:1. With a 2.4 litres engine with 13" or 15" tyres the best ratio is 4.88:1.

Track Racing: Since the character of the tracks varies more than in Rally and Rallycross, the top speed on the straights will decide. Normally 4.88:1 and 4.56:1 are the most suitable.

Pos	Qty	Part No	Description	Specification
	1	552144-8	Final gear 5.38:1, M30	21.8 km/h at 1.000 RPM. Application: Rally and Rallycross.
1	1	552880-1	Final gear 4.88:1, M30	24.0 km/h at 1.000 RPM. Application: Very fast Rallies and Track racing.
	1	380789-8	Gear, large, for output shaft	Reduction gear to give correct speedometer indication with rear axle ratio 4.88:1. Suits close-ratio gearbox M40.
	1	380305-3	Gear, small (plastic)	

	CLUTCH, DISC and WITHDRAWAL BEARING	EXPORT	810701	
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Pos	Qty	Part No	Description	Specification
		418930-4	Clutch "Laplander"	Clamping force 4660-5400 N (475-550 kp). Disc part no 418871. Withdrawal bearing part no 380569. Application: Engines up to about 125 kW (170 hp) and a maximum torque of about 206 Nm (21 kpm). Can be used in Rally cars, even if the safety margin then is small.
1	1	552145-5	Clutch "RAC"	Clamping force 7100-7750 N (725-790 kp). Disc part no 552146. Withdrawal bearing part no 672122. Application: "Special III" engines. Suitable for Rally, Rallycross and Drag-racing. Up to a torque of about 255 Nm (26 kpm). Plate for withdrawal bearing is to be dismantled.
		418871-0	Disc	To be used together with clutch 418930.
2	1	552146-3	Disc	To be used together with clutch 552145.
3	1	380569-4	Withdrawal bearing	To be used with clutch 418930.
		672122-9	Withdrawal bearing	Should be used with clutch 552145.



LIMITED SLIP DIFFERENTIAL


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By installing a limited slip differential you increase the power transferred to the wheel with the highest friction, and thereby the acceleration, in a situation where the two driving wheels have different friction. Consequently in all competition driving - where the rules permit - a limited slip differential should be used.

Presently it is homologated for the following models: 142S B20, 142 GL. See homologation papers for each model.

Pos	Qty	Part No	Description	Specification
1	1	384727-4	Limited slip differential M30	From year model 1970
	2	384509-6	Spacer sleeve	Necessary together with 384727 for models 1967-1969
	1	942654-5	Tubular pin	

	SUSPENSION	EXPORT	810701	
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In a production car the suspension is a compromise between several demands where the driver's and the passengers' comfort has a high priority. As our roads get more even and straight, and the customer's preference for a soft and silent ride increases, the need to modify the car for competition driving increases. Comfort has to be sacrificed for demands such as optimum road holding ability.

The shock absorber setting will have to be drastically changed - the relatively soft production shock absorbers are replaced by gas-pressure shock absorbers that keep the wheels on the road, no matter how bumpy it is, without fading. Much harder springs also have to be used.

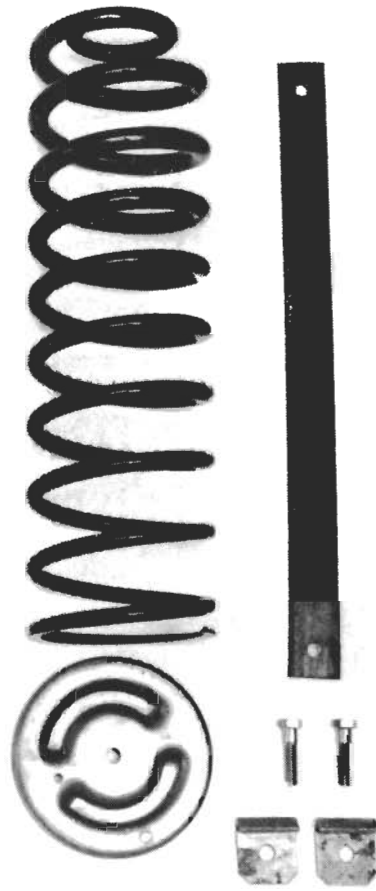
Between these two categories - the competition driver and the non-competition driver - there is a group of drivers who do not want to enter competitions but still want a car that can take tougher driving than the production car. As you will see, suspension parts are available for both the competition driver and the demanding non-competition driver.



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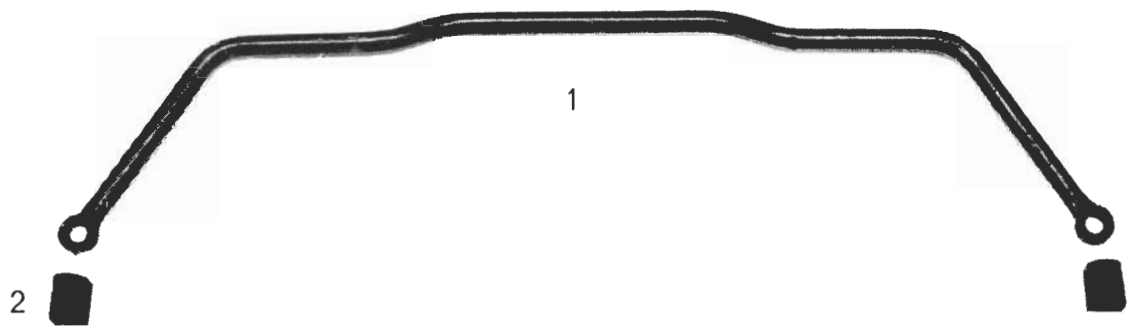
	SPRINGS	EXPORT	810701	
		FLAP	SECTION	PAGE
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Information on application for springs mentioned here is given in the table below.

Pos	Qty	Part No	Description	Specification
1	2	552105-9	Front spring, progressive rate	Length 0.29 m (0.30). 15 % stiffer than production spring.
2	2	552106-7	Front spring, progressive rate	Car, provided with this spring, is to be equipped as per the table below, for approval by SBP. Length 0.33 m (0.30) 25 % stiffer than production spring.
3	2	552137-2	Rear spring kit	Also suitable for 164
	1	552136-4	x Rear spring, progressive rate	Length 0.45 m (0.42)
	1	552151-3	x Lower spring holder	
	1	660108-2	x Limiting strap	
	2	552152-1	x Attachment for strap 660108	
	2	940162-1	x Bolt	
	2	679655-1	Rubber for rear spring ('67-'70)	Also suitable for 164 '70
4	2	552134-9	Front spring, non-progressive, Rally	Length 0.25 m (0.30). 70 % stiffer than production spring.
5	2	552128-1	Rear spring, non-progressive, Rally	Length 0.38 m (0.42). 10 % stiffer than production spring.

SPRINGS - APPLICATION

PART NO		EXECUTION	APPLICATION
FRONT	REAR		
552105	552137	progressive rate	Normal driving and Rally on good roads. Ride height same as with production springs.
		progressive rate	
552106	552137	progressive rate	Rally driving on very bad roads. Ride height increases.
		progressive rate	
552134	552128	linear	Normal driving, Rallycross and Rally driving - better road holding ability due to lower ride height.
		linear	





STABILIZERS and
SHOCK ABSORBERS

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E

3

Pos	Qty	Part No	Description	Specification
1	1	552172-9	Stabilizer, front, diameter 20 mm	Designed for normal driving and Rally. Offers a much increased stability.
2	2	552173-7	Rubber bushing for stabi- lizer 552172	
	1	552185-1	Shock absorber kit "Rally"	Gas pressure shock absorbers, designed mainly for Rally use. Also suitable for 164.
	2	552189-3	x Shock absorber, front, de Carbon, "Rally"	
	2	552190-1	x Shock absorber, rear, de Carbon, "Rally"	
3	1	552186-9	Shock absorber kit "Sport"	Gas pressure shock absorbers, designed for normal driving as well as for Rally use. Softer setting than the above. Also suitable for 164.
	2	552191-9	x Shock absorber, front, de Carbon, "Sport"	
	2	552192-7	x Shock absorber, rear, de Carbon, "Sport"	
4	1	552179-4	Road Holding Kit 140	Designed for driving where an in- creased stability is required with- out sacrificing comfort.
	1	552172-9	x Stabilizer, front, diameter 20 mm	
	2	552173-7	x Rubber bushing for 552172	
	1	552186-9	x Shock absorber kit "Sport"	



REINFORCED SUSPENSION PARTS

FLAP

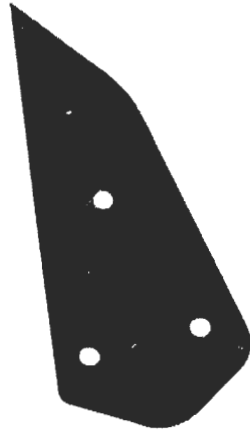
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1



2

Pos	Qty	Part No	Description	Specification
1	2	552142-2	Reinforcement plate for support arm	Reinforced
2	2	552140-6	Extra hard bushing for rear support arms	Should be used in connection with firmer shock absorbers

	MISCELLANEOUS EQUIPMENT	EXPORT	810701	
		FLAP	SECTION	PAGE
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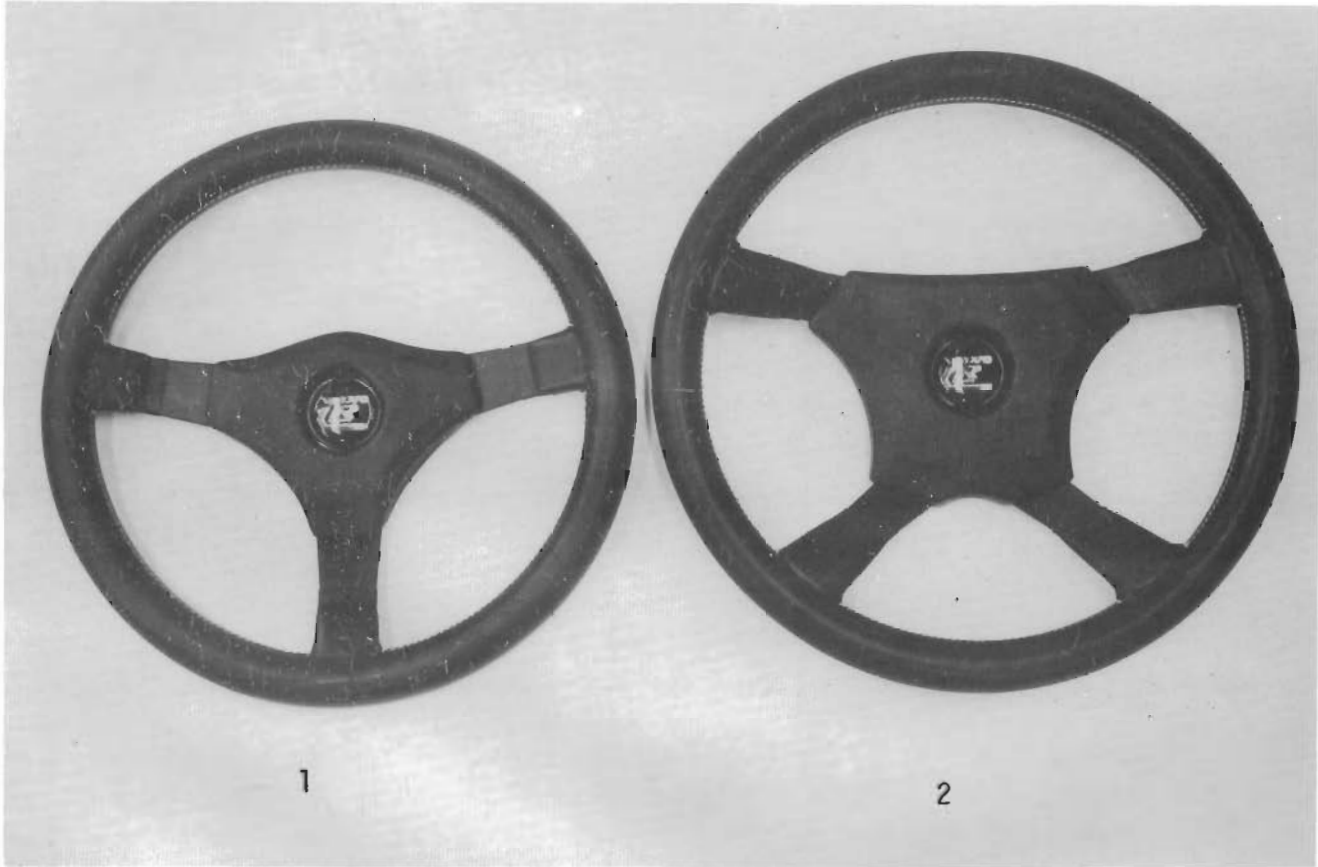


Pos	Qty	Part No	Description	Specification
1	1	552166-1	Front spoiler	Improves the car's stability and reduces fuel consumption. Suitable also for 164 1973. For 140 1974 and 164 1974-75 spoiler with part no 552168 should be used.



SPORTS STEERING WHEEL

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Handmade sports steering wheels, covered with genuine leather of the best possible quality. The steering wheel hubs are collapsible for added safety.


The steering wheels meet with all safety regulations in Europe, inclusive of TSV's and Svensk Bilprovning's.

Pos	Qty	Part No	Description	Specification
1	1	552033-3	Three spoke sports steering wheel, compl	Up to and inclusive of 1972 models. Diameter 350 mm. Rim thickness 29 mm.
1	1	552034-1	Three spoke sports steering wheel, compl	From 1973 year model. Diameter 350 mm. Rim thickness 29 mm,
2	1	552035-8	Four spoke sports steering wheel, compl	From 1973 year model. Diameter 380 mm. Rim thickness 29 mm.
	1	552343-6	Hub padding	Three spoke steering wheels
	1	552349-3	Hub padding	Four spoke steering wheels
	1	552342-8	Horn button	All steering wheels



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B	Fuel and exhaust systems
C	Electrical equipment and instruments
D	Power train
E	Suspension and brakes
F	Body and safety
G	Miscellaneous equipment

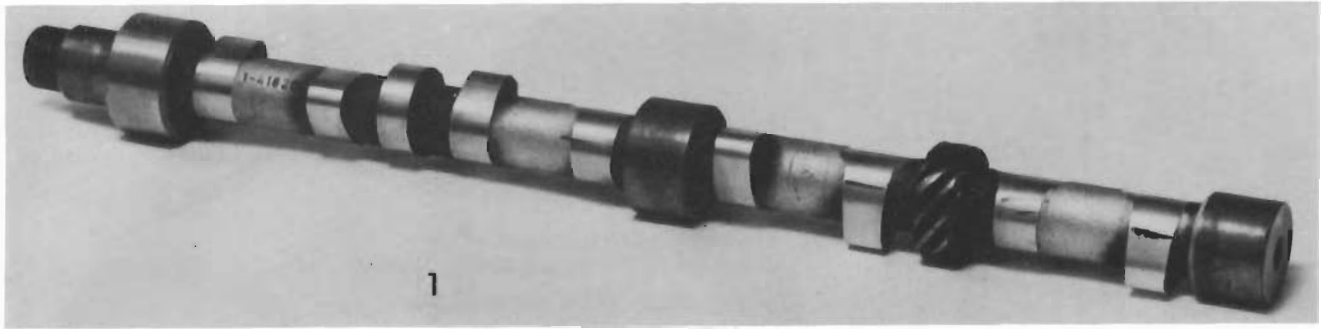
	GT - KIT B20	EXPORT	810701	
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GT-kit B20 for model year 1975 (552550) is discontinued.

Spare parts are available until further notice.

For information on parts included in the kit, please see 140, section A, pages 12-14.

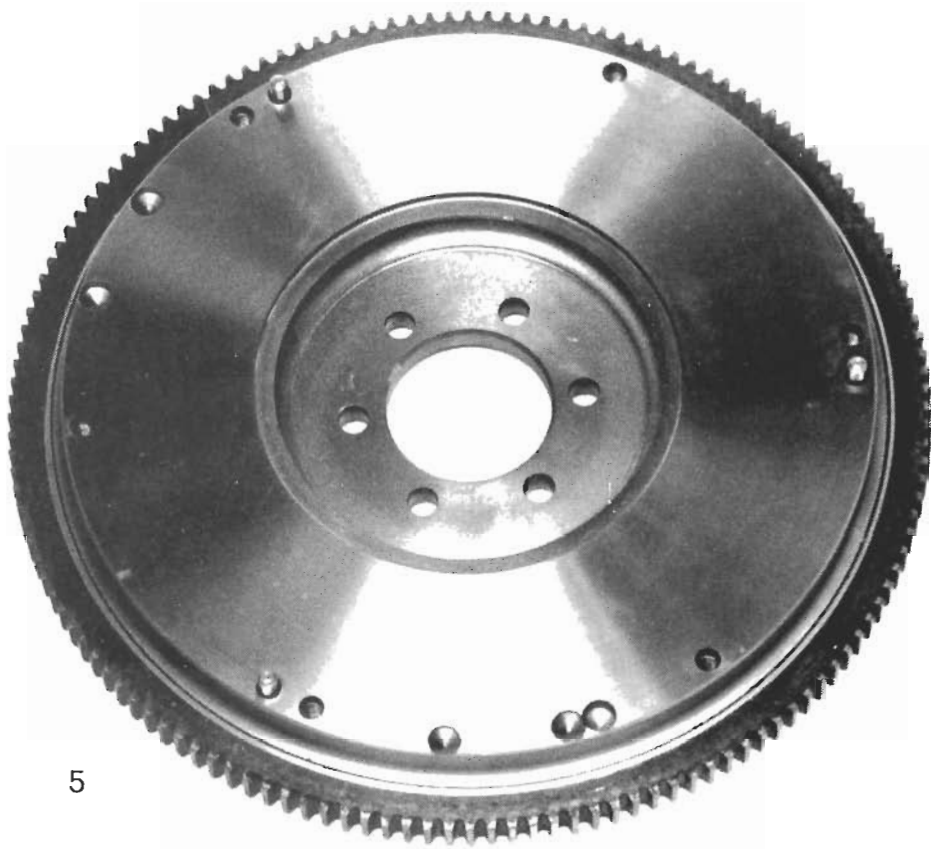
	CAMSHAFT B20	EXPORT	810701	
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Pos	Qty	Part No	Description	Specification
1	1	552422-8	Camshaft "K"	Standard camshaft in GT-kit B20. Suitable for single or twin carburetor engines with moderately increased output. Gives better low-end torque than production camshaft for injection engines.

