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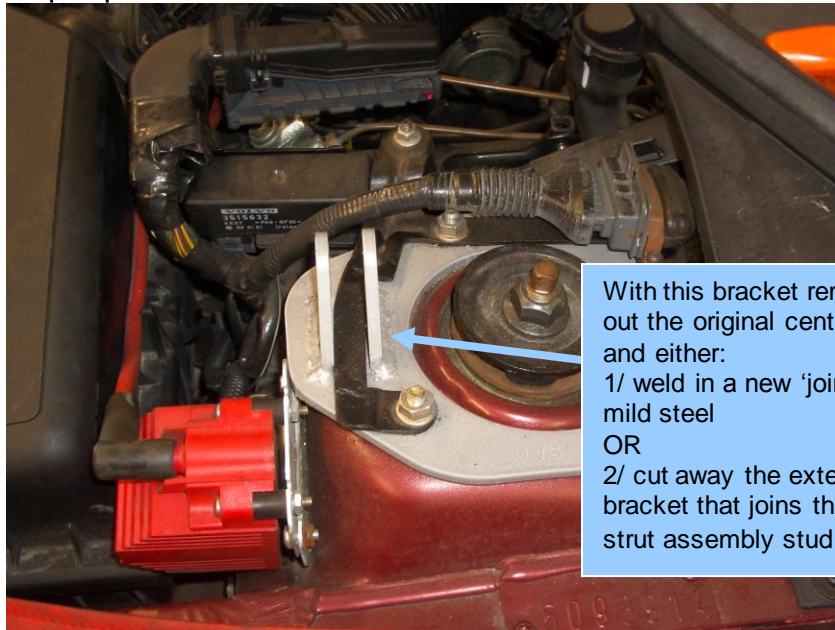
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VOLVO 850 '94 & '95 models only

VOLVO 850 C70/S70/V70 Strut tower to tower brace

Fitting instructions:

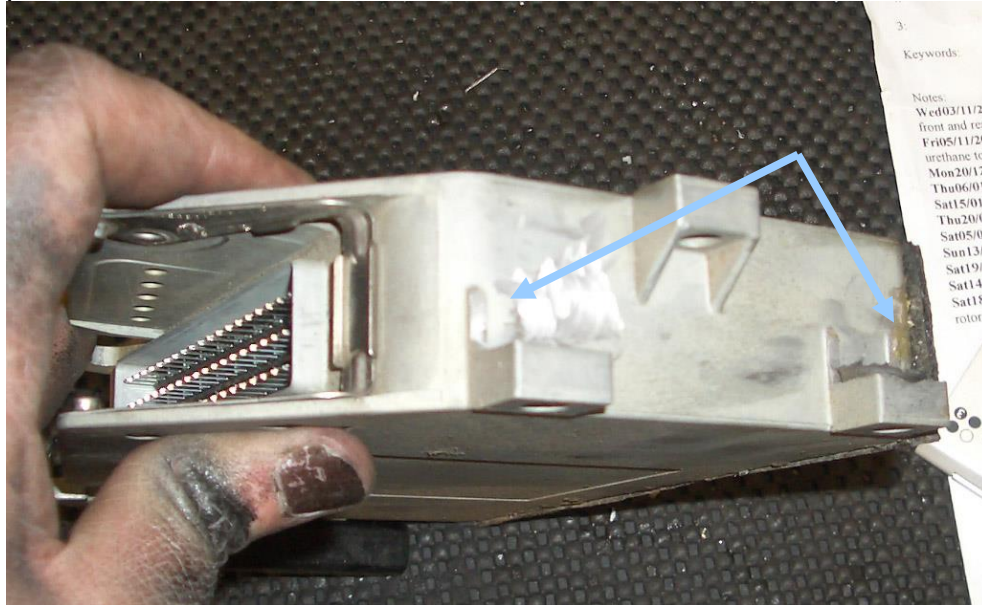
1. Remove brake distribution block bolts
2. Disconnect ABS/TRACS module connector
3. Remove ABS/TRACS module from bracket. Retain original screws.
4. Remove airbox to turbo duct (if applicable) and push to one side.
5. Remove ABS/TRACS module upper bracket from strut tower and modify as per photo.



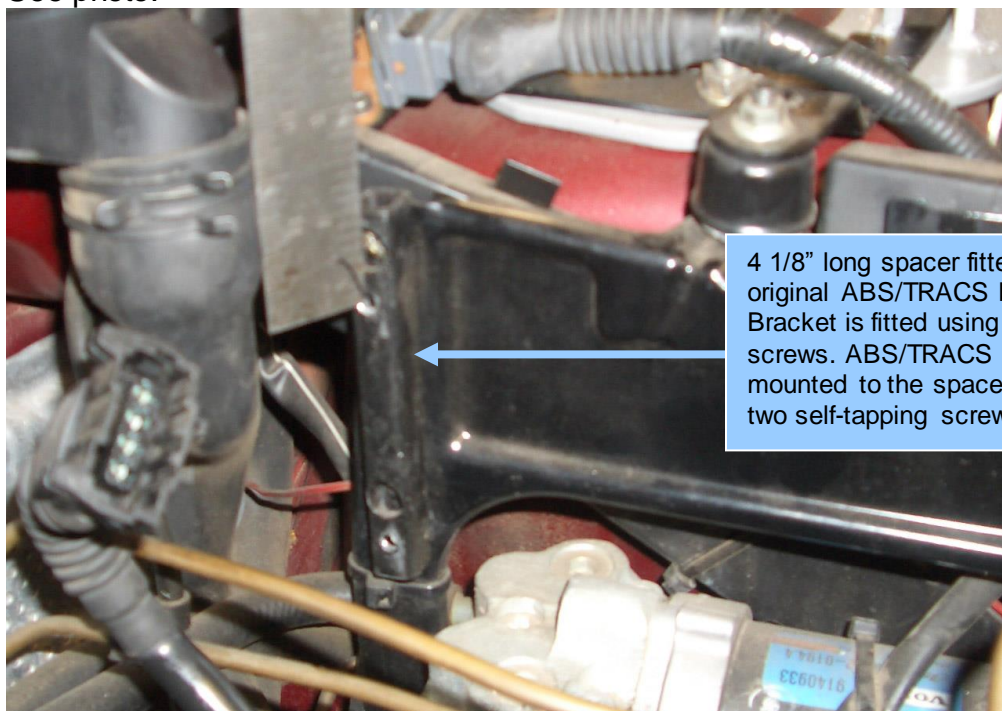
With this bracket removed, cut out the original centre section and either:
1/ weld in a new 'joiner' using ¼" mild steel
OR
2/ cut away the extension of the bracket that joins the outermost strut assembly stud

