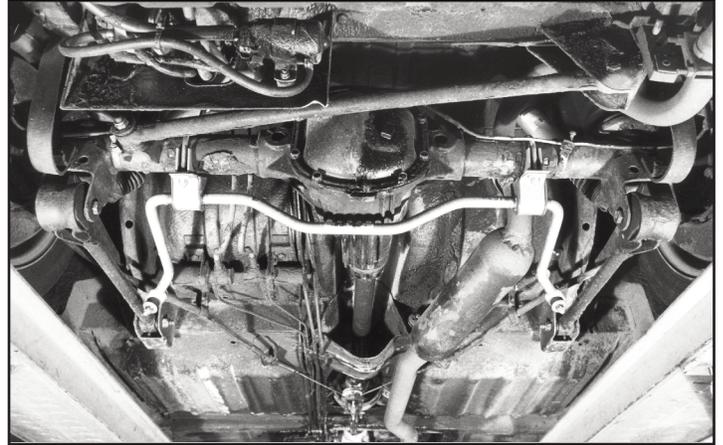


Dedicated to improving vehicle fun, safety & performance

## Installation Instructions

### Rear Sway Bar Mounting Kit for 122, 1800, 140, 164 (1967-74)



## INTRODUCTION

Before you begin, we suggest you separate the various components and lay them out in the way they will be fit to your car (referring to the drawings on page 2 & 3). This is also a good opportunity to make sure the kit is complete.

## SUGGESTED TOOLS

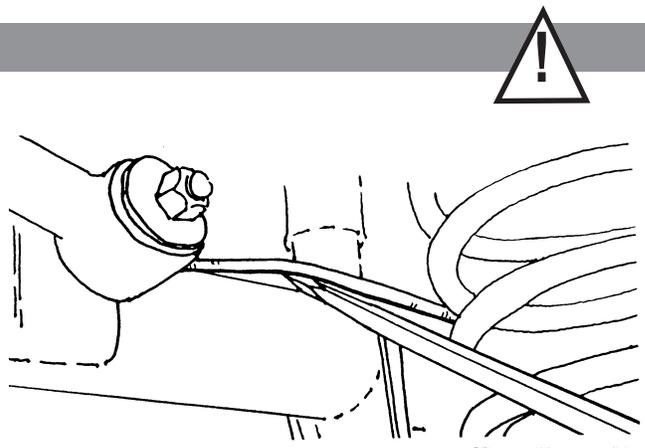
- 3/8" socket and wrench kits
- Center punch
- Jack stands
- 1/2" electric drill
- Large hammer
- 1/8", 5/16", 5/8" drill bits
- Floor jack

(It is very helpful to have a second person to help hold things for you during assembly)