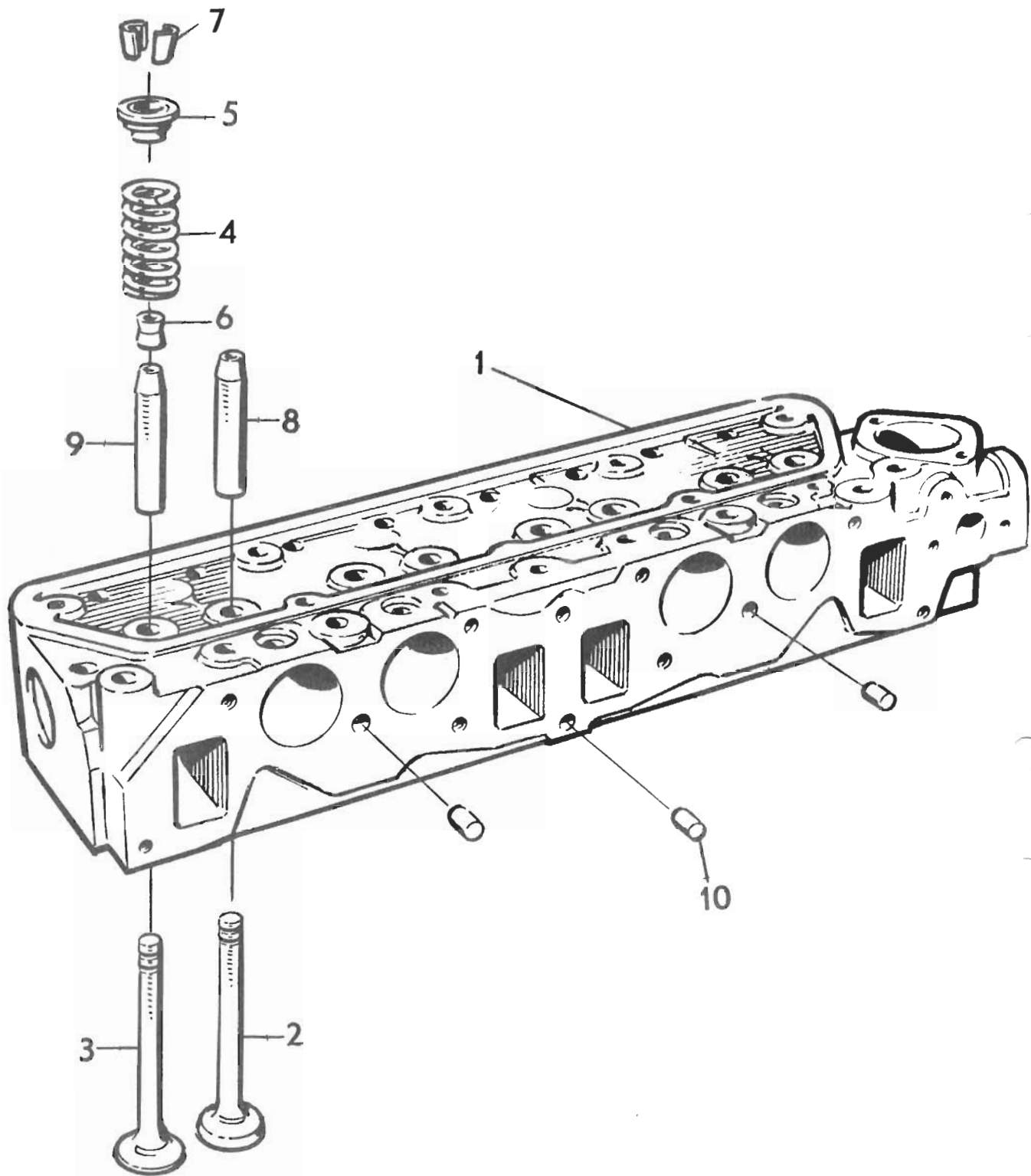
VALVE TIMING

Type	Valve lift	Inlet opens before TDC	Inlet closes after BDC	Exhaust opens before BDC	Exhaust closes after TDC	Tappet play Inl/Exh	Duration
K	10.8 mm	27°	70°	70°	27°	0.40/0.45 mm	277°



	PISTON, PISTON RING KIT, PISTON PINS, FLYWHEEL and OIL COOLERS	EXPORT	810701	
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Pos	Qty	Part No	Description	Specification
1	4	552450-9	Piston compl, forged, 93 mm, 2.2 litres	Piston pin diam, 24 mm. Designed for B20 engines 1974-1976. Can also be used in re-bored B21 engines.
2	4	552435-0	x Piston ring kit for piston 552450	
3	4	552433-5	x Piston pin 24 mm for piston 552450	
4	4	552434-3	x Locking ring for piston pin 552433	
5	1	552833-6	Lightened flywheel, 8 bolts, weight 7.3 kilos	For B20 1974-1976.
6	1	418693-8	Timing gear cover	Including neoprene seal (B20)
	1	552847-6	Baffled oil sump	B20
	1	552909-4	13 vane oil cooler, complete with thermostat	Thermostat controlled to ensure correct oil temperature in all driving conditions. Suitable for B20, B19 - B23.
		552907-8	x Adapter with thermostat	
		552918-5	x O-ring	
	1	552919-3	19 vane oil cooler, complete with thermostat	Thermostat controlled to ensure correct oil temperature in all driving conditions. Suitable for B20, B19 - B23.
		552907-8	x Adapter with thermostat	
		552918-5	x O-ring	





CYLINDER HEAD PARTS B20

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Pos	Qty	Part No	Description	Specification
1	1		Cylinder head	
2	4	552816-1	x Valve, inlet	Modified, diam. 44 mm
3	4	552817-9	x Valve, exhaust	Modified, diam. 35 mm
4	8	418737-3	x Valve spring	Production, yellow marking
5	8	460181-1	x Valve spring washer	Production
6	8	419702-6	x Valve seal	Production
7	16	419643-2	x Valve lock	Production
8	4	552828-6	x Valve guide, inlet	Shortened, tapered
9	4	552818-7	x Valve guide, exhaust	Shortened
10	3	950586-8	x Guide pin	



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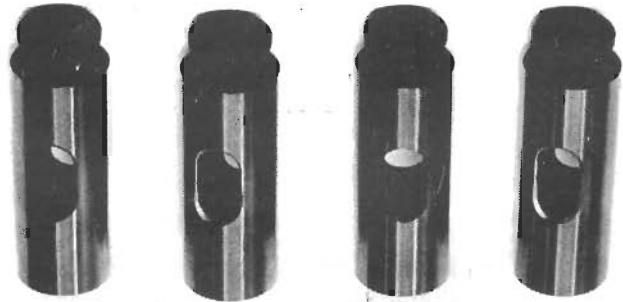


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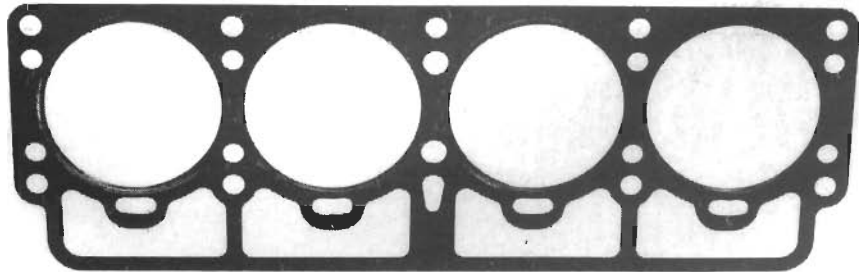
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VALVES, VALVE SPRINGS,
TAPPETS and CYLINDER HEAD
GASKETS

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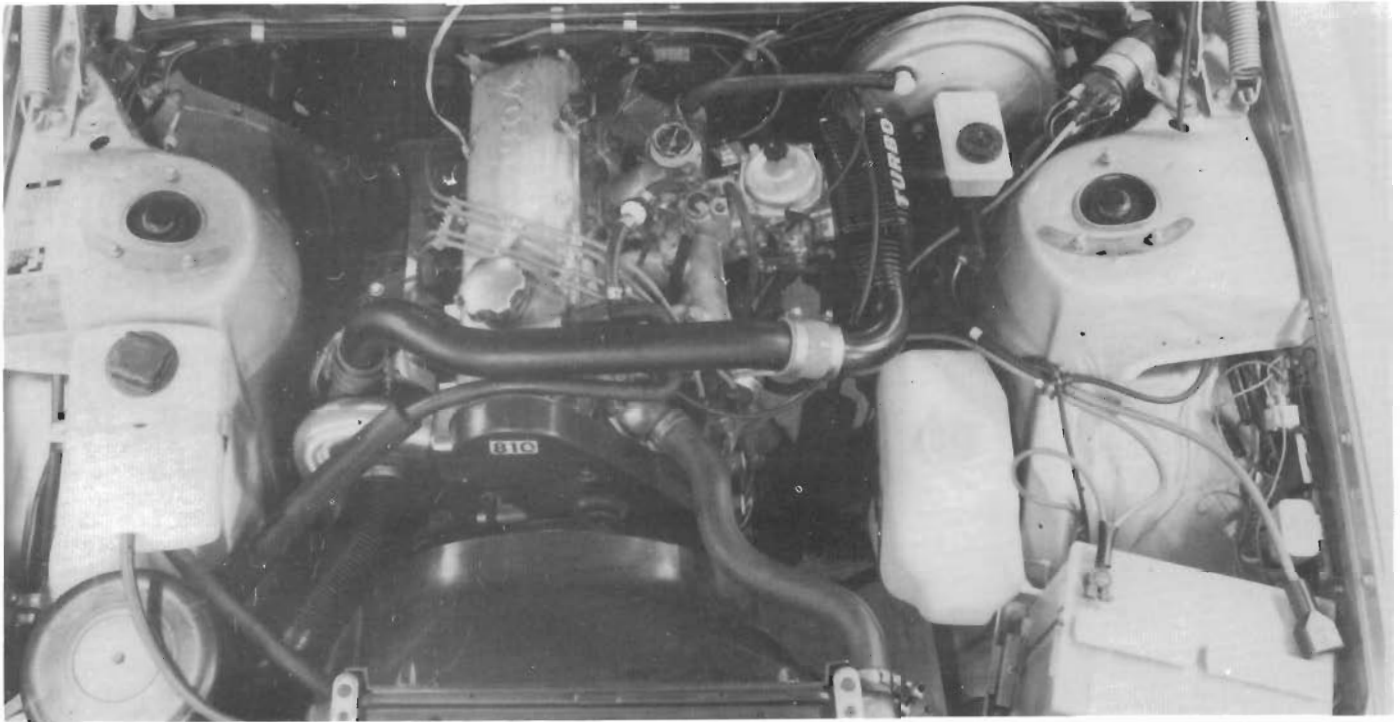
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Pos	Qty	Part No	Description	Specification
1	4	552816-1	Valve, inlet	44 mm, modified
2	4	552817-9	Valve, exhaust	35 mm, modified
3	4	552828-6	Valve guide, inlet	Shortened, tapered
4	4	552818-7	Valve guide, exhaust	Shortened
5	8	418737-3	Valve spring	Production spring. Yellow marking.
	8	460181-1	Valve spring washer	Production washer for valve spring 418737
	8	419702-6	Valve seal	Standard on all cylinder heads
	16	419643-2	Valve lock	Standard on all cylinder heads
6	8	552466-5	Valve tappet	Wizemann manufactured - Standard in GT-kit and Tuning kit "Special I" B20
	3	950586-8	Guide pin	
	1	552832-8	Shim kit for valve spring B20	Is used to adjust production valve spring (418737)
7	1	824855-1	Cylinder head gasket	Thickness 1.2 mm
	1	552836-9	Cylinder head gasket	Turbo gasket for pistons up to a diameter of 93.0 mm

	B19A/B21A TURBO KIT	EXPORT	810701	
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The turbo kit is certified with B19A and B21A engines according to ECE R15 01, 02, 03 and complies with European noise regulations.


It fits all 240-series cars with B19A or B21A engines with compression ratio 8.5:1 with the following exemptions:

- Cars with automatic gearbox
- Right hand steering cars
- 245 with elevated roof
- Cars with air conditioner
- Cars with parking heater - other than 03-B.





Depending upon each car's specification the basic turbo kit must be completed according to table below:

Specification	Crankcase vent. kit	Ign. coil	Tyres	Stabilizers	Washer	Choke-wire	Jet needle
Year model 1975-1978	8360031-2	1219230-8	HR-specificat.*	See table of Recommendat.			
Year model 1979-1980	"	-	"	"			
Year model 1981 -	8360032-0						
B19A engine							8360043-9
Cars with SU-carb.						1272658-4	
Cars with power steering and/or park.heater 03-B					1304149-6 1213943-2 1255568-6 1304205-6 1304204-9		

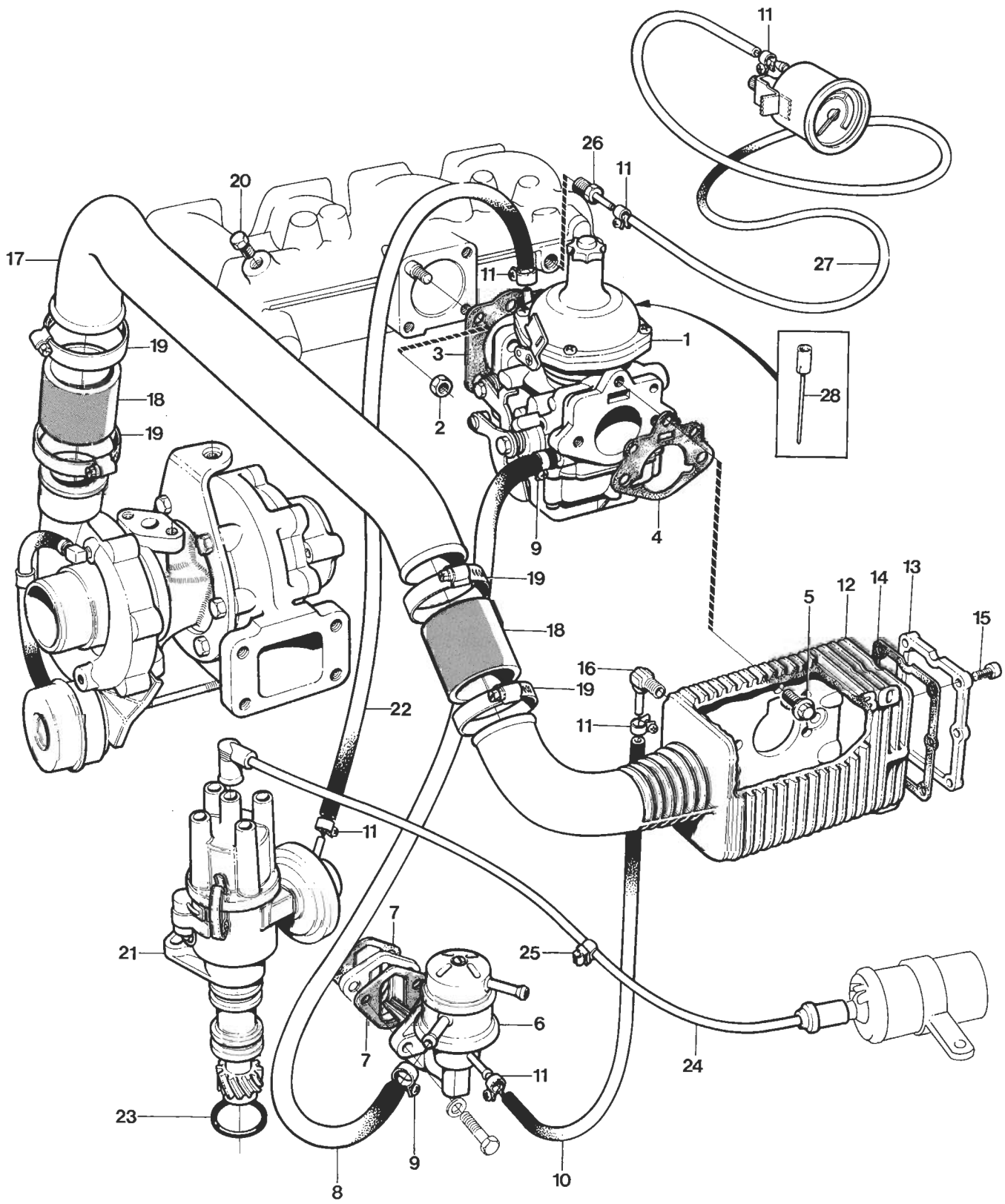
* Since top speed exceeds 180 km/h

	B19A/B21A TURBO KIT	EXPORT		810701
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Due to increased engine output we strongly recommend that the roadholding characteristics of the vehicle should be improved according to table:

SUITABLE SHOCK ABSORBER AND ANTI-SWAY BAR COMBINATIONS		This is especially important for model years 1975—1978.			
In order to match the increased engine output the road holding characteristics of the vehicle should be improved by changing shock absorbers and anti-sway bars as per table below.		Alt. 1: Volvo 240 1975—1978 - Optimal Alt. 2: Volvo 1975—1978 - Minimum Alt. 3: Volvo 1979—			
					
Shock absorber	1	1128793	1272192 ¹⁾	1128793	1206641 ¹⁾
	2	1128793	1272192 ¹⁾	1128793	1206641 ¹⁾
	3	1128793	1272192 ¹⁾	1128793	1206641 ¹⁾ (std)
Anti-sway bar	1	1228840	1229956	1228840	1229313
	2	—	1229313 ²⁾	—	—
	3	1228840	—	1228840	—
NOTE! The entire combination must be fitted. Otherwise road holding deteriorates.		2) Rear anti-sway bar must be replaced on model years 1975—1978 to provide installation space for the new exhaust system.			
1) Levelling system should not be used.					

B21A	Max. output DIN 103 kW/92 rps (140 hp/5500 rpm)
	Max. torque DIN 216 Nm/58 rps (22.0 kpm/3500 rpm)
B19A	Max. output DIN 99 kW/92 rps (135 hp/5500 rpm)
	Max. torque DIN 202 Nm/67 rps (20.6 kpm/4000 rpm)





B19A/B21A TURBO KIT

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Pos Qty Part No Description Specification

		8360000-7	B19/21 A Turbo, basic kit	
1	1	8360011-4	x Carburetor, compl	
2	4	955782-8	x Nut	
3	1	1269041-8	x Gasket	
4	1	680642-6	x Gasket	
5	3	966378-2	x Screw	
6	1	8360001-5	x Fuel pump	
7	2	463392-1	x Gasket	
8	1	1266500-6	x Fuel hose	
9	2	945651-8	x Hose clip	
10	1	948958-4	x Pressure hose	
11	6	947331-5	x Hose clip	
12	1	8360020-5	x Air inlet box	
13	1	8360021-3	x Cover	
14	1	8360025-4	x Gasket	
15	6	942001-9	x Screw	
16	1	949012-9	x Nipple	
17	1	8360010-6	x Air inlet pipe	
18	2	466327-4	x Connecting hose	
19	4	943478-8	x Hose clip	
20	1	191026-4	x Plug	
21	1	8360018-9	x Distributor	
22	1	948958-4	x Vacuum hose	
23	1	949659-7	x O-ring	
24	1	8360009-8	x Ignition cable	
25	1	947687-0	x Retainer	
26	1	948040-1	x Nipple	
27	1	192055-2	x Pressure hose	
28	1	8360043-9	Jet needle	

For B19 engines. Replaces needle in carburetor 8360011-4.
Not included in the basic kit.