6. Remove left side strut tower top nuts and fit strut tower brace top plate.
7. Re-fit modified ABS/TRACS module upper bracket to strut tower.

8. Modify ABS/TRACS module casing as shown. A die grinder or dremel tool is ideal for this. This needs to be done on both sides of the module. See photo.



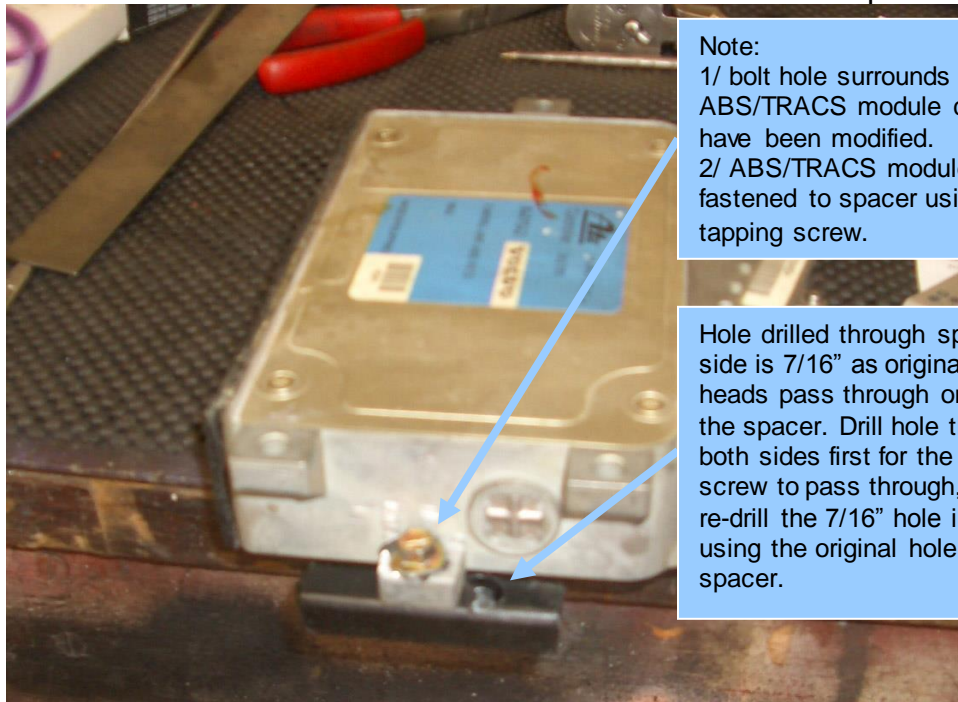
9. Fabricate two $\frac{1}{2}$ " square tube spacers. One of these needs to be $2\frac{1}{4}$ " long and the other needs to be $4\frac{1}{8}$ " long. The purpose of these spacers is to drop the ABS/TRACS module down by $\frac{5}{8}$ " and to space the module out by $\frac{1}{2}$ ". See photo.



10. Drill holes large enough for thread of original ABS/TRACS module original screws right through the spacer. Enlarge one side only of this hole to $7/16$ ".

The spacer will be fastened to the original bracket using the original mounting screws.

11. Measure down $5/8$ " from these hole and drill $1/8$ " pilot hole. ABS/TRACS module will be fastened to the spacer using self tapping screws. The longer ($4\ 1/8$ ") spacer uses two screws, whilst the smaller ($2\ 1/4$ ") spacer uses one.
12. Picture below shows the ABS/TRACS module with smaller spacer fitted.



Note:

1/ bolt hole surrounds on ABS/TRACS module casing have been modified.
2/ ABS/TRACS module is fastened to spacer using self tapping screw.

Hole drilled through spacer. One side is $7/16$ " as original screw heads pass through one side of the spacer. Drill hole through both sides first for the original screw to pass through, and then re-drill the $7/16$ " hole in one side, using the original hole as a spacer.

13. Refit ABS/TRACS module with spacers fitted. The module is fastened to the spacers, and then the module with spacers attached is re-fitted back into the original bracket. See picture.



14. Re-fit brake distribution block. Bracket may need to be bent slightly to clear ABS/TRACS module, as module now sits lower.
15. Re-fit all connectors. Re-fit airbox to turbo duct.
16. Fit RH tower top plate.
17. Fit strut bar to RH tower plate, adjust to length, fit to LH tower plate, adjust and tighten.