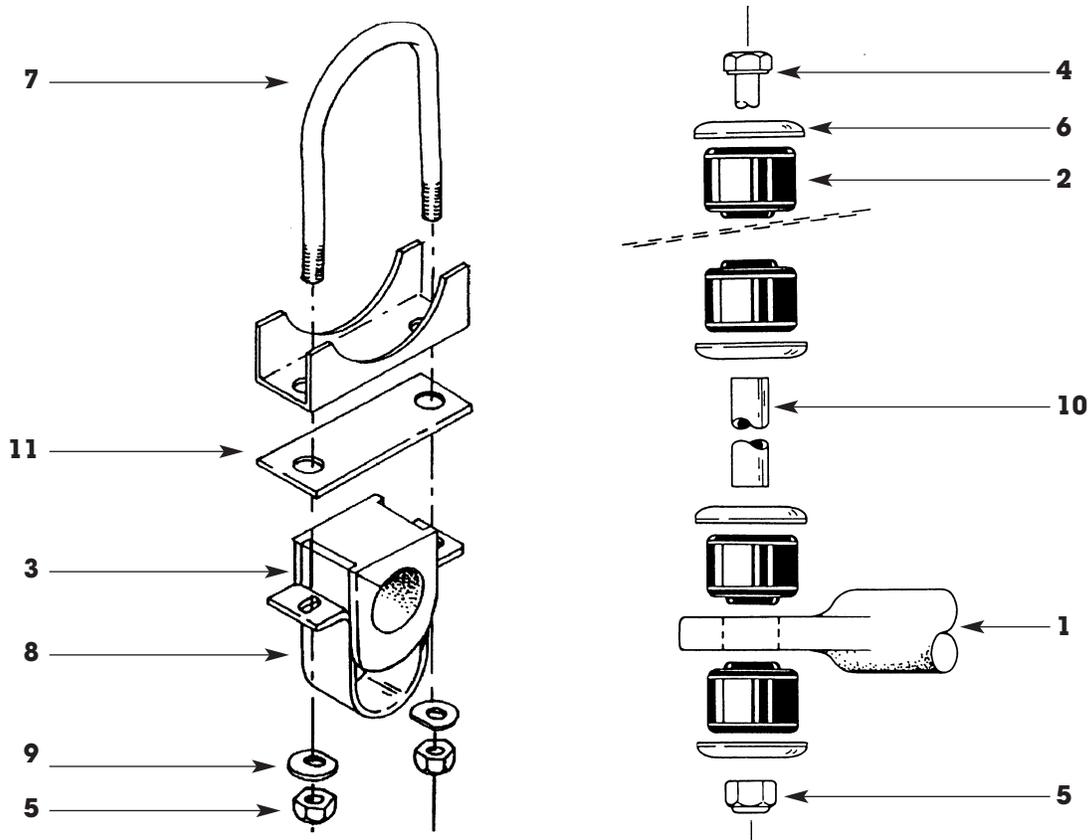
## SAFETY WARNINGS

The U-bolts must be installed under the brake lines. To do this, insert a screwdriver under the brake line and pry up gently. You only need enough clearance to insert the U-bolt under the line and slip it around the axle tube.

Be sure you do not kink the brake line, as loss of rear brakes could result.



# PARTS LIST



Part #	Description	Qty	Part #	Description	Qty
1. SB3405R	Sway bar, 3/4" (122,140,160)	1	8. B170	Bushing saddle brackets	2
1. SB3407R	Sway bar, (1800)	1	9. W408	5/16" cut washers	4
2. 2B1015	Urethane grommets	8	10. S501	Spacer sleeves	2
3. 2B1134	Urethane bushings	2	11. B123	Retaining plates	2
4. F376	3/8" x 7" Bolts	2	12. 2K3000	Floor pan reinforcing kit (not shown)	1
5. N205	3/8" Locknuts	6	13. AQUALUBE	Bushing lubricant	1
6. W404	Cup washers	8			
7. U364	3/8" x 2-1/2" U-bracket and bolts	2			

## Lifetime Warranty

All sway bar components are under a lifetime warranty to the original purchaser. Proof of purchase must be provided with any request for warranty parts replacement. Note: No warranty on vehicles used for any type of competition, i.e. autocross and racing.

## Satisfaction Guaranteed

or your money back. If you are not satisfied with the improvement in handling of your vehicle, simply remove the sway bar and return it to us for a full refund. Please include a copy of your invoice showing what you paid for the bar. The following instructions must be followed in the order listed to ensure a proper installation and to preserve the ipd warranty.

# INSTALLATION

## 1 Jack the car up and place on jack stands.

NEVER work under a car supported only by a jack. You will need enough space to move about freely under the car.

## 2 Prepare sway bar by lubricating i.d. of urethane bushings (#2B1134) and placing them over the center section of the sway bar. Place saddle brackets (B170) over the urethane bushings.

You are now ready to fit the sway bar to the axle.

## 3 Hold sway bar under rear axle to determine position for U-bolts and brackets. Brackets are to fit as close to sway bar arms as possible (or you could say outwards toward the wheels).

## 4 Install U-brackets to axle and fit sway bar into saddle brackets as shown in drawing. Do not tighten U-bolts yet.

## 5 Swing the sway bar as far forward as possible to allow arms to be in-line with drilling point on floor pan. There is a body indent on the floor pan and this is the best attaching point. In order to reach this drilling point the U-bolts/brackets will have to be tilted forward as shown.

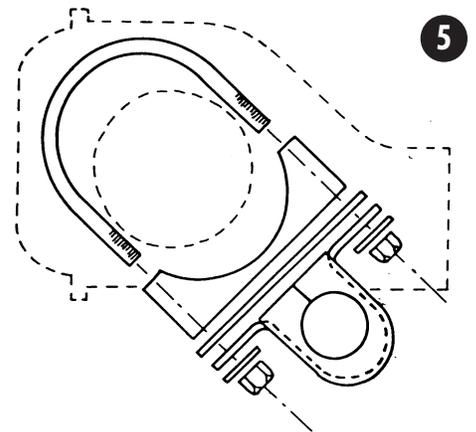
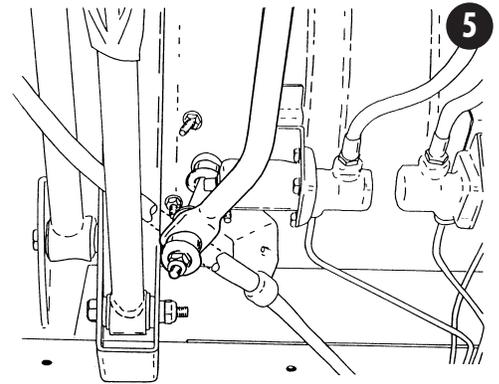
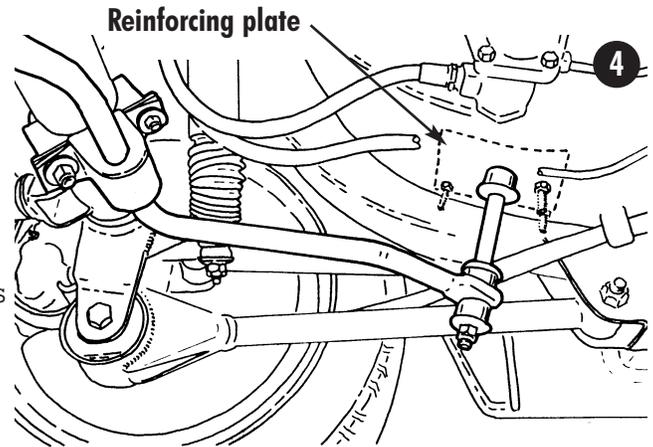
## 6 We suggest you hold the bar into position and pre-assemble the lower bar attachment with the spacer sleeve and bolt to determine the drilling point and mark this point. Once you have determined the drilling point and have located the U-clamps properly, tighten these bolts to 20-25 ft/lbs. Note: occasionally the U-bolt and locknut will fit quite tight due to the protective plating tolerances and will be hard to turn. If this happens you may have to run a thread chaser over the threads to clean them. Rarely, this bolt will break. If this should happen we will send you another.