B19A/B21A TURBO KIT

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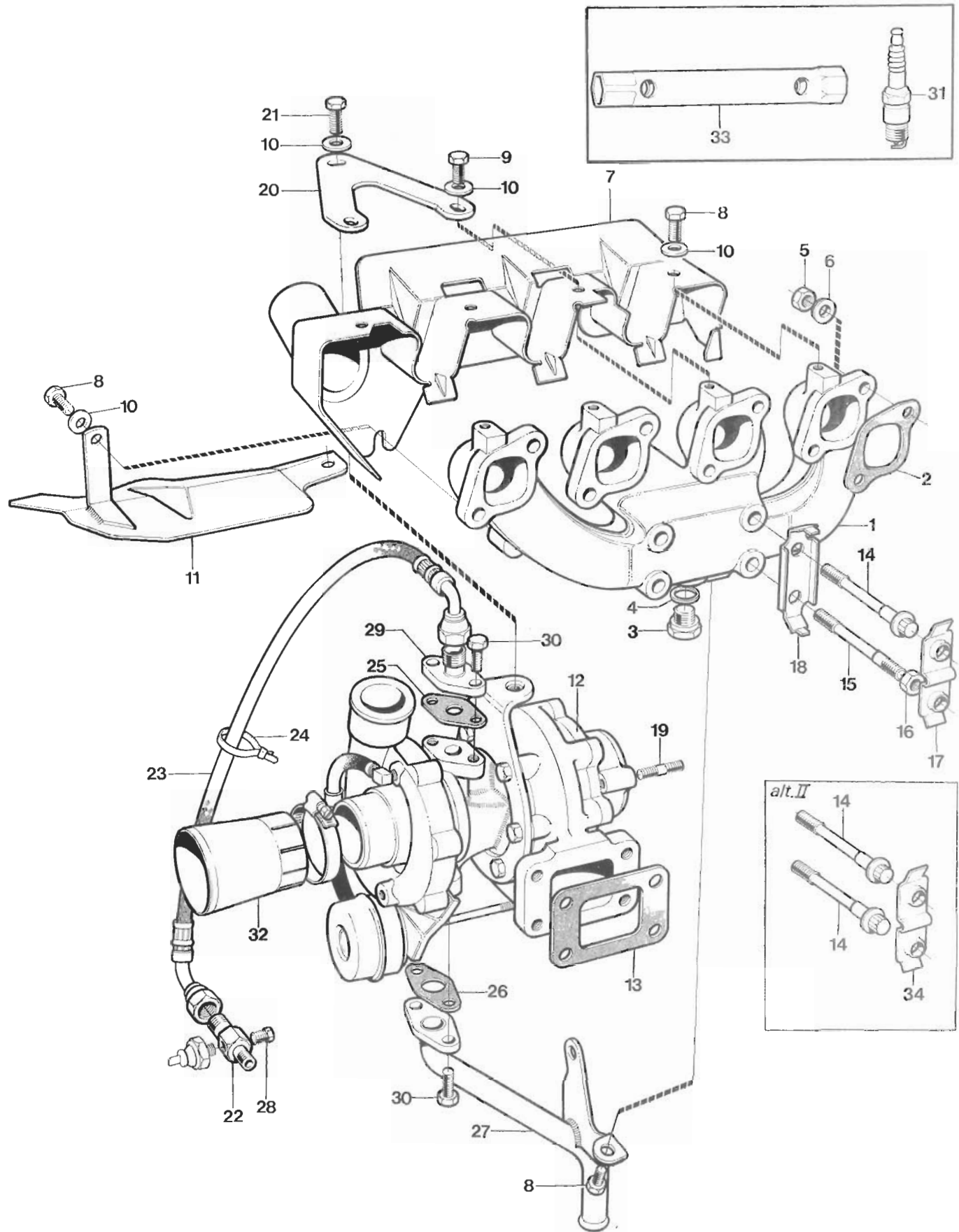
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Pos	Qty	Part No	Description	Specification
-----	-----	---------	-------------	---------------

		8360000-7	B19/21 A Turbo, basic kit	
1	1	8360011-4	x Carburetor, compl	
2	4	955782-8	x Nut	
3	1	1269041-8	x Gasket	
4	1	680642-6	x Gasket	
5	3	966378-2	x Screw	
6	1	8360001-5	x Fuel pump	
7	2	463392-1	x Gasket	
8	1	1266500-6	x Fuel hose	
9	2	945651-8	x Hose clip	
10	1	948958-4	x Pressure hose	
11	6	947331-5	x Hose clip	
12	1	8360020-5	x Air inlet box	
13	1	8360021-3	x Cover	
14	1	8360025-4	x Gasket	
15	6	942001-9	x Screw	
16	1	949012-9	x Nipple	
17	1	8360010-6	x Air inlet pipe	
18	2	466327-4	x Connecting hose	
19	4	943478-8	x Hose clip	
20	1	191026-4	x Plug	
21	1	8360018-9	x Distributor	
22	1	948958-4	x Vacuum hose	
23	1	949659-7	x O-ring	
24	1	8360009-8	x Ignition cable	
25	1	947687-0	x Retainer	
26	1	948040-1	x Nipple	
27	1	192055-2	x Pressure hose	
28	1	8360043-9	Jet needle	

For B19 engines. Replaces needle in carburetor 8360011-4.
Not included in the basic kit.

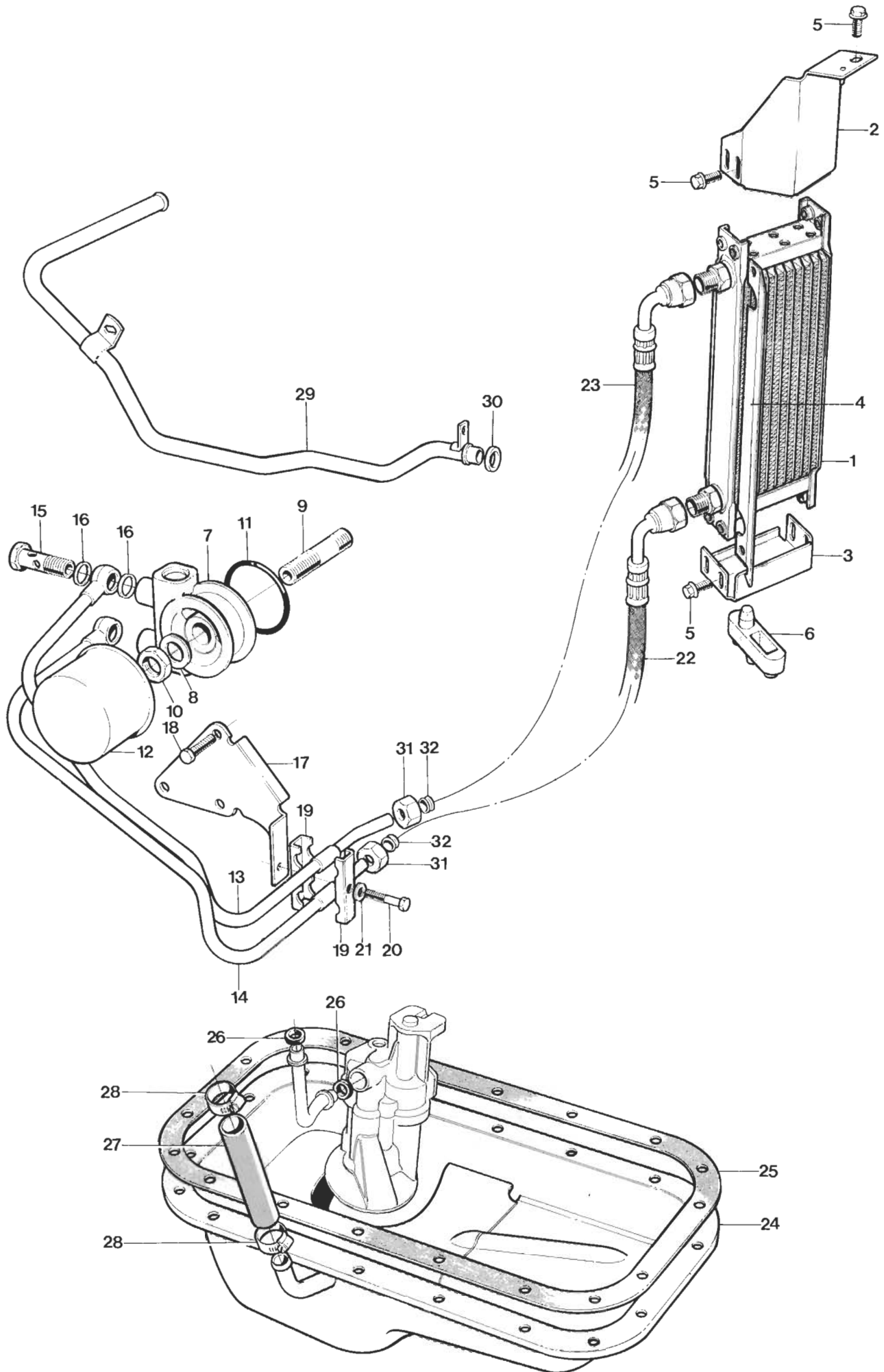




B19A/B21A TURBO KIT

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Pos	Qty	Part No	Description	Specification
1	1	1276998-0	x Exhaust manifold	
2	4	463846-6	x Gasket	
3	1	960632-8	x Plug	
4	1	947624-3	x Gasket	
5	8	946036-1	x Nut	
6	7	419401-5	x Washer	
7	1	1276832-1	x Air preheating plate	
8	4	963564-0	x Screw	
9	2	955294-4	x Screw	
10	5	960141-0	x Washer	
11	1	1306482-9	x Heat shield	
12	1	8360022-1	x Turbo unit	
13	1	1276689-5	x Gasket	
14	2	1317067-5	x Screw	
15	2	1326588-9	x Stud	
16	2	1326589-7	x Nut	
17	2	1326221-7	x Securing plate, upper	
18	2	1326222-5	x Securing plate, lower	
19	3	1306910-9	x Stud	
20	1	1306191-6	x Bracket	
21	1	946173-2	x Screw	
22	1	8360005-6	x Adapter	
23	1	8360008-0	x Oil hose	
24	1	948702-6	x Strip clamp	
25	1	420475-6	x Gasket, inlet	
26	1	420423-6	x Gasket, outlet	
27	1	8360030-4	x Draining pipe	
28	1	191026-4	x Plug	
29	1	8360006-4	x Flange	
30	4	955295-1	x Screw	
31	1	273591-8	x Spark plug kit (W5DC)	
31	1	273596-7	Spark plug kit (W6DC)	Alternative. Mainly for city driving.
32	1	8360028-8	x Connecting pipe	
33	1	210107-9	x Spark plug key	
			<u>Alternative II</u>	
14	4	1317067-5	Screw	Available from autumn 1981
34	2	1326586-3	Securing plate, upper	





B19A/B21A TURBO KIT

EXPORT

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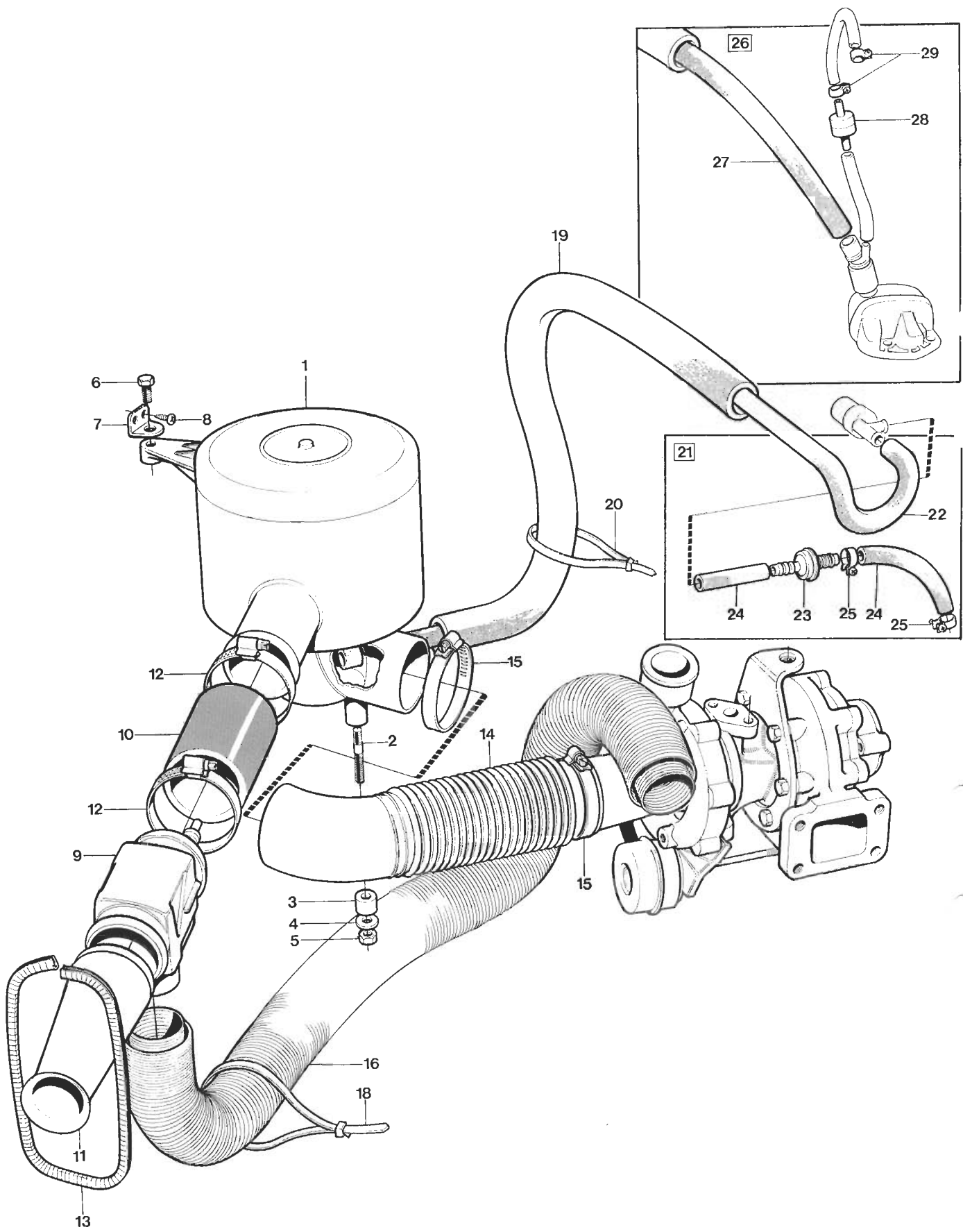
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Pos Qty Part No Description Specification

1	1	1276676-2	x Oil cooler	
2	1	1317695-3	x Bracket	
3	1	1276841-2	x Bracket	
4	1	1306647-7	x Cover plate	
5	9	965175-3	x Screw	
6	1	1276842-0	x Rubber cushion	
7	1	1276680-4	x Thermostat housing	
8	1	824589-6	x Washer	
9	1	1306707-9	x Nipple	
10	1	191701-2	x Nut	
11	1	925093-7	x O-ring	
12	1	1266286-2	x Oil filter	
13	1	1306580-0	x Oil pipe, upper	
14	1	1306579-2	x Oil pipe, lower	
15	2	941686-8	x Banjo screw	
16	4	957179-5	x Gasket	
17	1	1306152-8	x Bracket	
18	3	940142-3	x Screw	
19	2	1306156-9	x Clamp	
20	1	940101-9	x Screw	
21	1	960139-4	x Washer	
22	1	1306157-7	x Oil hose	
23	1	1306158-5	x Oil hose	
24	1	8360003-1	x Oil pan sump, compl	
25	1	463587-6	x Gasket	
26	2	418360-4	x Rubber ring	
27	1	8360026-2	x Hose	
28	2	943473-9	x Hose clip	
29	1	1306162-7	x Return pipe	
30	1	418411-5	x Sealing ring	
31	2	956984-9	x Nut	
32	2	956970-8	x Ferrule	





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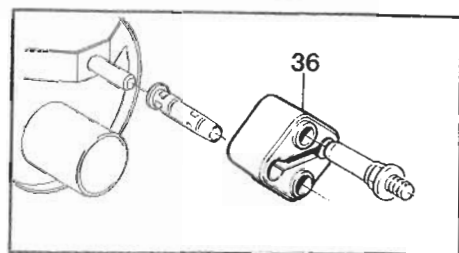
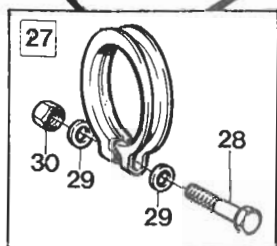
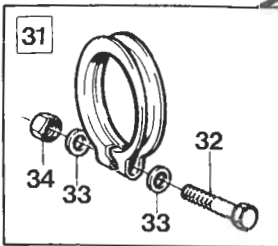
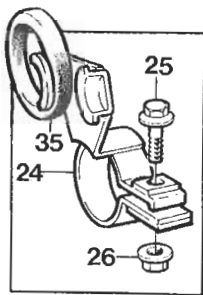
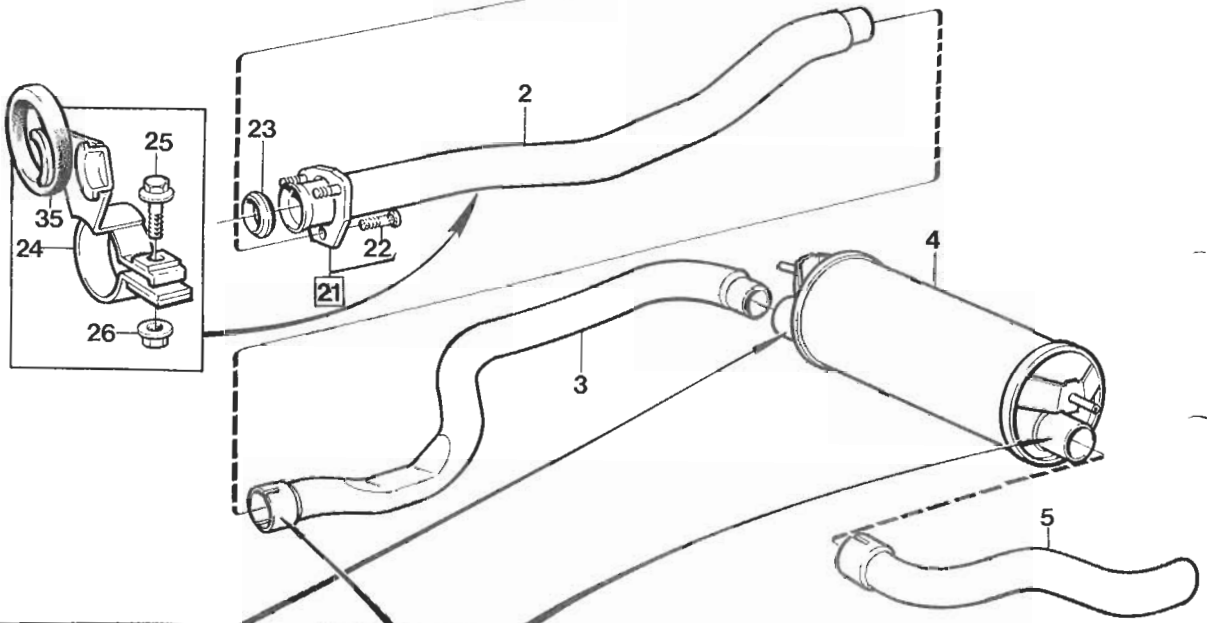
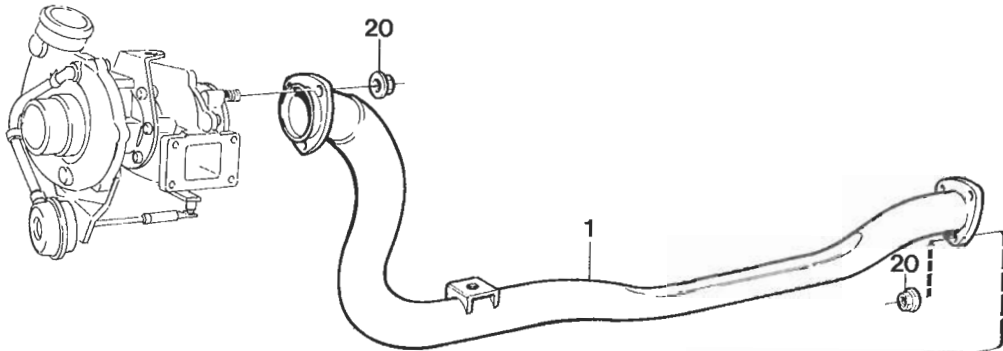
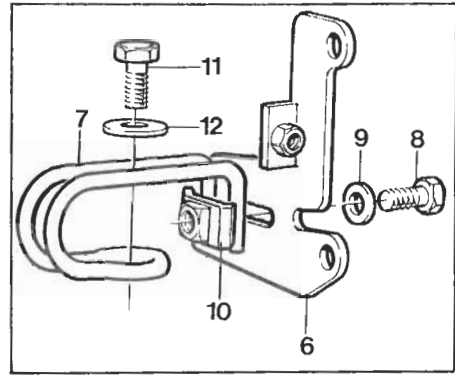
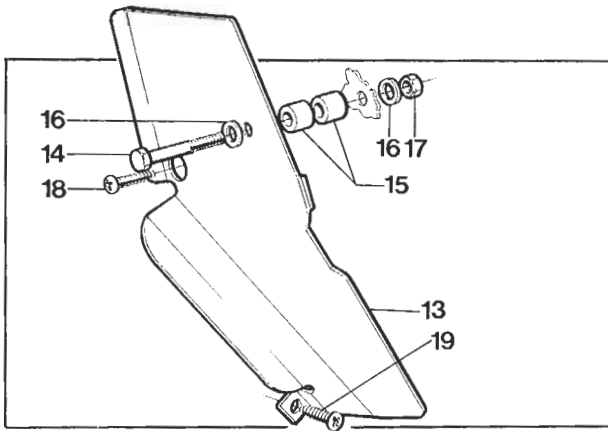
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Pos	Qty	Part No	Description	Specification
1	1	460944-2	x Air filter	
2	1	953241-7	x Stud	
3	1	8360016-3	x Spacer	
4	1	960141-0	x Washer	
5	1	955826-3	x Nut	
6	1	940113-4	x Screw	
7	1	8360027-0	x Bracket	
8	2	955137-5	x Screw	
9	1	1306088-4	x Shutter housing	
10	1	684576-2	x Hose	
11	1	1266458-7	x Air intake	
12	2	943480-4	x Hose clip	
13	1	679754-2	x Protector moulding	
14	1	8360039-5	x Air hose	
15	2	943480-4	x Hose clip	
16	1	8360017-1	x Hot air hose	
18	1	948616-8	x Strip clamp	
19	1	1276438-7	x Insulating hose	
20	1	948616-8	x Strip clamp	
21	1	8360031-2	Crankcase ventilation kit, year models 1975-1980	Not included in the basic kit
22	1	8360042-9	x Hose	
23	1	1228272-9	x Check valve	
24	2	944075-1	x Hose (2x0.1 m)	
25	2	947065-9	x Clip	
26	1	8360032-0	Crankcase ventilation kit, year model 1981-	Not included in the basic kit
27	1	949701-7	x Hose	
28	1	1276472-6	x Check valve	
29	2	947331-5	x Clip	





B19A/B21A TURBO KIT

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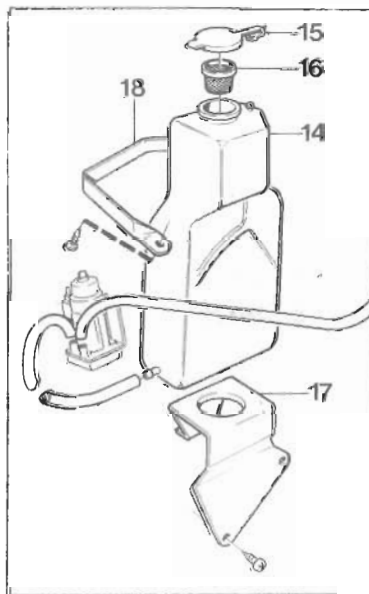
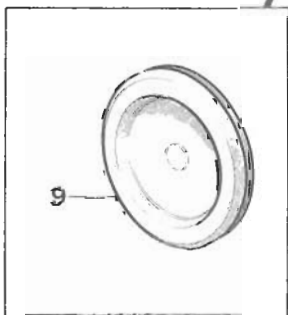
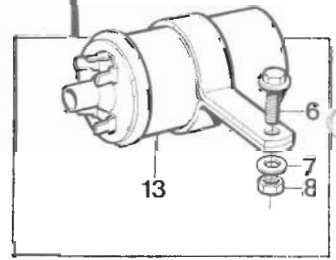
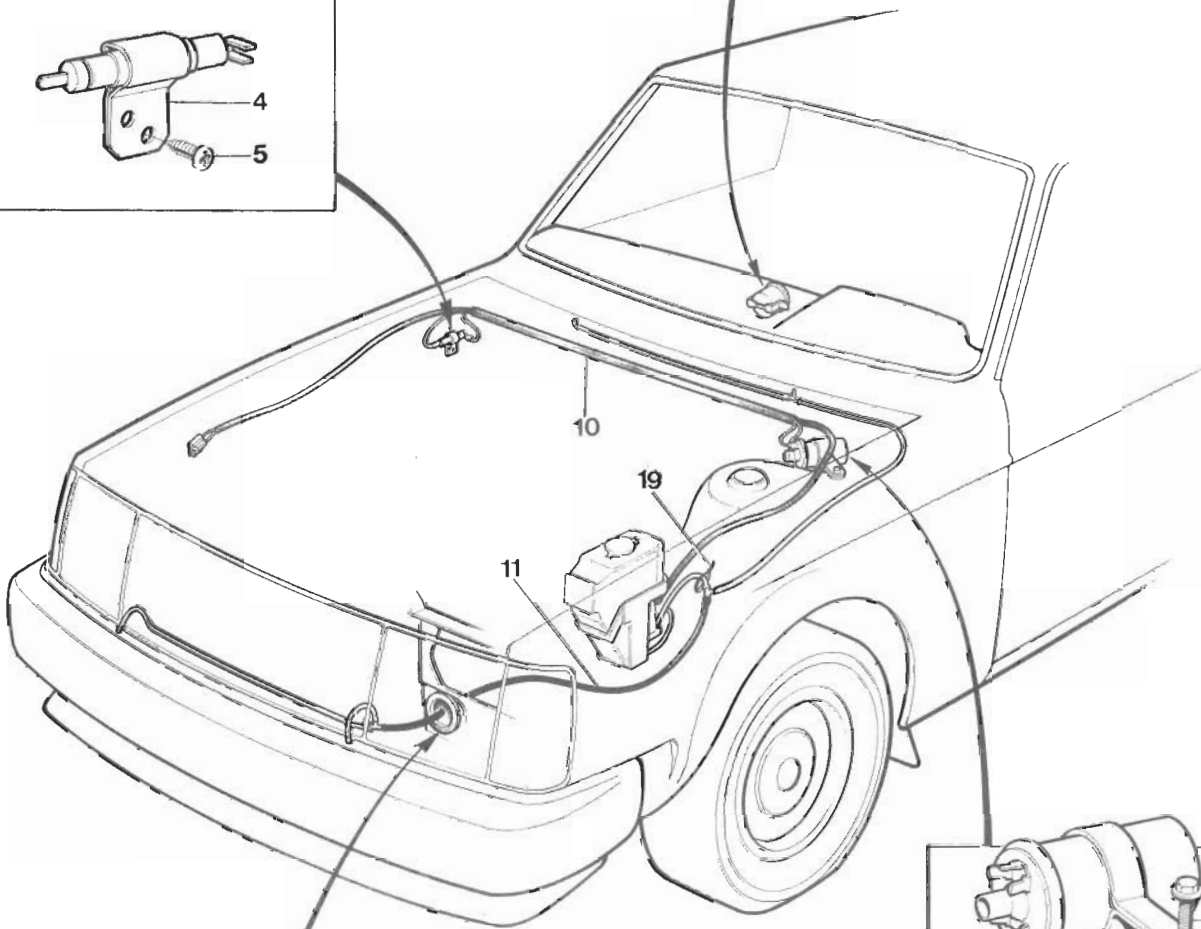
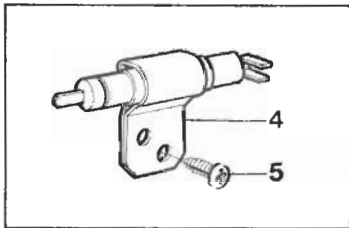
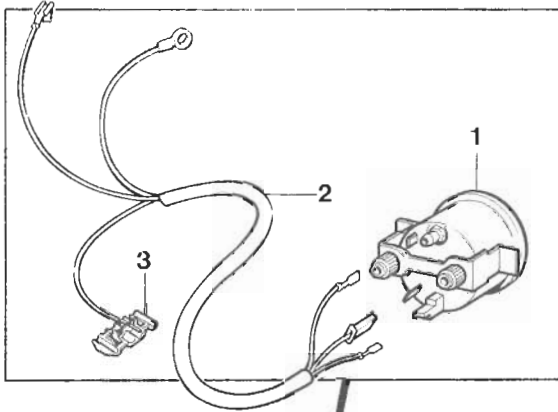
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Pos	Qty	Part No	Description	Specification
1	1	1306184-1	x Exhaust pipe	
2	1	1306187-4	x Exhaust pipe	
3	1	1306190-8	x Exhaust pipe	
4	1	1306192-4	x Silencer	
5	1	1306193-2	x Exhaust pipe	
6	1	1266519-6	x Bracket	
7	1	1306228-6	x Bracket	
8	1	940142-3	x Screw	
9	1	191172-6	x Washer	
10	1	1276582-2	x Nut plate	
11	1	955317-3	x Screw	
12	1	947541-9	x Washer	
13	1	1304869-9	x Heat shield	
14	1	955303-3	x Screw	
15	2	8360016-3	x Spacer	
16	2	960141-0	x Washer	
17	1	955782-8	x Nut	
18	1	965406-2	x Screw	
19	1	946451-2	x Screw	
20	6	948645-7	x Flange lock nut	
21	1	1306867-1	x Flange, compl	
22	3	1276215-9	xx Press screw	
23	1	1306852-3	x Sealing ring	
24	1	1306609-7	x Mounting bracket	
25	1	946472-8	x Flange screw	
26	1	945409-1	x Flange nut	
27	2	949677-9	x Clip	
28	1	955306-6	xx Screw	
29	2	120265-4	xx Washer	
30	1	955782-8	xx Nut	
31	1	949676-1	x Clip	
32	1	955304-1	xx Screw	
33	2	120265-4	xx Washer	
34	1	955782-8	xx Nut	
35	2	666407-2	x Rubber ring	
36	2	1206468-9	x Shackle	



TURBO 1.8 TURBO

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EXPORT

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Pos	Qty	Part No	Description	Specification
1	1	8360029-6	x Pressure gauge	
2	1	8360035-3	x El. cable	
3	1	1586597-5	x Joint sleeve	
4	1	1266014-8	x Resistance	
5	2	190071-1	x Screw	
6	1	946440-5	x Screw	
7	1	941907-8	x Spring washer	
8	1	955782-8	x Nut	
9	1	281334-3	x Protecting plug	
10	1	8360041-1	x El. cable	
11	1	943727-8	x Washer hose	
12	1	8360051-0	x Decal	
13	1	1219230-8	Ignition coil	Not included in the kit, but necessary for year models 1975 up to and incl 1978
14	1	1304149-6	Washer fluid container	Necessary for cars with servo steering and/or parking heater 03-B. Not included in the kit.
15	1	1213943-2	Cover	
16	1	1255568-6	Filter	
17	1	1304205-6	Bracket	
18	1	1304204-9	Attachment strap	
-	1		x Exhaust control decal	
19	1	948702-6	x Strip clamp	

	CARBURETOR SOLEX 40 EIES	EXPORT	810701	
		FLAP	SECTION	PAGE
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Pos	Qty	Part No	Description	Specification
		552554-8	Carburetor Solex 40 EIES, complete	Designed for B20 engines. Earlier included in GT-kit 552550. For parts see 140, section B, pages 7-9.



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EXHAUST SYSTEM

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B


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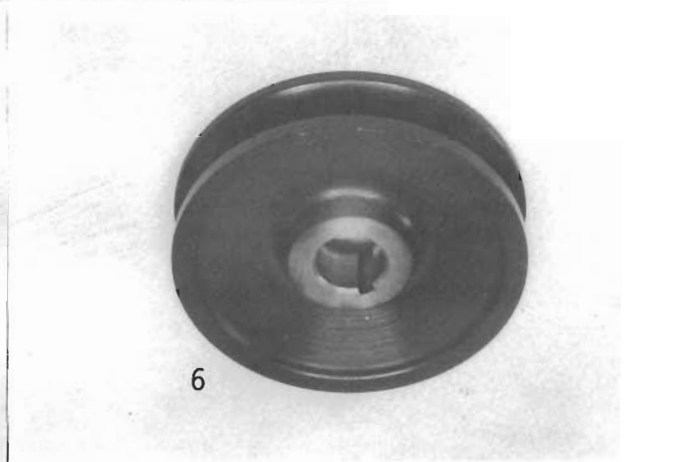
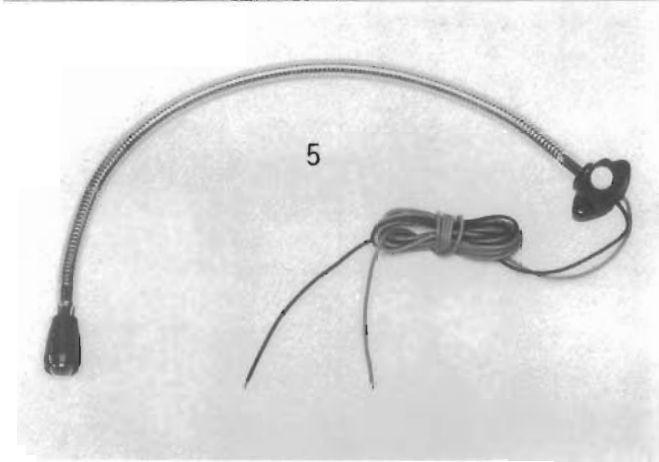
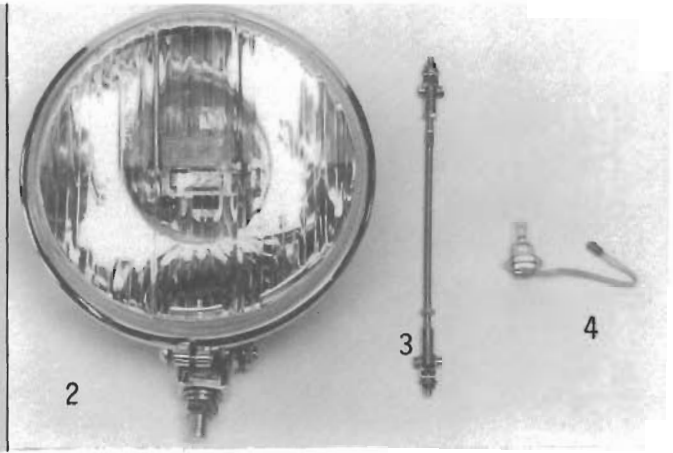
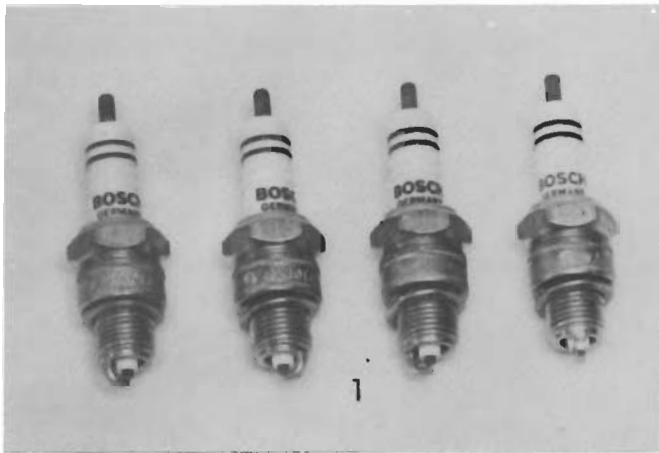
VOLVO RALLY EXHAUST KITS are designed to give the least possible loss of power.

With a VOLVO RALLY EXHAUST KIT the engine breathes better. These kits offer an increase in power of 5 to 9 hp DIN, depending on car model, and are designed for normal as well as competition driving.


The VOLVO RALLY EXHAUST KITS are as easy to fit as production exhaust kits - mounting details are included.

Pos	Qty	Part No	Description	Specification
1	1	552295-8	Rally Exhaust System, compl for P240 DL and GL, model year 1975	Part no 552295-8 is replaced by 552296-6. 552297 is replaced by 552397, 552292 by 552312 and 552294 by 552394.
	1	552297-4	x Front pipe	
	1	552228-3	x Intermediary pipe	
	1	552282-6	x Silencer, front	
	1	552291-7	x	
	1	552292-5	x Silencer, rear	
	1	552393-1	x Exhaust pipe	
	1	552294-1	x Assembly kit	
1	1	552289-1	Rally Exhaust System, compl for P240 L, model year 1975	
	1	552287-5	x Front pipe	
	1	552288-3	x Intermediary pipe	
	1	552282-6	x Silencer, front	
	1	552291-7	x	
	1	552292-5	x Silencer, rear	
	1	552393-1	x Exhaust pipe	
	1	552294-1	x Assembly kit	
1	1	552296-2	Rally Exhaust System, compl for P240 DL and GL 1976 -	
	1	552397-4	x Front pipe	
	1	552288-3	x Intermediary pipe	
	1	552282-6	x Silencer, front	
	1	552291-7	x	
	1	552312-1	x Silencer, rear	
	1	552393-1	x Exhaust pipe	
	1	552394-9	x Assembly kit	

	ELECTRICAL EQUIPMENT	EXPORT	810701	
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Pos	Qty	Part No	Description	Specification
1	1	273536-3	Spark plug Bosch W225T1 (W5A)	For B20 GT-kit and tuned B20-engines up to about 130 hp DIN
2	1	552028-3	Spotlight without bulb, 180 mm diameter.	Recommended for Rally driving and for normal driving
3	1	552031-7	Stay for spotlight 552028	Necessary for Rally driving and recommended for normal driving to avoid shaking lights
4	1	552030-9	Bulb 100 W	
5	1	283651-8	Map reading lamp	Necessary for Rally driving and recommended also for the production car
6	1	552884-9	Belt pulley for alternator	Diameter 86 mm


	ELECTRONIC IGNITION SYSTEM	EXPORT	810701	
		FLAP	SECTION	PAGE
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Electronic ignition system. Gives the following advantages:

- No wear (No breaker points)
- Setting remains unchanged
- Higher ignition voltage at all revs and increased starting properties,

Part No	Description	Specification
552737-9	Electronic ignition system	For all B21 A engines

	TRANSMISSION M40	EXPORT	810701	
		FLAP	SECTION	PAGE
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Production gearboxes often have relatively long steps between the different speeds. This is not accepted in a tuned competition car since it frequently means that the engine does not work in the right RPM range.