## 7 Steps 7 through 12 need to be done to both sides as you go.

### 7

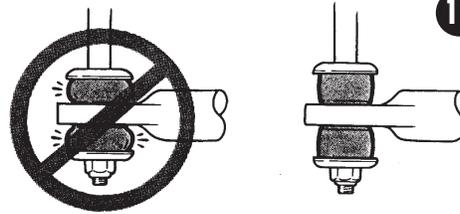
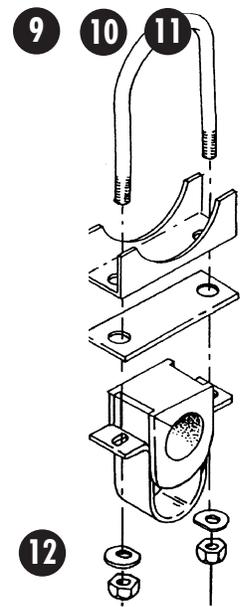
At the marked point, drill a 5/8" hole.

## 8 Remove back seat bottom cushion from car. See instructions for floor pan reinforcing kit, page 4. Install kit now.



# INSTALLATION

- 9 Slip a cup washer and urethane grommet on the long bolt. Place the stepped-end away from the bolt head. From inside the car drop the bolt (with washer and grommet) through the hole in the reinforcing plate/floor pan.
- 10 From underneath, slide a urethane grommet over the bolt. Then slide the cup washer, spacer sleeve cup washer, and urethane grommet over the bolt. Consult drawing for proper orientation of stepped end of grommets.
- 11 Raise the sway bar arm up and place the next component in order on bolt as shown.
- 12 Slide another grommet over the bolt (stepped-end up), then another cup washer. With a friend pushing down on the bolt from the inside of the car, start the 3/8" lock nut and tighten until there is no play in the grommets. Don't overtighten. Try to keep the sway bar arm as close as possible to parallel with the lower trailing arm. On lowered cars, shortening of the spacer sleeve and link bolt may be necessary to achieve this attitude.
- 13 Test drive the vehicle. After driving recheck all fasteners for tightness.



## FLOOR PAN REINFORCING PLATE

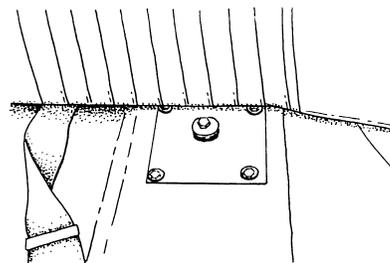
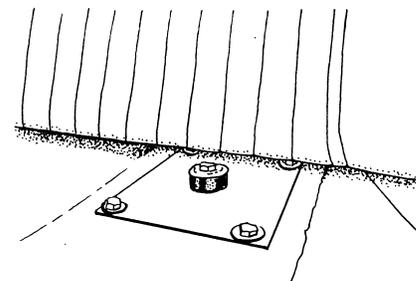
Part #	Description	Qty
1. B116	6" x 6" Metal plate	2
2. F319	5/16" x 1-1/4" Bolt	8
3. N206	5/16" Locknut	8
4. W409	5/16" Washer	16

**IMPORTANT:** Before drilling holes in plates, check under floor to make sure you don't drill into anything other than the floor.



On 140, 164, and late model 1800, avoid the brake proportioning valves mounted on the underside of the floor pan.

- 1 Center the plate over the 5/8" hole you drilled in Step 7, page 3. Note where the plates will have to be bent to conform to your Volvo's floor pan. Use a large hammer to form the plate. (You can hammer-form the plate in place in the car or do it over a piece of wood on a bench. Do whichever is easiest for you).
- 2 Locate where to drill 4 holes in each plate. In most cars you can position one in each corner of the plate.
- 3 Drill the four 5/16" holes in each plate. Verify that the plate closely match the floor contours and then drill the four 5/16" holes through the floor pan.
- 4 Use supplied bolts, washer, and lock nuts to secure plates to the floor pan.



140 and 164 illustrations. 122 and 1800 models are similar.