For this reason the following parts which are needed to convert a non-needle M40 gearbox to a close-ratio gearbox M40 and to convert an M45 gearbox to a close-ratio gearbox are available.

Information about range of application and ratio for M40 is given in table A below, and for M45 on page 3.

Table A: Close-ratio M40 gearbox of needle-bearing type for B20 engines (2.0-2.2 litres)

TYPE	R A T I O				APPLICATION
	1st	2nd	3rd	4th	
M40	2.62:1	1.67:1	1.24:1	1:1	Rally, rallycross and track racing
M40 production gearbox	3.41:1	1.99:1	1.36:1	1:1	



GEARBOX PARTS M40

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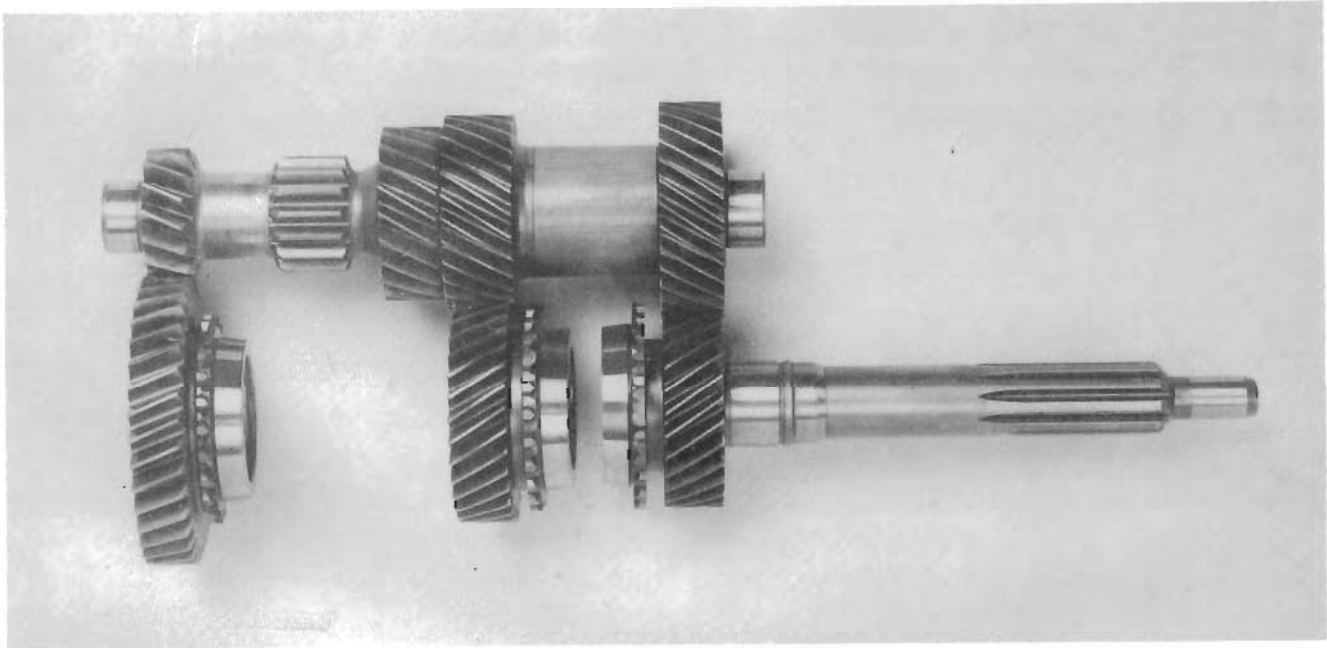


Table B: To convert a non-needle-bearing M40 gearbox to a needle-bearing type.

Qty	Part No	Description	Note
1	380217-0	1st speed gear	Production part
1	380218-8	2nd speed gear	Production part
2	181330-2	Needle bearing	Production part
1	181331-0	Needle bearing	Production part

Table C: To convert a needle-bearing type M40 gearbox to a close-ratio gearbox.

TYPE	P A R T N O			
	GEAR CLUSTER	1st SPEED GEAR	3rd SPEED GEAR	INPUT SHAFT
M40 year model 1975	380824-3	380217-0	380423-4	380382-2


	GEARBOX PARTS M45	EXPORT	810701	
		FLAP	SECTION	PAGE
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Table D: Ratios


TYPE	R A T I O			
	1st	2nd	3rd	4th
Close-ratio M45	2.50:1	1.63:1	1.27:1	1.0:1
M45 Production gearbox	3.71-4.03:1	2.16:1	1.37:1	1.0:1

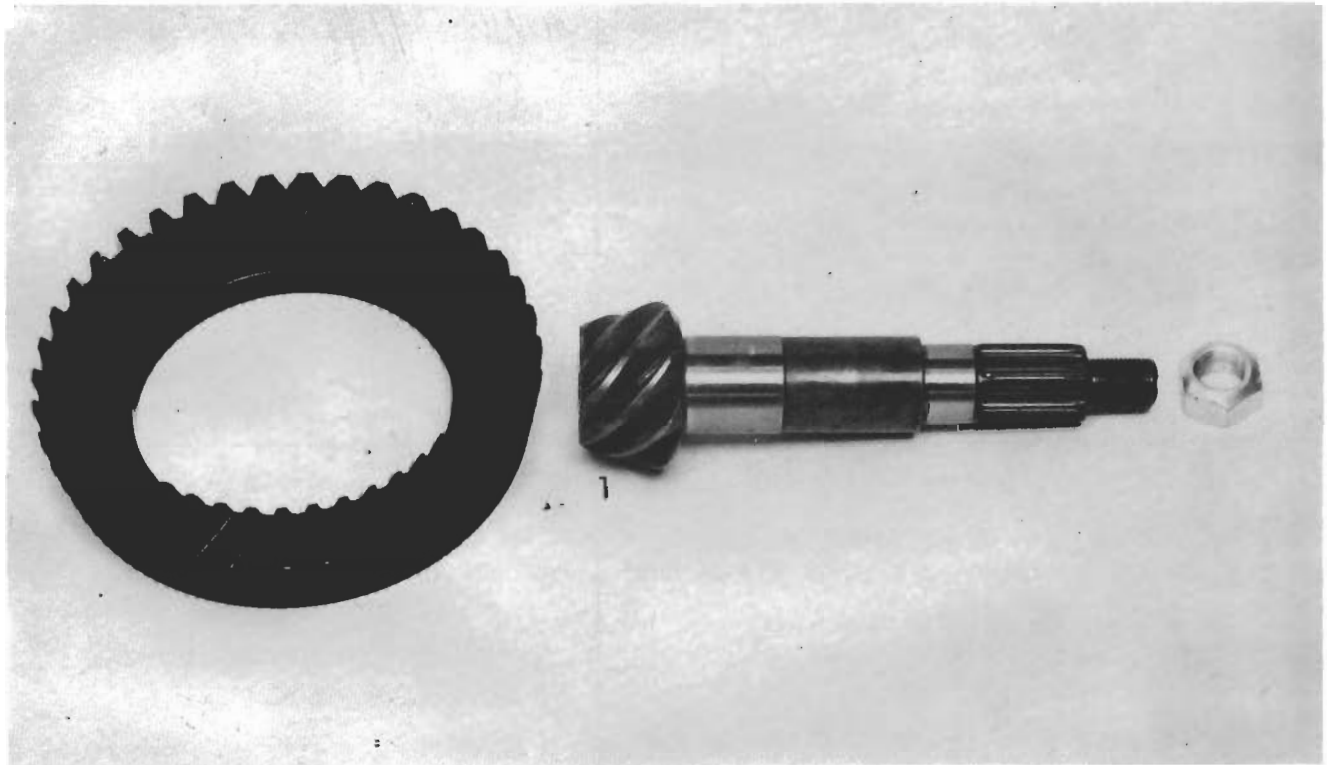
Table E: To convert a production M45 gearbox to a close-ratio gearbox.

TYPE	P A R T N O				
	INPUT SHAFT	1st SPEED GEAR	3rd SPEED GEAR	COUNTER SHAFT	RETAINING RING
M45 models 1976-1981 *)	1232709-4	1232710-2	1232714-4	1232345-7	951671-7
		Kit no 552396-4			

*) NOTE! For year models 1975-1978 also synchronizing cones and connection sleeves are to be replaced by a later execution,

For 1979 and later models production input shaft is provided with another type of splines, whereas input shaft no 1232709-4 has the earlier execution. This means that the clutch disc must be replaced.

	FINAL GEARS	EXPORT	810701	
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Rear axle ratios

To get the maximum power delivered at the wheel and thereby the best possible acceleration, the production rear axle ratio must be numerically raised in relation to the production ratio. This also means, however, that the top speed of the car is reduced at a given maximum motor speed, which has to be taken into consideration. Our general recommendation is:

Rally: Either final gear 5.38:1 or 4.88:1 for standard class, As a rule 5.38:1 is the most suitable.

Rallycross: 5.38:1 or 4.88:1 depending mainly on the engine displacement and the wheel dimension. A 2 litres engine and 15" tyres require 5.38:1. With a 2.4 litres engine with 13" or 15" tyres the best ratio is 4.88:1.

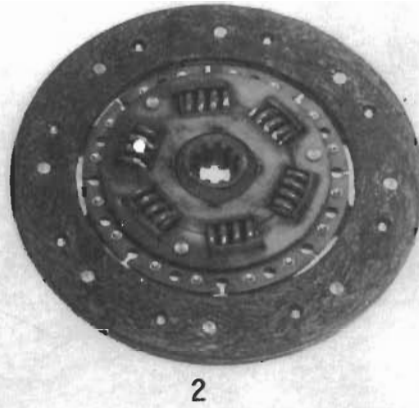
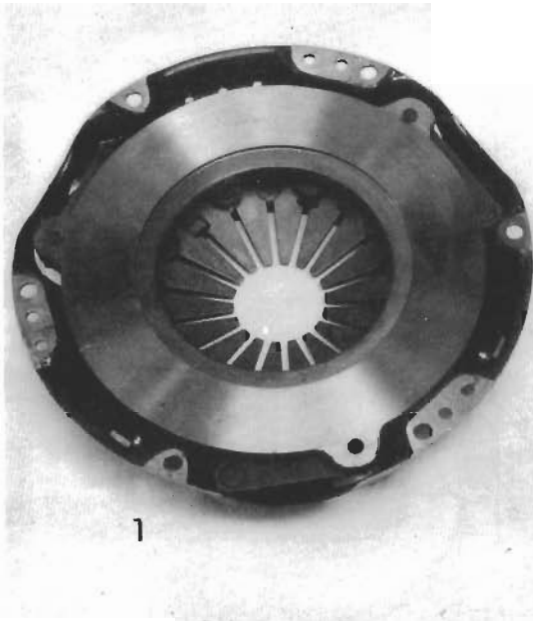
Track Racing: Since the character of the tracks varies more than in Rally and Rallycross, the top speed on the straights will decide. Normally 4.88:1 and 4.56:1 are the most suitable.

Pos	Qty	Part No	Description	Specification
	1	552144-8	Final gear 5.38:1, M30	21.8 km/h at 1,000 RPM, Application: Rally and Rallycross
1	1	525880-1	Final gear 4.88:1, M30	24.0 km/h at 1,000 RPM, Application: Very fast Rallies and Track racing
	1	380789-8	Gear, large, for output shaft	Reduction gear to give correct speedometer indication with rear axle ratio 4.88:1. Suits close-ratio gearbox M40.
	1	380305-3	Gear, small (plastic)	



CLUTCH B20

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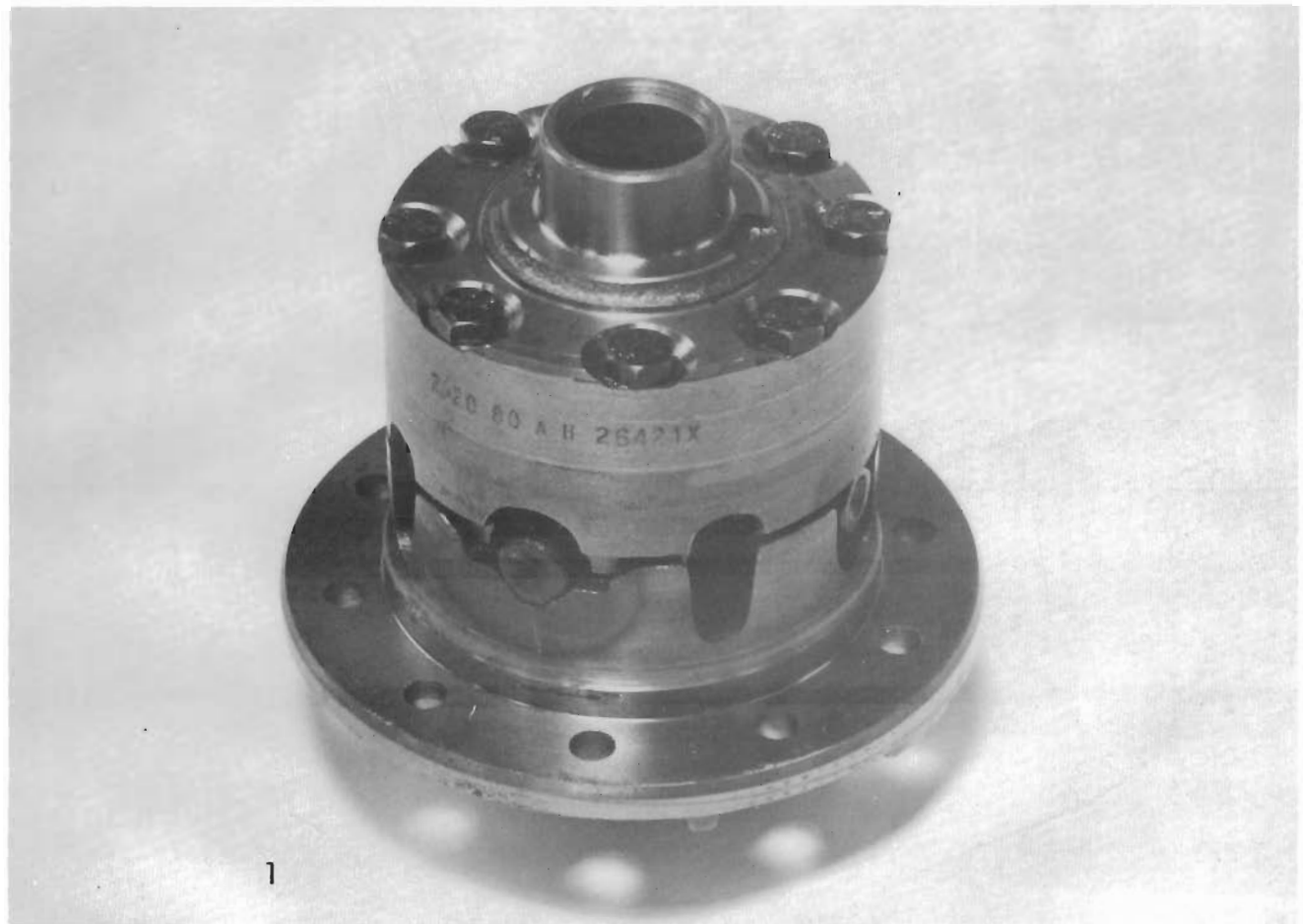


Pos	Qty	Part no	Description	Specification
<u>Clutch</u>				
	1	418930-4	Clutch "Laplander"	Clamping force 4660-5400 N (475-550 kp). Disc part no 418871. Withdrawal bearing part no 380569. Application: Where production clutch is insufficient, e.g. Rally or Standard class, or if car is heavily loaded or with towing.
1	1	552145-5	Clutch "RAC"	Clamping force 7100-7750 N (725-790 kp). Disc part no 552146. Withdrawal bearing part no 672122. Application: "Special II-III"-engines. Specially suitable for Rally, Rally-cross and Drag-racing. Up to a torque of 255 Nm (26 kpm). Plate for withdrawal bearing is dismounted.
<u>Discs</u>				
	1	418871-0	Disc	To be used with clutch 418930. Suitable up to and inclusive of model year 1978.
2	1	552146-3	Disc	To be used with clutch 552145. Suitable up to and inclusive of model year 1978.
<u>Withdrawal bearings</u>				
3	1	380569-4	Withdrawal bearing	To be used with clutch 418930.
		672122-9	Withdrawal bearing	To be used with clutch 552145.

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LIMITED SLIP DIFFERENTIAL



By installing a limited slip differential you increase the power transferred to the wheel with the highest friction, and thereby the acceleration, in a situation where the two driving wheels have different friction. Consequently in all competition driving - where the rules permit - a limited slip differential should be used.

Presently it is homologated for the following models: 242 L B20; 242 DL B21; 244 GL. See homologation papers for each model.

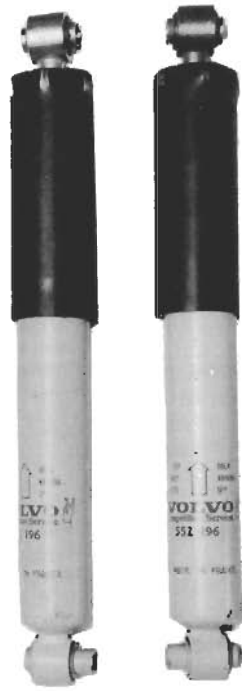
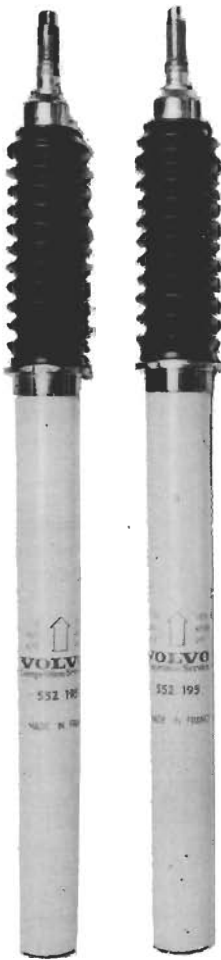
Pos	Qty	Part No	Description	Specification
1	1	384727-4	Limited slip differential M30	

		EXPORT		810701
		FLAP	SECTION	PAGE
SUSPENSION		240	E	1

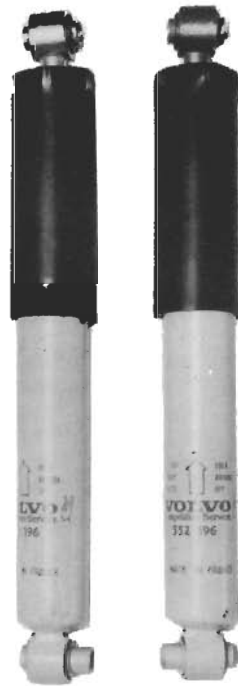
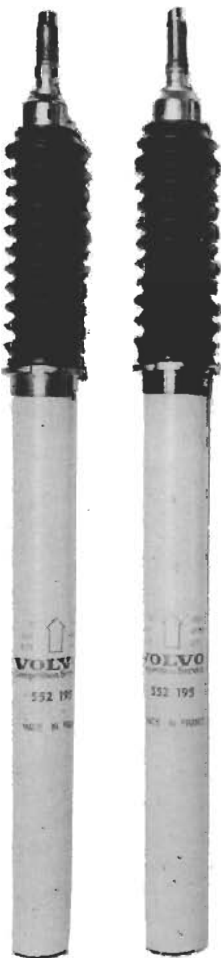
In a production car the suspension is a compromise between several demands where the driver's and the passengers' comfort has a high priority. As our roads get more even and straight, and the customer's preference for a soft and silent ride increases, the need to modify the car for competition driving increases. Comfort has to be sacrificed for demands such as optimum road holding ability.

The shock absorber setting will have to be drastically changed - the relatively soft production shock absorbers are replaced by gas-pressure shock absorbers that keep the wheels on the road, no matter how bumpy it is, without fading. Much harder springs also have to be used.

Between these two categories - the competition driver and the non-competition driver - there is a group of drivers who do not want to enter competitions but still want a car that can take tougher driving than the production car. As you will see, suspension parts are available for both the competition driver and the demanding non-competition driver.



1




2



SUSPENSION

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Pos	Qty	Part No	Description	Specification
1	1	552095-2	Road Holding Kit	Designed for driving when an increased stability is required.
2	1	552093-7	x Shock absorber kit	Gas pressure shock absorbers designed for normal driving. Somewhat harder setting than production shock absorbers. Designed for normal driving and Rally driving. Offers a much increased stability. Diameter 21 mm Diameter 25 mm For 245 only
	2	552195-0	xx Shock absorber, front	
	2	552196-8	xx Shock absorber, rear	
	1	552096-0	x Stabilizer kit	
	1	552097-8	xx Stabilizer, front	
	1	552098-6	xx Stabilizer, rear	
	2	955356-1	xx Bolt	
	2	1221956-4	xx Bracket	
	2	947292-9	xx Screw	
	2	945409-1	xx Nut	
	2	1228841-1	xx Rubber bushing for 552097	
	2	1206273-3	xx Bolt	
	2	1	552094-5	
2		552197-6	x Shock absorber, front	
2		552198-4	x Shock absorber, rear	
2		552538-1	Rally spring, front	
2		552539-9	Rally spring, rear	

	MISCELLANEOUS EQUIPMENT	EXPORT	810701	
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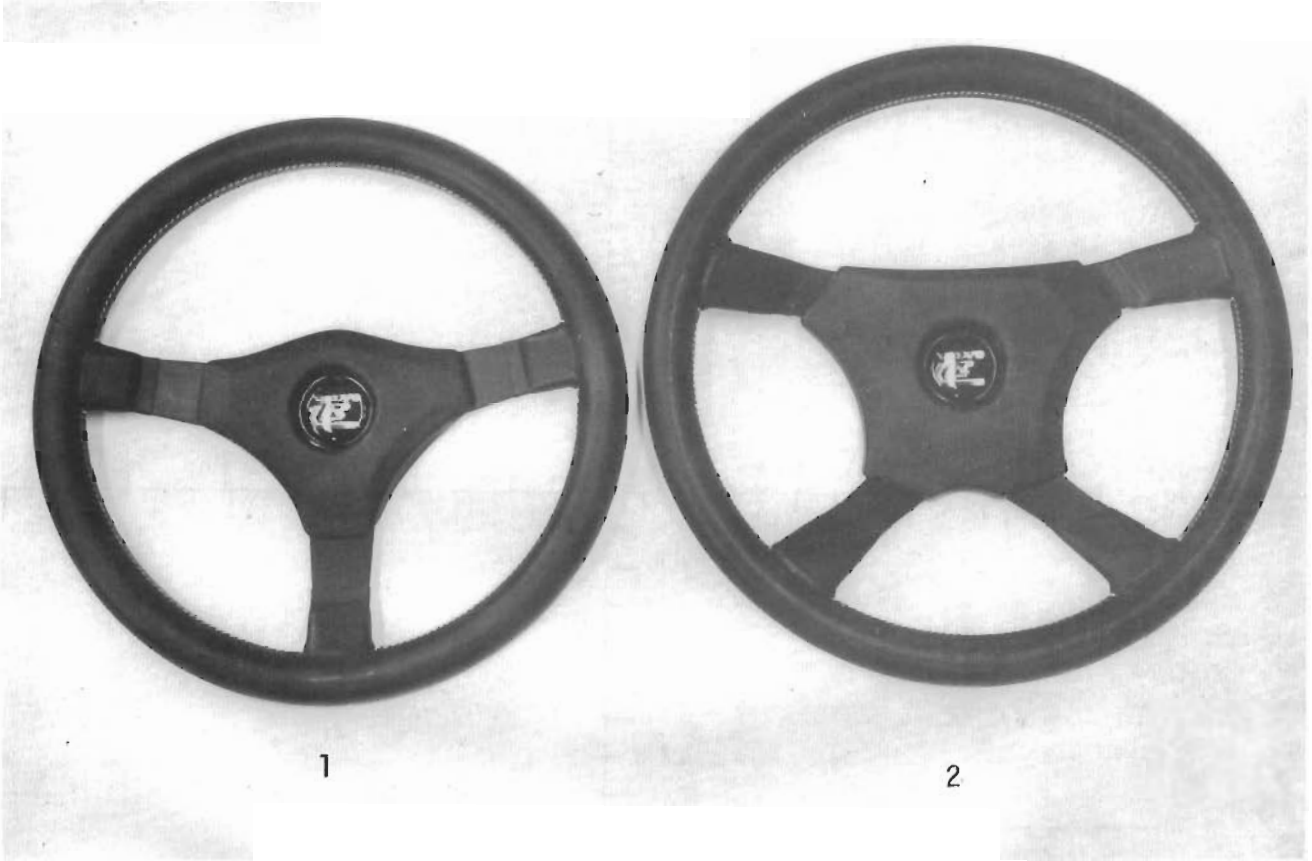


Pos	Qty	Part No	Description	Specification
	1	552168-7	Front spoiler	Improves the car's stability and reduces fuel consumption. Suitable also for 140 and 164 1974- .



STEERING WHEEL

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Handmade sports steering wheels, covered with genuine leather of the best possible quality. The steering wheel hubs are collapsible for added safety.

The steering wheels meet with all safety regulations in Europe, North America (FMVSS 203) and Australia (ADR 10B).

Pos	Qty	Part No	Description	Specification
1	1	552034-1	Three spoke sports steering wheel, compl	240/260 up to and inclusive of 1978 model Diameter 350 mm Rim thickness 29 mm
2	1	552035-8	Four spoke sports steering wheel, compl	240/260 up to and inclusive of 1978 model Diameter 380 mm Rim thickness 29 mm
1	1	552344-4	Three spoke sports steering wheel, compl	240/260 1979 - Diameter 350 mm
2	1	552345-1	Four spoke sports steering wheel, compl	240/260 1979 - Diameter 380 mm
	1	552343-6	Hub padding incl screws	Three spoke steering wheels
	1	552349-3	Hub padding incl screws	Four spoke steering wheels
	1	552342-8	Horn button	All steering wheels



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GT KIT B14

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This popular performance kit for the 340 B14 engine with manual gear box gives an increased effect without appreciably raising petrol consumption. It consists basically of just three units: the GT camshaft, the exhaust system and the thermostatically controlled electrical fan.

The GT kit is certified for EFTA countries in accordance with the ECE Regulation No 15.

Technical data:

Output: 83 hp (61 kW) at 6000 rpm (100 rps)
Torque: 116.5 Nm (11.8 kpm) at 3700 rpm (61.7 rps)
Acceleration: 0 - 80 km/h 10 s, 0 - 100 km/h 16 s
Top speed: 156 km/h
Estimated mounting time: 8 hours



GT KIT

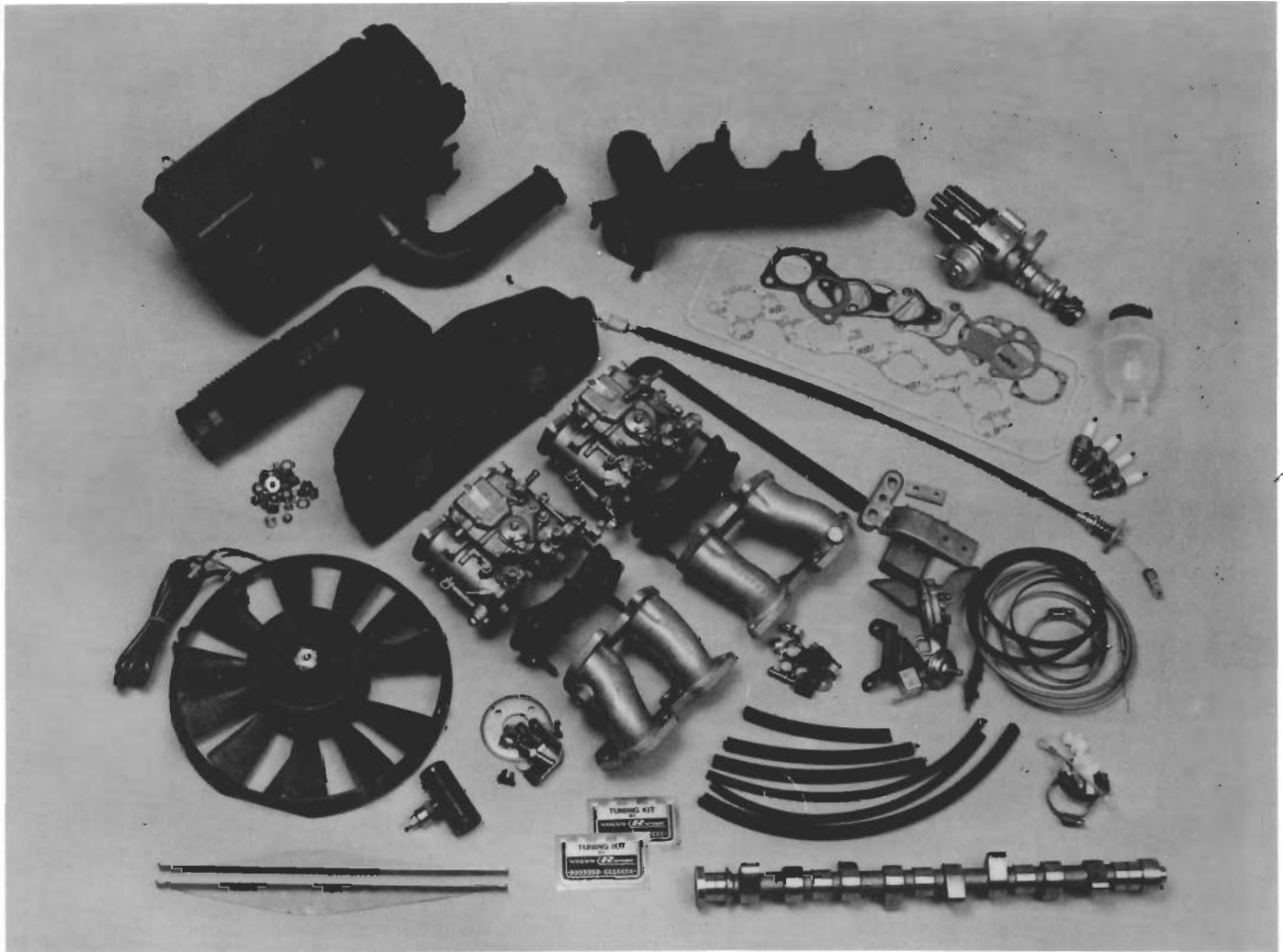
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Qty	Part No	Description	Specification
1	1156650-2	GT kit B14	-1980 models
1	1156655-1	GT kit B14	1981- models
1	1156530-6	x Exhaust kit, complete	-1980 models
1	1156710-4	x Exhaust kit, complete	1981- models
1	1156551-2	x Camshaft	
1	3267493-9	x Gasket kit	
1	3104936-4	x Retainer	
		x Fan complete	
1	1274041-1	xx Motor	
1	1274042-9	xx Fan	
1	1274043-7	xx Lock washer	
1	1274044-5	xx Nut	
1	1274045-2	xx Fan ring	
3	955780-2	xx Nut	
1	948210-0	xx Strip clamp	
1	1156651-0	x Bracket	
4	965175-3	x Screw	
1	1156652-8	x Thermo contact	
1	1276187-0	x Connecting pipe	
2	943476-2	x Hose clamp	
1	947621-9	x Gasket	
2	552553-0	x Emblem	
8	945407-5	x Nut	
1	1156653-6	x El cable harness	
1	1214764-1	x Relay	
4	955271-2	x Screw	
1	3267903-7	x Camshaft gear	For 1981- models
1	3102867-3	x Spacer ring	For 1981- models
1	3105250-9	x Washer	For 1981- models
1	3102866-5	x Key	For 1981- models
1	955295-1	x Bolt	For 1981- models

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GT-KIT B19

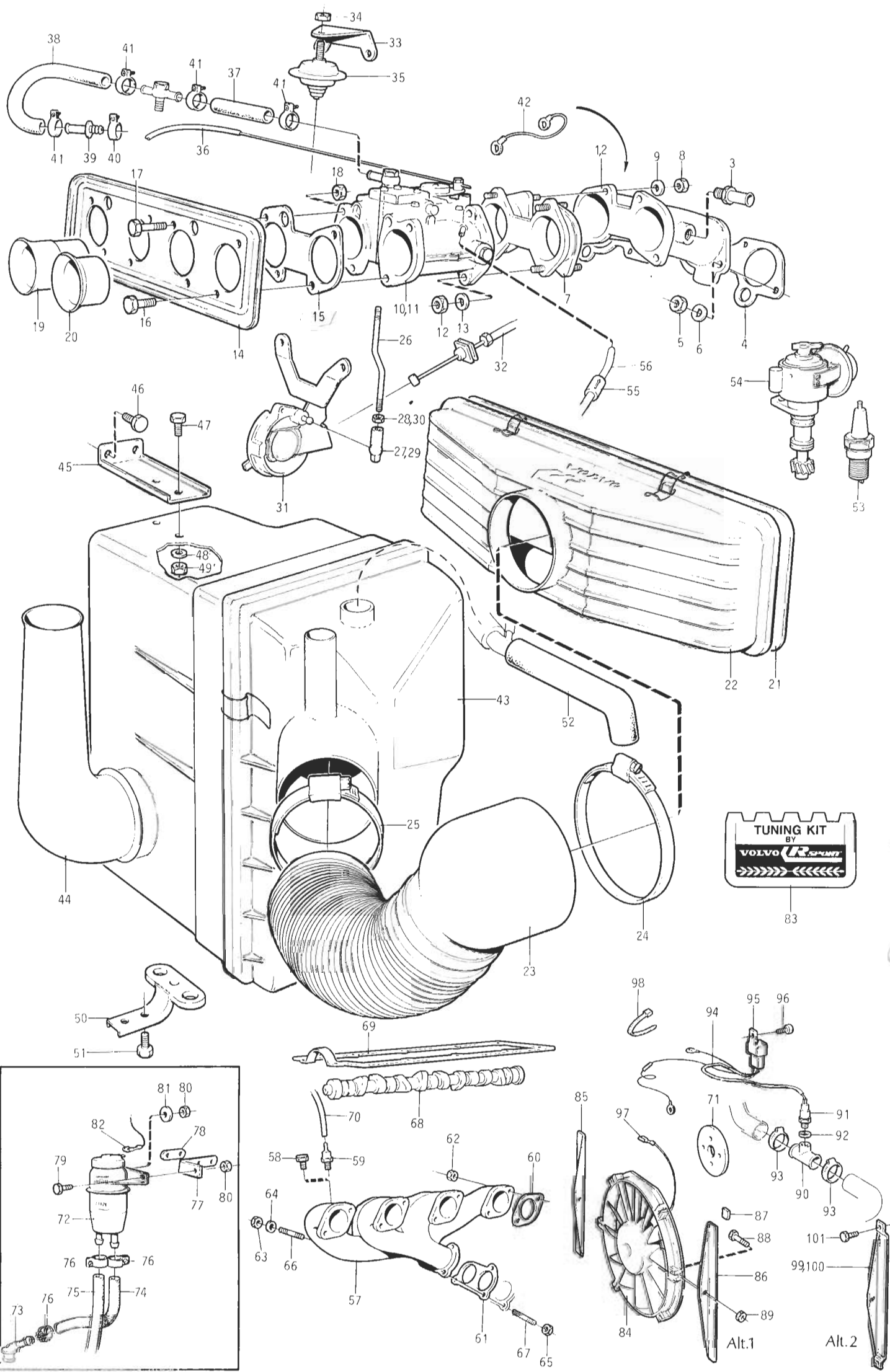


This GT-kit is intended for the 1981-models of the Volvo 340 Series with B19 engine and manual gearbox. It has been designed for the ordinary driver with extra requirements on sports appeal and driving pleasure. The basic version incorporates two twin-port SOLEX 40 ADDHE 39 carburetors, K-camshaft, ignition distributor, and an electric cooling fan. The GT kit increases output to 118 hp DIN (87 kW) compared with the 95 hp of the standard engine. To the GT kit can be added the Volvo R Sport exhaust system, part no 1156690, which increases output to 123 hp DIN (90 kW).

Both versions conform to the European noise and exhaust gas emission requirements. It is certified by the West German TÜV with the Volvo R Sport exhaust system.

Technical data:

Output: 118 hp (87 kW) at 6000 rpm
Torque: 160 Nm at 3000 rpm
Acceleration: 0 - 100 km/h in 10,0 sec
Top speed: 179 km/h
Estimated mounting time: 8 hours





GT-KIT B19

EXPORT

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FLAP

SECTION

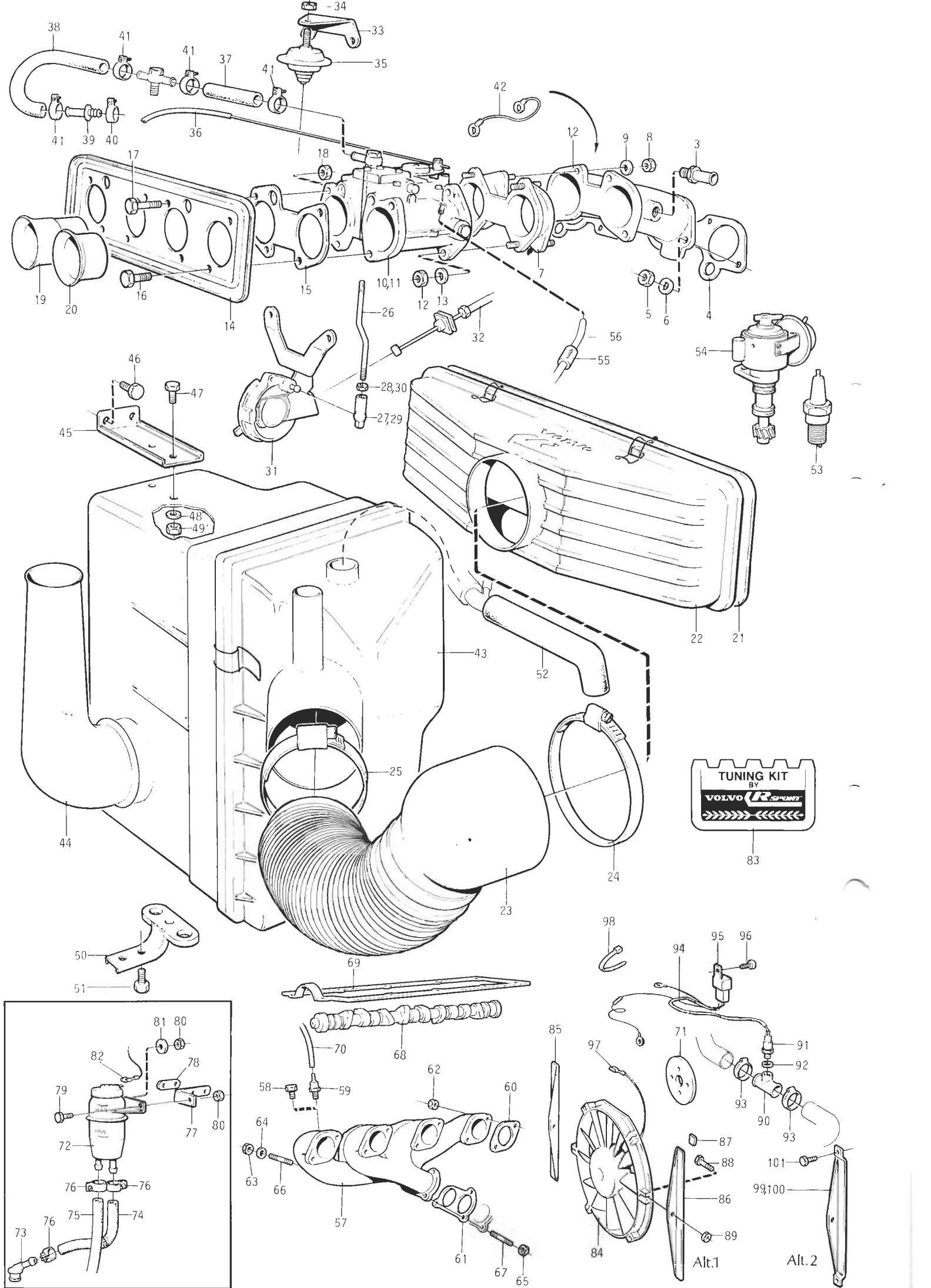
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Pos	Qty	Part no	Description	Specification
	1	1156670-0	GT-kit B19	1981 models. (Adaption for 1982 models will be ready August 1981).
1	1	1156659-3	x Inlet manifold, front	
2	1	1156660-1	x Inlet manifold, rear	
3	1	947043-6	x Nipple	
4	1	1266796-0	x Gasket	
5	8	955782-8	x Nut	
6	6	955894-1	x Washer	
7	2	1156502-5	x Flange	
8	8	955782-8	x Nut	
9	8	955894-1	x Washer	
10	1	552597-7	x Carburettor, front	
11	1	552598-5	x Carburettor, rear	
12	8	955782-8	x Nut	
13	4	955894-1	x Washer	
14	1	552584-5	x Bottom plate	
15	2	419906-3	x Gasket	
16	4	955272-0	x Screw M65 6x20	
17	4	955275-3	x Screw M65 6x30	
18	4	963105-2	x Lock nut	
19	2	552585-2	x Air intake, long	
20	2	552599-3	x Air intake, short	
21	1	552586-0	x Gasket	
22	1	552583-7	x Airbox	
23	1	552596-9	x Hose	
24	1	943483-8	x Hose clip	
25	1	943480-4	x Hose	
26	1	1156830-0	x Pull rod	
27	1	946703-6	x Ball socket	
28	1	955780-2	x Nut	
29	1	946704-4	x Ball socket	
30	1	942836-8	x Nut	
31	1	1156665-0	x Throttle control	
32	1	1156831-8	x Throttle wire	
33	1	552578-7	x Bracket	
34	1	3277656-9	x Nut	
35	1	3277546-2	x Dashpot	





GT-KIT B19

EXPORT

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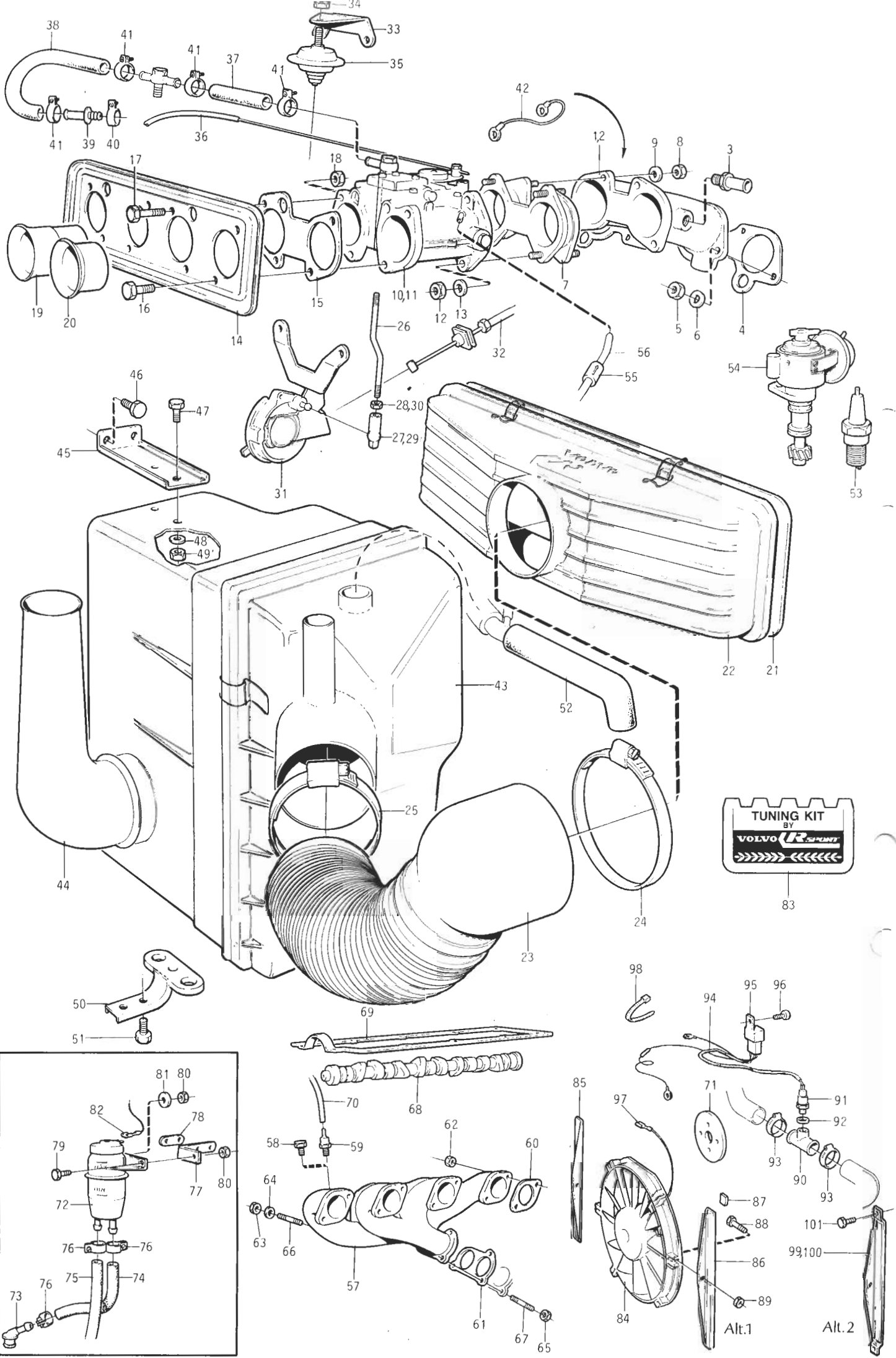
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Pos	Qty	Part no	Description	Specification
36	1	1156832-6	x Choke wire	
37	1	1156672-6	x Fuel hose	
38	1	1156673-4	x Fuel hose	
39	1	947441-2	x Nipple	
40	1	945650-0	x Hose clip	
41	4	945652-6	x Hose clip	
42	1	552589-4	x Earth cable	
43	1	1156671-8	x Air filter complete	
44	1	460887-3	x Inlet hose	
45	1	1156666-8	x Bracket	
46	2	190364-0	x Screw	
47	2	955271-2	x Screw	
48	2	960139-4	x Washer	
49	2	963105-2	x Lock nut	
50	1	1156667-6	x Bracket	
51	2	190364-0	x Screw	
52	1	460003-7	x Hose	
53	1	273596-7	x Spark plug kit	Bosch W6DC
54	1	552594-4	x Distributor	
55	1	552593-6	x Valve	
56	2	1156657-2	x Hose	
57	1	1156674-2	x Exhaust manifold	
58	4	191026-4	x Plug	
59	1	1156676-7	Plug	This plug is not included in the kit. Used only when adjusting the carburettors (should be distributed to your dealers/workshops).
60	4	463846-6	x Gasket	
61	1	1266713-5	x Gasket	
62	8	946036-1	x Lock nut	
63	4	946036-1	x Lock nut	
64	4	955894-1	x Washer	
65	3	940183-7	x Nut	
66	4	924061-5	x Stud	
67	3	924077-1	x Stud	
68	1	1306167-6	x K-camshaft	
69	1	463999-3	x Gasket	
70	1	1156654-4	Teflon hose	This teflon hose is not included in the kit. Used only when adjusting the carburettors (should be distributed to your dealers/workshops).





GT-KIT B19

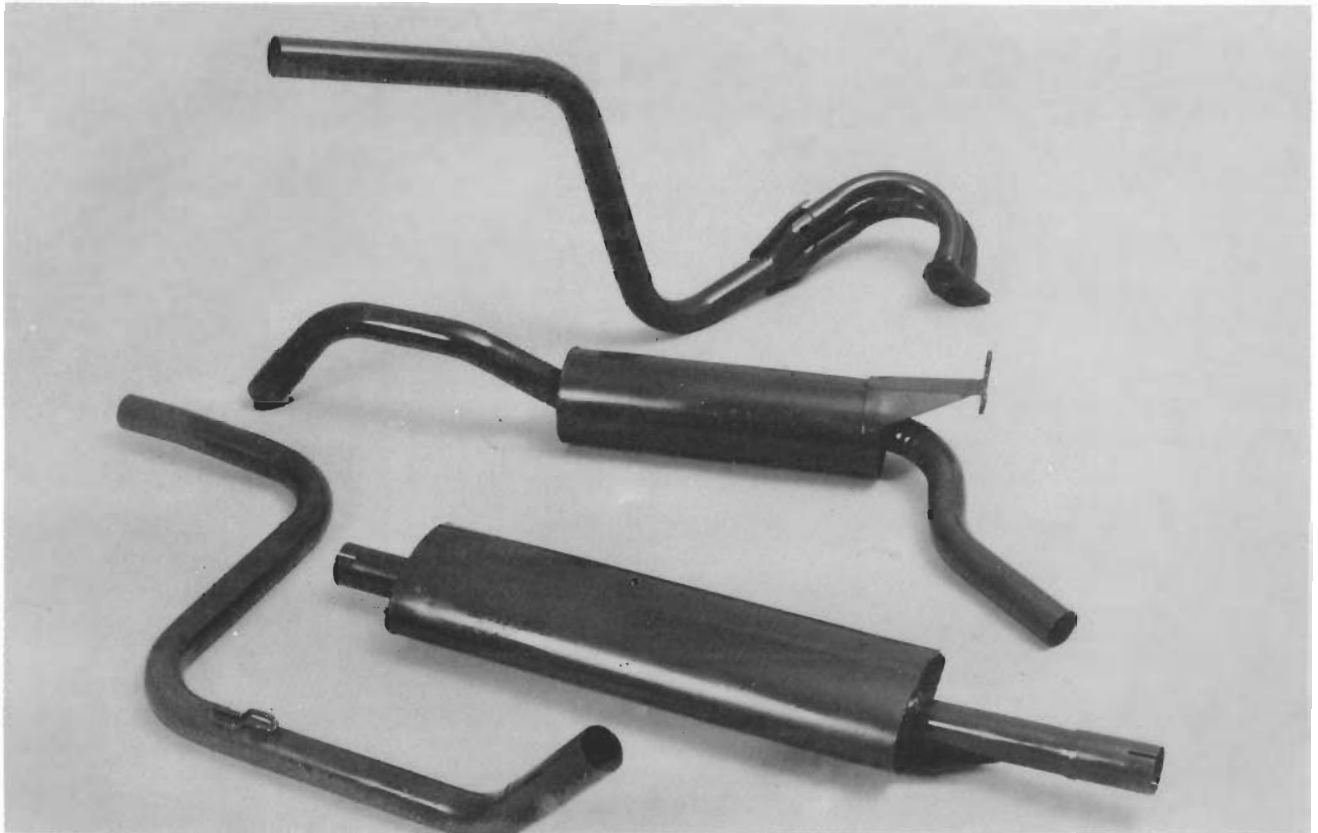
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Pos	Qty	Part no	Description	Specification
71	1	463301-2	x Washer	
72	1	1156679-1	x Brake fluid container	
73	2	1156678-3	x Angle connection	
74	1	1156677-5	x Brake fluid hose	
75	1	1156658-5	x Brake fluid hose	
76	4	945651-8	x Hose clip	
77	1	1156668-4	x Bracket	
78	1	1156669-2	x Washer	
79	4	946544-4	x Screw	
80	4	963105-2	x Lock nut	
81	1	960139-4	x Washer	
82	2	940341-1	x Cable terminal	
83	2	552553-0	x Sticker	
84	1	1274040-3	x El. cooling fan	
85	1	1156833-4	x Bracket	Alternative 1. Supplied in all kits earlier than Summer 1981.
86	1	1156834-2	x Bracket	
87	4	1156656-9	x Edge moulding	
88	2	955271-2	x Screw	
89	2	963105-2	x Lock nut	
90	1	1276187-0	x Pipe	
91	1	1156652-8	x Thermo contact	
92	1	947621-9	x Copper washer	
93	2	943476-2	x Hose clip	
94	1	1156712-0	x Cable harness	
95	1	1214764-1	x Relay	
96	1	955139-1	x Screw	
97	1	949489-9	x Cable terminal	
98	1	948616-8	x Strip clamp	
99	1	1156633-8	Bracket	Alternative 2. Will replace alternative 1 after Summer 1981.
100	1	1156634-6	Bracket	
101	4	960862-1	Screw	



EXHAUST SYSTEM

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VOLVO RALLY EXHAUST KITS are designed to give the least possible loss of power.

With a VOLVO RALLY EXHAUST KIT the engine breathes better. These kits offer an increase in power of 5 to 9 hp DIN, depending on car model, and are designed for normal as well as competition driving.

The VOLVO RALLY EXHAUST KITS are as easy to fit as production exhaust kits - mounting details are included.

Pos	Qty	Part No	Description	Specification
	1	1156530-6	Rally exhaust system, compl	-1980 model of B14 engine
	1	1156531-4	x Front pipe	
	1	1156532-2	x Front silencer	
	1	1156533-0	x Intermediary pipe	
	1	1156534-8	x Rear silencer	
	1	1156535-5	x Mounting kit	
	1	1156710-4	Rally exhaust system, compl	1981- model of B14 engine
	1	1156711-2	x Front pipe	
	1	1156532-2	x Front silencer	
	X1	1156533-0	x Intermediary pipe	
	1	1156534-8	x Rear silencer	
	1	1156535-5	x Mounting kit	
	1	1156690-8	Rally exhaust system, compl (front pipe excluded)	1981- models of B19 engine
	X1	1156691-6	x Front silencer	
	X1	1156694-0	x Intermediary pipe	
	1	1156692-4	x Rear silencer	
	1	1156693-2	x Mounting kit	



ELECTRICAL EQUIPMENT

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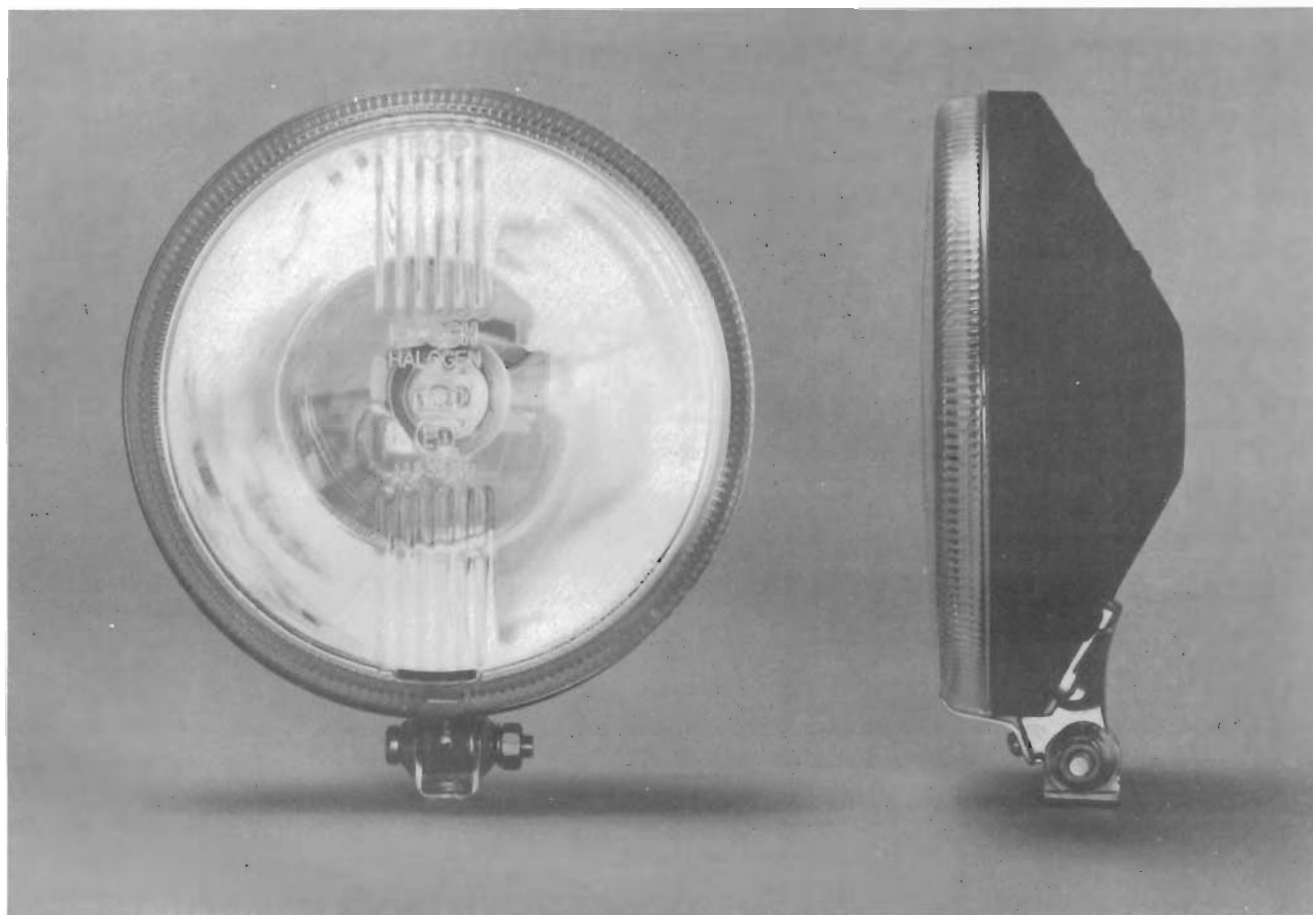
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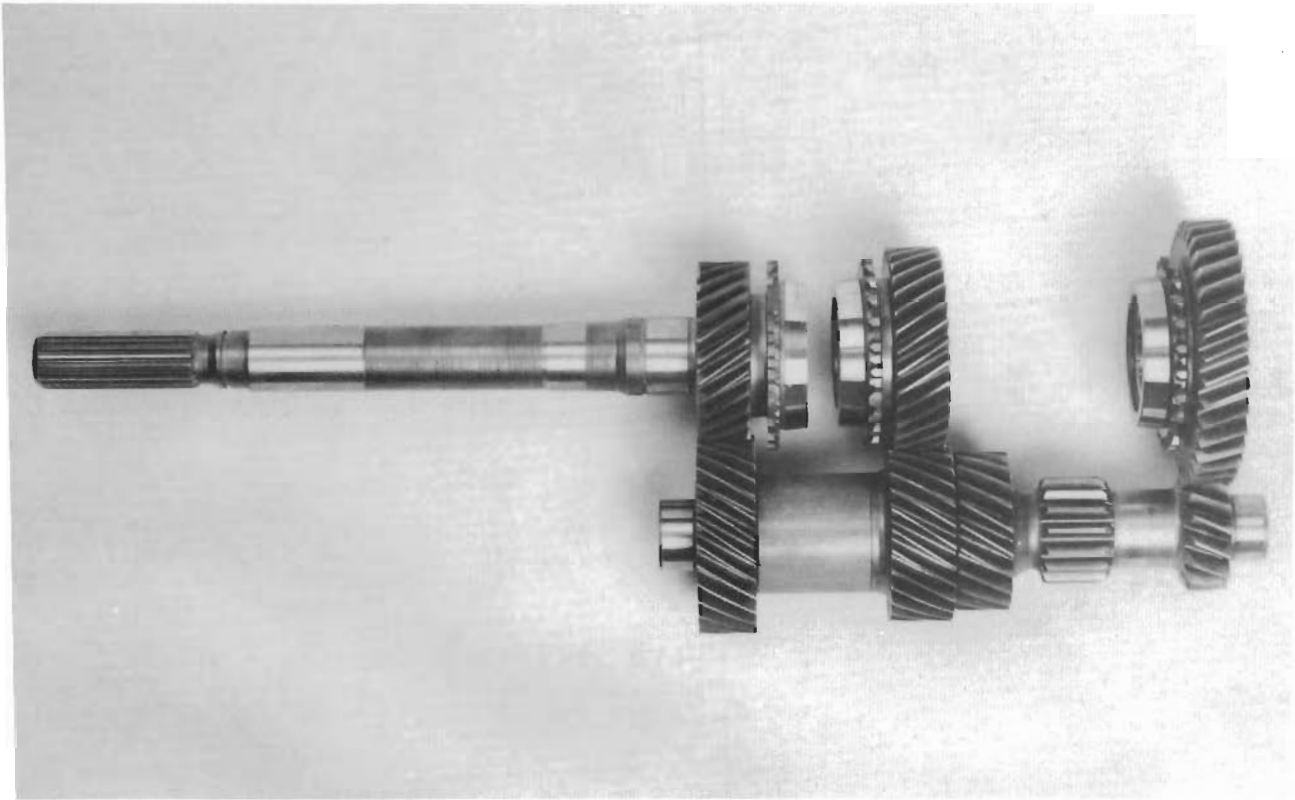
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Pos	Qty	Part no	Description	Specification
	2	1157228-6	Spotlight	The Bosch "Rally 190" spotlight. The housing is treated with a nice black epoxyhartz which makes it very resistant to rust and wear. Up to 1980 models.
	2	552031-7	Stay for spotlight 1157288	- 1980
	2	1157229-4	Bracket for stay 552031	- 1980
	1	1157226-0	Mounting kit for spotlight 1157228-6	1981 -



Standard gearboxes have a relatively large step between each gear. If the engine has been trimmed there is risk of the engine having too high a rpm in one gear, and in the next higher gear the engine does not have enough power because the rpm is too low.

This is unacceptable in a racing car where every second is precious.

Transmission parts have therefore been introduced to convert a standard gearbox to one with closer steps.

Table A

Type	Reduction ratio			
	1st	2nd	3rd	4th
M45 R standard	3.71:1	2.16:1	1.37:1	1.0:1
M45 R closer steps	2.50:1	1.63:1	1.27:1	1.0:1

Table B Rebuild parts for converting standard gearbox to closer-stepped gearbox

Type	Part No				
	Input shaft	1st gear	3rd gear	Intermediate shaft	Inhibitors
M45 R year model 79-	1232717-7	1232710-2	1232714-4	1232345-7	951671-7
	Kit No 1156680-9				



SHOCK ABSORBERS

EXPORT

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FLAP

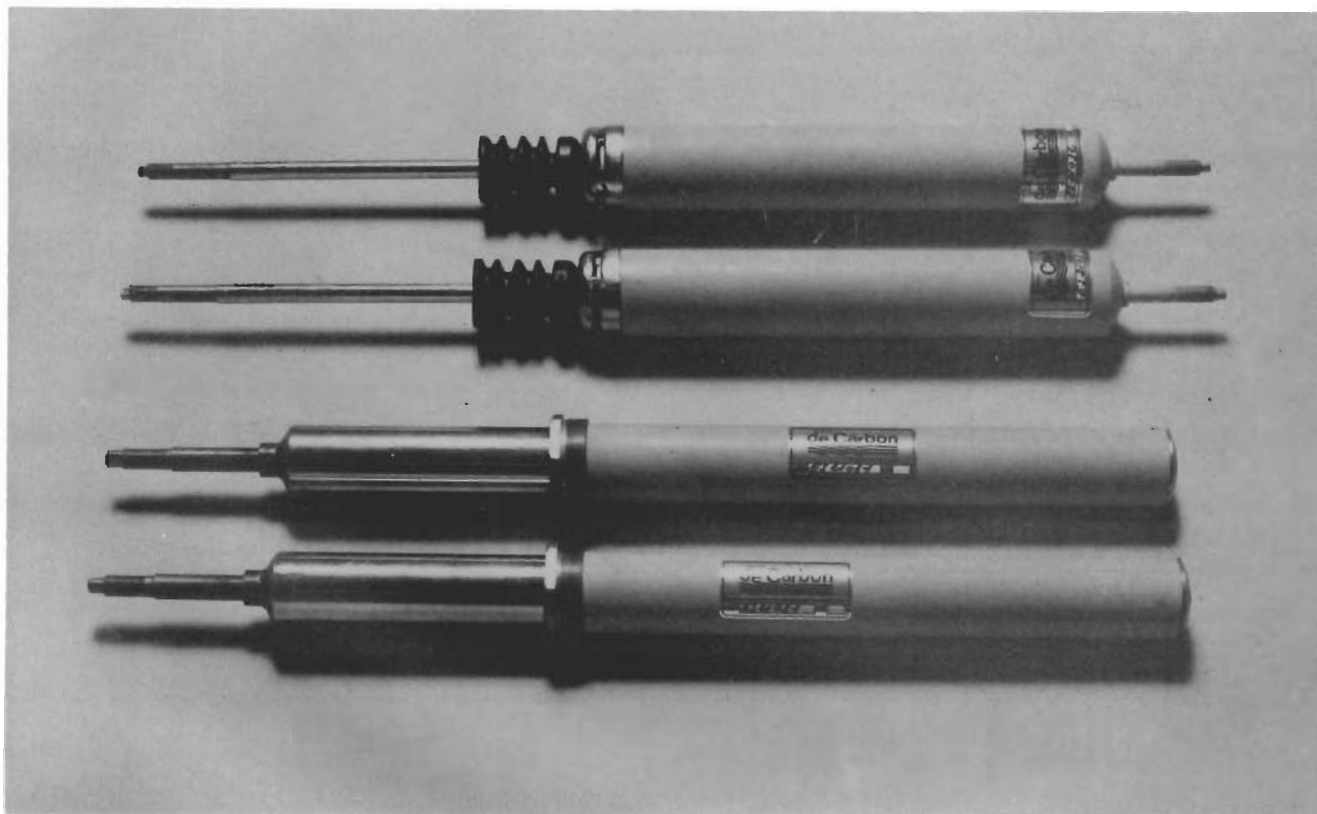
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Pos	Qty	Part No	Description	Specification
	1	1156640-3	Shock absorber kit, sport	Gas pressure shock absorbers for 340 B14. Designed for both rally and normal driving.
	2	1156641-1	x Shock absorber, front	
	2	1156642-9	x Shock absorber, rear	
	1	1156646-1	Shock absorber kit, sport	Gas pressure shock absorbers for 340 B19. Designed for both rally and normal driving.
	2	1156948-0	x Shock absorber, front	
	2	1156861-5	x Shock absorber, rear	

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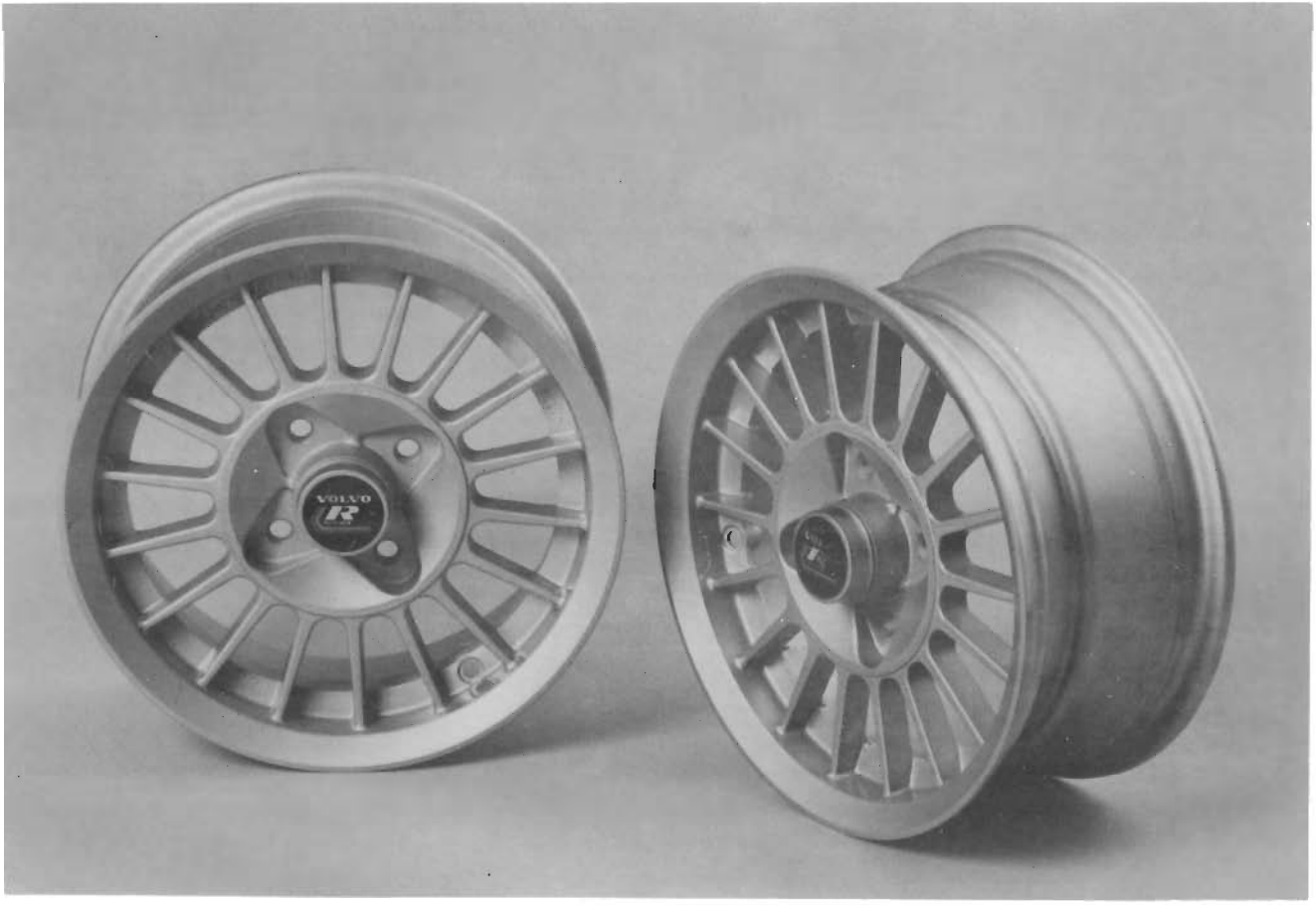


SPORT RIMS

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Sport rims of aluminium alloy. Increase track compared with standard rims of up to 10 mm. Size 6" x 13". Weight 4.7 kgs/each (reduced unsprung weight). Improved road properties.

High-class surface treatment consisting of etching primer, silver coat and two-component lacquer.


Conforms to the European safety regulations.

Qty	Part no	Description	Remarks
4	1156620-5	Sport rims	Delivered in cartons containing two rims each.
4	1156630-4	x Hub cap	

	SPOILER	EXPORT	810401	
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Pos	Qty	Part no	Description	Remarks
	1	1156520-7	Spoiler, front	<p>Improves driving characteristics of car:</p> <ul style="list-style-type: none"> - Considerably decreases sensitivity to side winds. - Improves road grip and steering through increased pressure on front axle. <p>Furthermore the spoiler underlines the sporting appearance of the car. Up to 1980 models,</p>

	STRIPES	EXPORT		810401
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Exclusive stripes to accentuate the sporting image of the car. Simple to apply. Made of finest 3M quality, this ensuring that the paintwork is not damaged in any way.

Pos	Qty	Part no	Description	Remarks
1	1	1156613-0	Stripes, yellow/blue	For 343 only
1	1	1156614-8	Stripes, black	For 343 only
1	1	1156615-5	Stripes, silver	For 343 only
2	1	1156713-8	Stripes, yellow/blue	For 345 only
2	1	1156714-6	Stripes, black	For 345 only
2	1	1156715-3	Stripes, silver	For 345 only
3	1	1156616-3	Spoiler stripes, yellow/blue	
3	1	1156617-1	Spoiler stripes, black	
3	1	1156618-9	Spoiler stripes, silver	
4	1	1156716-1	Hood stripes "2,0 litres", blue/yellow	
4	1	1156717-9	Hood stripes "2,0 litres", black	
4	1	1156718-7	Hood stripes "2,0 litres", silver	



ASP - MATERIAL

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Stickers

Three smart stickers with the Volvo R Sport identification on: One self-adhesive sticker in two sizes in multi colour print, to be put on your car (will not damage the paintwork), and one made of PVC, to be sewn on clothing, bags etc.

Part No	Description	Specification
552655-3	PVC sticker	Size 5,5 x 8,0 cm
552999-5	Self-adhesive sticker	200/package. Size 12,0 x 8,5 cm
1157100-7	Self-adhesive sticker	Size 35 x 50 cm
1157110-6	Self-adhesive sticker	200/package. Size 17,3 x 5,0 cm



ASP - MATERIAL

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Plastic bag

Excellent aid for your spare part shop. Carries the Volvo R Sport identification in multi colour print on both sides.

Is delivered in packages of 500 units.

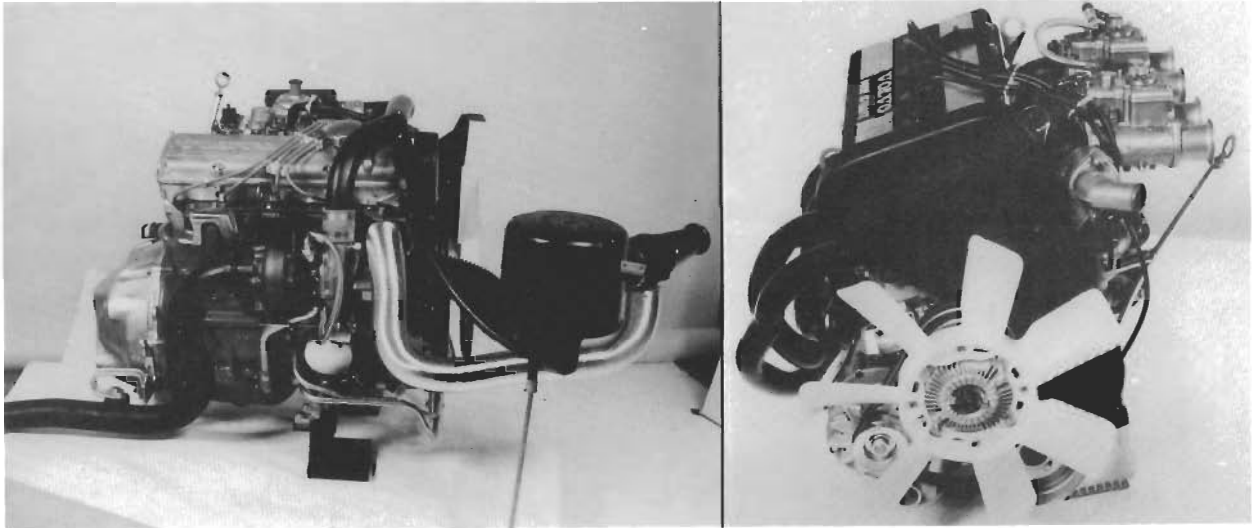
Part No	Description	Specification
552972-2	Plastic bag	Size 27 x 41 cm



ASP - MATERIAL

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Exhibition material

For exhibition purpose cars and engines can be borrowed from Volvo R Sport.

Please book with Mr Kenneth Olsson, telephone Gothenburg (031) 59 64 71.

Cost for transportation to and from Volvo R Sport and for insurance are to be covered by the borrower.